LEUCO

MAGENTIFY WOOD PROCESSING

CATALOG
GENERAL PROGRAM
GP 07



BRANDS YOU CAN RELY ON

Sizing saw blades

LEUCO topline	LEUCO precision saw blades
LEUCO highline	Saw blades with optimized price-performance ratio
DUPLOVIT®	The original hollow-ground tooth saw blades

Panel sizing circular saw blades

U-CUT TR-F · U-CUT MAX · U-CUT SPEED · U-CUT WS	Tungsten carbide-tipped panel sizing circular saw blades for the universal use in wood-based materials, for single panel or stack cuts and high volumes
Q-CUT G6 · Q-CUT TR-F K · Q-CUT G5 · Q-CUT TR-F K	Tungsten carbide-tipped panel sizing circular saw blades for finish-cut quality in wood-based materials, even with sensitive top layers, for single panel or stack cuts. Noise-reduced design nn-System

Hoggers

LEUCO unitec	DP compact hoggers with stepped cut
LEUCO compacttec	DP compact hoggers for universal use
LEUCO powertec airface	DP compact hoggers with crowned tooth geometry; noise-reduced airFace design

Cutterheads

SUPER PROFILER	Universal cutterhead system with standard body
LEUCO EcoPro	Flexible cutterhead system with direct knife clamping
LEUCO SetProfiler	Back-serrated knife system with large resharpenable area
LEUCO ultra-profiler-plus	High-performance cutterhead system for customized profiles, play-free and quick knife change
LEUCO power DIA Profiler	High-performance diamond profile cutters for highest feed rates
LEUCO smart jointer airface	Jointing cutterhead system with manually changeable DP-tipped segments, very high concentric accuracy and consistent tool diameter, noise-reduced airFace design

Clamping elements

LEUCO s|e system	Precision quick change system with bayonet mount for through-feed processing
LEUCO Hydro-S-System	Precision quick change system with bayonet mount on hydro bushing for through feed processing
LEUCO ZEROPLAN	Quick change system with adjustable runout for through-feed processing
LEUCO ps system	Quick change system with adjustable runout for through-feed processing
LEUCO TRIBOS	High-performance precision clamping element with polygonal clamping technology for shank-type tools

Drill bits

MOSQUITO	Drill bit program range with fine-grain tungsten carbide and optimized grinding for long edge lives
LEUCO topline	Drill bit program with ultra fine-grain tungsten carbide and optimized polished section for very long edge lives and best cutting quality in laminated panel materials
LEUCO EcoLine	Universal, economic dowel and through-hole bit program

System tools

LEUCO i system	System tools with optimized chip removal for aggregates with inward-directed chip jet
CM	All LEUCO tools with optimized chip removal design are characterized by this sign
AIR STREAM	Bores in the tool body optimize the aerodynamics and thus the noise level
airface	The aerodynamic surface of the body ensures a reduced noise level during operation
LEUCO ps system	Shank-type tools and bore-type cutters with a shear angle ≥ 55° for the best cutting quality currently available on the market; long edge lives and additional applications that were previously considered technically impossible
LEUCO g5 system	Saw blades and grooving cutters with a tooth group combination of 5 teeth: noise-reduced, low cutting pressure, excellent cutting quality
LEUCO nn system	DP format and panel sizing saw blades with very small chip gullets work quietly and comfortably. Noise level below the level required for hearing protection; best cutting quality, long edge life in many wood-based panels
LOW A) · LOW B)	All low noise level circular saw blades (A) and all low noise level tools with bore (B) are provided with this label

Cutting materials and coatings

LEUCO DUR®	LEUCO HW cutting materials
HL Board®	LEUCO HW cutting materials for panel board processing
HL Solid®	LEUCO HW cutting materials for solid wood processing
LEUCO TOP COAT	Coatings of the cutting edge are suited for each application
LEUCO DIA	Diamond high-performance cutting materials optimized for each application
LEUCO DIA	High-performance diamond tools with full height diamond tips (approx. 6 mm)
LEUCO DIAMAX®	Diamond-tipped tools with a resharpening area of 0.5 mm – 1.5 mm depending on the tool type and the tool diameter
LEUCO DIAREX	Diamond-tipped tools with a resharpening area of 1.5 mm or 2.0 mm depending on the tool type

® registered trademark by LEUCO

Circular saw blades

Hoggers

Milling tools with bore

Shank-type milling tools

Drill bits

Turnover knives
Exchangeable knives
Knives

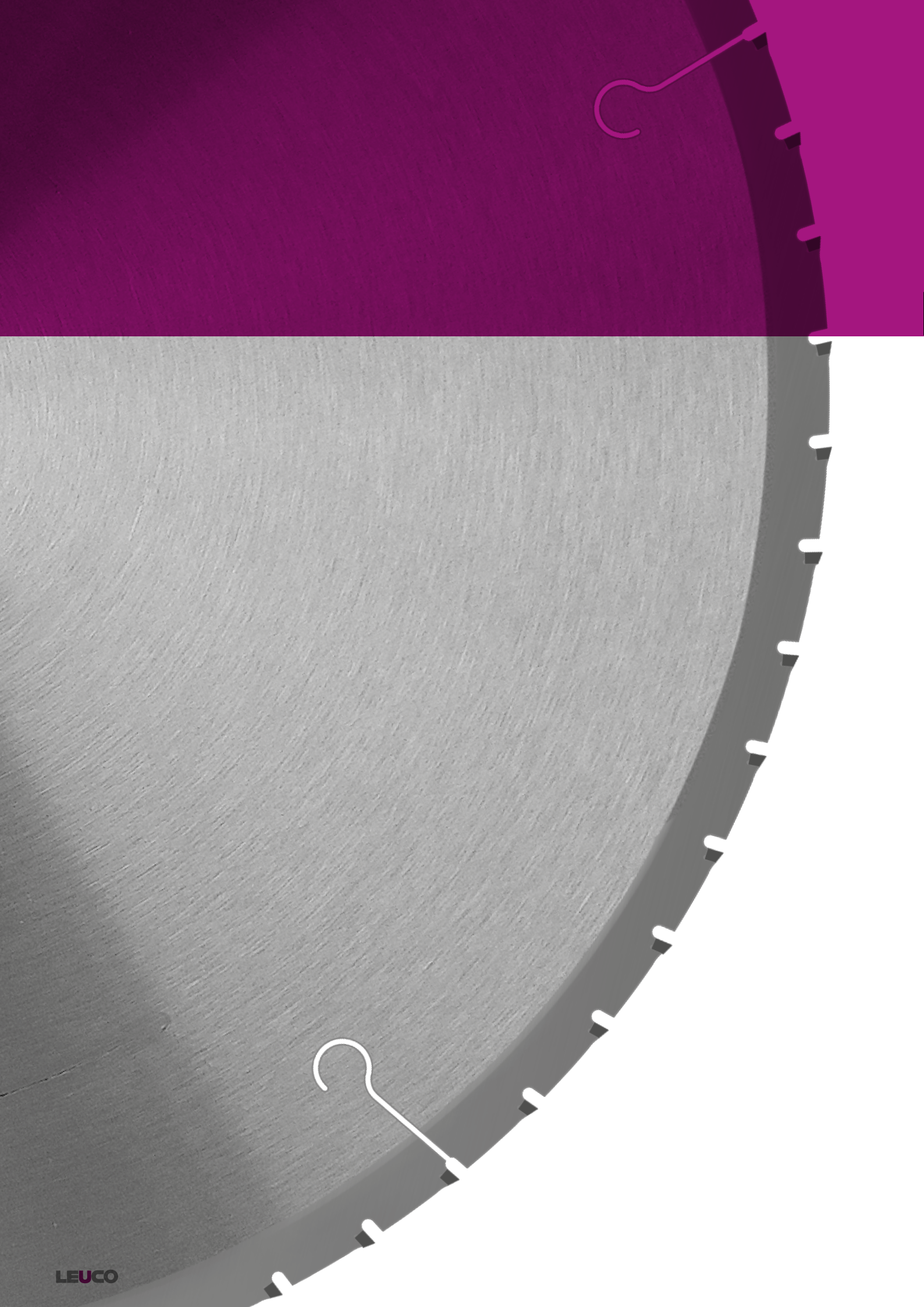
Clamping systems

Spare Parts
General technical information

General technical information
Inquiries custom manufacturing
Code designations



Version 03/2024



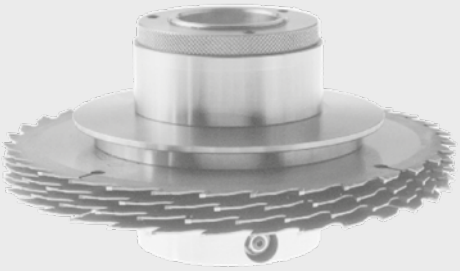
Circular Saw Blades

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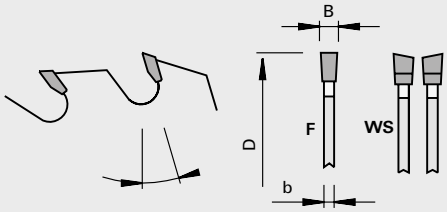
102317 / 102327

Thin-Kerf Saw Blades HW for parquet manufacturing

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- molders
- splitting machines
- for precise dividing cuts in trimmed solid woods

Design

- specially treated tool body with Oxytop coating
- tooth configuration:
- flat "F" for european hard woods (oak, beech, ...)
- alternate top bevel "WS"for exotic woods
- cutting material: HW HL Board 06 plus

Advantages

- optimum wood yield thanks to thin kerfs

Notes

- also suitable for Hydro clamping bushing
- bore extension to d=65 mm of edge saw blade for Schröder
- packing unit 10 pieces

Ø D	B	b	Ø d	Z	Hook angle	NL	Tooth geom-etry		Ident-No.
180	1,0	0.8	65	24	18	3/11/80	F	Schröder	80254254 C
180	1,0	0.8	65	30	20	3/11/80	WS	Schröder	80254256 C
220	1,2	0.9	60	27	18	3/10/74	F	Weinig	80252288 C
220	1,2	0.9	65	27	18	3/11/80	F	Schröder	80252289 C
220	1,2	0.9	60	30	20	3/10/74	WS	Weinig	80252290 C
220	1,2	0.9	65	30	20	3/11/80	WS	Schröder	80252291 S
220	3,8/3,5	3.0	60	30	18	3/10/74 + 3/11/80	F	Weinig, Schröder	80252292 S
[mm]	[mm]	[mm]	[mm]		[°]				

Saw Blade Adapter Weinig HSK	Ø D	Ø d	Ø d1	L2	L1	Class-No.	PU	Ident-No.
	105	Weinig HSK	60	68		997300	1	182974 C
	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Clamping Nuts	105x15xM58x1,5	995290	1	182993 C
	[mm]		[pc.]	

Hydro Clamping Bushing	Ø D	Ø d	Ø d1	L2	L1	Class-No.	PU	Ident-No.
	93	50	60	80	115	997300	1	182193 C
	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Ø D	B	Ø d	Class-No.	PU	Ident-No.
Cover flange top with handhold	130	16	60	997300	1	182194 C
Cover flange top with handhold	130	16	65	997300	1	182196 S
Cover flange bottom	130	14	60	997300	1	182195 C
Cover flange bottom	130	14	65	997300	1	182197 S
Spacers	130	4,2	60	955520	1	182200 S
Spacers	130	4,4	60	955520	1	182202 C
Spacers	130	4,5	60	955520	1	182203 S
Spacers	130	5,0	60	955520	1	182208 S
	[mm]	[mm]	[mm]			

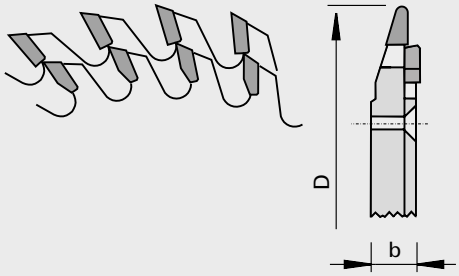
106384

Turnery saw blades HW

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- Special woodturning lathes (Zuckermann, Hempel, CMS-HIT)
- for woodturning applications in solid wood

Design

- carbide tipped
- special tooth configuration
- bore tolerance H7

Advantages

Notes

Ø D	b	Ø d	Z	NL	Ident-No.
350	11.3	60	2x64	6/11/170	185248 S
350	11.3	60	2x90	6/11/170	185249 C
[mm]	[mm]	[mm]			

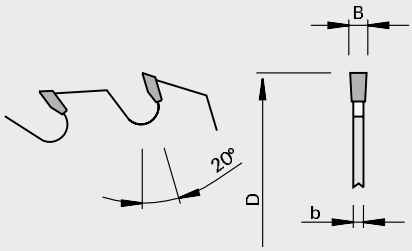
101310 / 101311

Gang-Rip Saw Blades HW “F”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- molders
- gang-rip saws with one or two shafts
- for precise ripping cuts in dry and planed soft woods

Design

- tooth configuration: flat “F”
- cutting material: HW HL Board 20
- type A and C with staggered double keyways

Advantages

- staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

- larger bore (max. Ø 100 mm) available for a surcharge
- for cutting height > 50 mm use version with HW rakers
- for inquiries / orders enclose specification sheet (see appendix)

Ø D	B	b	Ø d	Z	DKN	NL	Class-No.	Ident-No.
200	2,0	1.4	40	20			101311	188029 L
200	2,4	1.6	40	20			101311	188148 L
225	2,4	1.6	40	20			101311	188150 L
250	2,4	1.6	40	24			101311	188151 L
250	3,2	2.2	70	20	20x5		101310	189300 L
250	2,8	1.8	70	24	20x5		101311	188030 L
300	3,2	2.2	70	24	20x5		101310	189301 L
300	3,2	2.2	80	24	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100	101310	189302 L
350	3,5	2.5	70	28	20x5		101310	189303 L
350	3,5	2.5	80	28	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100	101310	188027 O
[mm]	[mm]	[mm]	[mm]		[mm]			

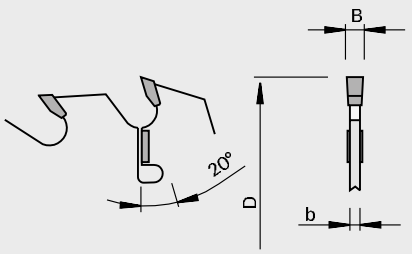
101715

Gang-Rip Saw Blades HW with HW-rakers - solid “F”

Product



Drawing



LEUCO solid

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- gang-rip saws with one or two shafts
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat “F”
- cutting material: HW HL Board 20

Advantages

- tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate

Notes

- for inquiries / orders enclose specification sheet (see appendix)
- for cutting height > 50 mm

Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of rakers	Ident-No.
350	3,5	2.4	50	100	140	20	2+2	189271 L
400	4,2	3.0	50	100	150	24	2+2	189272 L
450	4,2	3.0	50	100	160	24	2+2	189273 L
500	4,6	3.3	50	100	180	28	2+2+2	189274 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

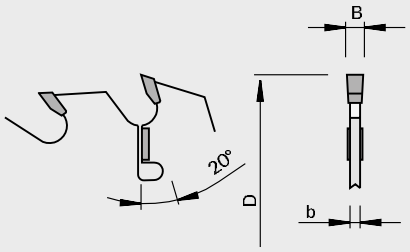
101315

Gang-Rip Saw Blades HW with HW-rakers “F”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- molders
- gang-rip saws with one or two shafts
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat “F”
- cutting material: HW HL Board 20
- type A and C with staggered double keyways

Advantages

- tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
- staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

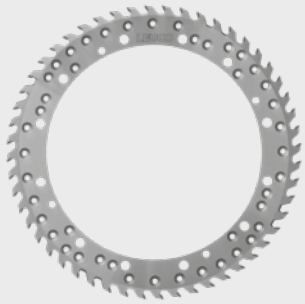
- for inquiries / orders enclose specification sheet (see appendix)
- for cutting height > 50 mm

Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of rakers	DKN	NL	Ident-No.
180	2,4	1.6	40	55	95	16	2			188096 L
200	2,0	1.4	40	75	115	16	2			188097 L
200	2,4	1.6	40	75	115	16	2			188098 L
225	2,4	1.6	40	80	120	16	2			188100 L
250	2,4	1.6	40	80	125	16	2			188101 L
250	2,8	1.8	70		125	24	2	20x5		189290 L
300	3,2	2.2	70		120	16	2+2	20,0x5		189293 L
300	3,4	2.2	80		120	16	2+2	12,5x4,5		189296 L
300	3,2	2.2	70		120	28	2+2	20,0x5		189294 L
300	3,2	2.2	80		125	16	2+2	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100	189295 L
350	3,5	2.5	70		120	20	2+2	20x5		189297 L
350	3,8	2.5	80		125	20	2+2	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100	189299 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	[mm]		

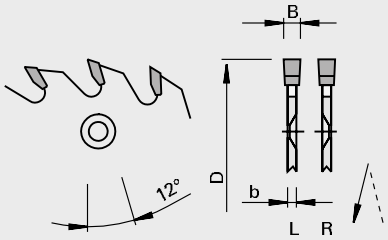
116413

Hogger Rings HW “F” - Linck

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- chipping line rough and fine cut
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat “F”
- cutting material: HW HL Solid 15 or HL Board 20

Advantages

- extremely high bending strength and hardness of the teeth

Notes

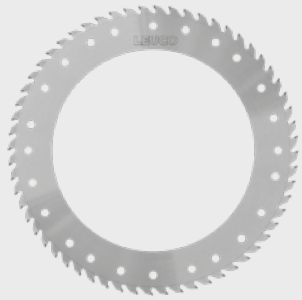
- the saw blade is optimized according to the LEUCO company standards as well as according to the customers specifications and machine parameters after consultation with the technical engineering
- Ident-No. is only for orientation

Ø D	B	b	b1	Ø D1	Ø d	Z		Ident-No. [L]	Ident-No. [R]
576	4,5	3.5	6.0	531	422	52	Linck V25	80347850 S	80347849 S
724	4,5	3.5	6.0	684	586	64	Linck VM45	80371095 S	80371094 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]				

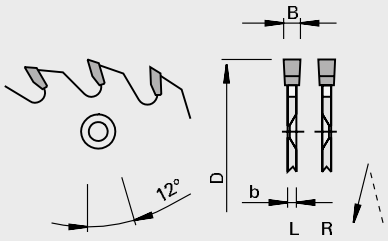
116413

Hogger Rings HW “F” - EWD

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- chipping line rough and fine cut
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat “F”
- cutting material: HW HL Solid 15 or HL Board 20

Advantages

- extremely high bending strength and hardness of the teeth

Notes

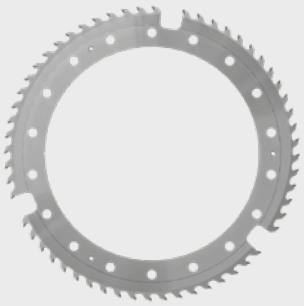
- the saw blade is optimized according to the LEUCO company standards as well as according to the customers specifications and machine parameters after consultation with the technical engineering
- Ident-No. is only for orientation

Ø D	B	b	b1	Ø D1	Ø d	Z		Ident-No. [L]	Ident-No. [R]
745	6,6	5.0	6.0	700	520	60	EWD PF19	80291614 S	80291613 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]				

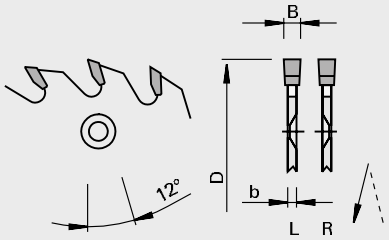
116410 / 116413

Hogger Rings HW “F”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- chipping line rough and fine cut
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat “F”
- cutting material: HW HL Solid 15 or HL Board 20

Advantages

- extremely high bending strength and hardness of the teeth

Notes

- the saw blade is optimized according to the LEUCO company standards as well as according to the customers specifications and machine parameters after consultation with the technical engineering
- Ident-No. is only for orientation

Ø D	B	b	b1	Ø D1	Ø d	Z	Ident-No. [L]	Ident-No. [R]
560	5,0	3.6	5.8	485	405	48-4	80317242 S	80317243 S
605	4,4	3.2	6.0	540	440	48	80294208 S	80294209 S
620	5,0	3.8	5.0	540	450	60-3	80206577 S	80206581 S
630	4,4	3.2	6.0	539	440	48-3	80274257 S	80274262 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

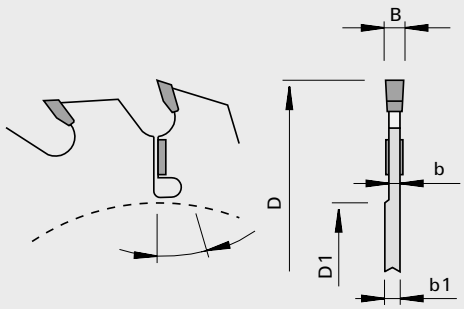
101315 / 101317

Pre-Cut Gang-Rip Saw Blades HW with HW-rakers “F” - Linck

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- primary machines with and without chippers
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat “F”
- cutting material: HW HL Board 20
- type A and C with staggered double keyways

Advantages

- extremely high bending strength and hardness of the teeth
- tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
- staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

- the saw blade is optimized according to the LEUCO company standards as well as according to the customers specifications and machine parameters after consultation with the technical engineering
- Ident-No. is only for orientation

Ø D	B	b	b1	Ø D1	Ø d	Z	Number of rakers	NL	DKN		Ident-No. [L]	Ident-No. [R]
445	4,8	3.2	6.8	190	120	28	4	4/13/156		Linck VS	80250724 S	80250723 S
470	5,0	3.6	6.8	190	120	28	6	8/13/156		Linck VS	80290358 S	80290357 S
505	5,6	3.8	6.8	190	120	28	4	8/14,5/156		Linck VS	80281372 S	80281373 S
520	5,0	3.2			110	32	6	12/13/140		Linck VS	80269113 S	80269113 S
525	5,6	4.0	6.8	190	120	24	6	6/13/156		Linck VS	80307585 S	80307584 S
525	4,8	3.2	6.8	240	160	28	6	6/12/210		Linck VS	80279581 S	80279579 S
540	4,2	2.8	5.1	235	145	24	6	8/12,5/165	20x7	Linck CSMK 285	80245193 S	80245192 S
540	5,0	3.4	6.8	205	150	24	6	8/12/180		Linck CSMK 285	80268479 S	80268478 S
540	4,8	3.2	6.8	205	150	28	6	8/11/180		Linck CSMK 285	80283376 S	80283375 S
540	5,2	3.4	6.8	205	150	28	6	8/12/180		Linck CSMK 285	80333677 S	80333678 S
550	5,2	3.5			120	24	6	8/18/155		Linck VS	80254383 S	80254381 S
580	5,0	3.2	5.2	250	145	32	6	8/12/165	20x5	Linck CSMK 325	80333690 S	80333692 S
648	5,6	3.8	6.8	210	160	24	8	8/11/185		Linck CSMK 375	80250585 S	80250584 S
695	5,0	3.4	6.8	350	170	50	8	12/12/195	20x5	Linck CSMK 425	80258266 S	80258264 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]		[mm]			

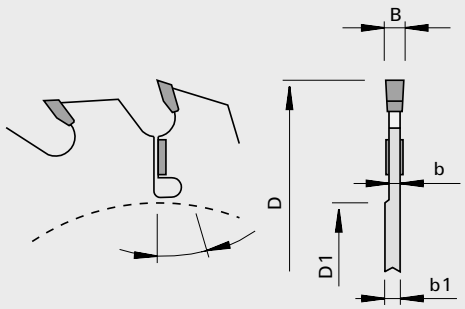
101317

Pre-Cut Gang-Rip Saw Blades HW with HW-rakers “F” - EWD

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- primary machines with and without chippers
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat “F”
- cutting material: HW HL Board 20
- type A and C with staggered double keyways

Advantages

- extremely high bending strength and hardness of the teeth
- tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
- staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

- the saw blade is optimized according to the LEUCO company standards as well as according to the customers specifications and machine parameters after consultation with the technical engineering
- Ident-No. is only for orientation

Ø D	B	b	b1	Ø D1	Ø d	Z	Number of rakers	NL	DKN		Ident-No. [L]	Ident-No. [R]
560	4,8	3.2	7.0	220	150	32	6	6/10,25/175		EWD FR 15	80291675 S	80291674 S
565	5,2	3.4	7.0	205	160	42	6	6/11/182,5 + 12/8,5/182,5	22,2x5,4	EWD DWK	80297832 S	80297833 S
580	4,1	2.8	5.5	300	160	32	6	6/12/182,5	23x6	EWD DWK	80309039 S	80309038 S
590	5,2	3.4	7.2	205	160	22	6	6/11/182,5 + 6/8,5/182,5	23x6	EWD FR 22	80309372 S	80309371 S
600	5,0	3.4	6.0	240	145	36	6	6/16/208 + 6/16/180	20x9,5	EWD VNK 300	80290174 S	80290175 S
610	5,0	3.2	6.0	240	145	36	6	6/16/208 + 6/16/180	20x9,5	EWD VNK 300	80306576 S	80306587 S
630	5,4	3.8	7.0	200	150	24	6	8/8,5/175 + 2/10,2/175	37x4	EWD FR 16	80143865 S	80143864 S
630	5,4	3.8	7.0	200	150	36	6	8/8,5/175	36,5x4	EWD FR 16	80359234 S	80359233 S
630	5,2	3.6	4.5	200	150	28	8		36,5x4	EWD FR 16	80300918 S	80300915 S
640	5,6	3.8	7.0	205	160	28	6	6/11/182,5 + 12/8,5/182,5	23x6	EWD DWK	80289037 S	80289036 S
700	5,2	3.8	6.0	190	125	32	6	8/16/160 + 4/18/165		EWD BNK 6	80278892 S	80278891 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]		[mm]			

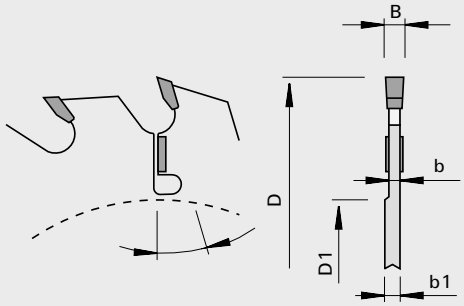
101317

Pre-Cut Gang-Rip Saw Blades HW with HW-rakers “F” - Möhringer

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- primary machines with and without chippers
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat “F”
- cutting material: HW HL Board 20
- type A and C with staggered double keyways

Advantages

- extremely high bending strength and hardness of the teeth
- tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
- staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

- the saw blade is optimized according to the LEUCO company standards as well as according to the customers specifications and machine parameters after consultation with the technical engineering
- Ident-No. is only for orientation

Ø D	B	b	b1	Ø D1	Ø d	Z	Number of rakers	NL		Ident-No. [L]	Ident-No. [R]
595	5,2	3.6	6.8	190	105	20	6	8/13/156	Möhringer	80293989 S	80293990 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]				

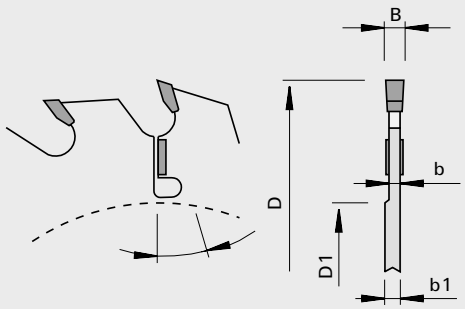
101315 / 101317

Re-Cut Gang-Rip Saw Blades HW with HW-rakers “F” - Linck

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- multi-blade machines with or without chipper
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat “F”
- cutting material: HW HL Board 20
- type A and C with staggered double keyways

Advantages

- extremely high bending strength and hardness of the teeth
- tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
- staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

- the saw blade is optimized according to the LEUCO company standards as well as according to the customers specifications and machine parameters after consultation with the technical engineering
- Ident-No. is only for orientation

Ø D	B	b	b1	Ø D1	Ø d	Z	Number of rakers	DKN		Ident-No.
520	3,6	2.2			150	36	4	37x10	Linck MKV	80231924 S
520	4,6	3.2			150	28	6	37x10	Linck MKV	80255324 S
540	4,8	3.4			150	24	4	37x10	Linck MKV	80254014 S
540	4,4	2.8	4.9	230	150	28	6	37x10	Linck MKV	80259614 S
540	3,2	2.0			150	46	4	37x10	Linck MKV	80273199 S
540	3,4	2.1	3.9	345	150	45	6	37x10	Linck MKV	80337192 S
540	4,0	2.6			150	36	6	36,5x9	Linck MKV	80293102 S
540	4,0	2.6			150	30	6	36,5x9	Linck MKV	80307378 S
545	2,8	1.8			150	57	3	37x10	Linck MKV	80326780 S
570	4,8	3.4			150	20	6	37x10	Linck MKV	80270360 S
570	3,2	2.2	4.6	400	150	54	6	37x10	Linck MKV	80293546 S
570	2,9	1.9	3.9	400	150	56	6	37x10	Linck MKV	80332037 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	[mm]		

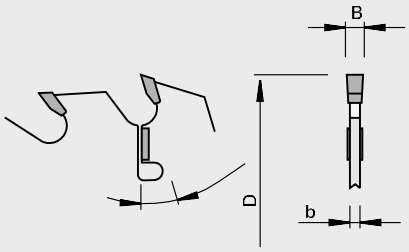
101315

Re-Cut Gang-Rip Saw Blades HW with HW-rakers “F” - EWD

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- multi-blade machines with or without chipper
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat “F”
- cutting material: HW HL Board 20
- type A and C with staggered double keyways

Advantages

- extremely high bending strength and hardness of the teeth
- tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
- staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

- the saw blade is optimized according to the LEUCO company standards as well as according to the customers specifications and machine parameters after consultation with the technical engineering
- Ident-No. is only for orientation

Ø D	B	b	Ø d	Z	Number of rakers	DKN		Ident-No.
450	3,8	2.5	110	24	4	17x8	EWD FR	80264025 S
450	4,2	2.7	150	36	4	37x7	EWD	80225333 S
500	4,4	3.0	150	24	4	37x7	EWD FR12	80236978 S
520	4,9	3.4	150	24	6	36,5x4	EWD FR12	80291680 S
520	4,9	3.4	150	48	6	36,5x4	EWD FR12	80291939 S
520	4,9	3.4	150	32	6	36,5x4	EWD FR12	80308059 S
[mm]	[mm]	[mm]	[mm]		[pc.]	[mm]		

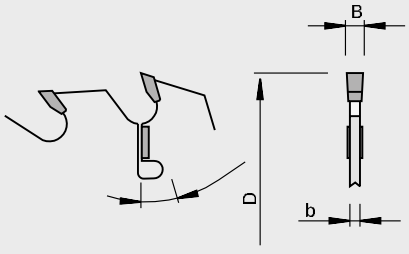
101316

Re-Cut Gang-Rip Saw Blades HW with HW-rakers “F” - HewSaw

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- multi-blade machines with or without chipper
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat “F”
- cutting material: HW HL Board 20

Advantages

- extremely high bending strength and hardness of the teeth
- tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
- staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

Ø D	B	b	Ø d	Z	Number of rakers		Ident-No.
351	4,4	3.2	70	24	2+2	HewSaw	192611 L
[mm]	[mm]	[mm]	[mm]		[pc.]		

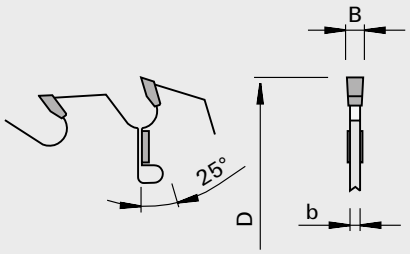
101315

Gang-Rip Saw Blades HW with HW-rakers “F” - for profiling aggregate HewSaw

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- profiling machines HewSaw
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat “F”
- cutting material: HW HL Board 10
- circular saw blades with different openings

Advantages

- extremely high bending strength and hardness of the teeth

Notes

Ø D	B	b	Ø d	Z	Number of rakers	NL	Ident-No.
351	4,6	3.2	70	24	2	1/6,3/100	80366486 C
351	4,6	3.2	70	24	2	1/6,3/100	80371233 C
[mm]	[mm]	[mm]	[mm]		[pc.]		

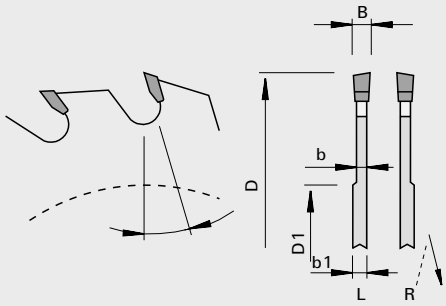
101353

Gang-Rip Saw Blades HW “ES” - for profiling aggregate HewSaw

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- profiling machines HewSaw
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: top bevel “ES”
- cutting material: HW HL Board 20

Advantages

- extremely high bending strength and hardness of the teeth

Notes

Ø D	B	b	b1	Ø D1	Ø d	Z	DKN	Free slots	Ident-No. [L]	Ident-No. [R]
250	5,2	3.6	6.0	115	70	24-6	20x8	3	80363728 S	80363727 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[pc.]		

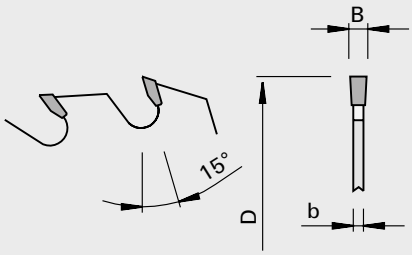
101310

Gang-Rip Saw Blades HW “F” - for Linck VPM profiling aggregate

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- Linck VPM profiling aggregate
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat “F”
- cutting material: HW HL Board 20

Advantages

- extremely high bending strength and hardness of the teeth

Notes

Ø D	B	b	Ø d	Z	Ident-No.
566	5,0	4.0	80	36	80350084 S
[mm]	[mm]	[mm]	[mm]		

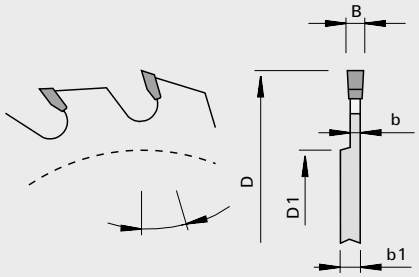
116313

HW Segments - for Linck VPM profiling aggregate

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- Linck VPM profiling aggregate
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat "F"
- cutting material: HW HL Board 20

Advantages

- extremely high bending strength and hardness of the teeth

Notes



Ø D	B	b	Ø D1	b1	Z	Ident-No. [L]	Ident-No. [R]
414 [mm]	3,5 [mm]	2.5 [mm]	360 [mm]	8 [mm]	10	80334874 S	80335077 S



Ø D	B	b	Ø D1	b1	Z	Ident-No. [L]	Ident-No. [R]
497 [mm]	3,5 [mm]	2.5 [mm]	446 [mm]	8 [mm]	8	80333596 S	80335075 S



Ø D	B	b	Ø D1	b1	Z	Ident-No. [L]	Ident-No. [R]
499.4 [mm]	3,5 [mm]	2.5 [mm]	446 [mm]	7 [mm]	10	80350396 L	80350395 L



Ø D	B	b	Ø D1	b1	Z	Ident-No. [L]	Ident-No. [R]
498.2 [mm]	3,5 [mm]	2.5 [mm]	447 [mm]	7 [mm]	11	80371097 S	80371098 S

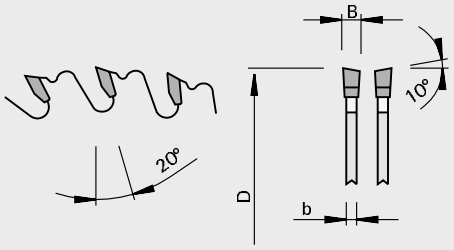
101725

Gang-Rip Saw Blades HW with internal HW-rakers - solid “WS”

Product



Drawing



LEUCO solid

LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- table saws
- climb-cutting rip saws
- suitable for manual feed
- for ripping and cross cuts in wet and dry solid woods

Design

- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 20
- 4 internal spurs HW

Advantages

- tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
- chip limiter design for universal application

Notes

- for inquiries / orders enclose specification sheet (see appendix)

Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of rakers	NL	Ident-No.
350	3,5	2.5	30	70	140	24	2+2	2/7/42 + 2/9,5/46,5 + 2/10/60	189643 L
400	3,5	2.5	30	80	160	28	2+2	2/7/42 + 2/9,5/46,5 + 2/10/60	189644 L
450	4,2	2.8	30	80	160	36	2+2	2/7/42 + 2/9,5/46,5 + 2/10/60	189645 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]		

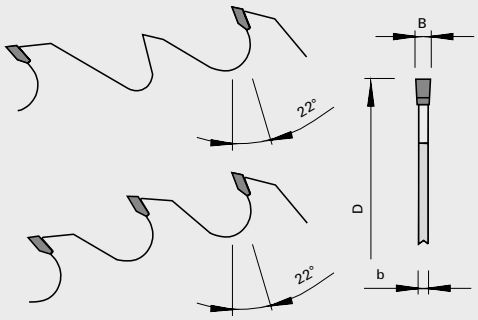
101315

Gang-Rip Saw Blades HW with HW-rakers - topline solid “F”

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- Gang rip machine with low feed rates
- Gang-rip machines with one or two shafts
- for longitudinal cuts in wet and dry solid woods

Design

- Tooth configuration: flat tooth “F”
- Cutting material: HW HL Board 20
- with internal and external HW rakers
- Body with and without clean out tooth

Advantages

- tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
- optimal chip evacuation thanks to special design
- particularly robust design

Notes

Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of rakers		Ident-No.
300	3,4	2.0	50	90	130	20	2+2		193265 L
350	4,2	2.8	50	100	140	18+18	2+2	Clean out tooth	193266 L
350	4,0	2.5	50	100	140	20	2+2		193267 L
400	4,4	3.0	50	100	150	18+18	2+2	Clean out tooth	193268 L
400	4,4	3.0	50	100	150	24	2+2		193269 L
450	4,8	3.3	50	100	160	18+18	2+2	Clean out tooth	193270 L
450	4,8	3.3	50	100	160	24	2+2		193271 L
500	5,0	3.5	50	100	180	18+18	4+2	Clean out tooth	193272 L
500	5,0	3.5	50	100	180	28	4+2		193273 L
550	5,2	3.6	50	140	180	18+18	4+2	Clean out tooth	193274 L
600	5,8	4.2	50	140	180	28	4+2		193275 L
630	6,0	4.2	50	140	180	18+18	4+2	Clean out tooth	193276 L
630	6,0	4.2	50	140	180	28	4+2		193277 L
650	6,0	4.2	50	140	180	18+18	4+2	Clean out tooth	193278 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]		

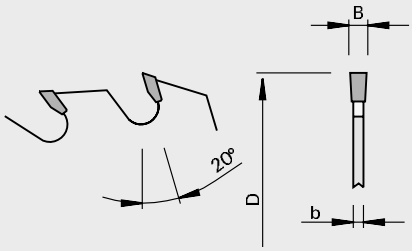
101310

Gang-Rip Saw Blades HW with cooling slots “F”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- molders
- gang-rip saw with one or two shafts (e.g. Raimann, Paul, Costa, ...)
- for precise ripping cuts in dry and planed hard woods

Design

- tooth configuration: flat “F”
- cutting material: HW HL Board 10

Advantages

- special design and tungsten carbide grade for highest cutting quality and very long edge lives

Notes

- for inquiries / orders enclose specification sheet (see appendix)

Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of cooling slots	DKN	NL	Ident-No.
250	3,4	2.2	30	80	120	24	3			189275 L
300	3,4	2.2	80	100	140	28	4	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100	189276 L
300	3,4	2.2	30	100	130	28	4			189277 L
350	3,6	2.4	30	100	140	32	4			189279 L
350	3,6	2.4	80	100	140	32	4	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100	189280 L
500	4,0	2.8	30	100	165	40	4			189282 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	[mm]		

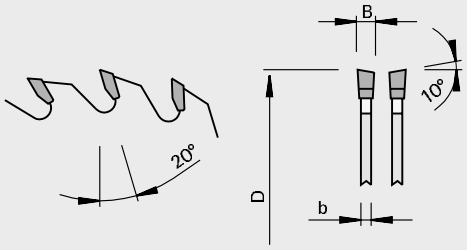
101320

Gang-Rip Saw Blades HW “WS”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- molders
- gang-rip saws with one or two shafts
- for precise ripping cuts in dry and planed solid woods and wood-based materials

Design

- staggered double keyways of type A and C
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 06 for wood-based materials
- cutting material: HW HL Board 20 for solid woods

Advantages

- staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

- larger bore (max. Ø 100 in) available for a surcharge
- for inquiries / orders enclose specification sheet (see appendix)

Ø D	B	b	Ø d	Z	DKN	NL		LEUCODUR	Ident-No.
190	3,4	2.2	30	20				HL Board 20	188049 L
200	3,2	2.2	60	34			Paul	HL Board 06	188038 L
200	3,2	2.2	60	42			Paul	HL Board 06	188041 L
210	3,2	2.2	100	34	12,5x4			HL Board 06	189283 L
220	3,4	2.2	50	24				HL Board 20	188051 L
300	3,2	2.2	80	28	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100		HL Board 20	188054 L
300	3,2	2.2	70	36	20x5			HL Board 20	189285 L
300	3,2	2.2	80	36	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100		HL Board 20	189286 L
300	3,2	2.2	70	48	20x5			HL Board 20	189287 L
[mm]	[mm]	[mm]	[mm]		[mm]				

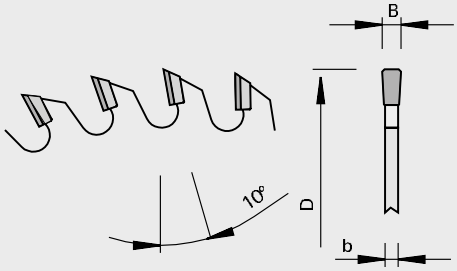
203049

Gang-Rip Saw Blades DP “F-FA” - nn-System

Product



Drawing



LEUCO nn system

LEUCO DIA

Polycrystalline diamond [DP]

NoNoise-KSN

Machine / Application

- gang-rip machines Paul, Homag
- for trimming cuts in raw and laminated panels and composite materials

Design

- tooth configuration: flat with chamfer “F-FA”

Advantages

- especially low noise level

Notes

- for saw blade Ø d=110 mm please use hydro bushing Ident-No. 183829 / 183821

Ø D	B	b	Ø d	Z	NL		Ident-No.
250	2,4	1.6	100	48	3/18/150	Paul, Homag	193337 C
250	1,8	1.2	100	48	3/18/150	Paul, Homag	193339 C
[mm]	[mm]	[mm]	[mm]				

Ø D	B	b	Ø d	Z	NL		Ident-No.
250	2,4	1.6	110	48	8/8,5/130	Paul, Homag	193336 C
250	1,8	1.2	110	48	8/8,5/130	Paul, Homag	193338 C
[mm]	[mm]	[mm]	[mm]				

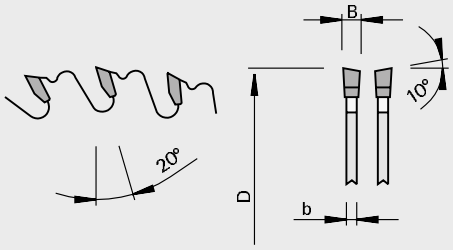
101320

Trimming Saw Blades HW - with chip limiter “WS” - topline

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application
- Table saws
- Suitable for manual feed
- for sizing cuts in solid woods
- especially for knotty woods

Design
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 20

Advantages
- no chipped edges from knots thanks to chip limiter
- noise-reduction thanks to laser ornaments

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
300	3,2	2.2	30	28	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	193240 L
350	3,5	2.5	30	32	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	193241 L
400	4,0	2.8	30	36	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	193242 L
450	4,4	3.0	30	40	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	193243 L
500	4,4	3.2	30	44	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	193244 L
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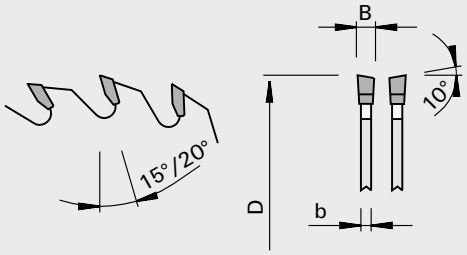
101620/107520

Trimming Saw Blades HW “WS”

Product



Drawing



LEUCO highline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application
- table saws
- for sizing cuts in solid woods

Design
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 10

Advantages
- noise-reduction thanks to laser ornaments for saw blades of more than Ø 250 mm

Notes
- larger bore (max. Ø 80 mm) available for a surcharge

Ø D	B	b	Ø d	Z	Hook angle	NL	Class-No.	Ident-No.
200	3,2	2.2	30	24	20	2/7/42	107520	189932 L
250	3,2	2.2	30	24	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189933 L
250	4,4	2.8	30	20	15	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189934 C
300	3,2	2.2	30	24	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189935 L
300	3,2	2.2	30	28	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189936 L
300	3,2	2.2	30	36	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189937 L
350	3,5	2.5	30	24	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189938 L
350	3,5	2.5	30	32	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189939 L
350	3,5	2.5	30	36	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189940 L
350	4,4	2.8	30	28	15	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189941 L
400	3,5	2.5	30	28	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189942 L
400	3,5	2.5	30	36	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189943 L
450	3,8	2.8	30	40	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189944 L
500	3,8	2.8	30	44	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189945 L
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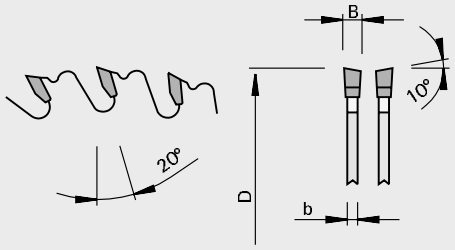
101620

Trimming Saw Blades HW - with chip limiter “WS”

Product



Drawing



LEUCO highline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- table saws
- special saws
- for sizing cuts in solid woods
- especially for knotty woods

Design

- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 10

Advantages

- no chipped edges from knots thanks to chip limiter
- noise-reduction thanks to laser ornaments

Notes

- larger bore (max. Ø 80 mm) available for a surcharge

Ø D	B	b	Ø d	Z	NL	Ident-No.
250	3,2	2.2	30	24	2/7/42 + 2/9,5/46,5 + 2/10/60	189946 L
300	3,2	2.2	30	28	2/7/42 + 2/9,5/46,5 + 2/10/60	189947 L
315	3,2	2.2	30	28	2/7/42 + 2/9,5/46,5 + 2/10/60	189948 L
350	3,5	2.5	30	32	2/7/42 + 2/9,5/46,5 + 2/10/60	189949 L
400	3,5	2.5	30	36	2/7/42 + 2/9,5/46,5 + 2/10/60	189950 L
450	3,8	2.8	30	40	2/7/42 + 2/9,5/46,5 + 2/10/60	189951 L
500	3,8	2.8	30	44	2/7/42 + 2/9,5/46,5 + 2/10/60	189952 L
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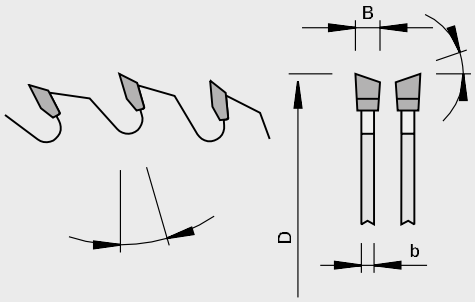
101320

Sizing Saw Blades HW “WS” - Weinmann

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- joinery machines
- special machines
- for sizing cuts in wood-based panels
- for clipping and miter cuts in solid woods and wood-based panels

Design

- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 20

Advantages

Notes

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner		Ident-No.
230	3,2	2.2	40	40	8/5,5/52	10	15	Weinmann	192427 L
240	3,0	2.0	40	30	8/6/52	10	15	Weinmann	192428 L
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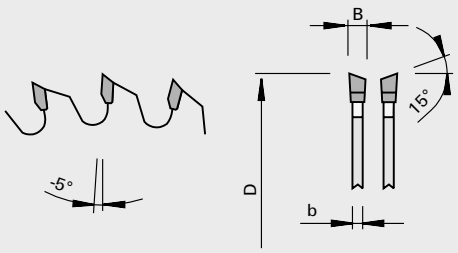
101320 / 102328

Trimming and sizing saw blades HW “WS” - easyFix

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

easyFix

Machine / Application

- chop and miter saws
- For cross cuts in solid wood and wood-based materials

Design

- Tooth configuration: alternate top bevel “WS”
- Cutting material: HW
- Class-No. 101320 HL Board 20 for wood-based materials
- Class-No. 102328 HL Board 06 for solid wood

Advantages

- easyFix: NEW, EASY HANDLING, easy and smooth mounting of the saw blade on the machine despite high-precision bore tolerance
- High cutting quality and safe handling thanks to negative hook angle
- Noise reduction thanks to laser ornaments

Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
300	3,2	2.2	40	72	2/9/55 + 4/12/64	Graule	193245 L
350	3,4	2.2	40	42	2/9/55 + 4/12/64	Graule	193246 L
350	3,2	2.2	40	72	2/9/55 + 4/12/64	Graule	193247 L
420	4,0	2.8	40	54	2/9/55 + 4/12/64	Graule	193248 L
420	3,5	2.5	40	84	2/9/55 + 4/12/64	Graule	193249 L
520	4,4	3.2	50	60	2/9/55 + 4/12/64	Graule	193250 L
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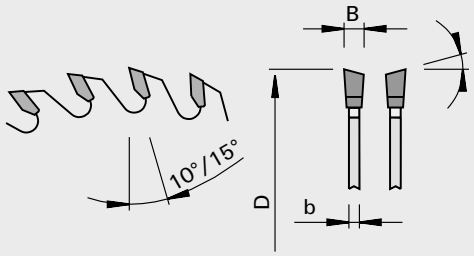
102620/102628/107520

Sizing Saw Blades HW “WS”

Product



Drawing



LEUCO highline

LEUCO DUR

Tungsten Carbide [HW]

LOW NOISE

Machine / Application

- table saws
- special saws
- for sizing cuts in wood-based panels

Design

- tooth configuration: alternate top bevel “WS”
- cutting material: HW
- Class-No. 107520 HL Board 10, hook angle 15°
- Class-No. 102620/102628 HL Board 06, hook angle 10°

Advantages

- optimum cutting quality, feed rate and adjustment for material thickness thanks to various numbers of teeth
- noise-reduction thanks to laser ornaments from Ø 250 mm upwards

Notes

- larger bore (max. Ø 80 mm) available for a surcharge

Ø D	B	b	Ø d	Z	KN	NL	Class-No.	Ident-No.
150	3,2	2.2	30	24		2/7/42	107520	189953 L
150	3,2	2.2	30	36		2/7/42	102620	189954 L
150	3,2	2.2	30	48		2/7/42	102620	189955 L
180	3,2	2.2	30	30		2/7/42	107520	189956 L
180	3,2	2.2	30	54		2/7/42	102620	189957 L
200	3,2	2.2	30	34		2/7/42	107520	189958 L
200	3,2	2.2	30	48		2/7/42	102620	189959 L
200	3,2	2.2	30	64		2/7/42	102620	189960 L
250	3,2	2.2	30	40		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189961 L
250	3,2	2.2	30	48		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189962 L
250	3,2	2.2	30	60		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189963 L
250	3,2	2.2	30	80		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189964 L
300	3,2	2.2	30	48		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189965 L
300	3,2	2.2	30	60		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189966 L
300	3,2	2.2	30	72		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189967 L
300	3,2	2.2	30	96		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189968 L
315	3,2	2.2	30	48		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189969 L
315	3,2	2.2	30	72		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189970 L
350	3,5	2.5	30	54		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189971 L
350	3,5	2.5	30	72		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189972 L
350	3,5	2.5	30	84		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189973 L
350	3,5	2.5	30	108		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189974 L
400	3,5	2.5	30	60		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189975 L
400	3,5	2.5	30	84		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189976 L
400	3,5	2.5	30	96		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189977 L
400	3,5	2.5	30	120		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189978 L
400	3,5	2.5	50	60	8x8,2	2/10/60	102628	189979 O
450	3,8	2.8	30	66		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189980 L
500	3,8	2.8	30	72		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189981 L
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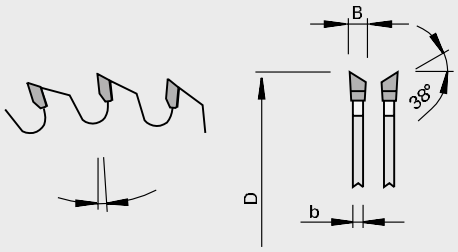
102628

Sizing Saw Blades HW “WS - profiles, ledges and plastic profiles

Product



Drawing



LEUCO highline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- chop and miter saws
- table saws
- for sizing and trimming cuts in wood-based panels

Design

- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 06

Advantages

- chip-free cutting without using a scoring aggregate thanks to 38 degree ATB
- noise-reduction thanks to laser ornaments

Notes

- for profiles, ledges and plastic profiles

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
250	3,2	2.2	30	80	2/7/42 + 2/9,5/46,5 + 2/10/60	-2	189982 L
300	3,2	2.2	30	96	2/7/42 + 2/9,5/46,5 + 2/10/60	2	189983 L
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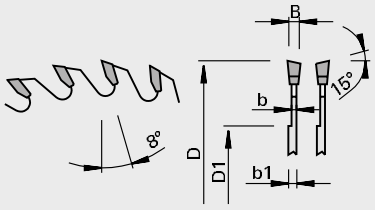
102323

Sizing Saw Blades HW - thin rim design of the steel plate “WS”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- table saws
- machines Scheer FM
- for sizing cuts in thin-walled plastic profiles and veneers

Design

- extra thin rim design of the steel plate
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 06

Advantages

- improved stability thanks to relieved tool body

Notes

Ø D	B	b1	b	Ø D1	Ø d	Z	NL	Ident-No.
160	1,8	2.2	1.0	80	16	48	2/7,5/31,5	188209 L
180	1,6	2.2	1.0	105	16	56	1/6/33	188210 L
250	1,7	2.2	1.0	170	30	80		188211 L
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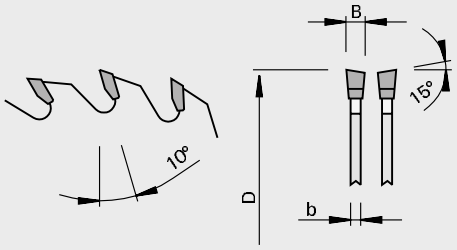
102321

Sizing Saw Blades HW - thin “WS” - wood-based panels

Product



Drawing



Tungsten Carbide [HW]

Machine / Application
- chop and miter saws
- table saws
- for clipping and miter cuts in solid woods, mainly in MDF
- for cross cutting of profiles (e.g. plastic profiles)

Design
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 03 plus

Advantages
- long edge lives

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
150	2,4	1.8	30	48		189699 L
180	2,4	1.8	30	60		189700 L
200	2,4	1.8	30	64		189701 L
250	2,4	1.8	30	80	2/7/42 + 2/9,5/46,5 + 2/10/60	189702 L
300	2,4	1.8	30	96	2/7/42 + 2/9,5/46,5 + 2/10/60	189704 L
300	2,6	2.2	30	96	2/7/42 + 2/9,5/46,5 + 2/10/60	189705 L
350	2,6	2.2	30	108	2/7/42 + 2/9,5/46,5 + 2/10/60	189706 L
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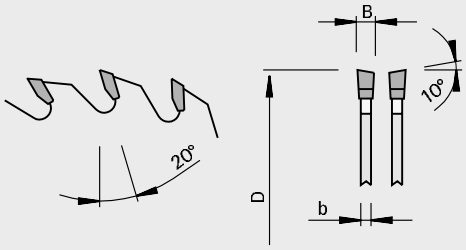
102321

Sizing Saw Blades HW - thin “WS” - solid woods

Product



Drawing



Tungsten Carbide [HW]

Machine / Application
- table saws
- sizing saws
- cut-off saws
- for sizing and clipping cuts in solid woods

Design
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 06

Advantages

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
180	2,4	1.8	30	30		188064 L
200	2,4	1.8	30	32		188065 L
250	2,4	1.8	30	40	2/7/42 + 2/9,5/46,5 + 2/10/60	188067 L
300	2,4	1.8	30	48	2/7/42 + 2/9,5/46,5 + 2/10/60	188068 L
350	2,6	2.0	30	54	2/7/42 + 2/9,5/46,5 + 2/10/60	188069 L
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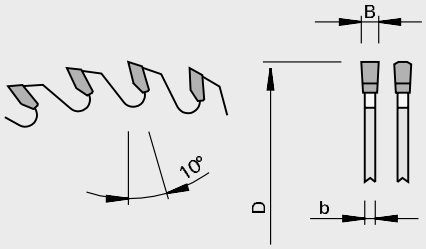
102678

Sizing Saw Blades HW “TR-F” - hook angle 10°

Product



Drawing



LEUCO highline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application

- table saws
- vertical panel sizing saws
- for sizing cuts in plastic-laminated panels

Design

- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 06

Advantages

- noise-reduction thanks to laser ornaments

Notes

- larger bore (max. Ø 50 mm) available for a surcharge

Ø D	B	b	Ø d	Z	NL	Ident-No.
250	3,2	2.2	30	80	2/7/42 + 2/9,5/46,5 + 2/10/60	189984 L
300	3,2	2.2	30	72	2/7/42 + 2/9,5/46,5 + 2/10/60	189985 L
300	3,2	2.2	30	96	2/7/42 + 2/9,5/46,5 + 2/10/60	189986 L
350	3,5	2.5	30	96	2/7/42 + 2/9,5/46,5 + 2/10/60	189987 L
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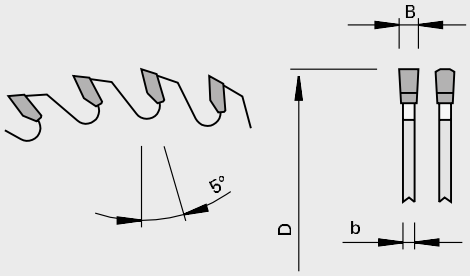
102678

Sizing Saw Blades HW “TR-F” - hook angle 5°

Product



Drawing



LEUCO highline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application

- table saws
- vertical panel sizing saws
- for sizing cuts in plastic-laminated panels

Design

- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 06

Advantages

- improved bottom edge (without scoring sawblade) thanks to 5 degree hook angle
- noise-reduction thanks to laser ornaments

Notes

- larger bore (max. Ø 50 mm) available for a surcharge

Ø D	B	b	Ø d	Z	NL	Ident-No.
250	3,2	2.2	30	80	2/7/42 + 2/9,5/46,5 + 2/10/60	189988 L
300	3,2	2.2	30	96	2/7/42 + 2/9,5/46,5 + 2/10/60	189989 L
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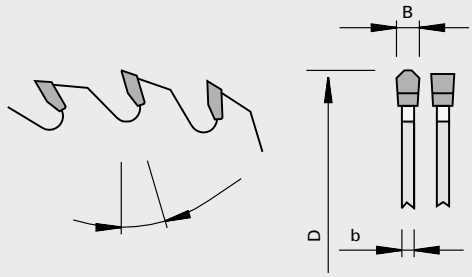
102378

Sizing Saw Blades HW “TR-F” - magnet bond boards

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

LOW NOISE

Machine / Application

- table saws
- horizontal panel sizing saws
- for sizing cuts in magnet bond boards or panels with thin steel foils
- for single or stack cuts

Design

- tooth configuration: triple chip / flat “TR-F”
- cutting material: special HW grade HL Steel 17

Advantages

- noise reduction thanks to laser ornaments
- spark-reduced cutting

Notes

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
350	3,2	2.5	30	110	2/7/42 + 2/9/46 + 2/10/60	5	192609 L
350	4,4	3.2	30	72		10	192610 L
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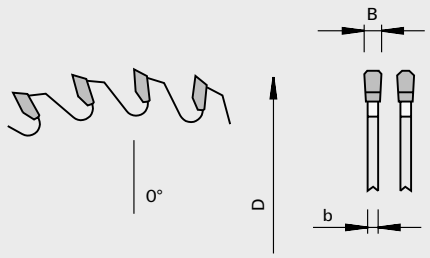
102388

Sizing Saw Blades HW - solid Surface “TR-F-FA”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

LOW NOISE

Machine / Application

- table saws
- vertical panel sizing saws
- especially for the machining of solid surface materials and hard wood-based panels such as Corian®, compact boards, ...

Design

- with laser ornaments
- tooth configuration: triple chip / flat with chamfer “TR-FA”
- cutting material: HW HL Board 06

Advantages

- less vibration and noise thanks to laser ornaments

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
303	3,2	2.5	30	84	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	193133 L
[mm]	[mm]	[mm]	[mm]			

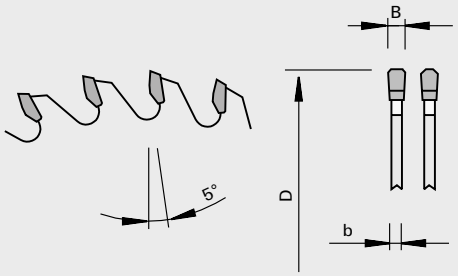
102388

Sizing Saw Blades HW “TR-F-FA” - plastics

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application
- table saws
- vertical panel sizing saws
- for finish cuts in varying thermoplastic materials

Design
- with laser ornaments
- tooth configuration: triple chip / flat with chamfer “TR-F-FA”
- cutting material: HW HL Board 06

Advantages
- less vibration and noise thanks to laser ornaments

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
303	3,2	2.2	30	84	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	193109 L
[mm]	[mm]	[mm]	[mm]			

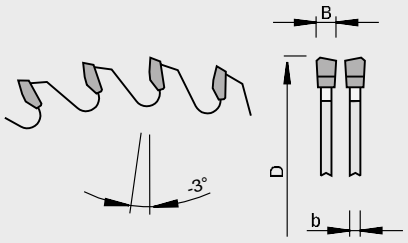
102388

Sizing Saw Blades HW “WS-FA” - plastics

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application
- table saws
- vertical panel sizing saws
- for finish cuts in varying thermoplastic materials, even with thickness > 15mm

Design
- saw blade body coating: non-stick effect and corrosion protection
- with laser ornaments
- tooth configuration: alternate top bevel with chamfer “WS-FA”
- cutting material: HW HL Board 06

Advantages
- thinner cutting width for reduced cutting pressure, also in thicker materials
- less vibration and noise thanks to laser ornaments

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
303	2,8	2.2	30	96	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	193378 L
[mm]	[mm]	[mm]	[mm]			

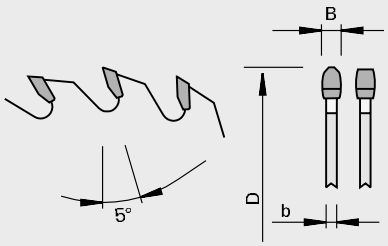
102388

Sizing Saw Blades HW “TR-F K” - anti fingerprint

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- table saws
- vertical panel sizing saws

Design

- with laser ornaments
- tooth configuration: TR-F K
- cutting material: HW HL Board 04 plus

Advantages

- excellent cutting quality in “anti fingerprint” materials and for conventional plastics
- no scoring on the cutting surface due to convex tooth sides
- no flares on the surface of sensible materials
- less vibration and noise thanks to laser ornaments

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
300	3,2	2.2	30	84	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	193195 L
[mm]	[mm]	[mm]	[mm]			

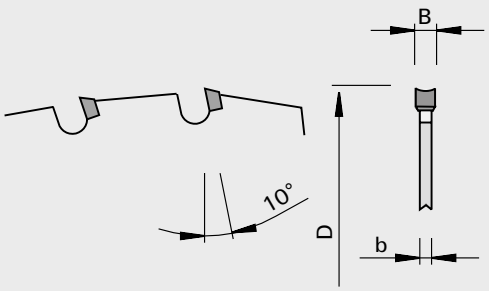
202289

Sizing Saw Blades DP “HR” - nn-System DP flex

Product



Drawing



LEUCO nn system

DP FLEX

Polycrystalline diamond [DP]

NO

Machine / Application

- sizing saws and table saws
- Vertical panel sizing saws
- clipping saws
- for precise cutting in all common wood-based panels such as raw and laminated particle and MDF boards, plywood boards, HDF, WPC, cement and gypsum fiber boards, mineral composites, Alucobond, ...
- for ripping and cross cuts in solid wood, glued laminated timber, thermotreated wood

Design

- resharpenable up to 2 times
- small gullets
- special cutting edge geometry
- tooth configuration: hollow back tooth ”HR”
- cutting material: DP

Advantages

- hardly perceivable noise level
- highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping
- reduced cutting pressure thanks to hollow back tooth geometry

Notes

- it is not recommended to use the saw blades for longitudinal cuts in soft wood and material thicknesses of more than 40 mm
- chip-free cuts can only be guaranteed in combination with a suitable scoring saw blade
- Attention! for these saw blades the thickness of the splitting wedge must range between 2.0 and 2.4 mm
- included in delivery: splitting wedge must be ordered separately

Ø D	B	b	Ø d	Z	NL	Ident-No.
250	2,5	2.0	30	50	2/7/42 + 2/9/46 + 2/10/60 + 8/5,2/90	192440 L
254	2,5	2.0	15,875	50		192441 L
260	2,5	2.0	30	60	2/7/42 + 2/9/46 + 2/10/60	192442 L
280	2,5	2.0	30	60	2/7/42 + 2/9/46 + 2/10/60	192443 L
303	2,5	2.0	30	60	2/7/42 + 2/9/46 + 2/10/60 + 8/5,2/90	192444 L
303	2,5	2.0	30	95	2/10/60 + 2/9/46 + 2/9/46,5 + 2/7/42	193238 L
315	2,5	2.0	30	64	2/7/42 + 2/9/46 + 2/10/60	192445 L
350	2,5	2.0	30	72	2/7/42 + 2/9/46 + 2/10/60 + 8/5,2/90	192446 L
[mm]	[mm]	[mm]	[mm]			

Accessories	B	For Ø D	for machine	Class-No.	PU	Ident-No.
Splitting wedge	2,25	240-250	HOLZ-HER Vertikal	985500	1	192429 L
Splitting wedge	2,25	250-350	Martin T60A	985500	1	192535 L
Splitting wedge	2,25	300	Putsch	985500	1	192457 L
Splitting wedge	2,25	300-350	Altendorf F45	985500	1	192425 L
Splitting wedge	2,25	300-350	Striebig Standard III Control Evolution	985500	1	192430 L
Splitting wedge	2,25	300-350	Striebig Standard Eco	985500	1	192431 L
	[mm]	[mm]				

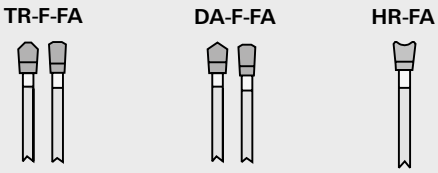
202180

DIAREX Sizing Saw Blades DP

Product



Drawing



LEUCO DIAREX

Polycrystalline diamond [DP]

LOW

Machine / Application

- table saws
- vertical panel sizing saws
- for finish cuts in varying materials

Design

- resharpening area 2.0 mm
- cutting material: DP in different designs depending on the application

Advantages

- long edge lives thanks to tooth group with higher number of quality-forming cutting edges
- less vibration and noise thanks to laser ornaments

Notes



TR-F-FA
- universal and robust geometry
- for melamine-laminated or HPL-laminated wood-based materials as well as composites associated with scoring saw blades
- very good suited for mineral materials



DA-F-FA
for finish cuts in melamine-laminated and HPL-laminated wood-based plates associated with scoring saw blades



HR-FA
- excellent cut quality (on top) thanks to pre-scoring effect and reduced cutting pressure
- well suited for magnet bond boards
- very well suited for thin plates made of CFRP and GFRP

Ø D	B	b	Ø d	Z	NL	Tooth geometry	Ident-No.
250	3,2	2.2	30	48	2/7/42 + 2/9/46 + 2/10/60	TR-F-FA	192955 L
303	3,2	2.2	30	60	2/7/42 + 2/9/46 + 2/10/60	TR-F-FA	192957 L
303	3,2	2.2	30	84	2/7/42 + 2/9/46 + 2/10/60	TR-F-FA	192960 L
350	3,2	2.2	30	60	2/7/42 + 2/9/46 + 2/10/60	TR-F-FA	192961 L
400	3,5	2.5	30	60	2/7/42 + 2/9/46 + 2/10/60	TR-F-FA	193100 L
303	3,2	2.2	30	70	2/7/42 + 2/9/46 + 2/10/60	DA-F-FA	192959 L
250	3,2	2.2	30	50	2/7/42 + 2/9/46 + 2/10/60	HR-FA	192956 L
303	3,2	2.2	30	65	2/7/42 + 2/9/46 + 2/10/60	HR-FA	192958 L
350	3,2	2.2	30	65	2/7/42 + 2/9/46 + 2/10/60	HR-FA	192962 L
[mm]	[mm]	[mm]	[mm]				

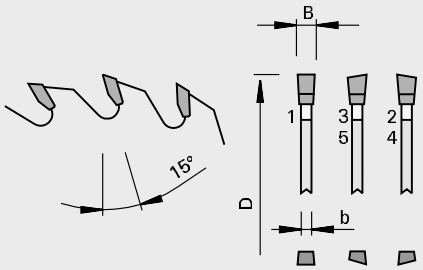
102348

Sizing Saw Blades HW “G5”

Product



Drawing



LEUCO G5 system

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application

- table saws
- chop and miter saws
- for chip-free sizing cuts as well as clipping and mitre cuts in wood-based panels, solid woods and plastics

Design

- tooth configuration: G5
- cutting material: HW HL Board 04 plus

Advantages

- excellent cutting quality for cross cuts
- excellent cutting quality thanks to special tooth geometry
- extremely long edge lives
- noise-reduction thanks to laser ornaments

Notes

- pay attention to nmax!!!
- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42

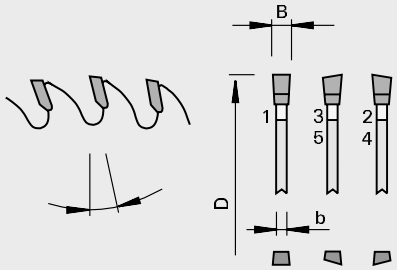
Ø D	B	b	Ø d	Z	NL**		nmax	Ident-No.
200	3,0	2.2	30	65			7630	192789 L
220	3,0	2.2	30	70			6940	192790 L
240	3,0	2.2	30	75			6360	192791 L
250	3,0	2.2	30	80	Combi3		6110	192792 L
280	3,0	2.2	30	85	Combi3		5450	192793 L
300	3,0	2.2	30	100	Combi3		5090	192794 L
303	3,2	2.2	30	100	Combi3	Striebig	5040	192795 L
315	3,0	2.2	30	100	Combi3		4850	192801 L
350	3,0	2.2	30	100	Combi3		4400	192796 L
380	3,0	2.2	32	120		elumatec	3340	192802 L
400	3,0	2.2	30	120	Combi3		3340	192797 L
450	3,6	2.8	30	130	Combi3		3180	192798 L
500	3,6	2.8	30	145	Combi3 + 2/10/70		2670	192799 L
550	4,0	3.2	30	160	Combi3		2780	192803 L
[mm]	[mm]	[mm]	[mm]				[min-1]	

102340

Sizing saw blades HW thin “G5” - clipping and miter saw blades

Product

Drawing



LEUCO G5 system

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application
- chop and miter saws
- for chip-free clipping and miter cuts in wood-based materials, solid woods and plastics

Design
- tooth configuration: G5
- cutting material: HW HL Board 06

Advantages
- excellent cutting quality for cross cuts
- excellent cutting quality thanks to special tooth geometry

Notes
- pay attention to nmax!!!
- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42

Ø D	B	b	Ø d	Z	NL**	Hook angle	nmax	Ident-No.
216	2,5	1.8	30	60	Combi3	5	7100	80469475 L
260	2,5	1.8	30	80	Combi3	15	5900	80460142 L
[mm]	[mm]	[mm]	[mm]			[°]	[min-1]	

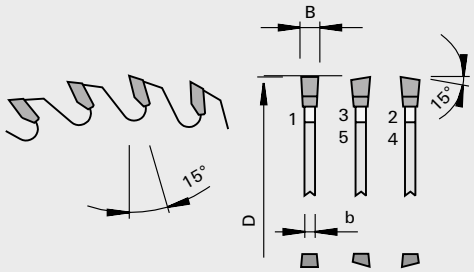
202080

Sizing Saw Blades DP “G5”

Product



Drawing



LEUCO G5 system

LEUCO DIA

Polycrystalline diamond [DP]

LOW noise

Machine / Application
- table saws
- vertical panel sizing saws
- for chip-free sizing cuts as well as clipping and miter cuts in wood-based panels, and plastics (e.g. plastic profiles)

Design
- resharpening area 3.5 mm
- tooth configuration: G5

Advantages
- excellent cutting quality for cross cuts
- excellent cutting quality thanks to special tooth geometry
- extremely long edge lives
- noise-reduction thanks to laser ornaments

Notes
- pay attention to nmax!!!

Ø D	B	b	Ø d	Z	NL	Ident-No.
303	3,2	2.2	30	100	2/7/42 + 2/9,5/46,5 + 2/10/60	189633 C
350	3,2	2.2	30	100	2/7/42 + 2/9,5/46,5 + 2/10/60	189634 L
[mm]	[mm]	[mm]	[mm]			

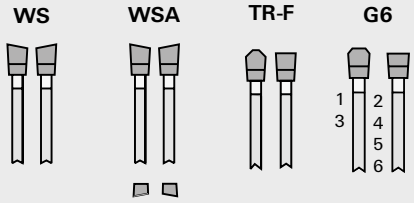
1023...

Sizing Saw Blades HW - LowNoise

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- table saws
- vertical panel sizing saws
- for sizing cuts

Design

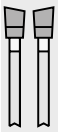
- vibration and noise damping ornaments
- additional expansion slots
- cutting material: HL Board 04 plus and HL Board 06

Advantages

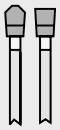
- extremely low-noise and smooth running thanks to vibration and noise damping ornaments as well as special expansion slot combinations
- for each application case the correct tooth form

Notes

- Ident-No. 189690: extremely straight steel plate for Striebig panel sizing saws with scoring device
- NL**- Combi2 = 2/7/42 + 2/9/46 + 2/10/60
- NL**- Combi3 = 2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60



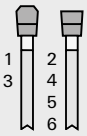
WS
- HW HL Board 04 plus for raw and laminated panels
- HL Board 06 for solid woods in combination with scoring saw blade



TR-F
- for raw and laminated panels
- 10° hook angle in combination with scoring saw blade
- 5° hook angle improved bottom edge even without scoring saw blade



WSA
- universal application
- in combination with scoring saw blade
- diagonal ground front for improvement of cutting quality



G6
- for raw and laminated panels
- in combination with scoring saw blade
- less cutting forces and very long edge lives thanks to innovative tooth group configuration

Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geom-etry	LEUCODUR	Class-No.	Ident-No.
220	3,2	2.2	30	36	10	2/7/42	WS	HL Board 06	102328	189664 L
250	3,2	2.2	30	40	10	Combi2	WS	HL Board 06	102328	189665 L
250	3,2	2.2	30	48	10	Combi2	WS	HL Board 06	102328	189666 L
300	3,2	2.2	30	48	10	Combi2	WS	HL Board 06	102328	189668 L
300	3,2	2.2	30	60	10	Combi2	WS	HL Board 06	102328	189669 L
300	3,2	2.2	60	48	10		WS	HL Board 06	102320	188185 O
350	3,5	2.5	30	54	10	Combi2	WS	HL Board 06	102328	189670 L
350	3,5	2.5	30	72	10	Combi2	WS	HL Board 06	102328	189671 L
400	3,5	2.5	30	60	10	Combi2	WS	HL Board 06	102328	189672 L
400	3,5	2.5	30	84	10	Combi2	WS	HL Board 06	102328	189673 L
[mm]	[mm]	[mm]	[mm]		[°]					

Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geometry	LEUCODUR	Class-No.	Ident-No.	
220	3,2	2.2	30	64	10	2/7/42	WS	HL Board 04 plus	102328	192763	L
250	3,2	2.2	30	60	10	Combi2	WS	HL Board 04 plus	102328	192764	L
250	3,2	2.2	30	80	10	Combi2	WS	HL Board 04 plus	102328	192765	L
300	3,2	2.2	30	72	10	Combi2	WS	HL Board 04 plus	102328	192766	L
300	3,2	2.2	30	96	10	Combi2	WS	HL Board 04 plus	102328	192767	L
350	3,5	2.5	30	84	10	Combi2	WS	HL Board 04 plus	102328	192768	L
350	3,5	2.5	30	108	10	Combi2	WS	HL Board 04 plus	102328	192769	L
350	3,5	2.5	35	84	10	Combi2	WS	HL Board 04 plus	102328	192770	O
400	3,5	2.5	30	96	10	Combi2	WS	HL Board 04 plus	102328	192771	L
400	3,5	2.5	30	120	10	Combi2	WS	HL Board 04 plus	102328	192772	L
450	4,0	2.8	30	132	10	Combi2	WS	HL Board 04 plus	102328	192773	L
[mm]	[mm]	[mm]	[mm]		[°]						

Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geometry	LEUCODUR	Class-No.	Ident-No.	
300	3,2	2.2	30	96	10	Combi2	WSA	HL Board 04 plus	102328	192774	L
[mm]	[mm]	[mm]	[mm]		[°]						

Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geometry	LEUCODUR	Class-No.	Ident-No.	
220	3,2	2.2	30	64	10	2/7/42	TR-F	HL Board 04 plus	102378	192775	L
250	3,2	2.2	30	60	10	Combi2	TR-F	HL Board 04 plus	102378	192776	L
250	3,2	2.2	30	80	5	Combi3	TR-F	HL Board 04 plus	102378	193196	L
250	3,2	2.2	30	80	10	Combi2	TR-F	HL Board 04 plus	102378	192777	L
300	3,2	2.2	30	72	10	Combi2	TR-F	HL Board 04 plus	102378	192778	L
300	3,2	2.2	30	96	5	Combi3	TR-F	HL Board 04 plus	102378	192779	L
300	3,2	2.2	30	96	10	Combi3	TR-F	HL Board 04 plus	102378	192780	L
350	3,5	2.5	30	84	10	Combi2	TR-F	HL Board 04 plus	102378	192781	L
350	3,5	2.5	30	108	10	Combi2	TR-F	HL Board 04 plus	102378	192782	L
[mm]	[mm]	[mm]	[mm]		[°]						

Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geometry	LEUCODUR	Class-No.	Ident-No.	
250	3,2	2.2	30	60	10	Combi2	TR-F-FA	HL Board 04 plus	102378	192785	O
250	3,2	2.2	30	80	10	Combi2	TR-F-FA	HL Board 04 plus	102378	192786	O
300	3,2	2.2	30	72	10	Combi2	TR-F-FA	HL Board 04 plus	102378	192787	O
300	3,2	2.2	30	96	10	Combi2	TR-F-FA	HL Board 04 plus	102378	192788	O
[mm]	[mm]	[mm]	[mm]		[°]						

Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geometry	LEUCODUR	Class-No.	Ident-No.	
300	3,2	2.2	30	96	5	Combi3	G6	HL Board 04 plus	102378	192783	L
[mm]	[mm]	[mm]	[mm]		[°]						

102338

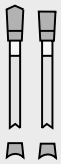
Sizing Saw Blades HW - easyFix - LowNoise

Product

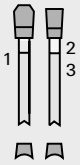


Drawing

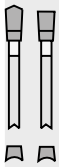
DA-F DU



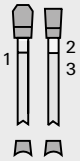
TR-F-F DU



Tungsten Carbide [HW]



DA-F DU
- 10° hook angle for raw and laminated panels
- -5° hook angle for sizing cuts in plastic and solid wood profile ledges
- good quality of bottom edge even without scoring saw blade
- excellent cutting quality



TR-F-F DU
- for raw and laminated panels
- good quality of bottom edge even without scoring saw blade
- longer edge life thanks to innovative tooth group configuration and cutting material HL Board 03

Machine / Application
- table saws
- vertical panel sizing saws
- for sizing cuts

Design
- vibration and noise damping ornaments
- cutting material: HL Board 06 and HL Board 03

Advantages
- easyFix: NEW, EASY HANDLING, easy and smooth mounting of the saw blade on the machine despite high-precision bore tolerance
- extremely low-noise and smooth running thanks to vibration and noise damping ornaments as well as special expansion slot combinations

Notes
- Ident-No. 193335: extremely straight steel plate for Striebig panel sizing saws with scoring device
- NL**- Combi3 = 2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60

Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geometry	LEUCODUR	Class-No.	Ident-No.
220	3,2	2.2	30	42	10	2/7/42 + 1/3/52	DA-F DU	HL Board 06	102338	193326 L
250	3,2	2.2	30	48	10	Combi3	DA-F DU	HL Board 06	102338	193327 L
303	3,2	2.2	30	60	10	Combi3	DA-F DU	HL Board 06	102338	193335 L
303	3,2	2.2	30	60	10	Combi3	DA-F DU	HL Board 06	102338	193328 L
350	3,5	2.5	30	72	10	Combi3	DA-F DU	HL Board 06	102338	193329 L
400	3,5	2.5	30	84	10	Combi3	DA-F DU	HL Board 06	102338	193330 L
[mm]	[mm]	[mm]	[mm]		[°]					

Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geometry	LEUCODUR	Class-No.	Ident-No.
250	3,2	2.2	30	48	-6	Combi3	DA-F DU	HL Board 06	102338	193331 L
303	3,2	2.2	30	60	-6	Combi3	DA-F DU	HL Board 06	102338	193332 L
350	3,5	2.5	30	72	-6	Combi3	DA-F DU	HL Board 06	102338	193333 L
[mm]	[mm]	[mm]	[mm]		[°]					

Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geometry	LEUCODUR	Class-No.	Ident-No.
303	3,2	2.2	30	60	10	Combi3	TR-F-F DU	HL Board 03	102338	193334 L
[mm]	[mm]	[mm]	[mm]		[°]					

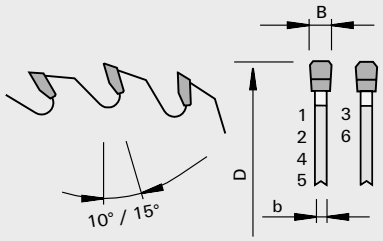
104248

Panel Sizing Saw Blades HW - Q-Cut “G6”

Product



Drawing



LEUCO topline

Q-CUT G6

Tungsten Carbide [HW]

LOW

Machine / Application

- panel sizing saws
- for finish cuts in veneered, foiled or melamine-laminated panels, in single sheets or in stacks

Design

- vibration and noise damping ornaments
- additional expansion slots
- up to ØD=370, 10 degree hook angle
- from ØD=380, 15 degree hook angle
- tooth configuration: G6
- cutting material: HW HL Board 04 plus

Advantages

- for highest performance demands
- impressive cutting quality thanks to exact and precise cuts
- reduced cutting pressure and optimized cutting geometry G6
- extremely low-noise and smooth running thanks to reinforced body and vibration and noise damping ornaments
- clearly increased edge life thanks to improved HW grade

Notes

- projection: min 20 - 25 mm
- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42
- NL**- Combi5 = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.
280	3,2	2.2	30	60	Combi3 + 2/13/94	Panhans EURO 5	193136 L
300	4,0	3.0	60	72	Combi7	Homag (Holzma) HPP 230	193370 L
300	4,4	3.3	60	72	Combi7	Homag (Holzma) HPP 230	193137 L
300	4,4	3.0	65	60	2/9/110	Selco EB 70	193138 L
300	4,4	3.0	75	60	2/9/110	Holzma CH03	193139 O
305	4,4	3.0	30	60	Combi3 + 2/13/94	Mayer, Panhans	193140 L
308	3,2	2.4	60	96	Combi7	Homag HPS 320	193141 L
320	4,4	3.3	30	60	Combi3 + 2/13/94	Mayer / Format 4	193142 L
320	4,0	3.0	60	72	Combi7	HOMAG SAWTEQ B-200	193372 L
320	4,4	3.3	60	72	Combi7	HOMAG SAWTEQ B-200	193221 L
320	3,6	2.5	65	60	2/9/110 + 2/9/100	Selco WN 230, Selco SK 230	193301 L
320	4,4	3.3	65	60	2/9/110	Biesse, Selco EB 80	193143 L
330	4,4	3.3	50	60	8/13/80	Giben	193144 C
350	4,25	3.3	30	72	Combi3 + 2/13/94	Scheer	193145 L
350	4,4	3.3	30	72	Combi3 + 2/13/94	SCM, Panhans, Mayer, Schelling, HOLZ-HER	193146 L
350	4,4	3.3	50	72	8/13/80	Giben Smart	193147 O
350	4,0	3.0	60	72	Combi7	Homag (Holzma) 72, HPP 350	193373 L
350	4,4	3.3	60	72	Combi7	Homag (Holzma) 72, HPP 350	193148 L
350	4,4	3.3	75	72		Homag Sawtech, Homag (Holzma) 250	193149 L
355	4,4	3.3	30	72	Combi3 + 2/13/94	Mayer / Format 4	193290 L
350	3,6	2.5	65	72	2/9/110 + 2/9/100	Selco WN 250	193302 L
355	4,4	3.3	75	72		Giben	193150 L
355	4,4	3.3	80	72	4/8,5/100 + 2/7/110 + 2/14/110	Gabbiani PRIMA, SCM ALPHA	193152 L
360	4,4	3.3	30	72	Combi3 + 2/13/94	Schelling	193153 L
360	4,4	3.3	75	72	4/15/105	Giben	193154 C
370	4,4	3.3	30	72	Combi3 + 2/13/94	Schelling FM	193155 L
380	4,4	3.3	30	72	Combi3 + 2/13/94	HOLZ-HER	193156 L
380	4,4	3.3	50	72	4/13/80	Giben Onyx	193157 L
380	4,0	3.0	60	72	Combi7	Homag (Holzma)	193374 L
380	4,4	3.3	60	72	Combi7	Homag (Holzma)	193158 L
380	4,8	3.6	60	72	Combi7	Homag (Holzma)	193159 L
380	3,6	2.5	65	72	2/9/110 + 2/9/100	Selco WN 610 - WNA 610	193303 L
380	4,4	3.3	65	72	2/9/100 + 2/9/110	Selco WN 610	193283 L
380	4,4	3.3	80	72	Combi5	SCM, Selco	193188 L
[mm]	[mm]	[mm]	[mm]				

Ø D	B	b	Ø d	Z	NL**		Ident-No.
380	4,8	3.6	80	72	Combi5	SCM, Selco	193189 L
400	4,25	3.3	30	72	Combi3 + 2/13/94	Scheer	193160 O
400	4,4	3.3	30	72	Combi3 + 2/13/94	HOLZ-HER, Irion, Mayer, Scheer, Schelling	193161 L
400	4,4	3.3	60	72	Combi7	Nanxing	193162 O
400	4,0	3.0	65	72	2/9/110 + 2/9/100	Selco WN 630 - WNA 630, Selco WN 650 - WNA 650	193304 L
400	4,4	3.3	65	72	2/9/100 + 2/9/110	Selco WN 630, WN 650	193284 L
400	4,4	3.3	75	72	4/15/105 + 2/7/110	Giben Prismatic 1, Giben Starmatic, Homag CH08+12	193163 L
400	4,4	3.3	80	72	Combi5	Gabbiani CLASS, SCM DELTA, Selco WN / EB	193164 L
420	4,8	3.6	60	72	Combi7	Homag (Holzma) Typ 92	193165 L
430	4,4	3.3	30	72	Combi3 + 2/13/94	HOLZ-HER	193166 L
430	4,0	3.0	65	72	2/9/110 + 2/9/100	Selco WN 650 - WNA 650	193305 L
430	4,4	3.3	65	72	2/9/100 + 2/9/110	Selco WN 650	193285 L
430	4,8	3.6	70	72	4/11/130	Selco WN	193169 L
430	4,4	3.3	75	72	4/15/105 + 2/7/110	Giben Prismatic 2 old	193167 L
430	4,4	3.3	80	72	Combi5	Selco WN	193168 L
450	4,4	3.3	30	72	Combi3 + 2/13/94	Irion, Schelling	193170 L
450	4,4	3.3	75	72	2/7/110	Giben	193171 L
450	4,4	3.3	80	72	Combi5	Gabbiani ELITE	193172 O
450	4,65	3.6	30	72	Combi3 + 2/13/94	Scheer	193173 O
450	4,8	3.6	30	72	Combi3 + 2/13/94	Scheer	193174 L
450	4,8	3.6	60	72	Combi7	Homag (Holzma)	193175 L
450	4,8	3.6	80	72	Combi5	Selco WN	193176 O
460	4,4	3.3	30	72	Combi3 + 2/13/94	Schelling FL, FH6	193177 L
470	4,4	3.3	75	72	4/15/105 + 2/19/120	Giben	193178 C
470	4,8	3.6	70	72	4/11/130	Selco WN	193179 C
480	4,4	3.3	30	72	Combi3 + 2/13/94	Schelling FH6 from 2016	193180 L
480	4,8	3.6	60	72	Combi7	Homag (Holzma)	193181 L
480	4,8	3.6	70	72	4/11/130	Selco Series 750	193183 C
480	4,8	3.6	80	72	Combi5	Selco WN	193184 L
500	4,8	3.6	60	72	Combi7	Homag (Holzma) Typ 22	193185 C
520	4,8	3.6	30	72	Combi3 + 2/13/94	Schelling FH8	193186 L
520	4,8	3.6	60	72	Combi7	Homag (Holzma) 23 / 550	193187 L
520	4,8	3.6	70	72	4/11/130	Selco WN	193182 L
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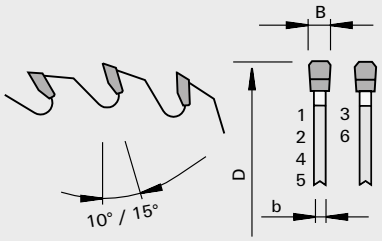
104249

Panel Sizing Saw Blades HW - Q-Cut “G6” - nn-System

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- panel sizing saws
- for finish cuts in veneered, foiled or melamine-laminated panels, in single sheets or in stacks up to 60 mm cutting height

Design

- special nn-System gullet geometry
- tooth configuration: G6
- cutting material: HW HL Board 04 plus

Advantages

- especially low noise level
- noise reduction by up to approx. 6 dB(A) when idling
- for highest performance demands
- impressive cutting quality thanks to exact and precise cuts without chippings
- reduced cutting pressure and power consumption thanks to optimized cutting geometry
- clearly increased edge life thanks to improved HW grade

Notes

- projection: min. 20 - 25 mm max. 40 mm
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.
310	4,0	3.0	60	72	Combi7	Homag (Holzma BR200)	193371 L
310	4,4	3.2	60	72	Combi7	Homag (Holzma BR200)	193190 L
350	4,4	3.2	60	72	Combi7	Homag (Holzma 72, 350, HPP 350)	193191 L
380	4,4	3.2	60	72	Combi7	Homag (Holzma)	193192 L
380	4,8	3.5	60	72	Combi7	Homag (Holzma 82, HPP 82, HPP 83, HPL 380)	193193 L
450	4,8	3.5	60	72	Combi7	Homag (Holzma 11510)	193194 L
[mm]	[mm]	[mm]	[mm]				

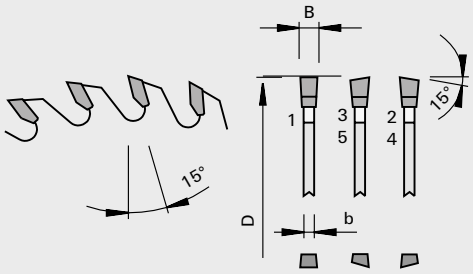
104258

Panel Sizing Saw Blades HW - Q-Cut “G5”

Product



Drawing



LEUCO G5 system

Q-CUT G5

Tungsten Carbide [HW]

LOW

Machine / Application

- horizontal panel sizing saws
- for sizing and finish cuts in wood core plywood, plywood boards, veneered or paper-laminated wood-based panels and honeycomb panels

Design

- vibration and noise damping ornaments
- additional expansion slots
- tooth configuration: G5
- cutting material: HW HL Board 04 plus

Advantages

- very low cutting pressure and small power consumption thanks to optimized cutting geometry
- excellent cutting quality in wood-based materials containing fibers
- extremely low-noise and smooth running thanks to vibration and noise damping ornaments as well as special expansion slot combinations

Notes

- Attention: when assigning the appropriate scoring saw blades, please take into account the cutting width reduction of 4 mm!
- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9.5/46.5 + 2/7/42
- NL**- Combi5 = 2/7/110 + 2/9/110 + 2/8.4/130 + 2/14/110 + 4/9/100 + 4/19/120
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.
300	4,0	3.2	30	100	Combi3	Fimal Concept 350	193312 L
350	4,0	3.2	30	80	Combi3 + 2/13/94	SCM, Panhans, Mayer, Schelling, HOLZ-HER	192813 L
350	4,0	3.2	60	80	Combi7	Homag (Holzma)	192814 L
380	4,0	3.2	60	80	Combi7	Homag (Holzma)	192815 L
400	4,0	3.2	30	85	Combi3 + 2/13/94		192816 L
430	4,0	3.2	30	85	Combi3 + 2/13/94		192817 L
430	4,0	3.2	80	90	Combi5	Selco	192818 L
450	4,0	3.2	60	90	Combi7	Homag (Holzma)	192819 L
460	4,0	3.2	30	90	2/13/94	Schelling	192820 C
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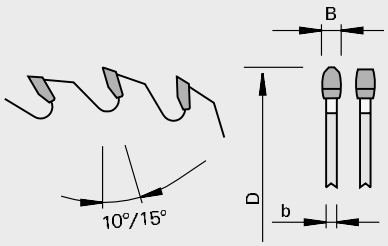
104278

Panel Sizing Saw Blades HW - Q-Cut “TR-F K”

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- horizontal panel sizing saws
- for micro cuts in new materials (special surfaces) and plastics

Design

- vibration and noise damping ornaments
- additional expansion slots
- tooth configuration: TR-F K
- cutting material: HW HL Board 04 plus

Advantages

- excellent cutting quality in “anti fingerprint” materials and for conventional plastics
- no scoring on the cutting surface due to convex tooth sides
- no flares on the surface of sensible materials

Notes

- Attention: when assigning the appropriate scoring saw blades, please take into account the cutting width reduction of 4 mm!
- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9.5/46.5 + 2/7/42
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.
350	4,0	3.2	30	72	Combi3 + 2/13/94	Schelling, SCM, Panhans, Mayer; HOLZ-HER	192974 L
350	4,0	3.2	60	72	Combi7	Homag (Holzma)	192975 L
380	4,0	3.2	60	72	Combi7	Homag (Holzma)	192976 L
400	4,0	3.2	30	72	Combi3 + 2/13/94	Schelling	192977 L
450	4,0	3.2	60	72	Combi7	Homag (Holzma)	192978 L
460	4,0	3.2	30	72	2/13/94	Schelling	192979 L
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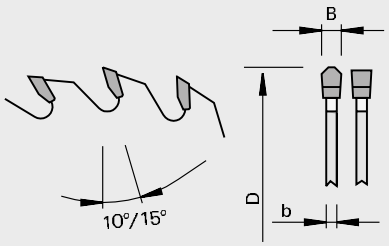
104378

Panel Sizing Saw Blades HW - U-Cut “TR-F”

Product



Drawing



LEUCO topline

U-CUT TR-F

Tungsten Carbide [HW]

LOW

Machine / Application

- panel sizing saws
- for sizing cuts in plastic-laminated panels

Design

- up to ØD=360, 10 degree hook angle
- from ØD=380, 15 degree hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 04 plus

Advantages

- improved cutting quality thanks to optimized cutting geometry
- noise-reduction thanks to laser ornaments

Notes

- specifically for plastic-laminated panels and plywood in single sheets and stacks
- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42
- NL**- Combi5 = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.
300	4,4	2.8	30	60	Combi3 + 2/13/94	Panhans Euro P8	192901 L
300	4,4	3.2	60	72	Combi7	Homag (Holzma) Typ 130, HPP 230	193299 L
300	4,4	3.0	75	72	2/9/110	Homag Espana	192902 L
300	4,4	3.2	80	72	Combi5	Gabbiani, SCM	193111 L
305	3,2	2.2	30	60	Combi3 + 2/13/94	Scheer FM 16	192903 L
305	4,4	2.8	30	60	Combi3 + 2/13/94	Mayer, Panhans	192904 L
305	4,4	2.8	60	60		Hoggers	192905 L
310	4,4	3.2	60	72	Combi7	Homag (Holzam)Typ 130	193300 L
320	4,4	3.2	60	72	Combi7	Homag Sawtec	80486008 L
320	4,4	3.2	65	60	2/9/110	Biesse, Selco EB 80	192906 L
320	4,4	3.2	75	72	3/13/95	Giben Smart	192907 L
320	4,4	3.2	80	60	Combi5	Gabbiani, SCM	193099 L
320	4,4	3.2	80	72	Combi5	SCM	193110 L
340	4,4	3.2	80	72	Combi5	SCM	193313 L
350	4,4	3.0	30	72	Combi3 + 2/13/94	SCM, Panhans, Mayer, Schelling, HOLZ-HER	192908 L
350	4,4	3.2	60	72	Combi7	Homag (Holzma) 72, HPP 350	192909 L
350	4,4	3.0	75	60		Giben MK Gamma	192910 L
350	4,4	3.2	75	72	2/7/110	KDT	80484667 L
355	4,4	3.2	30	72	Combi3 + 2/13/94	Mayer / Format 4	193289 C
355	4,4	3.2	65	72	2/9/110	Selco EB 95 / EB 100	193098 L
355	4,4	3.0	75	60		Giben Trend, Homag CH06+10	192912 L
355	4,4	3.0	75	72	4/15/105	Giben	192911 L
355	4,4	3.0	80	72	Combi5	Gabbiani PRIMA, SCM ALPHA, S.M.A., hoggers	192913 L
360	4,4	3.2	30	72	Combi3	Schelling FH4	193314 L
360	4,4	3.2	65	72	2/9/110	Selco	192914 L
380	4,4	3.2	60	72	Combi7	Homag (Holzma)	192915 L
380	4,8	3.5	60	72	Combi7	Homag (Holzma)	192916 L
380	4,4	3.2	80	72	Combi5	Gabbiani, SCM, Selco	192969 L
380	4,8	3.5	80	72	Combi5	Gabbiani, SCM, Selco	192993 L
400	4,25	3.2	30	72	Combi3 + 2/13/94	Scheer	192917 L
400	4,4	3.2	30	96	Combi3 + 2/13/94		192918 L
400	4,4	3.2	30	72	Combi3 + 2/13/94	Schelling, Mayer, Irion, Scheer, HOLZ-HER	192919 L
[mm]	[mm]	[mm]	[mm]				

Ø D	B	b	Ø d	Z	NL**		Ident-No.
400	4,4	3.2	60	72	Combi7	Anthon	192920 L
400	4,8	3.5	60	72	Combi7	Homag (Holzma) Typ 01	192923 L
400	4,4	3.2	75	72	4/15/105 + 2/7/110	Giben Prismatic 1, Giben Starmatic, Homag CH08+12	192921 L
400	4,4	3.2	80	72	Combi5	Selco WN / EB, S.M.A., Irion	192922 L
420	4,8	3.5	60	72	Combi7	Homag (Holzma)	192924 L
430	4,4	3.2	30	72	Combi3		192925 L
430	4,4	3.2	60	72	Combi7		192926 L
430	4,4	3.2	75	96	4/15/105 + 2/7/110	Giben Prismatic 2 old	192927 L
430	4,4	3.2	80	72	Combi5	Selco WN	192928 L
450	4,4	3.2	30	72	Combi3 + 2/13/94	Irion, Schelling	192929 L
450	4,8	3.5	60	72	Combi7	Homag (Holzma)	192931 L
450	4,4	3.2	75	72	2/7/110	KDT	80484668 L
450	4,4	3.2	80	72	Combi5	S.M.A., Irion	192930 L
450	4,8	3.5	80	72	Combi5	Selco WN	192932 L
460	4,4	3.2	30	72	Combi3 + 2/13/94	Schelling FL, FH 6	192933 L
470	4,8	3.5	70	72	4/11/130	Selco WN	192936 L
470	4,4	3.2	75	96	4/15/105 + 2/19/120	Giben Prismatic 3	192934 L
470	4,4	3.2	75	72	4/15/105 + 2/19/120	Giben	192935 L
480	4,4	3.2	30	72	Combi3 + 2/13/94	Schelling FL	192937 L
480	4,8	3.5	60	72	Combi7	Homag (Holzma) 530	192938 L
480	4,8	3.5	80	72	Combi5	Selco WN	192939 L
520	4,4	3.3	30	72	4/13/94	Schelling FH8	193251 L
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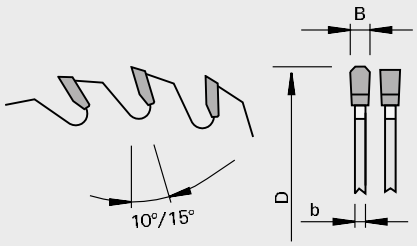
104378

Panel Sizing Saw Blades HW - U-Cut max “TR-F”

Product



Drawing



LEUCO topline

U-CUT MAX

Tungsten Carbide [HW]

LOW

Machine / Application

- panel sizing saws
- for sizing cuts in plastic-laminated panels

Design

- up to ØD=360, 10 degree hook angle
- from ØD=380, 15 degree hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 04 plus

Advantages

- higher edge life thanks to up to 6 times more resharpenings than U-Cut TR-F
- noise reduction thanks to laser ornaments

Notes

- specifically for plastic-laminated panels and plywood in single sheets and stacks
- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.
350	4,4	3.2	30	72	Combi3 + 2/13/94	SCM, Panhans, Mayer, Schelling, HOLZ-HER	193120 C
350	4,4	3.2	60	72	Combi7	Homag (Holzma) 72, HPP 350	193121 L
350	4,4	3.2	75	72		Giben MK Gamma	193122 L
380	4,4	3.2	60	72	Combi7	Homag (Holzma)	193123 L
380	4,8	3.5	60	72	Combi7	Homag (Holzma)	193124 L
380	4,4	3.2	80	72	Combi5	Gabbiani, SCM, Selco	193125 C
380	4,8	3.5	80	72	Combi5	Gabbiani, SCM, Selco	193126 C
400	4,4	3.2	30	72	Combi3 + 2/13/94	Schelling Mayer, Irion, Scheer, HOLZ-HER	193127 C
450	4,4	3.2	30	72	Combi3 + 2/13/94	Irion, Schelling	193128 C
450	4,8	3.5	60	72	Combi7	Homag (Holzma)	193129 L
470	4,8	3.5	70	72	2/11/130	Selco WN	193132 L
470	4,4	3.2	75	72	4/15/105 + 2/19/120	Giben	193130 C
470	4,8	3.5	75	72	4/15/105 + 2/7/110	Giben	193131 C
500	4,4	3.2	30	60	Combi3 + 2/13/94	Schelling, Irion	192940 L
500	4,8	3.5	60	72	Combi7	Homag (Holzma) Typ 22	192941 L
520	4,8	3.5	30	72	Combi3 + 2/13/94	Schelling FH 8	192942 L
520	4,8	3.5	60	72	Combi7	Homag (Holzma) Typ 23	192943 L
560	4,8	3.5	30	72	2/13/94	Schelling	193104 L
600	5,8	4.0	60	72	Combi7	Homag (Holzma) Typ 42	192944 L
650	6,2	4.0	40	72		Schelling	192945 L
[mm]	[mm]	[mm]	[mm]				

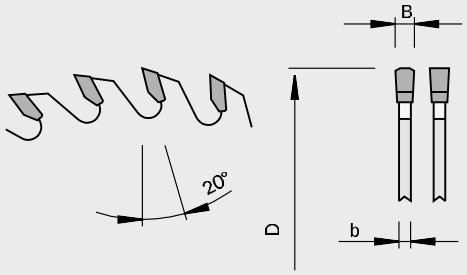
104270

Panel Sizing Saw Blades HW - U-Cut speed “TR-F”

Product



Drawing



LEUCO topline

U-CUT SPEED

Tungsten Carbide [HW]

LOW

Machine / Application

- horizontal panel sizing saws
- for stack cuts in raw and plastic-laminated panels

Design

- vibration and noise damping ornaments
- additional expansion slots
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 04 plus

Advantages

- for highest performance demands
- reduced cutting pressure and power consumption thanks to optimized cutting geometry
- extremely low-noise and smooth running thanks to vibration and noise damping ornaments as well as special expansion slot combinations
- clearly increased edge life thanks to improved HW grade

Notes

- stack height: Ident-No. 192629 up to max. 190 mm / Ident-No. 192631 up to max. 210 mm / Ident-No. 192633 up to max. 215 mm
- recommended projection: 20-30 mm
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.
520	4,8	3.5	60	60	Combi7	Homag (Holzma) Typ 23	192617 L
530	5,0	3.5	30	60		Schelling	192618 L
530	5,8	4.0	60	60	Combi7		192619 L
565	4,8	3.5	80	60	2/8/110		192620 C
565	5,0	3.5	100	60		Giben	192621 S
570	4,8	3.5	60	60	Combi7	Homag (Holzma)	192622 L
575	5,8	4.0	60	60	Combi7	Homag (Holzma)	192664 L
600	5,8	4.0	60	60	Combi7	Homag (Holzma) Typ 42	192624 L
600	5,8	4.0	80	60	2/11/115 + 2/19/120		192625 L
620	6,2	4.0	80	60	4/15/143		192626 C
650	6,2	4.0	40	60		Schelling	192627 C
670	6,0	4.4	60	48	Combi7	Homag (Holzma) 66 (Tandem)	192628 L
680	6,4	4.4	40	60	2/17/140 + 2/13/140	Schelling	192629 L
700	6,4	4.4	80	60	2/17/110	Anthon	192631 L
700	6,8	4.4	80	60	2/17/110		192632 S
720	6,4	4.4	40	60	2/13/114 + 2/13/140	Schelling	192633 L
730	6,4	4.4	60	60	Combi7	Homag (Holzma) 66 (Tandem)	192635 L
730	6,4	4.4	80	60	2/17/110	Anthon LNC	192634 L
750	6,5	4.6	40	72	2/13/140 + 2/13/114		192636 L
[mm]	[mm]	[mm]	[mm]				

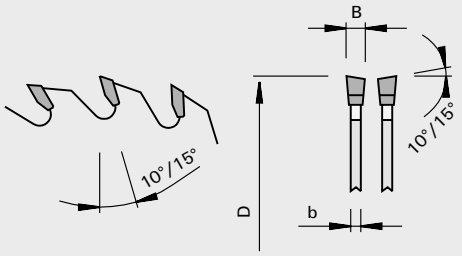
104320

Panel Sizing Saw Blades HW - U-Cut “WS”

Product



Drawing



LEUCO topline

U-CUT WS

Tungsten Carbide [HW]

Machine / Application

- panel sizing saws
- double-end tenoners
- for sizing cuts in raw and veneered particleboard, hardboard, MDF panels and high-density plywood in single sheets and stacks

Design

- up to ØD=355, 10 degree hook angle and 15 degree corner angle
- from ØD=400, 15 degree hook angle and 10 degree corner angle
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 04 plus

Advantages

Notes

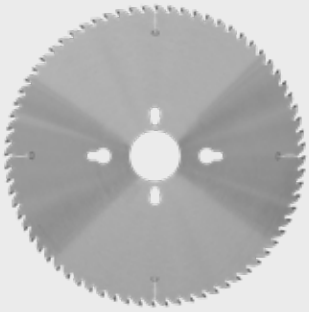
- for main/scoring saw combinations see specifications (appendix)
- on double-end tenoners in combination with large hoggers
- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42
- NL**- Combi5 = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.
305	4,4	2.8	30	48	Combi3 + 2/13/94	Mayer, Panhans	192821 L
305	4,4	2.8	60	48	Combi7		192822 L
320	4,4	3.2	30	50	Combi3	Mayer, Format 4	193215 L
350	4,4	3.0	30	54	Combi3 + 2/13/94	SCM, Panhans, Schelling	192823 L
350	4,4	3.0	60	54	Combi7	Holzma	193095 L
355	4,4	3.0	30	72	Combi3 + 2/13/94	Schelling, Mayer, Irion	192824 L
355	4,4	3.0	60	54	Combi7	Homag (Holzma)	192825 L
355	4,4	3.0	60	72	Combi7		192826 L
355	4,4	3.0	80	54	Combi5	S.M.A.	192827 L
355	4,4	3.0	80	72	Combi5	S.M.A.	192828 L
380	4,8	3.5	60	54	Combi7	S.M.A., Homag (Holzma)	192829 L
380	4,4	3.2	60	72	Combi7	Homag (Holzma)	193340 L
400	4,4	3.2	80	96	Combi5		192830 L
400	4,6	3.2	30	60	Combi3 + 2/13/94	Schelling, Mayer, Irion, HOLZ-HER	192831 L
400	4,6	3.2	30	72	Combi3 + 2/13/94	Schelling, Mayer, Irion, HOLZ-HER	192832 L
400	4,6	3.2	80	72	Combi5	S.M.A.	192834 O
430	4,6	3.2	75	72	4/15/105	Giben Prismatic 2	192835 L
430	4,6	3.2	80	72	Combi5	S.M.A.	192836 C
450	4,6	3.2	30	54	Combi3 + 2/13/94	Panhans, Irion, Schelling	192837 L
450	4,6	3.2	80	72	Combi5	S.M.A., Irion	192838 L
500	4,6	3.2	30	60	Combi3 + 2/13/94	Schelling, Irion	192839 L
500	4,6	3.2	80	60	Combi5	Teutomatic	192840 O
500	4,8	3.5	60	60	Combi7	Homag (Holzma)	192999 C
550	5,0	3.5	80	60	Combi5	Teutomatic	192841 L
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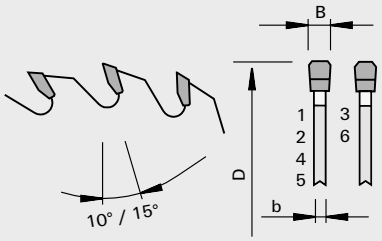
204080

Panel Sizing Saw Blades DP - Q-Cut “G6”

Product



Drawing





Polycrystalline diamond [DP]

Machine / Application

- horizontal panel sizing saws
- for finish cuts in raw and plastic-laminated panels

Design

- vibration-optimized tool body design
- LEUCODIA tipping quality
- G6: for finish cuts in unfinished and plastic-coated composite wood boards individually or in packages up to 80 mm

Advantages

- extremely good vibration damping due to laser ornaments filled with damping material

Notes

- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.
300	4,4	3.2	30	72			193409 L
300	4,4	3.2	30	72	2/10/60 + 2/13 /94	Panhans, Mayer, SCM, Schelling	80487406 O
300	4,4	3.2	60	72	2/14/110	HOMAG	80487408 O
300	4,4	3.2	65	72	2/9/100 + 2/9/110	Selco	80487409 O
300	4,4	3.2	75	72	2/9/11	HOMAG	80487410 O
300	4,4	3.2	80	72	2/14/110	SCM-Gabbiani	80487411 O
320	4,4	3.2	30	72			193410 L
320	4,4	3.2	50	72	3/15/80	Giben	80487412 O
320	4,4	3.2	60	72	2/14/100	HOMAG Sawtech B 200	80487413 O
320	4,4	3.2	65	72	2/9/100 + 2/9/110	Selco	80487414 O
320	4,4	3.2	75	72		Giben	80487415 O
320	4,4	3.2	80	72	2/14/110	SCM-Gabbiani	80487416 O
350	4,4	3.2	30	72			193412 L
350	4,4	3.2	50	72	4/13/80	Giben	80487418 O
350	4,4	3.2	60	72	Combi7	HOMAG	193411 L
350	4,4	3.2	60	72	2/10/60 + 2/13/94	Panhans, Mayer, SCM, Scheer	80487417 O
350	4,4	3.2	65	72	2/9/110	Selco	80487419 O
350	4,4	3.2	75	72	4/15/105 + 2/7/110	Giben	80487420 O
350	4,4	3.2	80	72	2/14/110	SCM-Gabbiani	80487421 O
380	4,4	3.2	60	72	Combi7	HOMAG	193413 L
400	4,4	3.2	30	72			193414 L
400	4,4	3.2	30	72	2/10/60 + 2/13/94	Panhans, Mayer, SCM, Scheer	80487422 O
400	4,4	3.2	65	72	2/9/110	Selco	80487423 O
400	4,4	3.2	75	72	4/15/105 + 2/7/110	Giben, KDT	80487424 O
400	4,4	3.2	80	72	2/14/110	SCM-Gabbiani	80487425 O
400	4,4	3.2	80	72	2/9/130 + 4/19/120	Selco	80487426 O
430	4,4	3.2	30	72			193415 L
430	4,4	3.2	30	72	2/10/60	Schelling	80487427 O
430	4,4	3.2	65	72	2/9/10	Selco	80487428 O
430	4,4	3.2	70	72	4/11/130	Selco	80487429 O
430	4,4	3.2	75	72	4/15/105 + 2/7/110	Selco	80487430 O
430	4,4	3.2	80	72	2/14/110	SCM-Gabbiani	80487431 O
450	4,8	3.5	60	72	Combi7	HOMAG	193416 L
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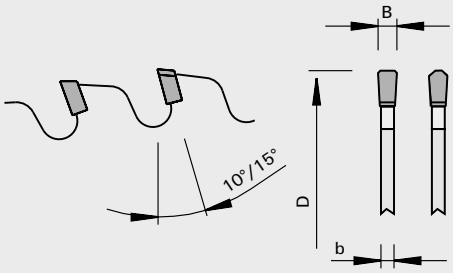
204080

Panel Sizing Saw Blades DP - U-Cut “TR-F-FA”

Product



Drawing



LEUCO topline

Polycrystalline diamond [DP]

Machine / Application

- horizontal panel sizing saws
- for sizing cuts in raw and plastic-laminated panels

Design

- Extra sturdy design for universal use
- Tooth configuration: triple chip - flat chamfer “TR-F-FA”
- Cutting material: DP

Advantages

- A larger wedge angle ensures a greater resistance to breakage at the tooth

Notes

- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9.5/46.5 + 2/7/42
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120
- Further dimensions on request

Ø D	B	b	Ø d	Z	NL**		Ident-No.
300	3,2	2.4	30	72	Combi3 + 2/13/94	Schelling LS1	193342 L
308	3,2	2.4	60	72	Combi7	HOMAG SAWTEQ B-320 flexTec	193343 L
350	4,4	3.2	30	72	Combi3 + 2/13/94	HOLZ-HER, Mayer, Panhans, Schelling SCM	193344 L
350	4,4	3.2	60	72	Combi7	HOMAG (HOLZMA), Nanxing	193345 L
350	4,4	3.2	75	72	4/15/105 + 2/7/110	Giben	193346 L
380	4,4	3.2	60	72	Combi7	HOMAG (HOLZMA), Nanxing	193347 L
380	4,4	3.2	60	72	Combi7	HOMAG (HOLZMA), Nanxing	193348 L
380	4,8	3.5	60	72	Combi7	HOMAG (HOLZMA), Nanxing	193349 L
400	4,4	3.2	30	72	Combi3 + 2/13/94	HOLZ-HER, Irion, Mayer, Panhans, Scheer, Schelling	193350 L
450	4,8	3.5	60	72	Combi7	HOMAG (HOLZMA), Nanxing	193351 L
[mm]	[mm]	[mm]	[mm]				

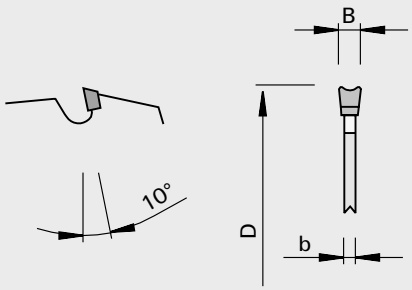
204180

DIAREX Panel Sizing Saw Blades DP “HR-FA”

Product



Drawing



LEUCO DIAREX

Polycrystalline diamond [DP]

Machine / Application

- horizontal panel sizing saws
- well suited for magnet bond boards
- very well suited for thin plates made of CFRP and GFRP

Design

- tooth configuration: hollow back with chamfer ”HR-FA”
- cutting material: DP
- resharpenable area 2.0 mm

Advantages

- excellent cut quality thanks to pre-scoring effect and reduced cutting pressure

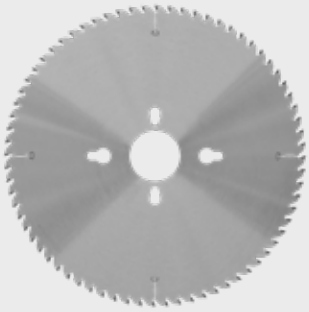
Notes

Ø D	B	b	Ø d	Z	Ident-No.
350	4,4	3.2	30	72	193222 L
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204380

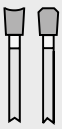
Panel Sizing Saw Blades DP “HR-TR” - topcoat

Product



Drawing

HR-TR



LEUCO topcoatplus

LEUCO DIA

Polycrystalline diamond [DP]

Machine / Application
- horizontal panel sizing saws
- for finish cuts in HPL and solid core materials

Design
- vibration-optimized tool body design
- LEUCODIA tipping quality
- LEUCO topcoat: smooth surfaces for the reduction of deposits and adhesions on the cutting edges

Advantages
- extremely good vibration damping due to laser ornaments filled with damping material
- increased edge lives thanks to topcoat coating

Notes
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.
350	4,4	3.2	60	72	Combi7	Homag (Holzma) 72, HPP 350	193046 L
[mm]	[mm]	[mm]	[mm]				

204389

Panel Sizing Saw Blades DP “TR-F-FA” - nn-System

Product



Drawing

TR-F-FA



LEUCO nn system

DP PANEL

Polycrystalline diamond [DP]

NO

Machine / Application
- panel sizing saws
- for sizing cuts in raw and plastic-laminated panels

Design
- special NoNoise gullet geometry
- diamond cutting edges with polished design
- LEUCODIA tipping quality

Advantages
- especially low noise level
- noise reduction by approx. 6 dB(A) when idling
- for each application case the correct tooth form

Notes
- further dimensions and tooth forms on request

Ø D	B	b	Ø d	Z	Tooth geometry		Ident-No.
308	3,2	2.4	60	96	TR-F-FA	Homag HPS 320	193103 L
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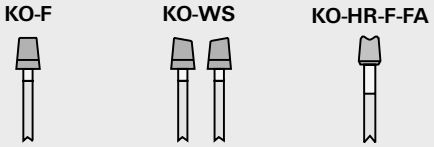
205099

Scoring Saw Blades DP - nn-System

Product



Drawing



LEUCO nn system

DP PANEL

Polycrystalline diamond [DP]

NO

Machine / Application

- Panel Sizing Saw Blades with scoring device
- for scoring of plastic-laminated panels

Design

- NoNoise gullet geometry
- LEUCODIA tipping quality

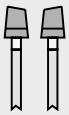
Advantages

- the optimized tooth configuration reduces the repair costs
- the correct tooth configuration for each application case

Notes



KO-F
Universal use in melamine and laminated panels



KO-WS
Veneered panels, reduced motor power



KO-HR-F-FA
Perfect Cutting quality in all different panel materials

Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident-No.
180	4,4-5,2	3.2	30	30	2/10/60	KO-F	Nanxing, Panhans, HOLZ-HER	193379 L
180	4,4-5,2	3.2	30	30	2/10/60	KO-HR-F-FA	Nanxing, Panhans, HOLZ-HER	193387 L
180	4,4-5,2	3.2	30	30	2/10/60	KO-WS	Nanxing, Panhans, HOLZ-HER	193402 L
180	4,4-5,2	3.2	30	36	2/10/60	KO-HR-F-FA	Nanxing, Panhans, HOLZ-HER	193388 C
180	4,4-5,2	3.2	45	30		KO-F	Homag (Holzma)	193380 L
180	4,4-5,2	3.2	45	30		KO-HR-F-FA	Homag (Holzma)	193389 L
180	4,8-5,6	3.5	45	30		KO-F	Homag (Holzma)	193381 L
180	4,8-5,6	3.5	45	30		KO-HR-F-FA	Homag (Holzma)	193391 L
180	4,8-5,6	3.5	45	30		KO-WS	Homag (Holzma)	193403 L
180	4,4-5,2	3.2	45	36		KO-HR-F-FA	Homag (Holzma)	193390 L
180	4,8-5,6	3.5	45	36		KO-HR-F-FA	Homag (Holzma)	193392 L
200	4,4-5,2	3.2	20	30	2/11/66	KO-HR-F-FA	Schelling	193393 L
200	4,4-5,2	3.2	20	36	2/11/66	KO-HR-F-FA	Schelling	193394 L
200	4,4-5,2	3.2	45	30		KO-F	Homag (Holzma)	193383 L
200	4,4-5,2	3.2	45	30		KO-HR-F-FA	Homag (Holzma)	193395 L
200	4,4-5,2	3.2	45	30		KO-WS	Homag (Holzma)	193404 L
200	4,8-5,6	3.5	45	30		KO-F	Homag (Holzma)	193384 L
200	4,8-5,6	3.5	45	30		KO-HR-F-FA	Homag (Holzma)	193397 L
200	4,4-5,2	3.2	65	30	2/9/100 + 2/9/110	KO-F	Selco, SCM	193385 L
200	4,4-5,2	3.2	65	30	2/9/100 + 2/9/110	KO-HR-F-FA	Selco, SCM	193399 L
200	4,4-5,2	3.2	20	30	2/11/66	KO-F	Schelling	193382 C
200	4,4-5,2	3.2	45	36		KO-HR-F-FA	Homag (Holzma)	193396 C
200	4,8-5,6	3.5	45	36		KO-HR-F-FA	Homag (Holzma)	193398 C
200	4,4-5,2	3.2	65	36	2/9/100 + 2/9/110	KO-HR-F-FA	Selco, SCM	193400 C
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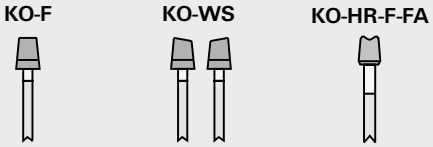
205090

Scoring Saw Blades DP

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

Machine / Application
- Panel Sizing Saw Blades with scoring device
- for scoring of plastic-laminated panels

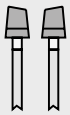
Design
- LEUCODIA tipping quality

Advantages
- the optimized tooth configuration reduces the repair costs
- the correct tooth configuration for each application case

Notes



KO-F
Universal use in melamine and laminated panels



KO-WS
Veneered panels, reduced motor power



KO-HR-F-FA
Perfect Cutting quality in all different panel materials

Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident-No.
220	3,4-4,2	2.4	45	60		KO-F	Homag HPS 320	193386 L
300	4,4-5,2	3.2	30	48	2/11/73 + 2/13/94	KO-HR-F-FA	Schelling	193401 L
300	4,4-5,2	3.2	30	48	2/11/73 + 2/13/94	KO-WS	Schelling	193406 L
300	3,2-4,0	2.4	30	72	2/11/73 + 2/13/94	KO-WS	Schelling	193405 L
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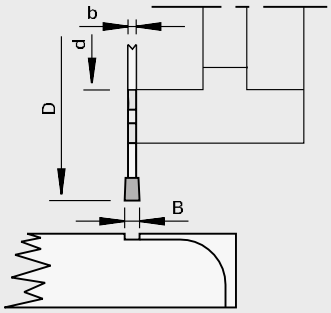
205010

Scoring Saw Blades DP for inlay profiles “F”

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

Machine / Application
- machines Homag
- for chip-free scoring of inlay profiles in veneered panels

Design
- resharpenable area 4.0 mm
- n max = 24,000 min-1
- tooth configuration: flat “F”

Advantages

Notes
- application with feed

Ø D	B	b	Ø d	Z	NL	Ident-No.
70	4,0	3.0	34	8	4/5,3/42	168473 L
75	3,2	2.2	22	10		168464 S
[mm]	[mm]	[mm]	[mm]			

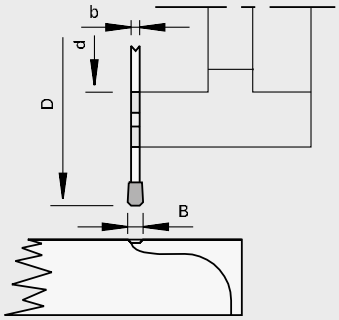
205080

Scoring Saw Blades DP for inlay profiles “F-FA”

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

Machine / Application

- machines Homag
- for chip-free scoring of softforming profiles

Design

- n max = 24,000 min-1
- resharpenable area 3.0 mm
- tooth configuration: flat with two-sided chamfer 1.5 x 45 degrees “F-FA”

Advantages

Notes

- for Homag flange
- application with feed

Ø D	B	b	Ø d	Z	NL	Ident-No.
70	4,3	3.0	34	8	4/5,3/42	168474 C
[mm]	[mm]	[mm]	[mm]			

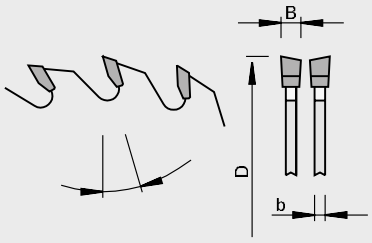
105320 / 105322

Scoring Saw Blades HW “WS”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- panel sizing saws with controllable scoring device
- for scoring of plastic-laminated postforming panels

Design

- tooth configuration: alternate top bevel ”WS”
- cutting material: HW HL Board 06

Advantages

Notes

- cutting width consistently .2 mm wider than the main saw kerf

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁		Ident-No.
180	3,3	2.2	22	36		10	15	Altendorf	192973 C
250	4,55	3.5	30	48	2/10/60	10	15	HOLZ-HER Cut 85	181999 L
250	4,55	3.5	45	48		10	15	Holzma HVP 120	189221 O
280	4,55	3.5	45	84		10	30	Holzma HPP 230+Hpp 250	189324 L
340	5,0	3.5	45	48		10	20	Holzma	188500 L
340	5,0	3.5	45	108		0	20	Holzma	188501 L
[mm]	[mm]	[mm]	[mm]			[°]	[°]		

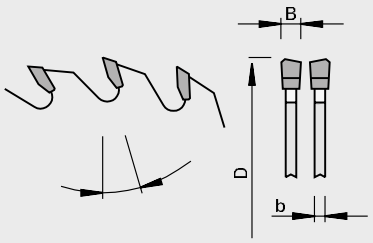
105320

Scoring Saw Blades HW “WS-FA”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- panel sizing saws with controllable scoring device
- for scoring of plastic-laminated postforming panels

Design

- tooth configuration: alternate top bevel with chamfer “WS-FA”
- cutting material: HW HL Board 06

Advantages

Notes

- cutting width consistently .2 mm wider than the main saw kerf

Ø D	B	b	Ø d	Z	NL	Corner◁		Ident-No.
180	4,55	3.2	30	36		15	Schelling	193096 L
300	4,6	3.2	65	72	2/8,4/110 + 2/9/100	5	Selco	188497 L
[mm]	[mm]	[mm]	[mm]			[°]		

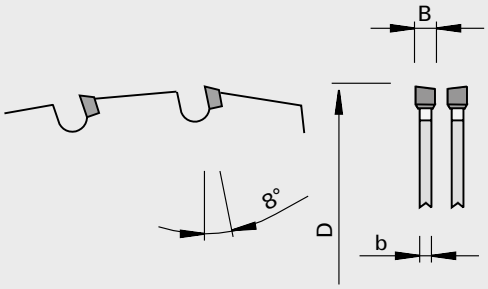
205229

Scoring Saw Blades DP “WS” - nn-System DP flex

Product



Drawing



LEUCO nn system

DP FLEX

Polycrystalline diamond [DP]

Machine / Application

- sizing saws and table saws
- for chip-free scoring of melamine-, paper- or HPL-laminated panels

Design

- resharpenable up to 2 times
- small gullets
- special cutting edge geometry
- tooth configuration: alternate top bevel “WS”
- cutting material: DP

Advantages

- hardly perceivable noise level
- highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping

Notes

- cutting width consistently 0.1 mm wider than the main saw kerf

Ø D	B	b	Ø d	Z	Ident-No.
120	2,6	2.0	22	24	192447 L
120	2,6	2.0	20	24	192448 L
125	2,6	2.0	20	24	192449 L
180	2,6	2.0	22	36	192964 S
[mm]	[mm]	[mm]	[mm]		

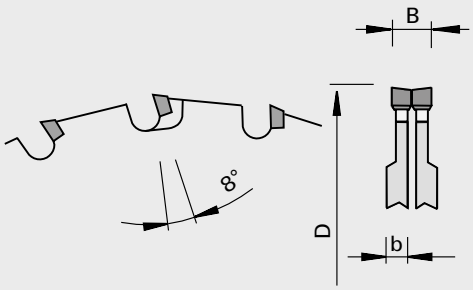
205288

Scoring Saw Blades DP “WS” - adjustable, nn-System DP flex

Product



Drawing



LEUCO nn system

DP FLEX

Polycrystalline diamond [DP]

Machine / Application

- sizing saws and table saws
- for chip-free scoring of melamine-, paper- or HPL-laminated panels

Design

- resharpenable up to 2 times
- small gullets
- tooth configuration: alternate top bevel “WS”
- cutting material: DP

Advantages

- hardly perceivable noise level
- highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping

Notes

- split version - cutting width adjustable with spacers
- Ident-No. 192452 and 192455 automatic kerf adjustment

Ø D	B	b	Ø d	Z		Ident-No.
120	2,4-3,2	2.2	20	12+12	SCM	192450 L
120	2,4-3,2	2.2	22	12+12	Altendorf, Martin	192451 L
120	2,4-3,2	2.2	50	12+12	Altendorf RAPIDO	192452 L
[mm]	[mm]	[mm]	[mm]			

Ø D	B	b	Ø d	Z		Ident-No.
120	2,8-3,6	2.2	20	12+12	SCM	192453 C
120	2,8-3,6	2.2	22	12+12	Altendorf, Martin	192454 L
120	2,8-3,6	2.2	50	12+12	Altendorf RAPIDO	192455 L
[mm]	[mm]	[mm]	[mm]			

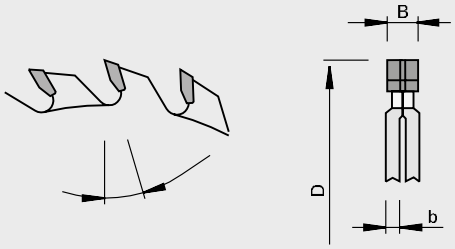
105318

Scoring Saw Blades HW - adjustable “F”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- table saws
- panel sizing saws
- panel sizing saws with controllable scoring device
- for scoring of plastic-laminated panels

Design

- tooth configuration: flat “F”
- cutting material: HW HL Board 03

Advantages

- universally applicable

Notes

- split version - cutting width adjustable with spacers
- for main/scoring saw combinations see specifications (Technical Appendix)
- X = Orginal Striebig Scoring Saw Blades, cutting width adjustable

Ø D	B	b	Ø d	Z	NL	Hook angle			Ident-No.	
70	2,8-3,6	2.2	20	2x8		12	Putsch		193252	L
80	2,8-3,6	2.2	20	2x6	2/4/34	10	Striebig	X	9201253	L
80	2,8-3,6	2.2	20	2x10		12	Striebig		193253	L
120	2,8-3,6	2.2	20	2x12		12	SCM		193197	L
120	2,8-3,6	2.2	22	2x12		12	Altendorf, Martin		193198	L
125	2,8-3,6	2.2	20	2x12		12	HOLZ-HER, SCM		193199	L
125	2,8-3,6	2.2	22	2x12		12	Altendorf, Martin		193200	L
[mm]	[mm]	[mm]	[mm]			[°]				

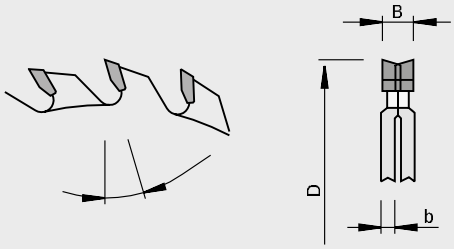
105325 / 105328

Scoring Saw Blades HW - adjustable “WS”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- table saws
- panel sizing saws
- panel sizing saws with controllable scoring device
- for scoring of plastic-laminated panels

Design

- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 03

Advantages

- low motor output thanks to tooth configuration “WS”

Notes

- split version - cutting width adjustable with spacers
- for main/scoring saw combinations see specifications (appendix)

Ø D	B	b	Ø d	Z	NL	Hook angle		Class-No.	Ident-No.
100	2,8-3,6	2.2	20	2x10		12	Schelling	105328	193254 L
100	2,8-3,6	2.2	22	2x10		12	Altendorf, Martin, Panhans, Striebig	105328	193255 L
120	2,8-3,6	2.2	20	2x12		8	SCM	105328	193201 L
120	2,8-3,6	2.2	22	2x12		8	Altendorf, Martin	105328	193202 L
120	2,8-3,6	2.2	22	2x12	2/3,8/42 + 4/4,6/55 + 4/4,6/39	8	Martin NC-adjustment	105328	193203 L
120	2,8-3,6	2.2	50	2x12		12	Altendorf RAPIDO	105328	193256 L
125	4,0-4,8	1.6	45	2x20		12	Giben, Mayer	105325	193257 L
140	2,8-3,6	2.0	36	2x12	2/6,2/51 + 3/ 4,2/55 + 3/9/55	12	Martin T75 PreX	105328	193258 L
160	2,8-3,6	2.2	30	2x16		12	Bäuerle	105328	193259 C
180	2,8-3,6	2.2	30	2x18		10	Koelle	105328	193260 C
300	4,2-4,7	1.8	50	2x32	3/15/80	12	Giben Prismatic + Starmatic	105325	193261 C
340	4,4-5,6	2.5	45	2x24		15	Holzma	105325	193262 C
[mm]	[mm]	[mm]	[mm]			[°]			

Ø D	B	b	Ø d	Z	NL	Hook angle		Class-No.	Ident-No.
120	2,8-3,6	2.2	20	2x22		8	SCM	105328	193204 L
120	2,8-3,6	2.2	22	2x22		8	Altendorf, Martin	105328	193205 L
180	2,8-3,6	2.2	22	2x18		12	Altendorf	105328	193263 C
180	3,2-3,8	2.2	50	2x18		12	Altendorf adjustment unit	105328	193264 L
[mm]	[mm]	[mm]	[mm]			[°]			

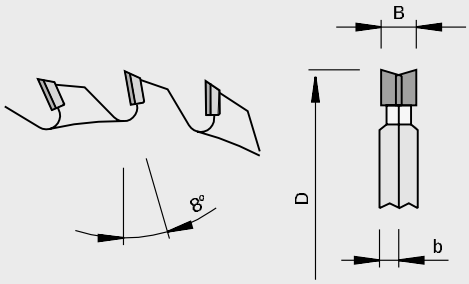
205088

Scoring Saw Blades DP - adjustable “WS”

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

Machine / Application

- table saws
- for chip-free scoring of melamine-, paper- or HPL-laminated panels

Design

- tooth configuration: alternate top bevel “WS”

Advantages

Notes

- application with feed
- split version - cutting width adjustable with spacers
- Ident-No. 189104 automatic kerf adjustment
- X = for Striebig “Compact”, “Evolution”, “Control”, adjustable by means of spring ring and attachment screw

Ø D	B	b	Ø d	Z	NL			Ident-No.	
80	2,8-3,6	2.2	20	2x6	2/4/34	Striebig	X	9201163	L
120	2,8-3,6	2.2	20	2x12	2/3,2/42	SCM		192422	L
120	2,8-3,6	2.2	22	2x12	2/3,8/42	Altendorf, Martin		189101	L
120	2,8-3,6	2.0	50	2x12	3/5,5/63 + 3/9/63	for LEUCO adjustment unit		189652	C
120	2,8-3,8	2.2	50	2x12	4/6,2/62	Altendorf adjustment unit		189104	L
[mm]	[mm]	[mm]	[mm]						

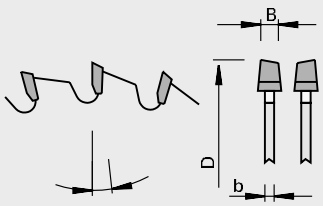
105390

Scoring Saw Blades HW “KO-WS”

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- panel sizing saws with scoring device
- for scoring of plastic-laminated panels

Design

- tooth configuration: conical / alternate top bevel “KO-WS”
- cutting material: HW HL Board 04 plus

Advantages

- low motor output thanks to tooth configuration “KO-WS”
- for longer edge lives compared to HL Board 03 plus
- optimum cutting quality thanks to improved runout accuracy
- reduction of the scoring depth

Notes

- height adjustable to kerf of main saw blade
- optimum scoring depth 1.0 - 2.0 mm

Ø D	B	b	Ø d	Z	NL	Hook angle		Ident-No.
100	3,2-4,0	2.2	20	20		8	Schelling	192717 L
120	3,1-3,9	2.2	20	24		8	Lasari	192718 L
120	3,1-3,9	2.2	22	24		8	Altendorf	192719 L
125	4,45-5,25	3.2	20	20		0	Panhans	192723 L
125	4,45-5,25	3.2	22	20		0	Martin	192724 C
125	4,45-5,25	3.2	45	20		0	Giben, Homag CH03	192725 L
125	3,0-3,8	2.2	20	24		8		192721 C
125	3,2-4,0	2.8	20	24		8	SCM, SICAR, Panhans	192722 L
125	3,0-3,8	2.5	22	24		0	Martin, Altendorf	192720 L
125	4,45-5,25	3.2	45	24		8	Homag Espana	192726 L
150	4,45-5,25	3.2	30	24		8	Irion, Mayer	192727 L
150	4,45-5,25	3.2	45	24		8	Homag CH06,08,10,12	192728 L
150	4,45-5,25	3.2	45	28		8	Homag Espana	192729 L
150	4,45-5,25	3.2	45	36		8	Homag Espana, Homag SAWTEC B-130	193310 L
160	4,45-5,25	3.2	45	28	3/11/70	8	Giben Prismatic	192730 L
160	4,45-5,25	3.2	55	36	3/6,5/66	8	Gabbiani	192731 L
180	4,45-5,25	3.2	20	30	2/9/60	8	Schelling, Anthon	192732 L
180	5,8-6,6	4.0	20	30		8	Anthon	192738 L
180	4,45-5,25	3.2	30	30	2/10/60	8	Panhans	192733 L
180	5,2-6,0	3.5	55	30		0	Giben	192737 C
180	4,45-5,25	3.2	45	36		8	Holzma	192734 L
180	4,85-5,65	3.5	45	36		8	Holzma Typ 11	192736 L
180	4,45-5,25	3.2	50	44	3/13/80	10	Giben Smart	192735 L
200	4,35-5,15	6.0	20	24	2/11/66	8	Schelling	192739 L
200	5,0-5,8	3.5	20	34	2/11/66	8	Schelling	192747 L
200	4,85-5,65	3.5	20	34	2/11/66	8	Schelling FH 8	192744 L
200	4,45-5,25	3.5	20	36	2/11/66	8	Schelling	192740 L
200	4,45-5,25	3.2	30	36	2/10/60	8	S.M.A., Panhans, Scheer	192741 L
200	4,85-5,65	3.5	45	36		8	Holzma	192745 L
200	5,9-6,6	4.0	45	36		8	Holzma	192748 L
200	4,4-5,2	3.2	50	42	3/13/80 + 2/7/80	8	Giben Smart	192742 L
200	4,45-5,25	3.2	65	36	2/9/100 + 2/9/110	8	Selco	192743 L
200	4,85-5,65	3.5	65	36	2/9/110	8	Selco WN / EB	192746 L
200	3,65-4,45	2.5	65	36	2/9/100 + 2/9/110	0	Biesse, Selco	193306 L
215	4,45-5,25	3.2	50	42	3/15/80 + 2/7/80	8	Giben Prismatic + Starmatic	192749 L
280	4,85-5,65	3.5	45	72		8	Holzma	192750 L
[mm]	[mm]	[mm]	[mm]			[°]		

Ø D	B	b	Ø d	Z	NL	Hook angle		Ident-No.
300	4,45-5,25	3.2	30	48	2/11/73 + 2/13/94	8	Schelling FX-H 430	192751 L
300	4,45-5,25	3.2	50	48	3/15/80	8	Giben Prismatic	192752 L
300	4,45-5,25	3.2	65	48	2/8,4/100 + 2/8,4/110	8	Selco EB	192753 L
[mm]	[mm]	[mm]	[mm]			[°]		

Suitable for Panel Sizing Saw Blades Q-Cut G5 + Q-Cut TR-F K

Ø D	B	b	Ø d	Z	NL	Hook angle		Ident-No.
180	4,05-4,85	3.2	20	36		0	Schelling, Anton	192754 C
180	4,05-4,85	3.2	30	36	2/10/60	0	Panhans	192755 C
180	4,05-4,85	3.2	45	36		0	Holzma	192756 L
180	4,05-4,85	3.2	50	36	3/13/80	0	Giben Smart	192757 O
200	4,05-4,85	3.2	20	36	2/11/66	0	Schelling	192758 L
200	4,05-4,85	3.2	30	36	2/10/60	0	S.M.A., Panhans, Scheer	192759 O
200	4,05-4,85	3.2	45	36		0	Holzma	192760 L
200	4,05-4,85	3.2	50	36	3/13/80	0	Giben Smart	192761 S
200	4,05-4,85	3.2	65	36	2/9/100 + 2/9/110	0	Selco	192762 O
[mm]	[mm]	[mm]	[mm]			[°]		

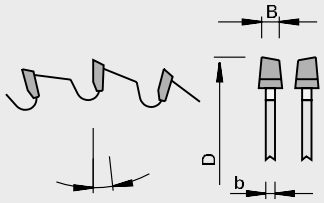
105390

Scoring Saw Blades HW “KO-WS” - LowNoise

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- Table saws
- Panel sizing saws
- Panel sizing saws with controllable scoring device
- for scoring of plastic-laminated panels

Design

- vibration and noise damping ornaments
- tooth configuration: conical / alternate top bevel “KO-WS”
- cutting material: HW HL Board 04 plus

Advantages

- Very quiet when idling and during operation
- Robust tool body thanks to a new design and a thicker tool body

Notes

- height adjustable to kerf of main saw blade
- 1 mm scoring depth = 0.21 mm cutting width
- optimum scoring depth 1.0 - 2.0 mm

Ø D	B	b	Ø d	Z	Hook angle		Ident-No.
120	3,0-3,8	2.5	20	24	8	SCM	193362 L
120	3,0-3,8	2.5	22	24	8	Altendorf, Martin	193363 L
125	3,0-3,8	2.5	20	24	8		193364 L
125	3,0-3,8	2.5	22	24	8	SCM, SICAR, Panhans	193365 L
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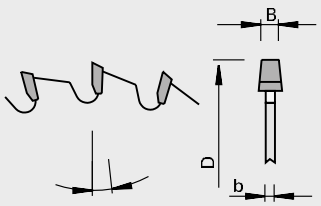
105390

Scoring Saw Blades HW “KO-F”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- panel sizing saws with scoring device
- for scoring of plastic-laminated panels

Design

- tooth configuration: conical-flat “KO-F”
- cutting material: HW HL Board 04 plus

Advantages

- quick adjustment
- universally applicable
- optimum cutting quality thanks to improved runout accuracy
- reduction of the scoring depth

Notes

- height adjustable to kerf of main saw blade
- 1 mm scoring depth = 0.17 mm cutting width
- optimum scoring depth 1.0 - 2.0 mm
- for main/scoring saw combinations see specifications (Technical Appendix)

Ø D	B	b	Ø d	Z	NL	Hook angle		Ident-No.
180	6,7-7,5	4.4	20	30		8	Anthon	192713 L
200	6,7-7,5	4.4	20	34	2/11/66	8	Schelling	192714 L
220	6,7-7,5	4.4	20	36	2/11/66	8	Schelling FS-H / AS-H	192716 L
220	3,25-4,0	2.4	45	60		8	Holzma HPS 320	192715 L
[mm]	[mm]	[mm]	[mm]			[°]		

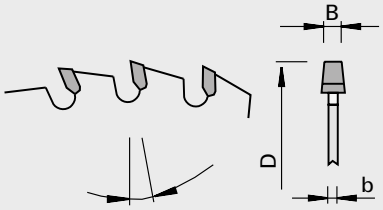
105390

Scoring Saw Blades HW “KO-F” - LowNoise

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- Table saws
- Panel sizing saws
- Panel sizing saws with controllable scoring device
- for scoring of plastic-laminated panels

Design

- vibration and noise damping ornaments
- tooth configuration: conical-flat “KO-F”
- cutting material: HW HL Board 04 plus

Advantages

- Very quiet when idling and during operation
- Robust tool body thanks to a new design and a thicker tool body

Notes

- height adjustable to kerf of main saw blade
- 1 mm scoring depth = 0.21 mm cutting width
- optimum scoring depth 1.0 - 2.0 mm

Ø D	B	b	Ø d	Z	Hook angle		Ident-No.
120	3,0-3,8	2.5	20	24	8	SCM	193366 L
120	3,0-3,8	2.5	22	24	8	Altendorf, Martin	193367 L
125	3,0-3,8	2.5	20	24	8	SCM, SICAR, Panhans	193368 L
125	3,0-3,8	2.5	22	24	8	SCM, SICAR, Panhans	193369 L
[mm]	[mm]	[mm]	[mm]		[°]		

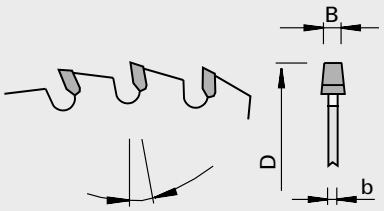
105399

Scoring Saw Blades HW “KO-F” - nn-System

Product



Drawing



LEUCO nn system

LEUCO DUR

Tungsten Carbide [HW]

NO

Machine / Application

- panel sizing saws with scoring device
- for scoring of plastic-laminated panels

Design

- special NoNoise gullet geometry
- tooth configuration: conical-flat “KO-F”
- cutting material: HW HL Board 04 plus

Advantages

- quick adjustment
- universally applicable
- optimum cutting quality thanks to improved runout accuracy
- reduction of the scoring depth
- especially low noise level
- noise reduction by approx. 6 dB(A) when idling
- excellent cutting quality in all common coatings
- long edge lives provide for the necessary productivity and economic efficiency

Notes

- height adjustable to kerf of main saw blade
- 1 mm scoring depth = 0.21 mm cutting width
- optimum scoring depth 1.0 - 2.0 mm
- for main/scoring saw combinations see specifications (Technical Appendix)

Ø D	B	b	Ø d	Z	NL	Hook angle		Ident-No.
120	3,1-3,9	2.5	20	24		8	SCM	192970 L
120	3,1-3,9	2.5	22	24		8	Altendorf, Martin	192971 L
125	3,1-3,9	2.2	20	24		8	SCM, SICAR, Panhans	192698 L
150	4,45-5,25	3.2	45	28		8	Holzma Typ 130	192699 L
150	4,45-5,25	3.2	45	36		8	Homag Espana, Homag SAWTEC B-130	193309 L
180	4,45-5,25	3.2	30	36	2/10/60	8	HOLZ-HER	192700 L
180	4,45-5,25	3.2	45	36		8	Holzma	192701 L
180	4,85-5,65	3.5	45	36		8	Holzma Typ 11	192702 L
200	4,45-5,25	3.5	20	36	2/11/66	8	Schelling	192703 L
200	4,45-5,25	3.0	45	36		8	Homag Sawtech	192704 L
200	4,85-5,65	3.5	45	36		8	Holzma	192705 L
200	4,45-5,25	3.2	65	36	2/9/100 + 2/9/110	8	Selco	192706 L
200	4,45-5,25	3.5	80	36	2/14/110	8	SCM	192707 L
200	4,85-5,65	3.5	80	36	2/14/110	8	SCM	192708 L
200	3,2-4,0	2.2	30	60		15	Scheer	192709 L
250	4,45-5,25	3.5	30	42	2/10/60	8	Panhans, HOLZ-HER	192710 L
280	4,45-5,25	3.2	30	48	2/10/60 + 2/11/66	8	HOLZ-HER	192711 L
[mm]	[mm]	[mm]	[mm]			[°]		

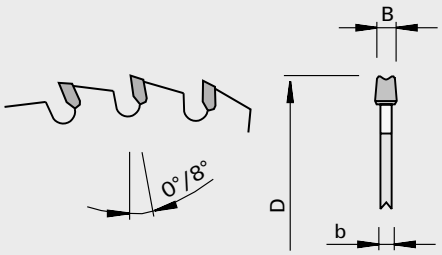
105399

Scoring Saw Blades HW “KO-HR” - nn-System

Product



Drawing



LEUCO nn system

LEUCO DUR

Tungsten Carbide [HW]

NO

Machine / Application

- Panel Sizing Saw Blades with scoring device
- for chip-free scoring of plastic coated, paper laminated as well as veneered panels

Design

- special NoNoise gullet geometry
- cutting material: HW HL Board 04 plus
- tooth configuration: conical hollow back “KO-HR”

Advantages

- especially low noise level
- noise reduction by approx. 6 dB(A) when idling
- excellent cutting quality in all common coatings
- long edge lives provide for the necessary productivity and economic efficiency

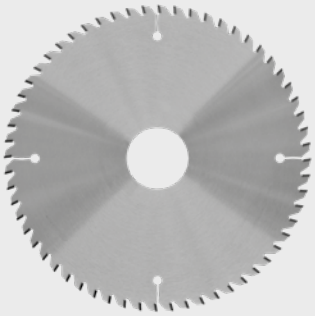
Notes

Ø D	B	b	Ø d	Z	NL	Hook angle		Ident-No.
150	4,05-4,85	3.2	45	28		8	Homag Espana, Homag SAWTEC B-130	193408 L
150	4,45-5,25	3.2	30	28		8	Format 4 Kappa Automatic 80	193219 L
150	4,45-5,25	3.2	45	36		8	Homag Espana, Homag SAWTEC B-130	193311 L
160	4,45-5,25	3.2	45	28	3/11/70	8	Giben Prismatic	192686 C
180	4,45-5,25	3.2	30	30	2/10/60	8	Panhans	192687 L
180	4,05-4,85	3.2	45	36		0	Holzma	192688 L
180	4,45-5,25	3.2	45	36		8	Holzma	192689 L
180	4,85-5,65	3.5	45	36	2/9/110	8	Holzma Typ 11	192690 L
200	4,45-5,25	3.5	20	36	2/11/66	8	Schelling	192691 L
200	4,45-5,25	3.2	30	36	2/10/60	8	S.M.A., Panhans, Scheer	192692 L
200	4,05-4,85	3.2	45	36		0	Holzma	192693 L
200	4,45-5,25	3.2	45	36		8	Holzma	192694 L
200	4,85-5,65	3.5	45	36	2/9/110	8	Holzma	192695 L
200	4,45-5,25	3.2	65	36	2/9/100 + 2/9/110	8	Selco	192696 L
200	4,85-5,65	3.5	65	36	2/9/110	8	Selco WN/EB	192697 L
[mm]	[mm]	[mm]	[mm]			[°]		

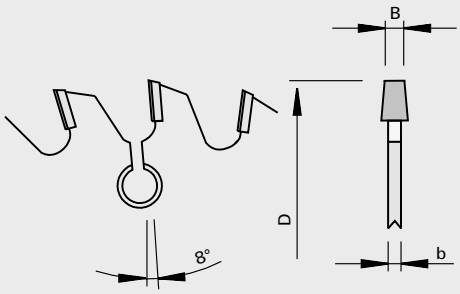
205090

Scoring Saw Blades DP “KO-F” - Homag HPS 320

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

Machine / Application

- Panel Sizing Saw Blades with scoring device
- for scoring of plastic-laminated panels

Design

- diamond cutting edges with polished design
- LEUCODIA tipping quality
- tooth configuration: conical-flat “KO-F”

Advantages

- suitable for high feed rates

Notes

- application with feed

Ø D	B	b	Ø d	Z		Ident-No.
220	3,4 - 4,2	2.4	45	60	Homag HPS 320	193105 S
[mm]	[mm]	[mm]	[mm]			

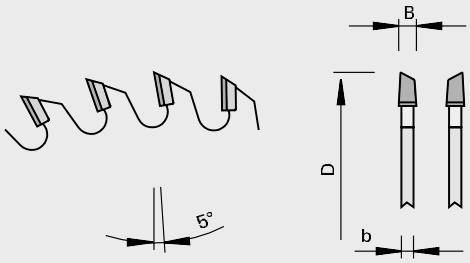
205091

Scoring Saw Blades DP “KO-WS”

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

Machine / Application

- table saws
- for chip-free scoring of melamine-, paper- or HPL-laminated panels

Design

- tooth configuration: conical / alternate top bevel “KO-WS”

Advantages

Notes

- application with feed
- kerf “B” = kerf of the main saw blade

Ø D	B	b	Ø d	Z		Ident-No.
120	3,1-3,9	2.2	22	16	Altendorf, Martin	178766 L
[mm]	[mm]	[mm]	[mm]			

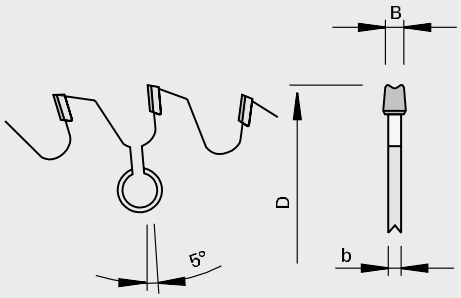
205090

Scoring Saw Blades Holzma DP “KO-HR-FA”

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

Machine / Application

- panel sizing saws
- table saws
- for chip-free scoring of melamine-, paper- or HPL-laminated panels

Design

- tooth configuration: conical hollow back with chamfer “KO-HR-FA”

Advantages

- long edge lives
- excellent cutting quality

Notes

- application with feed

Ø D	B	b	Ø d	Z	NL		Ident-No.
180	4,8-5,6	3.5	45	36		Holzma	182283 L
[mm]	[mm]	[mm]	[mm]				

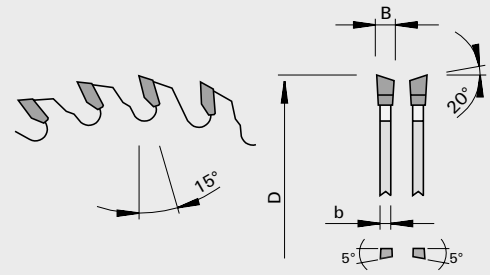
101320

Double Clipping Saw Blades HW with cooling slots “WSA”

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- joinery machines
- double clipping saws
- table saws
- for chop cuts (one-sided, double-sided) for precise lengths of boards, lamellas, etc.

Design

- positive hook angle
- proven asymmetric chip evacuation gap geometry and additional cooling elements
- tooth configuration: alternate top bevel with shear angle “WSA”
- cutting material: HW HL Board 10
- extremely high bending strength and hardness of the teeth

Advantages

- reduced cutting pressure thanks to alternating shear angle
- long edge lives provide for the necessary productivity and economic efficiency

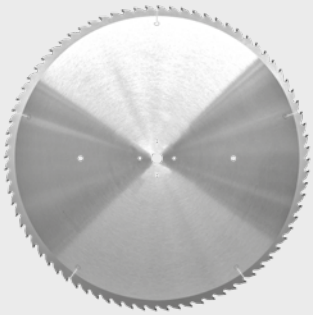
Notes

Ø D	B	b	Ø d	Z	DKN		NL	Ident-No.
350	4,0	2.6	30	54			2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	189788 L
400	4,4	3.0	30	60			2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	189789 L
450	4,4	3.0	30	72			2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	189790 L
500	4,8	3.2	30	72			2/10/80	189792 L
500	4,8	3.2	30	108			2/10/80 + 2/15/63	189794 L
500	4,0	3.2	70	108	20x6			192954 L
550	4,8	3.2	30	72			2/10/80	189795 L
630	5,4	4.0	40	72			2/10/60	189797 C
650	5,6	4.0	30	96			2/10/80 + 2/15/63 + 2/14/100	189798 L
650	5,6	4.0	30	54			2/10/80 + 2/15/63	189799 C
720	6,2	4.4	30	48		Hundegger	2/8,5/90	189800 C
720	6,2	4.4	30	72		Hundegger	2/8,5/90	189801 L
735	6,2	4.4	30	48		Hundegger	2/8,5/90	189802 C
735	6,2	4.4	30	72		Hundegger	2/8,5/90	189803 C
760	6,2	4.4	30	48		Hundegger	2/14/400 + 4/8,5/90	189804 C
760	6,2	4.4	30	72		Hundegger	2/14/400 + 4/8,5/90	189805 C
760	6,2	4.4	30	96		Hundegger	2/14/400 + 4/8,5/90	189806 L
800	6,2	4.4	30	48		Paul		189807 C
[mm]	[mm]	[mm]	[mm]		[mm]			

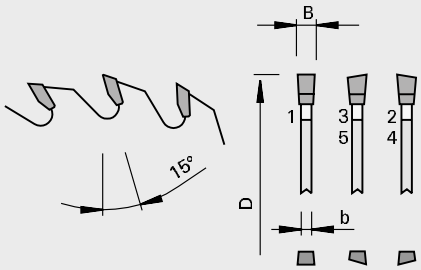
101340 / 101345

Clipping Saw Blades HW - joinery “G5”

Product



Drawing



LEUCO G5 system

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- joinery machines
- for clipping-, crosscut- and shifter cuts in solid wood

Design

- positive hook angle
- tooth configuration: “G5”
- cutting material: HW HL Board 09

Advantages

- excellent cutting quality thanks to special tooth geometry
- extremely quiet during operation due to the low cutting pressure

Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
450	4,4	3.0	30	65	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42		80481000 L
450	5,0	3.5	45	65	2/15/63		80481001 C
500	4,8	3.2	30	110	2/10/80 + 2/15/63		80481002 L
500	4,8	3.2	30	70	2/10/80 + 2/15/63		80481003 L
500	5,6	4.0	30	95	2/10/80		80481004 L
550	4,8	3.2	30	70	2/10/80		80481006 L
550	4,8	3.2	40	70			80481007 O
600	5,4	4.0	30	70	2/10/80 + 2/13/100		80481009 C
600	5,7	4.0	30	95	2/11/60 + 2/13/100		80481010 L
600	5,4	3.8	40	70			80481011 C
650	5,6	4.0	30	95	2/15/63 + 2/10/80 + 2/14/100		80481013 C
650	6,2	4.0	30	60		Krüsi	80481014 C
700	6,0	4.2	30	80	2/11/60 + 2/13/100		80481015 C
720	6,2	4.4	30	70	2/8,5/90	Hundegger	80481016 C
750	6,5	4.5	30	60	2/10,5/60		80481018 C
750	7,0	4.8	60	120		Springer	80481019 C
760	6,2	4.4	30	95	4/8,5/90 + 2/14/400	Hundegger	80481020 C
800	6,5	5.0	30	80	4/9/90 + 2/14/400 + 8/9/160	Hundegger	193097 L
[mm]	[mm]	[mm]	[mm]				

Ø D	B	b	Ø d	Z	NL		Ident-No.
500	4,2	2.8	30	35+2+2		Krüsi	80481005 L
550	4,6	3.2	30	35+2+2+2		Krüsi	80481008 C
640	5,4	3.6	30	40+2+2		Mafell	80481012 C
750	6,5	4.5	40	50+2+2	2/10,5/60	Krüsi, Schneider	80481017 C
[mm]	[mm]	[mm]	[mm]				

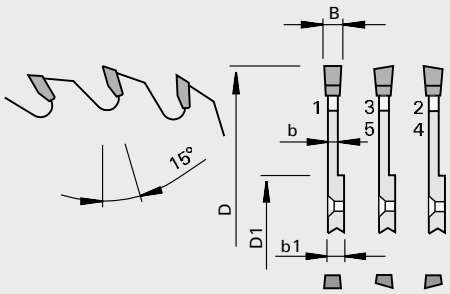
101347

Clipping Saw Blades HW with cooling slots - crosscut- and shifter cuts “G5”

Product



Drawing



LEUCO G5 system

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- joinery machines
- for clipping-, crosscut- and shifter cuts in solid wood

Design

- positive hook angle
- with cooling elements
- tooth configuration: “G5”
- cutting material: HW HL Board 20

Advantages

- excellent cutting quality thanks to special tooth geometry
- extremely quiet during operation due to the low cutting pressure

Notes

Ø D	B	b	b1	Ø D1	Ø d	Z	NL		Ident-No.
555	5,2	3.6	6.0	115	55	70	6/6,6/75	Weinmann	193220 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]				

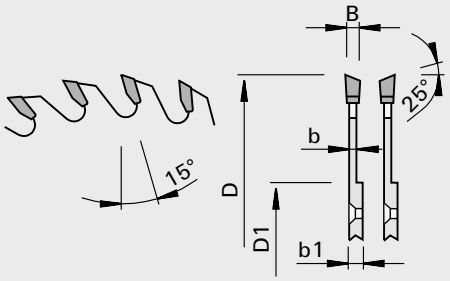
101327

Clipping Saw Blades HW with cooling slots - crosscut- and shifter cuts “WS”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- joinery machines
- for clipping-, crosscut- and shifter cuts in solid wood

Design

- positive hook angle
- with cooling elements
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 20

Advantages

- extremely high bending strength and hardness of the teeth

Notes

Ø D	B	b	b1	Ø D1	Ø d	Z	NL		Ident-No.
555	5,2	3.6	6.0	115	55	54	6/6,6/75	Weinmann	192656 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]				

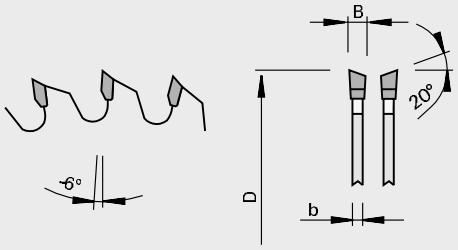
101322

Clipping Saw Blades HW “WS”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- chop and cross-cutting saws
- for cross cuts in solid woods

Design

- negative hook angle
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Solid 15

Advantages

Notes

Ø D	B	b	Ø d	Z	Ident-No.
450	4,4	3.2	30	54	188045 L
500	4,4	3.2	30	60	188046 L
[mm]	[mm]	[mm]	[mm]		

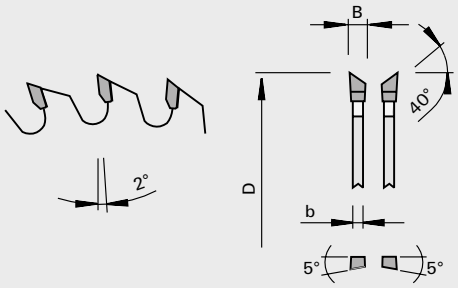
101322

Clipping Saw Blades HW for wood optimization “WSA”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- optimizing chop saws
- undertable cross-cut saws
- push-feed saws
- through-feed saws
- for cross cuts in solid woods

Design

- positive hook angle
- tooth configuration: alternate top bevel with shear angle “WSA”
- cutting material: HW HL Board 06
- extremely high bending strength and hardness of the teeth

Advantages

- reduced cutting pressure thanks to alternating shear angle
- long edge lives provide for the necessary productivity and economic efficiency

Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
400	3,4	2.8	30	120	2/10/60	DIMTER QUANTUM	189896 L
400	4,6	3.5	30	120	2/10/60	DIMTER	189833 L
450	4,6	3.5	30	132	2/15/63	DIMTER	189834 L
500	4,6	3.5	30	144	2/15/63	DIMTER	189835 L
520	4,6	3.5	30	144	2/15/63		189836 L
600	5,2	3.8	30	172	2/15/63	DIMTER	189838 L
630	5,4	4.0	30	180	2/15/63		189839 L
[mm]	[mm]	[mm]	[mm]				

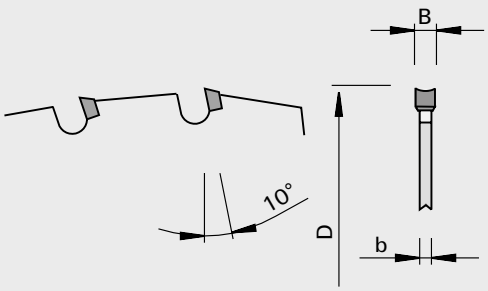
206289

Chop Saw Blades DP “HR” - nn-System DP flex

Product



Drawing



LEUCO nn system

DP FLEX

Polycrystalline diamond [DP]

NO

Machine / Application

- CNC machining centers and aggregates
- for precise cutting in all common wood-based panels such as raw and laminated particle and MDF boards, plywood boards, HDF, WPC, cement and gypsum fiber boards, mineral composites, Alucobond, ...
- for ripping and cross cuts in solid wood, glued laminated timber, thermotreated wood

Design

- resharpenable up to 2 times
- small gullets
- special cutting edge geometry
- tooth configuration: hollow back tooth “HR”
- cutting material: DP

Advantages

- hardly perceivable noise level
- highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping
- reduced cutting pressure thanks to hollow back tooth geometry

Notes

- it is not recommended to use the saw blades for longitudinal cuts in soft wood and material thicknesses of more than 40 mm
- chip-free cuts can only be guaranteed in combination with a suitable scoring saw blade

Ø D	B	b	Ø d	Z	NL		Ident-No.
180	2,5	2.0	30	36	2 x 4/6/52	Homag, Weeke	192432 L
180	2,5	2.0	40	36	8/6/52	Homag, Weeke	193319 L
200	2,5	2.0	30	40	2 x 4/6/52	Homag	192433 L
200	2,5	2.0	30	40	2/6,2/42 + 4/6,6/60	IMA	192434 L
220	2,5	2.0	30	44			192435 L
220	2,5	2.0	40	44	8/6/52	Homag, Weeke	192436 L
240	2,5	2.0	30	50	2 x 4/6/52	Homag	192437 L
240	2,5	2.0	40	50	8/6/52	Homag, Weeke	192438 L
240	2,5	2.0	30	50	2/6,2/42 + 4/6,6/60	IMA	192439 L
[mm]	[mm]	[mm]	[mm]				

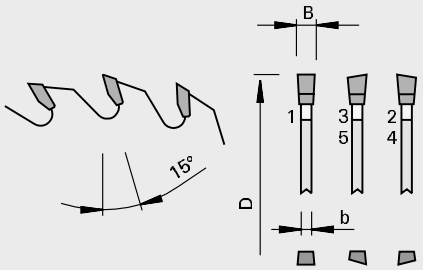
102348

Clipping Saw Blades HW “G5”

Product



Drawing



LEUCO G5 system

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application

- CNC machining centers and aggregates
- for chip-free sizing cuts as well as clipping and mitre cuts in wood-based panels, solid woods and plastics

Design

- tooth configuration: G5
- cutting material: HW HL Board 04 plus

Advantages

- excellent cutting quality for cross cuts
- excellent cutting quality thanks to special tooth geometry
- extremely long edge lives
- noise reduction thanks to laser ornaments

Notes

- pay attention to nmax!!!

Ø D	B	b	Ø d	Z	NL		Ident-No.
180	3,0	2.2	30	60	2 x 4/6/52	Homag, Weeke	192804 L
180	3,0	2.2	40	60	8/6/52	Homag, Weeke	192805 L
200	3,0	2.2	30	65	2 x 4/6/52	Homag	192806 L
200	3,0	2.2	30	65	2/6,2/42 + 4/6,6/60	IMA	192807 O
220	3,0	2.2	40	70	8/6/52	Homag, Weeke	192808 L
240	3,0	2.2	30	75	2 x 4/6/52	Homag	192809 L
240	3,0	2.2	40	75	8/6/52	Homag, Weeke	192810 L
240	3,0	2.2	30	75	2/6,2/42 + 4/6,6/60	IMA	192811 O
280	3,0	2.2	30	85	2 x 4/6/52	Homag	192812 O
[mm]	[mm]	[mm]	[mm]				

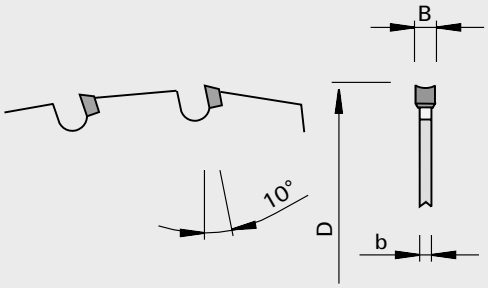
206289

Clipping Saw Blades DP for edge trimming “HR” - nn-System DP flex

Product



Drawing



LEUCO nn system

DP FLEX

Polycrystalline diamond [DP]

NO

Machine / Application

- edge banders
- for trimming of plastic-, veneer- and solid wood edges

Design

- small gullets
- special cutting edge geometry
- tooth configuration: hollow back tooth “HR”
- cutting material: DP
- resharpenable up to 2 times

Advantages

- hardly perceivable noise level
- highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping
- reduced cutting pressure thanks to hollow back tooth geometry

Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
100	2,5	2.0	22	20	2/4/30	EBM, Felder, Lohmeyer	192543 L
100	2,5	2.0	32	30		Brandt	192544 C
110	2,5	2.0	22	24		Reich	192551 C
110	2,5	2.0	22	20		Reich	192552 C
120	2,5	2.0	40	24	8/6/52	Homag	192541 C
120	2,5	2.0	40	36	2x4/5,5/52	Homag	192553 C
125	2,5	2.0	30	36	2x4/6,5/48	Homag BAZ	192554 C
125	2,5	2.0	40	24	2x4/5,8/60	Brandt	192549 C
140	2,5	2.0	16	36		Ott	192545 C
160	2,5	2.0	22	36		IMA	192546 L
160	2,5	2.0	22	48		IMA	192547 C
160	2,5	2.0	30	24	2/7/42	HOLZ-HER	192555 C
170	2,5	2.0	30	36	4/5,5/52	Homag	192542 L
180	2,5	2.0	22	42		IMA	192550 C
180	2,5	2.0	30	54	4/6/52	Homag BAZ	192556 L
200	2,5	2.0	30	64	4/6,6/60 + 2/6,2/42	IMA	192548 C
[mm]	[mm]	[mm]	[mm]				

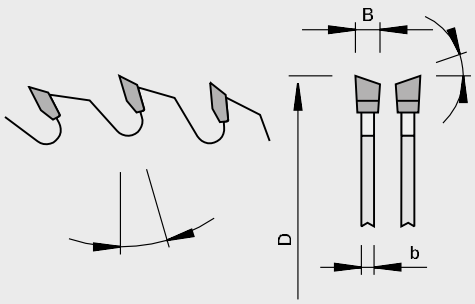
106320

Clipping Saw Blades HW for edge trimming “WS” - without countersink

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge banders
- edge trimming machines
- for trimming of plastic-, veneer- and solid wood edges

Design

- positive or negative hook angle
- with or without shear angle
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 06

Advantages

Notes

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁	Shear◁		Ident-No.
120	3,2	2.5	22	20		10	15	0	HolzHer	80446083 L
125	2,4	1.6	32	24		15	30	0	Brandt	192900 L
160	3,5	2.5	22	36		-5	15	5	IMA	188662 L
180	3,5	2.5	22	42		-6	15	5	IMA	189996 L
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]		

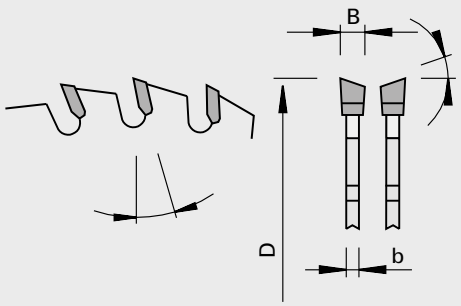
106329

Clipping Saw Blades HW for edge trimming “WS” - nn-System without countersink

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- edge banders
- edge trimming machines
- for trimming of plastic-, veneer- and solid wood edges

Design

- special NoNoise gullet geometry
- positive or negative hook angle
- with or without shear angle
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 06

Advantages

- especially low noise level
- noise reduction by approx. 6 dB(A) when idling

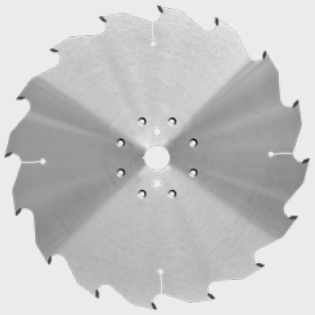
Notes

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁	Shear◁		Ident-No.
90	3,0	2.0	30	20		8	10	0	Reich	192471 L
100	2,4	1.6	22	12		15	10	5	HOLZ-HER	192472 L
100	2,4	1.6	22	20	2/4/30	-8	10	5	EBM	193352 L
100	2,4	1.6	22	30	2/4/30	-8	10	5	EBM, Hebrock	80465377 L
100	3,6	2.2	32	20		8	30	5	Wilmsmeyer	192474 C
100	3,2	2.2	22	20		8	15	0	Felder	192475 L
100	2,4	1.4	22	30		10	15	0	EBM, Hebrock	80484044 L
100	2,6	1.6	32	30		10	15	5	Brandt	192476 L
104	3,0	2.0	22	30		10	15	0	KDT	193353 L
110	3,6	2.5	22	20		8	30	5	HOLZ-HER, Reich	192477 L
110	3,6	2.5	32	20		8	30	5	Homag	192478 L
115	3,2	2.2	30	30		10	30	0	SCM Olimpic	80443014 L
115	3,2	2.2	56	30	3/7,1/68 + 3/7,1/68	15	15	0	Biesse Akron 400	192482 C
120	3,2	2.2	32	20		10	10	5	Homag	192483 L
140	3,2	2.2	16	36		10	15	5	Ott	192489 L
140	3,2	2.2	22	36		10	15	5	HOLZ-HER	192488 L
150	3,2	2.2	22	48		10	10	5	IMA	192493 L
160	3,0	2.5	22	36		-5	15	0	IMA	192456 L
160	3,2	2.2	20	48	2/5/32	10	10	5	HOLZ-HER	192497 L
160	3,2	2.2	22	48		-8	10	5	IMA	192498 L
160	3,2	2.2	30	24	2/7/42	15	10	5	HOLZ-HER	192495 L
160	3,2	2.2	40	30	4/5,5/52	-8	20	10	HOLZ-HER	192496 L
170	3,2	2.2	30	36	4/5,5/52	10	20	0	Homag	193354 L
200	3,2	2.2	30	64	4/6,6/60 + 2/6,2/42	10	15	0	IMA	192501 L
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]		

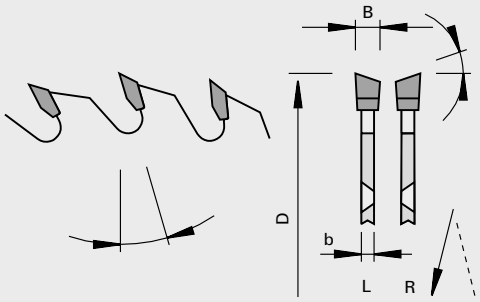
106320

Clipping Saw Blades HW for edge trimming “WS” - with countersink

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge trimming machines
- for trimming of plastic-, veneer- and solid wood edges

Design

- positive hook angle
- with or without shear angle
- pin holes with countersink
- tooth configuration: alternate top bevel ”WS”
- cutting material: HW HL Board 06

Advantages

Notes

- Ident-No. 189259 NL=2/10/60 have no countersink
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner	Shear			Ident-No.
350	3,6	2.5	30	16	2/10/60 + 8/6/90	20	10	0	Homag BAZ	R	189259 L
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]			

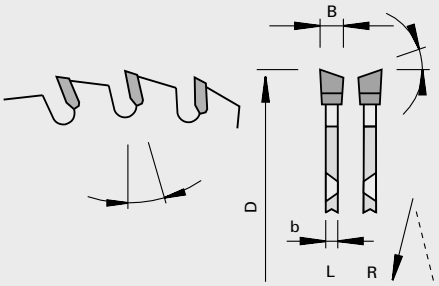
106329

Clipping Saw Blades HW for edge trimming “WS” - nn-System, with countersink

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- edge trimming machines
- for trimming of plastic-, veneer- and solid wood edges

Design

- special NoNoise gullet geometry
- positive hook angle
- with or without shear angle
- pin holes with countersink
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 06

Advantages

- especially low noise level
- noise reduction by approx. 6 dB(A) when idling

Notes

- Ident-No. 192494 NL=4/5,5/52 have no countersink
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁	Shear◁			Ident-No.
110	3,2	2.5	40	20	4/5,5/52	10	45	5	Homag	L	192480 L
110	3,2	2.5	40	20	4/5,5/52	10	45	5	Homag	R	192479 L
110	3,2	2.2	40	30	4/6/52	10	45	0	Homag BAZ	R	192481 C
120	3,6	2.8	40	24	2x4/6/52	8	30	0	Homag	N	189751 L
120	3,2	2.5	40	36	2x4/5,5/52	10	45	5	Homag	N	192484 L
120	3,6	2.8	40	36	2x4/6/52	12	20	0	Homag	N	192485 C
125	2,4	1.6	40	24	2x4/5,8/60	15	30	0	Brandt	N	192486 L
125	2,4	1.6	30	36	2x4/6,5/48	10	30	0	Homag BAZ	N	192487 L
140	3,2	2.2	30	36	4/8,6/46	10	15	5	Biesse Akron 600/800	L	192491 O
140	3,2	2.2	30	36	4/8,6/46	10	15	5	Biesse Akron 600/800	R	192490 O
150	3,6	2.8	40	30	4/6/52	8	30	0	Biesse Akron 600/800	N	192492 L
150	3,2	2.2	30	48	4/6/48 + 4/5,5/52	10	15	0	Homag BAZ	R	192494 L
180	3,2	2.2	30	54	4/6/52	10	30	5	Homag BAZ	L	192500 L
240	3,5	2.2	30	54	8/6,1/52	10	20	0	Homag BAZ	L	192502 C
240	3,5	2.2	40	54	8/6,1/52	10	20	0	Homag BAZ Flex 5, Weeke	L	192503 C
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]			

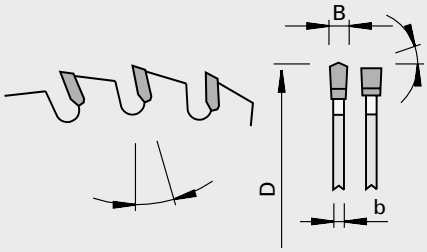
106379

Clipping Saw Blades HW for edge trimming “TR-F” - nn-System

Product



Drawing



LEUCO nn system

LEUCO DUR

Tungsten Carbide [HW]

NO

Machine / Application

- edge banders
- edge trimming machines
- for trimming of plastic-, veneer- and solid wood edges

Design

- special NoNoise gullet geometry
- without shear angle
- positive hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 06

Advantages

- especially low noise level
- noise reduction by approx. 6 dB(A) when idling

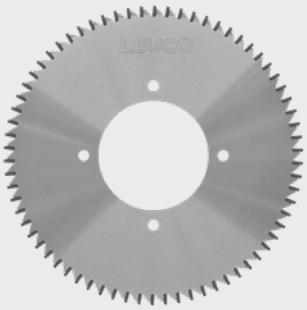
Notes

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁		Ident-No.
110	1,7	1.2	40	30	4/6/52	10	45	Homag BAZ	192504 L
[mm]	[mm]	[mm]	[mm]			[°]	[°]		

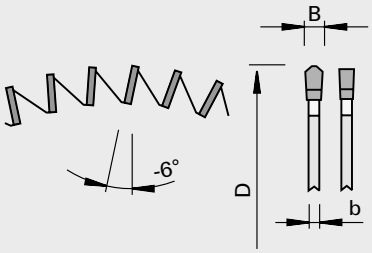
106370

Clipping Saw Blades HW for edge trimming “TR-F”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge banders
- edge trimming machines
- for trimming of plastic-, veneer- and solid wood edges

Design

- without shear angle
- negative hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 10

Advantages

Notes

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁		Ident-No.
140	2,2	2.0	52	70	4/5,5/65	-6	45	IMA	192998 L
[mm]	[mm]	[mm]	[mm]			[°]	[°]		

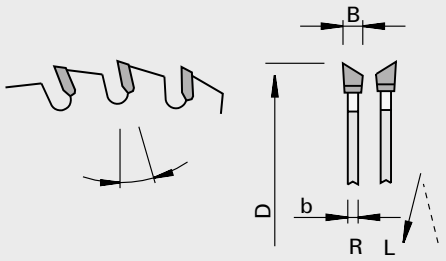
106359

Clipping Saw Blades HW for edge trimming “ES” - nn-System, without countersink

Product



Drawing



LEUCO nn system

LEUCO DUR

Tungsten Carbide [HW]

NO

Machine / Application

- edge banders
- edge trimming machines
- for trimming of thin plastic-, veneer- and solid wood edges

Design

- special NoNoise gullet geometry
- positive or negative hook angle
- with and without shear angle
- tooth configuration: top bevel “ES (right + left)”
- cutting material: HW HL Board 06

Advantages

- especially low noise level
- noise reduction by approx. 6 dB(A) when idling

Notes

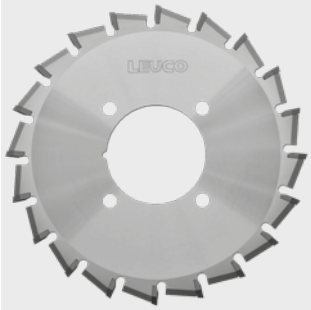
- sense of rotation see drawing

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁	Shear◁		Ident-No. [L]	Ident-No. [R]
100	3,2	2.2	32	20		-6	30	5	Homag	192507 L	192508 C
100	3,0	2.2	32	20		8	30	5	Wilmsmeyer	192505 L	192506 L
100	2,6	2.0	32	30		-10	15	0	Brandt	192510 L	192509 L
100	2,6	2.0	32	30		10	15	0	Homag CN	192514 C	192513 C
100	2,6	1.6	32	30		10	10	0	Brandt	192511 L	192512 L
125	2,6	1.6	32	30		10	10	0	Homag EDGETEQ S-380	193307 L	193308 L
150	3,5	2.2	22	30		-6	15	5	IMA	192521 C	192522 C
150	3,5	2.2	30	30		12	15	5	SCM-IDM	192519 C	192520 C
150	3,5	2.2	30	44	4/5,5/52	-12	45	10	Homag Powerline	192524 L	192523 L
160	3,6	2.5	40	18		8	30	0	HOLZ-HER	192525 C	192526 C
170	3,5	2.2	30	48	4/5,5/52	-12	45	10	Homag Powerline	192528 L	192527 L
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]			

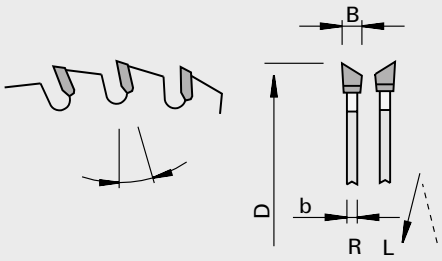
106359

Clipping Saw Blades HW for edge trimming “ES” - nn-System, with countersink

Product



Drawing



LEUCO nn system

LEUCO DUR

Tungsten Carbide [HW]

NO

Machine / Application

- edge banders
- edge trimming machines
- for trimming of thin plastic-, veneer- and solid wood edges

Design

- special NoNoise gullet geometry
- positive or negative hook angle
- with and without shear angle
- pin holes with countersink
- tooth configuration: top bevel “ES (right + left)”
- cutting material: HW HL Board 06

Advantages

- especially low noise level
- noise reduction by approx. 6 dB(A) when idling

Notes

- sense of rotation see drawing

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁	Shear◁		Ident-No. [L]	Ident-No. [R]
110	3,2	2.5	40	20	4/6/52	-6	45	5	Homag	192515 L	192516 L
120	3,2	2.5	40	20	4/6/52	-6	45	5	Homag	192517 L	192518 L
130	3,6	2.8	30	20+4	4/7,4/46	10	30	0	Biesse	192530 C	192529 C
140	3,6	2.8	30	20+2	4/7,4/46	-20	30	0	Biesse	192532 C	192531 C
150	3,8	2.5	35	24+6	4/6/50	10	15	0	SCM-Stefani	192534 L	192533 L
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]			

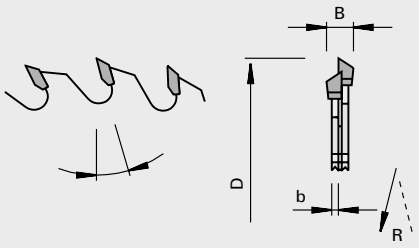
106354

Clipping Saw Blades HW for edge trimming - adjustable “ES”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge banders
- edge trimming machines Homag, Brandt, Raimann, Reich, Ott, SCM-Stefani
- for trimming and chamfering of plastic-, veneer- and solid wood edges

Design

- positive hook angle
- L - left hand bevel “ES-L” / R - right hand bevel “ES-R”
- cutting material: HW HL Board 06

Advantages

Notes

- LEUCODUR HW
- sense of rotation see drawing

Ø D	B	b	Ø d	Z	NL	Hook angle	Shear		Ident-No. [L]	Ident-No. [R]
100	5,8	2.2	32	2x20		8	5		169980 C	169983 L
125	6,2	2.0	30	2x20	2/3,1/42	10	0	SCM-Stefani	189329 L	189332 L
[mm]	[mm]	[mm]	[mm]			[°]	[°]			

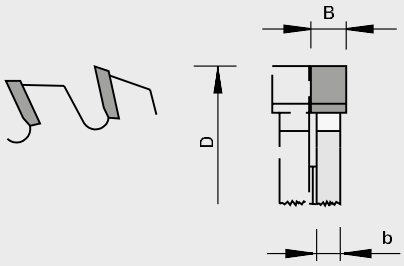
109015

Grooving Saw Blades HW - MAN

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- table shapers
- for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

- Application against feed along the grain (solid wood)
- Application with feed only with mechanical feed (wood-based materials)
- other groove widths possible by set combinations, maximum total groove width 10 mm for MAN
- Groove width calculation for tool sets: sum of all "b" + HW overlap left and right + spacer thickness

Ø D	B	b	Ø d	Z	nmin-nmax	Ident-No.
125	1,5	0.8	30	12	6100-10500	188359 L
125	1,8	1.0	30	12	6100-10500	188360 L
125	2,0	1.2	30	12	6100-10500	188361 L
125	2,2	1.2	30	12	6100-10500	188362 L
125	2,5	1.4	30	12	6100-10500	188363 L
125	3,0	2.0	30	12	6100-10500	188364 L
125	3,5	2.5	30	12	6100-10500	188365 L
125	4,0	2.5	30	12	6100-10500	188366 L
125	4,5	3.0	30	12	6100-10500	188367 L
125	5,0	4.0	30	12	6100-10500	188368 L
125	6,0	4.0	30	12	6100-10500	188369 L
125	7,0	5.0	30	12	6100-10500	188370 L
125	8,0	5.0	30	12	6100-10500	188371 L
125	10	6.0	30	12	6100-10500	188372 L
150	1,5	0.8	30	12	5200-8800	188373 L
150	2,0	1.2	30	12	5200-8800	188375 L
150	2,2	1.2	30	12	5200-8800	188376 L
150	2,5	1.5	30	12	5200-8800	188377 L
150	3,0	2.0	30	12	5200-8800	188378 L
150	3,5	2.5	30	12	5200-8800	188379 L
150	4,0	3.0	30	12	5200-8800	188380 L
150	4,5	3.5	30	12	5200-8800	188381 L
150	5,0	4.0	30	12	5200-8800	188382 L
150	6,0	4.0	30	12	5200-8800	188383 L
150	7,0	5.0	30	12	5200-8800	188384 L
150	8,0	5.0	30	12	5200-8800	188385 L
150	9,0	6.0	30	12	5200-8800	188386 L
150	10	6.0	30	12	5200-8800	188387 L
[mm]	[mm]	[mm]	[mm]		[min-1]	

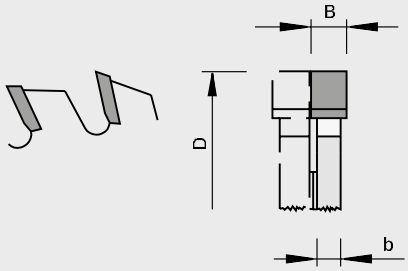
109010

Grooving Saw Blades HW

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- molders
- double end tenoners
- for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

- for Z = 12 and Z = 18 other groove widths are possible when tools are assembled as a set
- groove width calculation for tool sets: sum of all "b" + HW overlap left and right + shim thickness

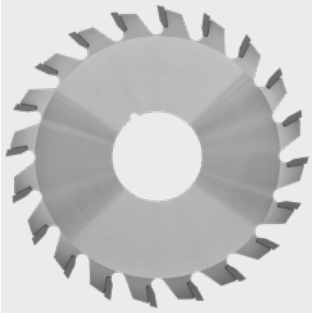
Ø D	B	b	Ø d	Z	DKN	nmax	NL	Ident-No.
150	4,0	3.0	30	12		12700		160802 L
150	5,0	4.0	30	12		12700		001434 L
150	6,0	4.0	30	12		12700		161617 L
150	7,0	5.0	30	12		12700		161619 L
150	8,0	5.0	30	12		12700		161620 L
150	10	6.0	30	12		12700		161622 L
150	5,0	4.0	35	12	10x4	12700		001435 O
150	10	6.0	35	12	10x4	12700		161623 O
150	1,5	0.8	35	18	10x4	10200		001447 L
150	1,8	1.0	35	18	10x4	10200		001448 L
150	2,0	1.2	35	18	10x4	10200		001449 L
150	2,2	1.2	35	18	10x4	10200		001450 C
150	2,5	1.5	35	18	10x4	10200		001451 L
150	3,0	2.0	35	18	10x4	12700		001452 L
150	4,0	3.0	35	18	10x4	12700		001453 L
150	5,0	4.0	35	18	10x4	12700		001454 L
150	6,0	4.0	35	18	10x4	12700		161627 L
150	8,0	5.0	35	18	10x4	12700		161628 L
150	4,0	3.0	30	24		12700		169689 L
150	5,0	4.0	30	24		12700		169688 L
150	6,0	4.0	30	24		12700		169687 L
150	4,0	3.0	30	48 WS		12700		160804 L
180	4,0	3.0	30	12		10600		001442 L
180	5,0	4.0	30	12		10600		001443 L
180	6,0	4.0	30	12		10600		161624 L
180	8,0	5.0	30	12		10600		161625 L
180	10	6.0	30	12		10600		161626 L
180	4,0	3.0	30	18		10600		169685 L
180	5,0	4.0	30	18		10600		169684 L
180	8,0	5.0	30	18		10600		169683 L
180	10	6.0	30	18		10600		169682 L
180	4,0	2.8	65	24		10600	2 x 6/5,5/90	192991 L
180	3,5	2.5	65	24		10600	2 x 6/5,5/90	192990 L
180	3,0	2.2	65	24		10600	2 x 6/5,5/90	192989 C
196	6,0	5.0	30	12 WS		9500		163836 C
200	4,0	2.8	30	24		9500		1527332 C
200	4,5	2.8	30	24		9500		1527333 O
200	5,0	2.8	30	24		9500		1527334 C
200	5,5	2.8	30	24		9500		1527335 O
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]		

Ø D	B	b	Ø d	Z	DKN	nmax	NL	Ident-No.
200	6,0	2.8	30	24		9500		1527336 O
200	6,5	2.8	30	24		9500		1527337 O
200	7,0	5.0	30	24		9500		1527339 O
200	7,5	5.0	30	24		9500		1527340 O
200	8,0	5.0	30	24		9500		1527341 O
200	8,5	5.0	30	24		9500		1527342 O
200	9,0	5.0	30	24		9500		1527343 O
200	9,5	5.0	30	24		9500		1527344 O
200	10	5.0	30	24		9500		1527345 O
220	4,0	3.0	30	30		8700		1521934 O
220	4,5	3.0	30	30		8700		1521935 O
220	5,0	3.0	30	30		8700		1521936 O
220	5,5	3.0	30	30		8700		1521937 O
220	6,0	3.0	30	30		8700		1521938 O
220	6,5	3.0	30	30		8700		1521939 O
220	7,0	5.0	30	30		8700		1521941 O
220	7,5	5.0	30	30		8700		1521942 O
220	8,0	5.0	30	30		8700		1521943 O
220	8,5	5.0	30	30		8700		1521944 O
220	9,0	5.0	30	30		8700		1521945 O
220	9,5	5.0	30	30		8700		1521946 O
220	10	5.0	30	30		8700		1521947 O
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]		

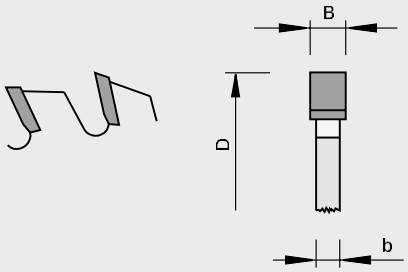
109010

Grooving Saw Blades HW - CNC machining center

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC machining centers
- for chip-free grooving in solid woods and in wood-based panels

Design

- positive hook angle
- without shear angle
- pin holes with countersink
- tooth configuration: flat "F"
- cutting material: HW
- HL Board 06

Advantages

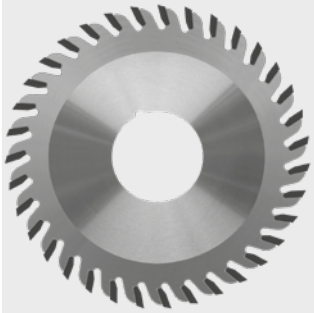
Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
100	3,2	2.2	30	20		Weeke	189571 L
100	4,0	3.0	30	20		Weeke	189647 L
100	5,0	3.0	30	20		Weeke	189260 L
120	4,0	3.0	35	30	4/6/50	Biesse, Felder Profit H22	189262 L
125	3,2	2.2	30	36	2x4/6,1/48	Weeke	189306 L
125	4,0	3.0	30	36	2x4/6,1/48	Weeke	189995 L
250	4,0	3.0	30	60	2/10/60		192470 L
[mm]	[mm]	[mm]	[mm]				

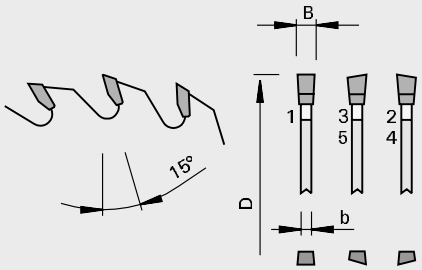
109340/122410

Grooving Saw Blades HW “G5”

Product



Drawing



LEUCO G5 system

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- Weeke BHX series
- CNC machining centers and aggregates
- for chip-free grooving in solid woods, raw and laminated wood-based panels and plastics

Design

- tooth configuration: G5
- cutting material: HW HL Board 03, HL Board 05

Advantages

- excellent cutting qualtiy
- especially low noise level
- long edge lives also thanks to highly wear-resistant cutting material

Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
100	4,0	2.8	30	35		Weeke BHX Series 050/055	189994 L
100	5,0	4.0	30	35		Weeke BHX Series 050/055	191947 L
100	8,5	3.5	20	30		HOLZ-HER	193135 L
100	8,5	3.5	30	30	2x4/5,5/48	Weeke BHX 050 series, Homag Drillteq V200/500	193134 C
120	4,0	2.8	20	35			191948 L
120	5,0	4.0	20	35			191949 L
120	4,0	2.8	20	35	2x3/4,5/35	SCM / Morbidelli	191950 L
120	5,0	4.0	20	35	2x3/4,5/35	SCM / Morbidelli	191951 O
120	4,0	2.8	35	35	2x4/5,5/50 + 2/6/46+50	Biesse	191952 L
120	5,0	4.0	35	35	2x4/5,5/50 + 2/6/46+50	Biesse	191953 L
125	4,0	2.8	30	35	2x4/5,5/48	Weeke BHX Series 500 and other BAZ, BOF m/c and aggregates	189993 L
125	5,0	4.0	30	35	2x4/5,5/48	Weeke BHX 500 series and other machining centers and aggregates	191946 L
[mm]	[mm]	[mm]	[mm]				

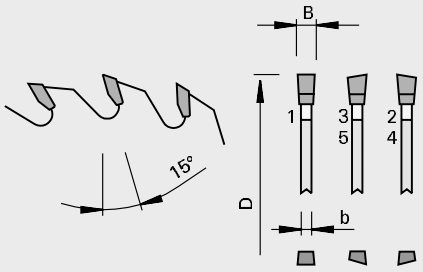
209080

Grooving Saw Blades DP “G5”

Product



Drawing



LEUCO G5 system

LEUCO DUR

Polycrystalline diamond [DP]

MEC

Machine / Application

- Weeke BHX series
- CNC machining centers and aggregates
- for chip-free grooving in solid woods, raw and laminated wood-based panels and plastics

Design

- tooth configuration: G5
- cutting material: DP

Advantages

- excellent cutting quality
- noise reduction due to the very low cutting pressure
- extremely long edge lives

Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
100	4,0	3.2	30	35		Weeke BHX Series 050/055	193315 L
120	4,0	3.2	20	35			193316 L
125	4,0	3.2	30	35	2x4/5,5/48	Weeke BHX Series 500 and other BAZ, BOF m/c and aggregates	193317 L
125	5,0	4.2	30	35	2x4/5,5/48	Weeke BHX Series 500 and other BAZ, BOF m/c and aggregates	193318 L
[mm]	[mm]	[mm]	[mm]				

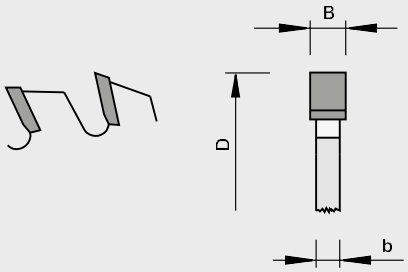
209010

Grooving Saw Blades DP - machining centers

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC machining centers
- for chip-free grooving in solid woods and in wood-based panels

Design

- positive hook angle
- without shear angle
- pin holes with countersink
- tooth configuration: flat “F”

Advantages

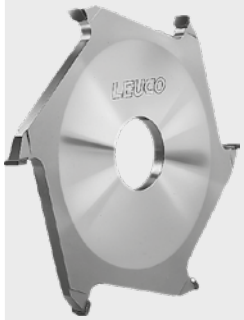
Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
125	3,2	2.2	30	36	4/6,1/48 + 4/6,1/48	Weeke	189649 C
125	4,0	3.0	30	36	4/6,1/48 + 4/6,1/48	Weeke	189648 C
[mm]	[mm]	[mm]	[mm]				

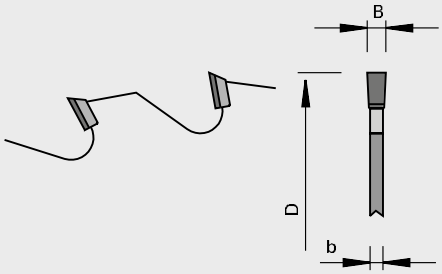
209010

Grooving Saw Blades DP

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- edge banding machines
- for chip-free grooving in solid woods and in wood-based panels

Design

- resharpenable area 3.5 mm
- tooth configuration: flat

Advantages

Notes

- application with feed
- number of teeth depends on the feed rate, the material to be cut and the desired cutting quality

Ø D	B	b	Ø d	Z	DKN	nmax	Ident-No.
180	4,0	3.0	35	12	10x4	10000	178194 C
180	4,0	3.0	35	18	10x4	10000	178195 C
180	4,0	3.0	35	24	10x4	10000	178196 C
180	5,0	4.0	35	18	10x4	10000	178197 C
180	5,0	4.0	35	24	10x4	10000	178198 C
180	6,0	5.0	35	12	10x4	10000	178199 C
180	6,0	5.0	35	18	10x4	10000	178200 C
180	6,0	5.0	35	24	10x4	10000	178201 C
180	8,0	7.0	35	12	10x4	10000	178202 C
180	8,0	7.0	35	18	10x4	10000	178203 C
180	8,0	7.0	35	24	10x4	10000	178204 C
180	5,0	4.0	35	12	10x4	10000	178205 C
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

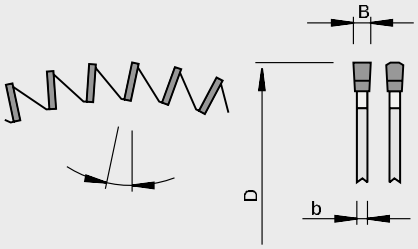
102370

NF-Chop Saw Blades HW “TR-F”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- chop and miter saws
- for cross cuts in thin-walled plastic and aluminum profiles

Design

- negative hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 10

Advantages

- smooth running and no chipping of edges of the workpiece thanks to the high number of teeth

Notes

Ø D	B	b	Ø d	Z	Hook angle	Ident-No.
200	2,2	2.0	30	100	-6	188388 L
250	2,2	1.6	30	126	-6	189709 L
[mm]	[mm]	[mm]	[mm]		[°]	

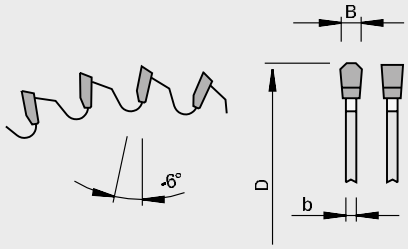
108672

NF-Chop Saw Blades HW - negative hook angle “TR-F” highline

Product



Drawing



LEUCO highline

LEUCO DUR

Tungsten Carbide [HW]

LOW NOISE

Machine / Application

- chop and miter saws
- for clipping and mitre cuts in aluminum and plastic profiles

Design

- negative hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 10

Advantages

- noise-reduction thanks to laser ornaments

Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
250	3,2	2.5	30	60	2/7/42	DeWALT, ELU, Haffner, Makita	189846 L
250	2,8	2.2	30	80	2/7/42	ELU, Mafell, Metabo, Festo, Haffner, Hitachi	189847 L
250	3,2	2.5	30	80	2/7/42	DeWALT, ELU, Haffner, Makita	189848 L
250	3,2	2.5	32	80	2/7/42 + 2/9/46 + 2/10/60	Kaltenbach TL 250, ELU TGS 71, 171, 172, Baier, Fezer, Ulmia, Trennjäger	189849 O
275	3,2	2.5	40	88	4/12/64 + 2/9/55	Eisele LMS I new, Graule, Trennjäger, Weidmann	189850 L
300	3,2	2.5	30	72	2/7/42 + 2/10/60	DeWALT, Fezer, Schleicher	189851 L
300	3,2	2.5	32	72	2/7/42 + 2/9/46 + 2/10/60	ELU MGS 73, Rapid, Trennjäger, Fezer, Berg&Schmid	189852 O
300	2,8	2.2	30	96	2/7/42 + 2/10/60		189853 L
300	3,2	2.5	30	96	2/7/42 + 2/10/60	DeWALT, Fezer, Schleicher	189854 L
300	3,2	2.5	32	96	2/7/42 + 2/9/46 + 2/10/60	ELU MGS 73, Rapid, Trennjäger, Fezer, Berg&Schmid	189855 O
330	3,2	2.5	30	96	2/10/60 + 2/9/46 + 2/7/42	ELU, Haffner	189856 L
330	3,2	2.5	32	96	2/10/60 + 2/9/46 + 2/7/42	ELU	189857 O
[mm]	[mm]	[mm]	[mm]				

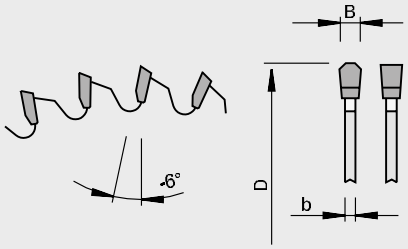
108372

NF-Chop Saw Blades HW - negative hook angle “TR-F” topline

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application

- chop and miter saws
- for clipping and mitre cuts in aluminum and plastic profiles

Design

- negative hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 06

Advantages

- noise-reduction thanks to laser ornaments

Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
350	3,8	3.2	40	84	4/12/64 + 2/9/55	Eisele LMS II, LMS II - P V, VA - L, Graule, Ulmia, Weidmann	193115 L
350	3,2	2.5	30	90	2/10/60	DeWALT, Haffner, Pfeiffer	193116 L
350	3,2	2.5	30	96	2/10/60		193117 L
350	3,2	2.5	30	108	2/9/55 + 2/10/60 + 4/12/64		193118 L
350	3,2	2.5	40	108	4/12/64 + 2/9/55	Eisele LMS II, LMS II - PV, VA - L, Graule, Ulmia, Weidmann	193119 O
400	3,8	3.2	30	96	2/12/64 + 4/15/80	DeWALT, Haffner	189863 L
400	3,8	3.2	50	96	4/15/80	Kaltenbach TL 400	189864 O
420	4,0	3.2	30	96		Rapid, ELU	189865 L
450	3,8	3.2	30	96	4/12/64 + 2/12/80	DeWALT, Haffner	189866 L
500	4,0	3.4	30	120	2/10/70	Pfeiffer, Rapid	189867 L
[mm]	[mm]	[mm]	[mm]				

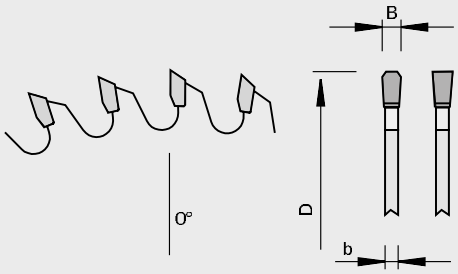
108370

NF-Chop Saw Blades HW - neutral hook angle “TR-F”

Product



Drawing



Tungsten Carbide [HW]

Machine / Application
- chop and miter saws
- table saws
- for clipping and mitre cuts in aluminum profiles

Design
- neutral hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 06

Advantages
- burr-free cuts in profiles with low roughness
- noise-reduction thanks to laser ornaments

Notes
- tight workpiece clamping required
- Kaltenbach as counter-bore type

Ø D	B	b	Ø d	Z	NL		Ident-No.
380	3,6	3.0	32	90		Elumatec	189111 L
420	3,8	3.2	30	102	2/10/70	Rapid, Elumatec	189074 L
500	4,0	3.4	30	114	2/10/70	Rapid, Elumatec	189075 L
500	4,0	3.4	32	114	2/12/64	Eisele LMS SCA	189076 L
550	4,4	3.8	30	126	2/10/70	Elumatec, Kaltenbach, Rapid	189113 L
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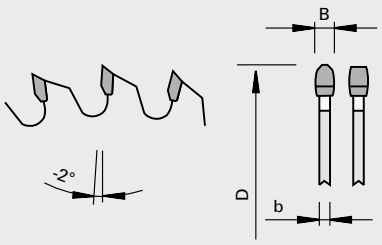
108377

NF-Chop Saw Blades HW - profiles “TR-F K” - easyFix

Product



Drawing



Tungsten Carbide [HW]

easyFix

Machine / Application
- clipping and miter saws
- table saws
- for burr-free and very smooth cuts in thin-walled aluminum profiles

Design
- negative hook angle
- tooth configuration: “TR-F K”
- cutting material: HW HL Board 06

Advantages
- easyFix: NEW, EASY HANDLING, easy and smooth mounting of the saw blade on the machine despite high-precision bore tolerance
- very clean cutting surfaces due to convex tooth sides
- very long edge life and economic efficiency

Notes
- secure workpiece clamping required
- wall thickness max. 5 mm (optimum 2-3 mm)

Ø D	B	b	Ø d	Z	Hook angle	NL	Ident-No.
350	3,2	2.5	30	96	-2	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	193291 L
380	3,8	3.2	32	108	-2	2/11/63	193292 L
400	3,8	3.2	30	108	-2	2/10/60 + 2/12/64	193293 L
420	4,0	3.2	30	108	-2	2/10/60 + 2/11/70	193294 L
450	3,8	3.2	30	120	-2	2/10/60 + 2/11/70	193295 L
500	4,0	3.4	30	144	-2	2/10/60 + 2/11/70	193296 L
550	4,0	3.4	30	144	-2	2/11/63 + 2/11/70	193297 L
600	5,0	4.0	30	140	-2	2/11/63 + 2/11/70	193298 L
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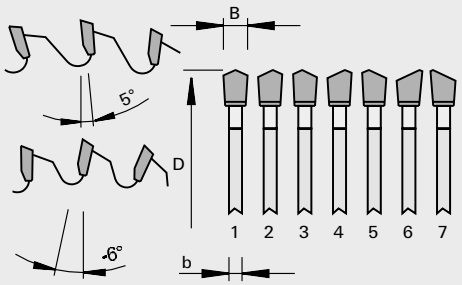
108351 / 108352

NF-Chop Saw Blades HW - profiles “G7”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application

- clipping and miter saws
- table saws
- clipping and miter cuts in PVC profiles
- for burr-free and smooth cuts in aluminum window and façade profiles

Design

- positive or negative hook angle
- tooth configuration: “G7”
- cutting material: HW HL Board 06

Advantages

- reduced cutting pressure thanks to group tooth geometry
- excellent burr-free cuts with low roughness thanks to tooth partition
- extremely noise-reduced thanks to special laser ornaments
- increased edge life compared to chop saw blades with tooth configuration “TR-F”
- increased performance and economic efficiency

Notes

- Secure workpiece clamping required
- Max. wall thickness 5 mm

Ø D	B	b	Ø d	Z	Hook angle	NL		Ident-No.
300	3,2	2.5	30	98	5	2/7/42 + 2/9/46 + 2/10/60 + 2/11/70		192663 L
350	3,2	2.5	30	98	5	2/7/42 + 2/9/46 + 2/10/60		192662 L
400	3,8	3.2	30	98	5	2/7/42 + 2/9/46 + 2/10/60 + 2/15/80 + 4/12/64		192659 L
420	3,8	3.2	30	98	5			192660 L
420	3,8	3.2	32	98	5	2/12/64		193361 L
500	4,0	3.4	30	126	5	2/7/42 + 2/9/46 + 2/10/60 + 2/10/70 + 4/12/64		192661 L
[mm]	[mm]	[mm]	[mm]		[°]			

Ø D	B	b	Ø d	Z	Hook angle	NL		Ident-No.
250	3,2	2.5	30	84	-6	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60		192965 L
300	3,2	2.5	30	98	-6	2/7/42 + 2/9/46 + 2/10/60 + 2/11/70		192568 L
350	3,2	2.5	30	112	-6	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60		192275 L
350	3,2	2.5	32	112	-6	2/12/64		193355 L
350	3,5	2.8	30	98	-6	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	DeWALT, Haffner, Pfeiffer, Rotox	192274 L
350	3,8	3.2	40	84	-6	4/12/64 + 2/9/55	Eisele LSM II, -LSM II-PV, -VA-L, Graule, Ulmia, Weidmann	192273 L
380	3,8	3.2	32	112	-6		Elumatec	192567 L
400	3,8	3.2	30	98	-6	2/10/60 + 2/12/64 + 4/15/80	DeWALT, Haffner	192276 L
400	3,8	3.2	30	126	-6	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 + 2/12/64		193356 L
420	4,0	3.2	30	98	-6	2/10/60 + 2/11/70	Rapid, ELU	192277 L
400	3,2	2.5	32	126	-6	2/12/64		193357 L
450	3,8	3.2	30	112	-6	2/12/64 + 4/15/80	DeWALT, Haffner	192278 L
450	3,8	3.2	32	112	-6	2/12/64		193358 L
450	3,8	3.2	32	126	-6	2/12/64		193359 L
500	4,0	3.4	30	126	-6	2/11/70 + 2/10/60	Pfeiffer, Rapid	192279 L
500	4,0	3.2	32	126	-6	2/12/64		193360 L
550	4,0	3.4	30	133	-6	2/10/60 + 2/12/64 + 4/15/80	Pfeiffer, Rapid, Elumatec	192392 L
600	4,6	4.0	32	140	-6		Pfeiffer, Rapid	193341 L
[mm]	[mm]	[mm]	[mm]		[°]			

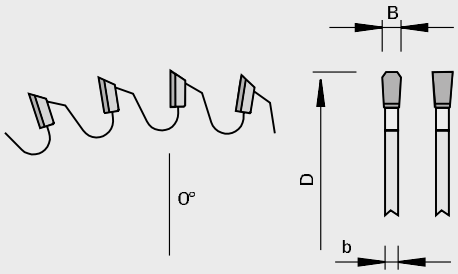
208170

DIAREX NF-Chop Saw Blades DP - Profile “TR-F”

Product



Drawing



LEUCO topline

LEUCO DIAREX

Polycrystalline diamond [DP]

LOW

Machine / Application
- chop and miter saws
- for clipping and mitre cuts in aluminum profiles

Design
- neutral hook angle
- tooth configuration: triple chip / flat “TR-F”

Advantages
- excellent burr-free cuts with low roughness thanks to special laser ornaments and tooth partition

Notes
- tight workpiece clamping required

Ø D	B	b	Ø d	Z	NL		Ident-No.
275	3,4	2.8	32	60	4/9/50	Wagner 1994	189868 C
285	3,4	2.8	32	60	4/9/50	Wagner	189869 C
380	3,6	3.0	32	84	4/9/50	Elumatec	189870 C
400	3,8	3.2	40	90	2/12/80	Eisele VA-L 350 NC1	189871 C
500	4,0	3.4	30	114	2/10/70	Elumatec	189872 C
550	4,2	3.6	30	120		Elumatec MGS	189873 C
[mm]	[mm]	[mm]	[mm]				

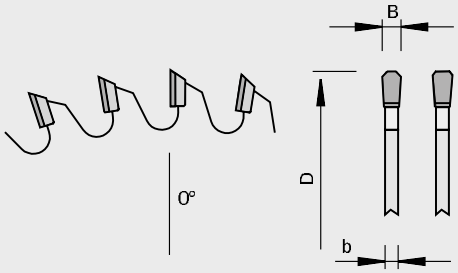
208180

DIAREX NF-Chop Saw Blades DP - Solid “TR-F-FA”

Product



Drawing



LEUCO topline

LEUCO DIAREX

Polycrystalline diamond [DP]

LOW

Machine / Application
- chop and miter saws
- for miter cuts in solid aluminum materials

Design
- neutral hook angle
- tooth configuration: inverted-v / flat with chamfer “TR-F-FA”

Advantages
- excellent burr-free cuts with low roughness thanks to special laser ornaments and tooth partition

Notes
- tight workpiece clamping required

Ø D	B	b	Ø d	Z	NL		Ident-No.
500	4,0	3.4	50	90	4/15/80	Kaltenbach RKL 550	189874 C
500	4,0	3.4	30	90		Elumatec	189875 C
550	4,4	3.8	50	96	4/15/80	Kaltenbach RKL 550	189876 C
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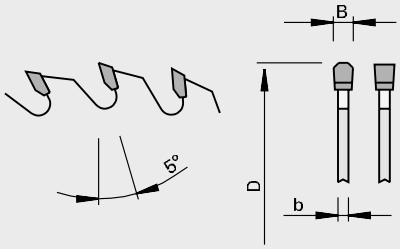
108671

NF-Chop Saw Blades HW - positive hook angle “TR-F” highline

Product



Drawing



LEUCO highline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application
- table saws
- for dividing and miter cuts in aluminum and plastic profiles as well as for wood-based panels (Corian®, Noblan, Varicor® and HPL)

Design
- positive hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 10

Advantages
- noise-reduction thanks to laser ornaments

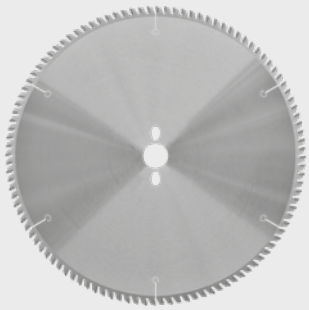
Notes
- tight workpiece clamping required

Ø D	B	b	Ø d	Z	NL		Ident-No.
250	3,2	2.5	30	80	2/7/42 + 2/9/46 + 2/10/60	Haffner, ELU, Makita	189877 L
300	3,2	2.5	30	72	2/7/42 + 2/9/46 + 2/10/60	Fezer, Rapid	189878 L
300	3,2	2.5	30	96	2/7/42 + 2/9/46 + 2/10/60	Fezer, Rapid	189879 L
300	3,2	2.5	32	96			189880 O
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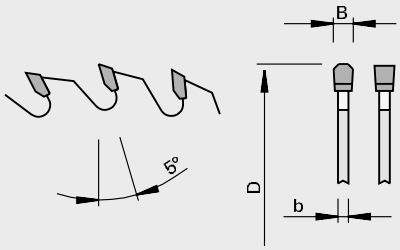
108371

NF-Chop Saw Blades HW - positive hook angle “TR-F” topline

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application
- table saws
- for dividing and miter cuts in aluminum and plastic profiles as well as for wood-based panels (Corian®, Noblan, Varicor® and HPL)

Design
- positive hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 06

Advantages
- noise-reduction thanks to laser ornaments

Notes
- tight workpiece clamping required

Ø D	B	b	Ø d	Z	NL		Ident-No.
350	3,2	2.5	30	108	2/7/42 + 2/9/46 + 2/10/60	Haffner, Rapid, Pfeffer	193114 L
350	3,2	2.5	32	92	2/12/64		193113 L
350	3,2	2.5	32	108	2/12/64		193112 L
400	3,8	3.2	30	96	4/12/64 + 2/12/80		189882 L
400	3,8	3.2	40	96	4/12/64 + 2/12/80	Eisele LMS II, LMS III	189883 O
420	3,8	3.2	30	96		ELU DG 102, 104, DLG, MGS 105, Rapid SAT	189884 L
450	3,8	3.2	40	108	4/12/64 + 2/12/80	Eisele	189885 L
500	4,0	3.4	30	120	2/10/70 + 2/12/64	Pfeifer, Rapid, BKS	189886 L
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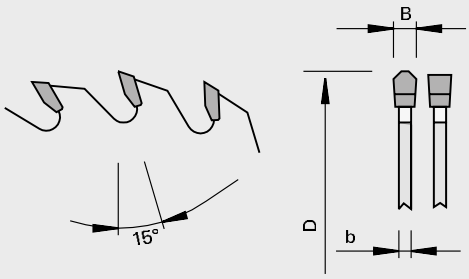
108373

NF-Panel Sizing Saw Blades HW - positive hook angle “TR-F”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

LOW NOISE

Machine / Application

- horizontal panel sizing saws
- for dividing cuts in aluminum block materials

Design

- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 09

Advantages

- noise-reduction thanks to laser ornaments

Notes

- for stack heights up to 200 mm (for large saw diameters)

Ø D	B	b	Ø d	Z	NL	H		Ident-No.
450	4,5	3.2	40	60	2/13/114	-100	Schelling	189887 C
450	4,8	3.5	60	60	2/14/125 + 2/19/120	-100	Holzma	189891 S
620	5,5	4.2	40	60	2/13/114	110-160	Schelling	189888 C
680	5,8	4.5	40	60	2/13/114	-200	Schelling	189889 C
720	6,0	4.8	40	60	2/13/114	150-220	Schelling	189890 C
[mm]	[mm]	[mm]	[mm]			[mm]		

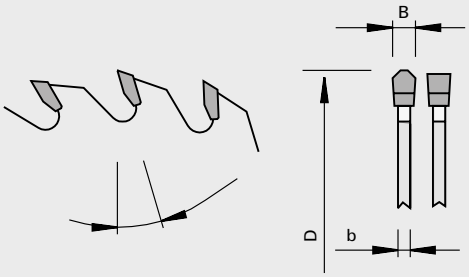
108271

NF-Thin-Kerf-Chop Saw Blades HW - positive hook angle “TR-F”

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- chop saws
- for dividing and trimming of aluminum profiles (bars, tubes, ...)

Design

- with laser ornaments
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 08

Advantages

- less vibration and noise thanks to laser ornaments

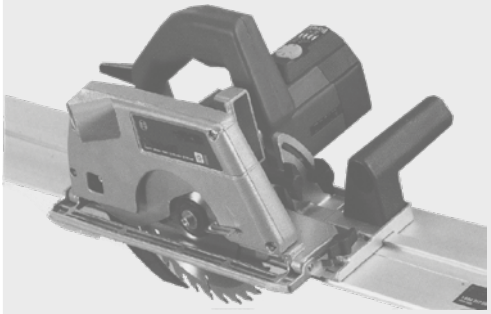
Notes

Ø D	B	b	Ø d	Z	Hook angle	NL		Ident-No.
285	2,0	1.6	32	60	5	4/9/50 + 4/11/63	Kasto Speed C9, Kasto WAC-70, Tsune, Nishijima, Rhobi, Everising, I.T.E.C	189655 C
360	3,4	2.6	50	60	5	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15, Kaltenbach KMR-100AP Tsune, Nishijima, Sinico, Endo	189657 S
360	3,4	2.6	50	80	5	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15, Kaltenbach KMR-100AP Tsune, Nishijima, Sinico, Endo	189656 S
425	3,4	2.6	50	50	5	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15	189658 S
425	3,4	2.6	50	60	5	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15	189659 S
460	3,4	2.6	50	50	8	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15, Everising, Noritake	189660 S
460	3,4	2.6	50	60	8	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15, Everising, Noritake	189662 C
460	3,4	2.6	50	80	8	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15, Everising, Noritake	189661 S
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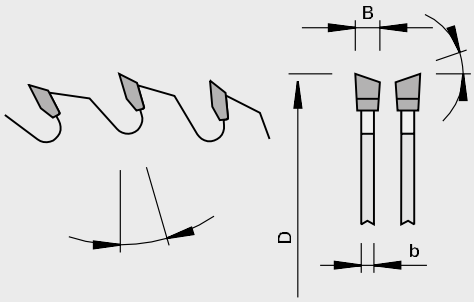
107520

Portable Saw Blades HW “WS”

Product



Drawing



LEUCO euroline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- portable saws
- chop and miter saws
- for ripping and cross cuts in solid woods and wood-based panels

Design

- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 10

Advantages

Notes

- lower numbers of teeth for solid woods
- higher numbers of teeth for wood-based panels

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
100	2,4	1.4	12	30		10	50110001 L
100	2,4	1.4	22	30		10	50110003 L
105	2,4	1.4	22	30		10	50110006 L
120	1,8	1.3	20	24		15	50104061 L
125	2,4	1.6	20	20	2/5,5/30	15	50110011 L
125	2,4	1.6	20	36	2/6/32,5	10	50110012 L
130	2,4	1.6	20	20	2/6/32,5	15	50110017 L
130	2,4	1.6	20	36	2/6/32,5	10	50110018 L
140	2,4	1.6	20	20	2/6/32,5	15	50110028 L
140	2,4	1.6	20	36	2/6/32,5	10	50110029 L
150	2,6	1.6	20	12	2/6/32,5	20	50110243 L
150	2,6	1.6	20	24	2/6/32,5	15	50110039 L
150	2,6	1.6	20	36	2/6/32,5	15	50110040 L
150	2,6	1.6	20	48	2/6/32,5	10	50110041 L
160	2,6	1.6	16	24	2/6/32,5	15	50110051 L
160	2,6	1.6	16	48	2/6/32,5	10	50110053 L
160	2,2	1.6	20	12	2/6/32,5	20	50110244 L
160	2,2	1.6	20	24	2/6/32,5	15	50110054 L
160	2,2	1.6	20	36	2/6/32,5	15	50110055 L
160	2,2	1.6	20	48	2/6/32,5	10	50110056 L
160	2,6	1.6	30	24	2/7/42	15	50110057 L
160	2,6	1.6	30	36	2/7/42	15	50110058 L
160	2,6	1.6	30	48	2/7/42	10	50110059 L
165	2,6	1.6	20	24	2/6/32,5	15	50110060 L
165	2,6	1.6	20	36	2/6/32,5	15	50110061 L
165	2,6	1.6	20	48	2/6/32,5	10	50110062 L
165	2,6	1.6	30	24	2/7/42	15	50110130 L
170	2,6	1.6	30	24	2/7/42	20	50110069 L
170	2,6	1.6	30	36	2/7/42	15	50110070 L
170	2,6	1.6	30	48	2/7/42	10	50110071 L
180	2,6	1.6	16	24	2/6/32,5	15	50110081 L
180	2,6	1.6	16	48	2/6/32,5	10	50110183 L
180	2,6	1.6	20	24	2/6/32,5	20	50110075 L
180	2,6	1.6	20	40	2/6/32,5	15	50110076 L
180	2,6	1.6	30	14	2/7/42	20	50110248 L
180	2,6	1.6	30	24	2/7/42	20	50110078 L
180	2,6	1.6	30	40	2/7/42	15	50110079 L
180	2,6	1.6	30	54	2/7/42	10	50110080 L
190	2,6	1.6	16	24	2/6/32,5	15	50110153 L
190	2,6	1.6	16	30	2/6/32,5	15	50110083 L
190	2,6	1.6	16	42	2/6/32,5	10	50110084 L
190	2,6	1.6	20	24	2/6/32,5	15	50110154 L
190	2,6	1.6	20	30	2/6/32,5	15	50110086 L
[mm]	[mm]	[mm]	[mm]			[°]	

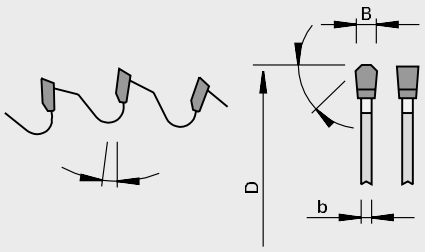
Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
190	2,6	1.6	20	48	2/6/32,5	10	50110087 L
190	2,6	1.6	30	16	2/7/42	20	50110251 L
190	2,6	1.6	30	24	2/7/42	20	50110155 L
190	2,6	1.6	30	30	2/7/42	15	50110089 L
190	2,6	1.6	30	48	2/7/42	10	50110090 L
190	2,6	1.6	30	60	2/7/42	10	50110091 L
200	2,8	1.8	30	18	2/7/42	20	50110252 L
200	2,8	1.8	30	30	2/7/42	15	50110095 L
200	2,8	1.8	30	48	2/7/42	15	50110096 L
205	2,6	1.8	18	30		15	50110286 L
210	2,8	1.8	30	18	2/7/42	20	50110253 L
210	2,8	1.8	30	30	2/7/42	15	50110104 L
210	2,8	1.8	30	48	2/7/42	15	50110105 L
210	2,8	1.8	30	60	2/7/42	10	50110106 L
216	2,8	1.8	30	30	2/7/42	20	50110107 L
216	2,8	1.8	30	48	2/7/42	15	50110108 L
216	2,8	1.8	30	60	2/7/42	10	50110109 L
220	2,8	1.8	30	24	2/7/42	15	50110164 L
220	2,8	1.8	30	36	2/7/42	15	50110110 L
220	2,8	1.8	30	48	2/7/42	15	50110111 L
220	2,8	1.8	30	64	2/7/42	10	50110112 L
225	2,8	1.8	30	24	2/7/42	15	50110165 L
225	2,8	1.8	30	34	2/7/42	15	50110228 L
225	2,8	1.8	30	48	2/7/42	10	50110237 L
230	2,8	1.8	30	18	2/7/42	20	50110255 L
230	2,8	1.8	30	24	2/7/42	15	50110168 L
230	2,8	1.8	30	36	2/7/42	15	50110113 L
230	2,8	1.8	30	48	2/7/42	15	50110114 L
230	2,8	1.8	30	64	2/7/42	10	50110115 L
235	2,8	1.8	30	18	2/7/42	20	50110256 L
235	2,8	1.8	30	24	2/7/42	15	50110170 L
235	2,8	1.8	30	36	2/7/42	15	50110117 L
240	2,8	1.8	30	24	2/7/42	20	50110174 L
240	2,8	1.8	30	36	2/7/42	15	50110123 L
240	2,8	1.8	30	48	2/7/42	15	50110124 L
235	2,8	1.8	30	48	2/7/42	15	58110121 L
235	2,8	1.8	30	64	2/7/42	10	58110118 L
250	3,2	2.2	30	24	2/7/42 + 2/9,5/46,5 + 2/10/60	20	58120060 L
250	3,2	2.2	30	30	2/7/42 + 2/9,5/46,5 + 2/10/60	20	58120061 L
250	3,2	2.2	30	40	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58100018 L
250	3,2	2.2	30	48	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58100026 L
250	3,2	2.2	30	60	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58100031 L
250	3,2	2.2	30	80	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58100038 L
254	3,2	2.2	30	40	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58120067 L
254	3,2	2.2	30	60	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58120068 L
260	3,2	2.2	30	32	2/7/42 + 2/9,5/46,5 + 2/10/60	20	58110185 L
260	3,2	2.2	30	40	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58110175 L
260	3,2	2.2	30	60	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58100254 L
270	3,2	2.2	30	24	2/7/42 + 2/9,5/46,5 + 2/10/60	20	58110176 L
270	3,2	2.2	30	60	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58110182 L
280	3,2	2.2	30	48	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58110136 L
[mm]	[mm]	[mm]	[mm]			[°]	

108472

Portable Saw Blades HW “TR-F”

Product

Drawing



LEUCO proline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- portable saws
- for ripping and cross cuts in wood-based panels, NF-metals and solid woods

Design

- negative hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 10

Advantages

Notes

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
150	2,8	2.2	20	42	2/6/32,5	-6	58115002 L
160	2,2	1.6	20	42	2/6/32,5	-6	58115004 L
160	2,2	1.6	20	56	2/6/32,5	-6	58115042 L
160	2,8	2.2	30	42	2/7/42	-6	58115026 L
180	2,8	2.2	20	48	2/6/32,5	-6	58115007 L
180	2,8	2.2	30	48	2/7/42	-6	58115008 L
190	2,8	2.2	20	54	2/6/32,5	-6	58115009 L
190	2,8	2.2	30	54	2/7/42	-6	58115010 L
200	2,8	2.2	30	54	2/7/42	-6	58115011 L
210	2,8	2.2	30	54	2/7/42	-6	58115012 L
216	2,8	2.2	30	60	2/7/42	-6	58115024 L
216	2,8	2.2	30	80	2/7/42	-6	58115034 L
220	2,8	2.2	30	54	2/7/42	-6	58115021 L
230	2,8	2.2	30	64	2/7/42	-6	58115014 L
235	2,8	2.2	30	64	2/7/42	-6	58115018 L
[mm]	[mm]	[mm]	[mm]			[°]	

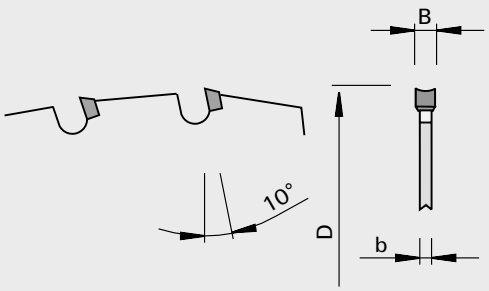
207289

Portable Saw Blades DP “HR” - nn-System DP flex

Product



Drawing



LEUCO nn system

DP FLEX

Polycrystalline diamond [DP]

NO

Machine / Application

- portable saws
- clipping saws
- for precise cutting in all common wood-based panels and ledges
- for ripping and cross cuts in solid woods
- suitable for many materials including façade boards

Design

- tooth configuration: hollow back tooth “HR”
- cutting material: DP
- special cutting edge geometry
- small gullets

Advantages

- highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping
- reduced cutting pressure thanks to hollow back tooth geometry

Notes

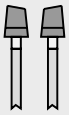
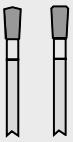
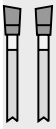
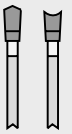
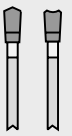
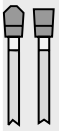
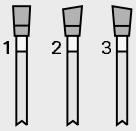
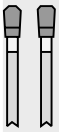
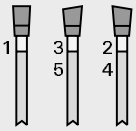
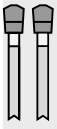
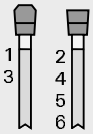
- Clean your nn-System DP flex saw blades regularly. You will profit from a long-lasting and precise cutting quality and maximize the edge lives of your innovative saw blades many times over.

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
160	2,2	1.6	20	20	2/6/32,5	10	192980 L
160	2,2	1.8	20	30	2/6/32,5	10	192981 L
216	2,5	2.0	30	40		10	192982 L
[mm]	[mm]	[mm]	[mm]			[°]	

Tooth configuration

The tooth design has a big influence on the edge quality and is depending on the following factors:

- workpiece material
- mode of application (with and across the grain)
- direction of cut (along / across the grain)

	F	Flat		DA	Inverted-v		KO-WS	Conical-alternate bevel
	F-FA	Flat with chamfers on both sides		DA-F	Inverted-v + flat		KO-HR-FA	Conical hollow back with chamfer
	F-WFA	Flat with alternating chamfer		DA-F-FA	Inverted-v + flat with chamfer		D	Hollow-ground
	WS	Alternate top bevel		DA-D	Inverted-v + hollow-ground		D-FA	Hollow-ground with two-sided chamfer
	WS-FA	Alternate top bevel with chamfer		DA-D-FA	Inverted-v + hollow-ground with chamfer		HR	Hollow back
	TR	Triple-chip		ES	Top bevel		HR-FA	Hollow back with chamfer
	TR-F	Triple-chip + flat		ES-L	Top bevel, left		G3	G3
	TR-F-FA	Triple-chip + flat with chamfer		ES-R	Top bevel, right		G5	G5
	TR-TR	Triple-chip + triple-chip		KO-F	Conical-flat		G6	G6

Number of teeth

The number of cutting edges subject to feed rate is to be found in section tool description on the respective pages. It is depending on the following criteria:

- feed
- RPM of the spindle
- diameter of the circular saw blade
- workpiece material
- cutting quality (sizing cut / finish cut)
- cutting height (single boards / stack)
- stack height (no. of single boards)
- pass

Cutting speed (standard values)

HW Saw Blades

Workpiece material	Cutting speed vc [m/s]
Al-Mg-Cu	40 - 60
Al-Si alloys	15 - 40
Panels veneered both sides	60 - 90
Thermosets (Pertinax®, Restitex®, etc.)	15 - 50
Exotic woods	50 - 85
Veneers	70 - 100
Gypsum plaster boards	40 - 65
Hardboards	50 - 80
Hard woods	60 - 100
Plastic laminated particle boards	60 - 80
Plastic profiles without filling	30 - 70
Pressed laminated woods	40 - 65
Pure aluminum	60 - 80
Raw particle boards	50 - 80
Laminated boards	60 - 80
Laminates, hard paper, fabric	50 - 70
Particle boards	60 - 80
Plywood boards	50 - 80
Thermoplastic (PA, PE, PMMA etc.)	30 - 70
Wood core plywood	50 - 90
Condensed woods	40 - 65
Soft fiber boards	60 - 100
Soft woods	60 - 100
Cement bonded boards	40 - 60

DP Saw Blades

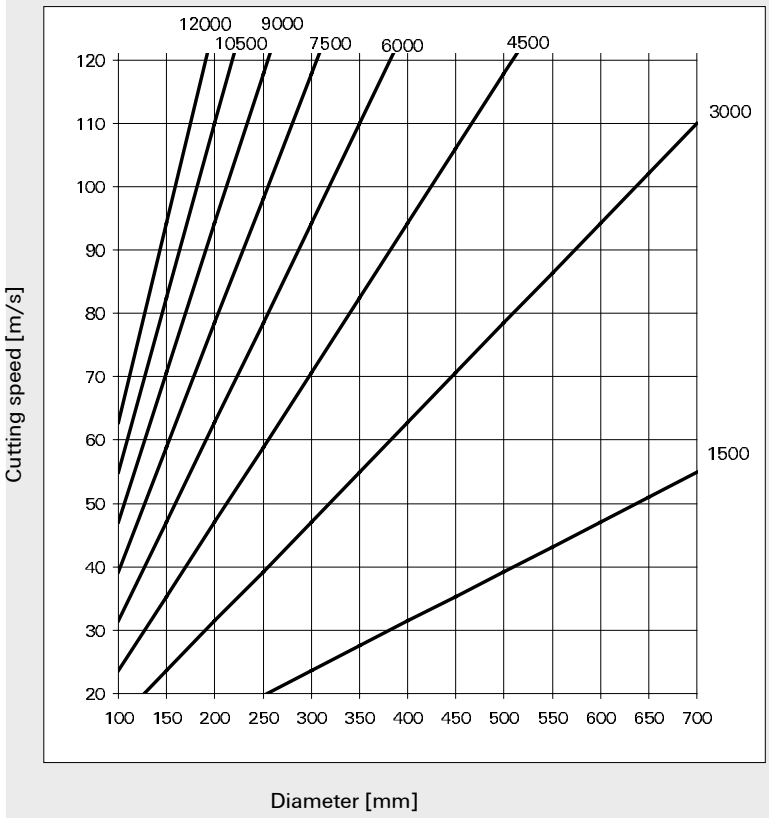
Workpiece material	Cutting speed vc [m/s]
CFRP, GFRP	40 - 60
Thermosets (Pertinax®, Restitex®, etc.)	50 - 80
Polymer bound boards (Corian®, Varicor®)	60 - 90
Pressed laminated woods	40 - 60
Laminated particle boards and MDF boards	50 - 80
Foil-coated particle boards and MDF boards	64 - 100
Veneered particle boards and MDF boards	65 - 100
Raw particle boards and MDF boards	65 - 100
Plywood boards	65 - 100
Thermoplastic (PA, PE, PMMA etc.)	60 - 90
Wood core plywood	60 - 80
Condensed woods	70 - 100
	50 - 80

Feed rate per tooth

HW Saw Blades

Workpiece material	Feed rate per tooth fz [mm]
Al-Mg-Cu	0,05 - 0,12
Al-Si alloys	0,03 - 0,08
Panels veneered both sides	0,03 - 0,10
Thermosets (Pertinax®, Restitex®, etc.)	0,02 - 0,05
Hardboards	0,03 - 0,08
Plastic laminated particle boards	0,03 - 0,15
Plastic profiles without filling	0,03 - 0,15
Solid wood with the grain	0,10 - 0,50
Solid wood across the grain	0,02 - 0,20
Polymer bound boards (Corian®, Varicor®)	0,05 - 0,15
Pure aluminum	0,05 - 0,12
Particle boards, MDF boards	0,05 - 0,25
Plywood boards	0,05 - 0,25
Thermoplastic (PA, PE, PMMA etc.)	0,05 - 0,08

Determination of RPM [min-1]



Order / Inquiry for Special Tools: Circular Saw Blades

Please copy and send the completed form to one of the LEUCO sales offices. (Only one tool description per form)

Customer-no.: _____
Company: _____
Plant: _____
Street: _____
Zip / City: _____
Country: _____
Contact partner: _____
Phone:
City and Date: _____

Order: O
Inquiry: O

Delivery (week no.): _____
(Not binding)
No. of pieces: _____

Fax:
Signature: _____

Machine

Maker: _____
Model: _____
Type: _____
Operating RPM [min-1]: _____
Feed rate [m/min]: _____
Flange diameter [mm]: _____
Motor output [kW]: _____
Type of machine: One shaft O
Two shafts O
Mode of application:
Against feed: From top O
From bottom O
With feed: From top O
From bottom O

Workpiece

Description:
Cut height [mm]:
Type of cut: Single O
Stack O
Cutting quality: Coarse O
Trimming cut O
Finish cut O
For solid wood: With grain O
Across grain O
For wood-based panels: Sizing O
Trimming O

Tool

Cutting diameter D [mm] _____
Cutting width B [mm] _____
Saw plate thickness b [mm]: _____
Bore diameter d [mm]: _____

Countersinks and recesses

No. of countersinks: _____
Bore diameter db [mm]: _____
Countersink diameter ds [mm]: _____
Position angle α [°]: _____
Boring circle diameter Dt [mm]: _____
No. of recesses: _____
Double keyway: Width bk | Height hk
Keyway: Width bk | Height hk
Pin holes: No. | Ø NL | Ø TK
Countersinks (per drawing): O
Cut-outs for hoggers (per drawing): O
No. of teeth [pcs.]: _____
Rakers:
Tooth configuration: Flat O
Alternate top bevel O
Top bevel O
Hollow-ground O
Triple-chip O
Inverted-v O
Conical-alternate bevel O
Hollow-ground / chamfer O
Triple chip / flat O
ATB / flat O
With relieved tool body:
Hub location (per drawing): A O B O
Hub diameter D1 [mm]: _____
Hub width b1 [mm]: _____
Sense of rotation: Right O Left O
Application: Single O Set O
o Check if applicable

Order / Inquiry for Special Tools: Circular Saw Blades

Name: _____ City and Date: _____

Product line

topline	O
proline	O
euroline (only portable saw blades)	O

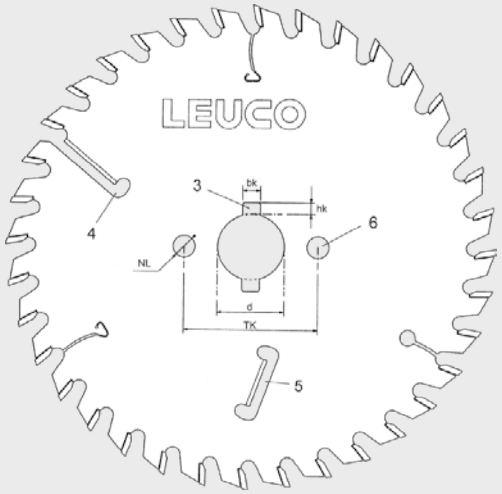
Cutting material

Carbide	O
Diamond	O
Stellite	O
HS	O

Please indicate additional dimension and markings in the schematic drawing.

Tool body

3	Double keyway
6	Pin hole
d	
bk	Width of keyway
hk	Height of keyway
TK	Reference diameter
NL	Pin hole diameter

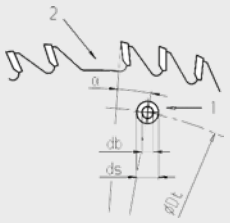


Additional tool body elements:

4	Raker with carbide cutting edge enclosed
5	Raker with carbide cutting edge open

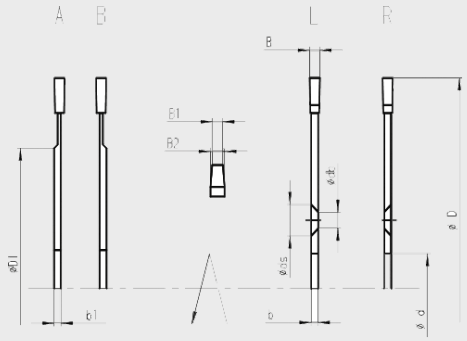
Countersink and cut-out for hoggers

1	Countersink for countersunk flat headed screw
2	Cut-out for hoggers
db	Bore diameter
ds	Countersink diameter
α	Position angle
Dt	Boring circle diameter



Tool body

D	Cutting diameter
b	Saw plate thickness
d	Bore
D1	Hub diameter
b1	Hub width
B1	Cutting width
B2	Cutting width
A/B	Hub location
db	Bore diameter
ds	Countersink diameter



Sense of rotation

L	Left
R	Right

Checklist for NF customers

Customer-no.:
Company:
Plant:
Street:
Zip / City:
Country:

Contact partner:
Function:
Phone:
Fax:
E-mail:

Machine data

Maker:
Model:
Year of manufacture:
Driving power [kW]:
RPM [min-1]: Min Max
Type of feed: MAN O MEC O
Cutting speed vc [m/min] max:
Type of machine:
Panel sizing saw: panel height [mm]:
Chop saw: Saw Blade From top
From bottom
Other

Workpiece

Workpiece material:
Workpiece material No.:
Workpiece clamping:
Workpiece form:
(E.g. round, tube, profile, block, etc.)
Dimension:
For profiles, wall thickness [mm]:

Application data

Feed rate vf [m/min]:
Cooling (spraying, dry, etc.):
Cutting speed vc [m/min]:
Rotations per minute (RPM) [min-1]

Saw Blade in current application

Maker:
Diameter [mm]:
Bore [mm]:
Cutting height [mm]:
No. of teeth [pcs.]:
Hook angle [°]:
Cutting material:
Flange diameter [mm]:
Pin holes:
Saw plate thickness b [mm]:
Tooth configuration:
Uneven pitch: Yes O No O
Low-noise design: Yes O No O

Requirements with regards to cutting quality

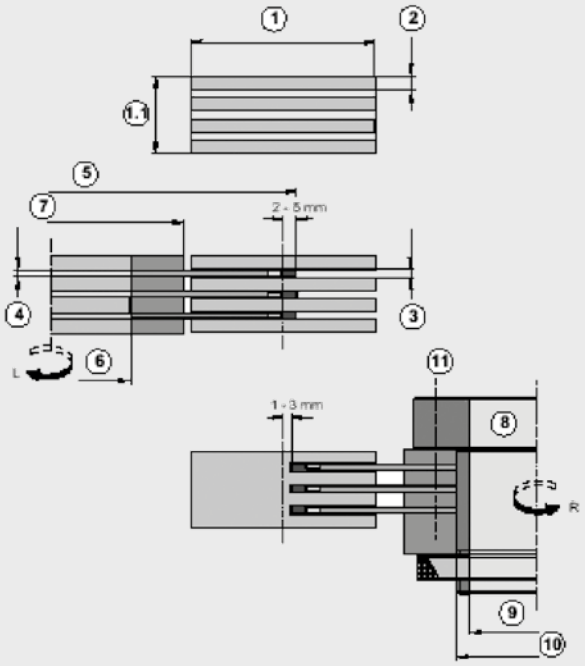
Cutting time [sec]:
Surface quality:
Tool life (no. of cuts):
Misc.:

Notes

503-01.0106

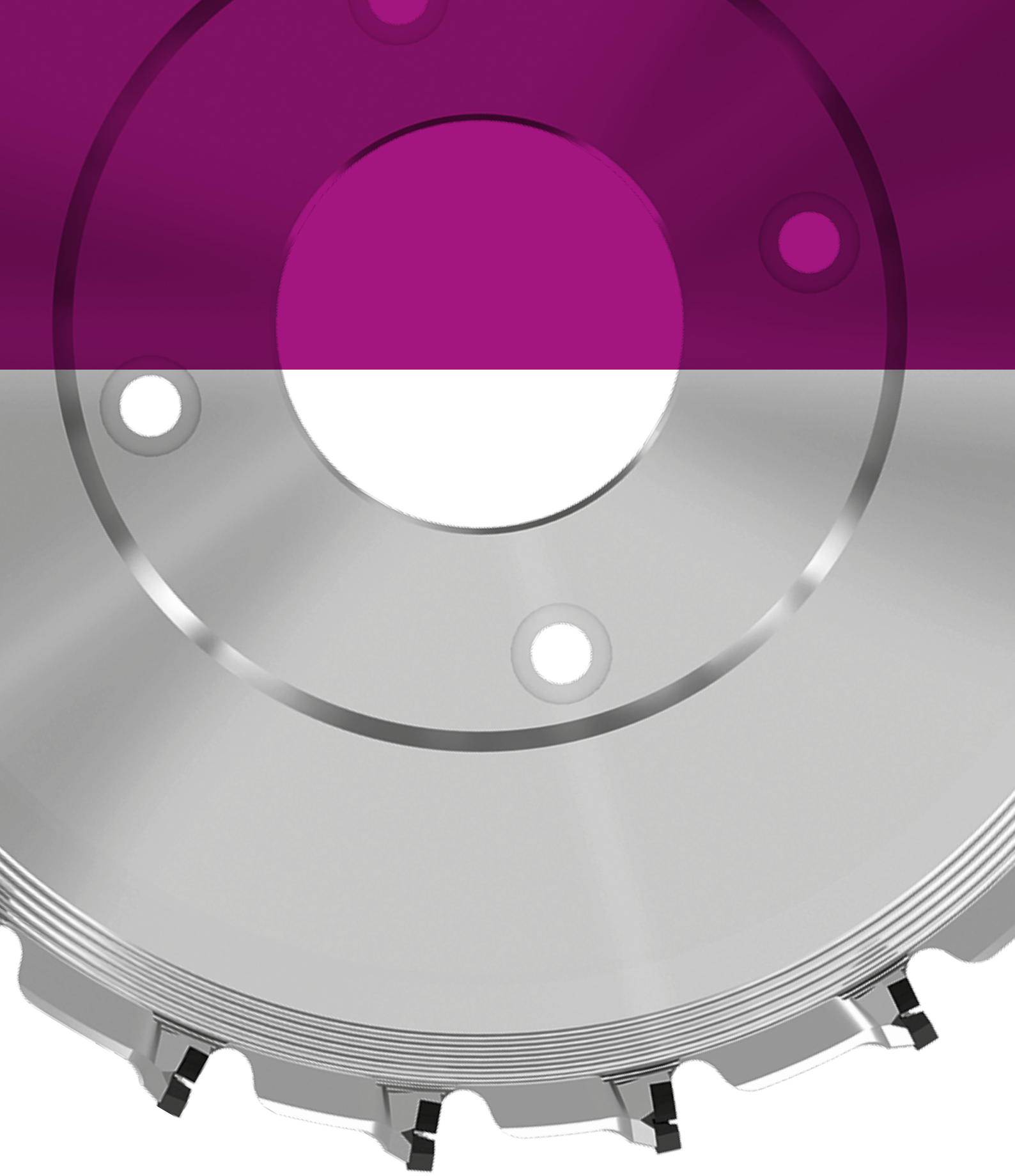
Thin-Kerf Saw Blades on splitting machines

Customer-no.:		Contact partner:	
Company:		Function:	
Plant:		Phone:	
Street:		Fax:	
Zip / City:		E-mail:	
Country:			



1.1 Wood type:	Humidity [%]:	No. of saw blades per spindle [pcs.]:	
0 Slat dimension: thickness	Length [mm]:	Edge saw blade:	Yes O No O
1 Lamella width [mm]:		Current dimension:	
2 Lamella thickness [mm]:		Saw Blades in current application (dimension):	
3 Cutting width [mm]:		RPM [min-1]:	
4 Saw plate thickness b [mm]:		Feed rate [m/min]:	
5 Saw blade diameter [mm]:		Spindle diameter [mm]:	
6 Bore diameter [mm]:		Spindle length [mm]:	
7 Flange diameter [mm]:		Driving pin:	
8 Bushing: hydro	Yes O No O	Spindle / Bushing:	Top O Bottom O
9 Bushing inside diameter [mm]:		Diameter [mm]:	
10 Bushing outside diameter [mm]:		Pitch circle diameter [mm]:	
11 Pin holes:	DKN:		

508-01.1006



LEUCO



Hoggers

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Segment Hoggers	2–11
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Saw Blade Hoggers	2–27
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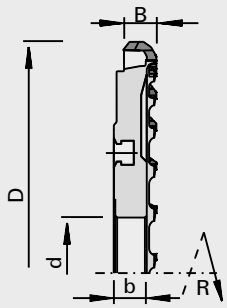
215332

PowerTec 5 airFace Hoggers DP for LEUCO s-System Ø 160 mm and Ø 192 mm (DZ)

Product



Drawing



LEUCO topline

LEUCO powertec 5 airface

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- for chip-free and low-noise sizing of raw, melamine-coated, paper-laminated, foil-coated and veneered wood-based materials as well as HPL materials, with a focus on durability and economic efficiency

Design

- LEUCO airFace design: reduced vibration and aerodynamic properties
- polished cutting edges for optimum cutting quality
- division of cut into with rounded edges on one wing
- resharpening area 4 mm
- n max= 7,200 rpm

Advantages

- very long edge live thanks to optimized tooth shape
- noise reduction during idling and machining thanks to airFace design
- cutting width and diameter consistency over the entire tool life
- high feed rates achievable
- low total cost/running meter ratio
- machining of panels from 8 mm thickness possible
- good chip removal
- compatible with a wide variety of clamping systems

Notes

- for double hogging process (DZ)
- application with feed
- sense of rotation according to VDMA 8849

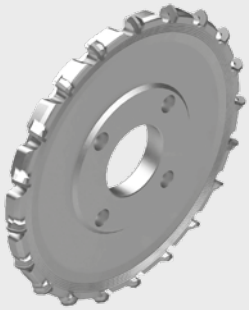
Ø D	B	b	Ø d	Z	Feed DZ		Ident-No. [L]	Ident-No. [R]
250	10	17.8	60	16+8	28	s-System Ø 160	80477092 L	80477091 L
250	10	17.8	60	20+10	45	s-System Ø 160	80477094 L	80477093 L
250	10	17.8	60	28+14	60	s-System Ø 160	80477096 L	80477095 L
250	10	17.8	60	36+18	80	s-System Ø 160	80477098 C	80477097 C
250	14,5	17.8	60	16+8+4	28	s-System Ø 160	80477100 C	80477099 C
250	14,5	17.8	60	20+10+5	45	s-System Ø 160	80477102 L	80477101 L
250	14,5	17.8	60	28+14+7	60	s-System Ø 160	80477104 L	80477103 L
250	14,5	17.8	60	36+18+9	80	s-System Ø 160	80477106 C	80477105 C
[mm]	[mm]	[mm]	[mm]		[m/min]			

Ø D	B	b	Ø d	Z	Feed DZ		Ident-No. [L]	Ident-No. [R]
250	10	17.8	80	16+8	28	s-System Ø 192	80477108 C	80477107 C
250	10	17.8	80	20+10	45	s-System Ø 192	80477110 C	80477109 C
250	14,5	17.8	80	16+8+4	28	s-System Ø 192	80477112 C	80477111 C
250	14,5	17.8	80	20+10+5	45	s-System Ø 192	80477114 C	80477113 C
[mm]	[mm]	[mm]	[mm]		[m/min]			

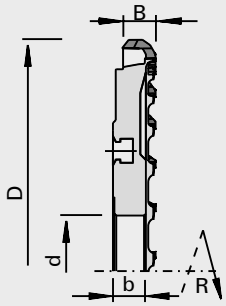
215332

PowerTec 5s airFace Hoggers DP for LEUCO s-System Ø 160 mm and Ø 192 mm (DZ)

Product



Drawing



LEUCO topline

LEUCO powertec 5s airface

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- ideally suited for chip-free and low-noise sizing of raw, melamine-coated, paper-laminated, foil-coated and veneered wood-based materials as well as HPL materials, with a focus on durability and economic efficiency

Design

- LEUCO airFace design: reduced vibration and aerodynamic properties
- polished cutting edges for optimum cutting quality
- division of cut into with rounded edges on one wing
- resharpening area 4 mm
- n max= 7,200 rpm

Advantages

- extremely long edge live thanks to optimized tooth shape and reinforced DP cutting edges
- noise reduction during idling and machining thanks to airFace design
- cutting width and diameter consistency over the entire tool life
- high feed rates achievable
- low total cost/running meter ratio
- machining of panels from 8 mm thickness possible
- good chip removal
- compatible with a wide variety of clamping systems

Notes

- for double hogging process (DZ)
- application with feed
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	Feed DZ		Ident-No. [L]	Ident-No. [R]
250	10	17.8	60	16	28	s-System Ø 160	80477120 C	80477119 C
250	10	17.8	60	20	45	s-System Ø 160	80477122 L	80477121 L
250	10	17.8	60	28	60	s-System Ø 160	80477124 L	80477123 L
250	10	17.8	60	36	80	s-System Ø 160	80477126 L	80477125 L
250	14,5	17.8	60	16+4	28	s-System Ø 160	80477128 C	80477127 C
250	14,5	17.8	60	20+5	45	s-System Ø 160	80477130 C	80477129 C
250	14,5	17.8	60	28+7	60	s-System Ø 160	80477132 C	80477131 C
250	14,5	17.8	60	36+9	80	s-System Ø 160	80477134 C	80477133 C
[mm]	[mm]	[mm]	[mm]		[m/min]			

Ø D	B	b	Ø d	Z	Feed DZ		Ident-No. [L]	Ident-No. [R]
250	10	17.8	80	16	28	s-System Ø 192	80477136 C	80477135 C
250	10	17.8	80	20	45	s-System Ø 192	80477138 L	80477137 L
250	10	17.8	80	28	60	s-System Ø 192	80490648 C	80490649 C
250	14,5	17.8	80	20+5	28	s-System Ø 192	80477140 C	80477139 C
[mm]	[mm]	[mm]	[mm]		[m/min]			

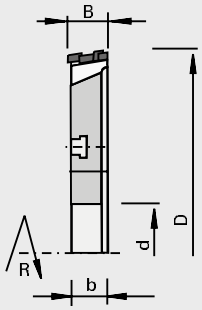
215044

UniTec Hoggers CM DP for LEUCO s-System Ø 160 mm and Bushing (RZ/DZ)

Product



Drawing



LEUCO unitec

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- Resharpening area: 5 mm
- n max=6,000 min-1
- division of cut in pre-cut and re-cut tooth
- constant cutting width

Advantages

- improved chip evacuation integrated into the tool (ChipMeister)
- reduced cleaning efforts
- reduced suction performance
- high quality of cut due to division of cut
- long edge lives thanks to optimized tooth form

Notes

- machining of 8 mm boards is also possible
- for scoring/hogging (RZ) and double hogging (DZ) process
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	Feed DZ	Ident-No. [L]	Ident-No. [R]
250	8,0	18	60	24+12	30	187771 C	187766 C
250	8,0	18	60	36+18	45	187774 L	187772 L
250	8,0	18	60	48+24	60	187778 C	187776 C
250	8,0	18	60	54+27	70	187782 C	187780 C
250	16	18	60	36+18+6	45	187785 C	187783 C
250	16	18	60	48+24+6	60	187788 C	187787 C
[mm]	[mm]	[mm]	[mm]		[m/min]		

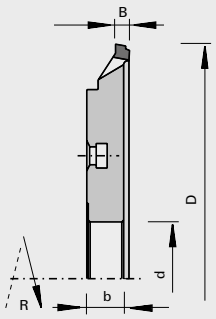
215044

UniTec A Hoggers CM DP for LEUCO s-System Ø 160 mm and Bushing (RZ/DZ)

Product



Drawing



LEUCO unitec

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- Resharpening area: 5 mm
- n max=6,000 min-1
- division of cut in pre-cut and re-cut tooth
- ascending chamfer at the step
- constant cutting width

Advantages

- improved chip evacuation integrated into the tool (ChipMeister)
- reduced cleaning efforts
- reduced suction performance
- high quality of cut due to division of cut
- long edge lives thanks to optimized tooth form

Notes

- machining of 8 mm boards is also possible
- for scoring/hogging (RZ) and double hogging (DZ) process
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	Feed DZ	Ident-No. [L]	Ident-No. [R]
250	8,0	18	60	36+18	40	187790 C	187789 C
250	8,0	18	60	48+24	50	187793 C	187791 C
250	8,0	18	60	60+30	75	187795 C	187794 C
[mm]	[mm]	[mm]	[mm]		[m/min]		

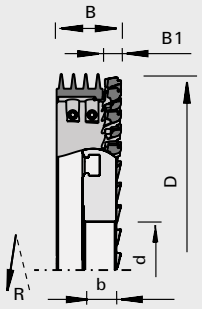
215044

UniTec Veneer Hoggers CM DP for LEUCO s-System Ø 160 mm and Bushing (RZ/DZ)

Product



Drawing



LEUCO unitec

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- for chip-free sizing of veneered panels

Design

- DP-tipped
- resharpening area 4 mm
- n max = 6,000 min-1
- HS insert sets Z=2+2 for hogging of excess veneer

Advantages

- improved chip evacuation integrated into the tool (ChipMeister)
- reduced cleaning efforts
- high cutting quality for veneered panels due to division of cut
- long edge lives thanks to optimized tooth form
- low power consumption
- safe hogging of excess veneer
- no formation of strips
- no clogging of the exhaustion

Notes

- machining of 8 mm boards is also possible
- for scoring/hogging (RZ) and double hogging (DZ) process
- sense of rotation according to VDMA 8849

Ø D	B	B1	b	Ø d	Z	Feed DZ	Ident-No. [L]	Ident-No. [R]
250	34-31,5	10-7,6	23	60	48+24	60	187797 C	187796 C
[mm]	[mm]	[mm]	[mm]	[mm]		[m/min]		

Spare parts	Class-No.	PU	Ident-No.
HS insert	332921	4 [pc.]	50570980 L

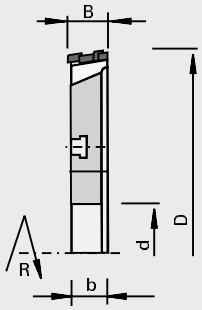
215044

UniTec Hoggers CM DP for LEUCO s-System Ø 192 mm (RZ/DZ)

Product



Drawing



LEUCO unitec

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- Resharpening area: 5 mm
- n max=6,000 min-1
- division of cut in pre-cut and re-cut tooth
- constant cutting width

Advantages

- improved chip evacuation integrated into the tool (ChipMeister)
- reduced cleaning efforts
- reduced suction performance
- high quality of cut due to division of cut
- long edge lives thanks to optimized tooth form

Notes

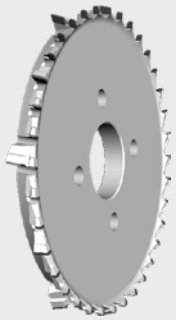
- especially for particle boards with loose core, recycling particle boards, particle boards with sensitive coating
- machining of 8 mm boards is also possible
- for scoring/hogging (RZ) and double hogging (DZ) process
- application with feed
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	Feed DZ	Ident-No. [L]	Ident-No. [R]
250	8,0	23	80	24+12	30	187801 C	187799 C
250	8,0	23	80	36+18	45	187805 C	187803 C
250	8,0	23	80	48+24	60	187809 C	187807 C
[mm]	[mm]	[mm]	[mm]		[m/min]		

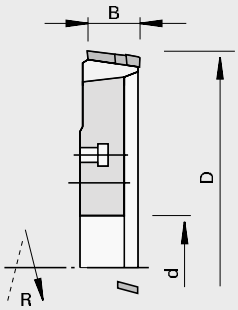
215082

CompactTec N Hoggers CM DP for LEUCO Hydro s-System Ø 160 mm and Bushing (RZ/DZ)

Product



Drawing



LEUCO compacttec

Polycrystalline diamond [DP]

MEC

Machine / Application

- double-end tenoners
- edge banding machines
- for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- negative hook angle
- tooth configuration chamfer ascending
- with shear angle
- resharpenable area 4 mm

Advantages

- improved chip evacuation thanks to chip evacuation integrated in the tool (Chip-Meister)
- reduced cleaning effort
- reduction of suction power
- long edge lives thanks to negative hook angle
- minimal machine downtimes thanks to long edge lives
- excellent cutting quality thanks to high concentric and runout accuracy

Notes

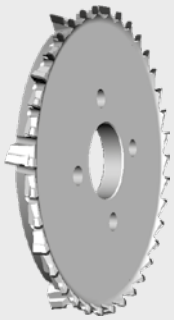
- for scoring/hogging (RZ) and double hogging (DZ) process
- application with feed for cutting with and across the grain
- resharpenable on the flanks
- the specified feed rates are based on n = 6,000 min-1
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	Feed DZ	Ident-No. [L]	Ident-No. [R]
250	20-17	20	60	30+5+5	30	182537 C	182536 C
250	20-17	20	60	36+6+6	35	182539 C	182538 C
250	20-17	20	60	48+6+6	50	182541 C	182540 C
[mm]	[mm]	[mm]	[mm]		[m/min]		

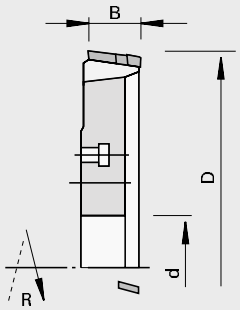
215082

CompactTec N Hoggers CM DP for LEUCO s-System Ø 192 mm (RZ/DZ)

Product



Drawing



LEUCO compacttec

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- edge trimming machines
- for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- negative hook angle
- tooth configuration chamfer ascending
- with shear angle
- resharpenable area 4 mm

Advantages

- improved chip evacuation thanks to chip evacuation integrated in the tool (Chip-Meister)
- reduced cleaning effort
- reduction of suction power
- long edge lives thanks to negative hook angle
- minimal machine downtimes thanks to long edge lives
- excellent cutting quality thanks to high concentric and runout accuracy

Notes

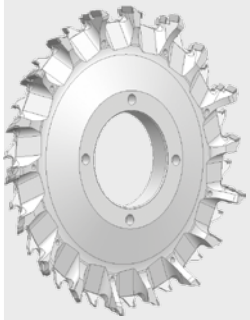
- for scoring/hogging (RZ) and double hogging (DZ) process
- application with feed for cutting with and across the grain
- sides of teeth can be resharpened
- the specified feed rates are based on n = 6,000 min-1
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	Feed DZ	Ident-No. [L]	Ident-No. [R]
250	20-17	20	80	30+5+5	30	182547 C	182546 C
250	20-17	20	80	36+6+6	35	182549 C	182548 C
250	20-17	20	80	48+6+6	50	182551 C	182550 C
[mm]	[mm]	[mm]	[mm]		[m/min]		

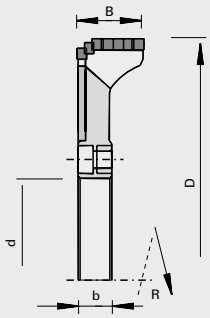
215089

Compact Hogger DP - for dividing laminate boards

Product



Drawing



LEUCO compacttec

Polycrystalline diamond [DP]

MEC

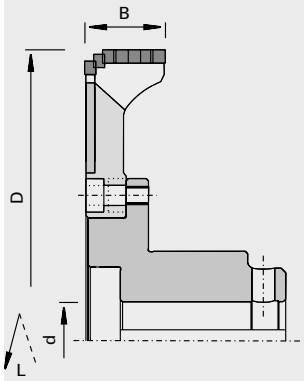
Machine / Application
- panel sizing saws
- laminate flooring

Design
- open gullet
- with shear angle
- resharpening area 4 mm

Advantages
- improved chip evacuation thanks to shear angle
- optimal positioning of knives from hogger to saw blade
- reduction of scouring on the tool

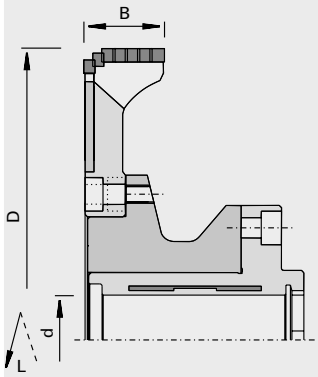
Notes
- application against feed for cutting along and across the grain
- sense of rotation according to VDMA 8849

Hogger on special flange 35 DKN 189750



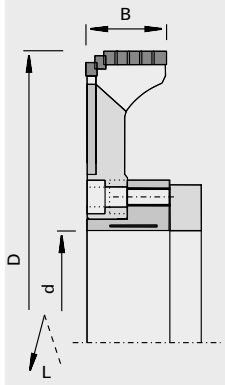
Ø D	B	Ø d	DKN	Z	NL	Ident-No. [L]	Ident-No. [R]
260	18	35	10x4	48+24+12+12	2x4/8/130	189737 S	189738 S
260	25	35	10x4	48+24+12+12	2x4/8/130	189739 S	189740 S
260	36	35	10x4	48+24+12+12	2x4/8/130	189741 S	189742 S
260	18	35	10x4	36+18+9+9	2x4/8/130	189743 S	189744 S
260	25	35	10x4	36+18+9+9	2x4/8/130	189745 S	189746 S
260	36	35	10x4	36+18+9+9	2x4/8/130	189747 S	189748 S
[mm]	[mm]	[mm]	[mm]				

Hogger on hydro bushing 172678 with special flange 189749



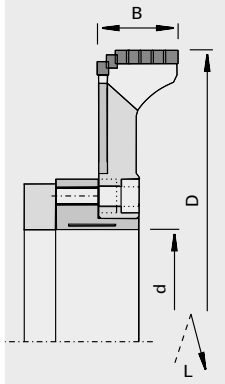
Ø D	B	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
260	18	40	48+24+12+12	2x4/8/130	189752 S	189753 S
260	25	40	48+24+12+12	2x4/8/130	189754 S	189755 S
260	36	40	48+24+12+12	2x4/8/130	189756 S	189757 S
260	18	40	36+18+9+9	2x4/8/130	189758 S	189759 S
260	25	40	36+18+9+9	2x4/8/130	189760 S	189761 S
260	36	40	36+18+9+9	2x4/8/130	189762 S	189763 S
[mm]	[mm]	[mm]				

Hogger on hydro bushing 183821 - saw blade away from the spindle (version 1)



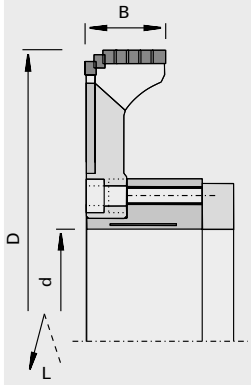
Ø D	B	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
260	18	100	48+24+12+12	2x4/8/130	189809 S	189810 S
260	25	100	48+24+12+12	2x4/8/130	189811 S	189812 S
260	36	100	48+24+12+12	2x4/8/130	189813 S	189814 S
260	18	100	36+18+9+9	2x4/8/130	189815 S	189816 S
260	25	100	36+18+9+9	2x4/8/130	189817 S	189818 S
260	36	100	36+18+9+9	2x4/8/130	189819 S	189820 S
[mm]	[mm]	[mm]				

Hogger on hydro bushing 183821 - saw blade towards the spindle (version 2)



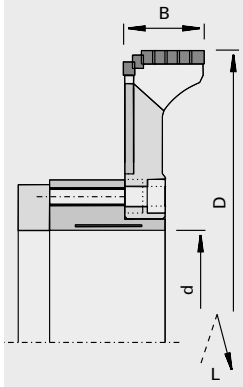
Ø D	B	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
260	18	100	48+24+12+12	2x4/8/130	189821 S	189822 S
260	25	100	48+24+12+12	2x4/8/130	189823 S	189824 S
260	36	100	48+24+12+12	2x4/8/130	189825 S	189826 S
260	18	100	36+18+9+9	2x4/8/130	189827 S	189828 S
260	25	100	36+18+9+9	2x4/8/130	189829 S	189830 S
260	36	100	36+18+9+9	2x4/8/130	189831 S	189832 S
[mm]	[mm]	[mm]				

Hogger on hydro bushing 183829 - saw blade away from the spindle (version 1)



Ø D	B	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
260	18	100	48+24+12+12	2x4/8/130	189764 S	189765 S
260	25	100	48+24+12+12	2x4/8/130	189766 S	189767 S
260	36	100	48+24+12+12	2x4/8/130	189768 S	189769 S
260	18	100	36+18+9+9	2x4/8/130	189770 S	189771 S
260	25	100	36+18+9+9	2x4/8/130	189772 S	189773 S
260	36	100	36+18+9+9	2x4/8/130	189774 S	189775 S
[mm]	[mm]	[mm]				

Hogger on hydro bushing 183829 - saw blade towards the spindle (version 2)



Ø D	B	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
260	18	100	48+24+12+12	2x4/8/130	189776 S	189777 S
260	25	100	48+24+12+12	2x4/8/130	189778 C	189779 C
260	36	100	48+24+12+12	2x4/8/130	189780 S	189781 S
260	18	100	36+18+9+9	2x4/8/130	189782 S	189783 S
260	25	100	36+18+9+9	2x4/8/130	189784 S	189785 S
260	36	100	36+18+9+9	2x4/8/130	189786 S	189787 S
[mm]	[mm]	[mm]				

Attachment Sleeves and Flanges	Dimension	Class-No.	PU	Ident-No.
Hydro Clamping Bushing	Ø120x96xØ60/40	933030	1	172678L
attachment flange for hydro clamping bushing 172678	Ø147x69,4xØ110/60	997300	1	189749S
Attachment Sleeves	Ø145x89,4xØ110/35 DKN	997300	1	189750S
Hydro Clamping Bushing	Ø145x65,5xØ110/100	933030	1	183829C
Hydro Clamping Bushing	Ø145x49,5xØ110/100	933030	1	183821C
	[mm]		[pc.]	

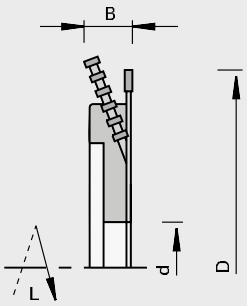
115122

Segment Hoggers HW - Circular Cut “WS”

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- double-board edgers and edgers
- double end tenoners
- for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration of the saw blade: alternate top bevel “WS”

Advantages

- excellent quality of cut thanks to high concentric and runout accuracy
- optimum hogging of the offal thanks to cut division of the cutting edges

Notes

- application with feed for cutting with the grain
- replacement saw blades: sizing saw blade Class-No. 102320 ATB
- sense of rotation see drawing

Ø D	B	Ø d	Z	Z segments	Ident-No. [L]	Ident-No. [R]
300	30	60	60	6x8	053174 C	053210 C
300	40	80	72	6x10	005446 S	005518 S
355	30	60	72	6x8	004283 S	004355 S
355	40	60	72	6x10	004289 S	004361 S
355	30	80	72	6x8	004286 O	004358 O
355	40	80	72	6x10	004292 O	004364 O
350	40	80	54	6x10	004895 O	004823 O
350	30	60	72	6x8	053211 S	053175 S
350	30	80	72	6x8	053214 O	053178 O
350	30	60	84	6x8	005510 S	005438 S
350	40	80	84	6x10	005519 O	005447 O
350	30	60	108	6x8	005654 S	005582 S
[mm]	[mm]	[mm]				

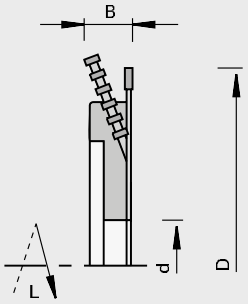
115122

Segment Hoggers HW - Stepped Cut “WS”

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- double-board edgers and edgers
- double end tenoners
- for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration of the saw blade: alternate top bevel “WS”

Advantages

- excellent quality of cut thanks to high concentric and runout accuracy
- optimum hogging of the offal thanks to cut division of the cutting edges

Notes

- application with feed for cutting across the grain
- replacement saw blades: sizing saw blade Class-No. 102320 ATB
- sense of rotation see drawing

Ø D	B	Ø d	Z	Z segments	Ident-No. [L]	Ident-No. [R]
300	30	80	48	6x8	004834 S	004906 S
300	40	60	60	6x10	053198 S	053234 S
350	40	60	72	6x10	053199 C	053235 C
350	40	80	84	6x10	005465 O	005537 O
355	30	60	72	6x8	004301 S	004373 S
355	40	60	72	6x10	004307 S	004379 S
355	40	80	72	6x10	004310 O	004382 O
[mm]	[mm]	[mm]				

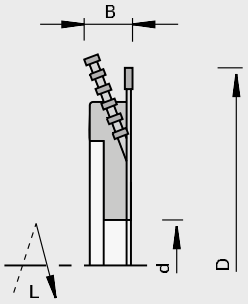
115147

Segment Hoggers HW - Circular Cut “TR-F”

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- double-board edgers and edgers
- double end tenoners
- for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration of the saw blade: triple chip / flat “TR-F”

Advantages

- excellent quality of cut thanks to high concentric and runout accuracy
- optimum hogging of the offal thanks to cut division of the cutting edges

Notes

- application with feed for cutting with the grain
- replacement saw blades: panel sizing saw blade Class-No. 104370 triple chip / flat
- sense of rotation see drawing

Ø D	B	Ø d	Z	Z segments	Ident-No. [L]	Ident-No. [R]
305	30	60	60	6x8	172951 S	172955 S
[mm]	[mm]	[mm]				

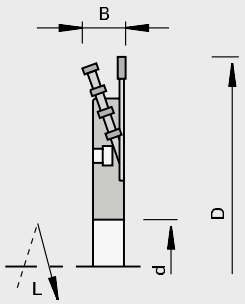
115521

Segment Hoggers HW for LEUCO s-System Ø 192 mm - Circular Cut “F” (RZ/DZ)

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- double end tenoners
- edge trimming machines
- for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration of the saw blade: flat “F”
- RPM: for B = 18 mm n max = 7,200 min-1 / for B = 36 mm n max = 6,000 min-1

Advantages

- excellent cutting quality thanks to high concentric and runout accuracy
- decreased downtimes thanks to extremely long edge lives
- optimum hogging of the offal thanks to cut division of the cutting edges with shear angle

Notes

- application with feed for cutting with the grain
- for scoring/hogging (RZ) and double hogging (DZ) process
- sense of rotation see drawing

Ø D	B	Ø d	Z	Z segments	Ident-No. [L]	Ident-No. [R]
250	18	80	48	6x4	160877 O	160879 S
250	18	80	72	6x4	160878 S	160880 S
250	36	80	48	12x4	164400 S	164401 S
[mm]	[mm]	[mm]				

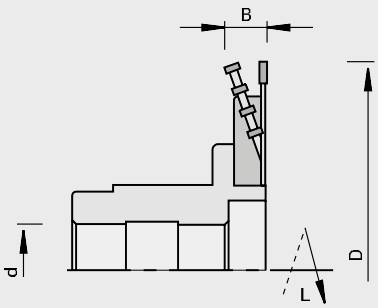
115321

Segment Hoggers HW mounted on Bushing - Circular Cut “F” (RZ/DZ)

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- double end tenoners
- edge trimming machines
- for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration of the saw blade: flat “F”
- Ø 200 mm: n max = 9,500 min-1
- Ø 250 mm: n max = 7,600 min-1

Advantages

- excellent quality of cut thanks to high concentric and runout accuracy
- optimum hogging of the offal thanks to cut division of the cutting edges

Notes

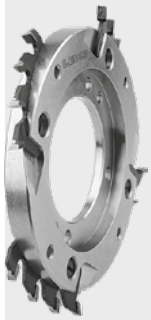
- application with feed
- for scoring/hogging (RZ) and double hogging (DZ) process
- sense of rotation see drawing

Ø D	B	Ø d	Z	Z segments		Ident-No. [L]	Ident-No. [R]
200	18	40	40	4x4	B+G	005864 C	005928 C
200	18	40	40	4x4	M+S	005865 C	005929 C
200	18	35	40	4x4	Homag, Homburg, SCM-IDM, IMA 14 / 16 / 19 / 20	005876 C	005940 C
200	18	35	60	4x4	Homag, Homburg, SCM-IDM, IMA 14 / 16 / 19 / 20	006004 C	006068 C
250	18	35	72	6x4	Celaschi	057160 C	057161 C
250	18	40	72	6x4	Gabbiani (spindle with key)	057164 O	057165 O
250	18	35	72	6x4	Homag, Homburg, IMA, Koch	057168 O	057169 O
250	18	35	48	6x4	Celaschi	162159 C	162163 C
250	18	40	48	6x4	M+S	162175 O	162179 O
250	18	40	48	6x4	Gabbiani (spindle with key)	162223 O	162227 O
250	18	35	48	6x4	Homag, SCM-IDM, Homburg, IMA	162239 O	162243 O
[mm]	[mm]	[mm]					

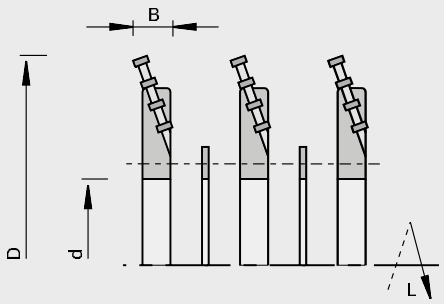
115301

Segment Extensions HW - Circular Cut

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- for hogging of large offal widths and veneer overhang

Design

Advantages

Notes

- extendable to 72 mm
- for subsequent extension of existing folding hoggers Ø 200 mm and Ø 250 mm
- the extensions consist of a body with installed HW segments, spacer and screws
- sense of rotation see drawing

Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
200	18-36	80	4x4	006406 O	006407 O
200	18-54	80	8x4	006408 C	006409 C
250	18-36	80	6x4	058390 O	058391 O
250	18-54	80	12x4	058392 O	058393 O
250	36-54	80	6x4	058396 O	058397 O
250	36-72	80	12x4	058398 O	058399 O
250	54-72	80	6x4	058402 O	058403 O
[mm]	[mm]	[mm]			

Spare parts		Dimension	Class-No.	PU	Ident-No.
Spacers		Ø115x1,0xØ80	955520	1	009255 L
Head Cap Screws	for attaching the extension (18 and 36 mm)	M8x16-8.8 DIN 7984	995111	10	180004 L
Head Cap Screws	for attaching the extension (54 mm)	M8x30-8.8 DIN 7984	995111	10	180005 L
Head Cap Screws	for attaching the extension (72 mm)	M8x50-8.8 DIN 7984	995111	10	180006 L
Cranked Wrench Keys		SW5 DIN ISO 2936	985730	1	009674 L
		[mm]		[pc.]	

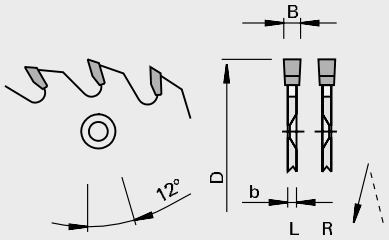
102312

Sizing Saw Blades HW for Segment Hoggers “F”

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application
- double end tenoners
- edge trimming machines
- for sizing cuts in laminated and raw panels

Design
- tooth configuration: flat “F”
- cutting material: HW HL Board 06

Advantages

Notes
- bore diameter 100 mm for s-System hogger
- sense of rotation see drawing

Ø D	B	b	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
200	4,0	2.8	80	40	4/6,5/140	188226 L	188227 L
200	4,0	2.8	80	60	4/6,5/140	188228 L	188229 L
250	4,0	2.8	80	48	6/6,5/200	188230 L	188231 L
250	4,0	2.8	100	48	6/6,5/200	188238 L	188239 L
250	4,0	2.8	80	72	6/6,5/200	188236 L	188237 L
250	4,0	2.8	100	72	6/6,5/200	188240 L	188241 L
[mm]	[mm]	[mm]	[mm]				

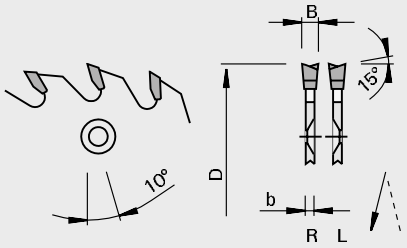
102322

Circular Saw Blades HW for Segment Hoggers “WS”

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application
- double end tenoners
- edge trimming machines
- for sizing cuts in raw and laminated panels

Design
- tooth configuration: ATB “WS”
- cutting material: HW HL Board 06

Advantages
- optimum cutting quality and edge life

Notes
- with pin holes for LEUCO Segment Hoggers
- sense of rotation acc. to VDMA 8849

Ø D	B	b	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
355	4,4	3.0	80	72	6/5,5/300 + 4/10/130	189055 L	189054 L
[mm]	[mm]	[mm]	[mm]				

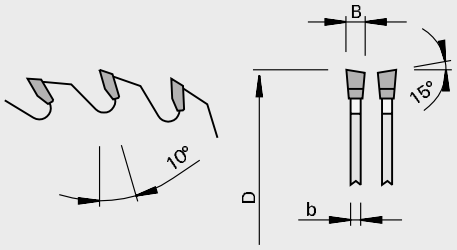
102328

Sizing Saw Blades HW - LowNoise for Segment Hoggers “WS”

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

Design

- tooth configuration: ATB “WS”

Advantages

Notes

- circular saw blades for large hoggers
- when ordering, please indicate hogger type: circular cut or stepped cut
- prices valid for saw blades only; additional pinholes, countersinks and reboring to fit onto hoggers at a surcharge
- other dimensions and versions see chapter “Circular Saw Blades”
- Combi2 = 2/7/42 + 2/9/46 + 2/10/60

Ø D	B	b	Ø d	Z	NL**	Ident-No.
300	3,2	2.2	60	48		188185 O
300	3,2	2.2	30	48	Combi2	189668 L
300	3,2	2.2	30	60	Combi2	189669 L
300	3,2	2.2	30	72	Combi2	192766 L
300	3,2	2.2	30	96	Combi2	192767 L
350	3,5	2.5	30	72	Combi2	189671 L
350	3,5	2.5	30	84	Combi2	192768 L
350	3,5	2.5	30	108	Combi2	192769 L
[mm]	[mm]	[mm]	[mm]			

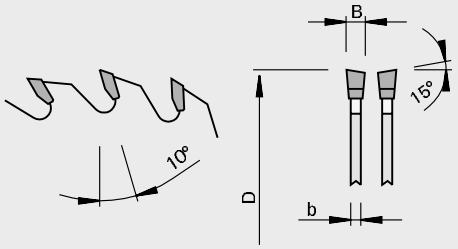
104320

Panel Sizing Saw Blades HW for Segment Hoggers “WS”

Product



Drawing



LEUCO topline

U-CUT WS

Tungsten Carbide [HW]

Machine / Application

Design

- tooth configuration: ATB “WS”
- cutting material: HW HL Board 04 plus

Advantages

Notes

- circular saw blades for large hoggers
- when ordering, please indicate hogger type: circular cut or stepped cut
- prices valid for saw blades only; additional pinholes, countersinks and reboring to fit onto hoggers at a surcharge
- other dimensions and versions see chapter “Circular Saw Blades”

Ø D	B	b	Ø d	Z	Ident-No.
355	4,4	3.0	30	72	193101 S
355	4,4	3.0	60	54	193102 L
[mm]	[mm]	[mm]	[mm]		

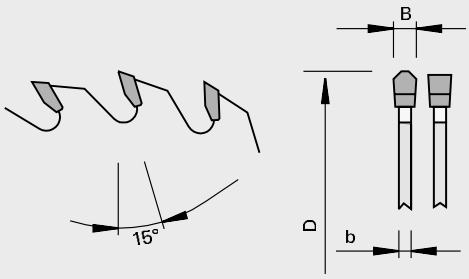
104370

Panel Sizing Saw Blades HW for Segment Hoggers “TR-F”

Product



Drawing



LEUCO topline

U-CUT TR-F

Tungsten Carbide [HW]

Machine / Application

Design

- tooth configuration: triple chip / flat “TR-F”

Advantages

Notes

- circular saw blades for large hoggers
- when ordering, please indicate hogger type: circular cut or stepped cut
- prices valid for saw blades only; additional pinholes, countersinks and reboring to fit onto hoggers at a surcharge
- other dimensions and versions see chapter “Circular Saw Blades”

Ø D	B	b	Ø d	Z	Ident-No.
305 [mm]	4,4 [mm]	2.8 [mm]	60 [mm]	60	192905 L

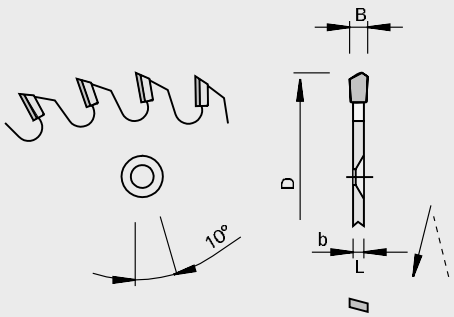
202062

Sizing Saw Blades DP for Segment Hoggers “ES-FA”

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- edge trimming machines
- for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration: top bevel with chamfer and face shear “ES-FA”
- saw blade with equal tooth pitch
- n max = 9,000 min-1 with Ø 200 mm
- n max = 7,200 min-1 with Ø 250 mm
- resharpenable area 4 mm; sides of teeth can be resharpened

Advantages

Notes

- application against feed
- for scoring/hogging (RZ) and double hogging (DZ) process
- for combination with LEUCO Segment Hoggers: Ø 80 on Segment Hoggers with standard bushing / Ø 100 on Segment Hoggers for s-System
- the specified feed rates are based on n = 6,000 min-1
- sense of rotation see drawing

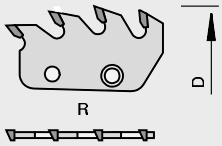
Ø D	B	b	Ø d	Z	Feed RZ	Feed DZ	Ident-No. [L]	Ident-No. [R]
200	4,0	2.8	80	24	15	25	170397 S	170398 S
200	4,0	2.8	80	28	17,5	30	170399 S	170400 S
200	4,0	2.8	80	32	20	32,5	170401 S	170402 S
200	4,0	2.8	80	36	22,5	35	170403 S	170404 S
200	4,0	2.8	80	40	25	40	170405 S	170406 S
200	4,0	2.8	80	44	27,5	45	170407 S	170408 S
200	4,0	2.8	80	48	30	50	170409 S	170410 S
250	4,0	2.8	80	24	15	25	170495 S	170496 S
250	4,0	2.8	80	30	20	32,5	170497 S	170498 S
250	4,0	2.8	80	36	25	40	170499 C	170500 C
250	4,0	2.8	80	42	27,5	45	170501 S	170502 S
250	4,0	2.8	80	48	30	50	170503 C	170504 C
250	4,0	2.8	80	54	35	55	170505 S	170506 S
250	4,0	2.8	80	60	40	60	170507 C	170508 C
250	4,0	2.8	80	66	45	65	170509 S	170510 S
250	4,0	2.8	100	24	15	25	170621 S	170622 S
250	4,0	2.8	100	30	20	32,5	170623 C	170624 C
250	4,0	2.8	100	36	25	40	170625 C	170626 C
250	4,0	2.8	100	42	27,5	45	170627 C	170628 C
250	4,0	2.8	100	48	30	50	170629 C	170630 C
250	4,0	2.8	100	54	35	55	170631 S	170632 S
250	4,0	2.8	100	60	40	60	170633 C	170634 C
250	4,0	2.8	100	66	45	65	170635 S	170636 S
250	4,0	2.8	100	72	50	70	170637 C	170638 C
[mm]	[mm]	[mm]	[mm]		[m/min]	[m/min]		

116200

Segments HW for Segment Hoggers - Circular Cut with shear angle

Product

Drawing



Tungsten Carbide [HW]

Machine / Application
- for complete hogging of the offal in wood-based panels

Design
- the first tooth of the segment features a 10 degree bevel on the side of the tooth
- with shear angle
- HW-tipped

Advantages
- no end chipping when cutting along the grain

Notes
- for offal widths to 18 mm
- ready-to-use in HW and DP Segment Hoggers Ø 200 mm and Ø 250 mm
- segments must be installed in sets; one set consists of 4 HW segments for Ø 250 mm / 6 HW segments for Ø 250 mm
- for scoring/hogging (RZ) and double hogging (DZ) process

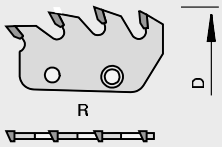
Ø D	Z		PU	Ident-No. [L]	Ident-No. [R]
200/250	4	DZ	12	171395 L	171396 L
[mm]			[pc.]		

116200

Segments HW for Segment Hoggers - Stepped Cut

Product

Drawing



Tungsten Carbide [HW]

MEC

Machine / Application
- for complete hogging of the offal in wood-based panels

Design
- Ident-No.177376 and 177377: the first tooth of the segment features a 10 degree bevel on the side of the tooth
- with shear angle
- HW-tipped

Advantages
- no end chipping when cutting across the grain

Notes
- for offal widths to 18 mm
- ready-to-use in HW and DP Segment Hoggers Ø 200 mm and Ø 250 mm
- segments must be installed in sets; one set consists of 4 HW segments for Ø 250 mm / 6 HW segments for Ø 250 mm
- for scoring/hogging (RZ) and double hogging (DZ) process

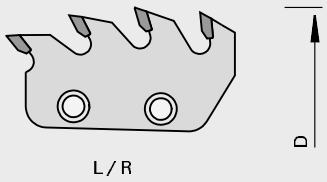
Ø D	Z		PU	Ident-No. [L]	Ident-No. [R]
200/250	4	stepped cut	12	177374 L	177375 L
200/250	4	stepped cut	12	177376 C	177377 C
[mm]			[pc.]		

116200

Segments HW for Segment Hoggers - Circular Cut

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for complete hogging of the offal in wood-based panels

Design

- HW-tipped
- segments for both left-hand and right-hand use

Advantages

- no end chipping when cutting along the grain

Notes

- for offal widths to 18 mm
- ready-to-use in HW Segment Hoggers Ø 200 mm and Ø 250 mm
- segments must be installed in sets; one set consists of 4 HW segments for Ø 250 mm / 6 HW segments for Ø 250 mm
- for scoring/hogging (RZ) and double hogging (DZ) process

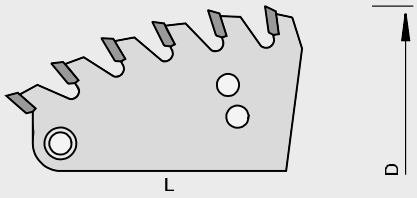
Ø D	Z		PU	Ident-No.	
200/250	4	RZ	12	168680	L
200/250	4	DZ	12	167118	L
[mm]			[pc.]		

116100

Segments HW for Segment Hoggers - Stepped Cut

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- for complete hogging of the offal in wood-based panels

Design

- segments for both left-hand and right-hand use

Advantages

- no end chipping when cutting along or across the grain thanks to stepped cut configuration

Notes

- ready-to-use in HW Segment Hoggers Ø 250 mm (old design) / Ø 300 mm - Ø 430 mm
- segments must be installed in sets; one set consists of 4 HW segments for Ø 250 mm (old design) / 6 HW segments for Ø 300 - 430 mm
- for scoring/hogging (RZ) and double hogging (DZ) process
- segments can be used for circular cut and stepped cut configuration

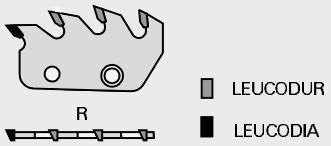
Ø D	Z	PU	Ident-No. [L]	Ident-No. [R]
250	6	12	006120 C	006129 C
250	8	12	006121 C	006130 C
300	6	12	006123 L	006132 L
300	8	12	006124 L	006133 L
300	10	12	006125 L	006134 L
350/430	6	12	006126 L	006135 L
350/430	8	12	006127 L	006136 L
350/430	10	12	006128 L	006137 L
[mm]		[pc.]		

216200

Segments for Segment Hoggers - Circular Cut Z=1 DP + 3 HW

Product

Drawing



LEUCO DIA

Polycrystalline diamond [DP]

Machine / Application

- for complete hogging of the offal in wood-based panels

Design

- the first tooth is DP-tipped, the following teeth are HW-tipped
- the first tooth of the segment features a 10 degree bevel on the side of the tooth
- with shear angle

Advantages

- no end chipping when cutting along the grain

Notes

- for offal widths to 18 mm
- ready-to-use in DP Segment Hoggers Ø 200 mm and Ø 250 mm
- segments must be installed in sets; one set consists of 4 DP segments for Ø 250 mm / 6 DP segments for Ø 250 mm
- for scoring/hogging (RZ) and double hogging (DZ) process

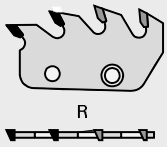
Ø D [mm]	Z	PU [pc.]	Ident-No. [L]	Ident-No. [R]
200/250	1+3	12	172288 C	172289 C

216200

Segments for Segment Hoggers - Circular Cut Z=2 DP + 2 HW

Product

Drawing



LEUCO DIA

Polycrystalline diamond [DP]

Machine / Application

- for complete hogging of the offal in wood-based panels

Design

- the first and second tooth are DP-tipped, the following teeth are HW-tipped
- the first tooth of the segment features a 10 degree bevel on the side of the tooth
- with shear angle

Advantages

- no end chipping when cutting along the grain

Notes

- for offal widths to 18 mm
- ready-to-use in DP Segment Hoggers Ø 200 mm and Ø 250 mm
- segments must be installed in sets; one set consists of 4 DP segments for Ø 250 mm / 6 DP segments for Ø 250 mm
- for scoring/hogging (RZ) and double hogging (DZ) process

Ø D [mm]	Z	PU [pc.]	Ident-No. [L]	Ident-No. [R]
200/250	2+2	12	172290 C	172291 C

Spare parts		Dimension [mm]	Class-No.	PU [pc.]	Ident-No.
Countersunk Screws	for attaching the segments	M8x12,5	995192	10	180010 L
Countersunk Screws		M5x12-5.8 DIN 87	995122	10	180007 L
Screwdrivers	for hoggers	9,0	985730	1	011088 L

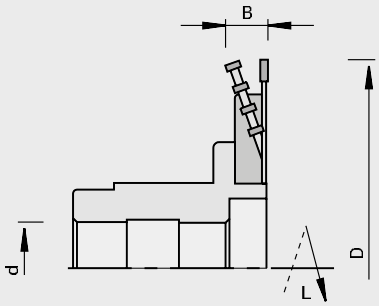
115421

Folding Segment Hoggers HW mounted on Bushing - Circular Cut “F”

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- folding machines
- for cutting of V grooves and rabbets in laminated and veneered panels

Design

- tooth configuration of the saw blade: flat “F”
- RPM n = 3,000 min-1 and n = 6,000 min-1depending on the machine

Advantages

Notes

- application against feed
- circular saw blade and segments have the same diameter
- the opening angle of > 90 degrees must be determined per application
- sense of rotation see drawing

H	Ø D	B	Ø d	Z	Z segments		Ident-No. [L]	Ident-No. [R]
25	200	36	35	40	8x4	Koch, Lehbrink	051211 O	051208 O
25	250	36	35	48	12x4	Koch, Lehbrink	164021 O	164022 O
16	250	22	35	48	6x5	Koch, Lehbrink	164027 O	164028 O
[mm]	[mm]	[mm]	[mm]					

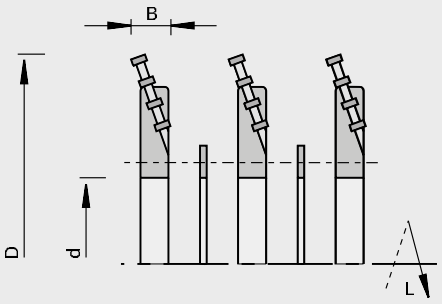
115401

Folding Segment Extensions HW - Circular Cut

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- for cutting of V grooves in thick panels

Design

- HW-tipped

Advantages

Notes

- extendable to 54 mm
- for subsequent extension of existing folding hoggers Ø 200 mm and Ø 250 mm
- the diameters of existing folding hoggers and folding extensions must match
- the extension assemblies consist of a body with installed HW segments, spacer and screws
- sense of rotation see drawing

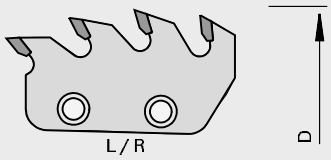
Ø D	B	Ø d	Z			Ident-No. [L]	Ident-No. [R]
250	36-54	80	6x4			164011 O	164012 O
[mm]	[mm]	[mm]					

116210

Segments HW - Z=4 for folding segment hoggers

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- for complete hogging of the offal during the V-groove cutting process

Design

- HW-tipped

Advantages

Notes

- ready-to-use in HW Folding Segment Hoggers Ø 200 mm and Ø 250 mm and for extensions
- circular saw blade and segments must have the same diameter
- segments can be used for clockwise and counter-clockwise rotation

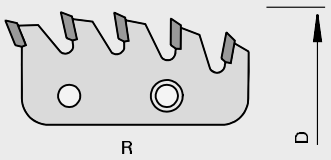
Ø D [mm]	Z	Ident-No.
200	4	168757 L
250	4	168760 L

116210

Segments HW - Z=5 for folding segment hoggers

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- for complete hogging of the offal during the V-groove cutting process

Design

- HW-tipped

Advantages

Notes

- ready-to-use in HW Folding Segment Hoggers Ø 200 mm and Ø 250 mm and for extensions
- circular saw blade and segments must have the same diameter

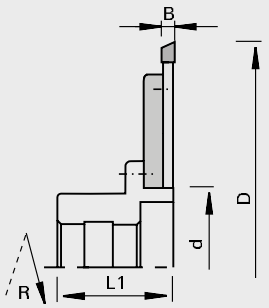
Ø D [mm]	Z	Ident-No. [L]	Ident-No. [R]
200	5	168759 S	168758 S
250	5	168761 L	168762 L

115775

Saw Hoggers HW for finger jointing lines - Grecon

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application
- finger jointing lines
- for chip-free cross-cutting of solid woods

Design

Advantages
- clean, chip-free cuts and long edge lives thanks to special cutting geometry
- precise fit for finger joints
- low noise level

Notes
- included in delivery: hogger saw blade, flange, screws and screwdrivers (not mounted); sleeve not included in delivery
- sense of rotation acc. to VDMA 8849

Ø D	B	b	L1	Ø d	Z	DKN		Ident-No. [L]	Ident-No. [R]
250	8,0	44	59	80	60	12x3,3	Grecon	182379 O	182378 O
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]			

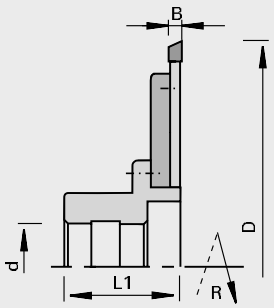
Spare parts	Dimension	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
Hogging Saw Blades	Ø250x6,3/5xØ75 Z80	102352	1	189033 L	189032 L
Hogging Saw Blades	Ø250x8,0/6,1xØ80 Z60	102352	1	189223 L	189222 L
Flanges	Ø210x8,4xØ80	997300	1		182377 L
Countersunk Screws	M8x20 DIN 7991-8.8	995121	10		056378 L
Countersunk Screws	M5x12 T20 D=Ø9,3	995125	10		166709 L
Screwdrivers	T20x100	985730	1		166092 L
Bushings for Grecon	Ø113x59x40DKN	997300	1		189100 L
Bushings for NKT	Ø206x100,3x38 DKN	997370	1		178294 L
	[mm]		[pc.]		

115775

Saw Hoggers HW mounted on bushing for finger jointing lines - Grecon

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application
- finger jointing lines
- for chip-free cross-cutting of solid woods

Design

Advantages
- clean, chip-free cuts and long edge lives thanks to special cutting geometry
- precise fit for finger joints
- low noise level

Notes
- sense of rotation acc. to VDMA 8849

Ø D	B	b	L1	Ø d	Z	DKN		Ident-No. [L]	Ident-No. [R]
250	8,0	44	59	40	60	12x3,3	Grecon	182599 O	182600 O
350	10	44	59	40	60+12	12x3,3	Grecon	182611 O	182612 O
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]			

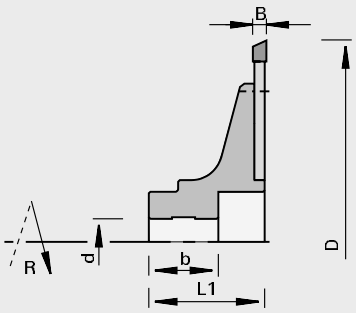
Spare parts	Dimension	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
Hogging Saw Blades	Ø250x6,3/5xØ75 Z80	102352	1	189033 L	189032 L
Hogging Saw Blades	Ø250x8,0/6,1xØ80 Z60	102352	1	189223 L	189222 L
Hogging Saw Blades	Ø350x10,0xØ80 Z60+12	102352	1	189246 L	189247 L
Flanges	Ø210x8,4xØ80	997300	1		182377 L
Countersunk Screws	M8x20 DIN 7991-8.8	995121	10		056378 L
Countersunk Screws	M5x12 T20 D=Ø9,3	995125	10		166709 L
Screwdrivers	T20x100	985730	1		166092 L
Bushings for Grecon	Ø113x59x40DKN	997300	1		189100 L
Bushings for Grecon-Combipact	Ø250x8x40	997370	1		178783 S
	[mm]		[pc.]		

115775

Saw Hoggers HW mounted on bushing for finger jointing lines - NKT

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- finger jointing lines
- for chip-free cross-cutting of solid woods

Design

Advantages

- clean, chip-free cuts and long edge lives thanks to special cutting geometry
- precise fit for finger joints
- low noise level

Notes

- sense of rotation acc. to VDMA 8849

Ø D	B	b	L1	Ø d	Z	DKN		Ident-No. [L]	Ident-No. [R]
250	8,0	84	102	38	60	10x4	NKT	182601 O	182602 O
300	8,0	84	102	38	60	10x4	NKT	182607 O	182608 O
350	10	84	102	38	60+12	10x4	NKT	182613 O	182614 O
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]			

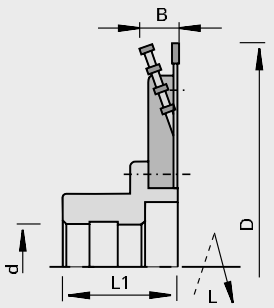
Spare parts	Dimension	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
Hogging Saw Blades	Ø250x8,0/6,1xØ80 Z60	102352	1	189223 L	189222 L
Hogging Saw Blades	Ø300x8,0/6,1xØ80 Z60	102352	1	189244 L	189245 L
Hogging Saw Blades	Ø350x10,0xØ80 Z60+12	102352	1	189246 L	189247 L
Countersunk Screws	M5x12 T20 D=Ø9,3	995125	10		166709 L
Screwdrivers	T20x100	985730	1		166092 L
Bushings for NKT	Ø206x100,3x38 DKN	997370	1		178294 L
	[mm]		[pc.]		

115775

Saw Segment Hogger HW mounted on bushing for finger jointing lines - Grecon

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application
- finger jointing lines
- for chip-free cross-cutting of solid woods

Design

Advantages
- clean, chip-free cuts and long edge lives thanks to special cutting geometry
- precise fit for finger joints
- low noise level

Notes
- sense of rotation see drawing

Ø D	B	b	L1	Ø d	Z	DKN		Ident-No. [L]	Ident-No. [R]
250	16,3	44	59	40	48+(6x4)	12x3,3	Grecon	189097 O	189096 O
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]			

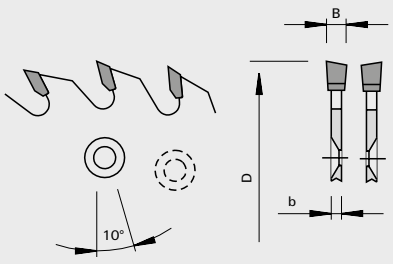
Spare parts	Dimension	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
Hogger Saw Blade	Ø250x4,0/2,8xØ120 Z48	102312	1	189092 L	189093 L
HW segments	Ø250 Z=4	116200	12	189094 L	189094 L
Bushings for Grecon	Ø113x59x40DKN	997300	1		189100 L
Countersunk Screws	M6x10 SW4 DIN EN ISO 10642	995121	10		182598 L
Countersunk Screws	M5x10-8.8 DIN EN ISO 2009	995122	10		055881 L
Head Cap Screws	M8x16-8.8 DIN EN ISO 4762	995111	10		001891 L
Screwdrivers	SW4x100	985730	1		166091 L
Screwdrivers	8,0	985730	1		053874 L
	[mm]		[pc.]		

105320

Scoring Saw Blades HW “WS” - for finger joint machines

Product

Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application
- finger jointing lines Grecon
- for scoring of solid woods

Design
- 6 countersunk pin holes on both sides each
- for clockwise and counter-clockwise rotation
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 06

Advantages

Notes
- along and accross the grain, from below

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁		Ident-No.
200	7,0	4.0	75	48	2x6/6,5/95	10	10	Grecon	189539 L
[mm]	[mm]	[mm]	[mm]			[°]	[°]		

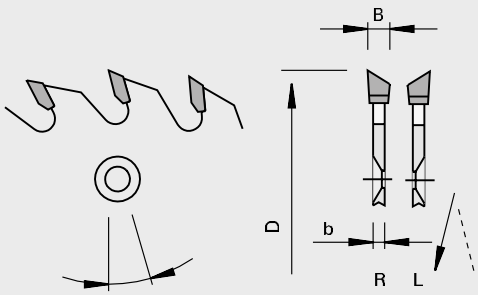
105350

Scoring Saw Blades HW “ES” - for finger joint machines

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application
- finger jointing lines Grecon-Combipact
- for scoring of solid woods

Design
- tooth configuration: top bevel “ES (right + left)”
- cutting material: HW HL Board 06

Advantages

Notes
- along and accross the grain, from above and below
- sense of rotation see drawing

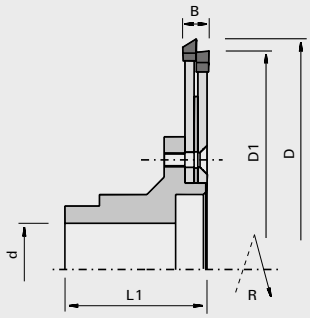
Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁		Ident-No. [L]	Ident-No. [R]
200	5,1	3.5	75	48	6/7/95	10	25	Grecon-Compipact	188947 L	188948 L
200	6,0	4.0	75	48	6/6,5/95	10	5	Grecon		189540 L
200	4,7	3.4	75	64	6/6,6/95	10	30	Grecon HS 120	189034 L	189035 L
[mm]	[mm]	[mm]	[mm]			[°]	[°]			

105355

Scoring Saw Blade Set HW “ES” - for finger joint machines

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application
- finger jointing lines Grecon Ultra / Profi Joint
- for scoring of solid woods

Design
- tooth configuration: top bevel “ES”
- cutting material: HW HL Board 06

Advantages

Notes
- along and accross the grain, from below
- sense of rotation according to VDMA 8849

Ø D1	Ø D	B	L1	Ø d	Z	DKN		Ident-No. [R]
190	200	11,6	61	40	48+48	12x3,3	Grecon Ultra / Profi Joint	189536 O
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Scoring Saw Blades	Ø200x6,0/4,0xØ75 Z48	105350	1	189537 L
Scoring Saw Blades	Ø190x6,0/4,0xØ75 Z48	105350	1	189538 L
Bushings for Grecon	Ø115x61xØ40DKN	997300	1	189543 L
Spacers	Ø150x1,5xØ75	955520	1	189542 L
Countersunk Screws	M6x20-8.8 SW4 DIN EN ISO 10642	995121	10	183114 L
Screwdrivers	SW4x100	985730	1	166091 L
	[mm]		[pc.]	

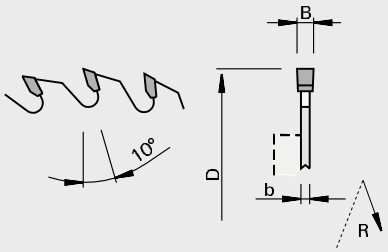
105311

Scoring Saw Blades HW “F” - for hoggers and flange

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- double end tenoners with scoring / hogging unit
- for chip-free scoring of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration: flat “F”
- cutting material: HW HL Board 06

Advantages

Notes

- application with feed
- for flange Ident-No. L 164770 R 164758 for LEUCO s-System
- for flange Ident-No. 006480 for Homag, Brandt, IMA motor shaft Ø 30 DKW
- flanges see chapter “Clamping Systems”
- included in delivery: saw blade without flange
- sense of rotation acc. to VDMA 8849

Ø D	B	b	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
180	3,2	2.2	65	36	6/6,5/90	188266 L	188267 L
180	3,2	2.2	65	48	6/6,5/90	188268 L	188269 L
180	3,2	2.2	65	54	6/6,5/90	188270 L	188271 L
[mm]	[mm]	[mm]	[mm]				

Complete sets with flange	Ø D	Z		Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	180	36	Homag, Brandt, IMA	105311	1	160656 O	160655 O
	180	48	Homag, Brandt, IMA	105311	1	161274 O	161273 O
	180	54	Homag, Brandt, IMA	105311	1	161272 O	161271 O
	[mm]				[pc.]		

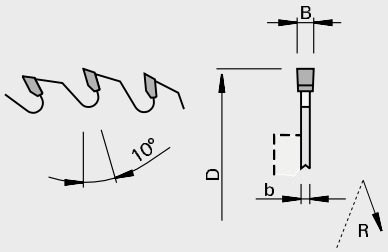
105311

Scoring Saw Blades HW “F” - for hoggers and flange 160849

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- double end tenoners with scoring / hogging unit
- for chip-free scoring of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration: flat “F”
- cutting material: HW HL Board 06

Advantages

Notes

- application with feed
- for flange Ident-No.160849 for LEUCO s-System
- flanges see chapter “Clamping Systems”
- included in delivery: saw blade without flange
- sense of rotation acc. to VDMA 8849

Ø D	B	b	Ø d	Z	NL	Ident-No.
180	3,2	2.2	50	36	3/22/80	188263 L
180	3,2	2.2	50	48	3/22/80	188264 L
180	3,2	2.2	50	54	3/22/80	188265 L
200	3,2	2.2	50	42	3/22/80	188272 O
[mm]	[mm]	[mm]	[mm]			

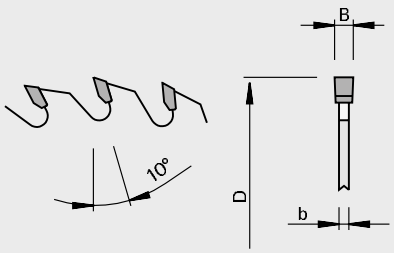
105311

Scoring Saw Blades HW “F” - for hoggers

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- double end tenoners with scoring / hogging unit
- for chip-free scoring of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration: flat “F”
- cutting material: HW HL Board 06

Advantages

Notes

- application with feed

Ø D	B	b	Ø d	Z	NL	Ident-No.
150	3,2	2.2	30	36		188295 L
150	3,2	2.2	40	36		188255 O
150	3,2	2.2	40	48		188256 L
150	3,2	2.2	55	36		188274 L
180	3,2	2.2	30	36		188257 L
180	3,2	2.2	30	54		188259 L
200	3,2	2.2	30	42		188260 L
200	3,2	2.2	60	64		188276 C
[mm]	[mm]	[mm]	[mm]			

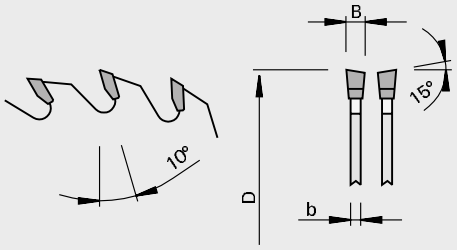
105320

Scoring Saw Blades HW “WS” - for hoggers

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- double end tenoners with scoring / hogging unit
- for chip-free scoring of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration: ATB “WS”
- cutting material: HW HL Board 06

Advantages

Notes

- application with feed

Ø D	B	b	Ø d	Z	Ident-No.
150	3,2	2.2	30	48	188292 L
180	3,2	2.2	30	54	188293 L
200	3,2	2.2	30	64	188294 L
[mm]	[mm]	[mm]	[mm]		

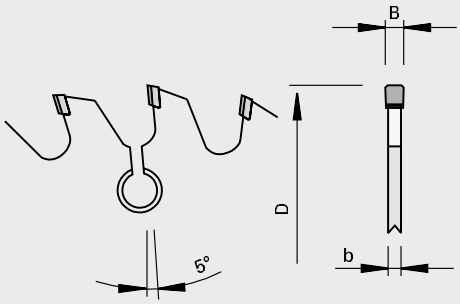
205241

DIAMAX Scoring Saw Blades DP “F-FA” - for hoggers and flange 160849

Product



Drawing



LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- edge trimming machines
- for chip-free scoring of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration: flat with two-sided chamfer “F-FA”
- n max = 10,000 min-1
- reduced resharpenable area

Advantages

- long edge lives
- low purchase price thanks to large-scale manufacturing

Notes

- application with feed
- the specified feed rates are based on n = 6,000 min-1
- for flange Ident-No.160849 for LEUCO s-System

Ø D	B	b	Ø d	Z	NL	Recommended feed	Ident-No.
180	3,2	2.2	50	24	3/22/80	20	173712 S
[mm]	[mm]	[mm]	[mm]			[m/min]	

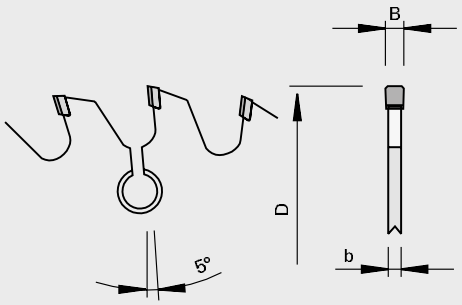
205241

DIAMAX Scoring Saw Blades DP “F-FA” - for hoggers and flange 006480

Product



Drawing



LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- edge trimming machines
- for chip-free scoring of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration: flat with two-sided chamfer “F-FA”
- n max = 10,000 min-1
- reduced resharpenable area

Advantages

- long edge lives
- low purchase price thanks to large-scale manufacturing

Notes

- application with feed
- the specified feed rates are based on n = 6,000 min-1
- for flange Ident-No. 006480 for Homag, Brandt, IMA for LEUCO s-System

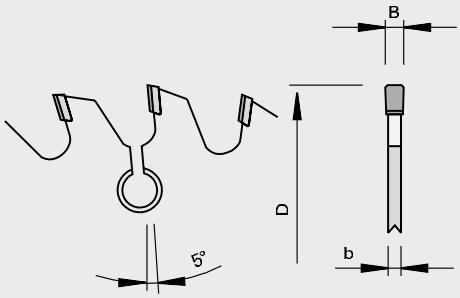
Ø D	B	b	Ø d	Z	NL	Recommended feed	Ident-No.
180	3,2	2.2	65	32	6/6,5/90	30	173722 L
[mm]	[mm]	[mm]	[mm]			[m/min]	

205041

Scoring Saw Blades DP “F-FA” - for hoggers

Product

Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- edge trimming machines
- for chip-free scoring of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration: flat with two-sided chamfer “F-FA”
- resharpenable area 4 mm

Advantages

- long edge lives

Notes

- application with feed
- the specified feed rates are based on n = 6,000 min-1

Ø D	B	b	Ø d	Z	Recommended feed	Ident-No.
150	3,2	2.2	55	28	25	169322 S
180	3,2	2.2	30	48	50	169338 S
180	3,2	2.2	30	44	45	169335 S
180	3,2	2.2	30	40	40	169332 S
180	3,2	2.2	30	36	35	169329 S
180	3,2	2.2	30	32	30	169327 S
180	3,2	2.2	30	28	25	169326 S
180	3,2	2.2	30	24	20	169325 S
150	3,2	2.2	55	32	30	169323 S
150	3,2	2.2	55	24	20	169321 S
200	3,2	2.2	30	24	20	169341 S
150	3,2	2.2	60	36	35	170173 S
150	3,2	2.2	55	36	35	169324 S
150	3,2	2.2	60	28	25	170171 S
150	3,2	2.2	60	32	30	170172 S
200	3,2	2.2	30	28	25	169343 S
150	3,2	2.2	60	24	20	170170 S
200	3,2	2.2	30	48	50	169353 S
200	3,2	2.2	30	44	45	169351 S
200	3,2	2.2	30	40	40	169349 S
200	3,2	2.2	30	36	35	169347 S
200	3,2	2.2	30	32	30	169345 S
[mm]	[mm]	[mm]	[mm]		[m/min]	

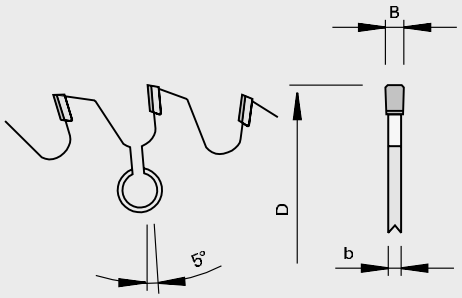
205040 / 205041

Scoring Saw Blades DP “F-FA” - for hoggers and flange 160849

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- edge trimming machines
- for chip-free scoring of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration: flat with two-sided chamfer “F-FA”
- resharpenable area 4 mm

Advantages

- long edge lives

Notes

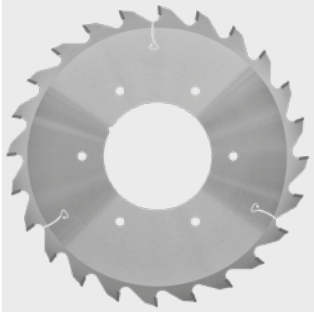
- application with feed
- the specified feed rates are based on n = 6,000 min-1
- for flange Ident-No.160849 for LEUCO s-System

Ø D	B	b	Ø d	Z	NL	Recommended feed	Ident-No.
180	3,2	2.2	50	24	3/22/80	20	168905 S
180	3,2	2.2	50	28	3/22/80	25	168907 C
180	3,2	2.2	50	32	3/22/80	30	168909 C
180	3,2	2.2	50	36	3/22/80	35	169330 S
180	3,2	2.2	50	40	3/22/80	40	169333 S
180	3,2	2.2	50	44	3/22/80	45	169336 S
180	3,2	2.2	50	48	3/22/80	50	169339 S
200	3,2	2.2	50	24	3/22/80	20	169342 S
200	3,2	2.2	50	28	3/22/80	25	169344 S
200	3,2	2.2	50	32	3/22/80	30	169346 S
200	3,2	2.2	50	36	3/22/80	35	169348 S
200	3,2	2.2	50	40	3/22/80	40	169350 S
200	3,2	2.2	50	44	3/22/80	45	169352 S
200	3,2	2.2	50	48	3/22/80	50	169354 S
[mm]	[mm]	[mm]	[mm]			[m/min]	

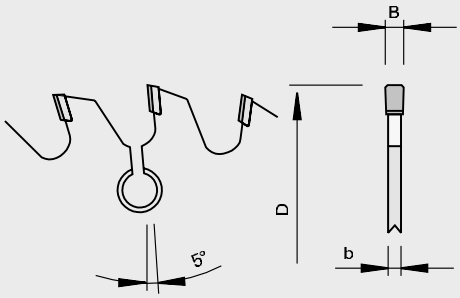
205041

Scoring Saw Blades DP “F-FA” - for hoggers and flange 006480

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application
- double end tenoners
- edge trimming machines
- for chip-free scoring of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design
- tooth configuration: flat with two-sided chamfer ”F-FA”
- resharpenable area 4 mm

Advantages
- long edge lives

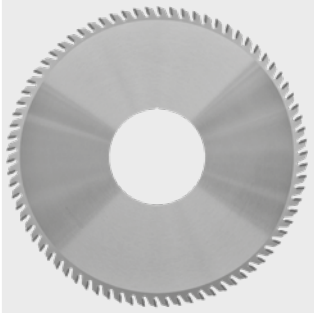
Notes
- application with feed
- the specified feed rates are based on n = 6,000 min-1
- for flange Ident-No. 006480 for Homag, Brandt, IMA for LEUCO s-System

Ø D	B	b	Ø d	Z	NL	Recommended feed	Ident-No.
180	3,2	2.2	65	24	6/5,5/90	20	168906 C
180	3,2	2.2	65	28	6/5,5/90	25	168908 C
180	3,2	2.2	65	32	6/6,5/90	30	169328 S
180	3,2	2.2	65	36	6/5,5/90	35	169331 S
180	3,2	2.2	65	40	6/6,5/90	40	169334 S
180	3,2	2.2	65	44	6/5,5/90	45	169337 S
180	3,2	2.2	65	48	6/6,5/90	50	169340 S
[mm]	[mm]	[mm]	[mm]			[m/min]	

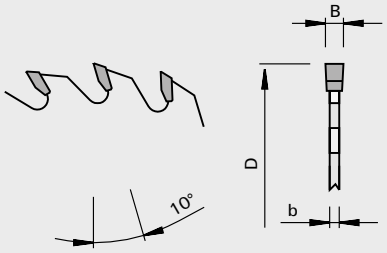
102312

Sizing Saw Blades HW “F” - for hoggers

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application
- double end tenoners
- for sizing cuts in raw and laminated panels

Design
- tooth configuration: flat ”F”
- cutting material: HW HL Board 06

Advantages

Notes

Ø D	B	b	Ø d	Z	Tooth geometry	Ident-No.
250	4,0	2.8	80	54	flat without cut out	188248 L
250	4,0	2.8	80	78	flat without cut out	188249 L
255	4,0	2.8	60	60	flat without cut out	188251 L
255	4,0	2.8	80	60	flat without cut out	188253 O
[mm]	[mm]	[mm]	[mm]			

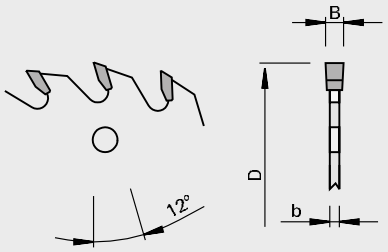
102312

Sizing Saw Blades HW “F” - for high-tech hoggers

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application
- double end tenoners
- for sizing cuts in raw and laminated panels

Design
- tooth configuration: flat “F”
- cutting material: HW HL Board 06

Advantages

Notes

Ø D	B	b	Ø d	Z	NL	Tooth geometry	Ident-No.
250	4,0	2.8	100	72	6/6,5/172	flat with 6 cut out	188245 S
[mm]	[mm]	[mm]	[mm]				

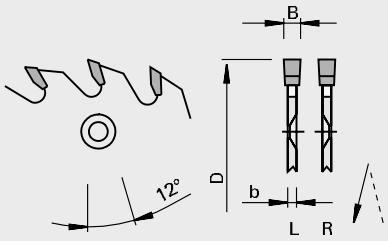
102312

Sizing Saw Blades HW for TwinTec Hoggers “F”

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application
- double end tenoners
- edge trimming machines
- for sizing cuts in laminated and raw panels

Design
- tooth configuration: flat “F”
- cutting material: HW HL Board 06

Advantages

Notes
- sense of rotation see drawing

Ø D	B	b	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
220	4,0	2.8	80	48	6/6/154	169820 L	169819 L
220	4,0	2.8	80	60	6/6/154	169818 L	169817 L
[mm]	[mm]	[mm]	[mm]				

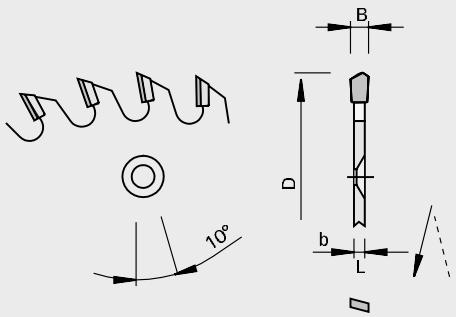
202062

Circular Saw Blades DP for TwinTec Hoggers “ES-FA”

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- edge trimming machines
- for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration: top bevel with chamfer and face shear “ES-FA”
- n max = 7,200 min-1
- resharpenable area 4 mm; sides of teeth can be resharpened
- saw blade with equal tooth pitch

Advantages

- decreased downtimes thanks to long edge lives

Notes

- application with feed
- for scoring/hogging (RZ) and double hogging (DZ) process
- for combination with LEUCO TwinTec hoggers
- the specified feed rates are based on n = 6,000 min-1
- sense of rotation see drawing

Ø D	B	b	Ø d	Z	Feed RZ	Feed DZ	Ident-No. [L]	Ident-No. [R]
220	4,0	2.8	80	24	15	25	171353 C	171354 C
220	4,0	2.8	80	30	20	32,5	171355 C	171356 C
220	4,0	2.8	80	36	25	40		171358 C
220	4,0	2.8	80	42	27,5	45	171359 C	171360 C
220	4,0	2.8	80	48	30	50	171361 C	171362 C
220	4,0	2.8	80	54	35	55	171363 C	171364 C
220	4,0	2.8	80	60	40	60	171365 C	171366 C
[mm]	[mm]	[mm]	[mm]		[m/min]	[m/min]		

150501

Segments VHW for TwinTec hogger

Product



Drawing



LEUCO DUR

Solid Tungsten Carbide

Machine / Application

- for use in TwinTec Hogger Ring

Design

- Z = 1 VHW
- with shear angle

Advantages

Notes

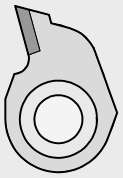
- one set consists of 6 segments
- completely tipped for circular cut: 12 segments / stepped cut: 24 segments

	Ident-No. [L]	Ident-No. [R]
	171232 L	171233 L

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x13,5 T20 D=Ø10	995125	10	171238 L
Screwdrivers	T20x100	985730	1	166092 L
	[mm]		[pc.]	

232921

Segments for TwinTec Hogger DP-tipped

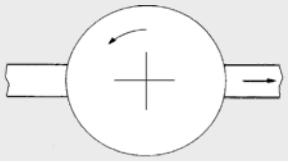
Product	Drawing	
		LEUCO DIA Polycrystalline diamond [DP]

Machine / Application	Design	Advantages	Notes
I for use in TwinTec Hogger Ring	I Z = 1 DP-tipped I with shear angle		I one set consists of 6 segments I completely tipped for circular cut: 12 segments / stepped cut: 24 segments

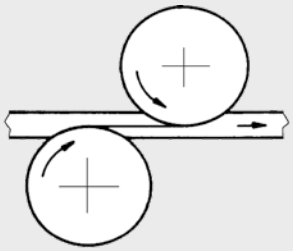
				Ident-No. [L]	Ident-No. [R]
				171234 C	171235 C
Spare parts	**Dimension**		**Class-No.**	**PU**	**Ident-No.**
Countersunk Screws	M5x13,5 T20 D=Ø10		995125	10	171238 L
Screwdrivers	T20x100		985730	1	166092 L
	[mm]			[pc.]	

Application example

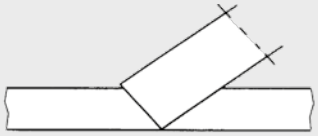
Hogging



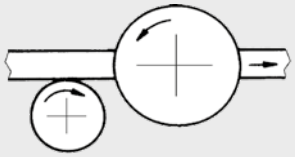
Double hogging



Folding Hogging



Scoring / Hogging



Order / Inquiry for Special Tools: Hoggers

Please copy and send the completed form to one of the LEUCO sales offices. (Only one tool description per form)

Customer-no.: _____
Company: _____
Plant: _____
Street: _____
Zip / City: _____
Country: _____
Contact partner: _____
Phone: _____
City and Date: _____

Order: o
Inquiry: o

Delivery (week no.): _____
(Not binding)
No. of pieces: _____

Fax: _____
Signature: _____

Machine

Maker: _____
Model: _____
Type: _____
Operating RPM [min-1]: _____
Feed rate [m/min]: _____
Flange diameter [mm]: _____
Motor output (hogger motor) [kW]: _____
Mode of application:
Hogger: Against feed: o
With feed: o
Mode of application: Hogging o
Scoring / Hogging o
Double hogging o

Workpiece

Description: _____
Material thickness [mm]: _____
Hogging width [mm]: _____
Cutting quality: Rough hogging o
Finish hogging o
Folding o
Circular cut o
Stepped cut o
Direction of cut: With grain o
(Solid wood) Across grain o

Coating

Yes o No o
Description: _____
Further Information _____

Tool

Compact Hoggers o
Segment Hoggers o
TwinTec Hoggers o
Radius hogger o
Other: o

Cutting diameter D [mm] _____
Hogging width [mm]: _____
No. of teeth [pcs.]: _____
Circular Saw Blade
No. x no. of segment teeth X

Sense of rotation Right o Left o

Interface

Bushing:
Double keyway Width Height
Keyway Width Height
Hydro Bushing: _____
Hydro s-System: _____
s-System: _____
Other: _____

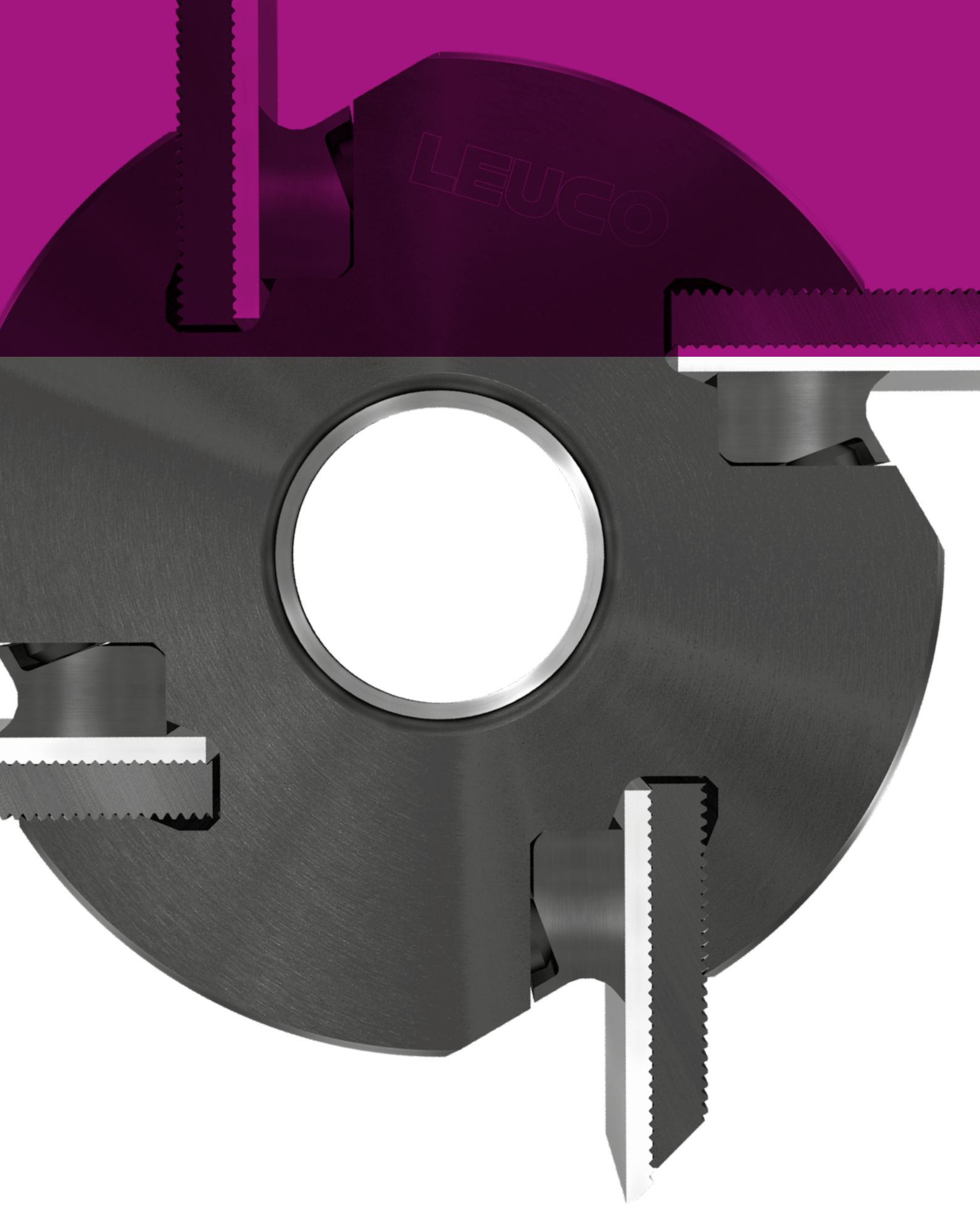
Cutting material

Circular Saw Blade: Carbide o
Diamond o
Segments: Carbide o
Diamond o

o Check if applicable

Tool drawing:

517-01.0708


LEUCO

Cutters with Bore

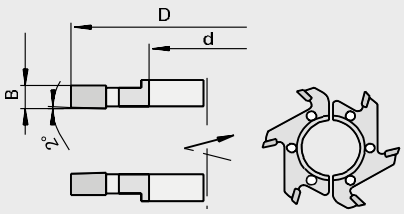
Product	Page
Edge trimming	3–1
Postforming	3–68
Grooving	3–72
Jointing/Rabbeting/Chamfering	3–83
Profiling	3–111
Groove bed	3–130
Planing	3–132
Jointing	3–146
Technical Information	3–167

122110

Edge Jointing Cutters HW two-part version - IMA (BIMA)

Product

Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines IMA model BIMA with glueing device / flush cutting unit 6135
- for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

- cutting edges parallel to cutter axis
- two part version
- countersunk on both sides
- n max = 18,000 min-1

Advantages

Notes

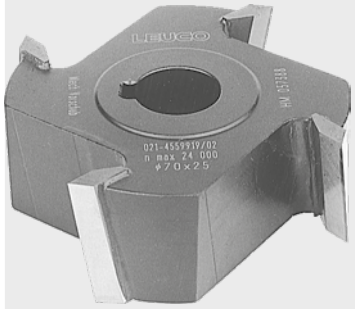
- sense of rotation see drawing

Ø D	B	b	Ø d	Z		Ident-No. [L]	Ident-No. [R]
70	6,0	6.0	30	6	IMA (BIMA)	716658 C	716657 C
[mm]	[mm]	[mm]	[mm]				

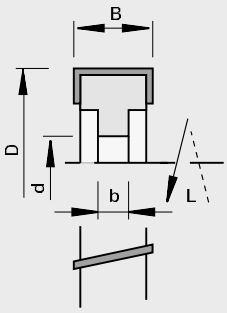
122110

Edge Jointing Cutters HW

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines
- for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

- with shear angle
- n max = 18,000 min-1

Advantages

Notes

- sense of rotation according to VDMA 8849

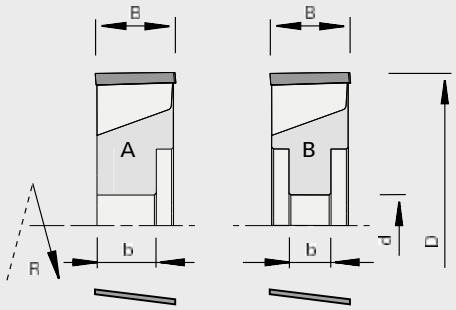
Ø D	B	b	Ø d	Z	DKN	Shear◁		Ident-No. [L]	Ident-No. [R]
70	25	10.5	16	4	5x2,3	10	Homag	180796 C	180795 C
100	25	15	30	4		15		160647 L	160109 C
[mm]	[mm]	[mm]	[mm]		[mm]	[°]			

122112

Edge Jointing Cutters HW - SCM-Stefani

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines SCM-Stefani with ED-System
- for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

- with shear angle
- n max = 18,000 min-1

Advantages

Notes

- sense of rotation according to VDMA 8849

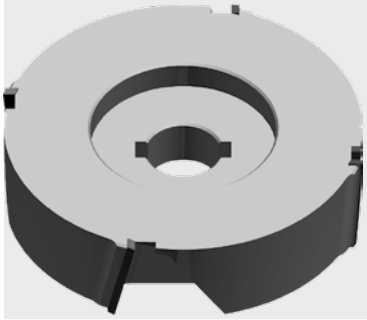
Ø D	B	b	Ø d	Z	DKN	Shear◁	Type		Ident-No. [L]	Ident-No. [R]
70	20	14.5	16	4	5x2,3	12	A	SCM-Stefani-RSK	182985 S	182986 S
75	20	10.5	16	4	5x2,3	12	A	SCM-Stefani-RSP	182989 C	182990 C
[mm]	[mm]	[mm]	[mm]		[mm]	[°]				

Ø D	B	b	Ø d	Z	DKN	Shear◁	Type		Ident-No. [L]	Ident-No. [R]
75	30	11	16	4	5x2,3	12	B	SCM-Stefani-RSP	182991 C	182992 C
80	20	11	16	4	5x2,3	12	B	SCM-Stefani-R	182617 C	182618 C
[mm]	[mm]	[mm]	[mm]		[mm]	[°]				

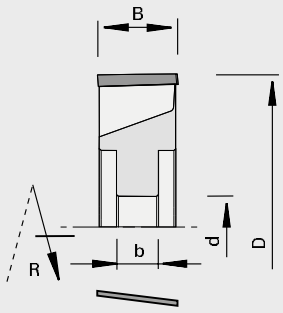
222210

DIAMAX Edge Jointing Cutters DP - SCM-Stefani

Product



Drawing



LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines SCM-Stefani with ED-System
- for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

- with shear angle
- reduced resharpenable area
- n max = 23,800 min -1

Advantages

Notes

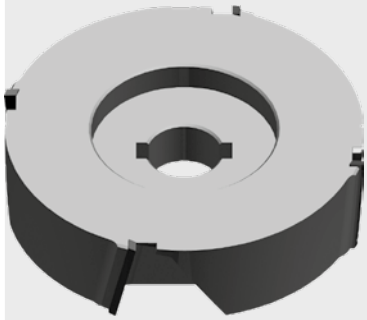
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	DKN	Shear◁		Ident-No. [L]	Ident-No. [R]
80	20	11	16	4	5x2,3	12	SCM-Stefani	182976 C	182975 C
[mm]	[mm]	[mm]	[mm]		[mm]	[°]			

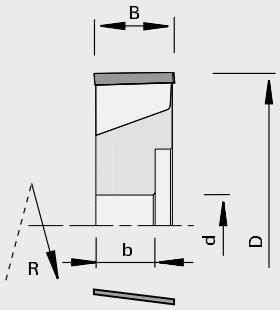
222810

DIAMAX Edge Jointing Cutters CM DP - SCM-Stefani

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines SCM Stefani with ED-System
- for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

- with shear angle
- n max = 24,000 min-1

Advantages

- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes

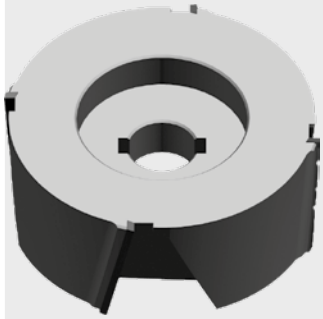
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	DKN	Shear		Ident-No. [L]	Ident-No. [R]
70	10	14.5	16	4	5x2,3	12	SCM-Stefani-RSK	182979 S	182980 S
70	20	14.5	16	4	5x2,3	12	SCM-Stefani-RSK	182977 S	182978 S
75	20	10.5	16	4	5x2,3	12	SCM-Stefani-RSP	182981 S	182982 S
[mm]	[mm]	[mm]	[mm]		[mm]	[°]			

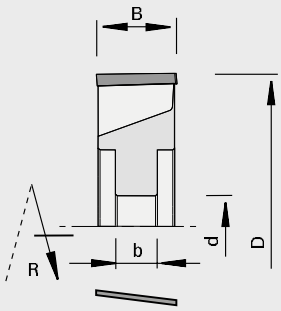
222810

DIAMAX Edge Jointing Cutters CM DP - SCM-Stefani

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines SCM Stefani with ED-System
- for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

- with shear angle
- n max = 24,000 min-1

Advantages

- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes

- sense of rotation according to VDMA 8849

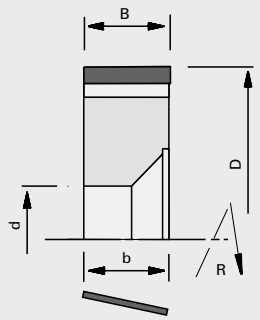
Ø D	B	b	Ø d	Z	DKN	Shear		Ident-No. [L]	Ident-No. [R]
75	30	11	16	4	5x2,3	12	SCM-Stefani-RSP	182983 C	182984 C
[mm]	[mm]	[mm]	[mm]		[mm]	[°]			

122110

Edge Jointing Cutters CM HW - HOLZ-HER

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application
- edge banding machines HOLZ-HER
- for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design
- with shear angle

Advantages
- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes
- sense of rotation according to VDMA 8849

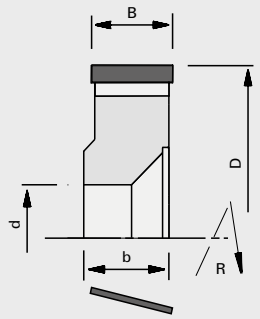
Ø D	B	b	Ø d	Z	DKN	Shear	nmax		Ident-No. [L]	Ident-No. [R]
50	18	17	20	2	5x2,2	10	24000	HOLZ-HER-1828	183113 C	183112 C
[mm]	[mm]	[mm]	[mm]		[mm]	[°]	[min-1]			

122110

Edge Jointing Cutters CM HW- HOLZ-HER 1828 - AirStream-System

Product

Drawing



AIR STREAM

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application
- edge banding machines HOLZ-HER aggregate 1828
- for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design
- with shear angle
- AirStream-System
- ChipMeister

Advantages
- improved chip removal thanks to ChipMeister version and AirStream-System
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- low noise level

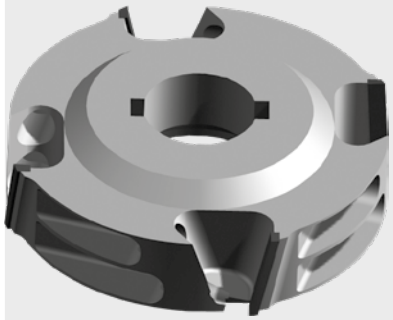
Notes
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	DKN	Shear	nmax		Ident-No. [L]	Ident-No. [R]
70	18	19	20	4	5x2,3	10	18000	HOLZ-HER-1828	184747 L	184746 L
[mm]	[mm]	[mm]	[mm]		[mm]	[°]	[min-1]			

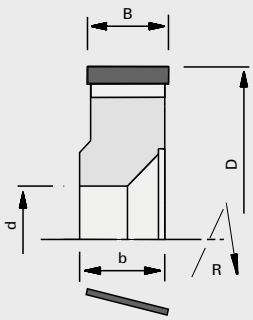
222810

Edge Jointing Cutters CM DP - HOLZ-HER 1828 - AirStream-System

Product



Drawing



AIR STREAM

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines HOLZ-HER aggregate 1828
- for for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

- with shear angle
- polished face and high-finish clearance angle
- AirStream-System
- ChipMeister
- n max = 18,000 min-1

Advantages

- improved chip removal thanks to ChipMeister version and AirStream-System
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- low noise level

Notes

- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	DKN	Shear◁	nmax		Ident-No. [L]	Ident-No. [R]
70	18	19	20	4	5x2,2	12	18000	HOLZ-HER 1828	184749 C	184748 C
70	19	20	20	4	5x2,2	12	18000	HOLZ-HER 1828	184751 C	184750 C
[mm]	[mm]	[mm]	[mm]		[mm]	[°]	[min-1]			

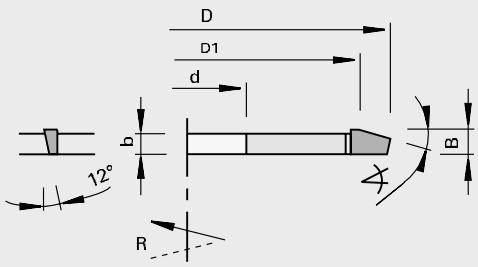
122115

Edge Jointing Cutters HW - Brandt

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- edge banding machines
- for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

- with shear angle
- n = 8,100 - 13,800 min-1

Advantages

Notes

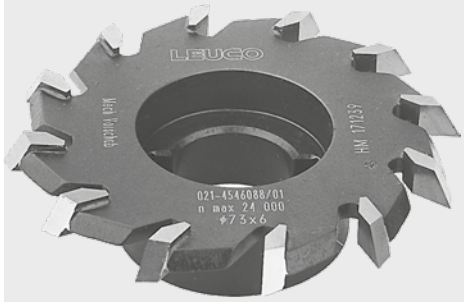
- sense of rotation according to VDMA 8849

Chamfer◁	Ø D1	Ø D	B	b	Ø d	Z	Shear◁		Ident-No. [L]	Ident-No. [R]
15	60	66	4,0	3.0	16	6	12	Brandt	819482 S	819481 S
16		96	5,8	5.0	40	12	12	Brandt	164658 C	164657 C
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[°]			

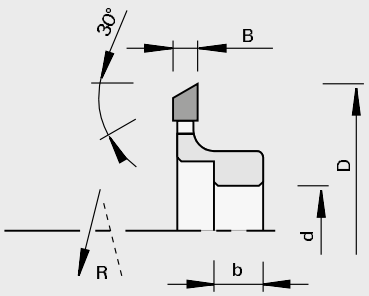
122100

Edge Jointing Cutters HW - IMA

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines
- for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

- cutting edges parallel to cutter axis
- n max = 18,000 min-1

Advantages

Notes

- sense of rotation see drawing

Ø D	B	b	Ø d	Z	DKN		Ident-No. [L]	Ident-No. [R]
73	6,0	12	20	12	6x3,5	IMA	171240 C	171239 C
[mm]	[mm]	[mm]	[mm]		[mm]			

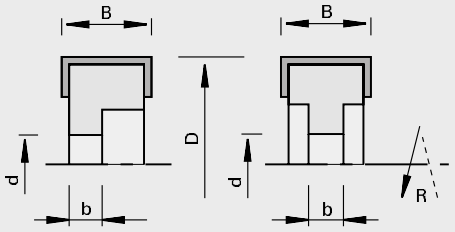
120100

Edge Jointing Cutterheads HW

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines
- for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 05
- n max = 18,000 min-1

Advantages

Notes

- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	DKN		Ident-No. [L]	Ident-No. [R]
50	12	10	16	4	5x2,3	Sudhoff, EBM, Ney		167258 L
50	12	10	16	2	5x2,3	Homag, Homburg		164066 C
50	15	10	16	4	5x2,3	EBM		179139 L
50	15	10	16	2	5x2,3	IMA, Raimann		164067 C
61	12	10	16	3	5x2,3	Homag		167899 C
61	20	11	16	3	5x2,3	Homag		167900 C
70	12	10	16	6	5x2,3	Brandt, Homag		164073 C
70	12	10	16	4	5x2,3	Brandt, Homag		164068 C
70	20	11	16	2	5x2,3	Reich		182077 S
70	20	11	16	4	5x2,3	Homag, HOLZ-HER 1823, Biesse Akron 400 RS 502		164071 L
70	20	20	16	4	5x2,3	Ott		164069 L
70	20	12.5	20	6	2/6x3,5	IMA, SCM-IDM	164134 C	164080 C
70	20	12.5	20	4	6x3,5	Brandt, Homag	164133 C	164079 C
70	20	11	20	4	6x3,5	HOLZ-HER		164070 C
80	40	25	30	4	8x3,3	HOLZ-HER		164072 L
[mm]	[mm]	[mm]	[mm]		[mm]			

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	12	12	1.5	150515	10	003080 L
	15	12	1.5	150515	10	003081 L
	20	12	1.5	150515	10	003082 L
	40	12	1.5	150515	10	164078 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=10	164066, 164067, 164068, 164073, 167258, 167899, 179139	925300	2	164526 L
Pressure Bars	B=18	164069, 164070, 164071, 164079, 164080, 164133, 164134, 167900, 182077	925300	2	164076 L
Pressure Bars	B=39	164072	925300	2	164077 L
Set Screws	M6x10 DIN EN ISO 4028	164066, 164067, 164068, 164073, 167258, 167899, 179139	995161	10	180002 L
Set Screws	M6x12 DIN EN ISO 4028	164069, 164070, 164071, 164072, 164079, 164080, 164133, 164134, 167900, 182077	995161	10	180214 L
Screwdrivers	SW3x100	For all	985730	1	166090 L
Cranked Wrench Keys	SW3 DIN ISO 2936	For all	985730	1	009672 L
	[mm]			[pc.]	

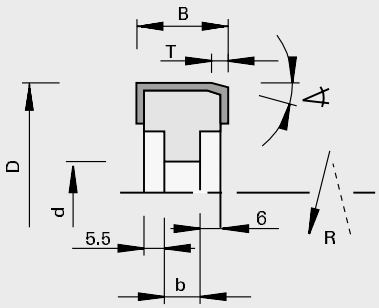
120100

Edge Jointing Cutterheads HW - HOLZ-HER

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines HOLZ-HER
- for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 06
- n max = 18,000 min-1

Advantages

Notes

- sense of rotation according to VDMA 8849

Chamfer◁	Ø D	B	b	Ø d	T	Z		Ident-No. [L]	Ident-No. [R]
15	70	29,5	17	20	5,0	4	HOLZ-HER	164462 C	164463 C
[°]	[mm]	[mm]	[mm]	[mm]	[mm]				

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
for counter-clockwise rotation	29,5	12	1.5	150515	10	160618 L
for clockwise rotation	29,5	12	1.5	150515	10	160118 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	B=30	925300	2	164185 L
Set Screws	M6x12 DIN EN ISO 4028	995161	10	180214 L
Screwdrivers	SW3x100	985730	1	166090 L
	[mm]		[pc.]	

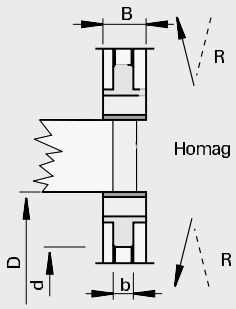
120101

Edge Jointing Cutterheads HW - Homag

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines
- for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 05
- n max = 18,000 min-1

Advantages

Notes

- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	DKN		Ident-No.
70	14,3	10	16	4	5x2,3	Homag	170247 C
70	20	10	16	4	5x2,3	Homag	168510 C
[mm]	[mm]	[mm]	[mm]		[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	14,3	14.3	2.5	150517	10	170248 L
	20	14.3	2.5	150517	10	168509 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x12 T20 D=Ø9,3	995125	10	166709 L
Screwdrivers	T20x100	985730	1	166092 L
	[mm]		[pc.]	

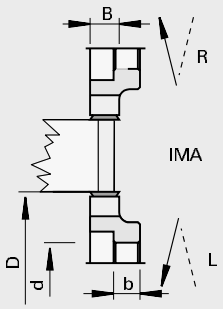
120101

Edge Jointing Cutterheads HW - IMA

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application
- edge banding machines
- for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design
- cutting edges parallel to cutter axis
- cutting material: HW HL Board 05
- n max = 18,000 min-1

Advantages

Notes
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	DKN		Ident-No. [L]	Ident-No. [R]
70	14,3	13	20	4	6x3,5	IMA	172717 S	172718 S
[mm]	[mm]	[mm]	[mm]		[mm]			

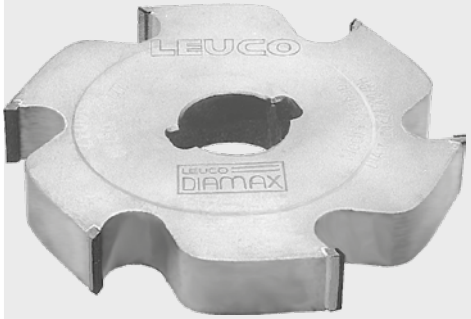
Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	14,3	14.3	2.5	150517	10	170248 L
	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x12 T20 D=Ø9,3	995125	10	166709 L
Screwdrivers	T20x100	985730	1	166092 L
	[mm]		[pc.]	

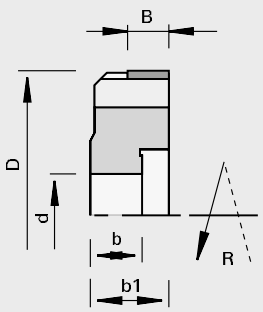
222510

DIAMAX Edge Jointing Cutters DP - Brandt, Homag, SCM-IDM, IMA

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application
- edge banding machines
- for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design
- polished face and high-finish clearance angle
- reduced resharpenable area
- straight cutter axis
- n max = 24,000 min-1

Advantages
- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing

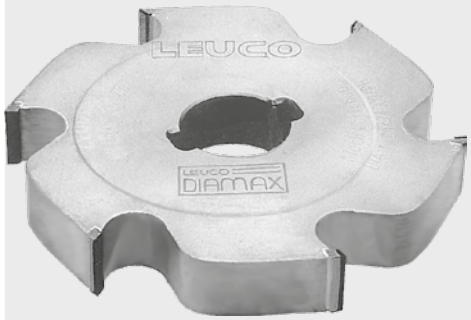
Notes
- sense of rotation according to VDMA 8849

Ø D	B	b	b1	Ø d	Z	DKN		Ident-No. [L]	Ident-No. [R]
70	10	12.5	19	20	4	6x2,8	Brandt, Homag, IMA	175787 C	175786 C
70	10	12.5	19	20	6	6x2,8	Brandt, Homag, IMA	187248 C	187247 C
70	10	12.5	19	20	6	5x2,3	SCM-IDM	175789 C	175788 C
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]			

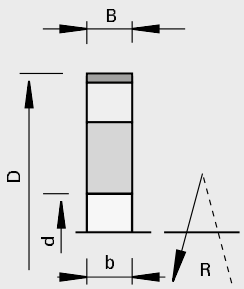
222510

DIAMAX Edge Jointing Cutters DP - Brandt, Homag, Biesse

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
- Biesse Akron 400 RS 502
- for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

- polished face and high-finish clearance angle
- reduced resharpening area 2.0 mm
- straight cutter axis
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing

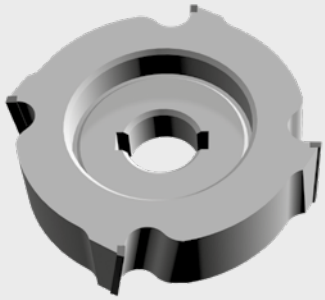
Notes

Ø D	B	b	Ø d	Z	DKN	Ident-No.
70	10	10	16	4	5x2,3	175779 L
70	10	10	16	6	5x2,3	175780 C
[mm]	[mm]	[mm]	[mm]		[mm]	

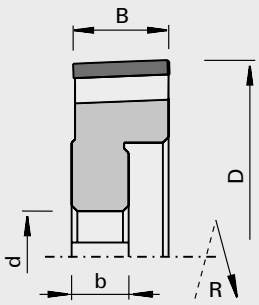
222810

DIAMAX Edge Jointing Cutters CM DP - Ott

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Ott
- for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

- with shear angle
- n max = 24,000 min-1

Advantages

- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes

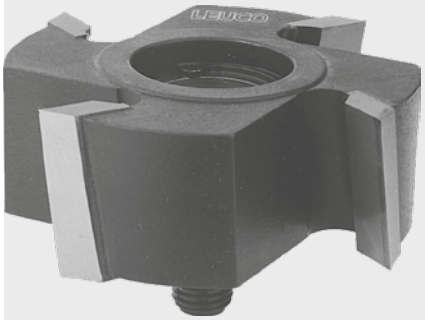
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
70	16,5	10	16	4	5x2,3	185677 C	185678 C
[mm]	[mm]	[mm]	[mm]		[mm]		

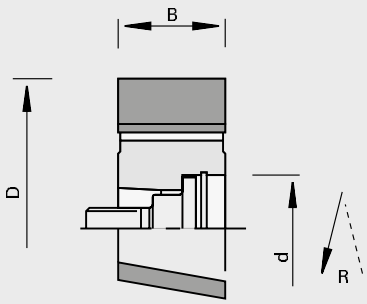
122110

Edge Jointing Cutters HW HSK 25R - Homag, IMA

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application
- edge banding machines Homag, IMA
- for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design
- with shear angle
- n max = 24,000 min-1

Advantages
- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing

Notes
- sense of rotation according to VDMA 8849

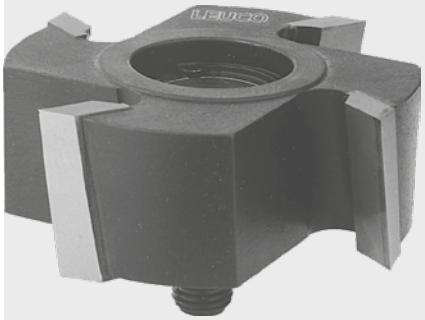
Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
70	35	HSK 25R	4	178035 C	178034 C
[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

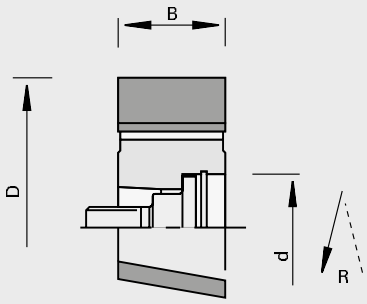
122110

Edge Jointing Cutters CM HW HSK 25R - Homag

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application
- edge banding machines Homag
- for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design
- with shear angle
- n max = 24,000 min-1

Advantages
- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing
- optimized chip removal thanks to internal chip evacuation
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes
- sense of rotation according to VDMA 8849

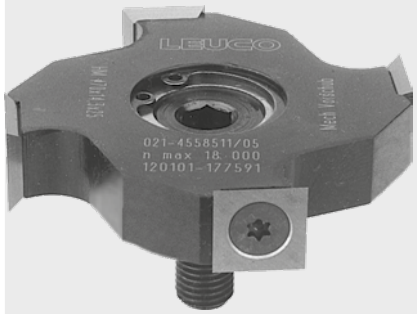
Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
70	25	HSK 25R	4	180765 L	180766 L
[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

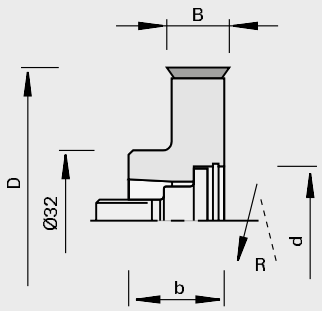
120101

Edge Jointing Cutterheads HW HSK 25R - Homag, IMA

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application
- edge banding machines Homag, IMA
- for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design
- cutting edges parallel to cutter axis, with 4 cutting edges
- cutting material: HW HL Solid 20
- n max = 18,000 min-1

Advantages
- excellent cutting quality thanks to high radial running accuracy and precise tool balancing

Notes
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
70	14,3	23	HSK 25R	4	177592 L	177591 L
[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	14,3	14.3	2.5	150517	10	170248 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x12 T20 D=Ø9,3	995125	10	166709 L
Screwdrivers	T20x100	985730	1	166092 L
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

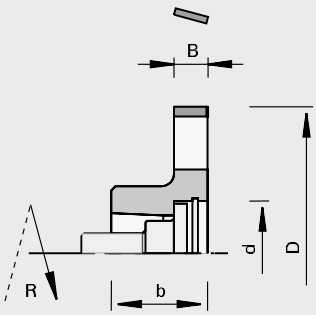
222510

DIAMAX-Edge Jointing Cutters DP HSK 25R - Homag, IMA

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Homag, IMA
- for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

- polished face and high-finish clearance angle
- with shear angle
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing
- low purchase price thanks to large-scale manufacturing

Notes

- not resharpenable because constant (zero) diameter must be maintained
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
70	8,0	23	HSK 25R	4	177651 L	177652 L
70	15	23	HSK 25R	4	177653 L	177654 L
70	8,0	23	HSK 25R	6	180492 L	180493 L
70	15	23	HSK 25R	6	180494 C	180495 C
[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

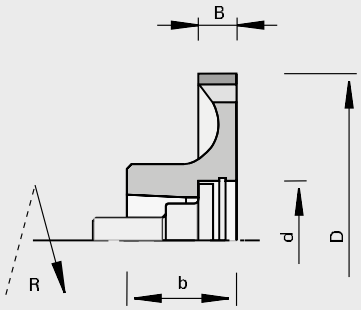
222810

Edge Jointing Cutters DP HSK 25R - Homag, IMA

Product



Drawing



LEUCO topline

LEUCO i-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Homag, aggregate FF and finish milling, IMA
- for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

- polished face and high-finish clearance angle
- with shear angle

Advantages

- highest concentricity
- optimized chip removal thanks to internal chip evacuation
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced
- low purchase price thanks to large-scale manufacturing

Notes

- Z = 4 for feed rate 20 - 30 m/min
- Z = 6 for feed rate 30 - 45 m/min
- Z = 8 for feed rate 45 - 60 m/min
- machines must be equipped with i-System
- constant basic dimensions
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
70	15	23	HSK 25R	4	180934 C	180935 C
70	15	23	HSK 25R	6	180936 C	180937 C
70	8,0	23	HSK 25R	4	181176 L	181177 L
70	8,0	23	HSK 25R	6	181178 L	181179 L
70	8,0	23	HSK 25R	8	181180 C	181181 C
[mm]	[mm]	[mm]	[mm]			

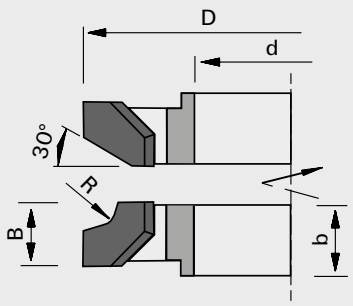
Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

122110

Edge Rounding / Chamfering Cutters HW one-part version - IMA (BIMA)

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines IMA model BIMA with glueing device / flush cutting unit 6135
- for flush-cutting and rounding or chamfering of solid wood, veneer and plastic edge bands

Design

- with shear angle
- one part version
- n max = 18,000 min-1

Advantages

Notes

- sense of rotation according to VDMA 8849

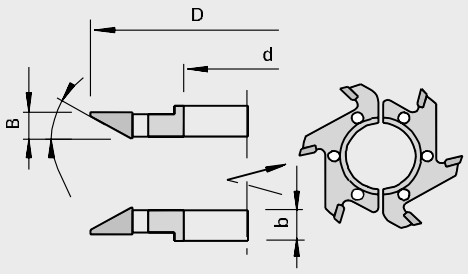
R	Chamfer◁	Ø D	B	b	Ø d	Z		Ident-No. [L]	Ident-No. [R]
1,0		65	10	10.7	30	6	IMA (BIMA)	192419 L	192418 L
1,3		65	10	10.7	30	6	IMA (BIMA)	192573 C	192574 C
1,5		65	10	10.7	30	6	IMA (BIMA)	184351 L	184352 L
2,0		65	10	10.7	30	6	IMA (BIMA)	184353 L	184354 L
2,5		65	10	10.7	30	6	IMA (BIMA)	192575 C	192576 C
3,0		65	10	10.7	30	6	IMA (BIMA)	184355 L	184356 L
	2	65	10	10.7	30	6	IMA (BIMA)	192577 S	192578 S
	15	65	10	10.7	30	6	IMA (BIMA)	192579 C	192580 C
	30	65	10	10.7	30	6	IMA (BIMA)	184357 C	184358 C
	45	65	10	10.7	30	6	IMA (BIMA)	192581 S	192582 S
[mm]	[°]	[mm]	[mm]	[mm]	[mm]				

122110

Edge Chamfering Cutters HW two-part version - IMA (BIMA)

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines IMA model BIMA with glueing device / flush cutting unit 6135
- for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

- with shear angle
- two part version
- n max = 18,000 min-1

Advantages

Notes

- sense of rotation see drawing

Chamfer◁	Ø D	B	b	Ø d	Z		Ident-No. [L]	Ident-No. [R]
30	70	9,0	9.0	30	6	IMA (BIMA)	180164 L	180163 L
[°]	[mm]	[mm]	[mm]	[mm]				

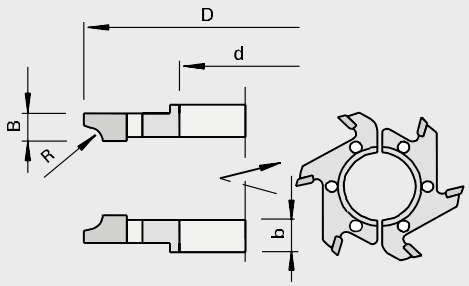
122110

Edge Rounding Cutters HW two-part version - IMA (BIMA)

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines IMA model BIMA with glueing device / flush cutting unit 6135
- for rounding and flush-cutting of solid wood, veneer and plastic edge bands

Design

- two part version
- with shear angle
- n max = 18,000 min-1

Advantages

Notes

- sense of rotation see drawing

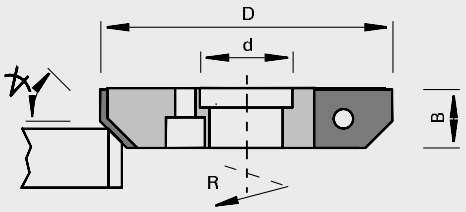
R	Ø D	B	b	Ø d	Z		Ident-No. [L]	Ident-No. [R]
2,0	70	6,0	6.0	30	6	IMA (BIMA)	180155 C	180156 C
2,0	70	9,0	9.0	30	6	IMA (BIMA)	180157 L	180158 L
3,0	70	9,0	9.0	30	6	IMA (BIMA)	180167 C	180168 C
[mm]	[mm]	[mm]	[mm]	[mm]				

120102

Edge Chamfering Cutterheads HW for machining centers - Homag

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- machining center Homag
- for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 05
- n max = 18,000 min-1

Advantages

Notes

- delivery with 3 additional profile knives
- sense of rotation according to VDMA 8849

Chamfer∢	Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
5	60	12	19	3	179207 C	179206 C
15	60	12	19	3	178634 C	178633 C
30	60	13,5	19	3	178632 C	178631 L
45	60	12	19	3	178630 C	178629 C
[°]	[mm]	[mm]	[mm]			

Knives	Chamfer∢	B	H	S	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	5	12	16	2.0	151586	10	179174 C	179173 C
	15	11,7	16	2.0	151586	10	177042 L	177045 L
	30	13,5	16	2.0	151586	10	177043 L	177046 L
	45	12,2	16	2.0	151586	10	177822 L	177823 L
	[°]	[mm]	[mm]	[mm]		[pc.]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	11x10x7	925300	2	178759 L
Magnetic Stops	0,0	997800	1	016613 L
Set Screws	M6x12 DIN EN ISO 4028	995161	10	180214 L
Screwdrivers	SW3x100	985730	1	166090 L
	[mm]		[pc.]	

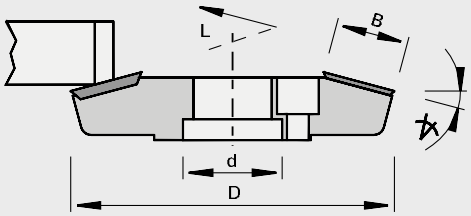
120101

Edge Chamfering Cutterheads HW for machining centers (particularly for thin edge bands) - Homag

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- machining center Homag
- for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

- cutting edges parallel to cutter axis
- cutting material: HW
- n max = 18,000 min-1

Advantages

Notes

- especially for thin edge bands
- sense of rotation according to VDMA 8849

Chamfer∢	Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
5	78	11,5	19	3	186577 C	186576 C
15	62	14	19	3	178640 L	178639 C
[°]	[mm]	[mm]	[mm]			

Knives	B	H	S	For Ident-No.	Class-No.	PU	Ident-No.
Spurs	14	14	2.0	178639, 178640	150558	10	003079 L
Triangular Spur	22	19.05	2.0	186576, 186577	150557	10	180779 L
	[mm]	[mm]	[mm]			[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Countersunk Screws	M5x6,8 T15 D=Ø9,4	186576, 186577	995125	10	180839 L
Countersunk Screws	M5x6 T20 D=Ø9,3	178639, 178640	995125	10	176199 L
Screwdrivers	T20x100	178639, 178640	985730	1	166092 L
	[mm]			[pc.]	

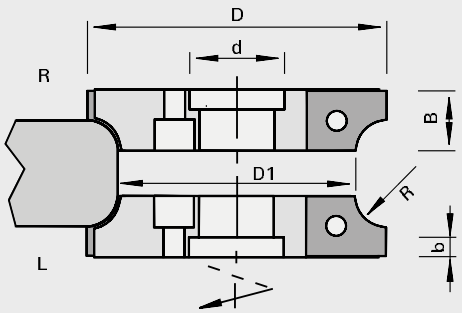
120102

Edge Rounding Cutterheads HW for machining centers - Homag

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- machining center Homag
- for rounding of solid wood, veneer and plastic edge bands

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 06
- n max = 18,000 min-1

Advantages

Notes

- same cutterhead body for R 1 - 3 mm; R 4 - 5 mm
- included in delivery: 3 additional spare knives
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	59	50	15	4.0	19	3	185197 O	185198 O
1,5	59	50	15	4.0	19	3	185199 O	185200 O
2,0	59	50	15	4.0	19	3	180749 O	180748 O
2,5	59	50	15	4.0	19	3	185201 C	185202 C
3,0	59	50	15	4.0	19	3	180751 O	180750 O
4,0	63	50	15	4.0	19	3	178795 S	178794 C
5,0	63	50	15	4.0	19	3	178797 C	178796 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

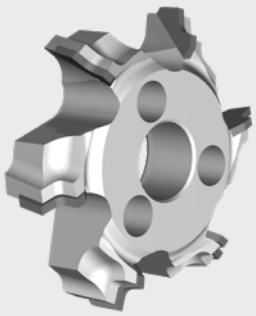
Knives	R	B	H	S	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	1,0	13	15	2.0	151545	10	180722 L	180721 L
	1,5	13	15	2.0	151545	10	181954 L	181953 L
	2,0	13	15	2.0	151545	10	181956 L	181955 L
	2,5	13	15	2.0	151545	10	180728 C	180727 C
	4,0	14	17	2.0	151546	10	177036 C	177040 C
	5,0	15	17	2.0	151545	10	177037 L	177041 C
	[mm]	[mm]	[mm]	[mm]		[pc.]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	11x10x7	925300	2	178759 L
Set Screws	M6x12 DIN EN ISO 4028	995161	10	180214 L
Screwdrivers	SW3x100	985730	1	166090 L
Magnetic Stops	1,0	997800	1	166094 L
Magnetic Stops	0,0	997800	1	016613 L
	[mm]		[pc.]	

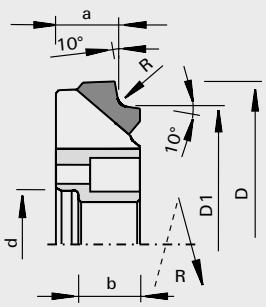
222582

DIAMAX high power Edge Rounding Cutters DP for machining center - Homag

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application
- machining center Homag
- for rounding of solid wood, veneer and plastic edge bands

Design
- polished face
- high-finish clearance angle
- with shear angle
- very high balance quality
- Z6 design
- n max = 24,000 min-1

Advantages
- excellent cutting quality thanks to excellent balance quality and high number of teeth
- possibility to do without scraper knife processing

Notes
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
1,0	59	50	11	11	19	6	3/4,2/25	185977 C	185978 C
1,5	59	50	11	11	19	6	3/4,2/25	185979 C	185980 C
2,0	59	50	11	11	19	6	3/4,2/25	185981 C	185982 C
3,0	59	50	11	11	19	6	3/4,2/25	185983 C	185984 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]				

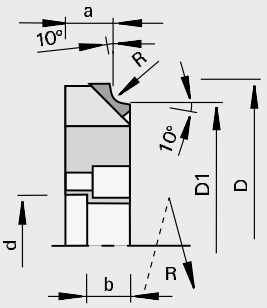
222582

DIAMAX Edge Rounding Cutters DP - Homag

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application
- machining center Homag
- for rounding of solid wood, veneer and plastic edge bands

Design
- polished face
- high-finish clearance angle
- with shear angle
- n max = 24,000 min-1

Advantages
- optimum cutting quality

Notes
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

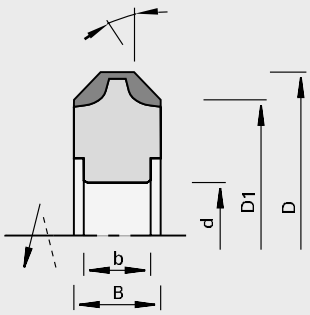
R	Ø D	Ø D1	a	b	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
1,0	58	50	11	10.5	19	3	3/4,2/25	179414 C	179415 C
2,0	57	50	11	9.5	19	3	3/4,2/25	179416 L	179417 L
3,0	59	50	11	10.5	19	3	3/4,2/25	179418 C	179419 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]				

120102

Edge Chamfering Cutterheads HW

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines
- for chamfering of solid wood, veneer and plastic edge bands

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 05
- n max = 18,000 min-1

Advantages

Notes

- for clockwise and counter-clockwise rotation
- sense of rotation according to VDMA 8849

Chamfer◁	Ø D	Ø D1	B	b	Ø d	Z	DKN		Ident-No.
45	57	50	12	12	16	2	5x2,3	HOLZ-HER	171189 O
45	62	50	16	10	16	2	5x2,3	HOLZ-HER	173379 C
45	73	61	16	11	16	3	5x2,3	Homag	173380 S
45	82	70	16	11	16	4	5x2,3	Brandt	172728 O
45	73	61	16	11	20	3	6x3,5	HOLZ-HER	173381 S
45	82	70	16	11	20	4	6x3,5	IMA, Wilmsmeyer	172729 S
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Knives	Chamfer◁	B	H	S	Class-No.	PU	Ident-No.
for Ø D = 57	45	12	12	1.5	151545	10	171190 L
for Ø D = 62/73/82	45	16	17.5	2.0	151545	10	169292 L
	[°]	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=15,6	173379, 173380, 173381	925300	2	169246 L
Pressure Bars	B=15,6	172728, 172729	925300	2	163488 L
Set Screws	M6x12 DIN EN ISO 4028	For all	995161	10	180214 L
Magnetic Stops	0,0	For all	997800	1	016613 L
Cranked Wrench Keys	SW2,5 DIN ISO 2936	172728, 172729, 173379, 173380, 173381	985730	1	009671 L
Cranked Wrench Keys	SW3 DIN ISO 2936	For all	985730	1	009672 L
	[mm]			[pc.]	

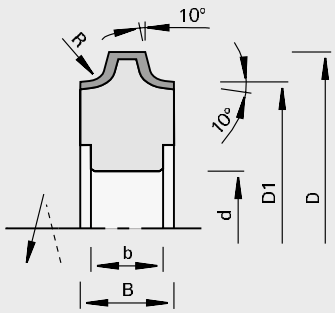
120102

Edge Rounding Cutterheads HW

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines
- for rounding of solid wood, veneer and plastic edge bands

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 05
- n max = 18,000 min-1

Advantages

Notes

- for clockwise and counter-clockwise rotation
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	B	b	Ø d	Z	DKN		Ident-No.
2,0	57	50	12	12	16	2	5x2,3	HOLZ-HER	170338 O
3,0	57	50	12	12	16	2	5x2,3	HOLZ-HER	170339 S
2,0	58	50	12	10	16	4	5x2,3	Brandt	177030 L
3,0	58	50	12	10	16	4	5x2,3	Brandt	177031 O
2,0	62	50	16	10	16	2	5x2,3	HOLZ-HER	179997 C
3,0	62	50	16	10	16	2	5x2,3	HOLZ-HER	169241 S
5,0	62	50	16	10	16	2	5x2,3	HOLZ-HER	169243 S
2,0	73	61	16	11	16	3	5x2,3	Homag, Ott	171128 L
3,0	73	61	16	11	16	3	5x2,3	Homag, Ott	171129 O
4,0	73	61	16	11	16	3	5x2,3	Homag, Ott	171130 S
5,0	73	61	16	11	16	3	5x2,3	Homag, Ott	171131 S
6,0	81	61	24	11	16	3	5x2,3	Homag, Ott	170254 S
8,0	81	61	24	11	16	3	5x2,3	Homag, Ott	170256 S
9,0	81	61	24	11	16	3	5x2,3	Homag, Ott	170257 S
2,0	78	70	16	11	16	4	5x2,3	Brandt	182086 O
2,0	82	70	16	11	16	4	5x2,3	Brandt	170192 O
3,0	82	70	16	11	16	4	5x2,3	Brandt	170193 S
4,0	82	70	16	11	16	4	5x2,3	Brandt	170194 S
5,0	82	70	16	11	16	4	5x2,3	Brandt	170195 S
2,0	73	61	16	11	20	3	6x2,8	HOLZ-HER	171132 S
3,0	73	61	16	11	20	3	6x2,8	HOLZ-HER	171133 C
4,0	73	61	16	11	20	3	6x2,8	HOLZ-HER	171134 C
5,0	73	61	16	11	20	3	6x2,8	HOLZ-HER	171135 C
2,0	82	70	16	11	20	4	6x2,8	IMA, Wilmsmeyer	166882 S
3,0	82	70	16	11	20	4	6x2,8	IMA, Wilmsmeyer	166881 S
4,0	82	70	16	11	20	4	6x2,8	IMA, Wilmsmeyer	166880 S
5,0	82	70	16	11	20	4	6x2,8	IMA, Wilmsmeyer	166879 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Knives	R	B	H	S	Class-No.	PU	Ident-No.
for Ø D = 57	2,0	12	12	1.5	151545	10	170340 L
for Ø D = 57	3,0	12	12	1.5	151545	10	170341 L
for Ø D = 58	2,0	12	13	2.0	151545	10	177033 L
for Ø D = 58	3,0	12	13	2.0	151545	10	177032 L
for Ø D = 78	2,0	16	15.5	2.0	151545	10	182087 L
for Ø D = 81	6,0	24	22	2.0	151545	10	170258 L
for Ø D = 81	8,0	24	22	2.0	151545	10	170260 L
for Ø D = 81	9,0	24	22	2.0	151545	10	170261 S
for Ø D = 62/73/82	1,0	16	17.5	2.0	151545	10	186745 L
for Ø D = 62/73/82	1,5	16	17.5	2.0	151545	10	176583 L
for Ø D = 62/73/82	2,0	16	17.5	2.0	151545	10	163489 L
for Ø D = 62/73/82	3,0	16	17.5	2.0	151545	10	163490 L
	[mm]	[mm]	[mm]	[mm]		[pc.]	

Knives	R	B	H	S	Class-No.	PU	Ident-No.
for Ø D = 62/73/82	4,0	16	17.5	2.0	151545	10	163491 L
for Ø D = 62/73/82	5,0	16	17.5	2.0	151545	10	163492 L
	[mm]	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=10,5	177030, 177031	925300	2	175640 L
Pressure Bars	B=15,6	169241, 169243, 171128, 171129, 171130, 171131, 171132, 171133, 171134, 171135, 179997	925300	2	169246 L
Pressure Bars	B=15,6	166879, 166880, 166881, 166882, 170192, 170193, 170194, 170195, 182086	925300	2	163488 L
Pressure Bars	24x14,5x7	170254, 170256, 170257	925300	2	170262 L
Set Screws	M5x12 DIN EN ISO 4028	177030, 177031	995161	10	050565 L
Set Screws	M6x12 DIN EN ISO 4028	166879, 166880, 166881, 166882, 169241, 169243, 170192, 170193, 170194, 170195, 170338, 170339, 171128, 171129, 171130, 171131, 171132, 171133, 171134, 171135, 179997, 182086	995161	10	180214 L
Set Screws	M8x12 DIN EN ISO 4028	170254, 170256, 170257	995161	10	180001 L
Magnetic Stops	0,0	For all	997800	1	016613 L
Cranked Wrench Keys	SW2,5 DIN ISO 2936	For all	985730	1	009671 L
Cranked Wrench Keys	SW3 DIN ISO 2936	For all	985730	1	009672 L
	[mm]			[pc.]	

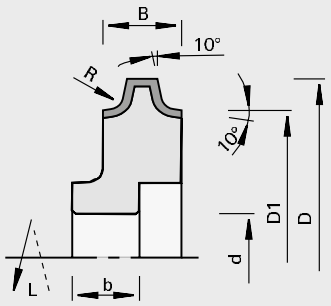
120102

Edge Rounding Cutterheads HW - IMA

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines IMA
- for rounding of solid wood, veneer and plastic edge bands

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 05
- n max = 18,000 min-1

Advantages

- same cutter head body for radius 1 - 5 mm and chamfer

Notes

- sense of rotation see drawing

R	Ø D	Ø D1	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	82	70	16	13	20	4	6x3,5	168373 C	168374 S
3,0	82	70	16	13	20	4	6x3,5	168353 C	168354 C
4,0	82	70	16	13	20	4	6x3,5	168375 S	168376 S
5,0	82	70	16	13	20	4	6x3,5	168377 S	168378 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

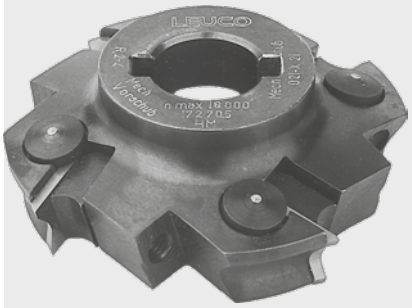
Knives	Chamfer∢	R	B	H	S	Class-No.	PU	Ident-No.
Chamfering Knives	45		16	17.5	2.0	151545	10	169292 L
Radius Knives		1,0	16	17.5	2.0	151545	10	186745 L
Radius Knives		2,0	16	17.5	2.0	151545	10	163489 L
Radius Knives		3,0	16	17.5	2.0	151545	10	163490 L
Radius Knives		4,0	16	17.5	2.0	151545	10	163491 L
Radius Knives		5,0	16	17.5	2.0	151545	10	163492 L
	[°]	[mm]	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	B=15,6	925300	2	163488 L
Set Screws	M6x12 DIN EN ISO 4028	995161	10	180214 L
Cranked Wrench Keys	SW3 DIN ISO 2936	985730	1	009672 L
	[mm]		[pc.]	

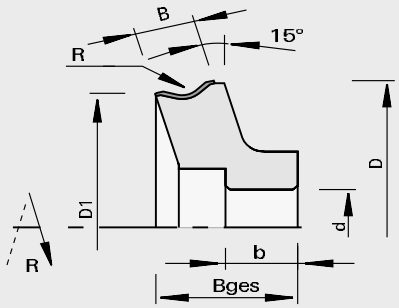
120102

Edge Rounding Cutters HW (cranked) - IMA

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines IMA
- for rounding of solid wood, veneer and plastic edge bands

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 05
- n max = 18,000 min-1

Advantages

Notes

- same cutterhead body for R 2 - 4 mm
- sense of rotation see drawing

R	Ø D	Ø D1	B	b	b1	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
4,0	77.6	70	13	13	27.9	20	4	6x3,5	172712 S	172711 S
3,0	77.6	70	13	13	27.9	20	4	6x3,5	172710 S	172709 S
2,0	77.6	70	13	13	27.9	20	4	6x3,5	172708 S	172707 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Knives	R	B	H	S	Class-No.	PU	Ident-No.
	2,0	13	16	2.0	151555	10	172713 L
	3,0	13	16	2.0	151555	10	172714 C
	4,0	13	16	2.0	151555	10	172715 C
	[mm]	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M6x12 DIN EN ISO 4028	995161	10	180214 L
Cranked Wrench Keys	SW3 DIN ISO 2936	985730	1	009672 L
	[mm]		[pc.]	

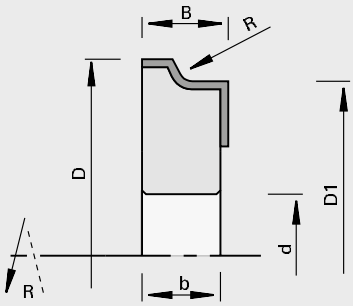
120112

Edge Rounding Cutterheads HW - Brandt

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines Brandt
- for rounding and flush-cutting of solid wood, veneer and plastic edge bands

Design

- with shear angle
- cutting material: HW HL Board 05
- n max = 18,000 min-1

Advantages

- optimum cutting quality on solid wood edges thanks to cutting edges with shear angle

Notes

- same cutterhead body for R 2 - 3 mm
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	78	70	18,5	10	16	4	5x2,3	180441 O	180440 O
3,0	78	70	18,5	10	16	4	5x2,3	173389 O	173388 O
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

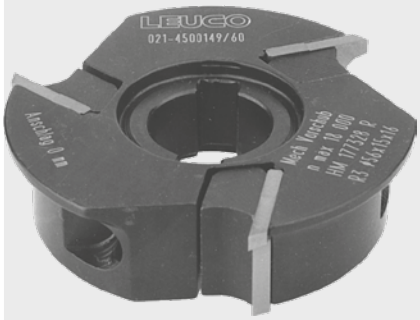
Knives	R	B	H	S	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	2,0	19,6	15.2	2.0	151545	10	173817 L	173816 L
	3,0	19,6	15.2	2.0	151545	10	173393 L	173392 L
	[mm]	[mm]	[mm]	[mm]		[pc.]		

Spare parts	Dimension		Class-No.	PU	Ident-No.
Pressure Bars	B=17	For all	925300	2	167971 L
Set Screws	M6x10 DIN EN ISO 4028	For all	995161	10	180002 L
Cranked Wrench Keys	SW3 DIN ISO 2936	For all	985730	1	009672 L
Magnetic Stops	0,0	For all	997800	1	016613 L
	[mm]			[pc.]	

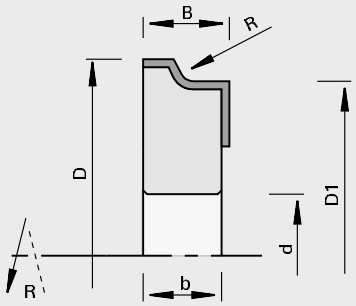
120102

Edge Rounding Cutterheads HW - Brandt, EBM, HOLZ-HER 1942M

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines Brandt, EBM, HOLZ-HER 1942M
- for rounding and flush-cutting of solid wood, veneer and plastic edge bands

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 05
- n max = 18,000 min-1

Advantages

Notes

- same cutterhead body for R 2 - 3 mm
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	56	50	15	11	16	3	5x2,3	179995 O	179996 O
2,5	56	50	15	11	16	3	5x2,3	177325 O	177326 O
3,0	56	50	15	11	16	3	5x2,3	177327 C	177328 C
2,0	56	50	12	11	16	4	5x2,3	172138 L	172137 L
3,0	56	50	12	11	16	4	5x2,3	172140 C	172139 C
2,0	56	50	16	11	16	4	5x2,3	178215 C	178214 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

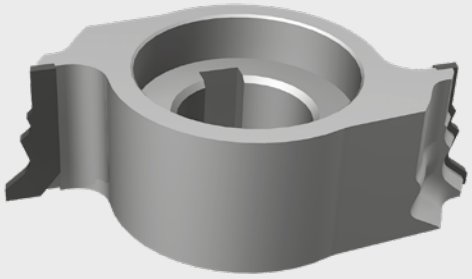
Knives	R	B	H	S	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	2,0	12	14.5	2.0	151545	10	172142 L	172141 L
	3,0	12	14.5	2.0	151545	10	172144 L	172143 L
	2,0	15	14.5	2.0	151545	10	177317 L	177318 L
	2,5	15	14.5	2.0	151545	10	177319 L	177320 L
	3,0	15	14.5	2.0	151545	10	177321 L	177322 L
	2,0	16,1	14	2.0	151546	10	178219 L	178218 L
	[mm]	[mm]	[mm]	[mm]		[pc.]		

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=10	172137, 172138, 172139, 172140	925300	2	171221 L
Pressure Bars	B=14	177325, 177326, 177327, 177328, 179995, 179996	925300	2	50774928 L
Pressure Bars	B=15	178214, 178215	925300	2	178213 S
Set Screws	M5x10 DIN EN ISO 4026	172137, 172138, 172139, 172140	995161	10	180028 L
Set Screws	M6x12 DIN EN ISO 4028	177325, 177326, 177327, 177328, 178214, 178215, 179995, 179996	995161	10	180214 L
Magnetic Stops	0,0	For all	997800	1	016613 L
Cranked Wrench Keys	SW2,5 DIN ISO 2936	172137, 172138, 172139, 172140	985730	1	009671 L
Cranked Wrench Keys	SW3 DIN ISO 2936	177325, 177326, 177327, 177328, 178214, 178215, 179995, 179996	985730	1	009672 L
	[mm]			[pc.]	

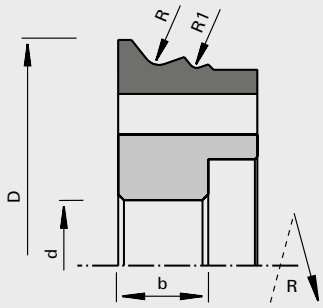
222212

DIAMAX Multi-profile edge trimming cutter DP - EBM

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- EBM edge banding machine with dual-profile technology
- for rounding of soft-wood, hard-wood, veneer and plastic edge bands

Design

- polished face and high-finish clearance angle
- n max = 24,000 min-1

Advantages

- Excellent cutting quality thanks to high concentric accuracy and precise tool balancing
- Combination of up to 2 different profiles in one tool

Notes

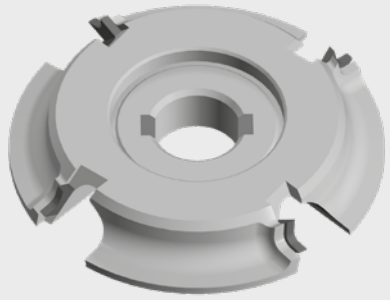
- not for resharpening
- sense of rotation according to VDMA 8849

R	R1	Ø D	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	1.0	56	11	16	2	8x3,3	187129 L	187130 L
3,0	2.0	56	11	16	2	8x3,3	187131 C	187132 C
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

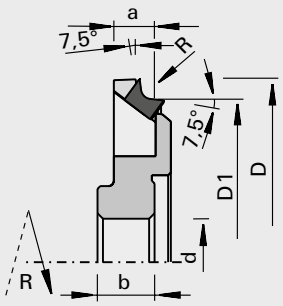
222882

DIAMAX Edge Rounding Cutters CM DP - Ott

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Ott
- for rounding and flush-cutting of solid wood, veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle
- with shear angle
- n max = 24,000 min-1

Advantages

- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes

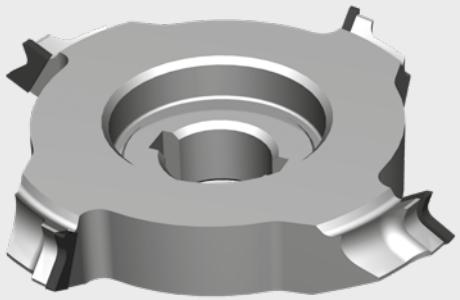
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	69	61	9.72	10.5	16	4	5x2,3	185681 C	185682 C
2,0	69	61	9.72	10.5	16	4	5x2,3	185679 L	185680 L
3,0	69	61	9.72	10.5	16	4	5x2,3	185683 C	185684 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

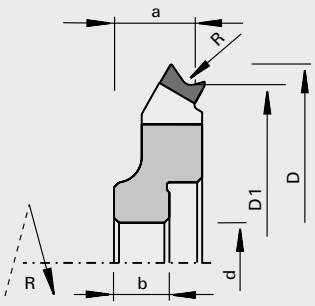
222582

DIAMAX Edge Rounding Cutters DP - Ott HFR 06.2

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application
- edge banding machines Ott HFR 06.2
- for rounding and flush-cutting of solid wood, veneer and plastic edge bands

Design
- polished face
- high-finish clearance angle
- without shear angle
- n max = 23,800 min-1

Advantages
- optimum cutting quality

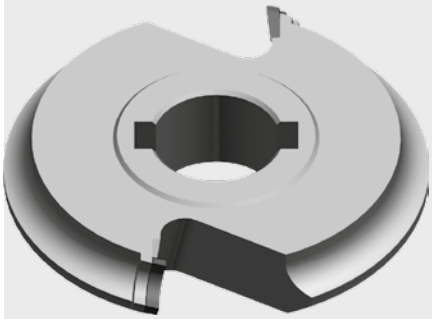
Notes
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	80	72	15.3	11	16	4	5x2,3	185685 C	185686 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

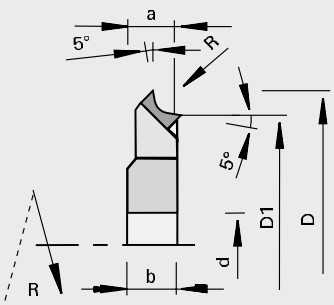
222582

DIAMAX Edge Rounding Cutters DP - HOLZ-HER

Product



Drawing



LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application
- edge banding machines HOLZ-HER
- for rounding of solid wood, veneer and plastic edge bands

Design
- with shear angle
- n max = 24,000 min-1

Advantages

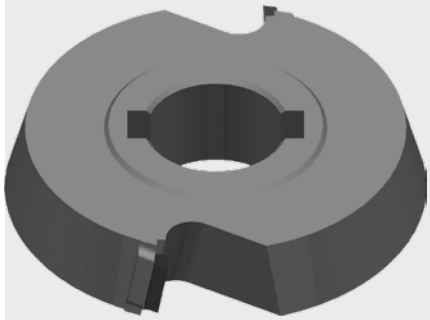
Notes
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	57	50	8.5	12.5	16	2	5x2,3	182141 L	182142 L
2,5	57	50	8.5	12.5	16	2	5x2,3	182143 C	182144 C
3,0	57	50	8.5	12.5	16	2	5x2,3	182145 C	182146 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

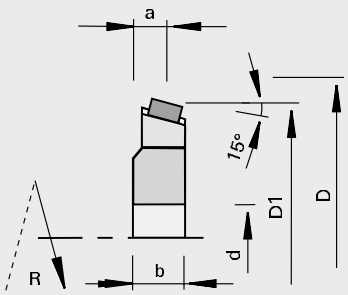
222212

DIAMAX Edge Chamfering Cutters DP - HOLZ-HER

Product



Drawing



LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application
- edge banding machines HOLZ-HER
- for chamfering of solid wood, veneer and plastic edge bands

Design
- with shear angle
- n max = 24,000 min-1

Advantages

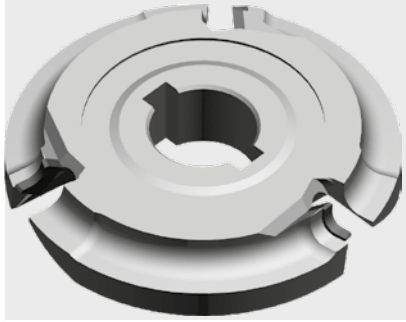
Notes
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

Chamfer∢	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
15	52	50	8.5	12.5	16	2	5x2,3	182147 C	182148 C
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

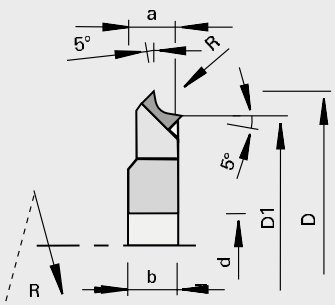
222882

DIAMAX Edge Rounding Cutters CM DP - HOLZ-HER 1832 / FF301

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application
- edge banding machines HOLZ-HER aggregate 1832 / FF301
- for rounding of solid wood, veneer and plastic edge bands

Design
- with shear angle
- polished face and high-finish clearance angle
- n max = 24,000 min-1

Advantages
- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

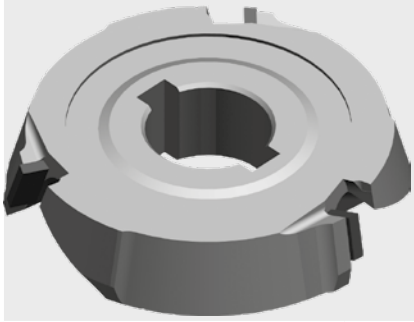
Notes
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No.
1,0	58.7	50	8.5	12	16	3	5x2,3	187137 C
1,3	58.7	50	8.5	12	16	3	5x2,3	187138 L
1,5	58.7	50	8.5	12	16	3	5x2,3	187141 C
2,0	58.7	50	8.5	12	16	3	5x2,3	187135 L
2,5	58.7	50	8.5	12	16	3	5x2,3	187139 C
3,0	58.7	50	8.5	12	16	3	5x2,3	187140 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

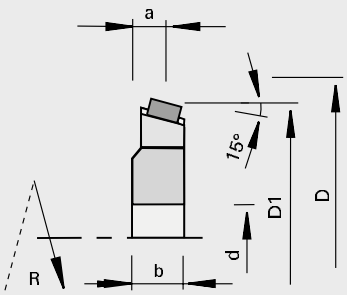
222812

DIAMAX Edge Chamfering Cutters CM DP - HOLZ-HER 1832 / FF301

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines HOLZ-HER aggregate 1832 / FF301
- for chamfering of solid wood, veneer and plastic edge bands

Design

- with shear angle
- polished face and high-finish clearance angle
- resharpenable area 3.5 mm
- n max = 24.000 min-1

Advantages

- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes

- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

Cham-fer◁	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No.
15	53	50	10	12	16	3	5x2,3	182687 S
45	56	50	10	12	16	3	5x2,3	182688 C
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

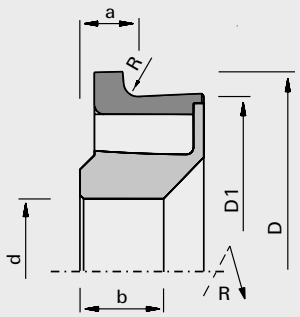
222882

DIAMAX Edge Rounding Cutters DP - HOLZ-HER 1827 - AirStream-System

Product



Drawing



AIR STREAM

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines HOLZ-HER aggregate 1827
- for rounding of solid wood, veneer and plastic edge bands

Design

- AirStream-System
- with shear angle
- polished face and high-finish clearance angle
- n max = 24,000 min-1

Advantages

- considerably increased chip caption degree thanks to AirStream-System
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- very low noise level

Notes

- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849
- not for resharpening

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	57	50	8.0	11.5	20	2	5x2,3	185440 C	185441 C
1,3	56	50	8.0	11.5	20	2	5x2,3	185434 L	185435 L
2,0	57	50	8.0	11.5	20	2	5x2,3	185436 L	185437 L
3,0	57	50	8.0	11.5	20	2	5x2,3	185438 L	185439 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

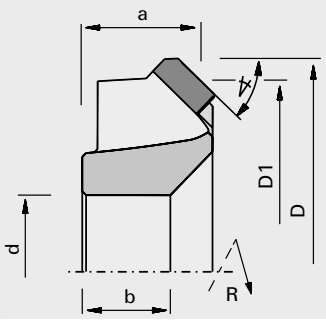
222812

DIAMAX Edge Chamfering Cutters DP - HOLZ-HER 1827 - AirStream-System

Product



Drawing



AIR STREAM

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines HOLZ-HER aggregate 1827
- for chamfering of solid wood, veneer and plastic edge bands

Design

- AirStream-System
- with shear angle
- polished face and high-finish clearance angle
- n max = 24,000 min-1

Advantages

- considerably increased chip caption degree thanks to AirStream-System
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- very low noise level

Notes

- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849
- not for resharpening

Chamfer∢	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
45	57	50	16	11.5	20	2	5x2,3	185442 C	185443 C
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

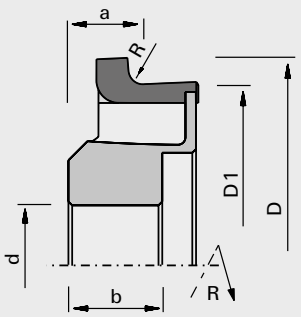
222882

DIAMAX Edge Rounding Cutters DP - HOLZ-HER FR201 - AirStream-System

Product



Drawing



AIR STREAM

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines HOLZ-HER aggregate FR201 (1825M)
- for rounding of solid wood, veneer and plastic edge bands

Design

- AirStream-System
- with shear angle
- polished face and high-finish clearance angle
- n max = 24,000 min-1

Advantages

- considerably increased chip caption degree thanks to AirStream-System
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- very low noise level

Notes

- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849
- not for resharpening

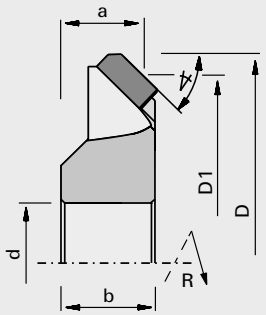
R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	57	50	10	12.5	16	2	5x2,3	185430 C	185431 C
1,3	57	50	10	12.5	16	2	5x2,3	185424 L	185425 L
2,0	57	50	10	12.5	16	2	5x2,3	185426 L	185427 L
3,0	57	50	10	12.5	16	2	5x2,3	185428 L	185429 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

222812

DIAMAX Edge Chamfering Cutters DP - HOLZ-HER FR201 - AirStream-System

Product

Drawing



AIR STREAM

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines HOLZ-HER aggregate FR201 (1825M)
- for chamfering of solid wood, veneer and plastic edge bands

Design

- AirStream-System
- with shear angle
- polished face and high-finish clearance angle
- n max = 24,000 min-1

Advantages

- considerably increased chip caption degree thanks to AirStream-System
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- very low noise level

Notes

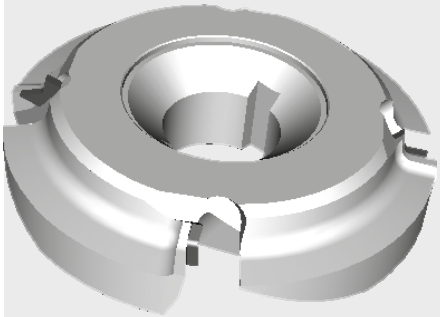
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849
- not for resharpening

Chamfer	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
45	57	50	10	12.5	16	2	5x2,3	186115 C	186116 C
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

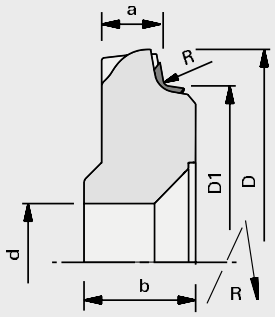
222882

DIAMAX Edge Rounding Cutters CM DP - HOLZ-HER FF701 (FF501 / 1833)

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines HOLZ-HER aggregate FF701 (FF501 / 1833)
- for rounding of solid wood, veneer and plastic edge bands

Design

- with shear angle
- polished face and high-finish clearance angle
- resharpenable area 3.5 mm
- n max = 24.000 min-1

Advantages

- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes

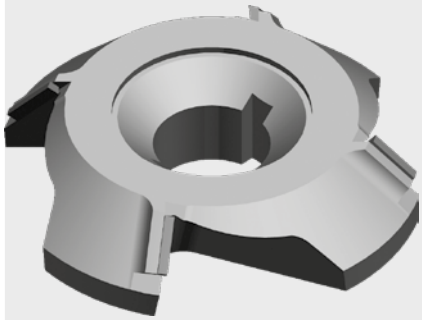
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	72.5	61	13.5	19	20	4	5x2,2	182501 C	182500 C
1,3	72.5	61	13.5	19	20	4	5x2,2	187035 L	187034 L
2,0	72.5	61	13.5	19	20	4	5x2,2	182503 L	182502 L
2,5	72.5	61	13.5	19	20	4	5x2,2	182505 C	182504 C
3,0	72.5	61	13.5	19	20	4	5x2,2	182507 L	182506 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

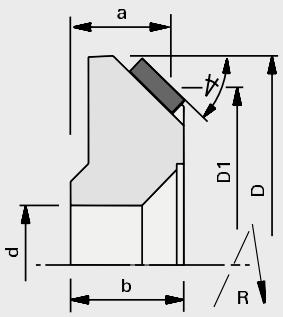
222812

DIAMAX Edge Chamfering Cutters CM DP - HOLZ-HER FF701 (FF501 / 1833)

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application
- edge banding machines HOLZ-HER aggregate FF701 (FF501 / 1833)
- for chamfering of solid wood, veneer and plastic edge bands

Design
- with shear angle
- polished face and high-finish clearance angle
- resharpenable area 3.5 mm
- n max = 24.000 min-1

Advantages
- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

Chamfer∢	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
45	72.5	61	17	19	20	4	5x2,2	182509 C	182508 C
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

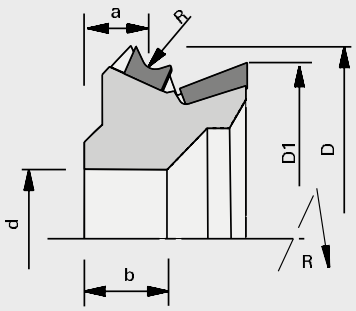
222882

Edge Rounding Trimming Cutters CM DP - HOLZ-HER 1826

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application
- edge banding machines HOLZ-HER aggregate 1826
- for rounding and flush-cutting of solid wood, veneer and plastic edge bands

Design
- with shear angle
- polished face and high-finish clearance angle
- resharpenable area 3.5 mm
- n max = 24.000 min-1

Advantages
- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

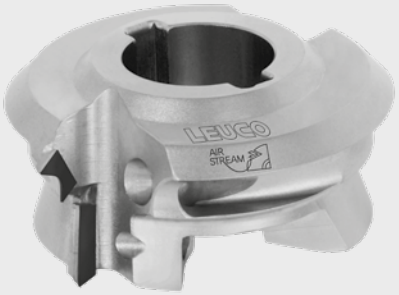
Notes
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	57.25	50	10.76	12	20	2+2	5x2,2	182481 C	182480 C
1,0	57.25	50	10.76	12	20	3+3	5x2,2	182491 C	182490 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

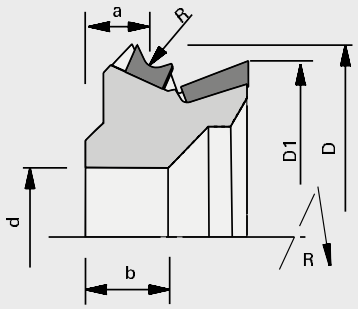
222882

Edge Rounding Trimming Cutters CM DP - HOLZ-HER 1826 - AirStream-System

Product



Drawing



AIR STREAM

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines HOLZ-HER aggregate 1826
- for rounding and flush-cutting of solid wood, veneer and plastic edge bands

Design

- with shear angle
- polished face and high-finish clearance angle
- AirStream-System
- ChipMeister
- n max = 24,000 min-1

Advantages

- improved chip removal thanks to ChipMeister version and AirStream-System
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- low noise level

Notes

- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	DKN		Ident-No. [L]	Ident-No. [R]
1,0	57.25	50	10.76	12	20	2+2	5x2,2	HOLZ-HER 1826	187634 C	187633 C
1,3	55	50	10.75	12	20	2+2	5x2,2	HOLZ-HER 1826	187632 L	187631 L
2,0	55	50	11.02	12	20	2+2	5x2,2	HOLZ-HER 1826	184735 L	184734 L
2,5	55.8	50	11.15	12	20	2+2	5x2,2	HOLZ-HER 1826	184737 L	184736 L
3,0	56	50	11.28	12	20	2+2	5x2,2	HOLZ-HER 1826	184739 L	184738 L
2,0	55	50	11.02	12	20	3+3	5x2,2	HOLZ-HER 1826	184741 L	184740 L
3,0	56	50	11.28	12	20	3+3	5x2,2	HOLZ-HER 1826	184745 C	184744 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]			

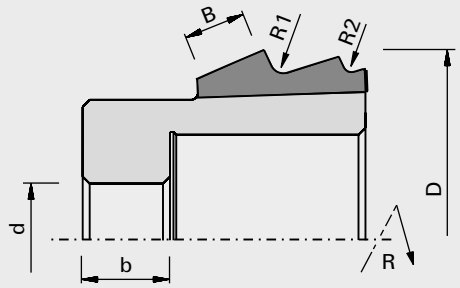
222882

DIAMAX Multi-profile edge trimming cutter DP - HOLZ-HER FR502 Multi - AirStream-System

Product



Drawing



AIR STREAM

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines HOLZ-HER aggregate FR502
- for flush-cutting, rounding and chamfering of solid wood, veneer and plastic edge bands

Design

- with shear angle
- polished face and high-finish clearance angle
- AirStream-System
- n max = 24,000 min-1

Advantages

- Significantly increased chip caption degree thanks to AirStream-System
- No contamination of the machine with chips
- No malfunctions due to chips
- Reduction of the extraction output
- Very low noise level

Notes

- not for resharpening
- constant basic dimensions
- sense of rotation according to VDMA 8849

B	R1	R2	Chamfer◁	Ø D	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
8	2.0	1.3		55.8	12.5	16	2	5x2,3	186787 L	186786 L
8	2.0		45	55.2	12.5	16	2	5x2,3	186917 L	186916 L
[mm]	[mm]	[mm]	[°]	[mm]	[mm]	[mm]				

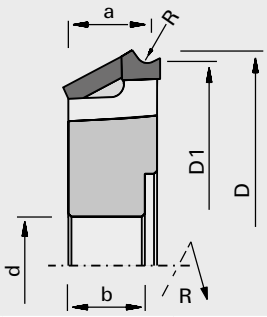
222882

DIAMAX Edge Rounding Flush-Cutting Cutters - HOLZ-HER FR701 - AirStream-System

Product



Drawing



AIR STREAM

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application
- edge banding machines HOLZ-HER aggregate FR701
- for rounding and flush-cutting of solid wood, veneer and plastic edge bands

Design
- with shear angle
- polished face and high-finish clearance angle
- AirStream-System
- n max = 24,000 min-1

Advantages
- considerably increased chip caption degree thanks to AirStream-System
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- very low noise level

Notes
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849
- not for resharpening

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	72.7	68	14	12.5	16	2+2	5x2,3	185874 C	185451 C
1,3	72.4	68	14	12.5	16	2+2	5x2,3	185875 L	185445 L
2,0	71.8	68	14	12.5	16	2+2	5x2,3	185876 L	185447 L
3,0	70.9	68	14	12.5	16	2+2	5x2,3	185877 L	185449 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

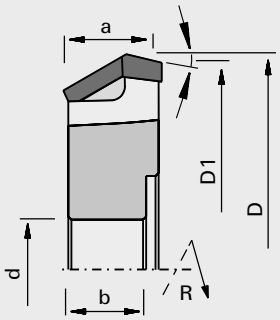
222812

Edge Chamfering Trimming Cutter CM DP - HOLZ-HER 1826 - AirStream-System

Product



Drawing



AIR STREAM

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application
- edge banding machines HOLZ-HER aggregate FR701
- for chamfering and flush-cutting of solid wood, veneer and plastic edge bands

Design
- with shear angle
- polished face and high-finish clearance angle
- AirStream-System
- n max = 24,000 min-1

Advantages
- considerably increased chip caption degree thanks to AirStream-System
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- very low noise level

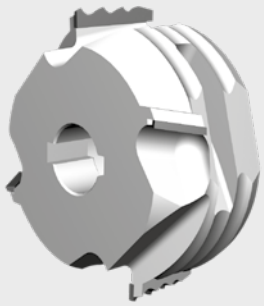
Notes
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849
- not for resharpening

Chamfer∢	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
45	70.5	68	14	12.5	16	2+2	5x2,3	185878 C	185453 C
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

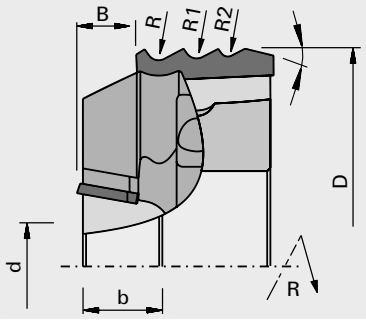
222882

DIAMAX Multi-profile edge trimming cutter DP - HOLZ-HER FR701 Multi - AirStream-System

Product



Drawing



AIR STREAM

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application
- edge banding machines HOLZ-HER aggregate FR701 Multi
- for flush-cutting, rounding and chamfering of solid wood, veneer and plastic edge bands

Design
- with shear angle
- polished face and high-finish clearance angle
- AirStream-System
- n max = 24,000 min-1

Advantages
- increased chip caption degree thanks to AirStream-System
- less chips remain inside of the machine
- less malfunctions due to chips
- reduction of suction power
- noise-reduced - combination of 4 different profiles and flush trimming cutting edge
- different profiles without tool change

Notes
- not for resharpening
- constant basic dimensions
- sense of rotation according to VDMA 8849

B	R	R1	R2	R3	Chamfer◁	Ø D	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
8,0	2,0	1.3	2.0	1.3		70.9	12.5	16	2+2	5x2,3	186884 L	186885 L
8,0	2,0	1.3	1.3		45	71	12.5	16	2+2	5x2,3	187615 L	187616 L
8,0	2,0	2.0	1.3		45	70.9	12.5	16	2+2	5x2,3	185467 L	185466 L
8,0	3,0	2.0	1.3		10	70.9	12.5	16	2+2	5x2,3	187618 C	187617 C
8,0	3,0	2.0	1.3		45	70.9	12.5	16	2+2	5x2,3	185465 L	185464 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	[mm]	[mm]	[mm]		[mm]		

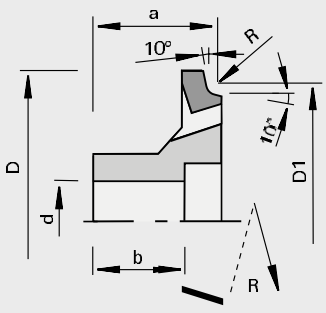
122110

Edge Rounding Cutters HW - SCM-Stefani Round/K

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application
- edge banding machines Stefani with ED system and aggregate Round/K
- for rounding of solid wood, veneer and plastic edge bands

Design
- with shear angle
- n max = 30,000 min-1

Advantages
- optimized chip removal
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

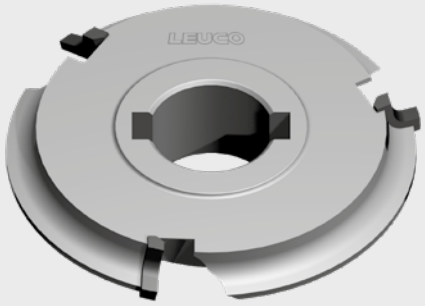
Notes
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	55.7	49,9	25.4	20	16	3	5x2,3	182446 C	182447 C
1,5	55.7	50,9	25.4	20	16	3	5x2,3	182448 C	182449 C
2,0	55.7	51,9	25.4	20	16	3	5x2,3	182450 L	182451 L
3,0	55.7	53,9	25.4	20	16	3	5x2,3	182454 L	182455 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

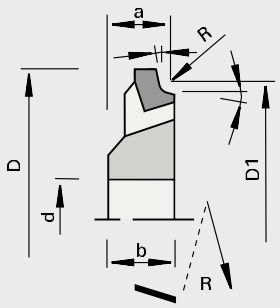
122112

Edge Rounding Cutters HW - SCM-Stefani K130

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application
- edge banding machines SCM-Stefani with aggregate K130
- for rounding of solid wood, veneer and plastic edge bands

Design
- with shear angle
- n max = 30,000 min-1

Advantages
- optimized chip removal
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

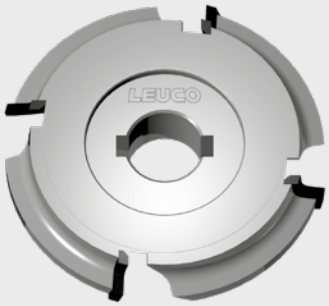
Notes
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	55.3	52	12	13.5	16	3	5x2,3	192213 L	192214 L
3,0	55.3	54	13	13.5	16	3	5x2,3	192216 L	192215 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

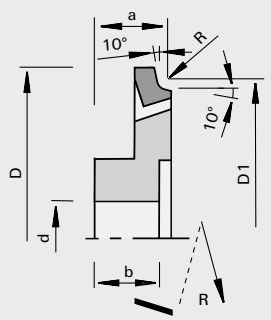
122122

Edge Rounding Cutters HW - SCM-IDM

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application
- edge banding machines SCM-IDM with ED system and aggregate C1 / C2
- for rounding of solid wood, veneer and plastic edge bands

Design
- with shear angle
- polished face and high-finish clearance angle
- n max = 18,000 min-1

Advantages
- optimized chip removal
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

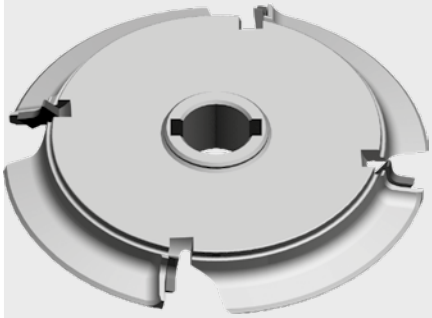
Notes
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	70	62,031	14.5	14	16	4	5x2,3	182911 C	182910 C
1,5	70	63,046	14.5	14	16	4	5x2,3	182909 C	182908 C
2,0	70	64,062	14.5	14	16	4	5x2,3	182907 L	182906 L
3,0	70	66,092	14.5	14	16	4	5x2,3	182903 C	182902 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

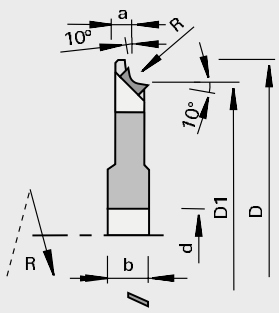
222882

DIAMAX Edge Rounding Cutters DP - SCM-Stefani

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines SCM Stefani with ED-System
- for rounding of solid wood, veneer and plastic edge bands

Design

- with shear angle
- n max = 20,000 min-1
- polished face and high-finish clearance angle

Advantages

- optimized chip removal
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes

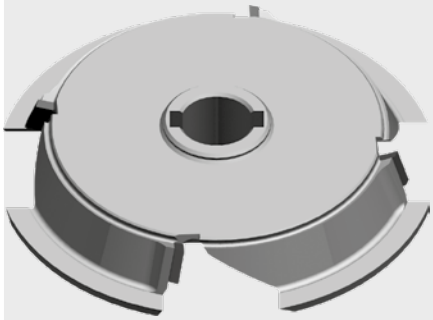
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	73	61,7	8.1	12	12	4	4x1,8	182288 C	182289 C
2,0	73	61,7	7.1	12	12	4	4x1,8	182292 C	182293 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

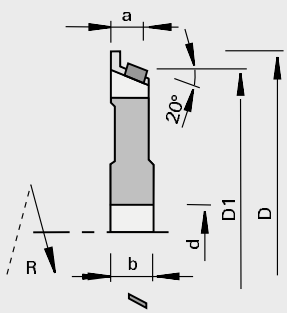
222812

DIAMAX Edge Chamfering Cutters DP - SCM-Stefani

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines SCM-Stefani with ED-System
- for chamfering of solid wood, veneer and plastic edge bands

Design

- with shear angle
- n max = 20,000 min-1
- polished face and high-finish clearance angle

Advantages

- optimized chip removal
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes

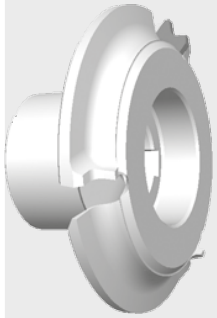
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

Chamfer∢	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
20	73	61,7	8.7	12	12	4	4x1,8	182302 S	182303 S
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

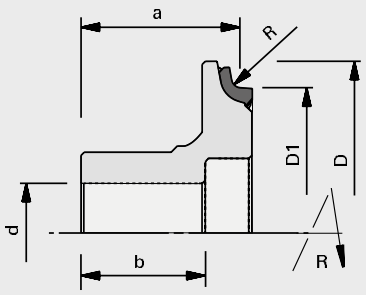
222882

Edge Rounding Cutters DP - SCM-IDM Round/K

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines SCM-IDM with ED system and aggregate Round/K
- for rounding of solid wood, veneer and plastic edge bands

Design

- with shear angle
- n max = 20,000 min-1
- polished face and high-finish clearance angle

Advantages

- optimized chip removal
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes

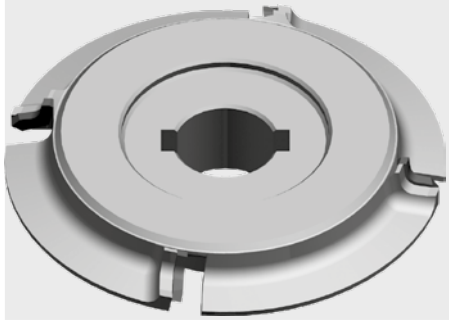
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	55.3	48	25.4	20	16	3	5x2,3	182416 C	182415 C
1,5	55.3	48	25.4	20	16	3	5x2,3	182418 S	182417 S
2,0	55.3	48	25.4	20	16	3	5x2,3	182414 C	182413 C
3,0	55.7	48	25.4	20	16	3	5x2,3	182412 C	182411 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

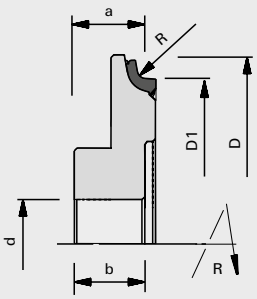
222882

Edge Rounding Cutters DP - SCM-IDM C1/C2

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines SCM-IDM with ED system and aggregate C1 / C2
- for rounding of solid wood, veneer and plastic edge bands

Design

- with shear angle
- n max = 18,000 min-1
- polished face and high-finish clearance angle

Advantages

- optimized chip removal
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes

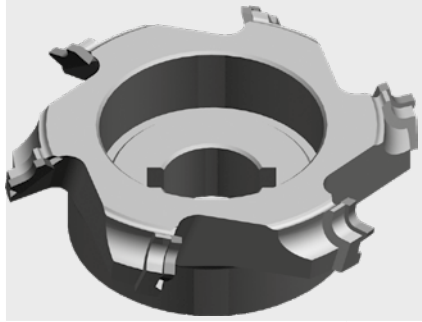
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	70	60	14.5	14	16	4	5x2,2	182901 C	182900 C
1,5	70	60	14.5	14	16	4	5x2,2	182899 S	182898 S
2,0	70	60	14.5	14	16	4	5x2,2	182897 C	182896 C
3,0	70	60	14.5	14	16	4	5x2,2	182893 C	182892 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

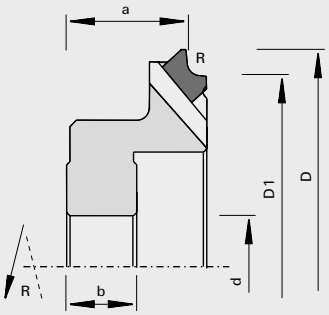
222282

DIAMAX Edge Rounding Cutters DP - Biesse Ergho, Akron

Product



Drawing



LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machine Biesse Ergho/Akron 200/800 - CR 200/CR 202
- for rounding of solid wood, veneer and plastic edge bands

Design

- with shear angle
- reduced resharpening area
- n max = 24,000 min-1

Advantages

Notes

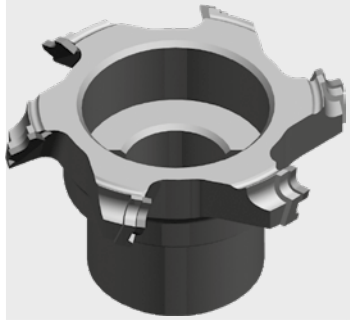
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,5	68	59,98	21	11	16	6	5x2,3	183699 C	183700 C
2,0	68	59,98	21	11	16	6	5x2,3	183701 C	183702 C
3,0	68	59,98	21	11	16	6	5x2,3	183703 C	183704 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

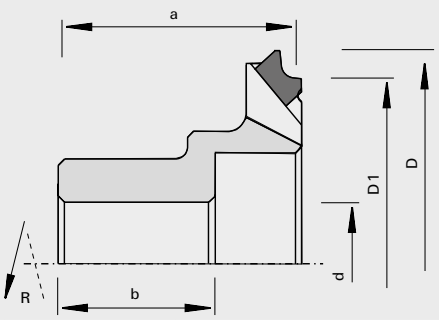
222582

DIAMAX Edge Rounding Cutters DP - Biesse

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Biesse
- for rounding of solid wood, veneer and plastic edge bands

Design

- with shear angle
- polished face and high-finish clearance angle
- reduced resharpening area
- n max = 24,000 min-1

Advantages

- optimum cutting quality

Notes

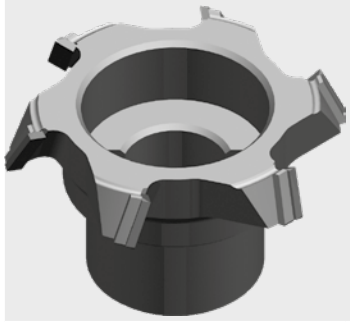
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,5	67	60	38.5	25.5	20	6	6x2,8	183709 C	183710 C
2,0	67	60	38.5	25.5	20	6	6x2,8	183711 C	183712 C
3,0	67	60	38.5	25.5	20	6	6x2,8	183713 S	183714 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

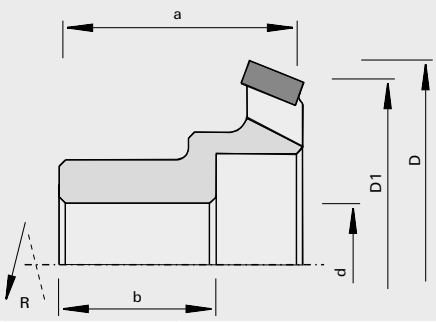
222512

DIAMAX Edge Chamfering Cutters DP - Biesse

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application
- edge banding machines Biesse
- for chamfering of solid wood, veneer and plastic edge bands

Design
- with shear angle
- polished face and high-finish clearance angle
- reduced resharpening area
- n max = 24,000 min-1

Advantages
- optimum cutting quality

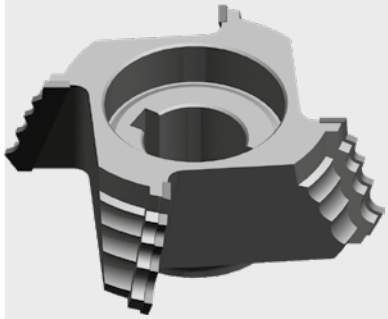
Notes
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

Chamfer◁	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
25	67	60	38.5	25.5	20	6	6x2,8	183715 S	183716 S
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

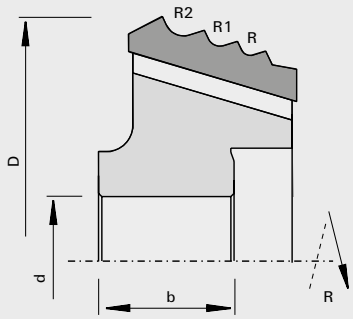
222582

DIAMAX Edge Rounding / Chamfering Cutters DP Multi - Biesse

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application
- edge banding machines Biesse RF 40
- for rounding and chamfering of solid wood, veneer and plastic edge bands

Design
- with shear angle
- polished face and high-finish clearance angle
- resharpening area 1,0 mm
- n max = 24,000 min-1

Advantages
- optimum cutting quality

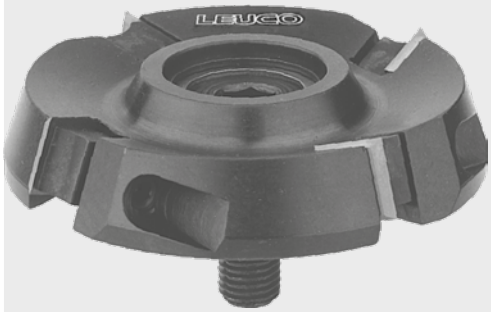
Notes
- sense of rotation according to VDMA 8849

R	R1	R2	Cham-fer◁	Ø D	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,5	2.0	3.0	25	75.4	21	20	4	6x2,8	183707 C	183708 C
[mm]	[mm]	[mm]	[°]	[mm]	[mm]	[mm]		[mm]		

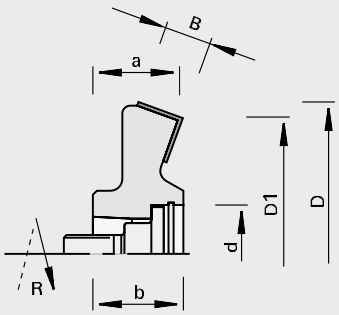
120120

Edge Chamfering Cutterheads HW HSK 25R - Homag, IMA

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines Homag, IMA
- for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

- with shear angle
- cutting material: HW HL Board 05
- n max = 18,000 min-1

Advantages

- excellent cutting quality thanks to high radial running accuracy and precise tool balancing

Notes

- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

Chamfer◁	Ø D	Ø D1	a	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
20	77	70	21.5	12	23	HSK 25R	4	177594 C	177593 C
[°]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	12	12	1.5	150515	10	003080 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
Pressure Bars	B=10	925300	2	164526 L
Set Screws	M6x12 DIN EN ISO 4028	995161	10	180214 L
Screwdrivers	SW3x100	985730	1	166090 L
	[mm]		[pc.]	

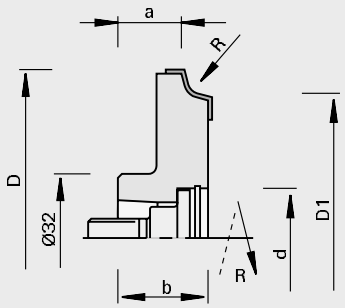
120102

Edge Rounding Cutterheads HW HSK 25R - Homag

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines Homag
- for rounding of solid wood, veneer and plastic edge bands

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 05

Advantages

- excellent cutting quality thanks to high radial running accuracy and precise tool balancing

Notes

- constant basic dimensions a and D1
- same cutterhead body for R 1.5 - 3 mm
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	nmax	Ident-No. [L]	Ident-No. [R]
1,5	79	70	16.5	23	HSK 25R	4	18000	177734 O	177733 O
2,5	79	70	16.5	23	HSK 25R	4	18000	177738 S	177737 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]		

Knives	R	B	H	S	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	1,5	12	17	2.0	151546	10	177606 L	177605 L
	2,0	12	17	2.0	151546	10	177608 L	177607 L
	2,5	12	17	2.0	151546	10	177610 C	177609 C
	3,0	12	17	2.0	151546	10	177612 L	177611 L
	[mm]	[mm]	[mm]	[mm]		[pc.]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	12x11x7	925300	2	177724 L
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
Set Screws	M6x16 SW3	995161	10	001617 L
Cranked Wrench Keys	SW3 DIN ISO 2936	985730	1	009672 L
	[mm]		[pc.]	

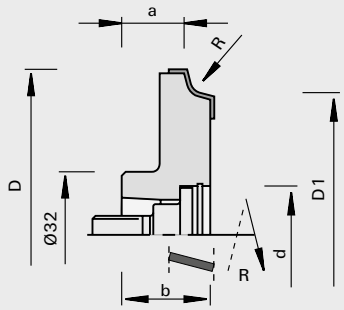
120112

Edge Rounding Cutterheads HW HSK 25R - IMA

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application
- edge banding machines IMA
- for rounding of solid wood, veneer and plastic edge bands

Design
- with shear angle
- cutting material: HW HL Board 06

Advantages
- excellent cutting quality thanks to high radial running accuracy and precise tool balancing

Notes
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	nmax	Ident-No. [L]	Ident-No. [R]
2,0	80	70	16.5	23	HSK 25R	4	18000	180170 O	180169 O
3,0	80	70	16.5	23	HSK 25R	4	18000	180172 O	180171 O
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]		

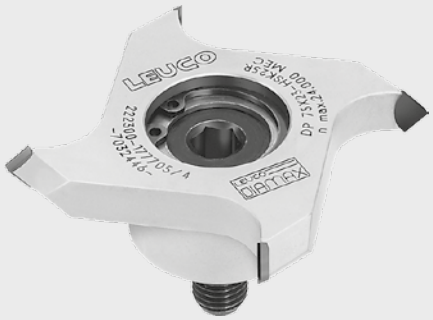
Knives	R	B	H	S	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	2,0	12	18	2.0	151586	10	180174 L	180173 L
	3,0	12	18	2.0	151586	10	180176 L	180175 L
	[mm]	[mm]	[mm]	[mm]		[pc.]		

Spare parts	Dimension		Class-No.	PU	Ident-No.
Pressure Bars	12x11x7	left	925300	2	180255 S
Pressure Bars	12x11x7	right	925300	2	180256 L
Screws	M10x1,25x32 SW8		995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988		995440	10	177781 L
Locking Rings	25x1,2 DIN 472		995460	10	177782 L
Set Screws	M6x16 SW3		995161	10	001617 L
Cranked Wrench Keys	SW3 DIN ISO 2936		985730	1	009672 L
	[mm]			[pc.]	

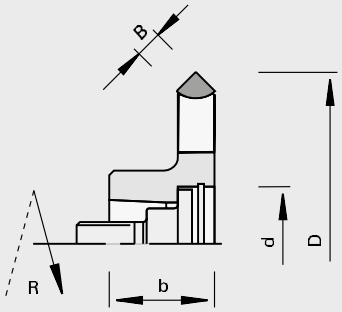
222512

Edge Chamfering Cutters DP HSK 25R - Homag, IMA

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application
- edge banding machines Homag, IMA
- for chamfering of solid wood, veneer and plastic edge bands

Design
- polished face
- high-finish clearance angle
- resharpenable
- n max = 24,000 min-1

Advantages
- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing

Notes
- sense of rotation according to VDMA 8849

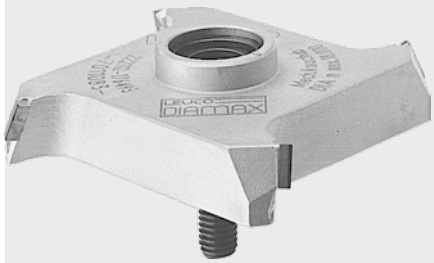
Chamfer◁	Ø D	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
45	75	8,0	23	HSK 25R	4	177705 C	177706 C
[°]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

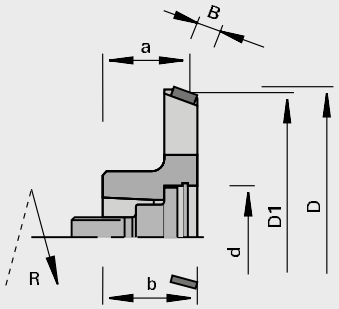
222512

DIAMAX Edge Chamfering Cutters DP HSK 25R - Homag, IMA

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application
- edge banding machines Homag aggregate FF, IMA,
- for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design
- polished face
- high-finish clearance angle
- with shear angle
- n max = 24,000 min-1

Advantages
- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing

Notes
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

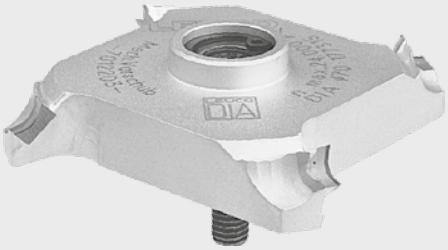
Chamfer◁	Ø D1	Ø D	a	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
20	70	73	21.5	6,0	23	HSK 25R	4	177649 C	177650 C
[°]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

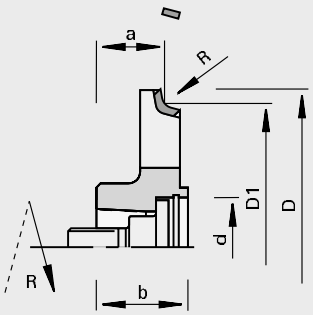
222582

DIAMAX Edge Rounding Cutters DP HSK 25R - Homag FF, IMA

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Homag aggregate FF, IMA,
- for rounding of solid wood, veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle
- with shear angle
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing

Notes

- constant basic dimensions a and D1
- Z = 4 for feed rate 20 - 30 m/min
- Z = 6 for feed rate 30 - 45 m/min
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	75.1	70	16.5	23	HSK 25R	4	177655 C	177656 C
1,5	76.1	70	16.5	23	HSK 25R	4	177657 C	177658 C
2,0	77.5	70	16.5	23	HSK 25R	4	177659 L	177660 L
2,5	78.1	70	16.5	23	HSK 25R	4	177661 C	177662 C
3,0	78.8	70	16.5	23	HSK 25R	4	177663 C	177664 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

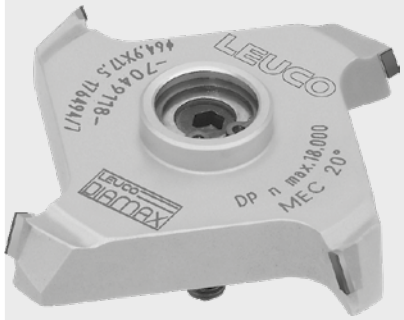
R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	75.1	70	16.5	23	HSK 25R	6	178545 C	178546 C
1,5	76.1	70	16.5	23	HSK 25R	6	178547 C	178548 C
2,0	77.5	70	16.5	23	HSK 25R	6	178549 C	178550 C
2,5	78.1	70	16.5	23	HSK 25R	6	178551 S	178552 S
3,0	78.8	70	16.5	23	HSK 25R	6	178553 C	178554 C
4,0	81.2	70	16.5	23	HSK 25R	6	178557 C	178558 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

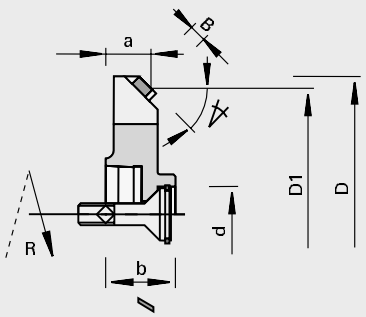
222512

DIAMAX Edge Chamfering Cutters DP HSK 32 - Homag

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Homag / aggregate FK 01, FK 02, FK 03
- for chamfering of solid wood, veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle
- with shear angle
- n max = 18,000 min-1

Advantages

- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing

Notes

- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

Chamfer◁	Ø D	Ø D1	a	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
30	65.9	62	11.5	6,0	17.5	HSK 32	4	177407 C	177406 C
45	71.5	62	11.5	6,0	17.5	HSK 32	4	177409 C	177408 C
20	64.9	62	11.5	6,0	17.5	HSK 32	4	176494 C	176493 C
[°]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Locking Rings	14x1 DIN 472	995460	10	057258 L
Shim Rings	8x14x1 DIN 988	995440	10	173406 L
Countersunk Screws	M6x30-8.8 SW4 DIN EN ISO 10642	995121	10	173407 L
	[mm]		[pc.]	

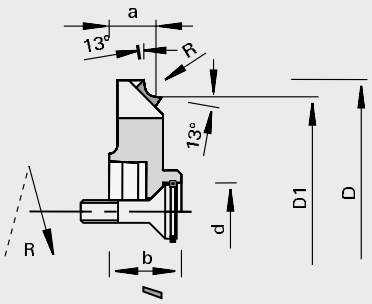
222582

DIAMAX Edge Rounding Cutters DP HSK 32 - Homag FK

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Homag / aggregate FK 01, FK 02, FK 03
- for rounding of solid wood, veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle
- with shear angle
- n max = 18,000 min-1
- HSK 32 shortened

Advantages

- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing

Notes

- constant basic dimensions a and D1
- Z = 4 for feed rate 20 - 30 m/min
- Z = 6 for feed rate 30 - 45 m/min
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
0,8	68.1	62	11.5	17.5	HSK 32	4	179376 C	179377 S
1,0	68.1	62	11.5	17.5	HSK 32	4	179378 C	179379 C
1,5	68.1	62	11.5	17.5	HSK 32	4	179380 C	179381 C
2,0	71.2	62	11.5	17.5	HSK 32	4	179382 L	179383 L
2,5	71.2	62	11.5	17.5	HSK 32	4	179384 C	179385 C
3,0	71.2	62	11.5	17.5	HSK 32	4	179386 C	179387 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	68.1	62	11.5	17.5	HSK 32	6	178466 C	178467 C
1,5	68.1	62	11.5	17.5	HSK 32	6	178468 C	178469 C
2,0	71.2	62	11.5	17.5	HSK 32	6	178470 C	178471 C
3,0	71.2	62	11.5	17.5	HSK 32	6	178474 S	178475 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Locking Rings	14x1 DIN 472	995460	10	057258 L
Shim Rings	8x14x1 DIN 988	995440	10	173406 L
Countersunk Screws	M6x30-8.8 SW4 DIN EN ISO 10642	995121	10	173407 L
	[mm]		[pc.]	

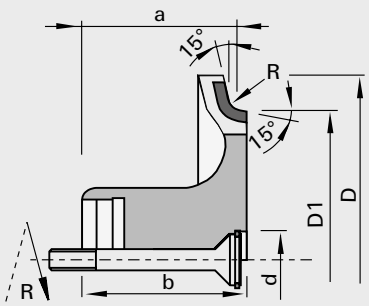
222882

Edge Rounding Cutters DP HSK 32 - Homag FK

Product



Drawing



LEUCO topline

LEUCO i-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Homag aggregate FK
- for rounding of solid wood, veneer and plastic edge bands

Design

- polished face
- precise clearance angle
- with shear angle
- runout angle 15°

Advantages

- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing
- optimized chip removal thanks to internal chip evacuation
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes

- constant basic dimensions a and D1
- machines must be equipped with i-System
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	74	62	31.5	33	HSK 32	4	180301 L	180300 L
1,5	74	62	31.5	33	HSK 32	4	180278 L	180279 L
2,0	74	62	31.5	33	HSK 32	4	180280 L	180281 L
2,5	74	62	31.5	33	HSK 32	4	180303 C	180302 C
3,0	74	62	31.5	33	HSK 32	4	180282 L	180283 L
4,0	74	62	31.5	33	HSK 32	4	180307 S	180306 S
5,0	74	62	31.5	33	HSK 32	4	180311 S	180310 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

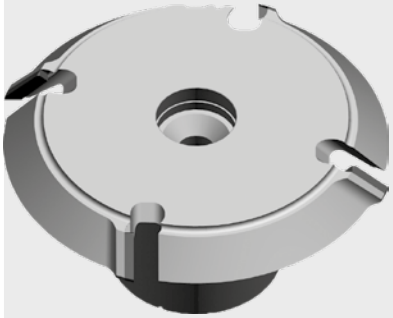
R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	74	62	31.5	33	HSK 32	6	180313 C	180312 C
1,5	74	62	31.5	33	HSK 32	6	180315 L	180314 L
2,0	74	62	31.5	33	HSK 32	6	180284 L	180285 L
2,5	74	62	31.5	33	HSK 32	6	180317 C	180316 C
3,0	74	62	31.5	33	HSK 32	6	180286 C	180287 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Locking Rings	14x1 DIN 472	995460	10	057258 L
Shim Rings	8x14x1 DIN 988	995440	10	173406 L
Countersunk Screws	M6x45-10.9 SW4 DIN EN ISO 10642	995121	10	180293 L
	[mm]		[pc.]	

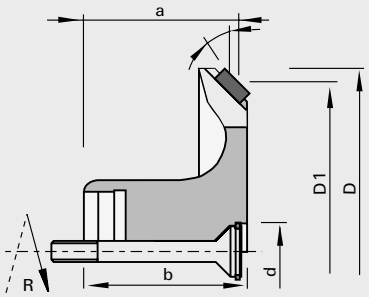
222812

Edge Chamfering Cutters DP HSK 32 - Homag

Product



Drawing



LEUCO topline

LEUCO ix system

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Homag / FK-aggregates
- for chamfering of solid wood, veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle
- with shear angle

Advantages

- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing
- optimized chip removal thanks to internal chip evacuation
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes

- constant basic dimensions a and D1
- attention: machines must be re-equipped accordingly
- sense of rotation according to VDMA 8849

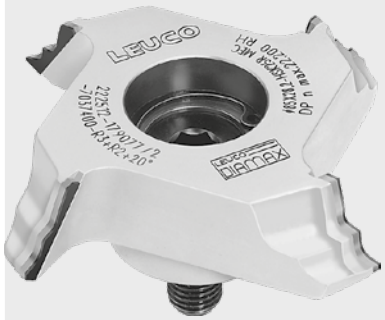
Chamfer◁	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
20	65.1	62,3	31.5	34	HSK 32	4	180288 L	180289 L
45	70	62,3	31.5	34	HSK 32	4	180319 L	180318 L
20	65.1	62,3	31.5	34	HSK 32	6	180290 L	180291 L
45	70	62,3	31.5	34	HSK 32	6	180321 C	180320 C
[°]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Locking Rings	14x1 DIN 472	995460	10	057258 L
Shim Rings	8x14x1 DIN 988	995440	10	173406 L
Countersunk Screws	M6x30-8.8 SW4 DIN EN ISO 10642	995121	10	173407 L
	[mm]		[pc.]	

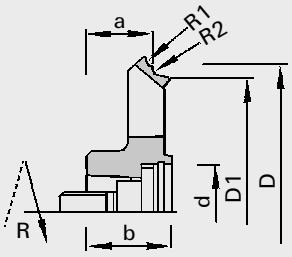
222582

DIAMAX Edge Rounding-Chamfering Cutters DP HSK 25R - Homag

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Homag aggregate FF
- for rounding and chamfering of solid wood, veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle
- with shear angle
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing

Notes

- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

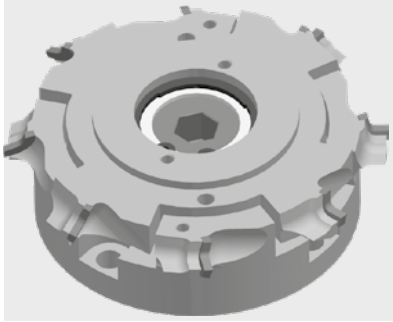
R1	R2	Cham-fer◁	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
3.0	2.0	20	85	69	22.75	28	HSK 25R	4	179076 C	179077 C
[mm]	[mm]	[°]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

223882

DIAMAX Edge Rounding-Chamfering Cutters CM DP HSK 25R - flexTrim - Homag

Product



Drawing

LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- Homag edge banding machines for shaping units FK11, FK20, FK21 , FF32, FF12, PF21 with flex Trim aggregate
- for rounding and / or chamfering of solid wood, veneer and plastic edge bands

Design

- 2 piece tool
- polished face
- precise clearance angle
- with shear angle
- runout angle 15°
- n max = 18,000 min-1

Advantages

- optimized chip removal thanks to ChipMeister version
- short workpiece gap at high feed rates
- excellent cutting quality thanks to high radial running accuracy and precise tool balancing
- combination of 2 different profiles

Notes

- further combinations on request
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

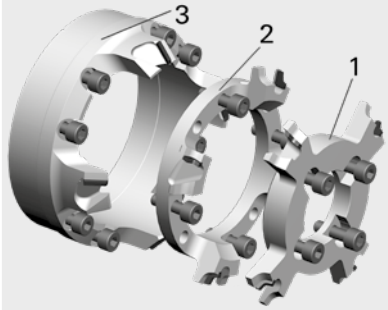
R1	R2	Chamfer◁	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1.5	1.0		78	70	19.5		HSK 25R	4	185077 L	185076 L
2.0	1.0		78	70	19.5		HSK 25R	4	185189 L	185188 L
2.0	1.2		78	70	19.5		HSK 25R	4	185975 C	185976 C
2.0	1.3		78	70	19.5		HSK 25R	4	187122 L	187123 L
2.0	1.5		78	70	19.5		HSK 25R	4	183121 L	183122 L
3.0	1.0		78	70	19.5		HSK 25R	4	186583 L	186582 L
3.0	2.0		78	70	19.5		HSK 25R	4	183115 L	183116 L
2.0		20	78	70	19.5		HSK 25R	4	185191 C	185190 C
2.0		45	78	70	19.5		HSK 25R	4	185193 C	185192 C
[mm]	[mm]	[°]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
Head Cap Screws	M5x12-10.9 DIN EN ISO 4762	995111	10	185320 L
O-Rings	41x1,78 NBR 11-70	997800	1	69004135 L
	[mm]		[pc.]	

222582

DIAMAX Edge Rounding-Chamfering Cutters CM DP - FK31 - Homag

Product



Drawing

LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- Edge banding machine HOMAG with shaping unit FK30 or FK31
- for rounding and / or chamfering of frond edge bands made of solid wood, veneer or plastic

Design

- 3 piece tool
- polished face
- precise clearance angle
- with shear angle
- runout angle 15°
- n max = 18,000 min-1

Advantages

- very short workpiece gaps of 400 mm at a max. part length of 600 mm
- Feed rates up to 35 m/min
- Combination of up to 3 different profiles without tool change
- Excellent cutting quality thanks to high concentric accuracy and smooth running
- Replacement of a whole set of individual profiles is possible
- Optimized chip removal thanks to ChipMeister version

Notes

- the profile of tool 1 must be larger than the profile of the tools 2 and 3. The biggest radius determines the maximum chamfer size of the moving chamfering tools 2 and 3.
- further profile combinations are available on short notice upon request
- it is possible to produce an additional chamfer profile using the runout angle
- constant reference diameter D1
- Tools are delivered with mounting screws
- sense of rotation according to VDMA 8849
- not intended for resharpening

Tool 1, fixed

R	Chamfer◁	Ø D	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0		88.5	7	12	30	4	187050 C	187051 C
1,2		88.5	7	12	30	4	187045 C	187046 C
1,3		88.5	7	12	30	4	187048 C	187049 C
1,5		88.5	7	12	30	4	184111 C	184112 L
2,0		88.5	7	12	30	4	184090 L	184091 C
3,0		88.5	7	12	30	4	184107 C	184108 C
	20	88.5	7	12	30	4	187052 C	187053 C
[mm]	[°]	[mm]	[mm]	[mm]	[mm]			

Tool 2, moving

R	Chamfer◁	Ø D	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
0,6		88.5	18.5	19.5	55	4	187057 C	187058 C
1,0		88.5	18.5	19.5	55	4	184094 C	184095 L
1,3		88.5	18.5	19.5	55	4	187055 C	187056 C
1,5		88.5	18.5	19.5	55	4	184092 L	184093 C
2,0		88.5	18.5	19.5	55	4	184113 C	184114 C
3,0		88.5	18.5	19.5	55	4	184125 C	184126 C
	45	88.5	18.5	19.5	55	4	184129 C	184130 C
	20	88.5	18.5	19.5	55	4	184133 C	184134 C
[mm]	[°]	[mm]	[mm]	[mm]	[mm]			

Tool 3, moving

R	Chamfer	Ø D	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
0,8		92	43	44	73	4	187065 C	187066 C
1,0		92	43	44	73	4	184096 L	184097 C
1,2		92	43	44	73	4	187060 C	187061 C
1,3		92	43	44	73	4	187067 C	187069 C
1,5		92	43	44	73	4	184115 C	184116 C
2,0		92	43	44	73	4	184135 C	184136 C
	15	92	43	44	73	4	187063 C	187062 C
	20	92	43	44	73	4	184098 L	184099 C
	30	92	43	44	73	4	184119 C	184120 C
	45	92	43	44	73	4	184117 C	184118 C
[mm]	[°]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Head Cap Screws	M5x12 DIN 7984	995111	10	184175 L
Head Cap Screws	M5x30 DIN EN ISO 4762	995111	10	185496 L
	[mm]		[pc.]	

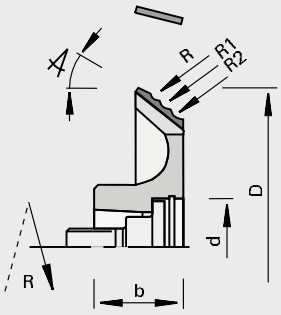
222882

Edge Rounding / Chamfering Cutters DP Multi HSK 25R - Homag MF20 / MF21

Product



Drawing



LEUCO topline

LEUCO i-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Homag aggregate MF20 / MF21
- for rounding and chamfering of solid wood, veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle
- with shear angle
- runout angle 15°
- resharpenable area 1.0 mm

Advantages

- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing
- optimized chip removal thanks to internal chip evacuation
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes

- constant basic dimensions
- Z = 4 for feed rate 20 - 30 m/min
- Z = 6 for feed rate 30 - 45 m/min
- machines must be equipped with i-System
- sense of rotation according to VDMA 8849

R	R1	R2	Chamfer	Ø D	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
2,0	3.0		20	81.6	28	HSK 25R	4	180757 L	180758 L
2,0	3.0		20	81.6	28	HSK 25R	6	180759 C	180760 C
1,5	2.0		20	80.6	28	HSK 25R	4	185075 L	185074 L
1,5	2.0	3.0	20	82	28	HSK 25R	4	180708 C	180709 C
1,5	2.0	3.0	20	82	28	HSK 25R	6	180763 C	180764 C
1,0	1.5	2.0	20	81	27	HSK 25R	4	186677 L	186676 L
1,0	1.3	2.0	20	81	27	HSK 25R	4	186679 C	186678 C
1,0	2.0		45	83	28	HSK 25R	4	187677 L	187678 L
[mm]	[mm]	[mm]	[°]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

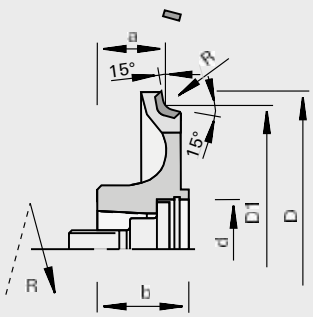
222882

Edge Rounding Cutters DP HSK 25R - Homag FF, IMA

Product



Drawing



LEUCO topline

LEUCO i-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Homag FF, IMA
- for chamfering of solid wood, veneer and plastic edge bands

Design

- polished face
- precise clearance angle
- with shear angle
- runout angle 15°

Advantages

- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing
- optimized chip removal thanks to internal chip evacuation
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes

- constant basic dimensions a and D1
- Z = 4 for feed rate 20 - 30 m/min
- Z = 6 for feed rate 30 - 45 m/min
- machines must be equipped with i-System
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	76	70	17.5	23	HSK 25R	4	184923 L	184924 L
1,3	76	70	17.8	23	HSK 25R	4	184927 L	184928 L
1,5	76	70	18	23	HSK 25R	4	184921 L	184922 L
2,0	76	70	18.5	23	HSK 25R	4	184919 L	184920 L
2,5	78	70	19	23	HSK 25R	4	184925 C	184926 C
3,0	78	70	19.5	23	HSK 25R	4	184917 L	184918 L
4,0	84	70	20.5	23	HSK 25R	4	180554 C	180555 C
5,0	84	70	21.5	23	HSK 25R	4	180558 C	180559 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

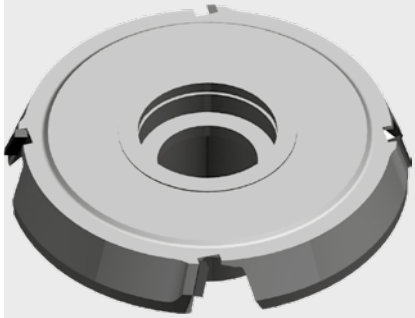
R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	76	70	17.5	23	HSK 25R	6	184939 C	184940 C
1,3	76	70	17.8	23	HSK 25R	6	184937 C	184938 C
1,5	76	70	18	23	HSK 25R	6	184935 L	184936 L
2,0	76	70	18.5	23	HSK 25R	6	184933 L	184934 L
2,5	78	70	19	23	HSK 25R	6	184931 C	184932 C
3,0	78	70	19.5	23	HSK 25R	6	184929 L	184930 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

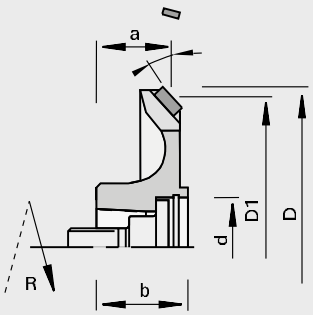
222812

Edge Chamfering Cutters DP HSK 25R - Homag FF, IMA

Product



Drawing



LEUCO topline

LEUCO i-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Homag aggregate FF, IMA
- for chamfering of solid wood, veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle
- with shear angle

Advantages

- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing
- optimized chip removal thanks to internal chip evacuation
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes

- constant basic dimensions a and D1
- Z = 4 for feed rate 20 - 30 m/min
- Z = 6 for feed rate 30 - 45 m/min
- machines must be equipped with i-System
- sense of rotation according to VDMA 8849

Chamfer	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
20	73	70	19.5	22.2	HSK 25R	4	180578 L	180579 L
45	78.7	70	19.5	22.2	HSK 25R	4	180580 C	180581 C
20	73	70	19.5	22.2	HSK 25R	6	180582 C	180583 C
45	78.7	70	19.5	22.2	HSK 25R	6	180584 L	180585 L
[°]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

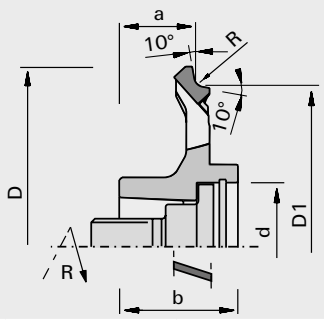
222582

DIAMAX Edge Rounding Cutters DP HSK 25R - Brandt

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Brandt
- for rounding of solid wood, veneer and plastic edge bands

Design

- with shear angle
- polished face and high-finish clearance angle
- n max = 18,000 min-1
- runout angle 10°

Advantages

- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing

Notes

- constant basic dimensions a and D1
- Z = 4 for feed rate 20 - 30 m/min
- sense of rotation according to VDMA 8849

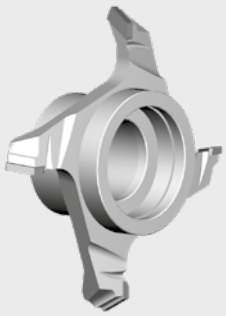
R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	70	62	16.5	23	HSK 25R	4	185279 L	185278 L
1,3	70	62	16.5	23	HSK 25R	4	185283 C	185282 C
1,5	70	62	16.5	23	HSK 25R	4	185285 C	185284 C
2,0	70	62	16.5	23	HSK 25R	4	185236 L	185237 L
3,0	70	62	16.5	23	HSK 25R	4	185287 L	185286 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

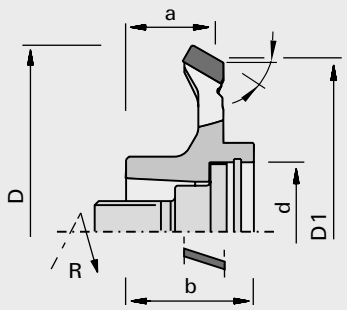
222512

DIAMAX Edge Chamfering Cutters DP HSK 25R - Brandt

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Brandt
- for chamfering of solid wood, veneer and plastic edge bands

Design

- with shear angle
- polished face and high-finish clearance angle
- n max = 18,000 min-1

Advantages

- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing

Notes

- constant basic dimensions a and D1
- Z = 4 for feed rate 20 - 30 m/min
- sense of rotation according to VDMA 8849

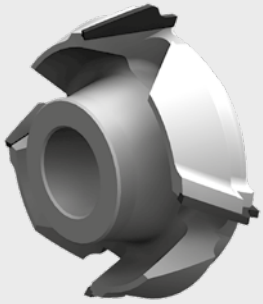
Chamfer∢	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
15	67	62	16.5	23	HSK 25R	4	185289 S	185288 S
30	67	62	16.5	23	HSK 25R	4	185297 C	185298 C
45	70	62	16.5	23	HSK 25R	4	185291 C	185290 C
[°]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

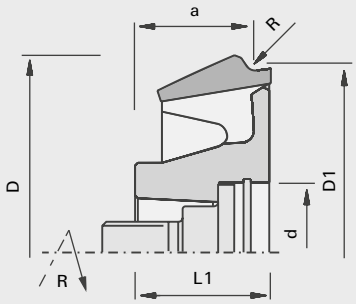
222882

Edge Rounding Trimming Cutters CM DP HSK 25R - Homag

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Homag for aggregate BF40
- for rounding of solid wood, veneer and plastic edge bands

Design

- with shear angle
- polished face and high-finish clearance angle
- runout angle 13°
- n max = 24.000 min-1

Advantages

- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing
- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes

- Z = 4 for feed rate 20 - 30 m/ min
- sense of rotation according to VDMA 8849
- not for resharpening

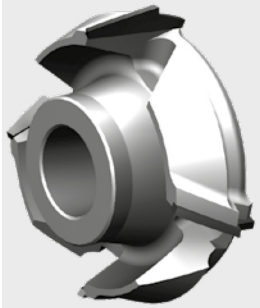
R	Ø D	Ø D1	a	L1	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	70.57	67,12	21.88	24.3	HSK 25R	4	187314 C	187306 C
1,3	70.57	67,70	21.78	24.3	HSK 25R	4	187315 C	187307 C
1,5	70.57	68,08	21.72	24.3	HSK 25R	4	187316 C	187308 C
2,0	70.57	69,05	21.55	24.3	HSK 25R	4	187318 C	187309 C
3,0	70.57	70,98	21.22	24.3	HSK 25R	4	187319 C	187310 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

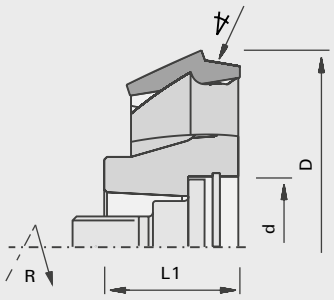
222882

Edge Chamfering Trimming Cutters CM DP HSK 25R - Homag

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Homag for aggregate BF40
- for rounding of solid wood, veneer and plastic edge bands

Design

- with shear angle
- polished face and high-finish clearance angle
- n max = 24.000 min-1

Advantages

- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing
- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes

- Z = 4 for feed rate 20 - 30 m/ min
- sense of rotation according to VDMA 8849
- not for resharpening

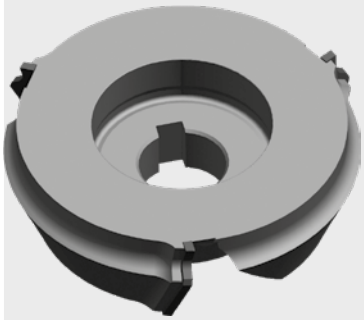
Chamfer	Ø D	L1	Ø d	Z	Ident-No. [L]	Ident-No. [R]
15	70.23	24.3	HSK 25R	4	187320 C	187311 C
30	70.23	24.3	HSK 25R	4	187321 C	187312 C
45	70.23	24.3	HSK 25R	4	187322 C	187313 C
[°]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

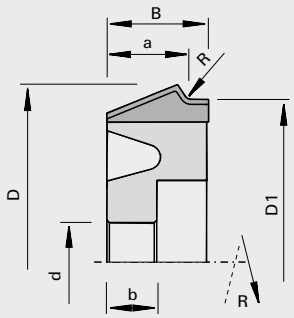
222882

Edge Rounding Trimming Cutters CM DP - Brandt

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application
- edge banding machines Brandt
- for rounding of solid wood, veneer and plastic edge bands

Design
- with shear angle
- polished face and high-finish clearance angle
- resharpenable area approx. 2 mm
- n max = 24.000 min-1

Advantages
- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

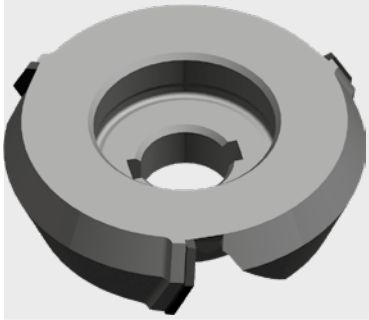
Notes
- Z = 3 for feed rate 8 - 20 m/min
- Z = 4 for feed rate 20 - 30 m/min
- sense of rotation according to VDMA 8849

R	Ø D	B	b	Ø d	Ø D1	a	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	70.57	20,3	10	16	65,08	17.8	3	5x2,3	183169 C	183168 C
2,0	70.57	20,3	10	16	65,08	17.8	4	5x2,3	185234 L	185235 L
3,0	70.57	20,3	10	16	65,02	17.59	4	5x2,3	185305 C	185304 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

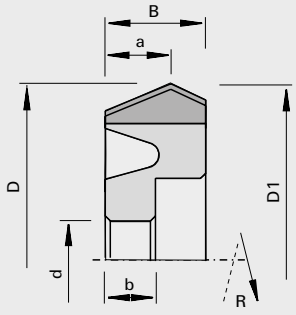
222812

Edge Chamfering Trimming Cutters CM DP - Brandt

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application
- edge banding machines Brandt
- for chamfering of solid wood, veneer and plastic edge bands

Design
- with shear angle
- polished face and high-finish clearance angle
- resharpenable area approx. 2 mm
- n max = 24.000 min-1

Advantages
- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

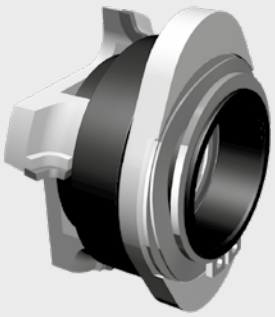
Notes
- sense of rotation according to VDMA 8849

Chamfer	Ø D	B	b	Ø d	Ø D1	a	Z	DKN	Ident-No. [L]	Ident-No. [R]
45	70.6	20	10	16	69,98	13.07	3	5x2,3	183171 C	183170 C
[°]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

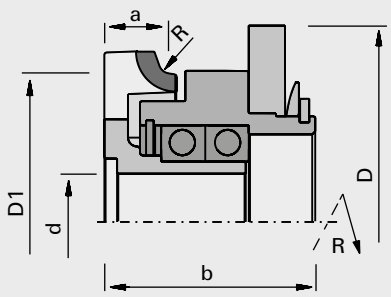
222582

DIAMAX Edge Rounding Cutters DP with copy wheel and torque support - Brandt

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Brandt
- for rounding of solid wood, veneer and plastic edge bands

Design

- cutters with integrated copy function and torque support
- torque support made of plastic to protect the workpiece
- bearing by means of roller bearing
- n max = 18,000 min-1

Advantages

- high precision and good cutting results thanks to integrated copy wheel

Notes

- constant basic dimensions a and D1
- for this application only one sense of rotation is required
- sense of rotation according to VDMA 8849

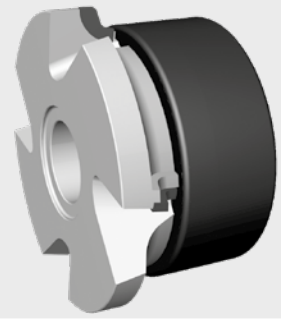
R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [R]
1,0	65	49,9	11	34.9	16	4	186746 L
1,3	65	49,9	11	34.9	16	4	186878 L
1,5	65	49,9	11	34.9	16	4	185357 L
2,0	65	49,9	11	34.9	16	4	185358 L
3,0	65	49,9	11	34.9	16	4	185359 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Torque Support	65x48x6	997500	1	185361 L
	[mm]		[pc.]	

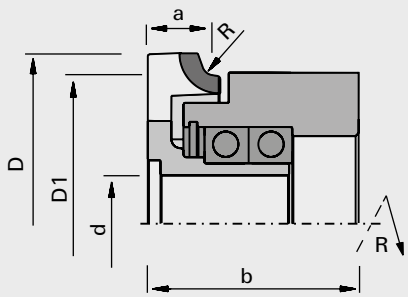
222582

DIAMAX Edge Rounding Cutters DP with copy wheel without torque support - Brandt

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Brandt
- for rounding of solid wood, veneer and plastic edge bands

Design

- cutter with integrated follower function
- bearing by means of roller bearing
- n max = 18,000 min-1

Advantages

- high precision and good cutting results thanks to integrated copy wheel

Notes

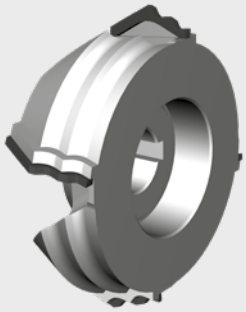
- constant basic dimensions a and D1
- for this application only one sense of rotation is required
- sense of rotation according to VDMA 8849

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [R]
2,0	58	49,9	11	32.5	16	4	185360 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

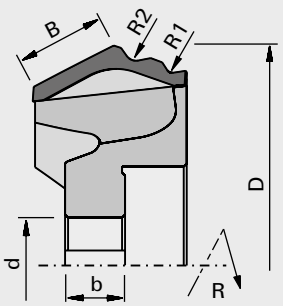
222882

DIAMAX Edge Multiprofile Cutter CM DP - Homag (Brandt)

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- Homag (Brandt) edge banding machine with dual-profile technology
- For rounding of soft-wood, hard-wood, veneer and plastic edge bands

Design

- with shear angle
- polished face
- High-finish clearance angle
- n max=24,000 min-1

Advantages

- Very long edge life compared to the HW cutterhead version
- Optimized chip removal thanks to ChipMeister version
- No contamination of the machine with chips
- No malfunctions due to chips
- Reduction of the extraction output
- Low noise level

Notes

- Sense of rotation according to VDMA 8849

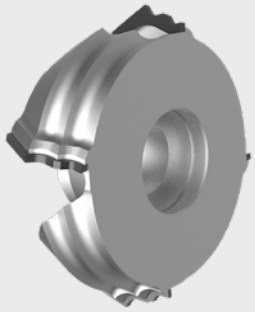
B	R1	R2	Ø D	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
14	1.0	2.0	74.24	10	16	4	5x2,3	186471 L	186472 L
14	1.3	1.3	74.67	10	16	4	5x2,3	186757 C	186758 C
14	1.3	2.0	74.24	10	16	4	5x2,3	186477 C	186478 C
14	1.3	3.0	74.24	10	16	4	5x2,3	186473 C	186474 C
14	1.5	2.0	74.24	10	16	4	5x2,3	186475 C	186476 C
14	2.0	2.0	74.67	10	16	4	5x2,3	186755 C	186756 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

B	Chamfer∢	R1	Ø D	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
14	45	1.0	74.67	10	16	4	5x2,3	186749 C	186750 C
14	45	1.3	74.67	10	16	4	5x2,3	186751 C	186752 C
14	45	1.5	74.67	10	16	4	5x2,3	186753 C	186754 C
14	45	2.0	74.67	10	16	4	5x2,3	186747 C	186748 C
[mm]	[°]	[mm]	[mm]	[mm]	[mm]		[mm]		

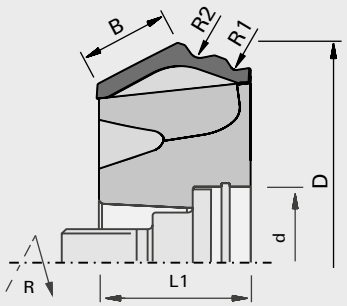
222882

DIAMAX Edge Multiprofile Cutter CM DP HSK 25R - Homag (Brandt) MS 40

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- Homag (Brandt) edge banding machine with dual-profile technology and MS 40 aggregate
- For rounding of soft-wood, hard-wood, veneer and plastic edge bands

Design

- with shear angle
- polished face
- High-finish clearance angle
- n max=24,000 min-1

Advantages

- Very long edge life compared to the HW cutterhead version
- Optimized chip removal thanks to ChipMeister version
- No contamination of the machine with chips
- No malfunctions due to chips
- Reduction of the extraction output
- Low noise level

Notes

- Sense of rotation according to VDMA 8849

B	R1	R2	Ø D	Ø d	L1	Z	Ident-No. [L]	Ident-No. [R]
14	1.0	2.0	74.67	HSK 25R	25.28	4	80476484 L	80476483 L
14	1.3	1.3	74.67	HSK 25R	25.28	4	80476486 C	80476485 C
14	1.3	2.0	74.67	HSK 25R	25.28	4	80476488 L	80476487 L
14	1.3	3.0	74.67	HSK 25R	25.28	4	80476490 C	80476489 C
14	1.5	2.0	74.67	HSK 25R	25.28	4	80476492 L	80476491 L
14	2.0	2.0	74.67	HSK 25R	25.28	4	80476494 C	80476493 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

B	Chamfer◁	R1	Ø D	Ø d	L1	Z	Ident-No. [L]	Ident-No. [R]
14	45	1.0	74.67	HSK 25R	25.28	4	80476496 C	80476495 C
14	45	1.3	74.67	HSK 25R	25.28	4	80476498 C	80476497 C
14	45	1.5	74.67	HSK 25R	25.28	4	80476500 C	80476499 C
14	45	2.0	74.67	HSK 25R	25.28	4	80476502 C	80476501 C
[mm]	[°]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

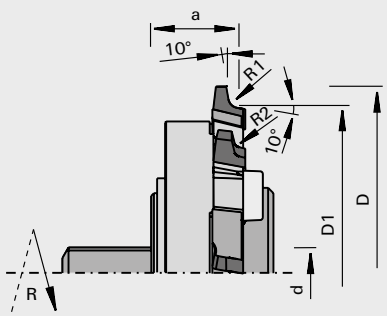
223882

DIAMAX Edge Rounding Cutters CM DP HSK 25R - flexClick - Homag

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- Homag edge banding machines for shaping units MF50, MF60
- for rounding and / or chamfering of MDF boards and plastic edge bands

Design

- 2-profile tool inclusive adjustment mechanics
- polished face
- high-finish clearance angle
- with shear angle
- runout angle 10°
- n max=13,000 rpm

Advantages

- combination of 2 different profiles
- simple profile change possible without disassembling the tool
- excellent cutting quality thanks to high radial running accuracy and precise tool balancing
- optimized chip removal thanks to ChipMeister version

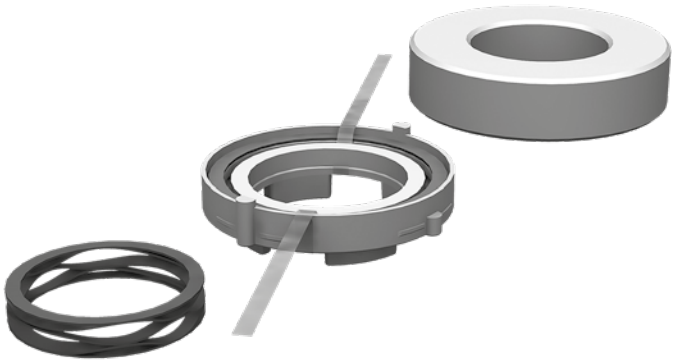
Notes

- further combinations on request
- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849

R1	R2	Ø D	Ø D1	a	Ø d	Z	Ident-No. [L]	Ident-No. [R]
2.0	1.0	70	62	16.5	HSK 25R	4	186203 L	186204 L
2.0	1.3	70	62	16.5	HSK 25R	4	186201 L	186202 L
2.0	1.5	70	62	16.5	HSK 25R	4	186199 C	186200 C
3.0	1.3	70	62	16.5	HSK 25R	4	186197 L	186198 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

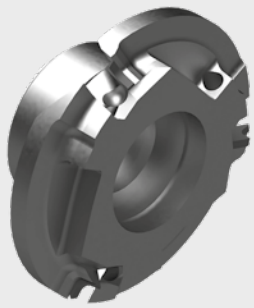
Spare parts	Dimension	Class-No.	PU	Ident-No.
Maintenance kit flexClick	For flexClick edge trimming cutterheads with clockwise rotation	997100	1	186981 L
Maintenance kit flexClick	For flexClick edge trimming cutterheads with counter-clockwise rotation	997100	1	186982 L
			[pc.]	



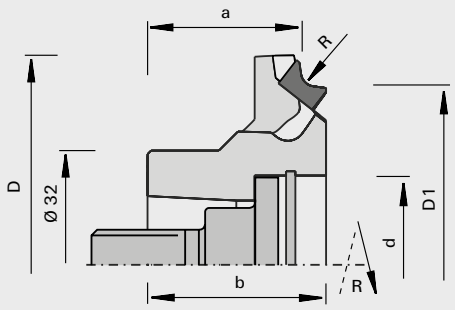
222882

DIAMAX Edge Rounding Cutters CM DP HSK 25R - HOLZ-HER FF502 - AirStream-System

Product



Drawing



AIR STREAM

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines HOLZ-HER aggregate FF502
- for rounding of solid wood, veneer and plastic edge bands

Design

- AirStream-System
- with shear angle
- polished face and high-finish clearance angle
- n max = 18,000 min-1

Advantages

- considerably increased chip caption degree thanks to AirStream-System
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- very low noise level

Notes

- constant basic dimensions a and D1
- sense of rotation according to VDMA 8849
- not for resharpening

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No.
1,0	58.7	50	21.5	25	HSK 25R	3	80477406 C
1,3	58.7	50	21.5	25	HSK 25R	3	80477407 L
1,5	58.7	50	21.5	25	HSK 25R	3	80477408 C
2,0	58.7	50	21.5	25	HSK 25R	3	80472258 L
3,0	58.7	50	21.5	25	HSK 25R	3	80477409 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

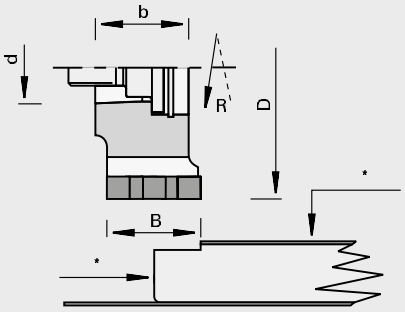
222020

Panel Raising Cutters DP HSK 25R Postforming for inlay profiles - Homag

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application
- postforming machines Homag
- for panel raising of melamine-, paper-, HPL-laminated and veneered panels during the direct postforming process

Design
- resharpenable area 3.5 mm
- inside edge Z = 9 resp. Z = 12
- shear angle and extreme division of cutting pressure
- n max = 24,000 min-1

Advantages
- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing
- no need for extra scoring station

Notes
- with inlay profiles
- application with feed
- * tracing with copy wheel
- sense of rotation see drawing

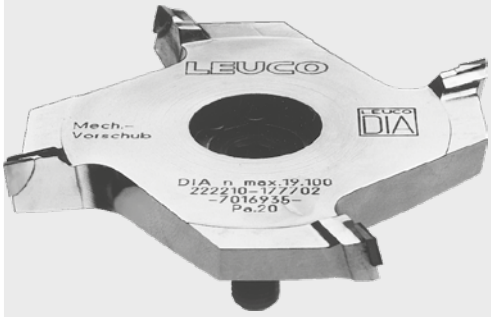
Ø D	B	b	Ø d	Z	Recommended feed	Ident-No. [L]	Ident-No. [R]
70	25	28	HSK 25R	9+3+3	25	179020 S	179019 S
70	25	28	HSK 25R	12+6+6	35	180464 C	180463 C
[mm]	[mm]	[mm]	[mm]		[m/min]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

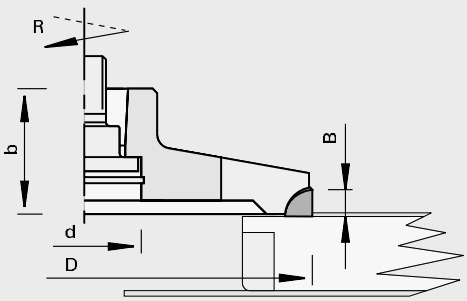
222020

Panel Raising Cutters DP HSK 25R Postforming for U and L profiles - Homag

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application
- postforming machines Homag
- for panel raising during the direct postforming process

Design
- with shear angle
- resharpenable area 3.5 mm
- n max = 24,000 min-1

Advantages
- optimum cutting quality thanks to high concenctric accuracy and precise tool balancing

Notes
- for panel raising of the U profile and flush-cutting of the L profile
- application against feed
- sense of rotation according to VDMA 8849

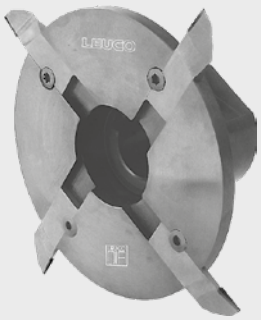
Ø D	B	b	Ø d	Z	Ident-No. [R]
100	5,0	28	HSK 25R	4	177702 S
[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

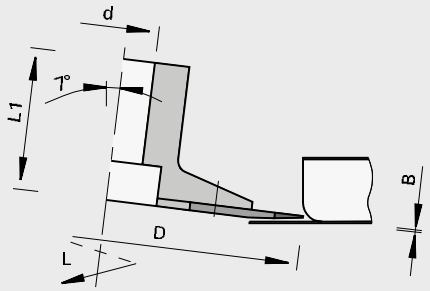
209080

Scribing Cutterheads DP Postforming - Homag, IMA

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- postforming machines Homag, IMA
- for scribing of the radii during the postforming process

Design

- exchangeable cutting edges
- straight cutter axis
- tooth configuration: symmetrical design for all radii
- n max = 9,000 min-1

Advantages

Notes

- for use without inlay strip
- application against feed
- LEUCODIA cutter inserts to be installed only in sets (packing unit 4 pieces)
- B=0.5 mm not recommended for butted-up workpieces; in this case B=1.2 mm should be used instead
- sense of rotation see drawing

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

Spare parts	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
LEUCODIA inserts "B" 0.5 mm with countersunk screws	232921	4	180063 L	180064 L
LEUCODIA inserts "B" 0.8 mm with countersunk screws	232921	4	180959 C	180960 C
LEUCODIA inserts "B" 1.2 mm with countersunk screws	232921	4	180834 C	180835 C
Countersunk Screws	995125	10		178722 L
Screwdrivers	985730	1		171188 L
		[pc.]		

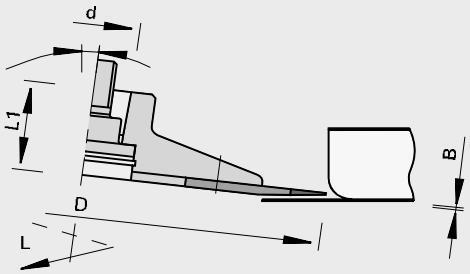
209080

Scribing Cutterheads DP HSK 25R Postforming - Homag

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- postforming machines Homag
- for scribing of the radii during the postforming process

Design

- cutting edges parallel to cutter axis
- tooth configuration: symmetrical design for all radii
- n max = 9,000 min-1

Advantages

- optimum cutting quality thanks to high concentric and runout accuracy and precise tool balancing

Notes

- for use without inlay strip
- application against feed
- LEUCODIA cutter inserts to be installed only in sets (packing unit 4 pieces)
- B=0.5 mm not recommended for butted-up workpieces; in this case B=1.2 mm should be used instead
- sense of rotation see drawing

Ø D	B	Ø d	L1	Z	DKN	Ident-No. [L]	Ident-No. [R]
125	0,5	HSK 25R	26	4		180075 S	180076 S
125	0,8	HSK 25R	26	4		180957 S	180958 S
125	1,2	HSK 25R	26	4		180832 S	180833 S
[mm]	[mm]	[mm]	[mm]		[mm]		

Spare parts	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
LEUCODIA inserts "B" 0.5 mm with countersunk screws	232921	4	180063 L	180064 L
LEUCODIA inserts "B" 0.8 mm with countersunk screws	232921	4	180959 C	180960 C
LEUCODIA inserts "B" 1.2 mm with countersunk screws	232921	4	180834 C	180835 C
Screws	995190	1		177780 L
Shim Rings	995440	10		177781 L
Locking Rings	995460	10		177782 L
Countersunk Screws	995125	10		178722 L
Screwdrivers	985730	1		171188 L
		[pc.]		

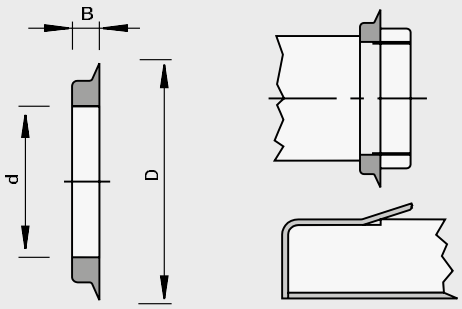
164507

Circular Knives solide carbide for edge trimming Softforming - Homag

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- machines Homag
- for cutting of softforming inlay profiles

Design

- LEUCODUR solid carbide circular knife

Advantages

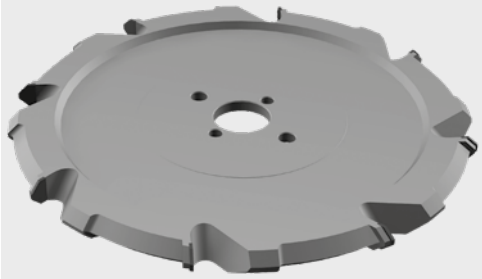
Notes

Ø D	B	Ø d	Ident-No.
40	3,0	25	172757 L
[mm]	[mm]	[mm]	

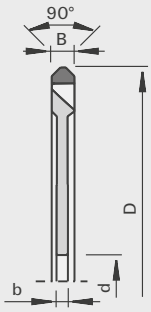
222065

DIAMAX V-groove profile cutters DP for aluminum composite materials

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MAN

Machine / Application
- vertical panel sizing saws
- for V-grooves in aluminum composite materials (Alucobond, Dibond, etc.)

Design
- cutting material: DP
- polished face
- high-finish clearance face
- milling cutter angle = 90°
- n max=5300 min-1

Advantages
- very long edge lives particularly in composite materials with mineral core
- Excellent cutting quality thanks to high concentric accuracy and precise tool balancing

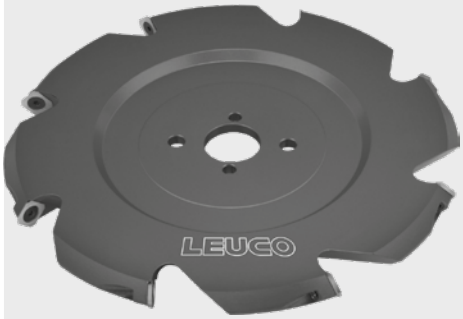
Notes

Ø D	B	b	Ø d	Z	Ident-No.
244	13	6.5	30	8	187124 L
[mm]	[mm]	[mm]	[mm]		

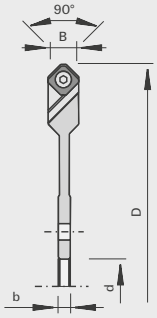
120405

V-groove profile cutterheads HW for aluminum composite materials - HOLZ-HER

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application
- vertical panel sizing saws
- for the production of facade elements, frames, corner elements from aluminum composite material, gutbond etc.

Design
- anodized aluminum body
- cutting material: HL Solid 40

Advantages
- consistent cutting circles thanks to turnover knives
- simple handling thanks to quick knife change

Notes
- attachment screw for turnover knives executed with two Torx; T15 from front and T10 from back

Ø D	B	b	Ø d	Z	Ident-No.
244	16,5	6.5	30	8	182616 L
[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	14	14	2.0	151553	10	182079 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x9 T10 / T15	995125	10	879309 L
Screwdrivers with handle	T10x80	985730	1	879329 C
Screwdrivers	T15x80	985730	1	171188 L
	[mm]		[pc.]	

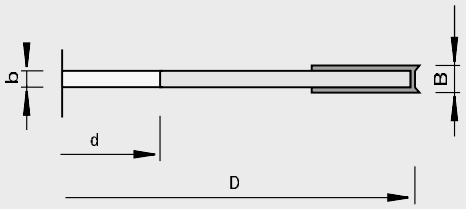
120455

Grooving Cutterheads HW

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- table shapers
- for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

- application against feed with and across the grain

Ø D	B	b	Ø d	Ø dmax	Z	nmin-nmax	Ident-No.
125	4,0	3.0	30	40	4+4	6500-11000	167253 L
125	5,0	4.0	30	40	4+4	6500-11000	165922 C
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

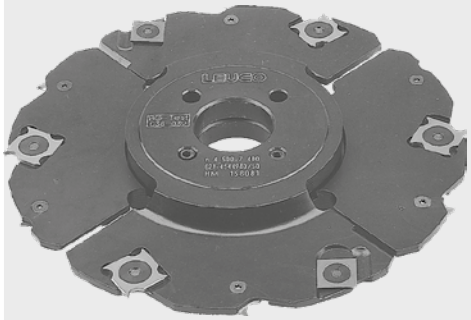
Turnover Knives		B	H	S	Class-No.	PU	Ident-No.
Spurs		14	14	1.2	150558	10	163701 L
Turnover Knives	for B = 4	18	18	1.95	150508	10	163699 L
Turnover Knives	for B = 5	18	18	2.5	150508	10	165906 L
		[mm]	[mm]	[mm]		[pc.]	

Spare parts		Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Countersunk Screws		M4x0,5x3,2 T9 D=Ø6	167253	995125	10	163925 L
Countersunk Screws		M4x0,5x4,2 T9 D=Ø6	165922	995125	10	165908 L
Special Nuts	for spurs	M4x0,5x1,6	For all	995290	10	163704 L
Special Nuts	for profile knives	M4x0,5x2,2	167253	995290	10	163703 L
Special Nuts	for profile knives	M4x0,5x2,75	165922	995290	10	165907 L
Screwdrivers		T9	For all	985730	1	164344 L
		[mm]				

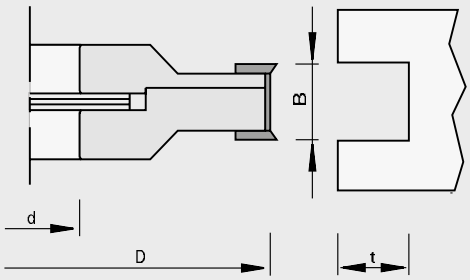
121455

Grooving Cutterheads HW - adjustable 4-15 mm

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- table shapers
- molders
- double end tenoners
- for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

- application against feed with and across the grain
- cutting width 4 - 7.5 mm two-piece
- cutting width 4 - 15 mm three-piece
- cutting width adjustable with shims in 0.1 mm increments
- single cutterheads and spacers secured against rotation with pins

Ø D	B	Ø d	Tmax	Z	DKN	nmin-nmax	Ident-No.
130	4,0-7,5	30	25	4+4		6000-10000	166509 L
180	4,0-7,5	30	35	8+4		4500-7400	168081 L
180	4,0-7,5	35	35	8+4	10x4	4500-7400	168083 C
180	4,0-7,5	40	35	8+4	12x5	4500-7400	168085 C
180	4,0-7,5	50	30	8+4		4500-7400	168087 C
180	4,0-15	30	35	8+2+4		4500-7400	168080 O
180	4,0-15	35	35	8+2+4	10x4	4500-7400	168082 C
180	4,0-15	40	35	8+2+4	12x5	4500-7400	168084 C
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

Turnover Knives	B	H	S	For Ident-No.	Class-No.	PU	Ident-No.
Turnover Knives	7,5	12	1.5	168080, 168082, 168084	150515	10	052543 L
Spurs	14	14	1.2	For all	150558	10	163701 L
Turnover Knives	18	18	1.95	For all	150508	10	163699 L
	[mm]	[mm]	[mm]			[pc.]	

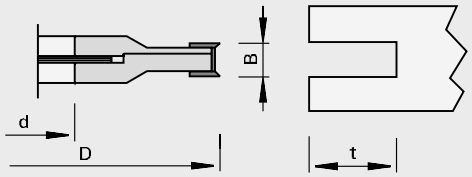
Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=7,2	168080, 168082, 168084	925300	2	168074 L
Set Screws	M5x12 DIN EN ISO 4028	168080, 168082, 168084	995161	10	050565 L
Countersunk Screws	M4x0,5x3,2 T9 D=Ø6	For all	995125	10	163925 L
Spacer Sets	50x3,5x30	166509	955521	1	166367 O
Spacer Sets	65x3,5x30	168080, 168081	955521	1	168075 L
Spacer Sets	70x3,5x35	168083, 168082	955521	1	168076 C
Spacer Sets	70x3,5x40	168084, 168085	955521	1	168077 C
Spacer Sets	90x3,5x50	168087	955521	1	168078 C
Special Nuts for spurs	M4x0,5x1,6	For all	995290	10	163704 L
Special Nuts for profile knives	M4x0,5x2,2	For all	995290	10	163703 L
Screwdrivers	SW2,5x100	168080, 168082, 168084	985730	1	168010 L
Screwdrivers	T9	For all	985730	1	164344 L
	[mm]				

121455

Grooving Cutterheads HW - adjustable 8-24 mm

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- table shapers
- molders
- double end tenoners
- for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

- application against feed with and across the grain
- cutting width 8 - 15 mm and 12,6 - 24 mm two-piece
- cutting width adjustable with shims in 0.1 mm increments
- single cutterheads and spacers secured against rotation with pins

Ø D	B	Ø d	Tmax	Z	DKN	nmin-nmax	Ident-No.
180	8,0-15	30	35	4+4		4500-7400	178725 L
180	8,0-15	35	35	4+4	10x4	4500-7400	178726 C
180	8,0-15	40	35	4+4	12x5	4500-7400	178727 C
180	12,6-24	30	40	4+4		4500-7400	178729 L
180	12,6-24	35	40	4+4	10x4	4500-7400	178730 C
180	12,6-24	40	40	4+4	12x5	4500-7400	178731 C
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

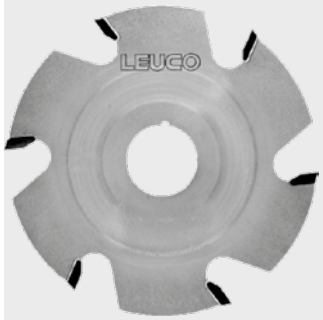
Turnover Knives	B	H	S	For Ident-No.	Class-No.	PU	Ident-No.
Spurs	14	14	2.0	For all	150558	10	003079 L
Turnover Knives	7,5	12	1.5	178725, 178726, 178727	150515	10	052543 L
Turnover Knives	12	12	1.5	178729, 178730, 178731	150515	10	003080 L
	[mm]	[mm]	[mm]			[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=10	178729, 178730, 178731	925300	2	164526 L
Pressure Bars	B=7,2	178725, 178726, 178727	925300	2	168074 L
Countersunk Screws	M5x6 T20 D=Ø9,3	For all	995125	10	176199 L
Set Screws	M5x12 DIN EN ISO 4028	178725, 178726, 178727	995161	10	050565 L
Set Screws	M6x12 DIN EN ISO 4028	178729, 178730, 178731	995161	10	180214 L
Spacer Sets	65x11,5x30	178729	955521	1	167278 C
Spacer Sets	70x11,5x35	178730	955521	1	167279 S
Spacer Sets	70x11,5x40	178731	955521	1	167280 C
Spacer Sets	65x7x30	178725	955521	1	167282 O
Spacer Sets	70x7x35	178726	955521	1	167283 S
Spacer Sets	70x7x40	178727	955521	1	167284 S
Screwdrivers	SW3x100	178729, 178730, 178731	985730	1	166090 L
Screwdrivers	SW2,5x100	178725, 178726, 178727	985730	1	168010 L
Screwdrivers	T20x100	For all	985730	1	166092 L
Adjusting Gauges	0,3	For all	985200	1	055883 L
	[mm]			[pc.]	

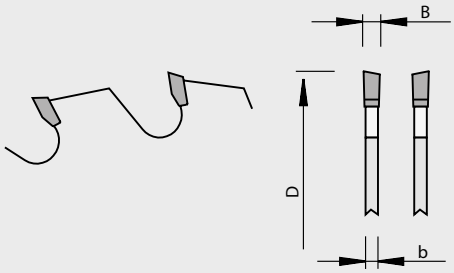
109085

Grooving Cutters HW - for Lamello®

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- machines Lamello®, ELU
- for chip-free grooving of Lamello® wood joints in solid woods and in wood-based panels

Design

Advantages

Notes

- application against feed with and across the grain

Ø D	B	b	Ø d	Z	NL	nmin-nmax		Ident-No.
100	4,0	3.45	22	6 WS	4/4,5/36	7600-13000	Lamello®	189095 L
102	3,85	3.0	22	12 WS		7500-13100	ELU DS 140	188358 L
[mm]	[mm]	[mm]	[mm]			[min-1]		

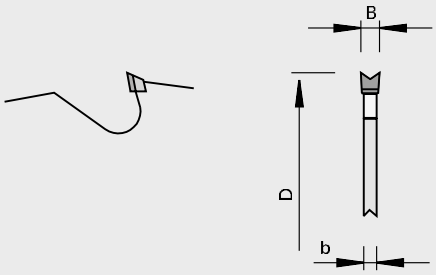
209285

Grooving Cutters DP - for Lamello®

Product



Drawing



LEUCO DIAMAX

Polycrystalline diamond [DP]

MAN

Machine / Application

- machines Lamello®
- for chip-free grooving of Lamello® wood joints in solid woods and in wood-based panels

Design

- reduced resharpenable area
- tooth configuration: concave

Advantages

Notes

- application against feed with and across the grain

Ø D	B	b	Ø d	Z	NL	nmin-nmax	Ident-No.
100	3,95	4.0	22	4	4/4,3/36	7000-13300	178496 L
[mm]	[mm]	[mm]	[mm]			[min-1]	

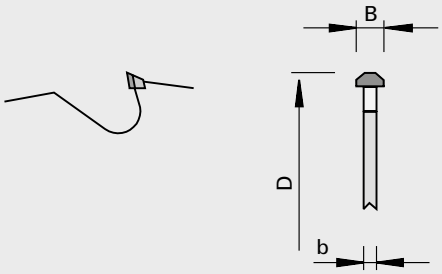
222240

Grooving Cutters DP - for Lamello Clamex P® - MEC

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application
- CNC machining centers
- for chip-free grooving for Lamello Clamex P® joints in solid woods and wood-based panels

Design
- not resharpenable
- tooth configuration: specific

Advantages

Notes
- application against feed with and across the grain
- can be used on CNC machines as a grooving cutter
- Mosquito Through-Hole Bits VHW for Lamello Clamex P® see chapter Drill Bits

Ø D	B	b	Ø d	Z	NL	nmax		Ident-No.
100.4	7,0	4.0	30	3	4/6,6/48	15200		189711 L
100.4	7,0	4.0	35	3	4/5,5/50	15200	Biesse	186094 L
100.4	7,0	4.0	40	3	4/5,5/52	15200	Homag FLEX 5 / FLEX 5+	186093 L
[mm]	[mm]	[mm]	[mm]			[min-1]		

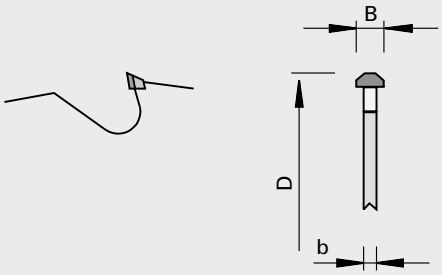
222245

Grooving Cutters DP for Lamello Clamex P® - MAN

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MAN

Machine / Application
- Lamello Zeta P2
- for chip-free grooving for Lamello Clamex P® joints in solid woods and wood-based panels

Design
- not resharpenable
- tooth configuration: specific

Advantages

Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
100.4	7,0	4.0	22	3	4/4,3/36	Lamello Zeta P2	186501 L
[mm]	[mm]	[mm]	[mm]				

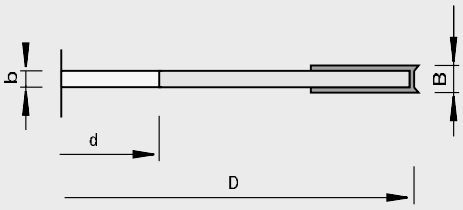
120455

Grooving Cutterheads HW - for Lamello®

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- machines Lamello®
- for chip-free grooving of Lamello® wood joints in solid woods and in wood-based panels

Design

Advantages

Notes

- application against feed with and across the grain

Ø D	B	b	Ø d	Z	NL	nmin-nmax	Ident-No.
100	4,0	4.0	22	4+4	4/4,5/36	7700-13300	164838 L
[mm]	[mm]	[mm]	[mm]			[min-1]	

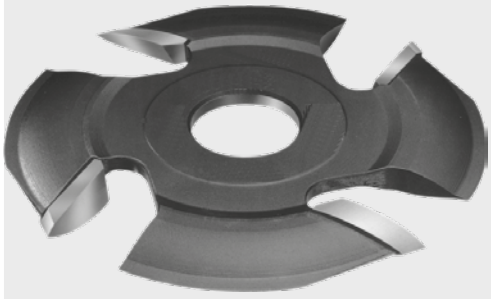
Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Spurs	14	14	1.2	150558	10	163701 L
Turnover Knives	18	18	1.95	150508	10	163699 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts		Dimension	Class-No.	PU	Ident-No.
Countersunk Screws		M4x0,5x3,2 T9 D=Ø6	995125	10	163925 L
Special Nuts	for profile knives	M4x0,5x2,2	995290	10	163703 L
Special Nuts	for spurs	M4x0,5x1,6	995290	10	163704 L
Screwdrivers		T9	985730	1	164344 L
		[mm]		[pc.]	

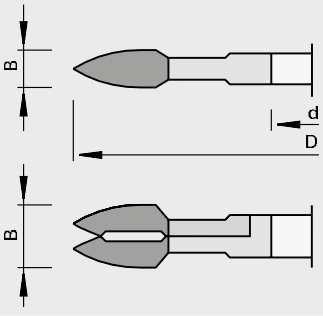
122415

Cutters HW for removing resin pockets

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- Mini-Spot machines
- for cutting out defects in solid woods

Design

- with alternating shear angle

Advantages

Notes

- for patch sizes 1-4

Ø D	B	Ø d	Z	NL	nmin-nmax	Ident-No.
100	8,0	22	4	4/4,3/36	7700-13300	180469 L
100	15	22	4		7700-13300	70176420 S
[mm]	[mm]	[mm]			[min-1]	

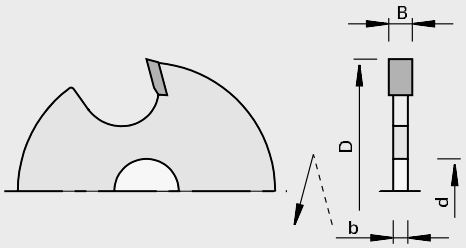
109015

Grooving Cutters HW - portable routers

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application
- portable routers
- for grooving in solid woods and wood-based panels

Design
- two brazed flat-tooth cutting edges

Advantages

Notes
- clamping elements: cutter arbor

Ø D	B	b	Ø d	Z	nmax	Ident-No.
40	1,8	1.0	8,0	2	24000	001367 C
40	2,0	1.2	8,0	2	24000	001370 L
40	2,5	1.5	8,0	2	24000	001374 L
40	3,0	2.0	8,0	2	24000	001377 L
40	3,5	2.5	8,0	2	24000	001380 L
40	4,0	3.0	8,0	2	24000	001383 L
[mm]	[mm]	[mm]	[mm]		[min-1]	

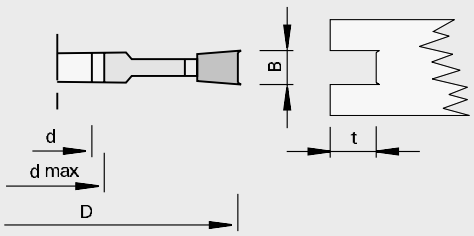
Spare parts	Dimension	Class-No.	PU	Ident-No.
Mounting arbors	8x8	997200	1	160363 L
	[mm]		[pc.]	

122455

Grooving Cutters HW with spur

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application
- stationary milling centers
- table shapers against feed
- for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes
- application with and across the grain
- cutting width = hub width

Ø D	B	Ø d	Ø dmax	Tmax	Z	nmin-nmax	Ident-No.
140	4,0	30	50	33	4+4	5400-9000	198032 C
140	10	30	50	33	4+4	5400-9000	198036 S
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

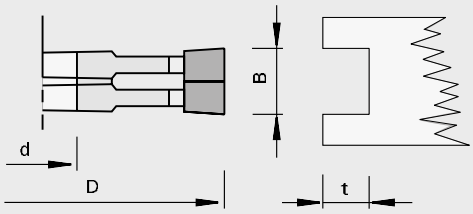
123455

Grooving Cutter Set HW

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- table shapers
- molders
- double end tenoners
- for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

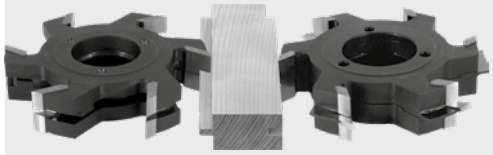
- application with and across the grain (solid wood)
- cutting width adjustable with shims in 0.1 mm increments

Ø D	B	Ø d	Tmax	Z	KN	nmin-nmax	Ident-No.
120	1,8 - 3,4	30	18	4+4		6400-10000	006188 C
120	2,2-4,0	30	18	4+4		6400-10000	006189 C
150	4,0-7,5	30	37	4+4		5200-9000	006190 C
150	7,5-14,5	30	37	4+4		5200-9000	006191 C
140	2,2-4,0	30	20	4+4		5400-9000	171136 L
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

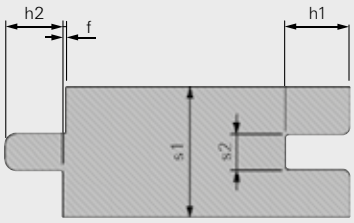
323500

Tongue and Groove Tools HS

Product



Drawing



LEUCO DUR

High Speed Steel [HS]

MEC

Machine / Application

- molders
- double end tenoners
- for tongue and groove board with or without space allowance in material (=open joint) or chamfer in soft and hard woods

Design

- body made from steel
- adjustable by means of spacers
- highest precision thanks to plane parallelism of all parts
- secured against rotation by means of 3 driving pins on minor diameter 75 mm

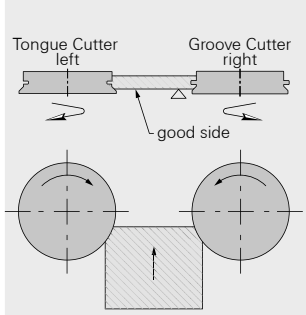
Advantages

Notes

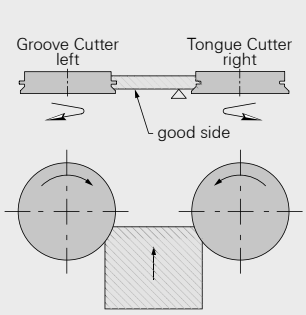
- indicate sense of rotation, direction of feed and face side according to diagram I, II, III or IV when placing an order
- without indications we will deliver according to diagram I
- delivery with HW-tipping possible with surcharge

Profile	Ø D	B	Ø d	nmax	s1	s2	f	Z	Ident-No.
501/502	180	35	40	8000	12-36	4,5-7,5	0,5	6	58532354 C
505/506	180	35	40	8000	15-27	4,5-7,5	0,5	6	58532358 S
512/513	180	35	40	8000	12-27	4,5-7,5		6+3	58532361 S
503/502	180	35	40	8000	12-36	4,5-7,5		6	58532382 S
529/530	180	35	40	8000	15-27	4,5-7,5	0,5	6	58532384 S
507/508	180	35	40	8000	15-27	4,5-7,5		6	58532387 S
525/526	180	35	40	8000	12-27	4,5-7,5		6+3	58532390 S
541/540	180	35	40	8000	14-19	4,5-7,5		6+3	58532391 S
	[mm]	[mm]	[mm]	[min-1]	[mm]	[mm]	[mm]		

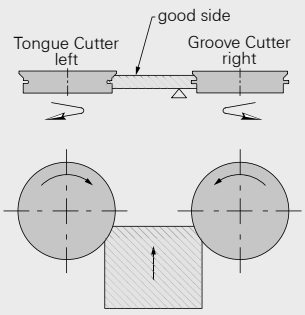
Example I



Example II



Example III



Example IV

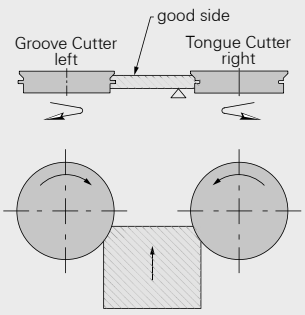
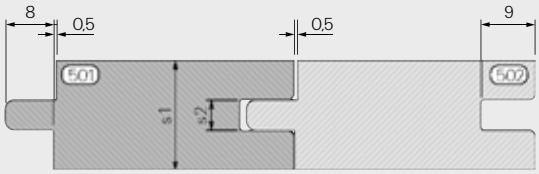


Diagram I

Tongue Cutters

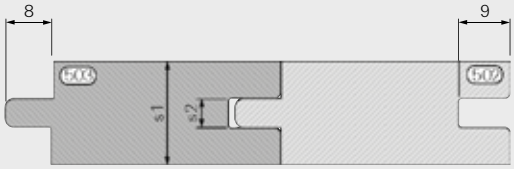
Grooving Cutters

Profile 501



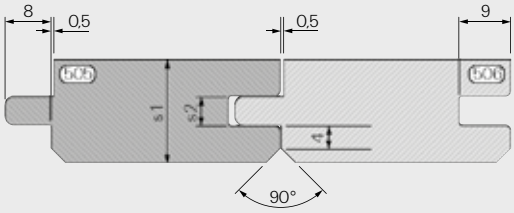
Profile 502

Profile 503



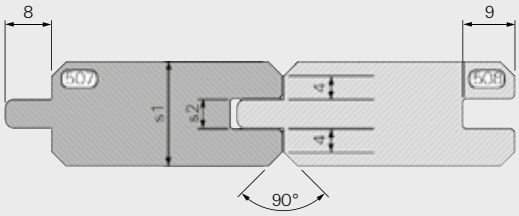
Profile 502

Profile 505



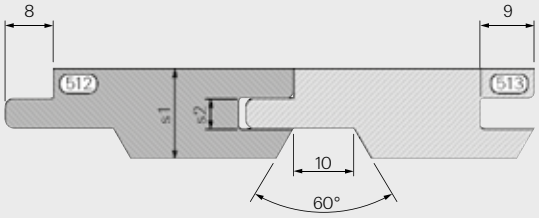
Profile 506

Profile 507



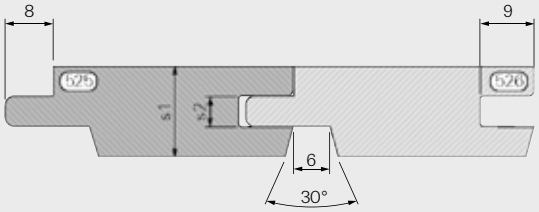
Profile 508

Profile 512



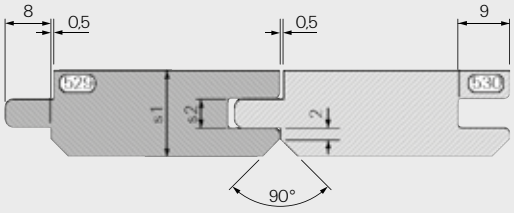
Profile 513

Profile 525



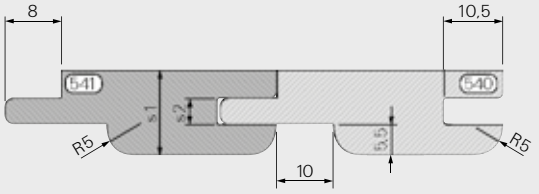
Profile 526

Profile 529



Profile 530

Profile 541



Profile 540

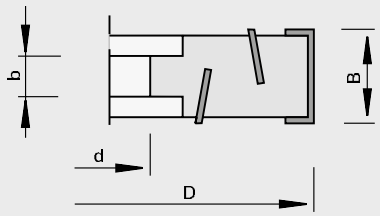
120215

Jointing Cutterheads HW

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- table shapers
- for chip-free jointing of plastic-laminated panels

Design

- opposing shear angle
- cutting material: HW HL Board 05

Advantages

Notes

- application against feed with and across the grain

Ø D	B	b	Ø d	Z	DKN	nmin-nmax	Ident-No.
100	34	35	30	3+3	8x3	7700-13300	171972 C
125	56	54	30	3+3	8x3	6100-10500	177004 L
150	56	54	30	3+3	8x3	5200-8800	177006 C
180	56	25	35	3+3	10x4	4200-7200	177002 C
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	20	12	1.5	150515	10	003082 L
	30	12	1.5	150515	10	003083 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=17	171972	925300	2	167971 L
Pressure Jaws	28x11x6	177002, 177004, 177006	925300	2	180344 L
Clamping Pieces	12x8,5/M6L	177002, 177004, 177006	925100	2	180356 L
Set Screws	M8x12 DIN EN ISO 4028	171972	995161	10	180001 L
Clamping Set Screws	M6/M6Lx20 T15	177002, 177004, 177006	995195	10	50930405 L
Screwdrivers	SW4x100	171972	985730	1	166091 L
Screwdrivers	T15x80	177002, 177004, 177006	985730	1	171188 L
	[mm]			[pc.]	

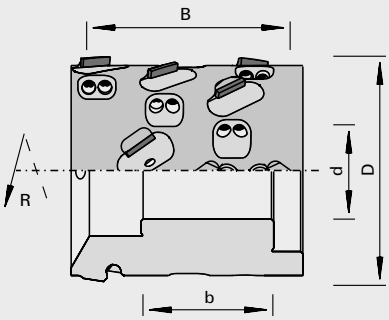
222220

DIAMAX Jointing Cutters DP - HOLZ-HER - AirStream-System

Product



Drawing



AIR STREAM

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- through feed machines HOLZ-HER aggregate 1801 / 1802 / 1804
- for extremely noise-reduced, chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- with patented AirStream-System
- symmetrical and asymmetrical design
- 35° shear angle
- resharpening area 1.5 mm

Advantages

- optimal glueing of edges
- extremely noise and flow-optimized thanks to AirStream-System
- considerably increased chip caption degree thanks to AirStream-System
- increase of edge life thanks to reduction of multiple hogging
- less chips remain inside of the machine
- high cutting quality thanks to large shear angle

Notes

- compatible with Pro Lock clamping on older aggregates
- sense of rotation according to VDMA 8849

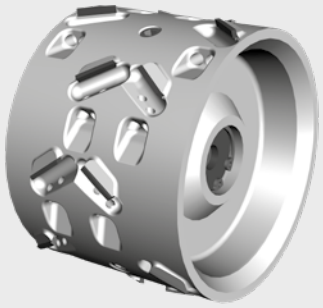
Ø D	B	b	Ø d	Z	DKN	nmax			Ident-No. [L]	Ident-No. [R]
70	48	41	30	2+2	8x3,3	18000	HOLZ-HER aggregate 1801 / 1802	asymmetrical	185800 L	185801 L
70	64	41	30	2+2	8x3,3	18000	HOLZ-HER aggregate 1801 / 1802	asymmetrical	185802 L	185803 L
70	48	41	30	3+3	8x3,3	18000	HOLZ-HER aggregate 1801 / 1802	asymmetrical	185806 C	185807 C
70	64	41	30	3+3	8x3,3	18000	HOLZ-HER aggregate 1801 / 1802	asymmetrical	185808 C	185809 C
100	63	40	30	3+3	8x3,3	18500	HOLZ-HER aggregate 1804	symmetrical	186937 L	186936 L
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]				

Accessories	Dimension	Class-No.	PU	Ident-No.
Face spanner	14-100/5	985720	1	187136 L
	[mm]		[pc.]	

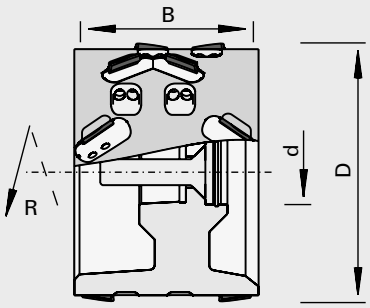
222220

DIAMAX Jointing Cutters DP HSK 32R - HOLZ-HER - AirStream-System

Product



Drawing



AIR STREAM

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- through feed machines HOLZ-HER aggregate FG701
- for extremely noise-reduced, chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- With patented AirStream-System
- Symmetrical design
- 35° shear angle
- Integrated balance screws
- HSK 32R
- Resharpening area 1.5 mm

Advantages

- Optimal glueing of edges
- Very low noise levels and optimized flow thanks to AirStream-System
- Significantly increased chip caption degree thanks to AirStream-System
- Increased edge life thanks to reduction of multiple hogging and best concentricity
- Reduced contamination of the machine with chips
- Excellent cutting quality thanks to large shear angle and best concentricity

Notes

- sense of rotation according to VDMA 8849

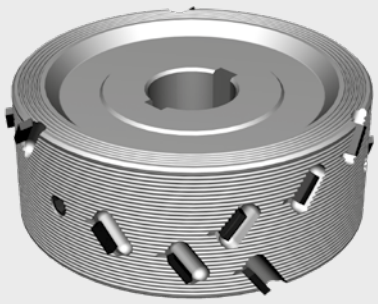
Ø D	B	b	Ø d	Z	nmax			Ident-No. [L]	Ident-No. [R]
100	42,3	34	HSK 32R	3+3	18500	HOLZ-HER FG701	symmetrical	187624 L	187629 L
100	63	34	HSK 32R	3+3	18500	HOLZ-HER FG701	symmetrical	186939 L	186938 L
[mm]	[mm]	[mm]	[mm]		[min-1]				

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M10x40-10.9 SW6 ISO 10642	995121	1	186761 L
Reducing Rings	25x3x9	955530	1	186762 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
	[mm]		[pc.]	

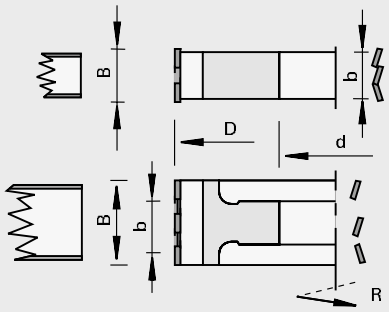
222220

DIAMAX airFace Jointing Cutters DP

Product



Drawing



LEUCO diamax airface

Polycrystalline diamond [DP]

MEC

Machine / Application

- through feed machines
- edge banding machines
- for very quiet and chip-free jointing of solid wood and wood-based panels with and without coating, focusing particularly on the reduction of noise

Design

- steel body with airFace surface
- integrated balance screws
- reinforced DP cutting edges
- reduced gullet volume
- shear angle 35°
- resharpening area 1.5 mm

Advantages

- compared to the LowNoise version, additional noise reduction by -1 dB(A) through airFace design and reduced gullet volume
- good durability and high cutting quality thanks to large shear angle
- machining of 8-mm panels is possible without adjustment

Notes

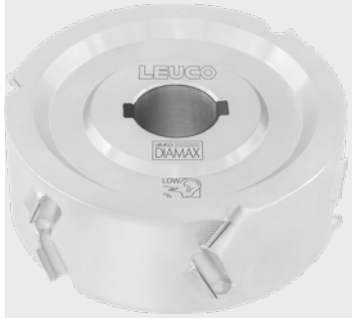
- possible to regenerate
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	DKN	nmax			Ident-No. [L]	Ident-No. [R]
60	64,5	62	25	2+2	8x3,3	24000	Felder/Format 4	asymmetrical	186382 L	186381 L
70	43,2	61	25	2+2	8x3,3	24000	EBM, Hebrock	asymmetrical	186380 C	186379 C
70	50,3	31	30	2+2	8x3,3	24000	HOLZ-HER 1801 (old)	asymmetrical	186390 C	186389 C
80	36	53	30	3+3	8x3,3	23300	Biesse	quasi symmetrical	186364 C	186364 C
80	64	53	30	3+3	8x3,3	23300	Biesse	symmetrical	186365 L	186365 L
80	43,2	53	30	3+3	8x3,3	23300	Biesse	symmetrical	186366 L	186366 L
80	64,5	62	25	2+2	8x3,3	23300	Felder/Format 4	asymmetrical	186384 C	186383 C
85	43,2	50	30	3+3	8x3,3	22000	Ott	asymmetrical	186408 L	186409 L
85	64,5	70	30	3+3	8x3,3	22000	Ott	asymmetrical	186410 C	186411 C
100	64	75	30	3+3	8x3,3	19000	Biesse	symmetrical	186367 C	186367 C
100	43,2	75	30	3+3	8x3,3	19000	Biesse	symmetrical	186368 C	186368 C
100	64,5	40.6	30	3+3	8x3,3	19000	Brandt	asymmetrical	186371 L	186372 L
100	43,2	40.6	30	3+3	8x3,3	19000	Brandt	asymmetrical	186373 L	186374 L
100	43,2	42	25	2+2	8x3,3	19000	Brandt Ambition 1110 F (KDF 110), 1120 FC (KDF 120 C)	asymmetrical	186376 C	186375 C
100	43,2	61	30	2+2	8x3,3	19000	EBM / Hebrock	asymmetrical	186378 L	186377 L
100	43,2	25	30	2+2	8x3,3	19000	HOLZ-HER up to 2008, SCM-Stefani	asymmetrical	186385 L	186386 L
100	64,5	60.6	30	3+3	8x3,3	19000	SCM-Stefani	asymmetrical	186412 L	186413 L
100	43,2	60.6	30	3+3	8x3,3	19000	SCM-Stefani	asymmetrical	186414 L	186415 L
100	64,5	25	30	2+2	8x3,3	19000	HOLZ-HER up to 2008, SCM-Stefani	asymmetrical	186387 L	186388 L
125	64,5	54	30	3+3	8x3,3	15000	Homag	asymmetrical	186391 C	186392 C
125	43,2	54	30	3+3	8x3,3	15000	Homag	asymmetrical	186395 L	186396 L
125	43,2	40	30	3+3	8x3,3	15000	Homag	symmetrical	186399 L	186399 L
125	64	40	30	3+3	8x3,3	15000	Homag	symmetrical	186400 L	186400 L
125	29	34	30	3+3	8x3,3	15000	Homag	symmetrical	186401 L	186401 L
125	36	40	30	3+3	8x3,3	15000	Homag	symmetrical	186402 L	186402 L
125	64,5	72	30	3+3	8x3,3	15000	IMA 08.378	asymmetrical	186393 C	186394 C
125	43,2	72	30	3+3	8x3,3	15000	IMA 08.378	asymmetrical	186397 O	186398 O
125	43,2	57	30	3+3	8x3,3	15000	IMA 08.379	asymmetrical	186404 C	186405 C
125	64,5	57	30	3+3	8x3,3	15000	IMA 08.379	asymmetrical	186406 C	186407 C
150	43,2	40	30	4+4	8x3,3	12000	Homag	symmetrical	186403 L	186403 L
150	64	40	30	4+4	8x3,3	12000	Homag	symmetrical	186519 L	186519 L
150	29	40	30	4+4	8x3,3	12000	Homag reference jointing (WZ10/WZ14), aggregate AF11/AW22/AW12	asymmetrical	186743 L	186744 L
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]				

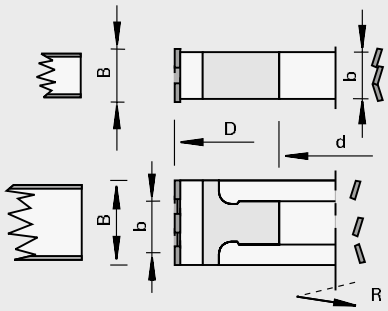
222220

DIAMAX Jointing Cutters DP LowNoise

Product



Drawing



LOW

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- through feed machines
- for noise-reduced, chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- symmetrical and asymmetrical design
- for left and right hand rotation
- opposing shear angle
- spiral cutting edges
- resharpening area 1.5 mm

Advantages

- optimal glueing of edges
- optimized as to noise level and chip flow

Notes

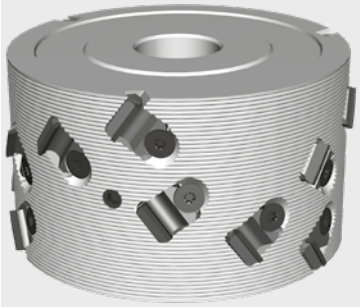
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	DKN	nmax			Ident-No. [L]	Ident-No. [R]
100	34	37.6	30	3+3	8x3,3	19000	IMA, Brandt	asymmetrical	184673 L	184672 L
100	53	25	30	2+2	8x3,3	18000	HOLZ-HER aggregate 1961	asymmetrical	182173 C	182172 C
125	43	40	30	3+3	8x3,3	15000	Homag	symmetrical	184029 L	184029 L
125	63	40	30	3+3	8x3,3	15000	Homag	symmetrical	184030 L	184030 L
150	43	40	30	4+4	8x3,3	12000	Homag reference jointing (WZ10/WZ14), aggregate AF11/AW22/AW12	asymmetrical	185258 L	185257 L
150	63	40	30	4+4	8x3,3	12000	Homag reference jointing (WZ10/WZ14), aggregate AF11/AW22/AW12	asymmetrical	184763 L	184764 L
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]				

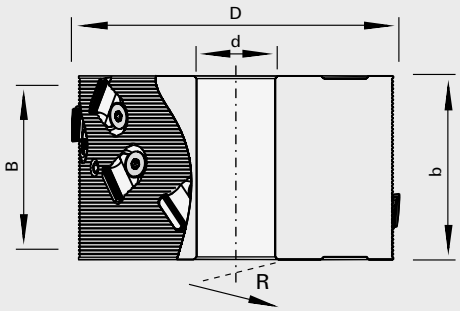
220225

DIAMAX SmartJointer airFace Jointing Cutterheads DP - MAN

Product



Drawing



LEUCO smart jointer airface

Polycrystalline diamond [DP]

MAN

Machine / Application

- table shapers
- For jump-milling units for very quiet jointing of solid wood and wood-based panels with and without coating, focusing particularly on diameter consistency and noise reduction

Design

- aluminum body with airFace surface
- with exchangeable stainless steel DP cutting edges
- DP cutting edges with integrated stainless steel gullet
- shear angle 35°
- resharpening area 1.5 mm

Advantages

- Additional noise reduction by up to -3 dB (A) thanks to the airFace design
- Reduced power consumption thanks to low-weight design with aluminum body
- Reduced spindle bearing load thanks to less unbalance
- Exchangeable DP cutting edges with wear-resistant exchangeable gullet
- Diameter consistency thanks to the use of new DP cutting edges
- Excellent cutting quality thanks to large shear angle
- Corrosion protection over the entire tool thanks to stainless steel segments

Notes

- Attention: when changing the cutting edges please observe operating instructions
- DP cutting edges packing unit 4 pieces
- plug insert packing unit 2 pieces
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	nmin-nmax		Number of cutting edges	Ident-No. [L]	Ident-No. [R]
125	43	49	30	3+3	6100-10500	symmetrical	12	186987 C	186987 C
125	64	70	30	3+3	6100-10500	symmetrical	18	186986 C	186986 C
[mm]	[mm]	[mm]	[mm]		[min-1]		[pc.]		

Spare parts		Dimension	Class-No.	PU	Ident-No.
DP cutting edges	Ø D=125 / 35°	17,2x14,2x8,9	232239	4	185974 L
		[mm]		[pc.]	

Spare parts / Accessories	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x13,5 T20	995125	10	185080 L
Plug Insert Torx	T20	985730	2	185293 L
Torque Screwdrivers	5,0 Nm	985730	1	185292 L
	[mm]		[pc.]	

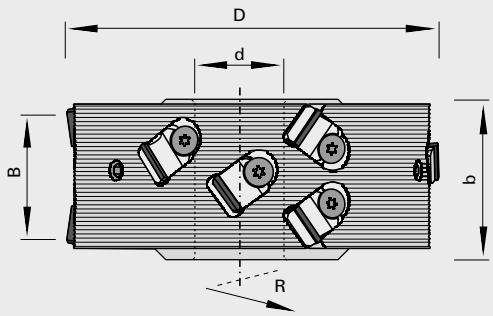
220220

DIAMAX SmartJointer airFace Jointing Cutterheads DP

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
- for jump-milling units for very quiet jointing of solid wood and wood-based panels with and without coating, focusing particularly on the reduction of unbalance and noise

Design

- aluminum body with airFace surface
- with exchangeable stainless steel DP cutting edges
- DP cutting edges with integrated stainless steel gullet
- shear angle 35°
- resharpening area 1.5 mm

Advantages

- additional noise reduction by up to -3 dB (A) thanks to the airFace design
- reduced power consumption thanks to low-weight design with aluminum body
- easy on spindle bearing thanks to less unbalance
- exchangeable DP cutting edges incl. wear-resistant exchangeable gullet
- excellent cutting quality thanks to large shear angle
- corrosion protection of the entire tool by stainless steel segments

Notes

- Attention: when changing the cutting edges please observe operating instructions
- DP cutting edges packing unit 4 pieces
- plug insert packing unit 2 pieces
- sense of rotation according to VDMA 8849

SmartJointer airFace Ø D=70 / 35°

Ø D	B	b	Ø d	Z	nmax			Number of cutting edges	Ident-No. [L]	Ident-No. [R]
60	43	45	20	2+2	21700	asymmetrical	Lange	8	187745 L	187746 L
[mm]	[mm]	[mm]	[mm]		[min-1]			[pc.]		

Spare parts		Dimension	Class-No.	PU	Ident-No.
DP cutting edges	Ø D=60 / 35°	17,2x14,2x8,9	232239	4	187743 L
		[mm]		[pc.]	

SmartJointer airFace Ø D=70 / 35°

Ø D	B	b	Ø d	Z	nmax			Number of cutting edges	Ident-No. [L]	Ident-No. [R]
70	43	61	25	2+2	18700	asymmetrical	EBM	8	186037 L	186038 L
70	43	41	30	2+2	18700	asymmetrical	HOLZ-HER 1801/1802	8	187027 C	187028 C
70	64	56	30	2+2	18700	asymmetrical	HOLZ-HER 1801/1802	12	187025 L	187026 L
[mm]	[mm]	[mm]	[mm]		[min-1]			[pc.]		

Spare parts		Dimension	Class-No.	PU	Ident-No.
DP cutting edges	Ø D=70 / 35°	17,2x14,2x8,9	232239	4	186076 L
		[mm]		[pc.]	

SmartJointer airFace Ø D=80 / 35°

Ø D	B	b	Ø d	Z	nmax			Number of cutting edges	Ident-No. [L]	Ident-No. [R]
80	64	63	25	2+2	16400	asymmetrical	Felder/Format 4	12	186040 L	186039 L
80	43	53	30	2+2	16400	symmetrical	Biesse	8	186031 L	186031 L
80	43	53	30	3+3	16400	symmetrical	Biesse	12	187267 L	187267 L
80	64	52	30	3+3	16400	symmetrical	Biesse	18	186032 L	186032 L
[mm]	[mm]	[mm]	[mm]		[min-1]			[pc.]		

Spare parts		Dimension	Class-No.	PU	Ident-No.
DP cutting edges	Ø D=80 / 35°	17,2x14,2x8,9	232239	4	186077 L
		[mm]		[pc.]	

SmartJointer airFace Ø D=85 / 35°

Ø D	B	b	Ø d	Z	nmax			Number of cutting edges	Ident-No. [L]	Ident-No. [R]
85	48	50	30	3+3	15500	asymmetrical	Ott	15	186058 L	186057 L
85	63	70	30	3+3	15500	asymmetrical	Ott	18	186060 L	186059 L
85	64	49	30	3+3	15500	asymmetrical	Ott	21	187762 L	187761 L
[mm]	[mm]	[mm]	[mm]		[min-1]			[pc.]		

Spare parts	B		Dimension	For Ident-No.	Class-No.	PU		Ident-No.
DP cutting edges	14,2	Ø D=85 / 35°	17,2x14,2x8,9	For all	232239	4	N	186078 L
DP cutting edges	8,2	Ø D=85 / 35°	17,2x8,2x8,9	186058, 187762	232239	3	L	187244 L
DP cutting edges	8,2	Ø D=60 / 35°	17,2x8,2x8,9	187761, 186057	232239	3	R	187243 L
	[mm]		[mm]			[pc.]		

SmartJointer airFace Ø D=100 / 35°

Ø D	B	b	Ø d	Z	nmax			Number of cutting edges	Ident-No. [L]	Ident-No. [R]
100	43	61	30	2+2	13000	asymmetrical	EBM	8	186034 C	186033 C
100	64	61	30	2+2	13000	asymmetrical	EBM	12	186035 L	186036 C
100	43	40.6	25	2+2	13000	asymmetrical	Brandt 1110F, 1120 FC	8	186071 L	186072 L
100	64,4	40.6	25	2+2	13000	asymmetrical	Brandt 1110F, 1120 FC	12	187703 L	187702 L
100	43	25	30	2+2	13000	asymmetrical	Brandt	8	187636 C	187635 C
100	64	25	30	2+2	13000	asymmetrical	Brandt	12	187638 L	187637 L
100	43	40.6	30	3+3	13000	asymmetrical	Brandt	12	186065 L	186066 L
100	64	40.6	30	3+3	13000	asymmetrical	Brandt	18	186073 L	186074 L
100	85	85	30	3+3	13000	asymmetrical	Brandt	24	186067 C	186068 C
100	106	85	30	3+3	13000	asymmetrical	Brandt	30	186069 C	186070 C
100	43	60.6	30	3+3	13000	asymmetrical	SCM	12	186063 L	186064 L
100	64	60.6	30	3+3	13000	asymmetrical	SCM	18	186062 L	186061 L
100	64	75	30	3+3	13000	symmetrical	Biesse	18	186030 C	186030 C
100	64	40	30	3+3	13000	symmetrical	HOLZ-HER 1804	18	186045 C	186046 C
[mm]	[mm]	[mm]	[mm]		[min-1]			[pc.]		

Spare parts		Dimension	Class-No.	PU	Ident-No.
DP cutting edges	Ø D=100 / 35°	17,2x14,2x8,9	232239	4	185250 L
		[mm]		[pc.]	

SmartJointer airFace Ø D=125 / 35°

Ø D	B	b	Ø d	Z	nmax			Number of cutting edges	Ident-No. [L]	Ident-No. [R]
125	43	40	30	3+3	10500	symmetrical	Homag	12	186047 L	186047 L
125	64	40	30	3+3	10500	symmetrical	Homag	18	186048 L	186048 L
125	32,5	54	30	3+3	10500	asymmetrical	Homag	9	186307 L	186306 L
125	43,2	54	30	3+3	10500	asymmetrical	Homag	12	185971 L	185970 L
125	64,4	54	30	3+3	10500	asymmetrical	Homag	18	185973 L	185972 L
125	43,2	72	30	3+3	10500	asymmetrical	IMA 08.378	12	186051 O	186052 O
125	64,4	72	30	3+3	10500	asymmetrical	IMA 08.378	18	186049 O	186050 O
[mm]	[mm]	[mm]	[mm]		[min-1]			[pc.]		

Spare parts		Dimension	Class-No.	PU	Ident-No.
DP cutting edges	Ø D=125 / 35°	17,2x14,2x8,9	232239	4	185974 L
		[mm]		[pc.]	

SmartJointer airFace Ø D=125 / 43°

Ø D	B	b	Ø d	Z	nmax			Number of cutting edges	Ident-No. [L]	Ident-No. [R]
125	45	57	30	3+3	10500	asymmetrical	IMA 08.379	15	186053 C	186054 C
125	63	57	30	3+3	10500	asymmetrical	IMA 08.379	21	186055 L	186056 L
125	45	51	30	3+3	10500	asymmetrical	Biesse	15	187264 L	187263 L
125	63	51	30	3+3	10500	asymmetrical	Biesse	21	187266 L	187265 L
[mm]	[mm]	[mm]	[mm]		[min-1]			[pc.]		

Spare parts		Dimension	Class-No.	PU	Ident-No.
DP cutting edges	Ø D=125 / 43°	17,2x14,2x8,9	232239	4	186075 L
		[mm]		[pc.]	

SmartJointer airFace Ø D=150 / 35°

Ø D	B	b	Ø d	Z	nmax			Number of cutting edges	Ident-No. [L]	Ident-No. [R]
150	43	40	30	4+4	9000	symmetrical	Homag	15	187241 L	187241 L
150	64	40	30	4+4	9000	symmetrical	Homag	24	187242 C	187242 C
[mm]	[mm]	[mm]	[mm]		[min-1]			[pc.]		

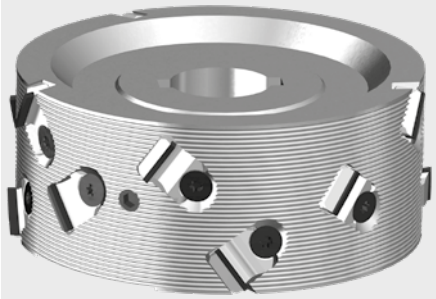
Spare parts		Dimension	Class-No.	PU	Ident-No.
DP cutting edges	Ø D=150 / 35°	17,2x14,2x8,9	232239	4	187245 L
		[mm]		[pc.]	

Spare parts / Accessories	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x13,5 T20	995125	10	185080 L
Plug Insert Torx	T20	985730	2	185293 L
Torque Screwdrivers	5,0 Nm	985730	1	185292 L
	[mm]		[pc.]	

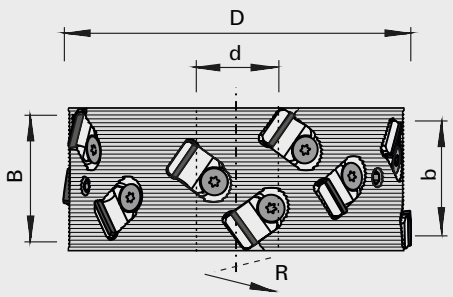
220220

DIAMAX SmartJointer airFace Jointing Cutterheads DP - Fibonacci

Product



Drawing



Fibonacci

LEUCO smart jointer airface

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
- for jump-milling units for very quiet jointing of solid wood and wood-based panels with and without coating, focusing particularly on the reduction of unbalance and noise

Design

- Patented arrangement of cutting edges according to the Fibonacci principle
- Aluminum body with airFace surface
- With exchangeable stainless steel DP cutting edges
- DP cutting edges with integrated stainless steel gullet
- Shear angle 35°
- Resharpening area: 1.5 mm

Advantages

- Unique optimal arrangement of cutting edges without overcuts
- Additional noise reduction by up to -3 dB (A) thanks to the airFace design
- Reduced power consumption thanks to lightweight aluminum design and an optimal cutting edge arrangement; less spindle bearing load through extremely smooth running
- Exchangeable DP cutting edges with wear-resistant gullet
- Excellent cutting quality thanks to a large shear angle and an optimal arrangement of cutting edges
- Corrosion protection over the entire tool thanks to stainless steel segments

Notes

- Attention: when changing the cutting edges please observe operating instructions
- DP cutting edges packing unit 4 pieces
- plug insert packing unit 2 pieces
- sense of rotation according to VDMA 8849

SmartJointer airFace Ø D=125 / 35°

Ø D	B	b	Ø d	Z	nmax			Number of cutting edges	Ident-No. [L]	Ident-No. [R]
125	45,7	40	30	3+3	10500	symmetrical	Homag	14	187764 L	187764 L
[mm]	[mm]	[mm]	[mm]		[min-1]			[pc.]		

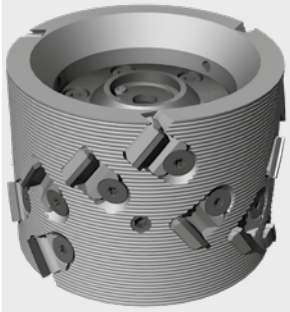
Spare parts		Dimension	Class-No.	PU	Ident-No.
DP cutting edges	Ø D=125 / 35°	17,2x14,2x8,9	232239	4	185974 L
		[mm]		[pc.]	

Spare parts / Accessories	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x13,5 T20	995125	10	185080 L
Plug Insert Torx	T20	985730	2	185293 L
Torque Screwdrivers	5,0 Nm	985730	1	185292 L
	[mm]		[pc.]	

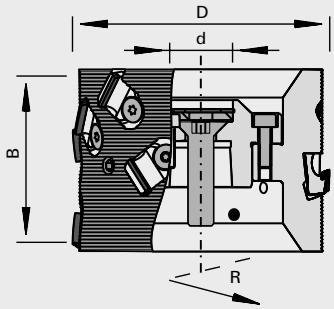
220220

DIAMAX SmartJointer airFace Jointing Cutterheads DP - HSK 32R

Product



Drawing



LEUCO smart jointer airface

Polycrystalline diamond [DP]

MEC

Machine / Application

- through feed machines HOLZ-HER aggregate FG701
- For jump-milling units for very quiet jointing of solid wood and wood-based panels with and without coating, focusing particularly on diameter consistency, noise reduction and perfect concentricity thanks to HSK clamping

Design

- Aluminum body with airFace surface
- With exchangeable stainless steel DP cutting edges
- DP cutting edges with integrated stainless steel gullet
- Shear angle 35°
- Integrated balance screws HSK 32R
- Resharpening area: 1.5 mm

Advantages

- Increased edge life thanks to reduction of multiple hogging and best concentricity
- Excellent cutting quality thanks to large shear angle and best concentricity
- Additional noise reduction by up to -3 dB (A) thanks to the airFace design
- Reduced power consumption thanks to low-weight design with aluminum body
- Reduced spindle bearing load thanks to less unbalance
- Exchangeable DP cutting edges with wear-resistant exchangeable gullet
- Excellent cutting quality thanks to large shear angle
- Corrosion protection over the entire tool thanks to stainless steel segments

Notes

- If the focus is on the best cutting quality and long edge lives, it is recommended to use the LEUCO resharpening service instead of changing cutting edges independently
- Sense of rotation according to DIN-EN 50144

Ø D	B	Ø d	Z	nmax			Number of cutting edges	Ident-No. [L]	Ident-No. [R]
100	64	HSK 32R	3+3	13000	asymmetrical	HOLZ-HER	18	187619 L	187621 L
[mm]	[mm]	[mm]		[min-1]			[pc.]		

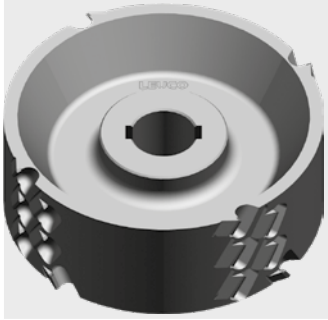
Spare parts		Dimension	Class-No.	PU	Ident-No.
DP cutting edges	Ø D=100 / 35°	17,2x14,2x8,9	232239	4	185250 L
		[mm]		[pc.]	

Spare parts / Accessories	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x13,5 T20	995125	10	185080 L
Plug Insert Torx	T20	985730	2	185293 L
Torque Screwdrivers	5,0 Nm	985730	1	185292 L
	[mm]		[pc.]	

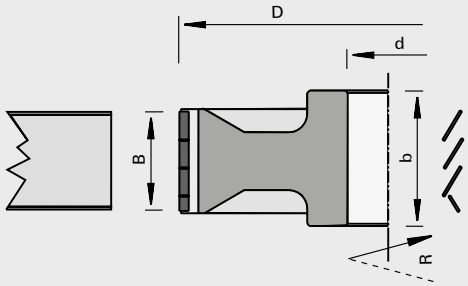
222220

DIAMAX Jointing Cutters CM DP - Homag

Product



Drawing



LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- through feed machines Homag
- for chip-free jointing of melamine-, paper-, HPL-laminated and veneered panels

Design

- opposing shear angle
- spiral cutting edges
- resharpenable area 1.5 mm

Advantages

- high quality in the decor
- optimized chip removal thanks to ChipMeister version (with i-System jointing aggregate)
- noise reduced

Notes

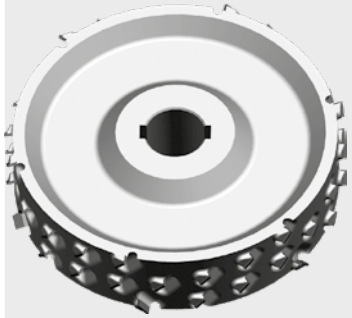
- application with or against feed
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	DKN	nmax	Ident-No. [L]	Ident-No. [R]
180	63	58.5	35	4+4	10x3,3	10000	181261 C	181262 C
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]		

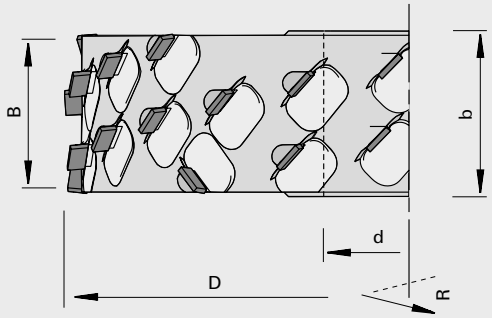
222020

Jointing Cutter CM DP - one-part

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- edge banding machines
- some of them for use on Homag KD11 milling aggregates
- for chip-free jointing of melamine resin and paper laminated, HPL-, foil-coated and veneered wood-based materials

Design

- asymmetrical design
- shear angle 43°
- resharpening area 4 mm

Advantages

- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- optimal glueing of edges
- excellent cutting quality even in the case of loose core
- suitable for laser edging
- optimized as to noise level and chip flow

Notes

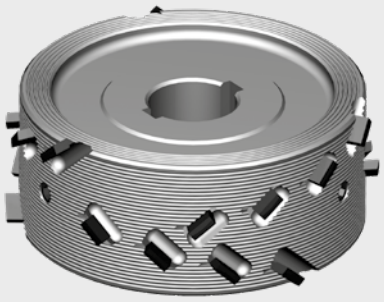
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	DKN	nmax			Ident-No. [L]	Ident-No. [R]
180	43	48	35	5+5	10x3,3	10300		asymmetrical	185065 L	185066 L
180	64,2	60	35	5+5	10x3,3	10300		asymmetrical	185067 C	185068 C
180	32,4	37	35	6+6	10x3,3	10300		asymmetrical	185131 C	185130 C
180	32,4	54	35	6+6	10x3,3	10300	Homag KD11	asymmetrical	80456242 L	80456241 L
180	43	54	35	6+6	10x3,3	10300	Homag KD11	asymmetrical	80456244 L	80456243 L
180	64,2	54	35	6+6	10x3,3	10300	Homag KD11	asymmetrical	80456246 C	80456245 C
180	32,4	54	35	7+7	10x3,3	10300	Homag KD11	asymmetrical	80456248 C	80456247 C
180	43	48	35	7+7	10x3,3	10300		asymmetrical	185047 C	185048 C
180	43	54	35	7+7	10x3,3	10300	Homag KD11	asymmetrical	80456250 C	80456249 C
180	64,2	54	35	7+7	10x3,3	10300	Homag KD11	asymmetrical	80456252 C	80456251 C
180	64,2	60	35	7+7	10x3,3	10300		asymmetrical	185049 C	185050 C
200	32,4	37	35	6+6	10x3,3	9000		asymmetrical	185133 C	185132 C
200	43	48	35	6+6	10x3,3	9000		asymmetrical	185069 C	185070 C
200	43	48	35	8+8	10x3,3	9000		asymmetrical	185053 C	185054 C
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]				

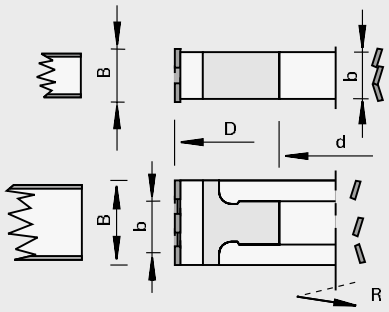
222120 / 223120

DIAREX airFace Jointing Cutters DP

Product



Drawing



LEUCO diarex airface

Polycrystalline diamond [DP]

MEC

Machine / Application

- through feed machines
- edge banding machines
- for very quiet and chip-free jointing of solid wood and wood-based panels with and without coating, focusing particularly on noise reduction and quality standards

Design

- steel body with airFace surface
- integrated balance screws
- reinforced DP cutting edges
- reduced gullet volume
- shear angle 48°
- resharpening area 3 mm

Advantages

- compared to the LowNoise version, additional noise reduction by -2 dB(A) through airFace design and reduced gullet volume
- increased durability in comparison to standard jointing cutters
- optimum cutting quality thanks to a very large shear angle
- suitable for zero-joint technology
- suitable for demanding abrasive panel materials
- machining of 8-mm panels is possible without adjustment

Notes

- Z=4+4 tools for feed speed > 22 m/min!
- possible to regenerate
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	DKN	nmax			Ident-No. [L]	Ident-No. [R]
70	48,1	41	30	3+3	8x3,3	24000	HOLZ-HER 1801 / 1802	asymmetrical	186316 C	186317 C
70	64	41	30	3+3	8x3,3	24000	HOLZ-HER 1801 / 1802	asymmetrical	186318 C	186319 C
80	42,8	53	30	2+2	8x3,3	23300	Biesse	symmetrical	186309 C	186309 C
85	48,1	50	30	3+3	8x3,3	22000	Ott	asymmetrical	186356 L	186357 L
85	64	70	30	3+3	8x3,3	22000	Ott	asymmetrical	186358 L	186359 L
100	64	75	30	3+3	8x3,3	18000	Biesse	symmetrical	186308 C	186308 C
100	42,8	40.6	30	3+3	8x3,3	18000	Brandt	asymmetrical	186312 L	186313 L
100	64	40.6	30	3+3	8x3,3	18000	Brandt	asymmetrical	186310 C	186311 C
100	42,8	61	30	2+2	8x3,3	18000	EBM, Hebrock	asymmetrical	186315 C	186314 C
100	64	40	30	3+3	8x3,3	18000	HOLZ-HER 1804	symmetrical	186320 L	186321 L
100	42,8	60.6	30	3+3	8x3,3	18000	SCM	asymmetrical	186362 L	186363 L
100	64	60.6	30	3+3	8x3,3	18000	SCM	asymmetrical	186360 C	186361 C
125	26,9	54	30	3+3	8x3,3	15000	Homag	asymmetrical	186904 C	186905 C
125	32,2	54	30	3+3	8x3,3	15000	Homag	asymmetrical	186900 L	186901 L
125	42,8	54	30	3+3	8x3,3	15000	Homag	asymmetrical	186332 L	186333 L
125	42,8	54	30	4+4	8x3,3	15000	Homag	asymmetrical	186336 C	186337 C
125	64	54	30	3+3	8x3,3	15000	Homag	asymmetrical	186328 L	186329 L
125	64	54	30	4+4	8x3,3	15000	Homag	asymmetrical	186340 C	186341 C
125	32,2	36.8	30	3+3	8x3,3	15000	Homag	symmetrical	186322 L	186322 L
125	32,2	36.8	30	4+4	8x3,3	15000	Homag	symmetrical	186325 L	186325 L
125	42,8	40	30	3+3	8x3,3	15000	Homag	symmetrical	186323 L	186323 L
125	42,8	40	30	4+4	8x3,3	15000	Homag	symmetrical	186326 L	186326 L
125	64	40	30	3+3	8x3,3	15000	Homag	symmetrical	186324 L	186324 L
125	64	40	30	4+4	8x3,3	15000	Homag	symmetrical	186327 C	186327 C
125	26,9	72	30	3+3	8x3,3	15000	IMA 08.378	asymmetrical	186906 C	186907 C
125	32,2	72	30	3+3	8x3,3	15000	IMA 08.378	asymmetrical	186902 O	186903 O
125	42,8	72	30	3+3	8x3,3	15000	IMA 08.378	asymmetrical	186334 O	186335 O
125	64	72	30	3+3	8x3,3	15000	IMA 08.378	asymmetrical	186330 O	186331 O
125	42,8	72	30	4+4	8x3,3	15000	IMA 08.378	asymmetrical	186338 C	186339 C
125	64	72	30	4+4	8x3,3	15000	IMA 08.378	asymmetrical	186342 C	186343 C
125	26,9	57	30	3+3	8x3,3	15000	IMA 08.379	asymmetrical	186910 C	186911 C
125	32,2	57	30	3+3	8x3,3	15000	IMA 08.379	asymmetrical	186908 C	186909 C
125	42,8	57	30	3+3	8x3,3	15000	IMA 08.379	asymmetrical	186350 C	186351 C
125	64	57	30	3+3	8x3,3	15000	IMA 08.379	asymmetrical	186348 C	186349 C
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]				

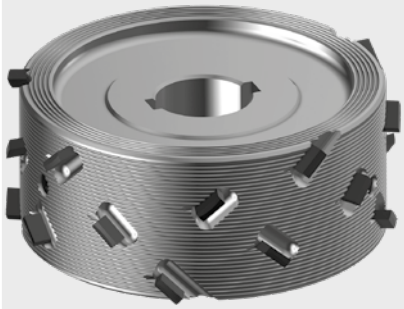
mounted on Hydro-Bushing Ident-No. 184310

Ø D	B	Ø d	Z	nmax			Ident-No. [L]	Ident-No. [R]
125	42,8	70/30	4+4	15000	IMA 08.379 - Hydro	asymmetrical	186352 C	186353 C
125	64	70/30	4+4	15000	IMA 08.379 - Hydro	asymmetrical	186354 C	186355 C
150	42,8	70/30	4+4	12000	IMA 08.378 - Hydro	asymmetrical	186344 C	186345 C
125	64	70/30	4+4	12000	IMA 08.378 - Hydro	asymmetrical	186346 C	186347 C
150	43	70/30	5+5	12000	Homag Power S2 / Performance S2 from 2023	symmetrical	187726 L	187728 L
150	63	70/30	5+5	12000	Homag Power S2 / Performance S2 from 2023	symmetrical	187731 L	187733 L
[mm]	[mm]	[mm]		[min-1]				

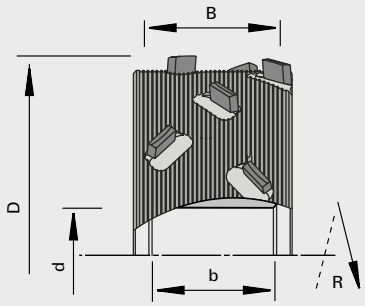
222127

DIAREX airFace Jointing Cutters DP - Fibonacci

Product



Drawing



LEUCO diarex airface

Polycrystalline diamond [DP]

MEC

Machine / Application

- through feed machines
- edge banding machines
- for very quiet and chip-free jointing of solid wood and wood-based panels with and without coating, focusing particularly on noise reduction and quality standards

Design

- patented arrangement of cutting edges according to the Fibonacci principle
- steel body with airFace surface
- integrated balance screws
- reinforced DP cutting edges
- reduced gullet volume
- shear angle 48°
- resharpening area 3 mm

Advantages

- unique optimal arrangement of cutting edges without overcuts
- compared to the LowNoise version, additional noise reduction by -2 dB(A) through airFace design and reduced gullet volume
- increased durability in comparison to standard jointing cutters
- optimum cutting quality thanks to a very large shear angle
- suitable for zero-joint technology
- suitable for demanding abrasive panel materials
- machining of 8-mm panels is possible without adjustment

Notes

- possible to regenerate
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	DKN	nmax			Ident-No. [L]	Ident-No. [R]
125	62,4	40	30	3+3	8x3,3	15000	Homag	symmetrical	187863 L	187863 L
125	43,7	40	30	3+3	8x3,3	15000	Homag	quasi symmetrical	187864 L	187864 L
100	43,7	40.6	30	3+3	8x3,3	18000	Brandt	asymmetrical	187865 L	187868 L
125	62,4	54	30	3+3	8x3,3	15000	Homag	asymmetrical	187869 L	187870 L
100	62,4	40.6	30	3+3	8x3,3	18000	Brandt	asymmetrical	187871 C	187872 C
125	37,5	36.8	30	3+3	8x3,3	15000	Homag	symmetrical	187874 L	187874 L
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]				

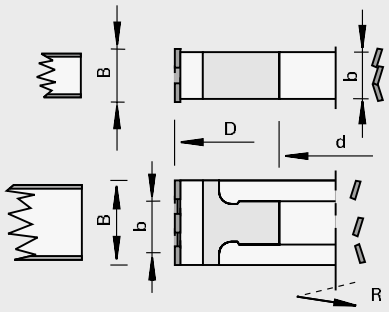
223120

DIAREX Jointing Cutters CM DP LowNoise

Product



Drawing



LOW

DIAREX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
- for noise-reduced, chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- symmetrical and asymmetrical design
- large opposing shear angle
- uneven cutting edge configuration
- resharpening area 3 mm

Advantages

- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- optimal glueing of edges
- optimized as to noise level and chip flow
- excellent cutting quality even in the case of loose core
- suitable for laser-edge-technology

Notes

- sense of rotation according to VDMA 8849

mounted on Hydro-Bushing Ident-No. 184310

Ø D	B	Ø d	Z	nmax			Ident-No. [L]	Ident-No. [R]
125	43	70/30	3+3	15000	IMA 08.378 - Hydro	asymmetrical	184969 C	184970 C
125	43	70/30	4+4	15000	IMA 08.379 - Hydro	asymmetrical	185119 C	185118 C
125	43	70/30	5+5	15000	Homag Performance S2 - Hydro	symmetrical	185169 L	185170 L
125	63	70/30	5+5	15000	Homag Performance S2 - Hydro	symmetrical	185171 L	185172 L
150	43	70/30	5+5	12000	Homag Power S2 / Performance S2 - Hydro	symmetrical	185165 L	185166 L
150	63	70/30	5+5	12000	Homag Power S2 / Performance S2 - Hydro	symmetrical	185167 L	185168 L
[mm]	[mm]	[mm]		[min-1]				

Spare parts / Accessories	Dimension	Class-No.	PU	Ident-No.
Face spanner	14-100/5	985720	1	187136 L
	[mm]		[pc.]	

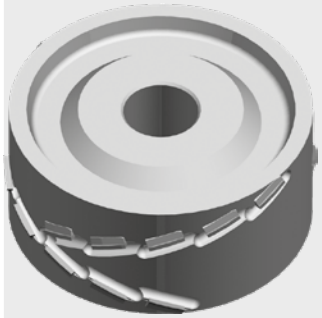
mounted on tool holder HSK 63 F, modified Ident-No. 184787

Ø D	B	Ø d	Z	nmax			Ident-No. [L]	Ident-No. [R]
150	43	HSK 63F	5+5	12000	Homag Power S2 HSK 63F	symmetrical	185173 C	185174 C
150	63	HSK 63F	5+5	12000	Homag Power S2 HSK 63F	symmetrical	185175 C	185176 C
[mm]	[mm]	[mm]		[min-1]				

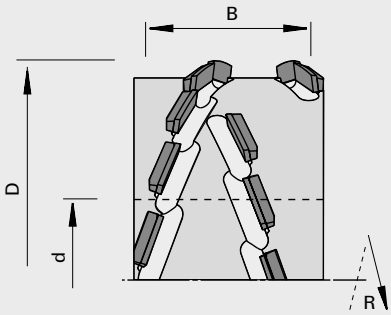
222226

p-System Jointing Cutters CM DP - MAN

Product



Drawing



LEUCO topline

LEUCO p-system

Polycrystalline diamond [DP]

MAN

Machine / Application

- table shaper
- for chip-free high-performance jointing of solid woods (free of knots) along and accross the grain
- for jointing and dividing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- symmetrical design
- non-convex design
- extremely scoring cut
- resharpening area 1.5 mm

Advantages

- maximum cutting quality and edge lives
- large depth of cut possible

Notes

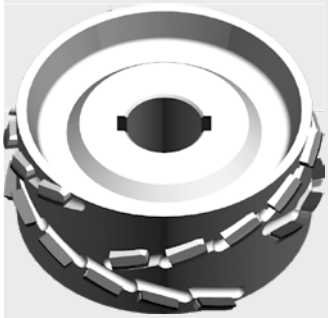
- application against feed
- recommended feed rate per tooth: wood-based panels 0.8 mm, solid wood 0.4 mm
- crowned design on request
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	Shear∢	nmin-nmax		Ident-No. [L]	Ident-No. [R]
125	28,2	35.2	30	2+2	70	6100-10500	symmetrical	184332 S	184332 S
125	47,8	54.8	30	2+2	70	6100-10500	symmetrical	184333 L	184333 L
125	28,2	35.2	30	3+3	70	6100-10500	symmetrical	184329 C	184329 C
125	47,8	54.8	30	3+3	70	6100-10500	symmetrical	184330 S	184330 S
[mm]	[mm]	[mm]	[mm]		[°]	[min-1]			

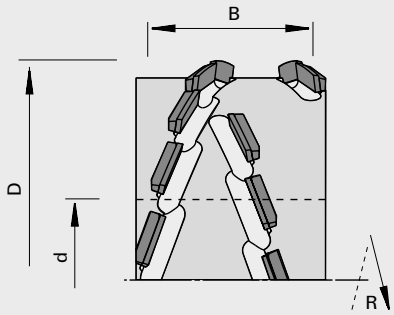
222324

p-System High-Performance Jointing Cutters CM DP - Fibonacci

Product



Drawing



LEUCO topline

LEUCO p-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- edge banding machines
- for chip-free high-performance jointing of solid woods (free of knots) along and accross the grain
- for jointing and dividing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- Patented arrangement of cutting edges according to the Fibonacci principle
- Symmetrical design
- Extremely pulling cut
- Resharpening area: 4 mm

Advantages

- Unique optimal arrangement of cutting edges without overcuts
- Maximum cutting quality and edge life
- Extremely smooth running
- Less power requirement

Notes

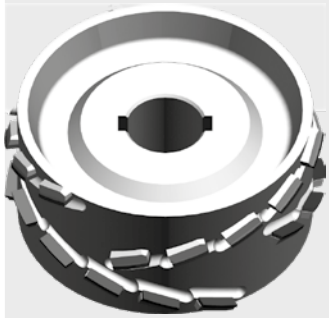
- application against feed
- recommended feed rate per tooth: wood-based panels 0.8 mm, solid wood 0.4 mm
- crowned design on request
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	DKN	nmax			Ident-No. [L]	Ident-No. [R]
125	33,1	25	30	3+3	8x3,3	15000	Homag	symmetrical	187765 L	187765 L
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]				

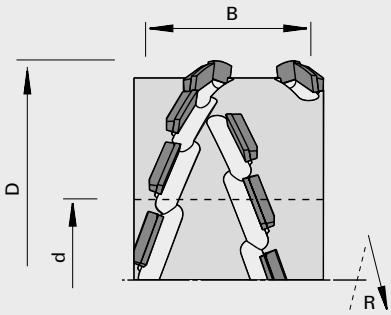
222324 / 223324

p-System High-Performance Jointing Cutters CM DP

Product



Drawing



LEUCO topline

LEUCO p-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- edge banding machines
- for chip-free high-performance jointing of solid woods (free of knots) along and across the grain
- for high-performance jointing and dividing of melamine-, paper-, HPL-laminated, foil-coated and veneered panels and lacquered surfaces
- Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- symmetrical and asymmetrical design
- extremely scoring cut
- resharpening area 4 mm

Advantages

- maximum cutting quality and edge lives
- large depth of cut possible
- perfectly suitable for laser-edge-technology

Notes

- application against feed
- recommended feed rate per tooth: wood-based panels 0.8 mm, solid wood 0.4 mm
- crowned design on request
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	DKN	nmax			Ident-No. [L]	Ident-No. [R]
70	47,8	41	30	3+3	8x3,3	27000		asymmetrical	184079 C	184078 C
100	42,9	40.6	30	3+3	8x3,3	19000	Brandt, SCM	asymmetrical	184074 C	184073 C
100	62,5	40.6	30	3+3	8x3,3	19000	Brandt, SCM	asymmetrical	184077 C	184076 C
125	33,1	25	30	3+3	8x3,3	15000	Homag	symmetrical	185818 L	185818 L
125	42,9	40.6	30	3+3	8x3,3	15000	Homag, IMA 08.378	asymmetrical	184961 C	184962 C
125	42,9	57	30	3+3	8x3,3	15000	IMA 08.379	asymmetrical	184987 C	184988 C
125	47,8	40	30	3+3	8x3,3	15000	Homag	symmetrical	184071 L	184071 L
125	61,5	40	30	3+3	8x3,3	15000	Homag	quasi symmetrical	184328 C	184327 C
125	62,5	40.6	30	3+3	8x3,3	15000	Homag, IMA 08.378	asymmetrical	184963 C	184964 C
125	62,5	57	30	3+3	8x3,3	15000	IMA 08.379	asymmetrical	184989 C	184990 C
180	42,9	58.5	35	5+5	10x3,3	10000		quasi symmetrical	184085 C	184063 C
180	62,5	58.5	35	5+5	10x3,3	10000		quasi symmetrical	184086 S	184064 S
200	42,9	50	35	5+5	10x3,3	9000		quasi symmetrical	184088 S	184066 S
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]				

mounted on Hydro-Bushing Ident-No. 184310

Ø D	B	Ø d	Z	nmax			Ident-No. [L]	Ident-No. [R]
125	42,9	70/30	4+4	15000	IMA 08.379 Hydro	asymmetrical	185127 C	185126 C
[mm]	[mm]	[mm]		[min-1]				

mounted on Hydro-Bushing Ident-No. 172678

Ø D	B	Ø d	Z	nmax			Ident-No. [L]	Ident-No. [R]
200	42,9	60/40	8+8	9000		asymmetrical	184068 C	184067 C
[mm]	[mm]	[mm]		[min-1]				

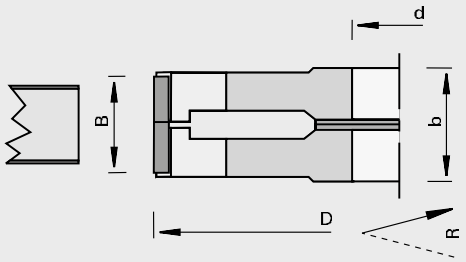
223020

Jointing Cutters DP

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application
- double end tenoners
- edge banding machines
- for chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design
- resharpenable area 3.5 mm
- opposing shear angle
- Ø 150 mm: n max = 12,000 min-1 / Ø 200 mm: n max = 9,000 min-1
- two-part version with spacer rings

Advantages
- tool allows for 3 adjustments = four single edge lives between sharpenings

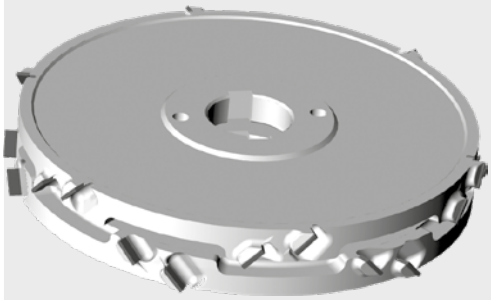
Notes
- the specified feed rates are based on Ø = 150 mm: n = 9,000 min-1 / Ø = 200 mm: n = 6,000 min-1
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	DKN	Recommended feed	Ident-No.
150	22-28	32	30	3+3	8x3	23	178798 C
200	22-28	32	35	4+4	10x4	20	178801 C
200	22-28	32	35	5+5	10x4	25	179073 C
200	22-28	32	35	6+6	10x4	30	178804 S
[mm]	[mm]	[mm]	[mm]		[mm]	[m/min]	

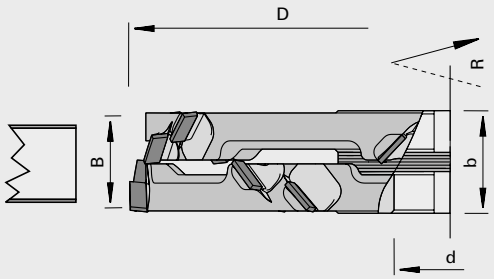
223020

Jointing Cutter CM DP - two-part

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application
- double end tenoners
- edge banding machines
- for chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design
- symmetrical design
- two-part adjustable via spacers
- large opposing shear angle
- resharpening area 4 mm

Advantages
- tool allows for 3 adjustments = four single edge lives between sharpenings
- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- optimal glueing of edges
- excellent cutting quality even in the case of loose core
- suitable for laser edging

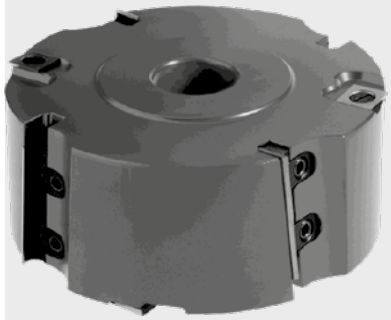
Notes
- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	DKN	nmax		Ident-No. [L]	Ident-No. [R]
200	22-28	32	35	6+6	10x3,3	9000	symmetrical	185079 L	185079 L
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]			

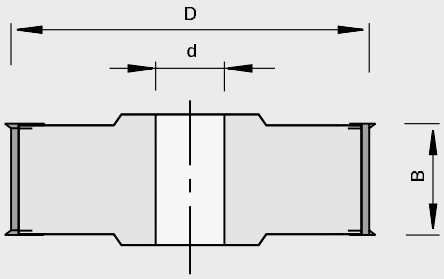
120265

Jointing and Rabbeting Cutterheads HW with shear angle

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- table shapers
- for chip-free jointing and rabbeting in solid woods and wood-based panels

Design

- with shear angle
- cutting material: HW HL Board 05
- body made from high-quality light-metal alloy

Advantages

- optimum cutting quality
- plane surface

Notes

- application against feed

Ø D	B	Ø d	Z	nmin-nmax	Ident-No.
140	60	30	4+4	5400-9400	179180 L
[mm]	[mm]	[mm]		[min-1]	

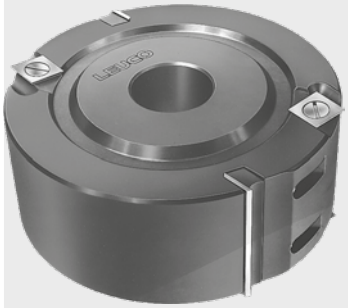
Turnover Knives		B	H	S	For Ident-No.	Class-No.	PU	Ident-No.
Spurs		14	14	2.0	For all	150558	10	003079 L
Knives	convex design	49,6	11.8	1.5	179181	151567	10	179330 L
Turnover Knives		50	12	1.5	179180	150515	10	003085 L
		[mm]	[mm]	[mm]			[pc.]	

Spare parts		Dimension	Class-No.	PU	Ident-No.
Pressure Bars		48x11x6	925300	2	180346 L
Clamping Pieces		12x8,5/M8L	925100	2	180357 L
Clamping Set Screws		M8x26 SW4	995195	10	180340 L
Countersunk Screws	for spur	M5x10,8 T15 D=Ø9,4	995125	10	180840 L
Screwdrivers		SW4x100	985730	1	166091 L
Screwdrivers		T15x80	985730	1	171188 L
		[mm]			

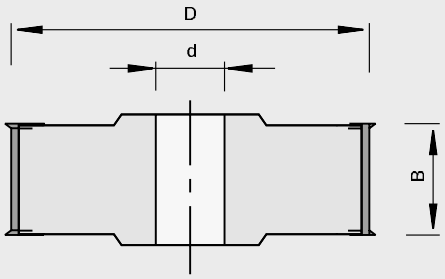
120255

Jointing and Rabbeting Cutterheads HW without shear angle

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- table shapers
- for jointing and rabbeting in solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 05

Advantages

Notes

- application against feed

Ø D	B	Ø d	Z	DKN	nmin-nmax	Ident-No.
85	50	30	2+4		9000-15500	167038 L
100	30	30	2+4		7700-13300	167039 C
100	50	30	2+4		7700-13300	167040 C
125	30	30	2+4		6100-10500	167041 L
125	50	30	2+4		6100-10500	167043 L
125	50	35	2+4	10x4	6100-10500	167044 C
125	50	30	4+4		6100-10500	167046 L
125	50	35	4+4	10x4	6100-10500	167047 C
125	50	40	4+4	12x5	6100-10500	167048 C
[mm]	[mm]	[mm]		[mm]	[min-1]	

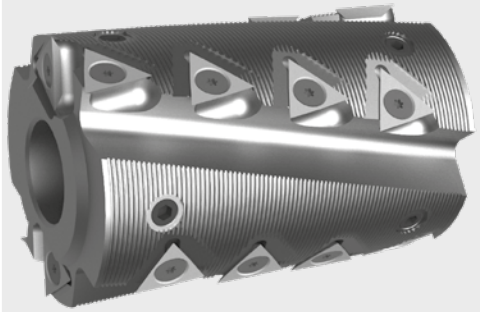
Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Spurs	14	14	2.0	150558	10	003079 L
Turnover Knives	30	12	1.5	150515	10	003083 L
Turnover Knives	50	12	1.5	150515	10	003085 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=30	167039, 167041	925300	2	164185 L
Pressure Bars	B=48	167038, 167040, 167043, 167044, 167046, 167047, 167048	925300	2	166984 L
Set Screws	M6x16 SW3	167039, 167041, 167043, 167044, 167046, 167047, 167048	995161	10	001617 L
Set Screws	M6x12 DIN EN ISO 4028	167038, 167040	995161	10	180214 L
Countersunk Screws	M5x10,8 T15 D=Ø9,4	For all	995125	10	180840 L
Screwdrivers	SW3x100	For all	985730	1	166090 L
Screwdrivers	T15x80	For all	985730	1	171188 L
Adjusting Gauges	1,0	For all	985200	1	011103 L
	[mm]			[pc.]	

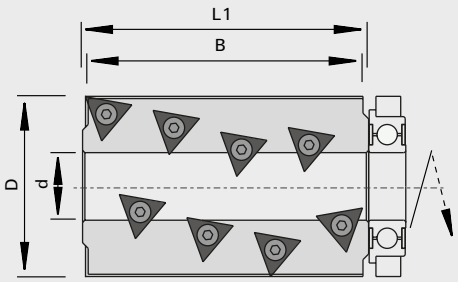
120265

Copying cutter with HW turnover knives - t3-System

Product



Drawing



LEUCO t3 system

Tungsten Carbide [HW]

MAN

Machine / Application

- Table machines
- Jointing, rabbeting, copying of solid woods and laminated timber

Design

- Triangular turnover knives with rounded cutting edges drawing from bottom to top and from top to bottom

Advantages

- Absolutely chip-free jointing and rabbeting
- Thanks to the rounded turnover knives the machined surface is offset-free
- Excellent edge and surface quality
- Very high milling performance
- Triangular turnover knives with rounded edges, 3 edge lives

Notes

Ø D	B	L1	Ø d	Z	Number of cutting edges	Ident-No.
80	82,1	85.8	30	2+2	12	187684 L
80	122,6	126	30	2+2	18	187685 L
[mm]	[mm]	[mm]	[mm]		[pc.]	

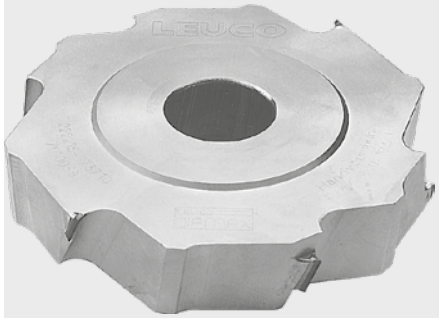
Turnover Knives	B	H	S	LEUCODUR	Class-No.	PU	Ident-No.
	20,88	18.3	3.0	HL Solid 20	150567	10	187251 L
	[mm]	[mm]	[mm]			[pc.]	

Spare parts / Accessories	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x10,8 T15 D=Ø9,4	995125	10	180840 L
Screwdrivers	T15x80	985730	1	171188 L
	[mm]		[pc.]	

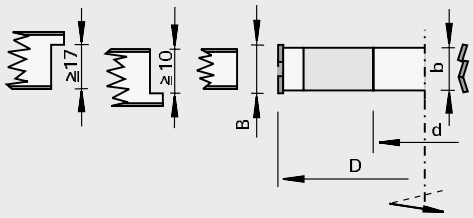
222225

DIAMAX Jointing / Rabbeting Cutters DP

Product



Drawing



LEUCO DIAMAX

Polycrystalline diamond [DP]

MAN

Machine / Application
- table shapers
- machines Homag
- for chip-free jointing and rabbeting of melamine-, paper-, HPL-laminated and veneered panels

Design
- opposing shear angle
- resharpenable area 1.5 mm

Advantages

Notes
- application against feed
- sense of rotation according to VDMA 8849

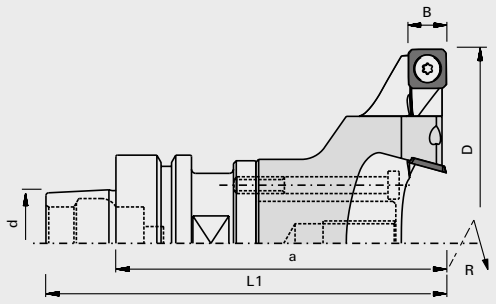
Ø D	B	Ø d	Z	DKN	nmin-nmax	Ident-No.
125	25	30	2+2	8x3	6100-10500	173710 L
125	25	50	2+2		6100-10500	173786 C
125	43	30	2+2	8x3	6100-10500	182705 C
[mm]	[mm]	[mm]		[mm]	[min-1]	

128200

Planing and Rabbeting Cutterheads HW - mounted on arbor

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application
- CNC routers
- for planing and rabbeting in wood-based panels

Design
- mounted on tool holder HSK 63 F

Advantages
- high milling performance when dressing the workbench boards, e.g. with Nesting-technology
- smooth surface thanks to special cutting edge geometry

Notes
- sense of rotation according to VDMA 8849

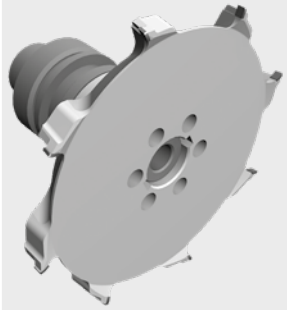
Ø D	B	Ø d	L1	a	Z	nmax	Ident-No.
150	14	HSK 63F	138	113	4	10100	182440 S
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

Spare parts	Class-No.	PU	Ident-No.
Mounting Arbors with HSK shank	933069	1 [pc.]	183748 L

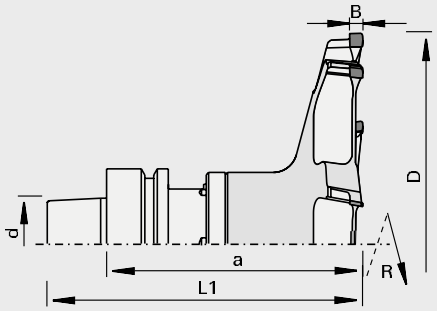
223020

Planing and Rabbeting Cutterheads DP - mounted on arbor

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for planing and rabbeting in wood-based panels

Design

- mounted on tool holder HSK 63 F
- resharpenable area 3.0 mm

Advantages

- high milling performance when dressing the workbench boards, e.g. with Nesting-technology
- smooth surface thanks to special cutting edge geometry

Notes

- sense of rotation according to VDMA 8849

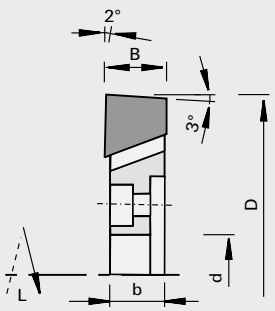
Ø D	B	Ø d	L1	a	Z	nmax	Ident-No.
150	5,6	HSK 63F	128	103	8	12700	182661 C
180	5,6	HSK 63F	128	103	8	10300	182425 L
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

122200

Corner Notching Cutters HW - Homag

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- CNC machining centers Homag / aggregate 7547
- for sharp-edged cutting out of inside corners

Design

- n max = 24.000 min-1

Advantages

Notes

- sense of rotation according to VDMA 8849

Ø D	B	b	Ø d	Z	Ident-No.
75	15	13	16	4	182457 L
[mm]	[mm]	[mm]	[mm]		

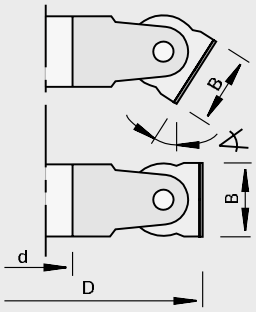
120305

Swivel Cutterheads HW

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- table shapers
- for chamfering, jointing and rabbeting with adjustable chamfer angle in solid woods and in veneered and plastic-coated panels

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 05

Advantages

Notes

- application against feed
- rabbeting with additional spur
- pivot range up to 60 degree
- Ø 120 mm chamfer angle adjustable from 5 degree to 5 degree
- Ø 150 mm chamfer angle adjustable from 1 degree to 1 degree

Ø D	B	Ø d	Z	nmin-nmax	Ident-No. top
120	40	30	2	6400-11000	179184 C
150	50	30	2	5200-9000	179185 L
150	50	40	2	5200-9000	180903 C
160	50	50	2	4800-8000	180904 C
[mm]	[mm]	[mm]		[min-1]	

Pre-scoring discs	Ø D	B	Ø d	Z	Class-No.	PU	Ident-No.
	150	8,0	30	2	120255	1	179182 C
	[mm]	[mm]	[mm]			[pc.]	

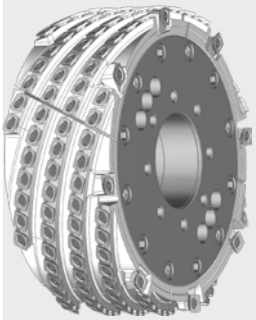
Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Spurs	14	14	2.0	150558	10	003079 L
Turnover Knives	40	12	1.5	150515	10	164078 L
Turnover Knives	50	12	1.5	150515	10	003085 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	B=40	925300	2	50930125 C
Pressure Bars	B=50	925300	2	50930124 L
Countersunk Screws	M5x6,8 T15 D=Ø9,4	995125	10	180839 L
Set Screws	M6x16 SW3	995161	10	001617 L
Screwdrivers	SW3x100	985730	1	166090 L
Cranked Wrench Keys	SW6 DIN ISO 2936	985730	1	009675 L
	[mm]		[pc.]	

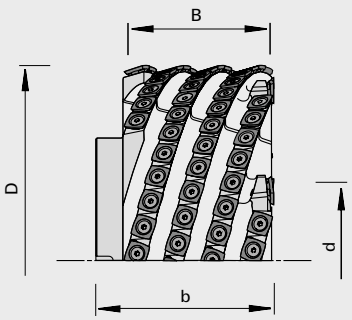
120281

p-System Profile Cutters HW

Product



Drawing



LEUCO p-system

Tungsten Carbide [HW]

MEC

Machine / Application

- machine
- EWD FR15, FR16
- Linck VPF340
- for milling of corners / profiling

Design

- one part and segmented
- turnover knives can be used on all four sides
- extremely scoring cut
- cutting material: HW HL Solid 20

Advantages

- no chippings due to knots
- considerable improvement of surface quality compared to the existing chipping knives
- small chips suitable for pellet production
- extremely long edge lives (up to 8 million running meters)

Notes

- chips are not suitable for paper industry
- feed rate per tooth fz = 2-8 mm

Ø D	B	b	Ø d	Z	Shear◁		
360	139,5	164	110	8+8	70	vertical axis top	EWD
360	139,5	164	110	8+8	70	vertical axis bottom	EWD
402	139	164	110	8+8	70	vertical axis top	EWD
402	139	164	110	8+8	70	vertical axis bottom	EWD
402	121	139	120/200	8+8	70	vertical axis top	Linck
402	121	139	120/200	8+8	70	vertical axis bottom	Linck
360	64	164	60	4+4	70	horizontal axis right	EWD
360	64	164	60	4+4	70	horizontal axis left	EWD
360	64	164	60	5+5	70	horizontal axis right	EWD
360	64	164	60	5+5	70	horizontal axis left	EWD
360	64	164	60	8+8	70	horizontal axis right	EWD
360	64	164	60	8+8	70	horizontal axis left	EWD
360	89,2	164	60	6+6	70	horizontal axis right	EWD
360	89,2	164	60	6+6	70	horizontal axis left	EWD
[mm]	[mm]	[mm]	[mm]		[°]		

Turnover Knives	B	H	S	LEUCODUR	Class-No.	PU	Ident-No.
for Ø D=360 mm	21	21	5.5	HL Solid 60	150569	10	186110 L
for Ø D=402 mm	21	21	5.5	HL Solid 60	150569	10	186111 L
	[mm]	[mm]	[mm]			[pc.]	

Spare parts		Dimension	Class-No.	PU	Ident-No.
Head Cap Screws		M14x60-12.9 DIN EN ISO 4762	995111	10	185008 L
Head Cap Screws		M14x80-12.9 DIN EN ISO 4762	995111	10	185181 L
Countersunk Screws		M7x17 T30 10.9	995125	10	185643 L
Conical Screws		M6x10 D7.8x20GRD 10.9	995191	10	184891 L
Repair set	thread inserts, twist drills, hand tap, spindle insert, tang break-off tool	M7	985200	1	185881 C
Helicoil®		M7x10,5	995490	10	50930340 L
		[mm]		[pc.]	

Accessories		Class-No.	PU	Ident-No.
Drilling fixture	for Ø D=360 mm left and Helicoil® d=7.5 mm	997600	1	186440 S
Drilling fixture	for Ø D=360 mm right and Helicoil® d=7.5 mm	997600	1	186441 S
Drilling fixture	for Ø D=360 mm left and core hole d=5.5 mm	997600	1	186442 S
Drilling fixture	for Ø D=360 mm right and core hole d=5.5 mm	997600	1	186443 S
Drilling fixture	for Ø D=402 mm left and Helicoil® d=7.5 mm	997600	1	186444 S
Drilling fixture	for Ø D=402 mm right and Helicoil® d=7.5 mm	997600	1	186445 S
			[pc.]	

Accessories		Class-No.	PU	Ident-No.
Drilling fixture	for Ø D=402 mm left and core hole d=5.5 mm	997600	1	186446 S
Drilling fixture	for Ø D=402 mm right and core hole d=5.5 mm	997600	1	186447 S
			[pc.]	

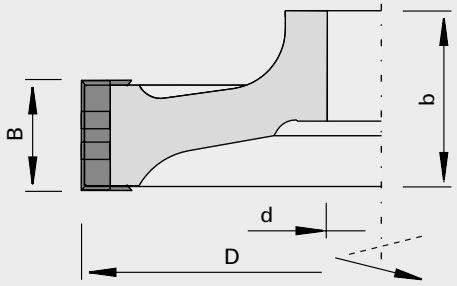
120261

Tenoning Cutterheads surfCut HW

Product



Drawing



LEUCO surfcut

Tungsten Carbide [HW]

MEC

Machine / Application
- Hundegger, Weinmann joinery centers
- for milling tenons, lap joints, profiles and notches

Design
- with shear angle
- with four-sided turnover knives
- spurs HW
- high-tensile aluminum body

Advantages
- high milling performance
- less rework
- clean-cut look
- variable use
- reduced frequency of cutting edge replacement
- longer edge life

Notes
- for HSK mounting arbors with double key without spacer
- exact dimensions and hub design to be cleared with the LEUCO Application Engineering Dept.

Ø D	B	b	Ø d	Z	DKN		Ident-No.
250	125	125	55	4+4		Weinmann	186169 S
300	20	80	55	4+4		Weinmann	186170 S
300	40	80	55	4+4		Weinmann	186171 S
350	40	75	55	4+4	16x4,3	Hundegger	186174 C
350	20	75	55	4+4	16x4,3	Hundegger	186175 S
350	60	75	55	4+4	16x4,3	Hundegger	186176 C
[mm]	[mm]	[mm]	[mm]		[mm]		

Turnover Knives	B	H	S	LEUCODUR	For Ident-No.	Class-No.	PU	Ident-No.
	13,8	13.8	2.5	HL Solid 20	186170, 186175	150567	10	184942 L
	20,6	20.6	5.5	HL Solid 30	186169, 186171, 186174, 186176	150568	10	186667 L
	[mm]	[mm]	[mm]				[pc.]	

Ø D	B	Ø d	Z	Number of cutting edges	Ident-No.
160	31-58	30	2+2	12	9260468 L
[mm]	[mm]	[mm]		[pc.]	

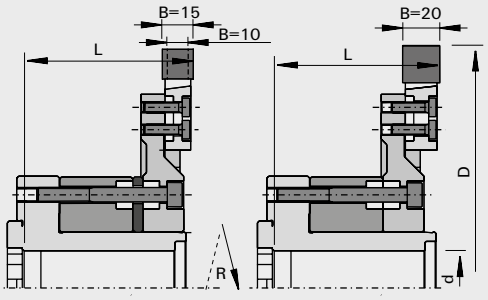
221060

Profile Cutterhead Sets - flooring - unprofiled

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

Machine / Application

- through-feed machines
- double end tenoners
- for profiling of the longitudinal and transverse profiles in machining of flooring (laminate, parquet and LVT)

Design

- Segments are unprofiled
- Modular design: bushing, flange, cutterhead and segment
- Design from Z2 to Z12
- All parts are available on stock
- Segment B=10 mm, flush mounting is not possible

Advantages

- fast, customer-specific profiling
- tools are available on short notice
- ideal for profile developments and tests

Notes

- single parts are mounted to sets
- cutting inserts can be profiled separate from the cutterhead
- reproducibility after exchange: max 0.05 mm in runout-accuracy / concentricity

Ø D	B	Ø d	Z	L	nmax	Ident-No. [L]	Ident-No. [R]
250	10	40	2	96.5	6000	186890 O	186889 O
250	10	40	3	96.5	6000	186892 O	186891 O
250	10	40	4	96.5	6000	186894 O	186893 O
250	10	40	6	96.5	6000	186896 O	186895 O
250	10	40	12	96.5	6000	186898 O	186897 O
[mm]	[mm]	[mm]		[mm]	[min-1]		

Ø D	B	Ø d	Z	L	nmax	Ident-No. [L]	Ident-No. [R]
251	15	40	2	98	6000	185309 O	185308 O
251	15	40	3	98	6000	185311 O	185310 O
251	15	40	4	98	6000	185313 O	185312 O
251	15	40	6	98	6000	185315 O	185314 O
251	15	40	12	98	6000	185317 O	185316 O
[mm]	[mm]	[mm]		[mm]	[min-1]		

Ø D	B	Ø d	Z	L	nmax	Ident-No. [L]	Ident-No. [R]
260.4	20	40	2	98	6000	185371 O	185381 O
260.4	20	40	3	98	6000	185372 O	185382 O
260.4	20	40	4	98	6000	185373 O	185383 O
260.4	20	40	6	98	6000	185374 O	185384 O
260.4	20	40	12	98	6000	185375 O	185385 O
[mm]	[mm]	[mm]		[mm]	[min-1]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Cutting edges DP-tipped unprofiled	B=10	232094	4	186888 L
Cutting edges DP-tipped unprofiled	B=15	232094	4	185045 L
Cutting edges DP-tipped unprofiled	B=20	232094	4	185370 L
Tool body profile cutterheads	210X23X60	396291	1	185043 L
Spacers (only for B=10+15)	Ø119x5,0xØ60	955520	1	185365 L
Spacers	Ø119x39,5xØ60	955520	1	185044 L
Head Cap Screws	M6x20-8.8 DIN 6912	995111	10	185355 L
Head Cap Screws	M8x70 DIN EN ISO 4762	995111	10	179470 L
Hydro Clamping Bushing	Ø120x96xØ60/40	933030	1	172678 L
	[mm]		[pc.]	

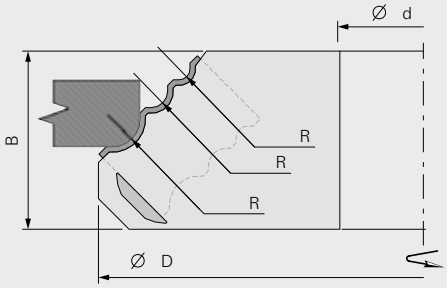
120325

Round Star Cutterheads HW

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- spindle moulder
- for profiling of solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Solid 20
- high-tensile aluminum body
- chip limiter design

Advantages

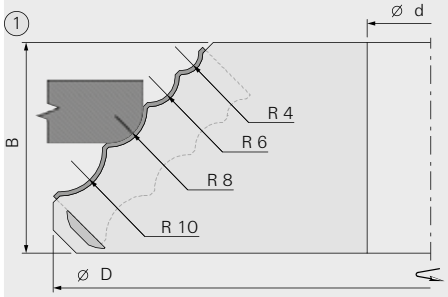
Notes

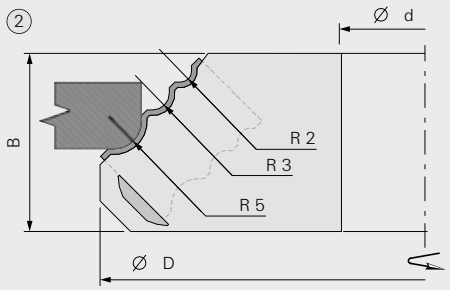
- application against feed

R	Ø D	B	Ø d	Z	Type	nmin-nmax	Ident-No.
2, 3, 5	140	32	30	2	2	5400-6400	50661673 C
4, 6, 8, 10	180	50	30	2	1	4600-7800	50661672 S
[mm]	[mm]	[mm]	[mm]			[min-1]	

Turnover Knives	Type	R	B	H	S	Class-No.	PU	Ident-No.
Profile Knives KB19	2	2, 3, 5	25	16	2.0	151547	2	50820002 L
Profile Knives KB20	1	4,6,8,10	50	16	2.0	151547	2	50820001 L
		[mm]	[mm]	[mm]	[mm]		[pc.]	

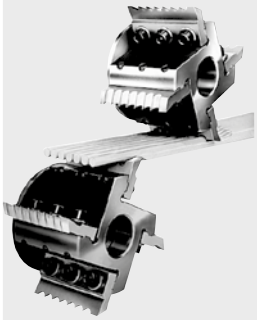
Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	48x11x6	925300	2	180346 L
Clamping Pieces	12x8,5/M8L	925100	2	180357 L
Clamping Set Screws	M8x26 SW4	995195	10	180340 L
Screwdrivers	SW4x100	985730	1	166091 L
	[mm]		[pc.]	



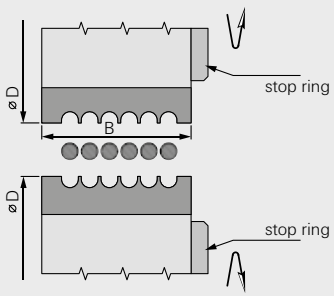


Multi Dowel Cutterheads HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- multi spindle milling machines
- for the production of smooth round bars of 2 to 16 mm and of corrugated dowels of 6.1 to 16.1 mm in solid woods

Design

- body made from steel
- 2 or 4 knife holders

Advantages

- quick knife change
- self-centering knife seat

Notes

- guide-plate for axial adjustment of knives
- further profiles on request

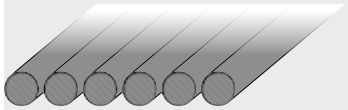
Ø D	B	Ø d	Ø dmax	Z	nmax	Ident-No.
102	50	35	40	2	6000	50389261 C
102	75	35	40	2	6000	50389262 S
102	100	35	40	2	6000	50389263 S
102	50	40	40	2	6000	50389264 C
102	75	40	40	2	6000	50389265 S
102	100	40	40	2	6000	50389266 S
102	125	40	40	2	6000	50389267 S
102	150	40	40	2	6000	50389268 S
102	50	35	40	4	6000	50389269 S
102	75	35	40	4	6000	50389270 C
102	100	35	40	4	6000	50389271 S
102	50	40	40	4	6000	50389272 S
102	75	40	40	4	6000	50389273 S
102	100	40	40	4	6000	50389274 S
102	125	40	40	4	6000	50389275 S
102	150	40	40	4	6000	50389276 S
[mm]	[mm]	[mm]	[mm]		[min-1]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Head Cap Screws	M8x30-8.8 DIN 7984	995111	10	180005 L
Cranked Wrench Keys	SW6x100	985730	1	180383 C
	[mm]		[pc.]	

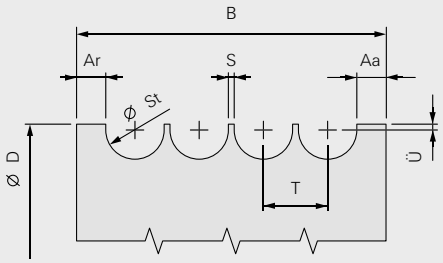
332990

Knives HS - smooth round bars

Product



Drawing



High Speed Steel [HS]

Machine / Application

Design

Advantages

Notes

- small quantities: surcharge of 50%
- intermediate dimensions: surcharge of 25% on the next lower dimension
- indicate machine type when placing an order
- price per piece when ordering 8 identical knives

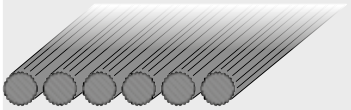
Knives

	St= bar Ø		2	3	4	5	6	7	8	9	10	11	12	13	14	15	16
	S = bridge		1	1	1	1	1	1	1	1	1	1,5	1,5	1,5	1,5	1,5	1,5
	T= pitch		3	4	5	6	7	8	9	10	11	12,5	13,5	14,5	15,5	16,5	17,5
	D= diameter		127	127	127	127	127	127	135	135	135	135	135	135	135	135	135
B=50	No. of bars		12	9	8	7	6	5	4	4	3	3	3	3	2	2	2
	Ident-No.	50...	389200	389201	389202	389203	389204	389205	389206	389207	389208	389209	389210	389211	389212	389213	389214
B=75	No. of bars			16	13	11	9	8	7	6	6	5	5	4	4	4	4
	Ident-No.	50...		389215	389216	389217	389218	389219	389220	389221	389222	389223	389224	389225	389226	389227	389228
B=100	No. of bars				18	15	13	11	10	9	8	7	6	6	6	5	5
	Ident-No.	50...			389229	389230	389231	389232	389233	389234	389235	389236	389237	389238	389239	389240	389241
B=125	No. of bars						16	14	13	11	10	9	8	8	7	7	7
	Ident-No.	50...					389242	389243	389244	389245	389246	389247	389248	389249	389250	389251	389252
B=150	No. of bars									14	13	11	10	9	9	8	8
	Ident-No.	50...								389253	389254	389255	389256	389257	389258	389259	389260

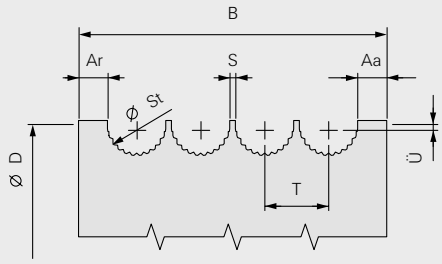
332990

Knives HS - ripple bars

Product



Drawing



High Speed Steel [HS]

Machine / Application

Design

Advantages

Notes

- small quantities: surcharge of 50%
- intermediate dimensions: surcharge of 25% on the next lower dimension
- indicate machine type when placing an order
- price per piece when ordering 8 identical knives

Knives

	St= bar Ø	6,1	7,1	8,1	10,1	11,1	12,1	13,1	14,1	15,1	16,1
	No. of serrations	16	16	20	22	22	22	22	22	22	22
	S = bridge	1	1	1	1	1,5	1,5	1,5	1,5	1,5	1,5
	T= pitch	7,1	8,1	9,1	11,1	12,6	13,6	14,6	15,6	16,6	17,6
	D= diameter	127	127	135	135	135	135	135	135	135	135
B=50	No. of bars	6	5	4	3	3	3	3	2	2	2
	Ident-No. 50...	389300	389301	389302	389303	389304	389305	389306	389307	389308	389309
B=75	No. of bars	9	8	7	6	5	5	4	4	4	3
	Ident-No. 50...	389310	389311	389312	389313	389314	389315	389316	389317	389318	389319
B=100	No. of bars	12	11	10	8	7	6	6	5	5	5
	Ident-No. 50...	389320	389321	389322	389323	389324	389325	389326	389327	389328	389329
B=125	No. of bars	16	14	13	10	9	8	8	7	7	6
	Ident-No. 50...	389330	389331	389332	389333	389334	389335	389336	389337	389338	389339
B=150	No. of bars				12	11	10	9	9	8	8
	Ident-No. 50...				389340	389341	389342	389343	389344	389345	389346

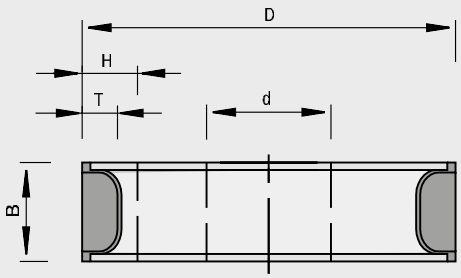
120607

SuperProfiler HW (inside profile) - MAN

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- table shapers
- for planing and profiling of solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- n = 6.200 - 10,700 min-1
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods

Advantages

- cutterhead for mounting of several profile knives

Notes

- application against feed
- profile knife can be profiled per customer specifications
- included in delivery: cutterhead with clamping elements, without profile knives, support plates and deflectors

Ø D	B	Ø d	Ø dmax	Tmax	Z	Drawing	Ident-No. unprofiled
125	40	30	35	13	2	SP 1	167263 L
125	60	30	35	15	2	SP 2	167264 C
[mm]	[mm]	[mm]	[mm]	[mm]		[Foil]	

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No.
SP blanks	40,6	28.2	HL Board 06	SP 1	152526	10	179112 L
SP blanks	40,6	28.2	HL Solid 60	SP 1	152529	10	177367 L
SP blanks	60,8	30.2	HL Board 06	SP 2	152526	10	179113 L
SP blanks	60,8	30.2	HL Solid 60	SP 2	152529	10	177368 L
support plates	40	26.5		SP 1	925402	2	178007 L
support plates	60	28.5		SP 2	925402	2	178008 L
deflector plates	40	28		SP 1	925407	1	167267 L
deflector plates	60	30		SP 2	925407	1	167268 L
	[mm]	[mm]				[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	36x12x8	167263	925300	2	166737 L
Pressure Bars	58x12x8	167264	925300	2	166738 L
Special Set Screws	M8x24	For all	995191	10	167269 L
Screwdrivers	SW4x100	For all	985730	1	166091 L
	[mm]			[pc.]	

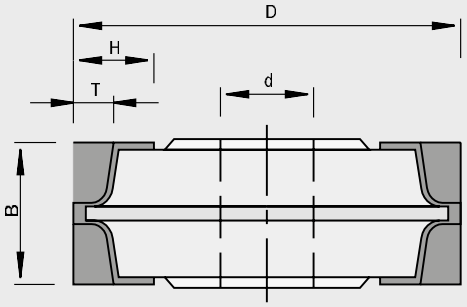
120607

SuperProfiler HW (outside profile) - MAN

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- table shapers
- for profiling of solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- n = 6.200 - 10,700 min-1
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods

Advantages

- cutterhead for mounting of several profile knives

Notes

- application against feed
- profile knife can be profiled per customer specifications
- included in delivery: cutterhead with clamping elements, without profile knives, support plates and deflectors

Ø D	B	Ø d	Ø dmax	Tmax	Z	Drawing	Ident-No. unprofiled
125	40	30	35	13	2	SP 3	167897 C
[mm]	[mm]	[mm]	[mm]	[mm]		[Foil]	

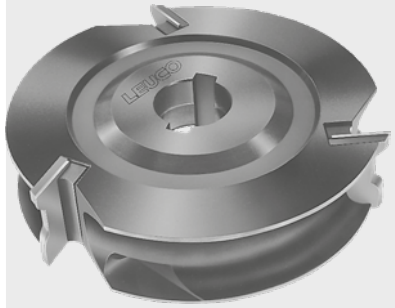
Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No.
SP blanks	40,6	28.2	HL Board 06	SP 3	152526	10	179112 L
SP blanks	40,6	28.2	HL Solid 60	SP 3	152529	10	177367 L
support plates	40	26.5		SP 3	925402	2	178011 L
deflector plates	40	28		SP 3	925407	1	167898 L
	[mm]	[mm]				[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	36x12x8	925300	2	166737 L
Special Set Screws	M8x24	995191	10	167269 L
Screwdrivers	SW4x100	985730	1	166091 L
	[mm]		[pc.]	

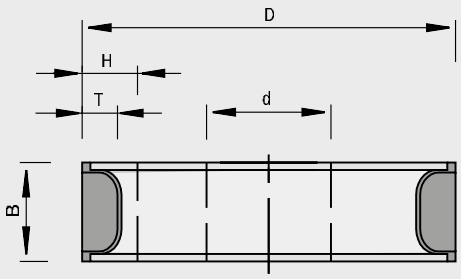
120602

SuperProfiler HW (inside profile) - MEC

Product



Drawing



SUPER PROFILER

Tungsten Carbide [HW]

MEC

Machine / Application

- double end tenoners
- molders
- profiling unit and length processing unit IMA
- for profiling of solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods

Advantages

- cutterhead for mounting of several profile knives

Notes

- profile knife can be profiled per customer specifications
- included in delivery: cutter-head with clamping elements, without profile knives and support plates

Ø D	B	Ø d	Ø dmax	Tmax	Z	DKN	nmax	Drawing	Ident-No. unprofiled
125	40	30	35	13	2	8x3	12000	SP 7	167439 C
125	40	31,75	35	13	2		12000	SP 7	167440 C
125	60	31,75	35	15	2		12000	SP 5	167442 C
150	40	30	50	13	3	8x3	10000	SP 7	166971 L
150	40	31,75	50	13	3		10000	SP 7	176184 C
150	40	35	50	13	3	10x4	10000	SP 7	166972 C
150	40	40	50	13	3	12x5	10000	SP 7	166973 L
150	60	30	50	15	3	8x3	10000	SP 5	166975 C
150	60	40	50	15	3	12x5	10000	SP 5	166977 C
150	60	31,75	35	25	3		7200	SP 4	176230 C
165	40	30	50	20	3	8x3	8500	SP 33	176088 C
180	40	35	50	13	3	10x4	8000	SP 7	166720 C
180	40	40	50	13	3	12x5	8000	SP 7	166721 C
180	60	35	50	15	3	10x4	8000	SP 5	166723 C
180	60	40	50	15	3	12x5	8000	SP 5	166724 C
180	60	31,75	50	25	3		6000	SP 4	168127 S
180	60	50	50	25	3		6000	SP 4	168131 C
180	80	40	50	25	3	12x5	6000	SP 6	167993 C
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	[Foil]	

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No.
SP blanks	40,6	28.2	HL Board 06	SP 7	152526	10	179112 L
SP blanks	40,6	28.2	HL Solid 60	SP 7	152529	10	177367 L
SP blanks	60,8	30.2	HL Board 06	SP 5	152526	10	179113 L
SP blanks	60,8	30.2	HL Solid 60	SP 5	152529	10	177368 L
SP blanks	40,6	40.6	HL Board 06	SP 33	152526	10	179115 L
SP blanks	40,6	40.6	HL Solid 60	SP 33	152529	10	178844 L
SP blanks	60,6	45.6	HL Board 06	SP 4	152526	10	179999 L
SP blanks	60,6	45.6	HL Solid 60	SP 4	152529	10	178845 L
SP blanks	80,6	45.6	HL Board 06	SP 6	152526	10	180016 L
SP blanks	80,6	45.6	HL Solid 60	SP 6	152529	10	180017 S
support plates	40	26.5		SP 7	925402	2	178007 L
support plates	40	38		SP 33	925402	2	178006 L
support plates	60	28.5		SP 5	925402	2	178008 L
support plates	60	43		SP 4	925402	2	178009 L
support plates	80	43		SP 6	925402	2	178013 L
	[mm]	[mm]				[pc.]	

Spare parts	Dimension	For drawing/foil	Class-No.	PU	Ident-No.
Pressure Bars	36x12x8	SP 7	925300	2	166737 L
Pressure Bars	36x14x8	SP 33	925300	2	176096 C
Pressure Bars	56x15x8	SP 4	925300	2	167055 L
Pressure Bars	58x12x8	SP 5	925300	2	166738 L
Pressure Bars	76x15x8	SP 6	925300	2	167989 S
Set Screws	M8x20 DIN EN ISO 4028		995161	10	001625 L
Screwdrivers	SW4x100		985730	1	166091 L
	[mm]			[pc.]	

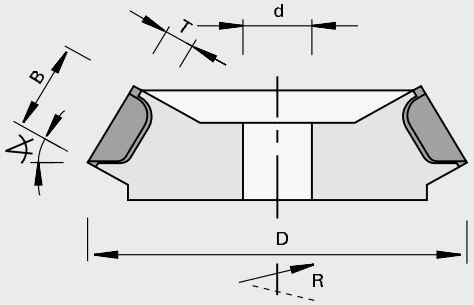
120622

SuperProfiler HW (outside profile) - MEC

Product



Drawing



SUPER PROFILER

Tungsten Carbide [HW]

MEC

Machine / Application
- double end tenoners
- molders
- for profiling of solid woods and wood-based panels

Design
- cutting edges parallel to cutter axis
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods

Advantages
- cutterhead for mounting of several profile knives

Notes
- profile knife can be profiled per customer specifications
- included in delivery: cutterhead with clamping elements, without profile knives and support plates
- sense of rotation according to VDMA 8849

Ø D	B	Ø d	Ø dmax	Tmax	Z	DKN	Crank∢	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
165	40	30	40	13	3	8x3	30	9000	SP 13	167967 C	167968 C
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[°]	[min-1]	[Foil]		

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No.
SP blanks	40,6	28.2	HL Board 06	SP 12 / 13	152526	10	179112 L
SP blanks	40,6	28.2	HL Solid 60	SP 12 / 13	152529	10	177367 L
support plates	40	26.5		SP 12 / 13	925402	2	178007 L
	[mm]	[mm]				[pc.]	

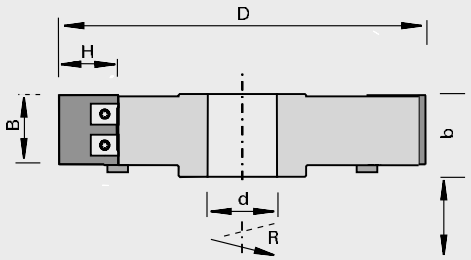
Spare parts	Dimension		Class-No.	PU	Ident-No.
Pressure Bars	36x12x8	left	925300	2	166736 L
Pressure Bars	36x12x8	right	925300	2	166737 L
Set Screws	M8x20 DIN EN ISO 4028		995161	10	001625 L
Screwdrivers	SW4x100		985730	1	166091 L
	[mm]			[pc.]	

120603

EcoPro Cutterheads HW (straight) - MAN

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- machining centers
- double end tenoners
- molders
- table shapers
- for profiling of solid woods and wood-based panels

Design

- special aluminum cutterhead body
- cutting edges parallel to cutter axis
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods

Advantages

- cutterhead body and knives will be profiled according to customer specifications

Notes

- profile knives can be profiled according to customer specifications
- cutterhead body can be used only for one profile
- sense of rotation according to VDMA 8849

Ø D	B	H	b	Ø d	Ø dmax	Z	nmin-nmax	EP-No.	Drawing	Ident-No. unprofiled
125	30	30	36	30	30	3	7700-10480	50	EP 382	179050 S
125	40	30	46	30	30	3	7700-9480	51	EP 384	179051 S
125	50	33	56	30	30	3	7700-8420	52	EP 386	179052 S
150	30	30	36	30	50	3	6200-9620	53	EP 382	179053 S
150	40	30	46	30	50	3	6200-8420	54	EP 384	179054 S
150	50	33	56	30	50	3	6200-7300	55	EP 386	179055 S
180	30	30	36	30	50	4	4800-8600	56	EP 382	179056 S
180	40	30	46	30	50	4	4800-7520	57	EP 384	179057 S
180	50	33	56	30	50	4	5200-6500	58	EP 386	179058 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]		[Foil]	

Blanks for Ident-No.	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
179050, 179053, 179056, 179087, 179090, 179093, 179094	30,2	30.4	HL Board 06	EP 382	152586	10		178528 L
179050, 179053, 179056, 179087, 179090, 179093, 179094	30,2	30.4	HL Solid 60	EP 382	152589	10		179528 L
179051, 179054, 179057, 179088, 179091, 179095, 179096	40,1	30.4	HL Board 06	EP 384	152586	10		178534 L
179051, 179054, 179057, 179088, 179091, 179095, 179096	40,1	30.4	HL Solid 60	EP 384	152589	10		179534 L
179052, 179055, 179058, 179089, 179092, 179097, 179098	49,9	33	HL Board 06	EP 386	152586	10		178540 L
179052, 179055, 179058, 179089, 179092, 179097, 179098	49,9	33	HL Solid 60	EP 386	152589	10		179540 L
179050, 179053, 179056, 179087, 179090, 179093, 179094	30,2	30.4	HL Board 06 topline	EP 382	152786	10	179585 L	179586 O
179050, 179053, 179056, 179087, 179090, 179093, 179094	30,2	30.4	HL Solid 60 topline	EP 382	152789	10	179659 O	179660 O
179051, 179054, 179057, 179088, 179091, 179095, 179096	40,1	30.4	HL Board 06 topline	EP 384	152786	10	179597 L	179598 O
	[mm]	[mm]				[pc.]		

Blanks for Ident-No.	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
179051, 179054, 179057, 179088, 179091, 179095, 179096	40,1	30.4	HL Solid 60 topline	EP 384	152789	10	179671 S	179672 S
179052, 179055, 179058, 179089, 179092, 179097, 179098	49,9	33	HL Board 06 topline	EP 386	152786	10	179609 L	179610 O
179052, 179055, 179058, 179089, 179092, 179097, 179098	49,9	33	HL Solid 60 topline	EP 386	152789	10	179683 L	179684 L
	[mm]	[mm]				[pc.]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M4,5x4,6x9 T15	995195	10	178239 L
Screwdrivers	T15x80	985730	1	171188 L
	[mm]		[pc.]	

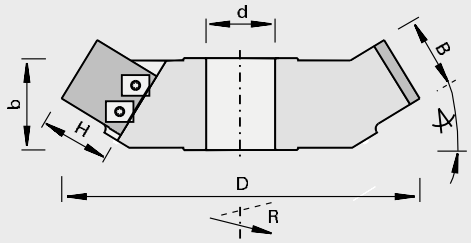
120613

EcoPro Cutterheads HW (cranked) - MAN

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- machining centers
- double end tenoners
- molders
- table shapers
- for profiling of solid woods and wood-based panels

Design

- with shear angle
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods

Advantages

- cutterhead body and knives will be profiled according to customer specifications

Notes

- profile knives can be profiled according to customer specifications
- cutterhead body can be used only for one profile
- sense of rotation according to VDMA 8849

Ø D	B	H	b	Ø d	Ø dmax	Z	Crank◁	nmin-nmax	EP-No.	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
150	40	30	49	30	30	3	30	6300-7460	59	EP 390	179350 S	179059 S
180	40	30	50	30	50	4	30	5000-6580	61	EP 390	179355 S	179061 S
180	50	33	57	30	50	4	30	5000-5700	62	EP 392	179358 S	179062 S
165	40	30	46	30	30	3	45	5300-6920	63	EP 396	179360 S	179063 S
165	50	33	53	30	30	3	45	4600-6040	64	EP 398	179362 S	179064 S
195	40	30	46	30	50	4	45	5300-6160	65	EP 396	179365 S	179065 S
195	50	33	53	30	50	4	45	4600-5320	66	EP 398	179368 S	179066 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[°]	[min-1]		[Foil]		

Blanks for Ident-No.	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
179059, 179061, 179063, 179065, 179099, 179101, 179102, 179105, 179107, 179108, 179349, 179350, 179353, 179354, 179355, 179359, 179360, 179363, 179364, 179365	40,1	30.4	HL Board 06	EP 396	152586	10		178534 L
	[mm]	[mm]				[pc.]		

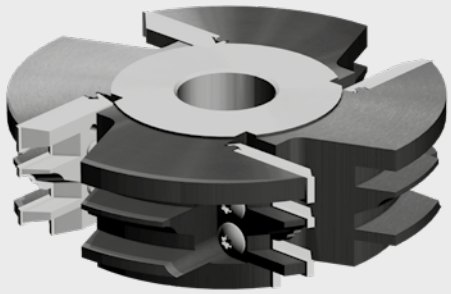
Blanks for Ident-No.	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
179059, 179061, 179063, 179065, 179099, 179101, 179102, 179105, 179107, 179108, 179349, 179350, 179353, 179354, 179355, 179359, 179360, 179363, 179364, 179365	40,1	30.4	HL Solid 60	EP 396	152589	10		179534 L
179060, 179062, 179064, 179066, 179100, 179103, 179104, 179106, 179109, 179110, 179351, 179352, 179356, 179357, 179358, 179361, 179362, 179366, 179367, 179368	49,9	33	HL Board 06	EP 398	152586	10		178540 L
179060, 179062, 179064, 179066, 179100, 179103, 179104, 179106, 179109, 179110, 179351, 179352, 179356, 179357, 179358, 179361, 179362, 179366, 179367, 179368	49,9	33	HL Solid 60	EP 398	152589	10		179540 L
179059, 179061, 179063, 179065, 179099, 179101, 179102, 179105, 179107, 179108	40,1	30.4	HL Board 06 topline	EP 390, EP 396	152786	10	179597 L	179598 O
179059, 179061, 179063, 179065, 179099, 179101, 179102, 179105, 179107, 179108	40,1	30.4	HL Solid 60 topline	EP 390, EP 396	152789	10	179671 S	179672 S
179060, 179062, 179064, 179066, 179100, 179103, 179104, 179106, 179109, 179110	49,9	33	HL Board 06 topline	EP 392 / 398	152786	10	179609 L	179610 O
179060, 179062, 179064, 179066, 179100, 179103, 179104, 179106, 179109, 179110	49,9	33	HL Solid 60 topline	EP 392 / 398	152789	10	179683 L	179684 L
	[mm]	[mm]				[pc.]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M4,5x4,6x9 T15	995195	10	178239 L
Screwdrivers	T15x80	985730	1	171188 L
	[mm]		[pc.]	

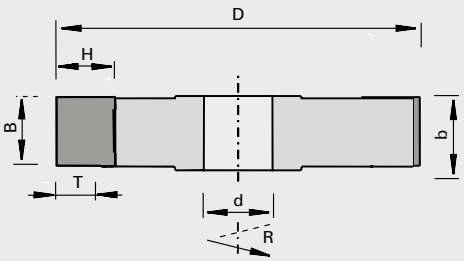
120604/120606

UltraProfiler plus - Cutterheads HW (straight) - MAN

Product



Drawing



LEUCO ultraprofiler plus

Tungsten Carbide [HW]

MAN

Machine / Application

- machining centers
- double end tenoners
- molders
- table shapers
- for profiling of solid woods and wood-based panels

Design

- cutterhead body made from extremely tight aluminum alloy
- with shear angle
- cutting material: HW HL Board 06 for solid woods and wood-based panels

Advantages

- large profile depths possible
- cutterhead body and knives will be profiled according to customer specifications
- cutting speed up to 80 m/s
- concentric accuracy 0,03 mm

Notes

- knives available in Topline design (polished face, ultra-fine ground clearance surface)
- with a larger shear angle, the number of teeth may be lower
- sense of rotation according to VDMA 8849

Ø D	B	H	Ø d	Ø dmax	T	Z	nmin-nmax
115	15	30	30	30	15	2-3	6500-13300
125	15-60	40	30	30	26	2-4	6500-12300
150	15-60	40	30	50	26	2-6	5500-10200
180	15-60	40	30	50	26	2-6	5000-8500
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]

Blanks	B	H	S	LEUCODUR	Class-No.	PU	Ident-No.
	15	30.4	2.0	HL Board 06	152516	10	183056 L
	20	40.4	2.0	HL Board 06	152516	10	183057 L
	25	40.4	2.0	HL Board 06	152516	10	183058 L
	32	40.4	2.0	HL Board 06	152516	10	182419 L
	40	40.4	2.0	HL Board 06	152516	10	182420 L
	50	40.4	2.0	HL Board 06	152516	10	182421 L
	60	40.4	2.0	HL Board 06	152516	10	182422 L
	[mm]	[mm]	[mm]			[pc.]	

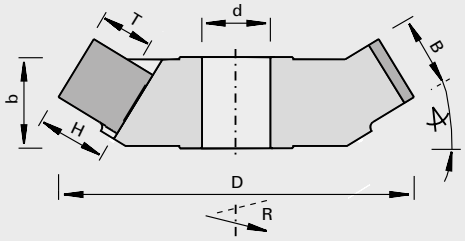
Blanks	B	H	S	LEUCODUR	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	15	30.4	2.0	HL Board 06 topline	152716	10	183680 S	183680 S
	20	40.4	2.0	HL Board 06 topline	152716	10	183681 S	183681 S
	25	40.4	2.0	HL Board 06 topline	152716	10	183682 S	183682 S
	32	40.4	2.0	HL Board 06 topline	152716	10	182563 C	182562 C
	40	40.4	2.0	HL Board 06 topline	152716	10	182565 S	182564 S
	60	40.4	2.0	HL Board 06 topline	152716	10	182569 S	182568 S
	[mm]	[mm]	[mm]			[pc.]		

120614/120616

UltraProfiler plus - Cutterheads HW (cranked) - MAN

Product

Drawing



LEUCO ultraprofiler plus

Tungsten Carbide [HW]

MAN

Machine / Application

- machining centers
- double end tenoners
- molders
- table shapers
- for profiling of solid woods and wood-based panels

Design

- cutterhead body made from extremely tight aluminum alloy
- with shear angle
- cutting material: HW HL Board 06 for solid woods and wood-based panels

Advantages

- large profile depths possible
- cutterhead body and knives will be profiled according to customer specifications
- cutting speed up to 80 m/s
- concentric accuracy 0,03 mm

Notes

- knives available in Topline design (polished face, ultra-fine ground clearance surface)
- with a larger shear angle, the number of teeth may be lower
- sense of rotation according to VDMA 8849

Ø D	B	H	Ø d	Ø dmax	T	Z	nmin-nmax
150	32-40	40	30	30	26	2-6	5100-10200
165	32-50	40	30	30	26	2-6	5100-9200
180	40-60	40	30	50	26	2-6	5000-8500
195	40-60	40	30	50	26	2-8	4800-7800
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]

Blanks	B	H	S	LEUCODUR	Class-No.	PU	Ident-No.
	15	30.4	2.0	HL Board 06	152516	10	183056 L
	20	40.4	2.0	HL Board 06	152516	10	183057 L
	25	40.4	2.0	HL Board 06	152516	10	183058 L
	32	40.4	2.0	HL Board 06	152516	10	182419 L
	40	40.4	2.0	HL Board 06	152516	10	182420 L
	50	40.4	2.0	HL Board 06	152516	10	182421 L
	60	40.4	2.0	HL Board 06	152516	10	182422 L
	[mm]	[mm]	[mm]			[pc.]	

Blanks	B	H	S	LEUCODUR	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	15	30.4	2.0	HL Board 06 topline	152716	10	183680 S	183680 S
	20	40.4	2.0	HL Board 06 topline	152716	10	183681 S	183681 S
	25	40.4	2.0	HL Board 06 topline	152716	10	183682 S	183682 S
	32	40.4	2.0	HL Board 06 topline	152716	10	182563 C	182562 C
	40	40.4	2.0	HL Board 06 topline	152716	10	182565 S	182564 S
	60	40.4	2.0	HL Board 06 topline	152716	10	182569 S	182568 S
	[mm]	[mm]	[mm]			[pc.]		

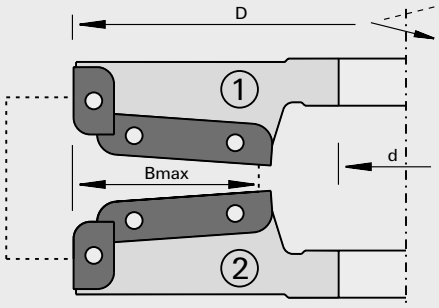
120645

Panel Raising Cutterheads HW - Silverline

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- spindle moulder
- for panel-raising of door panels in solid woods and wood-based panels

Design

- tool body made from steel
- cutting edges parallel to cutter axis
- cutting material: HW HL Board 05

Advantages

- up to 12 different profiles in the same tool body possible
- further versions possible thanks to height adjustment

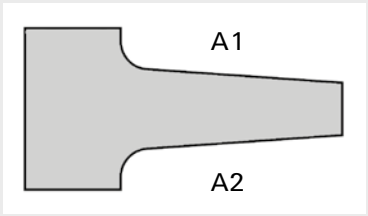
Notes

- included in delivery: 1 panel raising cutterhead with mounted knives for profile B (62556021, 62556022)
- alternative profiles not included in delivery

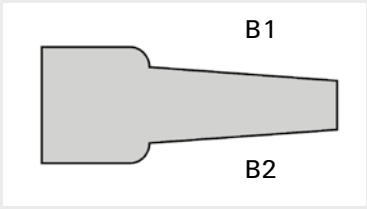
Cutter-no.	Ø D	Bmax	Ø d	Z	nmin-nmax		Ident-No.
1	200	60	30	2+2	3800 - 6500	L	68255130 C
2	200	60	30	2+2	3800 - 6500	R	68255230 C
1	200	60	40	2+2	3800 - 6500	L	68255140 C
2	200	60	40	2+2	3800 - 6500	R	68255240 C
1	200	60	50	2+2	3800 - 6500	L	68255150 C
2	200	60	50	2+2	3800 - 6500	R	68255250 C
	[mm]	[mm]	[mm]		[min-1]		

Turnover Knives	Dimension	For Ident-No.	Class-No.	PU		Ident-No.
Profile Panel Raising Cutting Edges A1	60x12x1,5	68255130, 68255140, 68255150	151549	6	L	62556011 C
Profile Panel Raising Cutting Edges A2	60x12x1,5	68255230, 68255250, 68255240	151549	6	R	62556012 C
Profile Panel Raising Cutting Edges B1	60x12x1,5	68255130, 68255140, 68255150	151549	6	L	62556021 C
Profile Panel Raising Cutting Edges B2	60x12x1,5	68255230, 68255250, 68255240	151549	6	R	62556022 C
Profile Panel Raising Cutting Edges C1	60x12x1,5	68255130, 68255140, 68255150	151549	6	L	62556031 C
Profile Panel Raising Cutting Edges C2	60x12x1,5	68255230, 68255250, 68255240	151549	6	R	62556032 C
Profile peripheral cutting edge T1	20x12x1,5	68255130, 68255140, 68255150	151549	6	L	62556023 C
Profile peripheral cutting edge T2	20x12x1,5	68255230, 68255250, 68255240	151549	6	R	62556024 C
Profile peripheral cutting edge V1	20x12x1,5	68255130, 68255140, 68255150	151549	6	L	62556013 C
Profile peripheral cutting edge V2	20x12x1,5	68255230, 68255250, 68255240	151549	6	R	62556014 C
	[mm]			[pc.]		

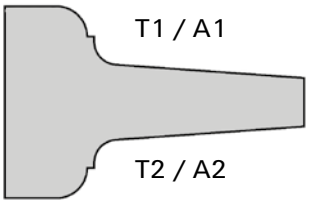
Profile combinations



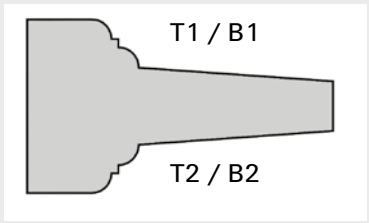
A



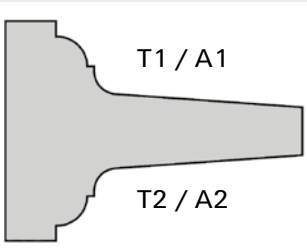
B



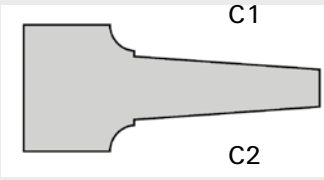
A/T



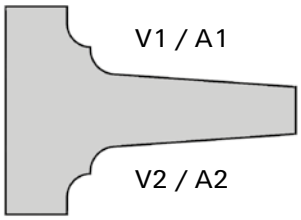
BT



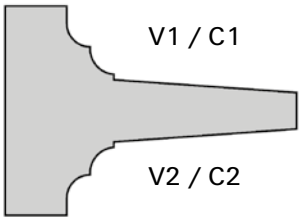
A/T



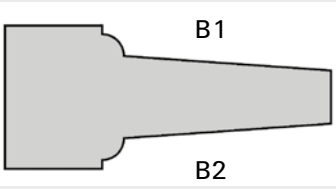
C



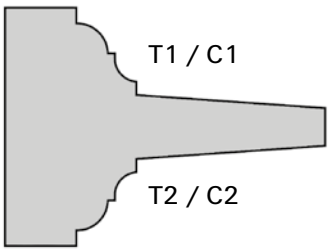
A/V



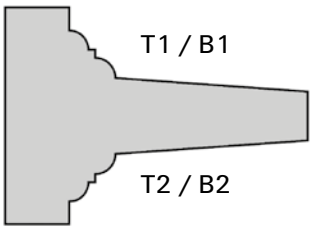
CV



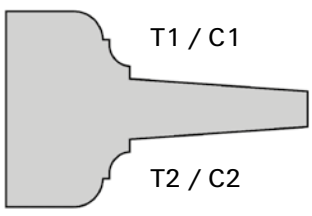
B



CT



B/T



CT

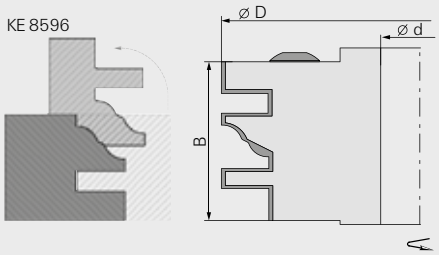
121625

Counter Profile Cutterheads HW

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- spindle moulder
- for milling of length- and counterprofiles on doors, furniture parts and door panels in solid woods and wood-based panels

Design

- body made from high-strength aluminium
- cutting edges parallel to cutter axis
- cutting material: HW HL Board 06
- chip limiter design

Advantages

- cutterhead for mounting of several profile knives
- simple knife change

Notes

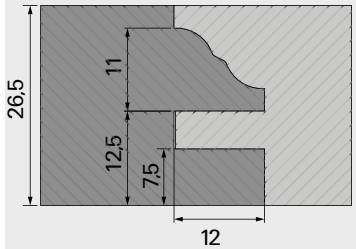
- counter profile set with profile KE8596
- alternative profiles not included in delivery

Ø D	B	Ø d	Z	nmin-nmax	Ident-No.
130 [mm]	40 [mm]	30 [mm]	2	6000-12000 [min-1]	50664637 L

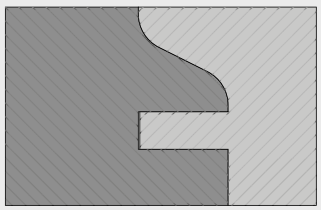
Turnover Knives	LEUCODUR	Class-No.	PU	Ident-No.
Profile Knives KE7824	HL Board 06	151586	6	50687824 C
Profile Knives KE7826	HL Board 06	151586	2	50687826 L
Profile Knives KE7828	HL Board 06	151586	6	50687828 C
Profile Knives KE8596	HL Board 06	151586	6	50688596 S
Profile Knives KE8598	HL Board 06	151586	6	50688598 C
			[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	B=36	925300	2	50773906 S
Set Screws	M6x16 SW3	995161	10	001617 L
Screwdrivers	SW3x100	985730	1	166090 L
	[mm]		[pc.]	

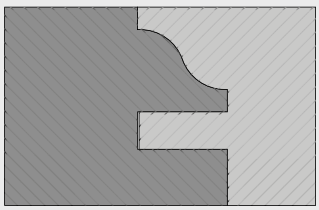
KE 8596



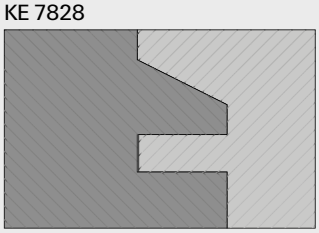
KE 7824



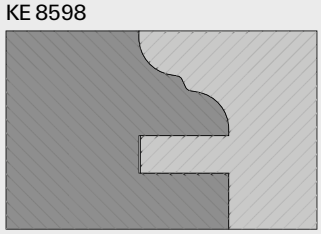
KE 7826



KE 7828



KE 8598

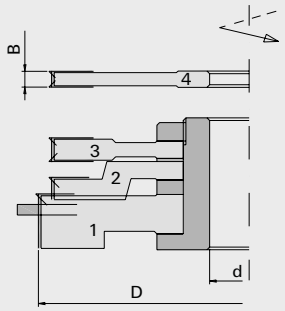


120450 / 121450

Door leaf set HW

Product

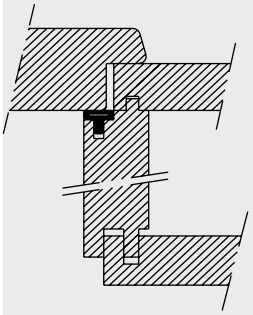
Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN



Machine / Application

- molders
- for manufacturing door leaves and cladding in solid woods and wood-based materials

Design

Advantages

- no tool change needed since different profiles are manufactured with the same cutter set

Notes

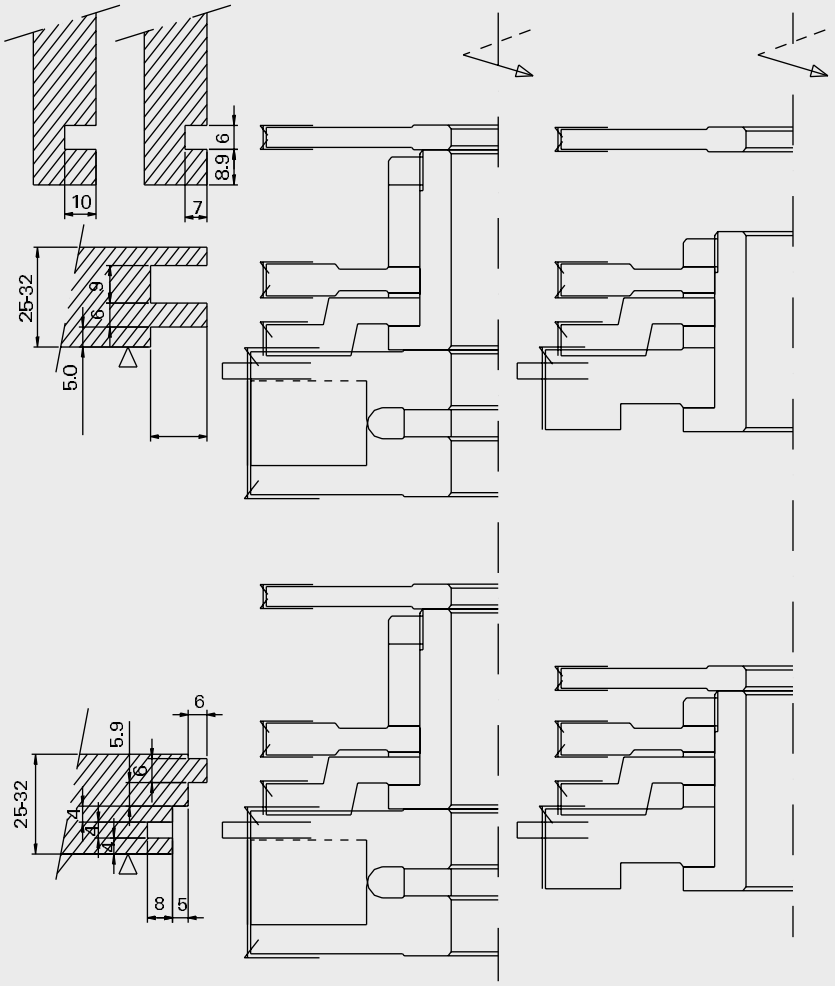
- Ident-No. 199399 with 887060 for complete processing
- Ident-No. 199398 as construction set for Poly Rabbeting Cutterhead

Ø D	B	Ø d	Z		Ident-No. top
150		30	2+2	Cutter 2/3 on clamping bushing	199398 L
150		30	2+2	Cutter 1/2/3 on clamping bushing	199399 L
150	9,0	30	4+4	Cutter 3	887059 S
150	6,0	30	4+4	Cutter 4	887060 L
[mm]	[mm]	[mm]			

Turnover Knives	B	H	S		Class-No.	PU	Ident-No.
Spurs	14	14	2.0	for cutters 1/2/3	150558	10	003079 L
Spurs	14	14	1.2	for cutter 4	150558	10	163701 L
VHW grooving cutter	4,0			for cutter 1	151512	10	199699 L
Turnover Knives	20	12	1.5	for cutter 1	150515	10	003082 L
Turnover Knives	7,5	12	1.5	for cutter 2	150515	10	052543 L
Turnover Knives	8,6	12	1.5	for cutter 3	150512	10	881585 L
Turnover Knives	18	18	2.9	for cutter 4	150514	10	418977 L
	[mm]	[mm]	[mm]			[pc.]	

Spare parts	Dimension		Class-No.	PU	Ident-No.
Pressure Bars		for cutter 1	925300	2	882863 S
Pressure Bars	B=7,2	for cutters 2/3	925300	2	870829 L
Countersunk Screws	M5x7 T15	for cutters 1/2/3	995125	10	900512 L
Set Screws	M6x16 SW3	for cutter 1	995161	10	001617 L
Set Screws	M5x16 DIN EN ISO 4028	for cutter 3	995161	10	873731 L
Special Nuts	M4x0,5x1,6	for cutter 4 / 163701	995290	10	163704 L
Special Nuts	M4x0,5x2,2	for cutter 4	995290	10	874748 L
Countersunk Screws	M4x0,5x4,2 T9 D=Ø6	for cutter 4	995125	10	165908 L
Countersunk Screws	M5x13,5 T20 D=Ø10	for cutter 1	995125	10	171238 L
Screwdrivers	T15	for cutters 1/2/3	985730	1	013953 L
Screwdrivers	T20	for cutter 1	985730	1	013954 L
	[mm]			[pc.]	

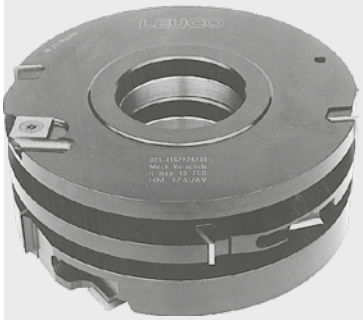
Spare parts	Dimension		Class-No.	PU	Ident-No.
Cranked Wrench Keys	SW2,5 DIN ISO 2936	for cutters 1/2/3	985730	1	009671 L
Hook Wrenches	68-75	for clamping bushing	985720	1	873631 L
Magnetic Stops	0,5	for cutters 1/2/3	997800	1	166093 L
	[mm]			[pc.]	



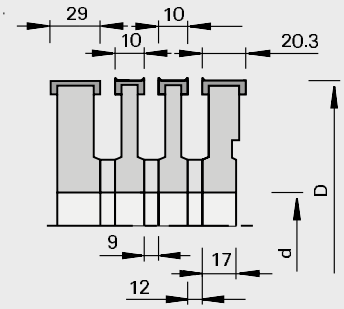
120450

Groove Bed Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- molders with groove bed section Weinig
- for cutting of guide grooves in solid woods

Design

- n max = 10,700 min-1
- single tools with spur
- Ident-No. 180536, 186498 without spur

Advantages

Notes

- application with the grain
- attention: replacement parts for old cutterhead sets: cutterhead width = 9 mm can be replaced with new cutterhead width = 10 mm when spacer width = 10 mm is replaced with spacer width = 9 mm cutterhead width = 10.5 mm can be replaced with cutterhead width = 10 mm

Ø D	B	Ø d	Z	Ident-No.
140	10	40	2+2	176066 L
140	20,3	40	2+2	176067 L
140	29	40	2	180536 S
140	39,5	40	2	186498 C
140	10	50	2+2	176069 L
140	20,3	50	2+2	176070 L
[mm]	[mm]	[mm]		

Spare parts	Ø D	B	Ø d	Class-No.	PU	Ident-No.
Spacers	70	9	40	955520	1	177308 C
Spacers	70	10	40	955520	1	185420 L
Spacers	70	12	40	955521	1	162706 O
Spacers	70	9	50	955520	1	177309 C
Spacers	70	10	50	955520	1	163886 C
Spacers	70	12	50	955521	1	163887 C
	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Spurs	14	14	2.0	150558	10	003079 L
Turnover Knives	9,6	12	1.5	150515	10	171163 L
Turnover Knives	20	12	1.5	150516	10	178287 L
Turnover Knives	29,5	12	1.5	150515	10	180825 L
Turnover Knives	39,5	12	1.5	150515	10	171149 L
	[mm]	[mm]	[mm]		[pc.]	

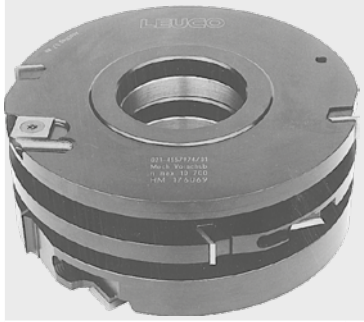
Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=7,2	176066, 176069	925300	2	168074 L
Set Screws	M5x12 DIN EN ISO 4028	176066, 176069	995161	10	050565 L
Countersunk Screws	M5x6 T20 D=Ø9,3	176066, 176069	995125	10	176199 L
Adjusting Gauges	0,7	176066, 176069	985200	1	056096 L
Pressure Bars	B=17	176067, 176070	925300	2	167971 L
Set Screws	M8x16 DIN EN ISO 4028	176067, 176070, 180536	995161	10	164422 L
Countersunk Screws	M5x10,8 T15 D=Ø9,4	176067, 176070	995125	10	180840 L
Adjusting Gauges	1,0	176067, 176070, 180536, 186498	985200	1	011103 L
Pressure Bars	B=30	180536	925300	2	164185 L
	[mm]			[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=38	186498	925300	2	50775234 L
Set Screws	M6x12 T15	186498	995195	10	50930404 L
Screwdrivers	SW2,5x100	176066, 176069	985730	1	168010 L
Screwdrivers	SW4x100	176067, 176070, 180536	985730	1	166091 L
Screwdrivers	T15x80	176067, 176070	985730	1	171188 L
Screwdrivers	T15x140	186498	985730	1	179145 L
Screwdrivers	T20x100	176066, 176067, 176069, 176070, 180536	985730	1	166092 L
	[mm]			[pc.]	

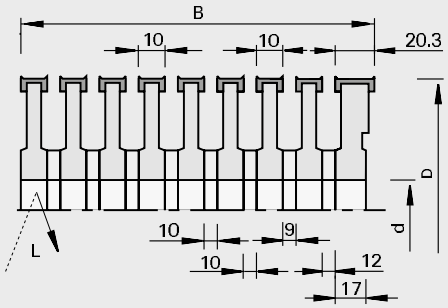
121450

Groove Bed Cutterhead Sets HW

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- molders with groove bed section Weinig
- for cutting of guide grooves in solid woods

Design

- n max = 10,000 min-1

Advantages

Notes

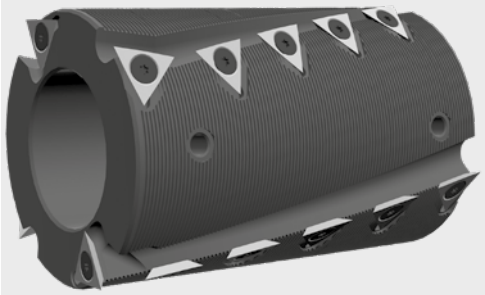
- application with the grain
- complete tool sets for specific wood widths "B"

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

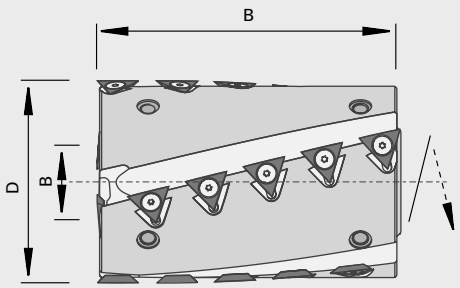
120260

Spiral Cutterheads HW - t3-System

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- stationary milling centers
- for dressing, rough-planing, jointing, rabbeting, copying of solid woods and laminated timber

Design

- Triangular turnover knives with rounded cutting edges drawing from bottom to top and from top to bottom
- ID nos. 187359 and 187360 in double-seam design with top and bottom spurs
- Body made of high-tensile aluminum

Advantages

- Absolutely chip-free jointing and rabbeting
- Thanks to the rounded turnover knives the machined surface is offset-free
- Excellent edge and surface quality
- Very high milling performance
- Triangular turnover knives with rounded edges, 3 edge lives

Notes

- for HSK mounting arbors with double key without spacer
- for Ident-No. 187359 clamping length 50 mm with HSK mounting arbor
- for Ident-No. 187360 clamping length 80 mm with HSK mounting arbor

Ø D	B	Ø d	Z	Number of cutting edges	nmax	Ident-No.
80	78	30	2+2	10	18000	187359 L
80	106	30	2+2	14	18000	187360 L
100	149	30	2+2	22	15000	187679 L
[mm]	[mm]	[mm]		[pc.]	[min-1]	

Turnover Knives	B	H	S	For Ident-No.	Class-No.	PU	Ident-No.
	20,88	18.3	3.0	For all	150567	10	187251 L
	14	14	2.0	187359, 187360	150558	10	003079 L
	[mm]	[mm]	[mm]			[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x10,8 T15 D=Ø9,4	995125	10	180840 L
Screwdrivers	T15x80	985730	1	171188 L
	[mm]		[pc.]	

Accessories	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Mounting arbors with HSK shank	Ø30x50xHSK 63F	187359	933069	1	183748 L
Mounting arbors with HSK shank	Ø30x80xHSK 63F	187360	933069	1	183749 L
	[mm]			[pc.]	

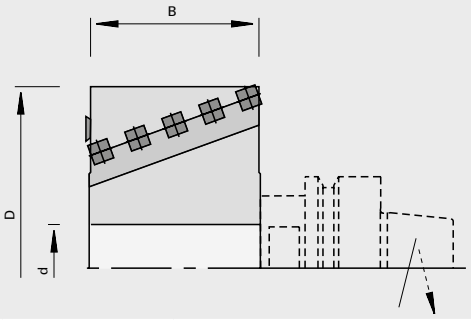
120760

Spiral Cutterheads HW - with spur

Product



Drawing



LEUCO CNC

Tungsten Carbide [HW]

MEC

Machine / Application

- stationary milling centers
- for dressing, rough-planing, jointing, rabbeting, copying of solid woods and laminated timber

Design

- with four-sided turnover knives, with rounded edges
- 2 front spurs HW
- spiral cutting layout of turnover knives and cut division
- high-tensile aluminum body

Advantages

- easy hogging, low cutting pressure and low noise level
- high hogging volume

Notes

- for HSK mounting arbors with double key without spacer
- for Ident-No. 183678 clamping length 50 mm with HSK mounting arbor
- for Ident-No. 183679 clamping length 80 mm with HSK mounting arbor

Ø D	B	Ø d	Z	DKN	nmax	Ident-No.
80	80	30	2+2+V2	8x3	18000	183678 L
80	100	30	2+2+V2	8x3	18000	183679 L
[mm]	[mm]	[mm]		[mm]	[min-1]	

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Turnover Knives (with rounded edges R=50 mm)	15	15	2.5	150567	10	180454 L
	[mm]	[mm]	[mm]		[pc.]	

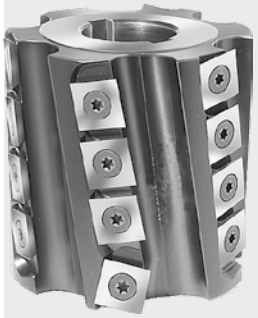
Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws with collar 6 mm	M5x15,5 T20 D=Ø8,5	995125	10	182112 L
Screwdrivers	T20x100	985730	1	166092 L
	[mm]		[pc.]	

Accessories	Dimension	Class-No.	PU	Ident-No.
Cutter Retaining Bolts	M16x26xØ42	995190	1	173592 L
	[mm]		[pc.]	

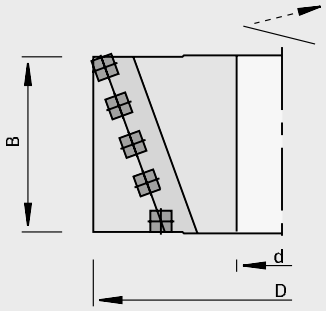
120710

Spiral Cutterheads HW - Steel

Product



Drawing



LEUCO CNC

Tungsten Carbide [HW]

MEC

Machine / Application

- Molders
- Stationary milling centers
- For trimming, rough-planing and finish-planing in solid woods

Design

- With four-sided turnover knives with rounded edges
- Spiral cutting layout of turnover knives and cut division
- Tool body made of steel for particularly high loads

Advantages

- easy hogging, low cutting pressure and low noise level

Notes

- For a medium quality finish cut

Ø D	B	Ø d	Z	DKN	nmax	Ident-No.
125	80	40	2+2	8x3	18000	187665 C
125	100	40	2+2	8x3	18000	187666 C
125	130	40	2+2	8x3	18000	187667 C
125	180	40	2+2	8x3	18000	187668 C
125	230	40	2+2	8x3	18000	187669 C
125	100	40	3+3	8x3	18000	187670 C
125	130	40	3+3	8x3	18000	187671 L
125	150	40	3+3	8x3	18000	187672 C
125	180	40	3+3	8x3	18000	187673 L
125	230	40	3+3	8x3	18000	187674 C
125	240	40	3+3	8x3	18000	187675 C
140	240	40	3+3	8x3	18000	187676 C
[mm]	[mm]	[mm]		[mm]	[min-1]	

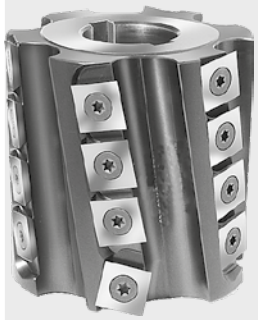
Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Turnover knives with rounded edges (rounded R=150 mm)	15	15	2.5	150567	10	187323 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws with collar 6 mm	M5x15,5 T20 D=Ø8,5	995125	10	182112 L
Screwdrivers	T20x100	985730	1	166092 L
	[mm]		[pc.]	

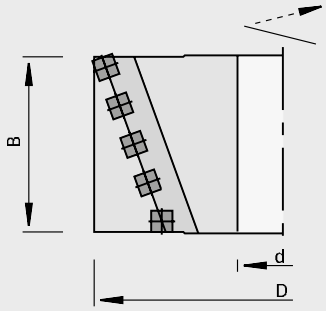
120710

Spiral Cutterheads HW - Aluminum

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- molders
- stationary milling centers
- for milling, rough-planing and finish-planing in solid woods

Design

- with four-sided turnover knives, with rounded edges
- spiral cutting layout of turnover knives and cut division
- high-tensile aluminum body

Advantages

- easy hogging, low cutting pressure and low noise level

Notes

- For a medium quality finish cut

Ø D	B	Ø d	Z	nmax	Ident-No.
100	80	40	2+2	12000	187642 C
125	100	40	2+2	12000	187643 C
125	130	40	2+2	12000	187644 C
125	170	40	2+2	12000	187646 C
125	180	40	2+2	12000	187649 C
125	210	40	2+2	12000	187650 C
125	230	40	2+2	12000	187651 C
125	240	40	2+2	12000	187654 C
125	100	40	3+3	12000	187656 C
125	130	40	3+3	12000	187657 L
125	150	40	3+3	12000	187658 C
125	180	40	3+3	12000	187659 C
125	230	40	3+3	12000	187661 C
125	240	40	3+3	12000	187660 C
140	240	40	3+3	12000	187662 C
[mm]	[mm]	[mm]		[min-1]	

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Turnover Knives (with rounded edges R=50 mm)	15	15	2.5	150567	10	180454 L
Turnover knives with rounded edges (rounded R=150 mm)	15	15	2.5	150567	10	187323 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws with collar 6 mm	M5x15,5 T20 D=Ø8,5	995125	10	182112 L
Screwdrivers	T20x100	985730	1	166092 L
	[mm]		[pc.]	

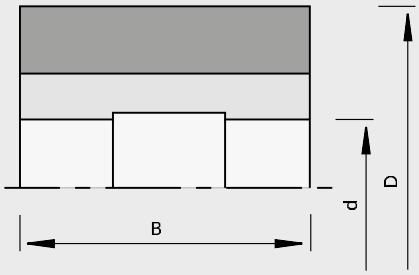
320700

Planing Cutterheads HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- multi spindle plunging machines
- for planing of solid woods

Design

- n max = 9,000 min-1

Advantages

Notes

- HS-tipped knives (18%) 30x3 mm
- for adjusting the planing knives 2 adjustment rings are needed
- alternative cutting material: ST for soft and hard woods; HW for hard and exotic woods

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

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	B=80	925300	2	179205 S
Pressure Bars	B=100	925300	2	181191 S
Pressure Bars	B=130	925300	2	179198 C
Pressure Bars	B=150	925300	2	179199 S
Pressure Bars	B=180	925300	2	179200 C
Pressure Bars	B=230	925300	2	181192 C
Adjustment Rings	125x40	985200	2	179201 C
Set Screws	M10x25 DIN EN ISO 4028	995161	10	168108 L
Cranked Wrench Keys	SW5 DIN ISO 2936	985730	1	009674 L
	[mm]		[pc.]	

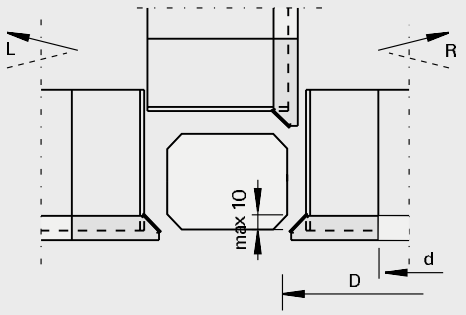
120301

Chamfering Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application
- molders
- for chamfering of solid woods

Design
- n max = 9,000 min-1

Advantages
- possibility of simultaneous planing and chamfering of different wood cross-sections without changing tools thanks to the combination with planing cutterheads on vertical and horizontal spindles

Notes
- recommendation: run 4th chamfer on universal spindle
- sense of rotation according to VDMA 8849

Chamfer◁	Ø D	B	Ø d	Ø dmax	Z		Ident-No. [L]	Ident-No. [R]
10x45	145.6	15	40	50	4	for Ø 125	181207 S	181206 S
10x45	160.6	15	40	50	4	for Ø 140	181209 S	181208 S
[°]	[mm]	[mm]	[mm]	[mm]				

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	15	15	2.5	150517	10	181243 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M6x10 T20 D=Ø8,8	995125	10	181244 L
Screwdrivers	T20x100	985730	1	166092 L
	[mm]		[pc.]	

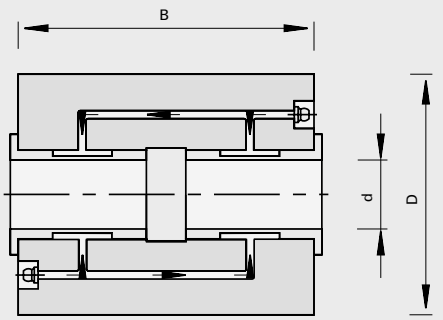
320700

Hydro Planing Cutterheads HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- hydro profile molders
- for planing of solid woods

Design

- n max = 9,000 min-1

Advantages

- high concentric accuracy and precise tool balancing thanks to Hydro clamping (system Weinig) for precise concentricity tolerance
- high feed rates and optimum cutting quality

Notes

- HS-tipped knives 30 x 3 mm
- alternative cutting material: ST for soft and hard woods; HW for hard and exotic woods

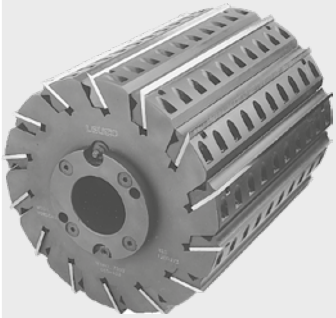
Ø D	B	Ø d	Z	Hook angle	Ident-No.
143	60	40	4	27	178104 C
143	130	40	4	27	178105 C
143	230	40	4	27	178106 C
163	60	50	4	27	178107 C
163	100	50	4	27	178108 C
163	130	50	4	27	178109 C
163	150	50	4	27	178110 C
163	180	50	4	27	178112 C
163	230	50	4	27	178113 C
163	260	50	4	27	178115 C
163	310	50	4	27	178116 C
163	60	50	6	27	178117 L
163	100	50	6	27	178118 L
163	130	50	6	27	178119 C
163	150	50	6	27	178120 L
163	180	50	6	27	178122 L
163	230	50	6	27	178123 L
163	260	50	6	27	178125 C
163	310	50	6	27	178126 C
163	60	50	8	25	178127 C
163	100	50	8	25	178128 C
163	130	50	8	25	178129 C
163	150	50	8	25	178130 C
163	230	50	8	25	178131 C
163	260	50	8	25	178132 C
[mm]	[mm]	[mm]		[°]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M12x25 DIN EN ISO 4028	995161	10	181466 L
Screwdrivers	SW6x200	985730	1	167817 L
Grease presses		993270	1	163706 L
Grease Cartridges		993270	1	163707 L
	[mm]		[pc.]	

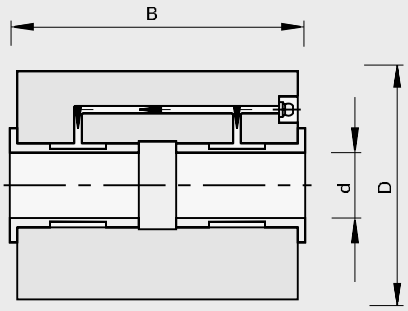
320700

Hydro-Rotaplane Cutterheads HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- hydro profile molders
- for planing of solid woods

Design

- n max = 6,000 min-1

Advantages

- high concentric accuracy and precise tool balancing thanks to Hydro clamping (system Weinig) for precise concentricity tolerance
- high feed rates and optimum cutting quality

Notes

- HS-tipped knives 30 x 3 mm
- alternative cutting material: ST for soft and hard woods; HW for hard and exotic woods

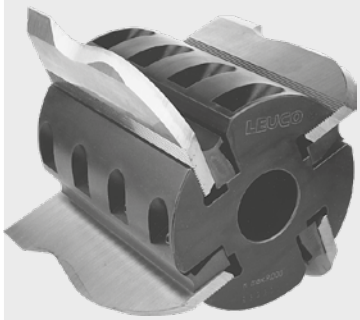
Ø D	B	Ø d	Z	Hook angle	Ident-No.
203	150	50	6	27	178133 C
203	230	50	6	27	178134 C
203	150	50	8	27	178136 C
203	230	50	8	27	178137 C
203	310	50	8	27	178139 C
203	150	50	10	23	178141 C
203	230	50	10	23	178142 C
203	100	50	12	23	178145 C
203	150	50	12	23	178146 C
203	230	50	12	23	178147 C
203	100	50	16	20	178150 S
203	150	50	16	20	178151 C
[mm]	[mm]	[mm]		[°]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M12x25 DIN EN ISO 4028	995161	10	181466 L
Screwdrivers	SW6x200	985730	1	167817 L
Grease presses		993270	1	163706 L
Grease Cartridges		993270	1	163707 L
	[mm]		[pc.]	

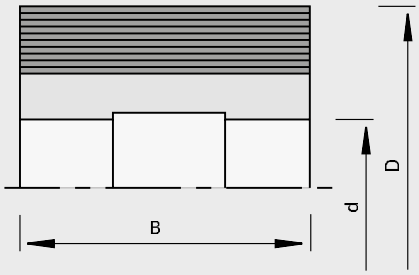
320600

Profile Cutterheads

Product



Drawing



MEC

Machine / Application

- molders
- for profiling of solid woods

Design

- hook angle 25 degrees

Advantages

- high profile accuracy and surface quality thanks to knives sharpened in the cutterhead

Notes

- precise serration (60 degrees, 1.6 mm pitch) ensures tight knife clamping
- adjustable knives
- profile depth and cutting circle Ø see table
- for back-serrated blanks S = 5, 8, 10 mm
- included in delivery: cutterhead and wedges; for blanks see chapter Turnover knives, Profile Knives, Knives

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

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	B=40	925300	2	179221 S
Pressure Bars	B=60	925300	2	179222 C
Pressure Bars	B=80	925300	2	179223 C
Pressure Bars	B=100	925300	2	179224 C
Pressure Bars	B=130	925300	2	179225 S
Pressure Bars	B=150	925300	2	179226 S
Pressure Bars	B=180	925300	2	179227 S
Pressure Bars	B=230	925300	2	179228 S
Dummy Pieces	B=40	925900	2	179229 C
Dummy Pieces	B=60	925900	2	179230 C
Dummy Pieces	B=80	925900	2	179231 S
Dummy Pieces	B=100	925900	2	179232 C
Dummy Pieces	B=130	925900	2	179233 C
Dummy Pieces	B=150	925900	2	179234 C
Dummy Pieces	B=180	925900	2	179235 S
Dummy Pieces	B=230	925900	2	179236 C
Set Screws	M10x20 DIN EN ISO 4028	995161	10	815807 L
Screwdrivers	SW5x150	985730	1	168703 L
	[mm]		[pc.]	

Maximum cutting circle diameter

	HS	HW	ST	HS	HW	HS	ST
Knife height H [mm]	50	50	55	60	60	70	70
Knife thickness S [mm]	8	10	10	8	10	8	10
Profile depth T [mm]	12	10	15	20	18	30	27
Dmax at D=122	161	161	171	181	181	201	201
Dmax at D=137	176	176	186	196	196	216	216

Maximum RPM

B (mm)	50	55	60	70
Dmax at D=122	161	171	181	201
Max.RPM (min-1):	9000	8400	8000	7200
Dmax at D=137	176	186	196	216
Max.RPM (min-1):	8200	7700	7300	6600

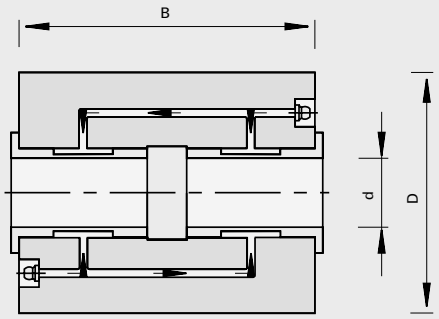
320600

Hydro Profile Cutterheads HS

Product



Drawing



MEC

Machine / Application
- hydro profile molders
- for profiling of solid woods

Design
- the max. RPM depends from the knife height (see table "Max. RPM")

Advantages
- best cutting quality without knife marks at high feed rates
- precise concentricity tolerance (system Weinig) thanks to dual-chamber Hydro clamping
- high concentric accuracy and low operating vibration
- tight clamping thanks to precise serration (60 degrees, 1.6 mm pitch)

Notes
- adjustable knives
- profile depth and cutting circle Ø see table
- for back-serrated blanks S = 5, 8, 10 mm
- included in delivery: cutter-head and wedges; for blanks see chapter Turnover knives, Profile Knives, Knives

Ø D	B	Ø d	Z	Ident-No.
137	60	40	4	176342 C
137	100	40	4	176343 C
137	130	40	4	176344 C
137	150	40	4	176345 C
137	180	40	4	176346 C
137	230	40	4	176347 C
150	60	50	4	176348 L
150	60	50	6	176349 L
150	100	50	4	176350 C
150	100	50	6	176351 C
150	130	50	4	176352 C
150	130	50	6	176353 C
150	150	50	4	176354 C
150	150	50	6	176355 C
150	180	50	4	176356 C
150	180	50	6	176357 C
[mm]	[mm]	[mm]		

Ø D	B	Ø d	Z	Ident-No.
150	230	50	4	176358 C
150	230	50	6	176359 C
150	260	50	4	176360 C
150	260	50	6	176361 C
150	310	50	4	176362 C
150	310	50	6	176363 C
163	60	50	8	176364 L
163	100	50	8	176365 C
163	130	50	8	176366 C
163	150	50	8	176367 C
163	180	50	8	176368 C
163	230	50	8	176369 C
163	260	50	8	176370 C
163	310	50	8	176371 C
195	60	50	10	176372 C
195	100	50	10	176373 C
195	130	50	10	176374 C
195	150	50	10	176375 C
215	60	50	12	176380 C
215	100	50	12	176381 C
215	130	50	12	176382 C
215	150	50	12	176383 C
[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M12x25 DIN EN ISO 4028	995161	10	181466 L
Screwdrivers	SW6x200	985730	1	167817 L
Grease presses		993270	1	163706 L
Grease Cartridges		993270	1	163707 L
	[mm]		[pc.]	

Maximum cutting circle diameter

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

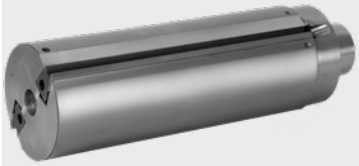
Maximum RPM

Dmax for D=215	50	55	60	70
Dmax at D=137	174	184	194	214
Max.RPM (min-1):	8300	7800	7400	6700
Dmax at D=150	189	199	209	229
Max.RPM (min-1):	7700	7300	6900	6300
Dmax at D=163	202	212	222	242
Max.RPM (min-1):	7200	6800	6500	6000
Dmax for D=195	254	264	274	294
Max.RPM (min-1):	5700	5400	5200	4900

320208

Planing Cutterheads HS with Weinig HSK and Centrolock clamping bar

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- molders "Weinig Powermat"
- for planing of solid woods

Design

- n max = 12,000 min-1

Advantages

- quick knife change thanks to Centrolock clamping bar

Notes

- clamping by means of front screw
- HS-tipped turnover knives
- alternative cutting material: HW for hard woods, glued timber and MDF
- picture shows sense of rotation left (acc. to DIN left)
- Turnover Knives see chapter Turnover Knives, Knives, Inserts

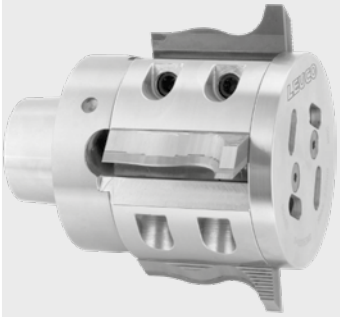
Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
93	60	Weinig-HSK	2	181728 S	181737 S
93	80	Weinig-HSK	2	181729 S	181738 S
93	100	Weinig-HSK	2	181730 S	181739 S
93	130	Weinig-HSK	2	181731 S	181740 S
93	150	Weinig-HSK	2	181732 S	181741 S
93	170	Weinig-HSK	2	181733 S	181742 S
93	190	Weinig-HSK	2	181734 S	181743 S
93	210	Weinig-HSK	2	181735 S	181744 S
93	240	Weinig-HSK	2	181736 S	181745 S
[mm]	[mm]	[mm]			

Spare parts	Class-No.	PU	Ident-No.
Hammer for Releasing the Knives	985740	1	181746 S
HSK-Mounting Device	985202	1	181747 S
		[pc.]	

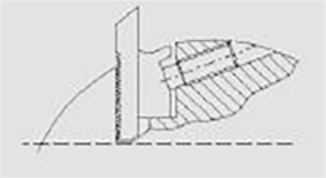
320608

Profile Cutterheads HS - Powerlock with Weinig HSK (blanks S=5,8,10 mm)

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- molders "Weinig Powermat"
- for profiling of solid woods

Design

- hook angle 20 degrees (special 12 degrees)
- n max = 12,000 min-1

Advantages

- fixed-shape knife clamping by highly precise serration 60 degrees, partition 1.6mm
- high profile accuracy and surface quality thanks to knives sharpened in the cutterhead

Notes

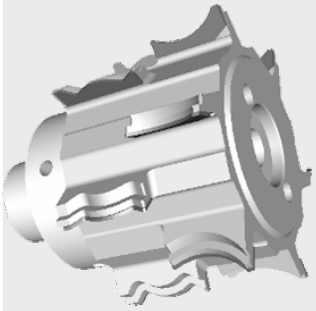
- adjustable knives
- possibility of sideways stop in the cutterhead
- control of adjusting range of the knives through lunettes
- picture shows sense of rotation right (acc. to DIN right)
- for all back-serrated blanks S = 5, 8, 10 mm
- included in delivery: cutter-head and wedges; for blanks see chapter Turnover knives, Profile Knives, Knives

Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
90	40	Weinig-HSK	2	182312 C	182314 C
90	60	Weinig-HSK	2	181766 C	181775 C
90	80	Weinig-HSK	2	181767 C	181776 C
90	100	Weinig-HSK	2	181768 C	181777 C
90	130	Weinig-HSK	2	181769 C	181778 C
90	150	Weinig-HSK	2	181770 C	181779 C
90	170	Weinig-HSK	2	181771 C	181780 C
90	190	Weinig-HSK	2	182313 C	181781 C
90	210	Weinig-HSK	2	181773 C	181782 C
90	240	Weinig-HSK	2	181774 C	181783 C
90	80	Weinig-HSK	4	181785 C	181794 C
90	100	Weinig-HSK	4	181786 C	181795 C
90	130	Weinig-HSK	4	181787 C	181796 C
90	150	Weinig-HSK	4	181788 C	181797 C
90	170	Weinig-HSK	4	181789 C	181798 C
90	190	Weinig-HSK	4	181790 C	181799 C
90	210	Weinig-HSK	4	181791 C	181800 C
90	40	Weinig-HSK	4	182315 C	182316 C
90	60	Weinig-HSK	4	181784 C	182317 C
90	240	Weinig-HSK	4	181792 C	182318 C
[mm]	[mm]	[mm]			

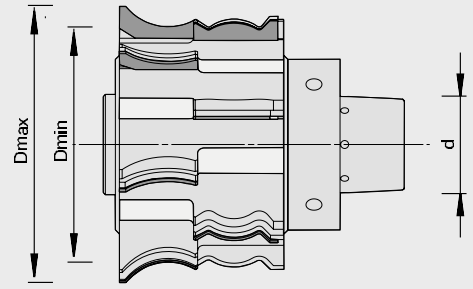
222068

PowerDiaProfiler DP

Product



Drawing



LEUCO PowerDiaProfiler

Polycrystalline diamond [DP]

MEC

Machine / Application

- molding automats with HSK-interface
- for profiling of MDF, hard and exotic woods

Design

- topline (polished knife face and precise cutting edge)

Advantages

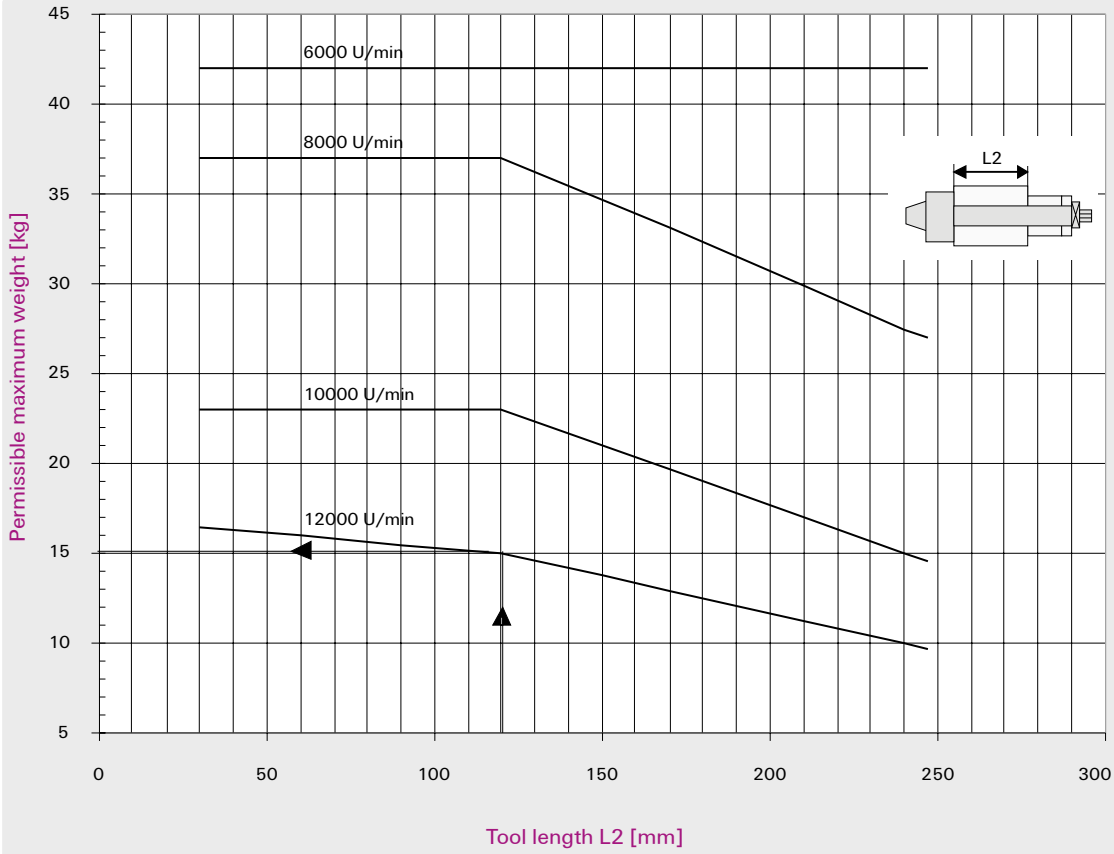
- highest concentricity
- feed speed and workpiece surface like in the case of jointed HW-tools

Notes

- optimal cutting speed 80 - 100m/s
- profiles according to customer specifications
- price on request
- n max = depending on L2 and weight (see chart)

Ø Dmax	ø Dmin	Ø d	Z	Recommended feed
180	100	Weinig HSK	2	33
180	100	Weinig HSK	3	50
180	100	Weinig HSK	4	66
180	100	Weinig HSK	5	83
180	100	Weinig HSK	6	100
180	100	Weinig HSK	7	117
180	100	Weinig HSK	8	133
[mm]	[mm]	[mm]		[m/min]

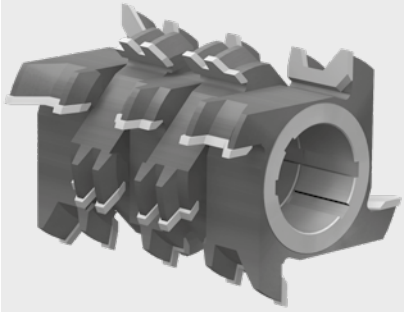
Diagram for PowerLock-Adapter



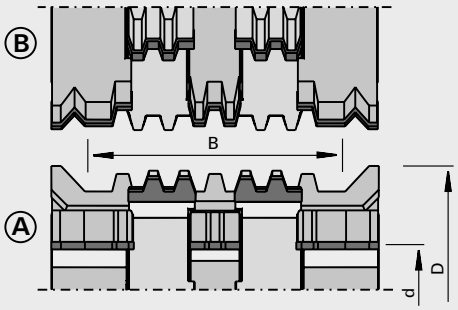
123600

HW Counter Profile Cutter set

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application
- molders
- For manufacturing of longitudinal joints on block piles

Design
- Body made from steel
- Symmetrical design
- Double keyway for twist locking

Advantages
- Maximum possible precision thanks to plane parallelism of all parts

Notes

Ø D	B	Ø d	Z	nmax	Profile	Ident-No.
190	220	80	5x4	8000	A	192657 S
190	220	80	5x4	8000	B	192658 S
[mm]	[mm]	[mm]		[min-1]		

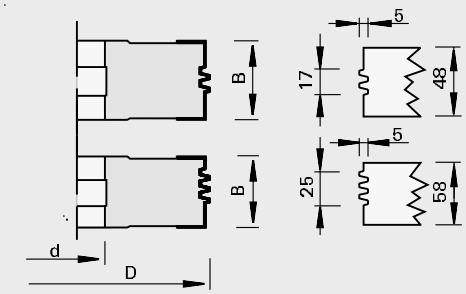
120505

Glue Joint Profile Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application
- molders
- table shapers
- for cutting of edge glue joints in solid woods

Design
- cutting edges parallel to cutter axis
- n = 5,700 - 9,800 min-1

Advantages
- continuous high profile accuracy thanks to turnover knives

Notes
- application against feed
- fit of joints can be defined by moving the knives sideways by means of dials (see spare parts)
- when delivered, tool is set to 0.3 mm joint play

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

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	50	23	2.0	151555	10	180431 L
	60	23	2.0	151555	10	180432 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	48x11x6	177007	925300	2	50591365 L
Pressure Bars	58x11x6	177008	925300	2	180434 L
Clamping Pieces	12x8,5/M8L	For all	925100	2	180357 L
Clamping Set Screws	M8x26 SW4	For all	995195	10	180340 L
Screwdrivers	SW4x100	For all	985730	1	166091 L
	[mm]			[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Setting Discs	0,1 + 0,15	995490	1	180435 L
Setting Discs	0,15 + 0,2	995490	1	180436 L
Setting Discs	0,2 + 0,25	995490	1	180437 L
Setting Discs	0,25 + 0,3	995490	1	180438 L
Setting Discs	0,3 + 0,35	995490	1	180439 L
	[mm]		[pc.]	

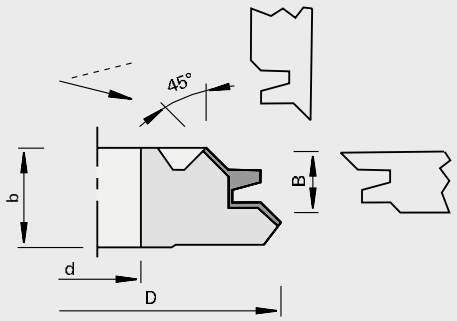
120525

Miter Glue Joint Profile Cutterheads HW

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application
- molders
- table shapers
- for cutting of miter lock joints in solid woods and wood-based panels

Design
- body made from high-strength aluminium alloy
- cutting edges parallel to cutter axis
- n = 4,600 - 7,800 min-1

Advantages
- continuous high profile accuracy thanks to profile knives
- profile play adjustable by means of shims underneath the grooving/chamfering knives

Notes
- application against feed
- wood thickness approx. 15 mm to max. 26 mm

Ø D	B	Ø d	Z	Ident-No.
174	26	30	2+2	176097 L
[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Grooving / Chamfering Knife	16	34	5.0	150508	5	184275 L
Miter Glue Joint Profile Knives	39,5	12	1.5	151547	10	165916 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	38x11x6	925300	2	180538 L
Clamping Pieces	12x8,5/M8L	925100	2	180357 L
Clamping Set Screws	M8x26 SW4	995195	10	180340 L
Countersunk Screws	M5x10,8 T15 D=Ø9,4	995125	10	180840 L
Screwdrivers	SW4x100	985730	1	166091 L
Screwdrivers	T15x80	985730	1	171188 L
	[mm]		[pc.]	

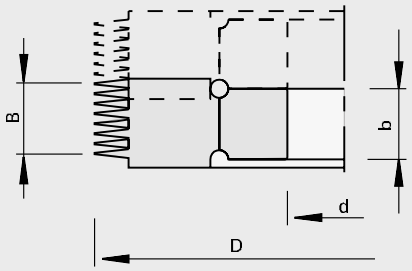
327110 / 327130

Finger Joint Cutters HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines with cross-cutting device
- for longitudinal joints in soft woods

Design

- standard and topcoat

Advantages

- increased edge lives and higher wear resistance and gliding features thanks to topcoat coating

Notes

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
160	32,4	30.4	50	3+3	1.6	4/4,5	20	9000		182122 C
250	26	24	50	3+3	1.6	4/4,5	16	6000		182113 C
250	30	28	50	6+6	2.8	6/7	10	6000		192467 L
255	30	28	50	6+6	2.8	6/7	10	6000		192468 S
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
160	32,4	30.4	50	3+3	1.6	4/4,5	20	9000	topcoat	192202 S
250	26	24	50	3+3	1.6	4/4,5	16	6000	topcoat	192201 C
250	30	28	50	6+6	2.8	6/7	10	6000	topcoat	192466 C
255	30	28	50	6+6	2.8	6/7	10	6000	topcoat	192469 S
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

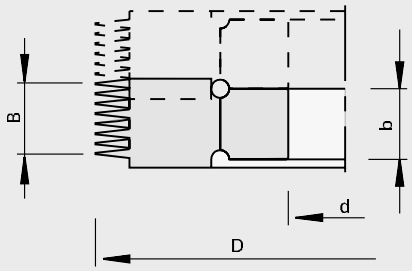
3271.. / 5271.. / 127110

Finger Joint Cutters 10/10

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines without cross-cutting device
- For longitudinal joints in soft, hard and exotic woods, with a finger length of 10 mm

Design

- Finger length of 10 mm
- HS suitable for soft woods
- HS Solid 34 suitable for knotty soft woods
- HW suitable for hard and exotic woods

Advantages

- HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
160	28,6	26.6	50	2+2	3.8	10/10	7	8000	HS	187376 C
160	28,6	26.6	50	2+2	3.8	10/10	7	8000	HS, topcoat 104	187379 C
160	28,6	26.6	50	2+2	3.8	10/10	7	8000	HS Solid 34	187380 C
160	28,6	26.6	50	2+2	3.8	10/10	7	8000	HS Solid 34, topcoat 104	187377 C
160	28,6	26.6	50	2+2	3.8	10/10	7	8000	HW	187378 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
250	28,6	26.6	50	3+3	3.8	10/10	7	6000	HS	187382 C
250	28,6	26.6	50	3+3	3.8	10/10	7	6000	HS, topcoat 104	187384 C
250	28,6	26.6	50	3+3	3.8	10/10	7	6000	HS Solid 34	187386 C
250	28,6	26.6	50	3+3	3.8	10/10	7	6000	HS Solid 34, topcoat 104	187383 C
250	28,6	26.6	50	3+3	3.8	10/10	7	6000	HW	187385 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

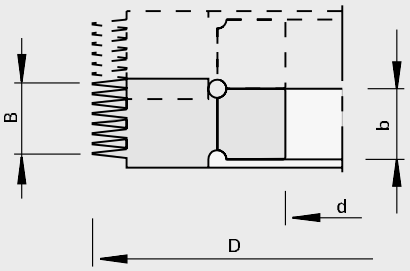
3271.. / 5271.. / 127110

Finger Joint Cutters 10/11

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines without cross-cutting device
- For longitudinal joints in soft, hard and exotic woods, with a finger length of 10 mm

Design

- Finger length of 10 mm
- HS suitable for soft woods
- HS Solid 34 suitable for knotty soft woods
- HW suitable for hard and exotic woods

Advantages

- HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

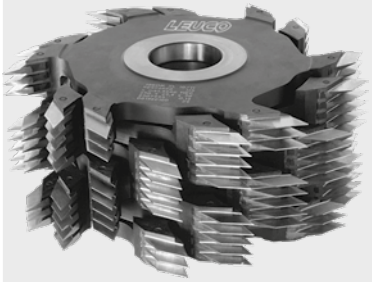
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
160	28,6	26.6	50	2+2	3.8	10/11	7	8000	HS	187389 L
160	28,6	26.6	50	2+2	3.8	10/11	7	8000	HS, topcoat 104	187391 C
160	28,6	26.6	50	2+2	3.8	10/11	7	8000	HS Solid 34	187388 C
160	28,6	26.6	50	2+2	3.8	10/11	7	8000	HS Solid 34, topcoat 104	187390 C
160	28,6	26.6	50	2+2	3.8	10/11	7	8000	HW	187392 L
160	32,4	30.4	50	2+2	3.8	10/11	8	8000	HS	187397 L
160	32,4	30.4	50	2+2	3.8	10/11	8	8000	HS, topcoat 104	187395 C
160	32,4	30.4	50	2+2	3.8	10/11	8	8000	HS Solid 34	187396 C
160	32,4	30.4	50	2+2	3.8	10/11	8	8000	HS Solid 34, topcoat 104	187394 C
160	28,6	26.6	50	3+3	3.8	10/11	7	8000	HS	187399 C
160	28,6	26.6	50	3+3	3.8	10/11	7	8000	HS, topcoat 104	187401 C
160	28,6	26.6	50	3+3	3.8	10/11	7	8000	HS Solid 34	187402 C
160	28,6	26.6	50	3+3	3.8	10/11	7	8000	HS Solid 34, topcoat 104	187400 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
250	28,6	26.6	50	3+3	3.8	10/11	7	6000	HS	187406 L
250	28,6	26.6	50	3+3	3.8	10/11	7	6000	HS, topcoat 104	187408 C
250	28,6	26.6	50	3+3	3.8	10/11	7	6000	HS Solid 34	187407 L
250	28,6	26.6	50	3+3	3.8	10/11	7	6000	HS Solid 34, topcoat 104	187409 L
250	28,6	26.6	50	3+3	3.8	10/11	7	6000	HW	187405 L
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

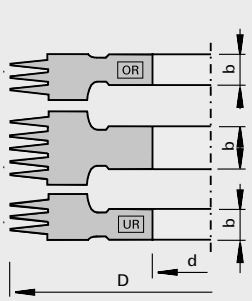
327610 / 327630 / 5276..

Finger Joint Cutters 10/11 - real Z=6

Product



Drawing



cutting height	number of cutters
15 mm	OR + UR
34 mm	OR + 1 + UR
53 mm	OR + 2 + UR
72 mm	OR + 3 + UR
91 mm	OR + 4 + UR
110 mm	OR + 5 + UR
129 mm	OR + 6 + UR
148 mm	OR + 7 + UR
167 mm	OR + 8 + UR
186 mm	OR + 9 + UR
208 mm	OR + 10 + UR
260 mm	OR + 13 + UR
310 mm	OR + 16 + UR

High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines with cross-cutting device
- For longitudinal joints in soft, hard and exotic woods, with a finger length of 10 mm

Design

- Real Z=4 or Z=6 for high feed rates
- Finger length of 10 mm
- HS suitable for soft woods
- HS Solid 34 suitable for knotty soft woods

Advantages

- HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

- no. of cutters: see table

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
250	26,4	15.4	50	6	3.8	10/11	3	6000	top finish cutter, HS	187424 L
250	41	19	50	6	3.8	10/11	5	6000	base cutter, HS	187411 L
250	26,4	15.4	50	6	3.8	10/11	3	6000	bottom finish cutter, HS	187416 L
250	26,4	15.4	50	6	3.8	10/11	3	6000	top finish cutter, HS, topcoat 104	187423 C
250	41	19	50	6	3.8	10/11	5	6000	base cutter, HS, topcoat 104	187412 C
250	26,4	15.4	50	6	3.8	10/11	3	6000	bottom finish cutter, HS, topcoat 104	187418 C
250	26,4	14.8	50	6	3.8	10/11	3	6000	top finish cutter, HS Solid 34	187425 L
250	41	19	50	6	3.8	10/11	5	6000	base cutter, HS Solid 34	187413 L
250	26,4	14.8	50	6	3.8	10/11	3	6000	bottom finish cutter, HS Solid 34	187417 L
250	26,4	14.8	50	6	3.8	10/11	3	6000	top finish cutter, HS Solid 34, topcoat 104	187426 L
250	41	19	50	6	3.8	10/11	5	6000	base cutter, HS Solid 34, topcoat 104	187414 L
250	26,4	14.8	50	6	3.8	10/11	3	6000	bottom finish cutter, HS Solid 34, topcoat 104	187420 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

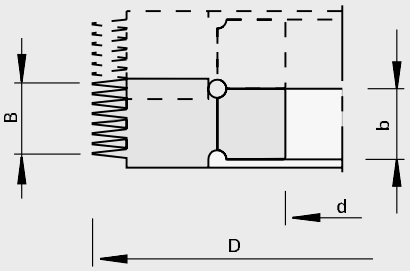
3271.. / 5271.. / 127110

Finger Joint Cutters 15/15

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines without cross-cutting device
- For longitudinal joints in soft, hard and exotic woods, with a finger length of 15 mm

Design

- Finger length of 15 mm
- HS suitable for soft woods
- HS Solid 34 suitable for knotty soft woods
- HW suitable for hard and exotic woods

Advantages

- HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

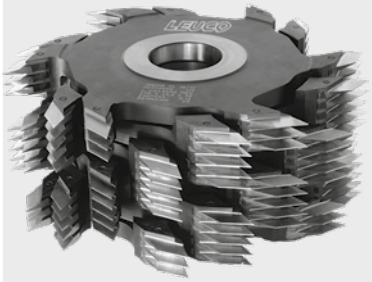
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	HS	187432 L
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	HS, topcoat 104	187706 C
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	HS Solid 34	187433 L
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	HS Solid 34, topcoat 104	187436 C
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	HW	187435 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	HS	187491 C
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	HS, topcoat 104	187488 C
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	HS Solid 34	187487 C
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	HS Solid 34, topcoat 104	187494 C
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	HW	187490 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

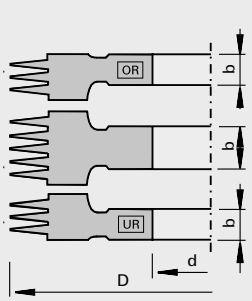
327610 / 327630 / 5276..

Finger Joint Cutters 15/15 - real Z=4 or Z=5

Product



Drawing



cutting height	number of cutters
15 mm	OR + UR
34 mm	OR + 1 + UR
53 mm	OR + 2 + UR
72 mm	OR + 3 + UR
91 mm	OR + 4 + UR
110 mm	OR + 5 + UR
129 mm	OR + 6 + UR
148 mm	OR + 7 + UR
167 mm	OR + 8 + UR
186 mm	OR + 9 + UR
208 mm	OR + 10 + UR
260 mm	OR + 13 + UR
310 mm	OR + 16 + UR

High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines with cross-cutting device
- For longitudinal joints in soft, hard and exotic woods, with a finger length of 15 mm

Design

- Real Z=4 or Z=5 for high feed rates
- Finger length of 15 mm
- HS suitable for soft woods
- HS Solid 34 suitable for knotty soft woods

Advantages

- HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

- no. of cutters: see table

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	26,4	14.8	50	4	3.8	15/15	3	8000	top finish cutter, HS	187467 C
170	41	19	50	4	3.8	15/15	5	8000	base cutter, HS	187712 C
170	26,4	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter, HS	187460 C
170	26,4	14.8	50	4	3.8	15/15	3	8000	top finish cutter, HS, topcoat 104	187466 C
170	41	19	50	4	3.8	15/15	5	8000	base cutter, HS, topcoat 104	187452 C
170	26,4	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter, HS, topcoat 104	187713 C
170	26,4	14.8	50	4	3.8	15/15	3	8000	top finish cutter, HS Solid 34	187469 C
170	41	19	50	4	3.8	15/15	5	8000	base cutter, HS Solid 34	187454 C
170	26,4	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter, HS Solid 34	187462 C
170	26,4	14.8	50	4	3.8	15/15	3	8000	top finish cutter, HS Solid 34, topcoat 104	187470 C
170	41	19	50	4	3.8	15/15	5	8000	base cutter, HS Solid 34, topcoat 104	187456 C
170	26,4	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter, HS Solid 34, topcoat 104	187463 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
180	26,4	14.8	50	5	3.8	15/15	3	6000	top finish cutter, HS Solid 34, topcoat 104	187479 C
180	41	19	50	5	3.8	15/15	5	6000	base cutter, HS Solid 34, topcoat 104	187473 C
180	26,4	14.8	50	5	3.8	15/15	3	6000	bottom finish cutter, HS Solid 34, topcoat 104	187476 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

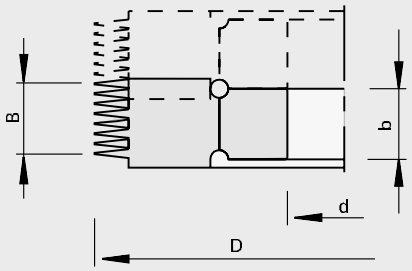
3271.. / 5271.. / 127110

Finger Joint Cutters 15/15 - PUR glueing

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines without cross-cutting device
- For longitudinal joints in soft, hard and exotic woods, with a finger length of 15 mm
- Flexible tool for finger joints when using fibrous and non-fibrous PU glue

Design

- Standard for PUR glueing
- Finger length of 15 mm
- HS suitable for soft woods
- HS Solid 34 suitable for knotty soft woods

Advantages

- HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

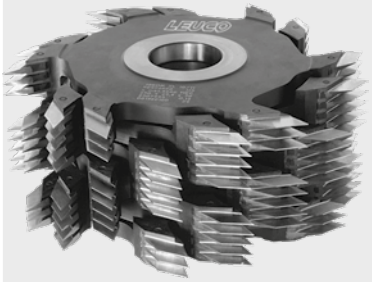
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	HS	187428 L
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	HS Solid 34, topcoat 104	187429 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	HS	187482 C
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	HS Solid 34, topcoat 104	187484 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

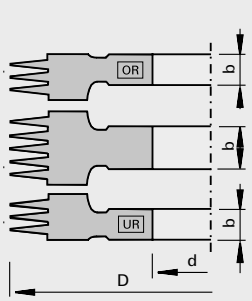
327610 / 327630 / 5276..

Finger Joint Cutters 15/15 - real Z=4 for PUR glueing

Product



Drawing



cutting height	number of cutters
15 mm	OR + UR
34 mm	OR + 1 + UR
53 mm	OR + 2 + UR
72 mm	OR + 3 + UR
91 mm	OR + 4 + UR
110 mm	OR + 5 + UR
129 mm	OR + 6 + UR
148 mm	OR + 7 + UR
167 mm	OR + 8 + UR
186 mm	OR + 9 + UR
208 mm	OR + 10 + UR
260 mm	OR + 13 + UR
310 mm	OR + 16 + UR

High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines without cross-cutting device
- For longitudinal joints in soft, hard and exotic woods, with a finger length of 15 mm
- Flexible tool for finger joints when using fibrous and non-fibrous PU glue

Design

- Standard for PUR glueing
- Real Z=4 for high feed rates
- Finger length of 15 mm
- HS suitable for soft woods
- HS Solid 34 suitable for knotty soft woods

Advantages

- HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

- no. of cutters: see table

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	25,8	14.8	50	4	3.8	15/15	3	8000	top finish cutter, HS	187711 C
170	41	19	50	4	3.8	15/15	5	8000	base cutter, HS	187439 C
170	25,8	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter, HS	187709 C
170	25,8	14.8	50	4	3.8	15/15	3	8000	top finish cutter, HS Solid 34, topcoat 104	187448 L
170	41	19	50	4	3.8	15/15	5	8000	base cutter, HS Solid 34, topcoat 104	187440 L
170	25,8	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter, HS Solid 34, topcoat 104	187444 L
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

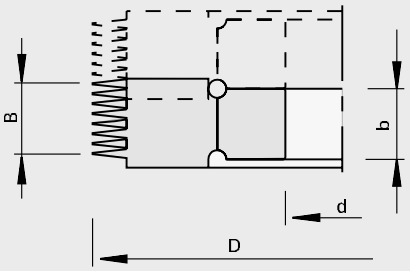
3271.. / 5271.. / 127110

Finger Joint Cutters 15/16,5

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines with cross-cutting device
- For longitudinal joints in soft, hard and exotic woods, with a finger length of 15 mm

Design

- Finger length of 15 mm
- HS suitable for soft woods
- HS Solid 34 suitable for knotty soft woods
- HW suitable for hard and exotic woods

Advantages

- HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	28,6	26.6	50	2+2	3.8	15/16,5	7	8000	HS	187718 L
170	28,6	26.6	50	2+2	3.8	15/16,5	7	8000	HS, topcoat 104	187501 C
170	28,6	26.6	50	2+2	3.8	15/16,5	7	8000	HS Solid 34	187502 C
170	28,6	26.6	50	2+2	3.8	15/16,5	7	8000	HS Solid 34, topcoat 104	187504 C
170	28,6	26.6	50	2+2	3.8	15/16,5	7	8000	HW	187503 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

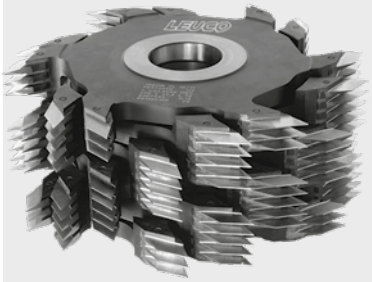
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	28,6	26.6	50	3+3	3.8	15/16,5	7	8000	HS	187514 C
170	28,6	26.6	50	3+3	3.8	15/16,5	7	8000	HS, topcoat 104	187511 C
170	28,6	26.6	50	3+3	3.8	15/16,5	7	8000	HS Solid 34	187513 C
170	28,6	26.6	50	3+3	3.8	15/16,5	7	8000	HS Solid 34, topcoat 104	187518 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000	HS	187558 L
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000	HS, topcoat 104	187561 C
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000	HS Solid 34	187559 C
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000	HS Solid 34, topcoat 104	187693 C
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000	HW	187560 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

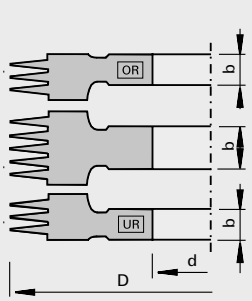
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Finger Joint Cutters 15/16,5 - real Z=4

Product



Drawing



cutting height	number of cutters
15 mm	OR + UR
34 mm	OR + 1 + UR
53 mm	OR + 2 + UR
72 mm	OR + 3 + UR
91 mm	OR + 4 + UR
110 mm	OR + 5 + UR
129 mm	OR + 6 + UR
148 mm	OR + 7 + UR
167 mm	OR + 8 + UR
186 mm	OR + 9 + UR
208 mm	OR + 10 + UR
260 mm	OR + 13 + UR
310 mm	OR + 16 + UR

High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines with cross-cutting device
- For longitudinal joints in soft, hard and exotic woods, with a finger length of 15 mm

Design

- Real Z=4 for high feed rates
- Finger length of 15 mm
- HS suitable for soft woods
- HS Solid 34 suitable for knotty soft woods

Advantages

- HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

- no. of cutters: see table

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	top finish cutter, HS	187540 C
170	41	19	50	4	3.8	15/16,5	5	8000	base cutter, HS	187524 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	bottom finish cutter, HS	187532 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	top finish cutter, HS, topcoat 104	187538 C
170	41	19	50	4	3.8	15/16,5	5	8000	base cutter, HS, topcoat 104	187523 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	bottom finish cutter, HS, topcoat 104	187531 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	top finish cutter, HS Solid 34	187536 C
170	41	19	50	4	3.8	15/16,5	5	8000	base cutter, HS Solid 34	187720 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	bottom finish cutter, HS Solid 34	187530 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	top finish cutter, HS Solid 34, topcoat 104	187722 C
170	41	19	50	4	3.8	15/16,5	5	8000	base cutter, HS Solid 34, topcoat 104	187525 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	bottom finish cutter, HS Solid 34, topcoat 104	187533 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	top finish cutter, HS Solid 34, topcoat 103	187549 C
170	41	19	50	4	3.8	15/16,5	5	8000	base cutter, HS Solid 34, topcoat 103	187721 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	bottom finish cutter, HS Solid 34, topcoat 103	187534 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	top finish cutter, HS Solid 34 O, topcoat 103	187557 C
170	41	19	50	4	3.8	15/16,5	5	8000	base cutter, HS Solid 34 O, topcoat 103	187527 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	bottom finish cutter, HS Solid 34 O, topcoat 103	187535 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

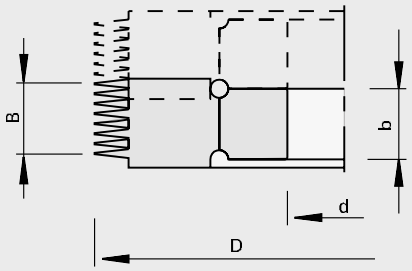
3271.. / 5271..

Finger Joint Cutters 20/20

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines with cross-cutting device
- For longitudinal joints in soft, hard and exotic woods, with a finger length of 20 mm

Design

- Finger length of 20 mm
- HS suitable for soft woods
- HS Solid 34 suitable for knotty soft woods

Advantages

- HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
180	33	31	50	2+2	6.2	20/20	5	8000	HS	187572 L
180	33	31	50	2+2	6.2	20/20	5	8000	HS, topcoat 104	187575 C
180	33	31	50	2+2	6.2	20/20	5	8000	HS Solid 34	187573 L
180	33	31	50	2+2	6.2	20/20	5	8000	HS Solid 34, topcoat 104	187576 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

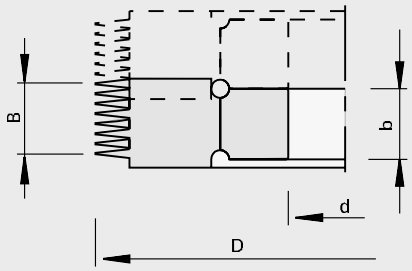
327140 / 5271160

Finger Joint Cutters 20/20 - PUR glueing

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines without cross-cutting device
- For longitudinal joints in soft, hard and exotic woods, with a finger length of 20 mm
- Flexible tool for finger joints when using fibrous and non-fibrous PU glue

Design

- Standard for PUR glueing
- Finger length of 20 mm
- HS suitable for soft woods
- HS Solid 34 suitable for knotty soft woods

Advantages

- HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

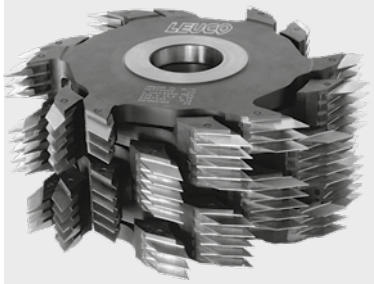
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
180	33	31	50	2+2	6.2	20/20	5	8000	HS	187568 C
180	33	31	50	2+2	6.2	20/20	5	8000	HS Solid 34, topcoat 104	187569 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
260	33	31	50	3+3	6.2	20/20	5	6000	HS	187599 C
260	33	31	50	3+3	6.2	20/20	5	6000	HS Solid 34, topcoat 104	187600 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

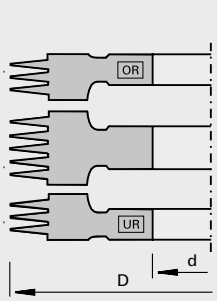
327640 / 527660

Finger Joint Cutters 20/20 - real Z=3 for PUR glueing

Product



Drawing



cutting height	number of cutters
15 mm	OR + UR
34 mm	OR + 1 + UR
53 mm	OR + 2 + UR
72 mm	OR + 3 + UR
91 mm	OR + 4 + UR
110 mm	OR + 5 + UR
129 mm	OR + 6 + UR
148 mm	OR + 7 + UR
167 mm	OR + 8 + UR
186 mm	OR + 9 + UR
208 mm	OR + 10 + UR
260 mm	OR + 13 + UR
310 mm	OR + 16 + UR

High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines without cross-cutting device
- For longitudinal joints in soft, hard and exotic woods, with a finger length of 20 mm
- Flexible tool for finger joints when using fibrous and non-fibrous PU glue

Design

- Standard for PUR glueing
- Real Z=3 for high feed rates
- Finger length of 20 mm
- HS suitable for soft woods
- HS Solid 34 suitable for knotty soft woods

Advantages

- HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

- no. of cutters: see table

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
180	27,2	17.2	50	3	6.2	20/20	2	8000	top finish cutter, HS	187591 C
180	39,6	19.1	50	3	6.2	20/20	3	8000	base cutter, HS	187579 C
180	27,2	17.2	50	3	6.2	20/20	2	8000	bottom finish cutter, HS	187586 C
180	27,2	17.2	50	3	6.2	20/20	2	8000	top finish cutter, HS Solid 34, topcoat 104	187593 C
180	39,6	19.1	50	3	6.2	20/20	3	8000	base cutter, HS Solid 34, topcoat 104	187580 C
180	27,2	17.2	50	3	6.2	20/20	2	8000	bottom finish cutter, HS Solid 34, topcoat 104	187587 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

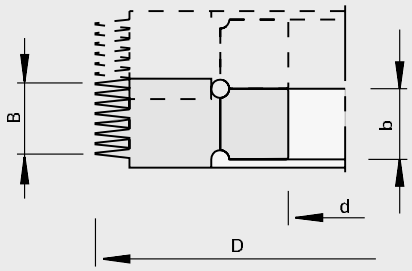
3271.. / 5271..

Finger Joint Cutters 20/22

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines with cross-cutting device
- For longitudinal joints in soft, hard and exotic woods, with a finger length of 20 mm

Design

- Finger length of 20 mm
- HS suitable for soft woods
- HS Solid 34 suitable for knotty soft woods

Advantages

- HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

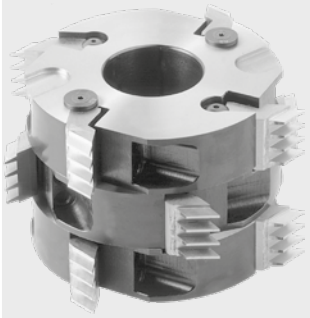
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
180	33	31	50	2+2	6.2	20/22	5	8000	HS	187603 L
180	33	31	50	2+2	6.2	20/22	5	8000	HS, topcoat 104	187605 C
180	33	31	50	2+2	6.2	20/22	5	8000	HS Solid 34	187604 C
180	33	31	50	2+2	6.2	20/22	5	8000	HS Solid 34, topcoat 104	187606 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
260	33	31	50	3+3	6.2	20/22	5	6000	HS	187609 L
260	33	31	50	3+3	6.2	20/22	5	6000	HS, topcoat 104	187610 C
260	33	31	50	3+3	6.2	20/22	5	6000	HS Solid 34	187611 C
260	33	31	50	3+3	6.2	20/22	5	6000	HS Solid 34, topcoat 104	187612 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

396291

Finger Joint Cutterheads - with exchangeable HS cutting edges

Product



Drawing



LEUCO TOP COAT

High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- for longitudinal joints in highly stressed components

Design

- tool body made from steel
- 4/6 exchangeable knives (160 mm) or 6/8 exchangeable knives (250 mm) for particularly high feedrates
- secured against twisting
- cutting material: HS-topcoat

Advantages

- multiple edge lives compared to conventional material, increased edge lives and higher wear resistance and gliding features thanks to topcoat coating

Notes

- included in delivery: tool body without knife inserts

Ø D	Ø D1	B	b	Ø d	Z	nmax	Ident-No.
129.8	160/170	30,4	30.4	50	2+2	8500	192180 S
129.8	160/170	30,4	30.4	50	3+3	8500	192181 S
216	250/260	30,4	30.4	50	2+2	6000	192182 S
216	250/260	30,4	30.4	50	3+3	6000	192183 S
216	250/260	30,4	30.4	50	4+4	6000	192188 S
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

Overview

wood width in mm	Number of cutters	wood width in mm	Number of cutters
27	1	179	6
58	2	210	7
88	3	240	8
118	4	271	9
149	5	297	10

Knives	Class-No.	PU	Ident-No.
HS insert topcoat 10/10	332924	4	192184 S
HS insert topcoat 10/11	332924	4	192185 C
HS insert topcoat 15/15	332924	4	192186 S
HS insert topcoat 15/16.5	332924	4	192187 L
		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M8x20 DIN EN ISO 4028	995161	10	001625 L
	[mm]		[pc.]	

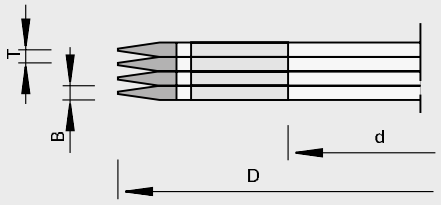
127210

Finger Joint Cutters disc-type HW

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- finger joint machines Grecon/ Dimter, SMB, Scharpf + Kögel, Dieffenbacher, NKT
- machines with cross-cutting device
- for longitudinal joints in soft and hard woods

Design

- high-tensile steel body
- topline grinding
- Ø 160 mm: n max = 11,800 min-1
- Ø 250 mm: n max = 7,400 min-1
- Ø 260 mm: n max = 7,200 min-1

Advantages

- extremely long edge lives thanks to the special coordination of cutting material to the material to be cut and the spiral arrangement of the cutting edges

Notes

- adjustable to any wood thickness with bushing

Ø D	B	Ø d	Z	Partition	Finger joint length		Ident-No.
160	3,8	70	2	3.8	10/11	Soft wood	177561 S
160	3,8	70	2	3.8	10/11	hard woods/exotic woods	177562 S
160	3,8	70	4	3.8	10/11	Soft wood	177563 L
160	3,8	70	4	3.8	10/11	hard woods/exotic woods	177564 L
250	3,8	70	6	3.8	10/11	hard woods/exotic woods	180938 L
250	3,8	70	6	3.8	10/11	Soft wood	180939 L
260	3,8	70	6	3.8	15/16	Soft wood	178253 S
[mm]	[mm]	[mm]		[mm]	[mm]		

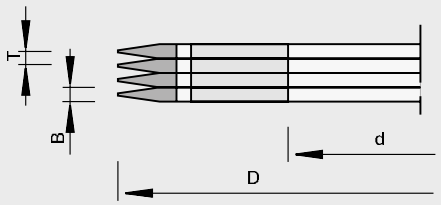
127230

Finger Joint Cutters disc-type HW - coated

Product



Drawing



LEUCO TOP COAT

Tungsten Carbide [HW]

MEC

Machine / Application

- finger joint machines Grecon/ Dimter, SMB, Scharpf + Kögel, Dieffenbacher, NKT
- machines with cross-cutting device
- for longitudinal joints in soft and hard woods

Design

- high-tensile steel body
- HW topcoat coating
- Ø 160 mm: n max = 11,800 min-1
- Ø 250 mm: n max = 7,400 min-1

Advantages

- extremely long edge lives thanks to coated cutting edge material and the spiral arrangement of the cutting edges
- compared to traditional HW finger joint cutters the edge live is 2 - 3 times as long

Notes

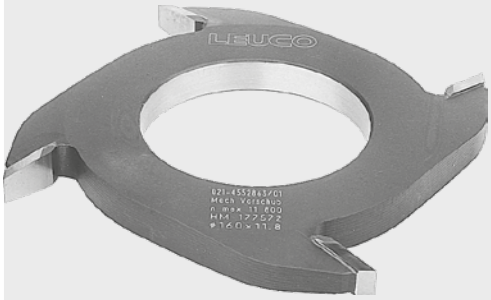
- adjustable to any wood thickness with bushing

Ø D	B	Ø d	Z	Partition	Finger joint length	Ident-No.
160	3,8	70	4	3.8	10/11	181230 S
250	3,8	70	6	3.8	10/11	181233 S
[mm]	[mm]	[mm]		[mm]	[mm]	

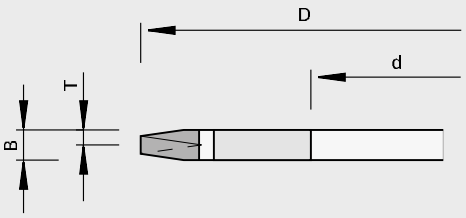
127310

Disc-type Edge Finger Joint Cutters HW

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- finger joint machines
- for cutting of closed visible longitudinal joints in hard and soft woods

Design

- high-tensile steel body
- Ø 149 mm: n max = 12,700 min-1
- Ø 160 mm: n max = 11,800 min-1
- Ø 239 mm: n max = 7,900 min-1
- Ø 250 mm: n max = 7,400 min-1

Advantages

Notes

- in combination with finger joint cutters with same Ø and pitch
- Ø 149 mm and Ø 239 mm (half shoulder) only with scoring saw blade

Ø D	B	Ø d	Z	Partition	Finger joint length	Ident-No.
149	3,8	70	4	3.8	5	180916 S
160	11,4	70	4	3.8	10/11	177574 S
239	3,8	70	6	3.8	10	180917 S
239	11,4	70	6	3.8	10/11	181245 L
250	11,4	70	6	3.8	10/11	177576 S
[mm]	[mm]	[mm]		[mm]	[mm]	

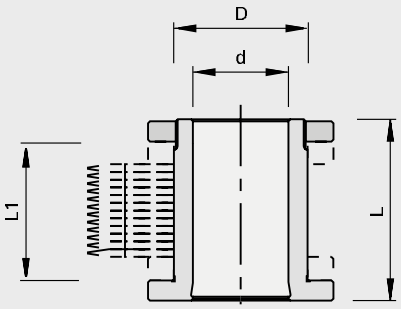
997300

Bushings for Finger Joint Cutters

Product



Drawing



Machine / Application

- for clamping of finger joint cutters and edge finger joint cutters

Design

- high-tensile steel body
- spacers Ø 97 mm for cutters Ø 160-210 mm (not required)

Advantages

- high concentric and runout accuracy
- for varying wood thicknesses

Notes

- fill intermediate sizes with spacers
- for cutter Ø 250 mm install at least one spacer Ø 177 on top and bottom
- fastening nut or hydraulic clamping for cutter attachment must be ordered separately
- for cutter sets over 100 mm height we recommend hydraulic clamping
- the bushing length depends on the wood height "H" and on the type of nut
- accessories: mounting device, mounting ring and wrench is imperative for self-resharpening

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

Spacer Rings	Ø D	B	Ø d	Class-No.	PU	Ident-No.
	100	7,6	70	955520	1	180940 L
	100	11,4	70	955520	1	180941 L
	175	7,6	70	955520	1	186163 S
	175	11,4	70	955520	1	181034 L
	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Mounting Devices		997300	1	177103 L
Pin-type face wrenches		985720	1	177102 L
Fastening Nut	M68x1,5x14	995290	1	177104 L
Hydraulic Clumping Nuts	M68x1,5x56	933090	1	178787 C
Screwdrivers	SW4x100	985730	1	166091 L
	[mm]		[pc.]	

Finger Joint Cutters - Calculation of cutting width

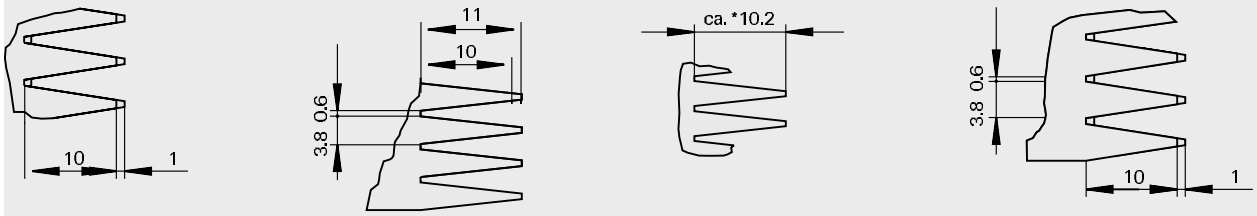
Combination of the cutter sets depending on the wood thickness

Finger length [mm]	Wood thickness [mm]	Number of cutters	Finger length [mm]	Wood thickness [mm]	Number of cutters
10+15	24	1	20	28	1
10+15	51	2	20	59	2
10+15	77	3	20	90	3
10+15	104	4	20	121	4
10+15	131	5	20	152	5
10+15	157	6	20	183	6
10+15	184	7	20	214	7
10+15	210	8	20	245	8
10+15	237	9	20	276	9
10+15	264	10	20	307	10

Finger joint cutters - cross cutting with extended finger joint profile

Finger length [mm]	For machines with sizing device	For machines without sizing device	Finger length [mm]
10/10		X	No
10/11	X		10-11
15/15		X	No
15/16,5	X		15-16,5
20/20		X	No
20/22	X		20-22

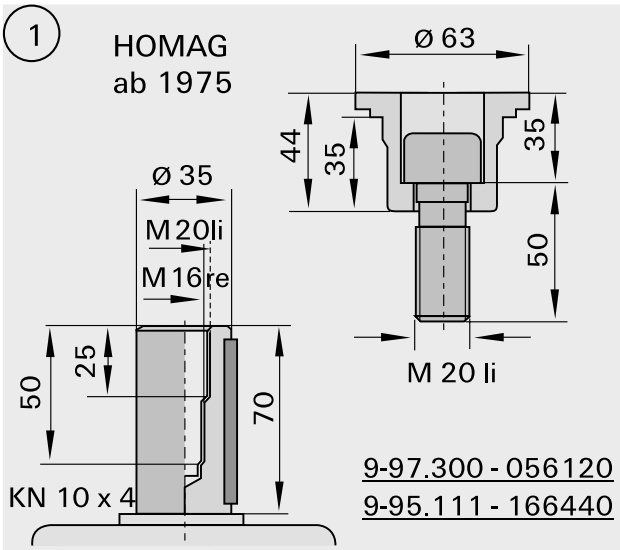
Drawing profile example



Fasteners for Jointing Cutterheads

1

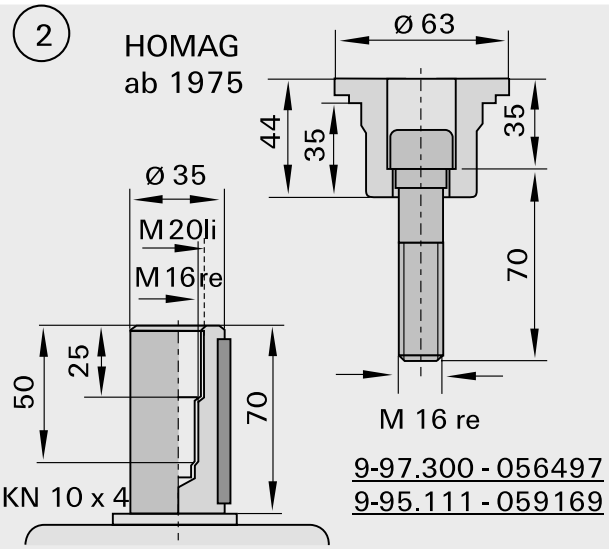
HOMAG
ab 1975



9-97.300 - 056120
9-95.111 - 166440

2

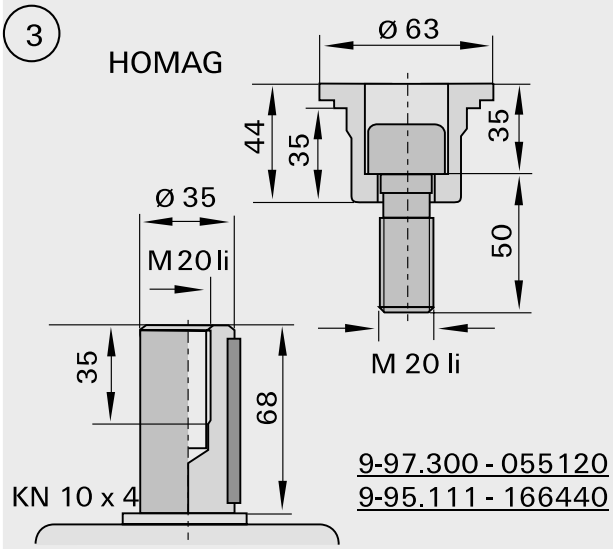
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ab 1975



9-97.300 - 056497
9-95.111 - 059169

3

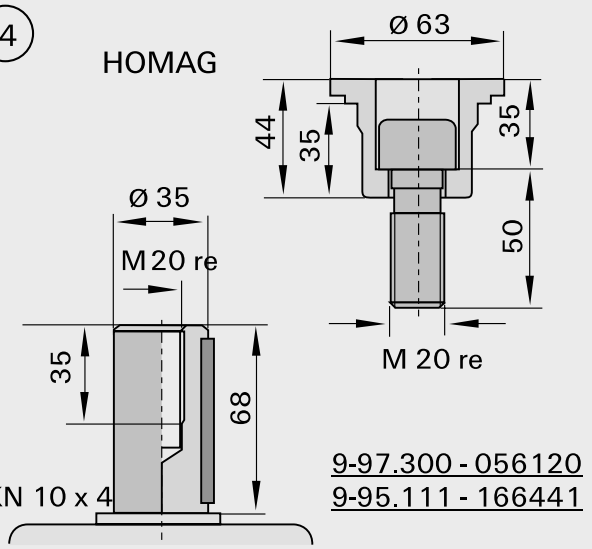
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9-97.300 - 055120
9-95.111 - 166440

4

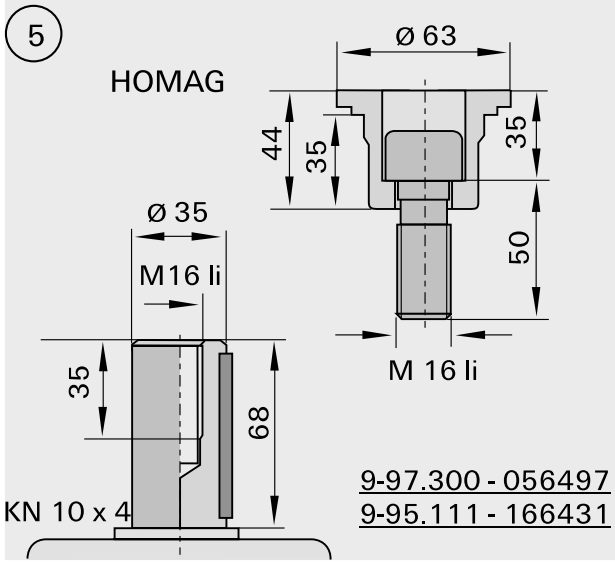
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9-95.111 - 166441

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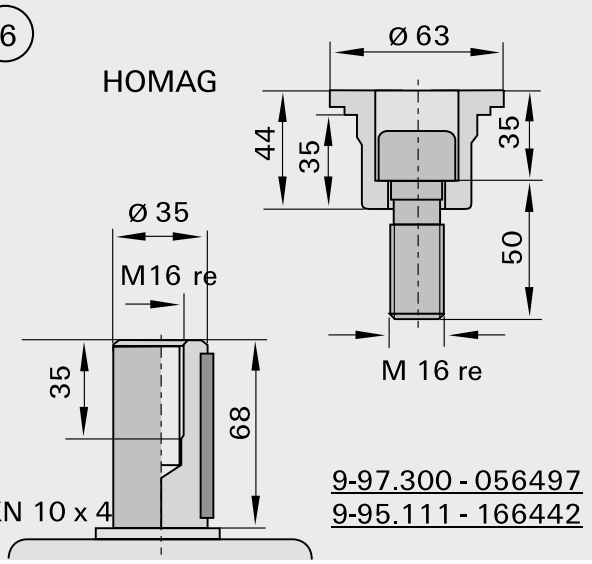
HOMAG



9-97.300 - 056497
9-95.111 - 166431

6

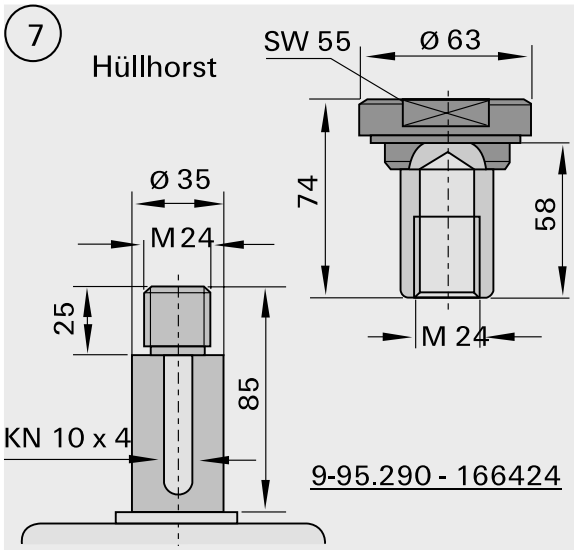
HOMAG



9-97.300 - 056497
9-95.111 - 166442

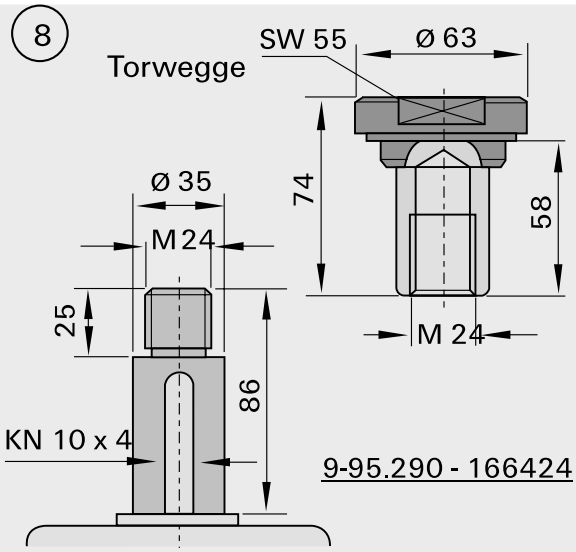
Fasteners for Jointing Cutterheads

7 Hüllhorst



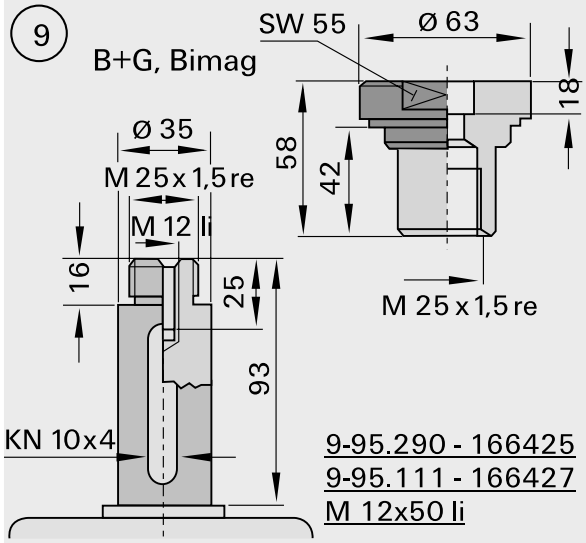
9-95.290 - 166424

8 Torwegge



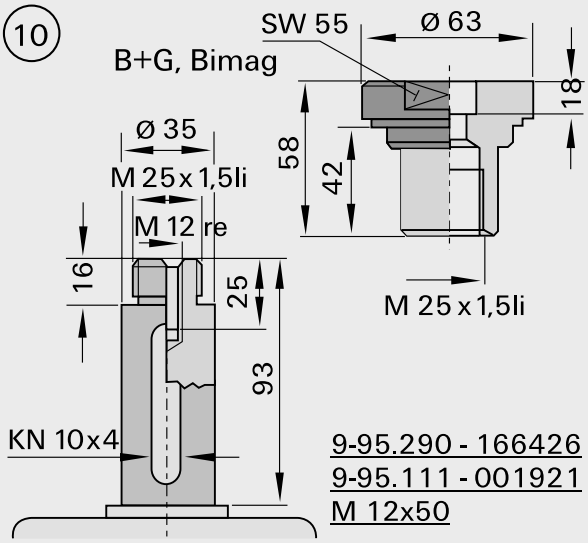
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9 B+G, Bimag



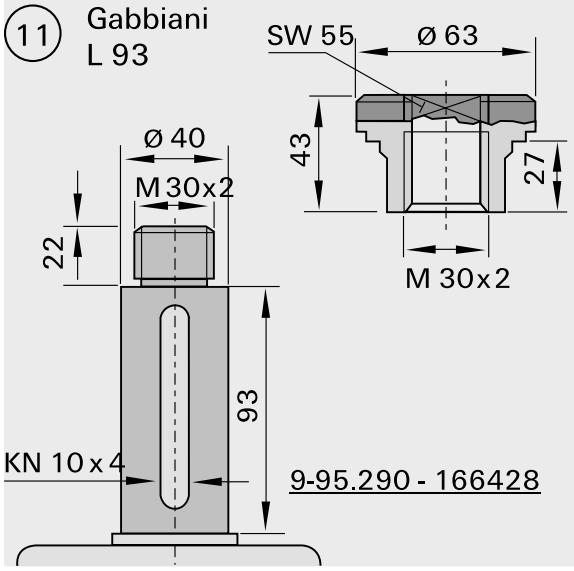
9-95.290 - 166425
9-95.111 - 166427
M 12x50 li

10 B+G, Bimag



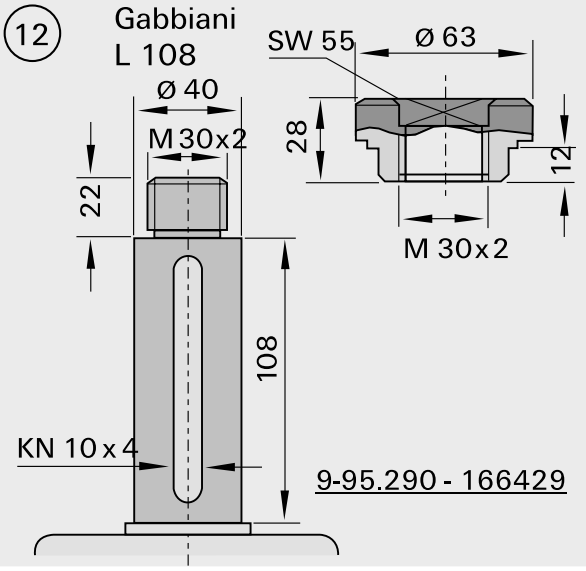
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9-95.111 - 001921
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11 Gabbiani L 93



9-95.290 - 166428

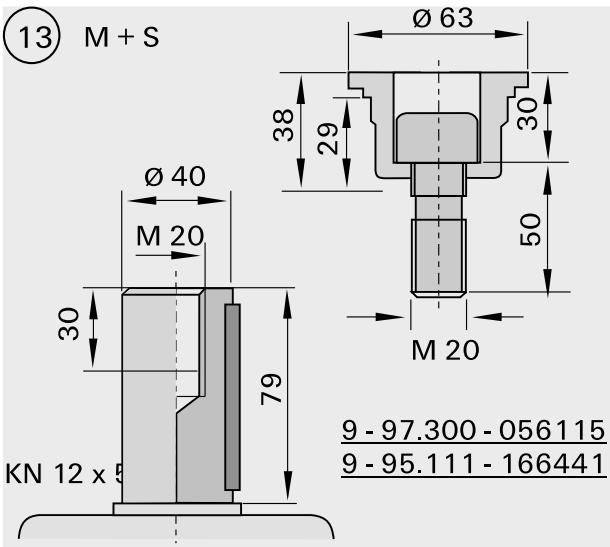
12 Gabbiani L 108



9-95.290 - 166429

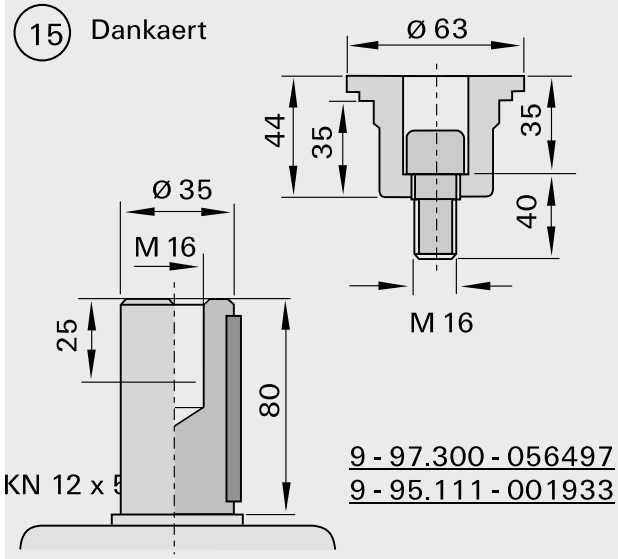
Fasteners for Jointing Cutterheads

13 M + S



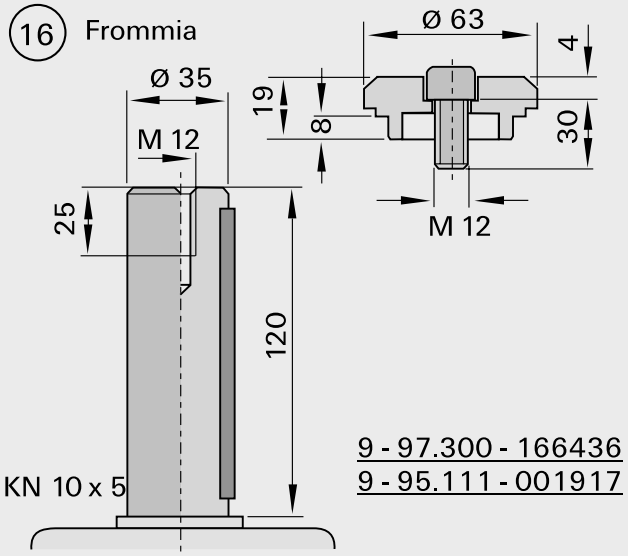
9 - 97.300 - 056115
9 - 95.111 - 166441

15 Dankaert



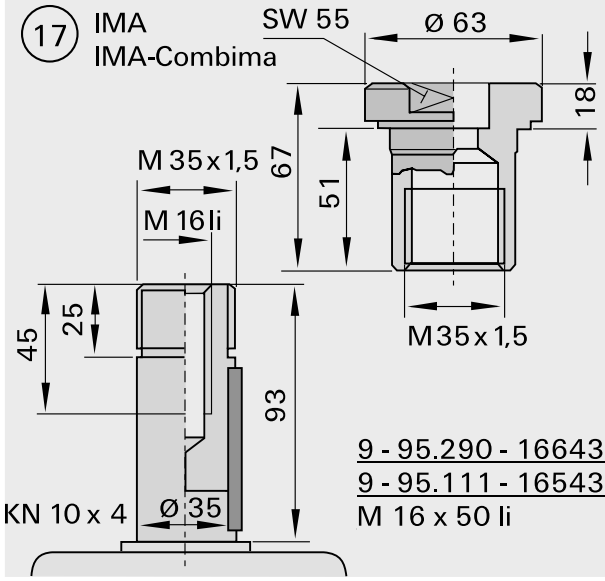
9 - 97.300 - 056497
9 - 95.111 - 001933

16 Frommia



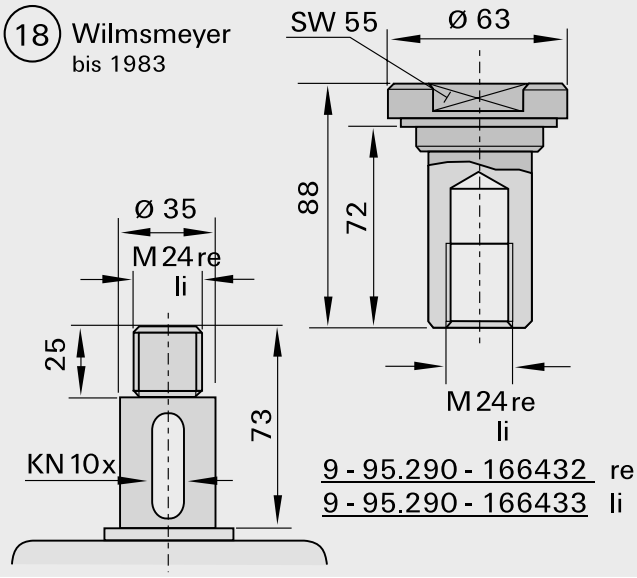
9 - 97.300 - 166436
9 - 95.111 - 001917

17 IMA
IMA-Combima



9 - 95.290 - 166430
9 - 95.111 - 165431
M 16 x 50 li

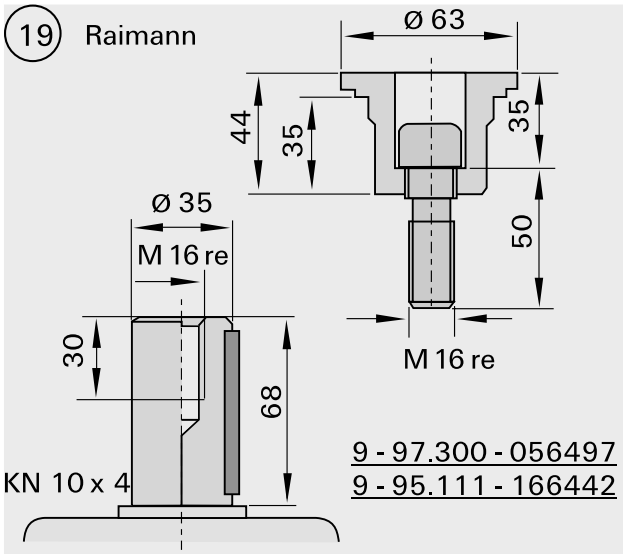
18 Wilmsmeyer
bis 1983



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

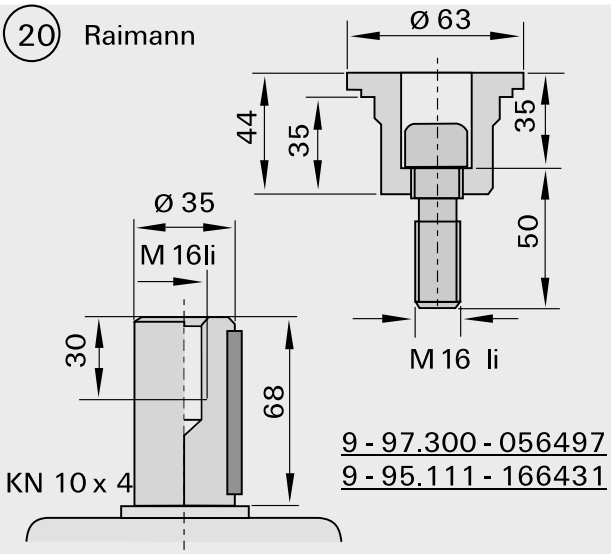
Fasteners for Jointing Cutterheads

19 Raimann



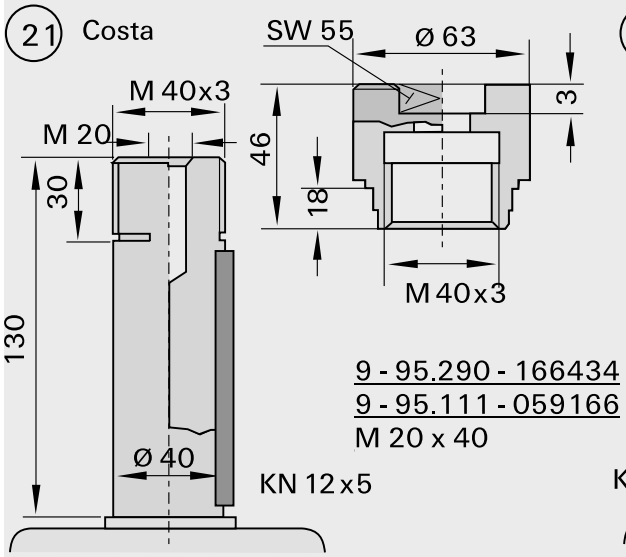
9 - 97.300 - 056497
9 - 95.111 - 166442

20 Raimann



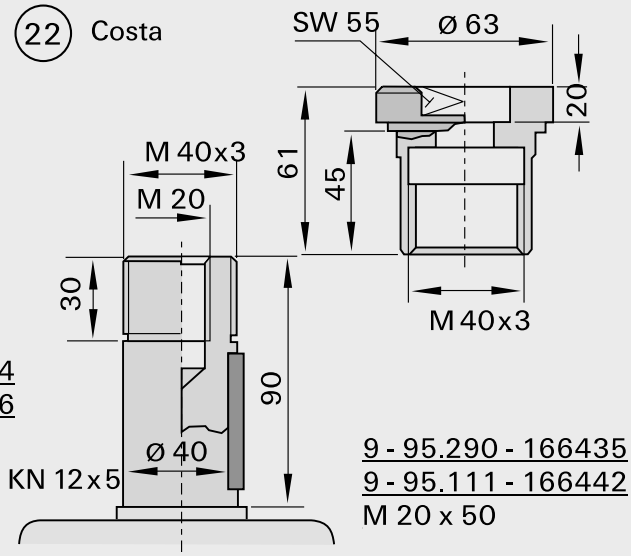
9 - 97.300 - 056497
9 - 95.111 - 166431

21 Costa



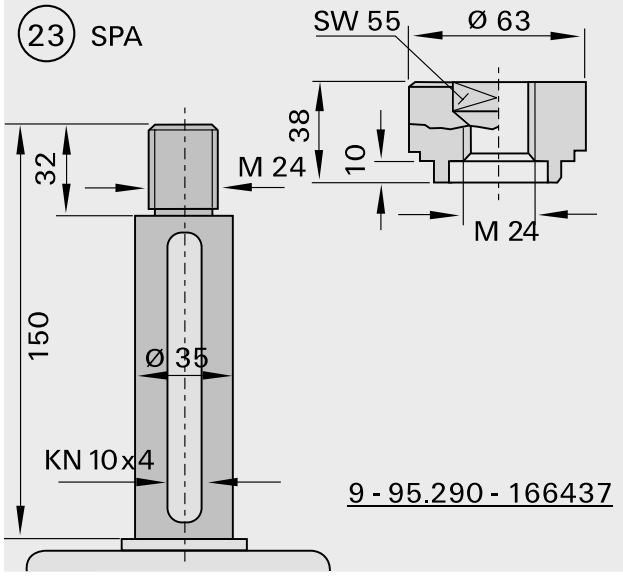
9 - 95.290 - 166434
9 - 95.111 - 059166
M 20 x 40

22 Costa



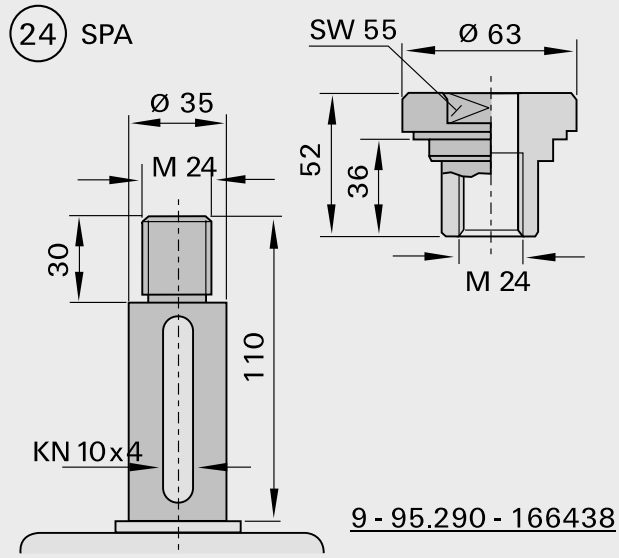
9 - 95.290 - 166435
9 - 95.111 - 166442
M 20 x 50

23 SPA



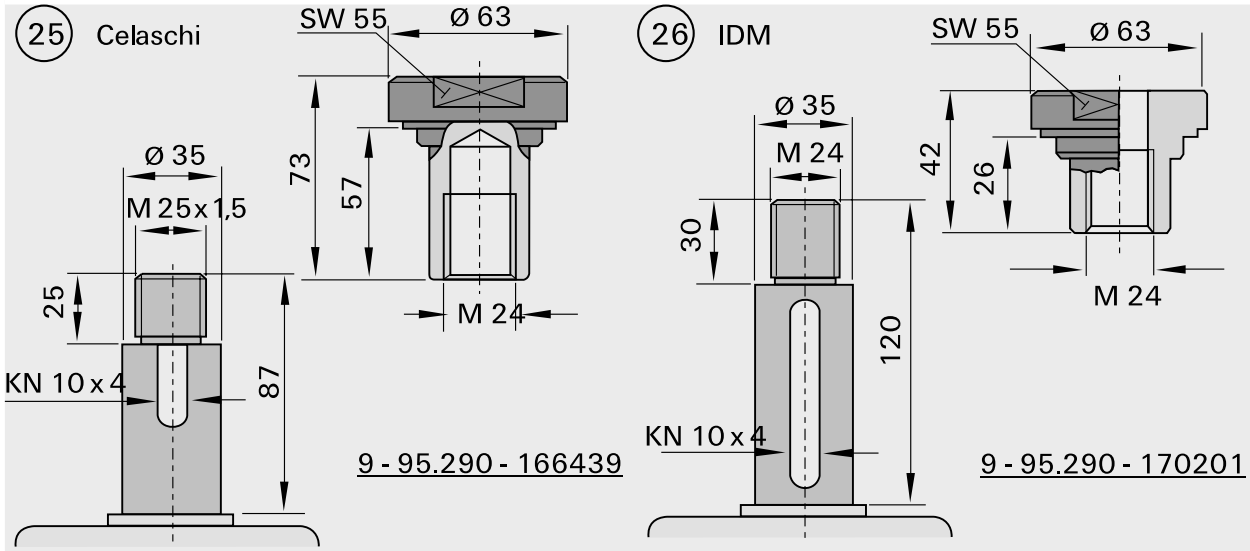
9 - 95.290 - 166437

24 SPA

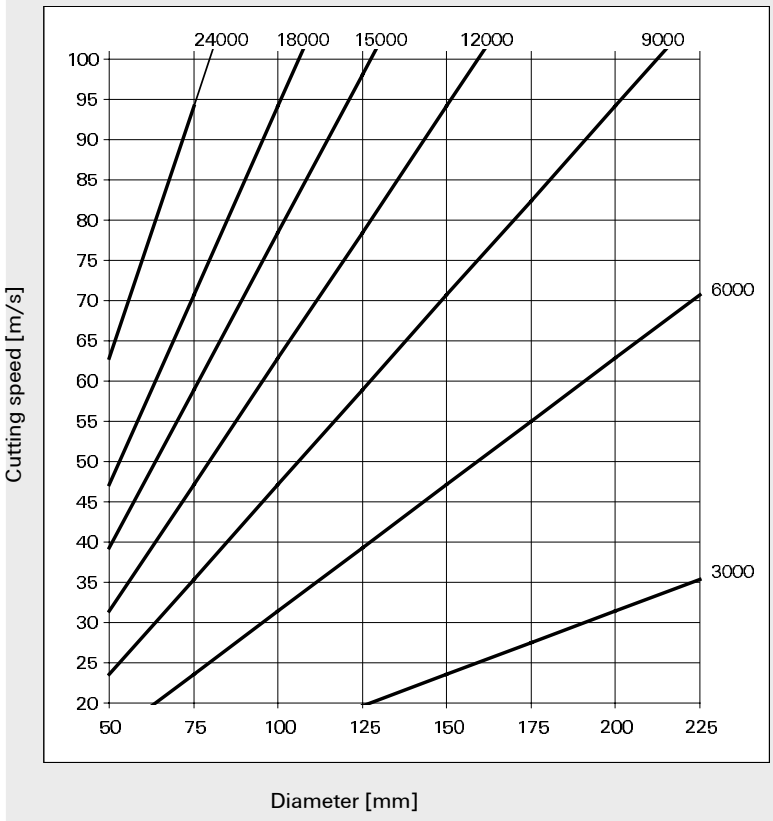


9 - 95.290 - 166438

Fasteners for Jointing Cutterheads



Determination of RPM [min-1]



Feed rate per tooth

Milling

Workpiece material	Feed rate per tooth fz [mm]
Solid woods with the grain	0,60 - 0,80
Solid woods across the grain	0,30 - 0,40
Laminated woods	0,40 - 0,50
Raw panels	0,50 - 0,70
Laminated panels	0,20 - 0,40
Veneered panels	0,10 - 0,15

Planing

Cutting quality	Effective feed rate per tooth fz eff [mm]	Formulas for calculation
Fine	1,3 - 1,7	Feed rate vf [m/min]
Medium	1,7 - 2,5	Rotations per minute (RPM) [min-1]
Coarse	2,5 - 5,0	Number of teeth z
		Effective feed rate per tooth (tooth/knife progression) fz eff [mm]
		Tools with conventional clamping
		fz eff = (vf x 1000) / (n x 1)
		Tools with Hydro clamping
		fz eff = (vf x 1000) / (n x z)

Order / Inquiry for Special Tools: Cutters with Bore

Please copy and send the completed form to one of the LEUCO sales offices. (Only one tool description per form)

Customer-no.: _____
Company: _____
Plant: _____
Street: _____
Zip / City: _____
Country: _____
Contact partner: _____
Phone: _____
City and Date: _____

Order: o
Inquiry: o

Delivery (week no.): _____
(Not binding)
No. of pieces: _____

Fax: _____
Signature: _____

Machine

Maker: _____
Model: _____
Type (e.g. DET, etc.): _____
RPM range [min-1] _____
Feed rate [m/min]: _____

Workpiece

Description: _____
_____
Cutting quality: _____
Direction of cut:

Solid wood	With grain	o
	Across grain	o
	On end	o
Wood-based materials	Top layer	o
	Middle layer	o
	Top and middle layer	o

Coating

Yes o No o

Description: _____
Further Information _____

Tool

Single tool o
Tool set:
With tipped cutting edges: o
With exchangeable cutting edges:
EcoPro Cutterhead o
SuperProfiler o
UltraProfiler o
Standard o

Cutting diameter D [mm]: _____
basic diameter D1 [mm]: _____
Cutting width B [mm]: _____
Depth of cut [mm]: _____

Type of feed: MAN o MEC o
Sense of rotation: Left o Right o
Mode of application: Against feed o With feed o

No. of teeth [pcs.]:
Rakers: _____
Spur: _____
Grooving knives: _____
Edge breaker: _____

Arrangement of cutting edges:
Shear angle: Single-sided o
Alternate o

Interface

Bore d [mm]: _____

Double keyway:	Height	Width
Keyway:	Height	Width

Clamping Bushing [Ø]: _____
Hydro Bushing [Ø]:: _____
Hydro s-System: _____
s-System [Ø]: _____
Other:

o check if applicable

Please indicate the following on workpiece samples or drawings:

Bottom side of workpiece	Dimensions
Sense of rotation	Application conditions
Motor spindle	Profile drawing
Hydro Bushing [Ø]::	Tool drawing

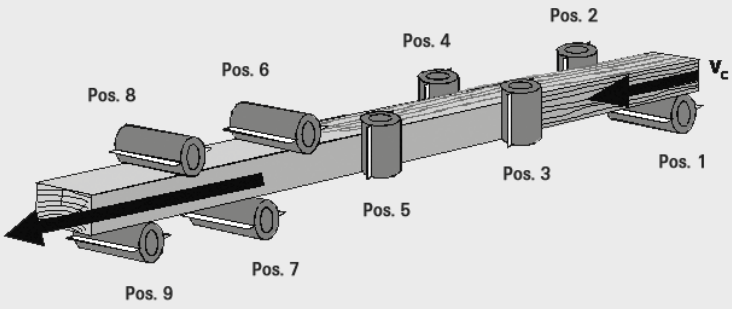
Please indicate clearly if the workpiece or the tool is shown.

Please indicate additional dimension and markings in the tool drawing.

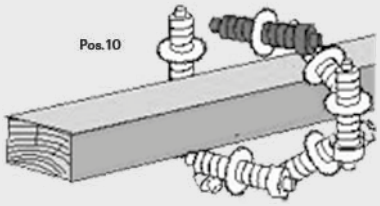
518-01.0708

Checklist for molders (incl. “Weinig Powermat” series)

Overview of the max.possible number of spindles (please mark with a cross)



Universal spindle (pos. 10) can be combined with every type series.



Universal spindle available: Yes O No O

Additional third spindle above (pos. 11), mostly after the first spindle below (see pos. 1): Yes O No O

Pos. 1

Spindle diameter (mm): _____

HSK interface: Yes O No O

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes O No O From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 2

Spindle diameter (mm): _____

HSK interface: Yes O No O

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes O No O From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 3

Spindle diameter (mm): _____

HSK interface: Yes O No O

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes O No O From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 4

Spindle diameter (mm): _____

HSK interface: Yes O No O

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes O No O From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

497-03.1207

Checklist for molders (incl. “Weinig Powermat” series)

Pos. 5

Spindle diameter (mm): _____

HSK interface: Yes O No O

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes O No O _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 6

Spindle diameter (mm): _____

HSK interface: Yes O No O

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes O No O _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 7

Spindle diameter (mm): _____

HSK interface: Yes O No O

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes O No O From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 6

Spindle diameter (mm): _____

HSK interface: Yes O No O

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes **O** No O From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 9

Spindle diameter (mm): _____

HSK interface: Yes O No O

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes O No O From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 10

Spindle diameter (mm): _____

HSK interface: Yes O No O

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes O No O From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 11

Spindle diameter (mm): _____

HSK interface: Yes O No O

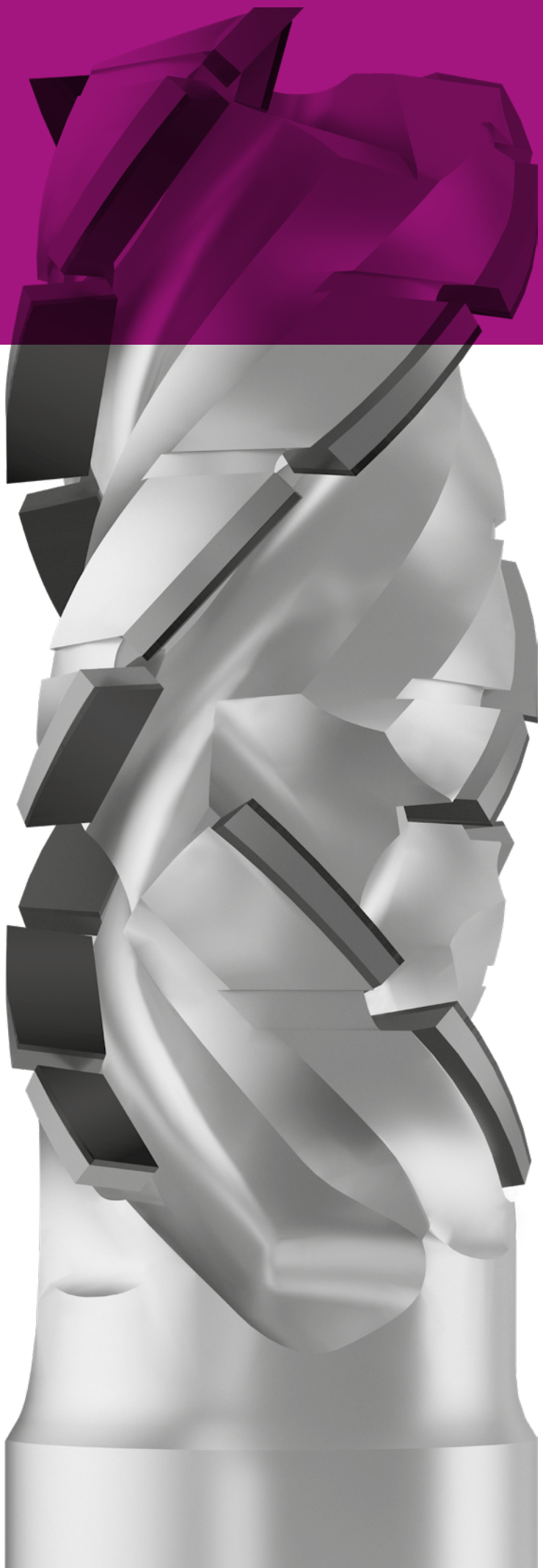
Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes O No O From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

497-03.1207



LEUCO

Shank-Type Cutters

Product	Page
Straight Shank-Type Tools for stationary routers	4–1
Profiled Shank-Type Tools for stationary routers	4–66
Straight Shank-Type Tools for portable routers	4–93
Profiled Shank-Type Tools for portable routers	4–101
Technical Information	4–107

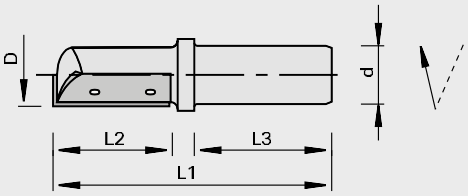
128415

Shank-Type Cutters with HW Turnover Knives - Z=1, MAN

Product



Drawing



LEUCO CNC

Tungsten Carbide [HW]

MAN

Machine / Application

- portable routers
- CNC routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- cutting edge parallel to cutter axis and face cutting
- cutting material: HW HL Board 05

Advantages

Notes

- Clamping elements: ps-System, TRIBOS , draw-in collet chuck, adapter

Ø D	L2	Ø d	L3	L1	Z			Ident-No.
8.0	20	12	40	70	1		R	175669 L
10	25	10	40	75	1		R	175678 L
10	25	12	40	75	1		R	175670 L
10	25	16	45	80	1		R	180797 L
12	30	12	40	80	1		R	175664 L
12	30	12	40	80	1		L	175665 C
14	30	12	40	80	1		R	175666 L
16	50	12	40	100	1		R	175668 L
[mm]	[mm]	[mm]	[mm]	[mm]				

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
for Ø D = 8	20	4.1	1.1	150535	10	173480 L
for Ø D = 10	25	5.5	1.1	150535	10	173793 L
for Ø D = 12+14	30	5.5	1.1	150535	10	173482 L
for Ø D = 16	50	5.5	1.1	150535	10	173483 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Clamping Wedges	B=20	175669	925500	2	175722 L
Clamping Wedges	B=25	180797, 175670, 175678	925500	2	175724 C
Clamping Wedges	B=30	175664	925500	2	175726 C
Clamping Wedges	B=30	175665	925500	2	175730 C
Clamping Wedges	B=30	175666	925500	2	175728 C
Clamping Wedges	B=30	175667	925500	2	175731 C
Clamping Wedges	B=50	175668	925500	2	175729 C
Head Cap Screws	M2,5x3 T8	175669	995115	10	168237 L
Head Cap Screws	M2,5x4 T8	180797, 175670, 175678	995115	10	168238 L
Head Cap Screws	M3x5,5 T8	175664, 175667, 175666, 175665	995115	10	168239 L
Head Cap Screws	M3,5x5,5 T15	175668	995115	10	168236 L
Screwdriver with flag	T8	175664, 180797, 175667, 175670, 175678, 175666, 175669, 175665	985730	1	166499 L
Screwdrivers	T15	175668	985730	1	163161 L
	[mm]			[pc.]	

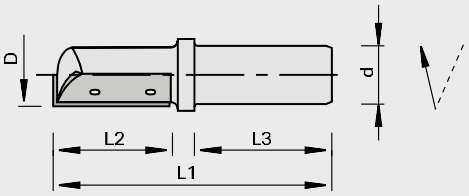
128415

Shank-Type Cutters with HW Turnover Knives - Z=1 with high breaking strength, MAN

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable routers
- CNC routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- tool body made of heavy metal
- cutting edge parallel to cutter axis and face cutting
- cutting material: HW HL Board 05

Advantages

- high breaking strength

Notes

- Clamping elements: ps-System, TRIBOS , draw-in collet chuck, adapter

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
8.0	20	12	40	80	1	180816 L
10	25	12	40	80	1	180817 L
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
for Ø D = 8	20	4.1	1.1	150535	10	173480 L
for Ø D = 10	25	5.5	1.1	150535	10	173793 L
	[mm]	[mm]	[mm]		[pc.]	

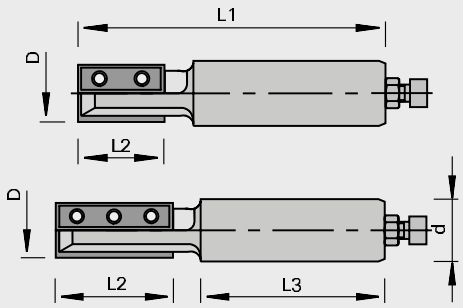
Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Clamping Wedges	B=20	180816	925500	2	175722 L
Clamping Wedges	B=25	180817	925500	2	175724 C
Head Cap Screws	M2,5x3 T8	180816	995115	10	168237 L
Head Cap Screws	M2,5x4 T8	180817	995115	10	168238 L
Screwdriver with flag	T8	For all	985730	1	166499 L
	[mm]			[pc.]	

128410

Shank-Type Cutters with HW Turnover Knives - Z=2 with mini turnover knives

Product

Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- cutting edges parallel to cutter axis; peripheral cutting and face cutting
- cutting material: HW HL Board 05
- cutting material: HW HL Board 03 for abrasive materials, e.g. laminated panel boards
- with attachment screw

Advantages

Notes

- Clamping elements: ps-System, TRIBOS , draw-in collet chuck, adapter
- with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	30	25	55	100	2	180804 C
16	50	25	55	120	2	180805 C
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	LEUCODUR	Class-No.	PU	Ident-No.
	29,5	9.0	1.5	HL Board 05	150515	10	180821 L
	29,5	9.0	1.5	HL Board 03	150513	10	180807 L
	50	9.0	1.5	HL Board 03	150513	10	181982 L
	[mm]	[mm]	[mm]			[pc.]	

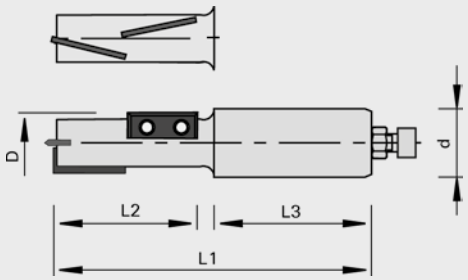
Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M3,5x4,8 T15	995195	10	180915 L
Screwdrivers	T15	985730	1	163161 L
	[mm]		[pc.]	

128260

Shank-Type Cutters with HW Turnover Knives - Z=1+1 with alternating shear angle

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for jointing of chip-free cutting edges in laminated panels
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- with alternating shear angle
- plunge tip: Ø 16 - Ø 18 HW-tipped; Ø 30 HW turnover knife
- with attachment screw

Advantages

- 2 edge lives by exchanging the upper and lower knife

Notes

- Clamping elements: ps-System, TRIBOS , draw-in collet chuck, adapter
- with attachment screw

Ø D	L2	Ø d	L3	L1	Z		Ident-No.
16	30	25	55	110	1+1	R	180443 C
16	50	25	55	130	1+1	R	180444 L
18	50	25	55	130	1+1	R	180445 C
[mm]	[mm]	[mm]	[mm]	[mm]			

Knives	B	H	S	Class-No.	PU	Ident-No.
L2 = 30	16	7.0	1.5	150523	10	180262 L
L2 = 50	28	7.0	1.5	150523	10	180260 L
	[mm]	[mm]	[mm]		[pc.]	

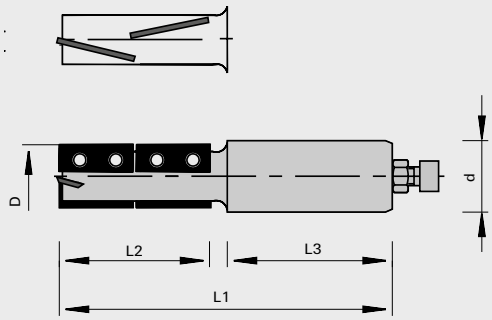
Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M3x4 T9	995195	10	180449 L
Screwdrivers	T9x60	985730	1	173796 L
	[mm]		[pc.]	

128260

Shank-Type Cutters with HW Turnover Knives - Z=2+2 with alternating shear angle

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for jointing, dividing, grooving and rabbeting in laminated panels and solid woods
- traveling plunge cut using Z and X or Y axis

Design

- staggered HW knives with with alternating shear angle
- plunge tip: 4-side HW turnover knife

Advantages

- 4 edge lives by turning the knives and exchanging the upper and lower turnover knife

Notes

- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with attachment screw

Ø D	L2	Ø d	L3	L1	Z		Ident-No.
20	33	25	55	110	2+2	R	184252 L
20	53	20	55	125	2+2	R	184253 L
20	53	25	55	125	2+2	R	184254 L
20	53	25	55	125	2+2	L	184256 C
30	75	25	55	145	2+2	R	180814 C
[mm]	[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
L2 = 33	17,5	7.0	1.5	150515	10	184257 L
L2 = 53	29,5	7.0	1.5	150515	10	184258 L
L2 = 75	39,5	9.0	1.5	150515	10	180815 L
plunge tip for Ø 20	9,0	9.0	1.5	150515	10	184259 L
plunge tip for Ø 30	7,5	12	1.5	150515	10	052543 L
	[mm]	[mm]	[mm]		[pc.]	

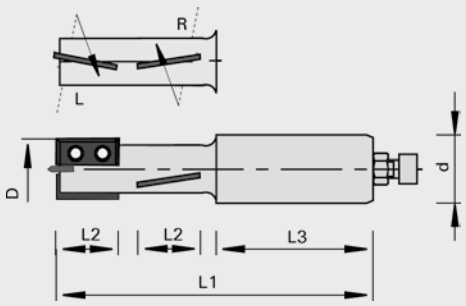
Spare parts	Dimension		Class-No.	PU	Ident-No.
Round Head Screws	M3x4 T9	for Ø D = 20	995195	10	180449 L
Screwdrivers	T9x60	for Ø D = 20	985730	1	173796 L
Head Cap Screws	M3,5x5,5 T15	for Ø D = 30	995115	10	168236 L
Head Cap Screws	M4x5 T15	for Ø D = 30	995115	10	180819 C
Screwdrivers	T15		985730	1	163161 L
	[mm]			[pc.]	

128260

Shank-Type Cutters with HW Turnover Knives - Z=2+2, sense of rotation L+R

Product

Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- cutting edges of RH resp. LH cutting parts with down-shear angle
- lower part of the cutter can be run in left hand rotation by adjusting the Z-axis and changing the direction of rotation; this allows optimum machining of frail edges utilizing only one spindle
- with attachment screw

Advantages

Notes

- workpiece secured on clamping blocks
- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
20	28	25	55	130	2+2	180442 C
[mm]	[mm]	[mm]	[mm]	[mm]		

Knives	B	H	S	Class-No.	PU	Ident-No.
	28	7.0	1.5	150523	10	180260 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M3x4 T9	995195	10	180449 L
Screwdrivers	T9x60	985730	1	173796 L
	[mm]		[pc.]	

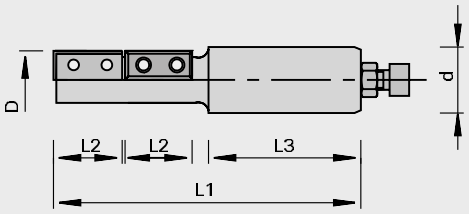
128410

Shank-Type Cutters with HW Turnover Knives - Z=1+1, 2+2 sense of rotation L+R

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- cutting edges parallel to cutter axis; face cutting
- customized direction of rotation (right or left) by installing the appropriate turnover knife
- cutting material: HW HL Board 05
- lower part of the cutter can be run in left hand rotation by adjusting the Z-axis and changing the direction of rotation; this allows optimum machining of frail edges utilizing only one spindle
- Ident-No. 172269 with attachment screw
- Ident-No. 180227 without attachment screw

Advantages

Notes

- workpiece secured on clamping blocks
- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
18	29	25	55	132	1L+1R	172269 L
40	39	25	55	158	2L+2R	180227 L
[mm]	[mm]	[mm]	[mm]	[mm]		

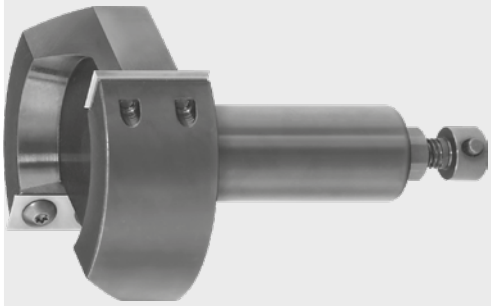
Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	29,5	12	1.5	150515	10	180825 L
	39,5	12	1.5	150515	10	171149 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=27	172269	925900	2	171068 L
Round Head Screws	M3,5x6 T15	180227	995195	10	177549 L
Round Head Screws	M3,5x12 T15	172269	995195	10	171067 L
Screwdrivers	T15x80	For all	985730	1	171188 L
	[mm]			[pc.]	

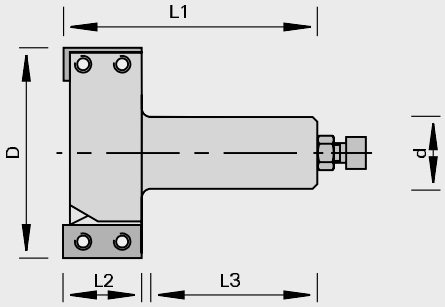
128210

Shank-Type Cutters with HW Turnover Knives for jointing, rabbeting, planing

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for jointing, rabbeting and planing in solid woods and wood-based panels

Design

- cutting edge parallel to cutter axis and face cutting
- cutting material: HW HL Board 05
- with attachment screw

Advantages

Notes

- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
80	30	25	55	89	2	168732 L
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	29,5	12	1.5	150515	10	180825 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Magnetic Stops	1,0	997800	1	166094 L
Round Head Screws	M4x5,9 T15	995195	10	167966 L
Screwdrivers	T15	985730	1	163161 L
	[mm]		[pc.]	

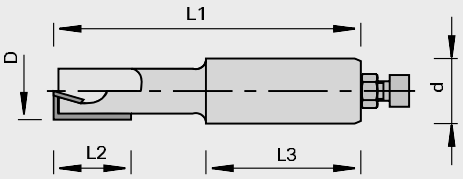
128215

Shank-Type Cutters with HW Turnover Knives - Z=1+1, MEC

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- 1 cutting edge parallel to cutter axis and peripheral cutting
- 1 plunging tip with shear angle
- cutting material: HW HL Board 05

Advantages

Notes

- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	30	16	43	92	1+1	168682 L
20	30	16	43	96	1+1	168684 L
20	30	25	55	108	1+1	168685 L
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Plunge tip for Ø 16	7,5	12	1.5	150515	10	052543 L
plunge tip for Ø 20	9	12	1.5	150515	10	167256 L
Turnover Knives	29,5	12	1.5	150515	10	180825 L
	[mm]	[mm]	[mm]		[pc.]	

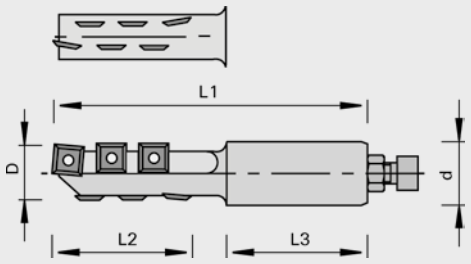
Spare parts	Dimension	Class-No.	PU	Ident-No.
Head Cap Screws	M3,5x3,8 T15	995115	10	162645 L
Round Head Screws	M3,5x4 T15	995195	10	168893 L
Screwdrivers	T15	985730	1	163161 L
	[mm]		[pc.]	

128210

Shank-Type Cutters with HW Turnover Knives - Z=1+1 with high milling performance

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for pre-cutting and finish cutting in coated laminated materials
- traveling plunge cut using Z and X or Y axis

Design

- upper and lower turnover knife with shear angle
- cutting material: HW HL Board 05
- cutting material: HW HL Board 03
- with attachment screw

Advantages

- high hogging volume
- chip-free cutting edges

Notes

- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
22	60	25	55	131	1+1	180803 O
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	LEUCODUR	Class-No.	PU	Ident-No.
	12	12	1.5	HL Board 05	150515	10	003080 L
	12	12	1.5	HL Board 03	150513	10	180820 L
	[mm]	[mm]	[mm]			[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M4x5,9 T15	995195	10	167966 L
Screwdrivers	T15	985730	1	163161 L
	[mm]		[pc.]	

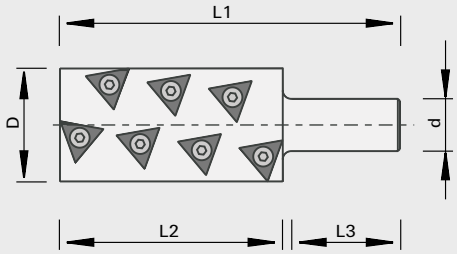
128260

Shank-Type Cutters with HW Turnover Knives - t3-System

Product



Drawing



LEUCO t3>system

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC and joinery machines
- For offset- and chip-free jointing, rabbeting and sizing of solid wood

Design

- Rounded triangular turnover knives with cutting edges drawing from bottom to top and from top to bottom
- Cutting material: HW
- HL Solid 20 for hard wood and soft wood
- HL Board 06 for wood-based materials, plastics and hard woods
- topcoat coating for increased edge lives

Advantages

- absolutely chip-free jointing and rabbeting
- Thanks to the rounded turnover knives the machined surface is offset-free
- excellent edge and surface quality
- very high milling performance
- spiral plunge-cutting for free form milling
- Triangular turnover knives with rounded edges 3 edge lives

Notes

- spiral plunge-cutting, pockets larger than Ø 60
- feed rate per tooth fz = 0.2-0.5 mm
- turnover knife 9209773 scoring without projection, suitable for jointing without groove

Ø D	L2	Ø d	L3	L1	Z	Number of cutting edges	Ident-No.
54	78	20	52	133.5	2+2	14	187268 L
54	63	25	52	120	2+2	12	187299 L
54	78	25	52	133.5	2+2	14	187300 L
54	106,5	25	52	162.5	2+2	18	187113 L
61	79,1	25	52	139.2	2+2	14	187330 C
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

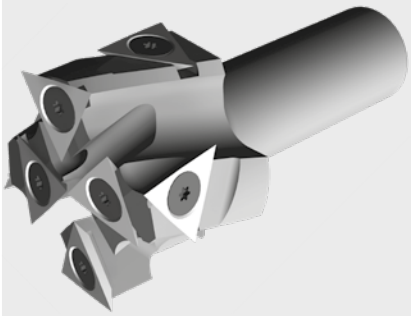
Turnover Knives	B	H	S	Class-No.		PU	
	20,38	17.9	3.0	HL Solid 20	150557	10	9209773 O
	20,88	18.3	3.0	HL Board 06	150566	10	187692 L
	20,88	18.3	3.0	HL Solid 20	150567	10	187251 L
	20,88	18.3	3.0	HL Solid 20 topcoat	150567	10	187694 L
	[mm]	[mm]	[mm]			[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x10,8 T15 D=Ø9,4	995125	10	180840 L
Screwdrivers	T15x80	985730	1	171188 L
	[mm]		[pc.]	

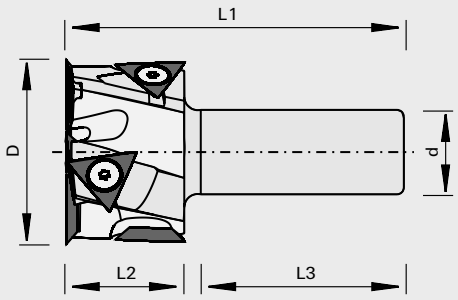
128260

Rabbeting Shank-Type Cutters with HW Turnover Knives - t3-System

Product



Drawing



LEUCO t3 system

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC and joinery machines
- for offset and chip-free rabbeting of solid wood and wood-based materials

Design

- Rounded triangular turnover knives with cutting edges drawing from top to bottom
- also for rabbets <21 mm
- Cutting material: HW
- HL Solid 20 for hard wood and soft wood
- HL Board 06 for wood-based materials, plastics and hard woods
- topcoat coating for increased edge lives

Advantages

- absolutely chip-free rabbeting
- Thanks to the rounded turnover knives the machined surface is offset-free
- excellent edge and surface quality
- very high milling performance
- spiral plunge-cutting for free form milling
- Triangular turnover knives with rounded edges 3 edge lives

Notes

- spiral plunge-cutting, pockets larger than Ø 60
- feed rate per tooth fz = 0.2-0.5 mm
- turnover knife 9209773 scoring without projection, suitable for jointing without groove

Ø D	L2	Ø d	L3	L1	Z	Number of cutting edges	Ident-No.
54	35	25	61	100	2+2	8	187269 C
61	35	25	61	100	2+2	8	187369 L
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

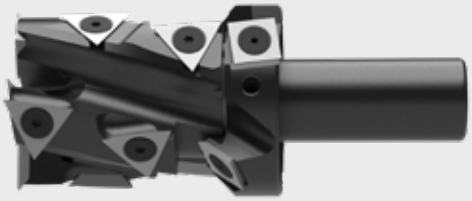
Turnover Knives	B	H	S	Class-No.		PU	
	20,38	17.9	3.0	HL Solid 20	150557	10	9209773 O
	20,88	18.3	3.0	HL Board 06	150566	10	187692 L
	20,88	18.3	3.0	HL Solid 20	150567	10	187251 L
	20,88	18.3	3.0	HL Solid 20 topcoat	150567	10	187694 L
	[mm]	[mm]	[mm]			[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x10,8 T15 D=Ø9,4	995125	10	180840 L
Screwdrivers	T15x80	985730	1	171188 L
	[mm]		[pc.]	

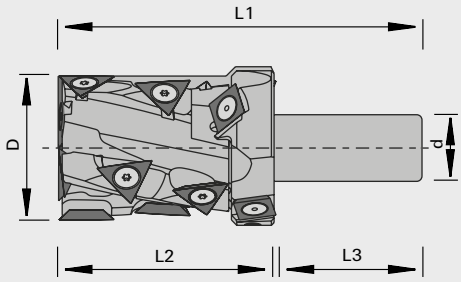
128260

Socket hole milling cutter HW - t3-System

Product



Drawing



LEUCO t3>system

Tungsten Carbide [HW]

MEC

Machine / Application

- Joinery machines, e.g. Hundegger, Weinmann, Krüsi
- for milling of socket holes in soft and hard wood, glued laminated timber, wood and panel materials as well as gypsum board and hardwood laminated, beech veneer lumber

Design

- Rounded triangular turnover knives with cutting edges drawing from top to bottom
- Cutting material: HW
- HL Solid 20

Advantages

- Drilling and chamfering 2x45° in the same operation
- Thanks to the rounded turnover knives the machined surface is offset-free
- Excellent edge and surface quality
- Very high milling performance
- spiral plunge-cutting for free form milling
- Triangular turnover knives with rounded edges, 3 edge lives

Notes

Ø D	L2	Ø d	L3	L1	Z	Number of cutting edges	Ident-No.
61	80	25	55	136.5	2+2+2	16	80479566 C
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

Turnover Knives	B	H	S	LEUCODUR	Class-No.	PU	Ident-No.
	14	14	2.0	HL Solid 30	150558	10	003079 L
	20,38	17.9	3.0	HL Solid 20	150557	10	9209773 O
	20,88	18.3	3.0	HL Solid 20	150567	10	187251 L
	20,88	18.3	3.0	HL Solid 20 topcoat	150567	10	187694 L
	20,88	18.3	3.0	HL Board 06	150566	10	187692 L
	[mm]	[mm]	[mm]			[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x6 T20 D=Ø9,3	995125	10	176199 L
Countersunk Screws	M5x10,8 T15 D=Ø9,4	995125	10	180840 L
Screwdrivers	T20x100	985730	1	166092 L
Screwdrivers	T15x80	985730	1	171188 L
	[mm]		[pc.]	

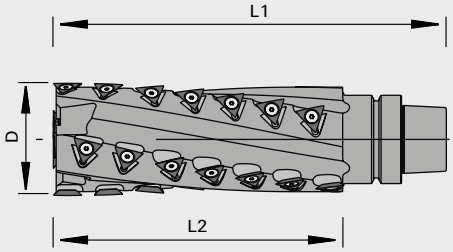
128260

Monolitic shank-type cutter HSK 63E with turnover knives - t3-System

Product



Drawing



LEUCO t3 system

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC and joinery machines
- for shoulder- and chip-free jointing, rabbeting and sizing of soft and hard wood, glued laminated timber, wood and panel materials as well as gypsum board and hardwood laminated, beech veneer lumber

Design

- Triangular turnover knives with rounded cutting edges drawing from bottom to top and from top to bottom
- Monolitic design thanks to the removal of the interface

Advantages

- Absolutely chip-free jointing and rabbeting
- Thanks to the rounded turnover knives the machined surface is offset-free
- Excellent edge and surface quality
- Very high milling performance
- spiral plunge-cutting for free form milling
- Triangular turnover knives with rounded edges, 3 edge lives
- further optimization of the concentricity due to the removal of the interface

Notes

Ø D	L2	Ø d	L1	Z	Number of cutting edges	Ident-No.
80	207,6	HSK 63E	280.5	2+2	32	80482108 C
[mm]	[mm]	[mm]	[mm]		[pc.]	

Turnover Knives	B	H	S	Class-No.		PU	
	20,38	17.9	3.0	HL Solid 20	150557	10	9209773 O
	20,88	18.3	3.0	HL Solid 20	150567	10	187251 L
	20,88	18.3	3.0	HL Solid 20 topcoat	150567	10	187694 L
	20,88	18.3	3.0	HL Board 06	150566	10	187692 L
	[mm]	[mm]	[mm]			[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x10,8 T15 D=Ø9,4	995125	10	180840 L
Screwdrivers	T15x80	985730	1	171188 L
	[mm]		[pc.]	

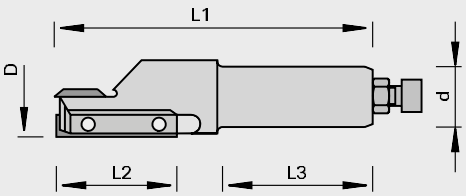
128415

Shank-Type Cutters with HW Turnover Knives - Z=1+1 with mini turnover knives

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- 1 cutting edge parallel to cutter axis and peripheral cutting
- 1 plunging tip
- cutting material: HW HL Board 05
- with attachment screw

Advantages

Notes

- Clamping elements: ps-System, TRIBOS , draw-in collet chuck, adapter
- with attachment screw

Ø D	L2	Ø d	L3	L1	Z			Ident-No.
16	50	16	45	106	1+1		R	175714 L
16	50	25	55	116	1+1		R	175715 L
18	30	12	40	81	1+1		R	175707 C
18	50	16	45	106	1+1		R	180798 L
18	50	25	55	116	1+1		L	175717 L
18	50	25	55	116	1+1		R	175716 L
22	30	12	40	81	1+1		R	175711 C
[mm]	[mm]	[mm]	[mm]	[mm]				

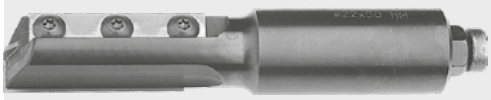
Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Turnover Knives	12	12	1.5	150515	10	003080 L
Mini Turnover Knives	30	5.5	1.1	150535	10	173482 L
Mini Turnover Knives	50	5.5	1.1	150535	10	173483 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Clamping Wedges	B=30	175707	925500	2	169281 O
Clamping Wedges	B=50	175714, 175715	925500	2	171111 O
Clamping Wedges	B=50	175717	925500	2	171114 O
Clamping Wedges	B=50	175716, 180798	925500	2	171113 L
Clamping Wedges	B=30	175711	925500	2	169283 S
Head Cap Screws	M3,5x5,5 T15	175714, 175715, 175716, 175707, 175717, 180798	995115	10	168236 L
Head Cap Screws	M3,5x6,5 T15	175711	995115	10	163223 L
Round Head Screws	M4x5,9 T15	For all	995195	10	167966 L
Screwdrivers	T15	For all	985730	1	163161 L
	[mm]			[pc.]	

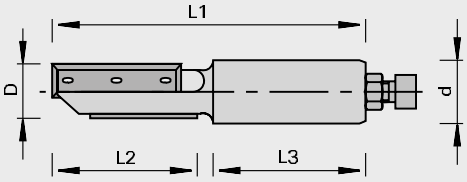
MEC

Shank-Type Cutters with HW Turnover Knives - Z=2

Product



Drawing



100.00

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- CNC routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- cutting edges parallel to axis in stepped design (Ident-No. 180799 without stepped design)
- 1 plunging tip
- cutting material: HW HL Board 05
- with attachment screw

Advantages

Notes

- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with attachment screw

Ø D	L2	Ø d	L3	L1	Z		Ident-No.
18	55	25	55	125	2	R	177156 L
18	55	25	55	125	2	L	180906 L
20	55	25	55	125	2	R	177157 L
22	55	25	55	125	2	R	177158 C
25	50	25	55	119	2	R	180799 L
[mm]	[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	50	12	1.7	150516	10	179994 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Screwdrivers	T15	For all	985730	1	163161 L
Round Head Screws	M4x5,9 T15	177156, 177158, 177159, 177157, 180906	995195	10	167966 L
Head Cap Screws	M4x6 T15	180799	995115	10	180989 O
	[mm]			[pc.]	

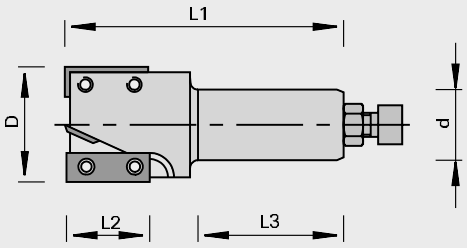
128410

Shank-Type Cutters with HW Turnover Knives - Z=2+1

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Dimension

- 2 cutting edges parallel to cutter axis and peripheral cutting
- 1 plunging tip with shear angle
- cutting material: HW HL Board 05
- with attachment screw

Advantages

Notes

- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [R]
40	30	16	43	91	2+1	168731 L
40	30	25	55	106	2+1	168730 L
[mm]	[mm]	[mm]	[mm]	[mm]		

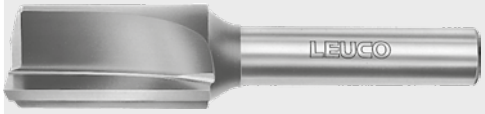
Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	12	12	1.5	150515	10	003080 L
	29,5	12	1.5	150515	10	180825 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Magnetic Stops	1,0	997800	1	166094 L
Round Head Screws	M4x5,9 T15	995195	10	167966 L
Screwdrivers	T15	985730	1	163161 L
	[mm]		[pc.]	

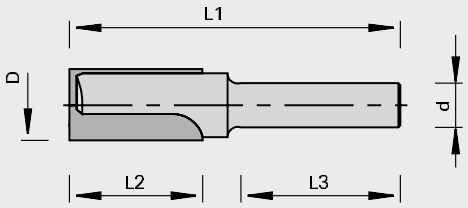
129415

Router Bits HW-tipped - face cutting

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- routers
- for jointing, rabbeting, grooving and copying in hard and exotic woods and wood-based panels

Design

- cutting edges parallel to cutter axis

Advantages

Notes

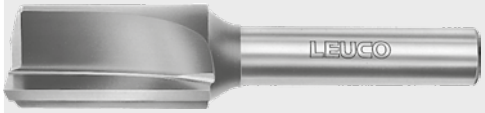
- face cutting design allows plunge-cuts
- clamping elements: centric clamping chuck, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	23	10	35	70	2	160336 L
12	23	10	35	70	2	160337 L
12	26	12	40	72	2	006229 L
14	28	12	40	76	2	006231 C
15	30	12	40	80	2	006232 L
16	35	12	40	90	2	180775 L
18	35	12	40	90	2	180776 L
25	41	12	40	92	2	006240 C
[mm]	[mm]	[mm]	[mm]	[mm]		

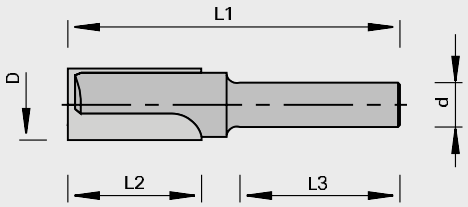
129415

Router Bits with solid carbide body - face cutting

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- routers
- for jointing, rabbeting, grooving and copying in hard and exotic woods and wood-based panels

Design

- cutting edges parallel to cutter axis

Advantages

Notes

- face cutting design allows plunge-cuts
- clamping elements: centric clamping chuck, draw-in collet chuck

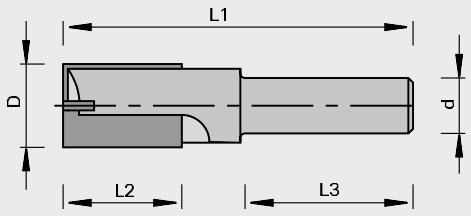
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
3.0	5,0	9,5	20	34	2	006219 L
5.0	7,0	9,5	20	39	2	006221 C
4.0	10	10	35	49	2	160332 L
5.0	12	10	35	49	2	160333 L
6.0	14	10	35	53	2	160334 L
8.0	20	10	35	60	2	160335 L
[mm]	[mm]	[mm]	[mm]	[mm]		

129415

Router Bits HW-tipped - face cutting and plunge tip

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- routers
- for jointing, rabbeting, grooving and copying in hard and exotic woods and wood-based panels

Design

- cutting edges parallel to cutter axis

Advantages

Notes

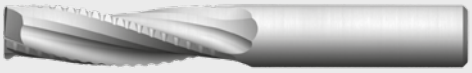
- face cutting design and plunging insert allows plunge-cuts
- clamping elements: centric clamping chuck, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	35	12	50	90	2	177160 L
12	35	12	50	90	2	177161 L
12	45	12	40	90	2	177162 L
14	35	12	50	90	2	177163 C
16	35	12	50	90	2	177164 C
18	35	12	50	90	2	177165 C
20	35	12	50	90	2	177166 C
22	35	12	50	90	2	177167 C
24	35	12	50	90	2	177168 C
[mm]	[mm]	[mm]	[mm]	[mm]		

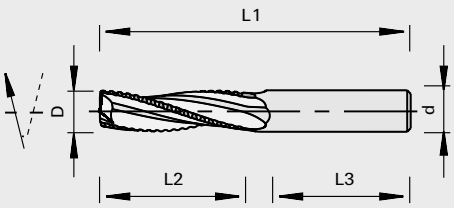
129453

Roughing Cutters VHW - ecoline

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- CNC routers
- for rough-cutting in solid woods, plywood and uncoated panels
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- positive spiral for tightly clamped workpieces face side down
- n max = 30,000 min-1

Advantages

- high hogging volume
- optimum upward chip evacuation thanks to positive spiral
- well-priced version

Notes

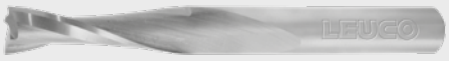
- ecoline design = reduced number of traces and less resharpening possibilities
- slightly rough cutting surface due to fine cut division
- clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Helical direction	Ident-No.
8.0	32	8,0	35	75	3	positive	183950 L
10	32	10	30	75	3	positive	183951 L
12	42	12	40	90	3	positive	183952 L
16	35	16	38	90	3	positive	183953 L
16	55	16	36	110	3	positive	183954 L
[mm]	[mm]	[mm]	[mm]	[mm]			

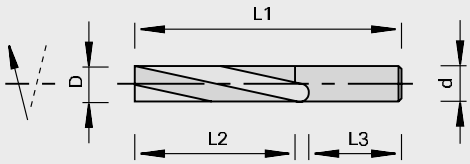
129453

Finishing Cutters VHW - ecoline

Product



Drawing



LEUCO ecoline

LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application

- CNC routers
- for finish-cutting in solid woods, plywood and uncoated panels
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- positive spiral for tightly clamped workpieces face side down
- negative spiral for smaller workpieces hard to clamp with face side up
- n max = 30,000 min-1

Advantages

- high hogging volume
- optimum upward chip evacuation thanks to positive spiral
- optimum downward chip evacuation thanks to negative spiral
- well-priced version

Notes

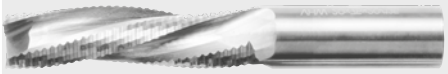
- ecoline design = reduced number of traces and less resharpening possibilities
- clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Helical direction	Ident-No.
3.0	15	3,0	36	60	2	positive	183937 L
3.0	15	6,0	36	60	2	positive	183938 L
4.0	15	4,0	36	60	2	positive	183939 L
4.0	15	4,0	28	60	2	negative	183940 L
4.0	15	6,0	36	60	2	positive	183941 L
5.0	15	6,0	36	60	2	positive	183942 L
6.0	22	6,0	30	60	2	positive	183943 L
6.0	22	6,0	30	60	2	negative	183944 L
8.0	30	8,0	36	75	2	positive	183945 L
8.0	30	8,0	36	75	2	negative	183946 L
10	30	10	35	75	2	positive	183947 L
10	30	10	36	75	2	negative	183948 L
12	42	12	40	90	3	positive	183949 L
[mm]	[mm]	[mm]	[mm]	[mm]			

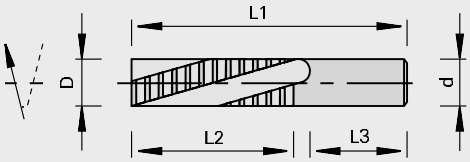
129450

Roughing Cutters VHW - negative spiral

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- CNC routers
- for rough cutting in solid woods, plywood and uncoated panels
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- negative spiral for smaller workpieces hard to clamp with face side up
- n max = 30,000 min-1

Advantages

- high hogging volume
- cutting pressure towards the bottom thanks to negative spiral

Notes

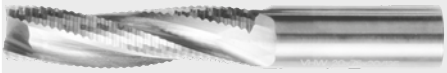
- slightly rough cutting surface due to fine cut division
- clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	30	10	40	75	2	178300 L
12	42	12	45	90	3	178304 L
14	35	14	45	90	3	178306 C
16	35	16	48	90	3	178311 L
16	55	16	48	110	3	178312 L
18	55	18	48	115	3	178317 C
20	55	20	50	115	3	178320 L
20	75	20	50	135	3	178323 C
[mm]	[mm]	[mm]	[mm]	[mm]		

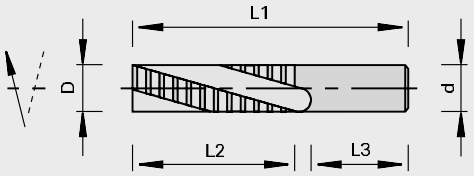
129450

Roughing Cutters VHW - positive spiral

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- CNC routers
- for rough cutting in solid woods, plywood and uncoated panels
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- positive spiral for tightly clamped workpieces face side down
- n max = 30,000 min-1

Advantages

- high hogging volume
- optimum upward chip evacuation thanks to positive spiral

Notes

- slightly rough cutting surface due to fine cut division
- clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

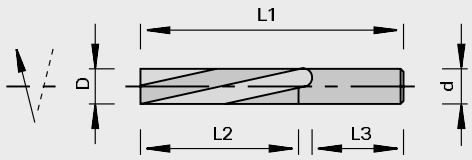
Ø D	L2	Ø d	L3	L1	Z		Ident-No.
10	30	10	40	75	2		178301 L
12	45	12	45	90	2		178302 L
12	45	12	45	90	3		178303 L
14	35	14	45	90	3		178305 L
14	55	14	45	110	3		178307 L
16	35	16	48	90	2		178309 L
16	35	16	48	90	3		178310 L
16	55	16	48	110	2		178313 L
16	55	16	48	110	3		178314 L
18	55	18	48	115	2		178315 C
18	55	18	48	115	3		178316 L
20	55	20	50	115	2		178318 L
20	55	20	50	115	3		178319 L
20	75	20	50	135	2		178321 C
20	75	20	50	135	3		178322 L
20	110	20	48	170	3	variable pitch	185458 L
25	55	25	50	115	4		178324 L
[mm]	[mm]	[mm]	[mm]	[mm]			

129450

Finishing Cutters VHW - negative spiral

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- CNC routers
- for finish cutting in solid woods and plastic
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- negative spiral for smaller workpieces hard to clamp with face side up
- n max = 30,000 min-1

Advantages

- cutting pressure and chip evacuation towards the bottom thanks to negative spiral

Notes

- clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
4.0	15	4,0	28	60	2		178326 L
6.0	15	6,0	36	60	2		178327 L
8.0	30	8,0	36	75	2		178330 L
10	30	10	40	75	2		178332 L
12	42	12	45	90	2		178335 L
12	42	12	45	90	3		178336 L
14	35	14	45	90	2		178338 C
16	35	16	48	90	2		178342 L
16	35	16	48	90	3		178343 L
16	55	16	48	110	3	178349 C	178347 L
20	55	20	50	115	3		178354 C
20	75	20	50	135	3		178356 L
[mm]	[mm]	[mm]	[mm]	[mm]			

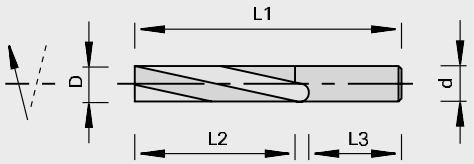
129450

Finishing Cutters VHW - positive spiral

Product



Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application

- CNC routers
- for finish cutting in solid woods and plastic
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- positive spiral for tightly clamped workpieces face side down
- n max = 30,000 min-1

Advantages

- optimal upward chip evacuation thanks to positive spiral

Notes

- clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

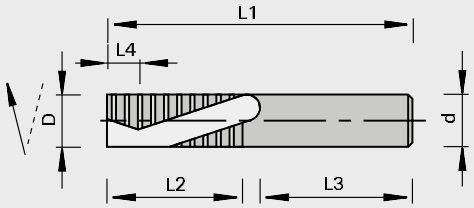
Ø D	L2	Ø d	L3	L1	Z		Ident-No. [L]	Ident-No. [R]
6.0	15	6,0	36	60	2			178328 L
8.0	30	8,0	36	75	2			178329 L
10	30	10	40	75	2			178331 L
12	42	12	45	90	2			178333 L
12	42	12	45	90	3			178334 L
14	35	14	45	90	3			178337 L
14	55	14	45	110	3			178339 L
16	35	16	48	90	2			178340 C
16	35	16	48	90	3			178341 L
16	55	16	48	110	2			178344 L
16	55	16	48	110	3		178348 L	178345 L
18	55	18	48	115	2			178350 C
18	55	18	48	115	3			178351 L
20	55	20	50	115	2			178352 C
20	55	20	50	115	3			178353 L
20	75	20	50	135	3			178355 L
20	110	20	48	170	3	variable pitch		185715 L
[mm]	[mm]	[mm]	[mm]	[mm]				

129450

Roughing Cutters VHW - positive/negative spiral with shear angle

Product

Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application
- CNC routers
- for rough cutting of solid wood and plastics
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design
- two-sided shear angle
- n max = 30,000 min-1

Advantages
- optimum cutting quality in laminated panels thanks to shear angle

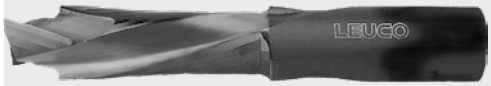
Notes
- clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
20	17	55	20	50	115	2+2	185838 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

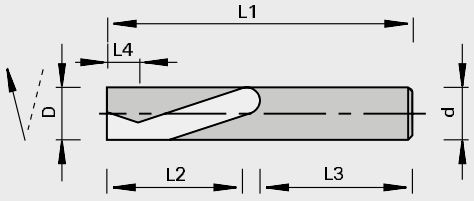
129450

Finishing Cutters VHW - positive/negative spiral with shear angle

Product



Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application
- CNC routers
- for finish cutting in solid woods and plastic
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design
- two-sided shear angle
- n max = 30,000 min-1

Advantages
- optimum cutting quality in laminated panels thanks to shear angle

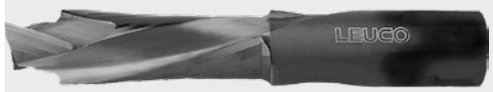
Notes
- clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L4	L2	Ø d	L1	Z	Ident-No.
8.0	7.0	32	8,0	80	2+2	180870 L
10	7.0	32	10	80	2+2	180871 L
12	7.0	42	12	90	2+2	180872 L
16	24	55	16	110	2+2	180873 L
18	30	55	18	110	2+2	180874 L
[mm]	[mm]	[mm]	[mm]	[mm]		

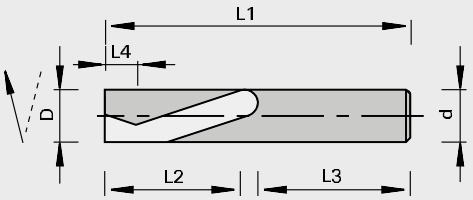
129450

Finishing Cutters VHW - magnet bond boards

Product



Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application

- CNC routers
- specific for sizing and jointing magnet bond boards

Design

- with shear angle on both sides
- special tungsten carbide

Advantages

- high cutting quality thanks to shear angle
- tungsten carbide with better wear resistance for longer edge life compared to conventional VHW shank-type cutters

Notes

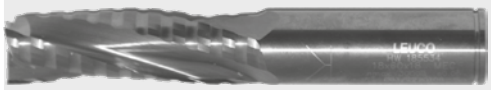
- clamping elements: ps-System with reducing bushing Class-No. 933280, TRIBOS
- recommended application parameters:
- feed (Vf) approx. 1 - 1,5 m/ min
- RPM (N) approx. 3,000 - 4,500
- use with feed
- oscillating milling allows longer edge life

Ø D	L4	L2	Ø d	L1	Z	Ident-No.
12	7	36	12	90	2+2	186242 L
18	7	36	18	90	2+2	186243 L
[mm]	[mm]	[mm]	[mm]	[mm]		

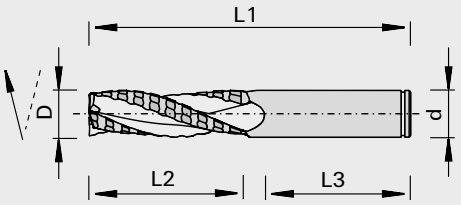
129450

Roughing / Finishing Cutter VHW “NF”

Product



Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application

- CNC routers
- for sizing and grooving particularly in soft and hard woods, glued woods, Multiplex, plywood and many wood-based panels
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- NF serration
- Z=3 for high cutting performance
- positive spiral for tightly clamped workpieces face side down
- negative spiral for workpiece support with face side up
- n max = 30,000 min-1

Advantages

- cutting surfaces almost in finishing quality
- reduced effort thanks to division of cut
- smooth running

Notes

- clamping elements:we recommend hydro expansion chuck ps-System, TRIBOS or heat shrink-fit chuck

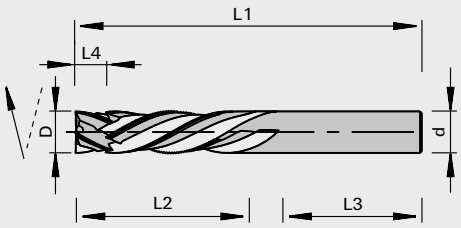
Ø D	L2	Ø d	L3	L1	Z	Helical direction	Ident-No. [L]	Ident-No. [R]
12	35	12	40	80	3	positive		185527 L
12	35	12	40	100	3	negative	185529 L	185528 L
12	42	12	45	90	3	positive		185530 L
14	42	14	50	100	3	positive		185531 L
16	52	16	55	110	3	positive	185533 L	185532 L
18	60	18	55	115	3	positive		185534 L
20	60	20	55	120	3	positive	185536 L	185535 L
20	75	20	50	130	3	positive	185538 L	185537 L
[mm]	[mm]	[mm]	[mm]	[mm]				

129450

Roughing / Finishing Cutter VHW for lightweight panels

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- CNC routers
- for sizing and grooving
- for milling of openings and contours
- particularly in many lightweight construction materials, e.g. honeycomb panels, plywood, composite panels with hard foam core
- for plunge cutting with feed in the direction of the Z, X or Y axis

Design

- special serration of the roughing knives
- alternating shear angle
- special tungsten carbide
- n max=24,000 min-1

Advantages

- high cutting quality thanks to shear angle and finishing cutting edges
- reduced effort thanks to division of cut and roughing design
- smooth running
- Longer edge lives

Notes

- clamping elements:we recommend hydro expansion chuck ps-System, TRIBOS or heat shrink-fit chuck

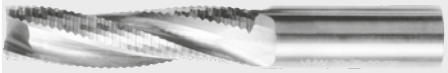
Ø D	L4	L2	Ø d	L3	L1	Z		Ident-No.
12	9	20	12	45	86	2+2	R	187301 L
12	9	40	12	40	100	2+2	R	187302 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Ø D	L4	L2	Ø d	L3	L1	Z		Ident-No.
12	7	20	12	40	86	2+2	R	187850 L
12	7	20	12	40	86	2+2	L	187852 L
12	7	40	12	45	100	2+2	R	187857 L
12	7	40	12	45	100	2+2	L	187859 L
20	7	32	20	55	110	3+3	R	187860 L
20	7	32	20	55	110	3+3	L	187862 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

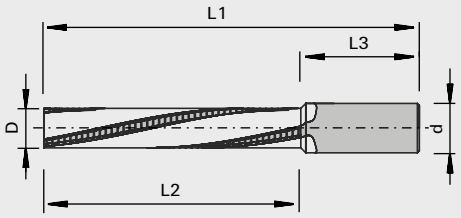
129450

Roughing Cutters VHW - joinery machines

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- Joinery machines
- Portal processing systems
- for separating, sizing, grooving. drilling and milling of soft and hard wool, glued laminated timber, gluelam construction timber and solid wood boards

Design

- Roughing cutters VHW for long edge life
- Shaft for shrinking or stepped shaft for collet chuck ER 40 (Hundegger shaft)
- Central cutting edge

Advantages

- positive spiral direction for improved chip evacuation
- Roughing tool for larger chip versions

Notes

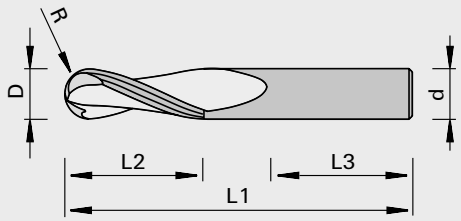
Ø D	L2	Ø d	L3	L1	Z			Ident-No.
20	75	20	55	130	3		R	80484531 C
20	135	20	55	190	3		R	80484532 C
20	175	20	45.8	230	3		R	80484518 C
20	130	25	60	190	3		R	80484522 C
20	130	25	57.5	190	3		R	80484523 C
25	55	25	60	115	3		R	80484530 C
25	55	25	53	115	3	Hundegger shaft	R	80484533 C
25	145	25	60	210	3		R	80452219 C
25	170	25	60	230	3		R	80484519 C
25	190	25	60	250	3		R	80484520 C
30	120	30	53	195	3	Hundegger shaft	R	80484529 C
30	125	30	53.5	195	3	Hundegger shaft	R	80371692 C
30	125	30	53.5	195	3	Hundegger shaft	L	80371693 C
30	180	30	60	250	3		R	80484521 C
40	120	30	60	190	3		R	80484524 C
40	120	30	53	195	3	Hundegger shaft	R	80484528 C
40	160	30	53	235	3	Hundegger shaft	R	80484527 C
40	170	30	60	250	3		R	80484525 C
40	180	30	60	250	3		R	80484526 C
[mm]	[mm]	[mm]	[mm]	[mm]				

129650

Radius Shank-Type Cutter VHW

Product

Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application

- CNC routers
- for grooving, contour milling and template copying
- for milling of contours, surface profiles, string wreaths, and other relief profile milling work
- traveling plunge cut using Z and X or Y axis

Design

- positive spiral
- face-ground
- solid tungsten carbide (VHW)
- right-hand cutting
- no. of cutting edges Z=2 resp. Z=3

Advantages

- long edge lives thanks to high-quality micrograin carbide

Notes

- clamping elements: we recommend hydro expansion chuck ps-System, TRIBOS or heat shrink-fit chuck

Ø D	L2	Ø d	L1	Z	R	Ident-No.
3.0	12	3,0	50	2	1,5	185208 C
4.0	15	4,0	50	2	2,0	185209 L
5.0	17	5,0	50	2	2,5	185210 C
6.0	22	6,0	60	2	3,0	185211 L
8.0	22	8,0	70	2	4,0	185212 L
10	32	10	70	2	5,0	185213 L
10	42	10	100	2	5,0	185214 C
12	32	12	80	2	6,0	185215 L
12	42	12	100	2	6,0	185216 C
14	42	14	100	2	7,0	185217 C
16	42	16	100	2	8,0	185218 L
16	52	16	100	2	8,0	185219 C
18	52	18	100	2	9,0	185220 C
20	52	20	100	2	10	185221 L
20	72	20	130	2	10	185222 C
[mm]	[mm]	[mm]	[mm]		[mm]	

Ø D	L2	Ø d	L1	Z	R	Ident-No.
8.0	22	8,0	70	3	4,0	185223 C
10	32	10	70	3	5,0	185224 C
10	42	10	100	3	5,0	185225 C
12	32	12	80	3	6,0	185226 C
12	42	12	100	3	6,0	185227 C
14	42	14	100	3	7,0	185228 C
16	42	16	100	3	8,0	185229 C
16	52	16	100	3	8,0	185230 C
18	52	18	100	3	9,0	185231 C
20	52	20	100	3	10	185232 C
20	72	20	130	3	10	185233 C
[mm]	[mm]	[mm]	[mm]		[mm]	

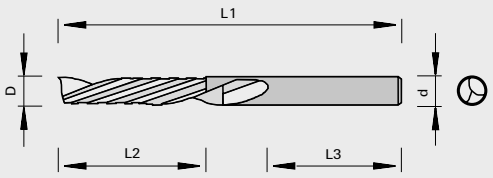
129454

High-Performance Shank-Type Cutters with solid carbide body for the machining of plastic - Z1

Product



Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application
- CNC routers
- for jointing, rabbeting and grooving in plastics
- traveling plunge cut using Z and X or Y axis

Design
- positive spiral
- high-polish spiral grooves
- wear-resistant micrograin carbide HL Board 10

Advantages
- optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral

Notes
- negative spiral on request
- clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L2	Ø d	L1	Z	Helical direction	Ident-No.
3.0	12	3,0	50	1	positive	184715 L
4.0	15	4,0	50	1	positive	184716 L
5.0	17	5,0	50	1	positive	184717 L
6.0	22	6,0	60	1	positive	184718 L
8.0	22	8,0	70	1	positive	184719 L
8.0	32	8,0	70	1	positive	184720 L
10	32	10	70	1	positive	184721 L
12	32	12	80	1	positive	184722 L
[mm]	[mm]	[mm]	[mm]			

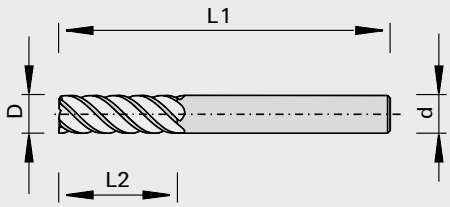
129454

Polishing Shank-Type Cutter VHW for acrylic glass and PMMA - Z5

Product



Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application
- CNC routers
- for finishing of acrylics and PMMA with relatively clear surfaces
- attention: these tools are not suitable for sizing or dividing but only for polishing!

Design
- positive spiral
- high-quality solid tungsten carbide (VHW) with 5 cutting edges

Advantages
- reduced production times as postprocessing is no longer necessary
- produces relatively clear surfaces which are sufficient in many cases

Notes
- finish milling (removal of 0.05 - 0.1 mm) at a feedrate of approx. 0.5 – 1 m/min
- high RPM is recommended (18,000 - 24,000 min-1 or higher)
- application against feed
- the good quality can only be reached in connection with a precision clamping element

Ø D	L2	Ø d	L1	Z	Helical direction	Ident-No.
6.0	22	6,0	60	5	positive	184704 L
8.0	25	8,0	70	5	positive	184705 L
[mm]	[mm]	[mm]	[mm]			

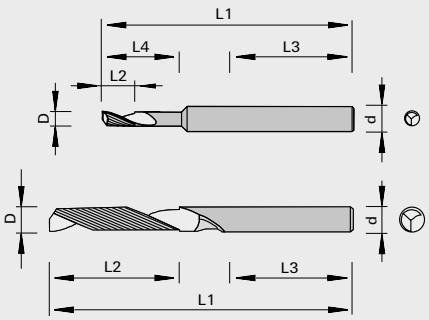
129454

High-Performance Shank-Type Cutters with solid carbide body for the machining of aluminum - Z1

Product



Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application
- CNC routers
- for jointing, rabbeting and grooving in aluminum alloys, copper alloys and NF metals
- traveling plunge cut using Z and X or Y axis

Design
- positive spiral
- polished chip gullets

Advantages
- optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral

Notes
- negative spiral on request
- clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L2	L4	Ø d	L3	L1	Z	Helical direction	Ident-No.
3.0	10	25	8,0	55	80	1	positive	184709 L
4.0	10	25	8,0	55	80	1	positive	184710 L
5.0	10	25	8,0	55	80	1	positive	184711 L
6.0	10	25	8,0	55	80	1	positive	184712 L
8.0	20	25	8,0	55	80	1	positive	80473248 L
8.0	25	50	8,0	45	100	1	positive	184713 L
10	25	35	10	60	100	1	positive	184714 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

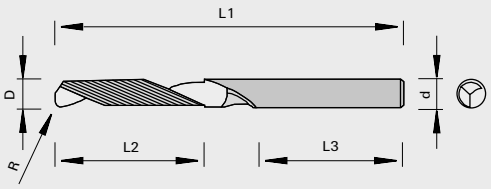
129454

High-Performance Shank-Type Cutters with solid carbide body for the machining of aluminum - Z1 with radius

Product



Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application
- CNC routers
- for jointing, rabbeting and grooving in aluminum alloys, copper alloys and NF metals
- especially for grooving in aluminum
- traveling plunge cut using Z and X or Y axis

Design
- positive spiral
- polished chip gullets

Advantages
- especially for aluminum with high silicium rate
- optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral
- reduced cutting pressure thanks to radius

Notes
- negative spiral or reinforced shank diameter on request
- clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Helical direction	R	Ident-No.
5.0	20	6,0	40	70	1	positive	1,0	183972 C
6.0	20	8,0	45	80	1	positive	1,5	183973 C
8.0	22	10	45	90	1	positive	1,5	183974 C
10	25	10	50	100	1	positive	2,0	183975 C
12	30	12	60	120	1	positive	2,5	183976 C
[mm]	[mm]	[mm]	[mm]	[mm]			[mm]	

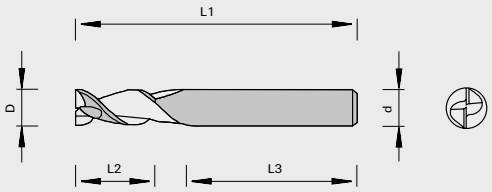
129454

High-Performance Shank-Type Cutters with solid carbide body for the machining of aluminum - Z2

Product



Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application

- CNC routers
- for jointing, rabbeting and grooving in aluminum alloys, copper alloys and NF metals
- traveling plunge cut using Z and X or Y axis

Design

- positive spiral
- polished chip gullets
- spiral angle 45°
- special grinding

Advantages

- optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral

Notes

- negative spiral or reinforced shank diameter on request
- clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Helical direction	Ident-No.
3.0	8,0	6,0	36	57	2	positive	183977 C
4.0	11	6,0	36	57	2	positive	183978 C
5.0	13	6,0	36	57	2	positive	183979 C
6.0	13	6,0	36	57	2	positive	183980 C
8.0	19	8,0	36	63	2	positive	183981 O
10	22	10	40	72	2	positive	183982 C
12	26	12	45	83	2	positive	183983 C
16	32	16	48	92	2	positive	183984 C
20	38	20	50	104	2	positive	183985 C
[mm]	[mm]	[mm]	[mm]	[mm]			

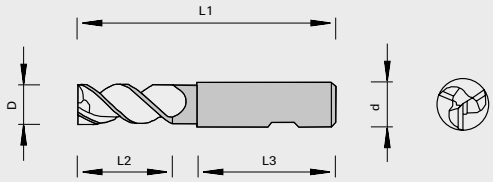
129454

High-Performance Shank-Type Cutters with solid carbide body for the machining of aluminum - Z3

Product



Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application
- CNC routers
- for jointing, rabbeting and grooving in aluminum alloys, copper alloys and NF metals
- traveling plunge cut using Z and X or Y axis

Design
- positive spiral
- polished chip gullets
- cutting edges with variable pitch
- spiral angle 42° - 43°
- special grinding

Advantages
- optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral
- smooth and low-noise running thanks to variable pitch

Notes
- negative spiral or reinforced shank diameter on request
- clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Helical direction	Ident-No.
3.0	8,0	6,0	45	57	3	positive	183986 C
4.0	11	6,0	39	57	3	positive	183987 C
5.0	13	6,0	39	57	3	positive	183988 C
6.0	13	6,0	39	57	3	positive	183989 C
8.0	21	8,0	38	63	3	positive	183990 C
10	22	10	42	72	3	positive	183991 C
12	26	12	47	83	3	positive	183992 C
16	36	16	50	92	3	positive	183993 C
20	41	20	52	104	3	positive	183994 C
[mm]	[mm]	[mm]	[mm]	[mm]			

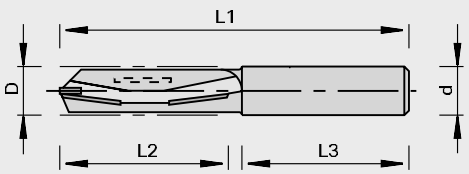
129860

Router Bits for Sash Openings HW-tipped with shear angle

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application
- stationary routers
- CNC routers
- for cutting of cut-outs in doors, countertops and furniture parts in hard and exotic woods and wood-based panels

Design
- with shear angle
- n max = 16.000 min-1

Advantages
- optimum cutting quality on veneered and plastic laminated parts

Notes
- face cutting design allows plunge-cuts
- clamping elements: draw-in collet chuck, centric clamping chuck

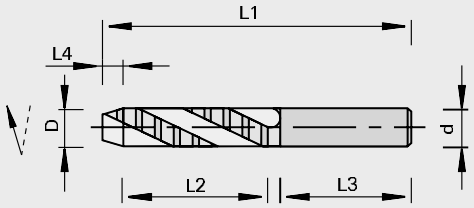
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
14	50	14	48	100	1+1+1	167662 C
[mm]	[mm]	[mm]	[mm]	[mm]		

129450

Roughing Plunge Cutters VHW - door manufacturing

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application
- CNC machining centers
- for drilling of latchholes and keyholes

Design
- positive spiral
- n max = 30,000 min-1

Advantages

Notes
- clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
16	5.0	75	16	48	130	2	185831 L
20	5.0	75	20	50	135	3	185832 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

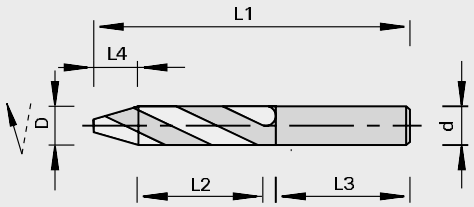
129450

Finishing Plunge Cutters VHW - door manufacturing

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application
- CNC machining centers
- for drilling of peepholes and for through holes

Design
- positive spiral
- n max = 30,000 min-1

Advantages

Notes
- clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

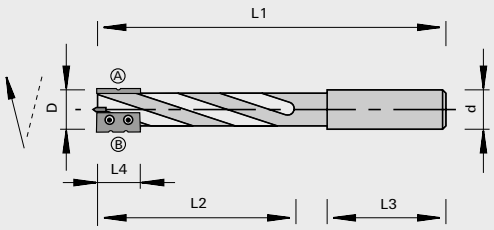
Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
12	10	47	12	53	110	2	185826 L
12	10	70	12	50	130	2	185828 L
14	10	47	14	45	110	2	185829 L
16	11	52	16	60	130	2	185830 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

129410

Lock-Case Cutters with HW Knives - door manufacturing

Product

Drawing

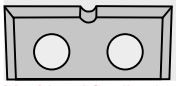


LEUCO DUR

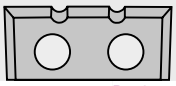
Tungsten Carbide [HW]

MEC

A



B



Machine / Application

- CNC machining centers
- for cutting of lock-cases and face-plates in doors

Design

- Positive spiral
- High-strength carrier material (heavy metal)
- With HW-tipped (soldered) plunge tip
- Tipped with 2 knives with chip breaker, one in form A and one in form B
- n max=18,000 min-1

Advantages

- optimum chip evacuation thanks to positive spiral
- high balance quality thanks to cutting edges with chip breakers
- constant diameter thanks to exchangeable knives

Notes

- clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck
- for attachment in horizontal boring-cutting aggregat (Homag, Weeke) side clamping surfaces are necessary (see Technical Information)

Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
16	16	105	16	55	170	2	183750 C
16	16	105	20	55	170	2	183751 C
18	16	105	20	55	170	2	183752 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Type	Class-No.	PU	Ident-No.
	16	7.0	1.5	A	150525	10	183753 L
	16	7.0	1.5	B	150525	10	183754 L
	[mm]	[mm]	[mm]			[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M3x4 T9	995195	10	180449 L
Screwdrivers	T9x60	985730	1	173796 L
	[mm]		[pc.]	

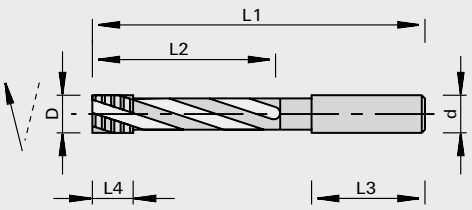
129450

Lock-Case Roughing Cutters VHW - door manufacturing

Product



Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application
- CNC machining centers
- for cutting of lock-cases in doors

Design
- positive spiral
- roughing design

Advantages
- optimum chip evacuation thanks to positive spiral
- high smoothness of running

Notes
- clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck
- for attachment in horizontal boring-cutting aggregate (Homag, Weeke) side clamping surfaces are necessary (see Technical Information)

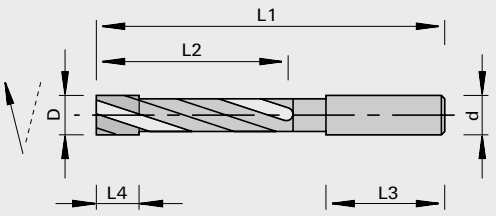
Ø D	L4	L2	Ø d	L3	L1	Z	nmax	Ident-No.
14	25	95	14	50	155	3	24000	185835 L
16	25	115	16	50	175	3	24000	185836 L
18	25	115	20	50	175	3	24000	185837 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

129450

Lock-Case Finishing Cutters VHW - door manufacturing

Product

Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application
- CNC machining centers
- for cutting of lock-cases and face-plates in doors

Design
- positive spiral
- finishing design

Advantages
- optimum chip evacuation thanks to positive spiral
- high smoothness of running

Notes
- clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck
- for attachment in horizontal boring-cutting aggregate (Homag, Weeke) side clamping surfaces are necessary (see Technical Information)

Ø D	L4	L2	Ø d	L3	L1	Z	nmax	Ident-No.
14	25	95	14	50	155	2	24000	185833 L
16	25	115	16	50	175	2	24000	185834 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

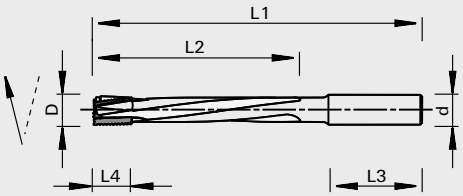
129450

Lock-Case Roughing Cutters VHW - negative spiral - door manufacturing

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- High-performance door machining systems
- CNC machining centers
- Machines with lock-case units
- For cutting lock-cases in doors

Design

- Negative spiral
- Fine roughing design
- High-quality cutting material

Advantages

- Very smooth running and therefore very gentle on the milling units
- Lowest load even when changing the milling direction
- Longer edge lives

Notes

- Recommended for use in hydraulic expansion chucks or heat-shrinking chucks
- For mounting in horizontal drilling-milling aggregate (Homag, Weeke), lateral clamping surfaces are required (see Technical Information)

Ø D	L4	L2	Ø d	L3	L1	Z	nmax	Ident-No. [L]
16	25	115	16	50	175	3	24000	186763 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

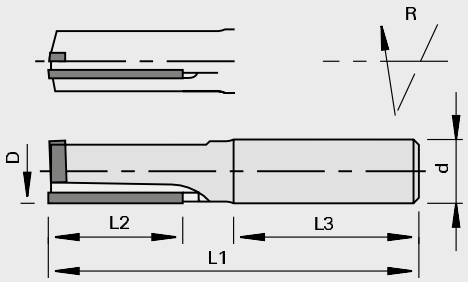
229222

DIAMAX Shank-Type Cutters DP

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for jointing and sizing without overlap marks in wood-based panels, solid woods and plastics

Design

- Polished face and high-finish clearance angle
- With HW plunge tip for diagonal plunge-cutting (simultaneous feed using Z and X axis)
- Ø 10 mm with plunge tip integrated in VHW body, all other diameters with brazed HW plunge tip
- Straight cutter axis
- Solid tungsten carbide body for Ø 5 mm to Ø 10 mm

Advantages

- high quality machining of MDF and hard woods
- no overlap-marks thanks to continuous cutting edge
- increased stability thanks to special design of brazing area

Notes

- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- Ø D=12 and 16 mm with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	nmax	Resharpening area	Ident-No. [L]	Ident-No. [R]
5.0	12	12	40	60	1	24000	0.2		183566 L
6.0	12	12	40	60	1	24000	0.2		183567 L
8.0	12	12	35	60	1	24000	0.5		178659 L
8.0	12	12	40	60	2	24000	0.5		183568 L
8.0	22	12	35	70	2	24000	0.5		187724 L
10	22	12	35	70	2	24000	1.2	186785 L	186784 L
12	25.4	12	35	70	1	24000	1.2		181102 L
16	25.4	16	45	85	1	24000	1.2		181104 L
16	35	16	45	95	1	24000	1.2		181106 L
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[mm]		

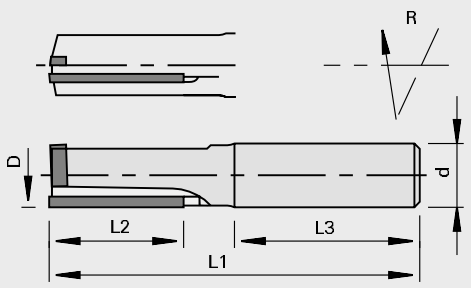
229222

DIAMAX Shank-Type Cutters DP - Z=1

Product



Drawing



LEUCO topline

DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for jointing without overlap marks in solid woods and wood-based panels
- not suitable for dividing and deep grooves
- for light millwork only

Design

- polished face and high-finish clearance angle
- with HW plunge tip for diagonal plunge-cutting (travelling plunge-cut using Z and X axis)
- straight cutter axis
- resharpening area 0.8 mm

Advantages

- high quality machining of MDF and hard woods
- no overlap-marks thanks to continuous cutting edge

Notes

- Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	nmax	Ident-No. [R]
8.0	22	8	35	65	1+1	24000	187842 L
8.0	22	12	35	65	1+1	24000	182664 L
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

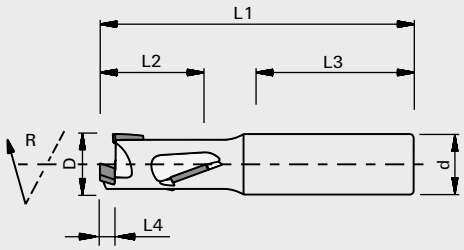
229222

DIAMAX Shank-Type Cutters DP - Z=1+1

Product



Drawing



LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for jointing, rabbeting, grooving and copying in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- with DP plunge tip for diagonal plunge-cutting
- with shear angle
- resharpenable several times
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to larger shear angle, alternating top and bottom
- smooth running thanks to special tool body
- Chip-free grooving possible from groove depths of 4.5 mm

Notes

- Feed rates up to 8 m/min
- Recommended clamping elements: ps-System, TRIBOS, heat-shrinking chuck
- Tools with Ø d = 12, 16 and 20 mm without thread and Ø d = 25 mm with thread for length adjusting screw

Ø D	L2	L4	Ø d	L3	L1	Z	Resharpening area	Ident-No. [L]	Ident-No. [R]
8	22	4.1	12	40	69	1+1	0.6		186994 L
8.5	15	4.1	12	40	65	1+1	0.6		187249 L
10	22	4.1	12	40	69	1+1	0.6		186789 L
10	32	4.1	12	40	79	1+1	0.6		186995 L
16	28	4.1	16	45	83	1+1	1.0		186795 L
12	22	4.1	12	40	69	1+1	0.8		186790 L
12	28	4.1	12	40	75	1+1	0.8	186793 L	186792 L
12	28	8.7	25	55	95	1+1	0.8		187166 L
16	22	4.1	16	45	78	1+1	1.0		186794 L
16	35	4.1	16	45	90	1+1	1.0	186797 L	186796 L
16	35	12.6	16	45	90	1+1	1.0		187167 L
18	28	4.1	16	45	85	1+1	1.0		186798 L
18	28	4.1	20	45	95	1+1	1.0	186799 L	186800 L
18	35	4.1	16	45	92	1+1	1.0	186801 L	186802 L
18	35	4.1	20	55	102	1+1	1.0	186804 L	186803 L
18	43	4.1	16	45	100	1+1	1.0	186806 L	186805 L
18	43	12.6	20	55	110	1+1	1.0		187168 L
18	43	4.1	20	55	110	1+1	1.0	186808 L	186807 L
18	43	4.1	25	55	110	1+1	1.0	186913 L	186912 L
20	35	4.1	20	55	102	1+1	1.0		186809 L
20	52	4.1	25	55	120	1+1	1.0	186811 L	186810 L
20	52	12.3	25	55	120	1+1	1.0		187169 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Ø D	L2	L4	Ø d	L3	L1	Z	Resharpening area	Ident-No.
1/2″	1″	4.1	1/2″	1 3/8″	2 2/3	1+1	1.0	186791 L
[inch]	[inch]	[mm]	[inch]	[inch]	[inch]		[mm]	

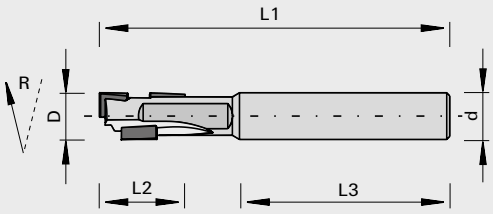
229040

Grooving Shank-Type Cutters DP

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- especially for grooving but also for jointing, and dividing in raw and laminated panels as well as for example in glued veneered woods (Multiplex)

Design

- extremely rigid VHW tool body
- with alternating shear angle
- with DP plunge tip
- polished face
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to shear angle, alternating top and bottom
- smooth running thanks to special cutting edge configuration
- very long edge lives, less cutting forces and less noise thanks to optimized tool body
- clean ground of groove

Notes

- clamping elements: hydro expansion chuck ps-System or TRIBOS with precision reducing sleeves Ident-No. 183032 or 182305 or with heat shrink-fit chuck Ident-No. 80362923

Ø D	L2	Ø d	L3	L1	Z		Ident-No.
8.0	14	8,0	36	60	1+1	R	185734 L
[mm]	[mm]	[mm]	[mm]	[mm]			

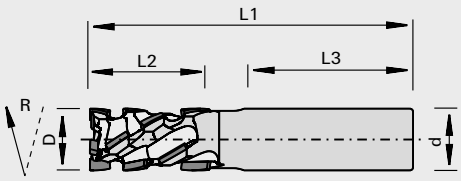
229122

DIAREX High-Performance Shank-Type Cutters DP - Z=2+2

Product



Drawing



LEUCO DIAREX

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for jointing, rabbeting, grooving and copying in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- with DP plunge tip for diagonal plunge-cutting
- with shear angle
- resharpening area 1.2 mm
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to shear angle, alternating top and bottom
- smooth running thanks to 4-wing design of cutting edges
- very long edge lives, less cutting forces and less noise thanks to optimized tool body

Notes

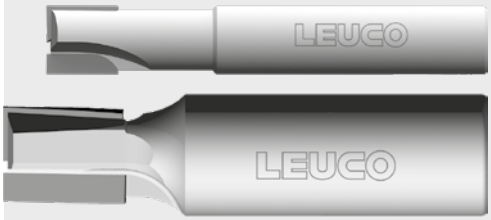
- feed rates up to 20 m/min
- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
16	28	16	45	80	2+2		186147 L
16	38	16	45	90	2+2	186149 L	186148 L
20	28	20	55	95	2+2		186150 L
20	28	25	55	95	2+2	186152 L	186151 L
20	38	20	55	105	2+2		186153 L
20	38	25	55	105	2+2	186155 L	186154 L
20	48	20	55	115	2+2		186156 L
20	48	25	55	115	2+2	186158 L	186157 L
25	65	25	55	130	2+2	186160 L	186159 L
[mm]	[mm]	[mm]	[mm]	[mm]			

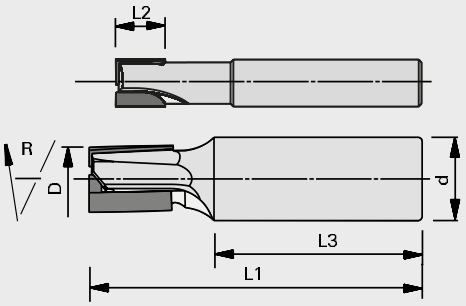
229342

High-Performance Shank-Type Cutters DP - for the machining of solid core panels

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for jointing and sizing without overlap marks in solid woods and wood-based panels
- especially suited for the machining of plastic solid core panels (e.g. Trespa®, Corian®, Varicor®, LG-HiMacs, etc.)

Design

- high-performance tool for pre- and finish-milling
- Ø D = 8 mm - Ø D = 10 mm solid carbide design of tool body
- Ø D > 10 mm tool body made from steel
- with face shear angles
- with DP plunging tip
- face cutting for diagonal plunge-cutting
- polished face
- n max = 24.000 min-1

Advantages

Notes

- Clamping elements: ps-System, TRIBOS, draw-in collet chuck, heat-shrinking chuck
- Ø D > 10 mm with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Resharpening area		Ident-No.
8	10	10	40	65	1+1	0.5	R	187261 L
10	10	10	40	65	1+1	0.6	R	187262 L
12	15	16	45	75	2+1	1.0	R	186436 L
12	15	16	45	75	3+1	1.0	R	186305 L
12	22	16	45	75	2+1	1.0	R	186437 L
14	28	16	45	80	2+1	1.5	R	186438 L
16	20	20	50	80	2+1	2.8	R	186439 L
16	20	20	50	80	3+1	1.6	R	186431 L
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

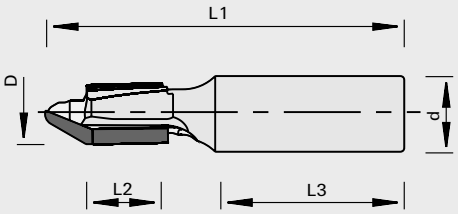
229322

Multi-purpose shank-type cutting jointer DP - for solid core panel machining

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application
- CNC routers
- for jointing without overlap marks, sizing and milling of cutouts in plastic solid core panels (e.g. Trespa®, Corian®, Varicor®, LG-HiMacs, etc.) and fiber cement boards

Design
- special PCD type in topline design
- with alternating shear angle and DP plunge tip

Advantages
- flexible multi-function tool
- vertical boring and through-drilling
- milling of any hole diameters >Ø16 mm and cutouts
- profile grooves 60° with R=3 mm
- Chamfering of edges 30°
- only 1 tool change location required

Notes
- Clamping elements: ps-System, TRIBOS, heat-shrinking chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	20	20	48	95	2+1	187373 L
[mm]	[mm]	[mm]	[mm]	[mm]		

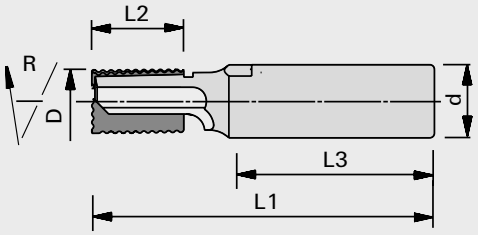
229021

High-Performance Roughing Shank-Type Cutters DP - for the machining of solid core panels

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application
- CNC routers
- for pre-sizing in roughing quality in wood-based panels, solid wood and plastic
- especially suited for the machining of plastic solid core panels (e.g. Trespa®, Corian®, Varicor®, LG-HiMacs, etc.)

Design
- high-performance tool for rough and finish milling
- with alternating shear angle
- with DP plunge tip
- face cutting for diagonal plunge-cutting
- n max = 24,000 min-1

Advantages

Notes
- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Resharpening area		Ident-No.
14	20	16	45	75	2+1	1.5	R	186579 L
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

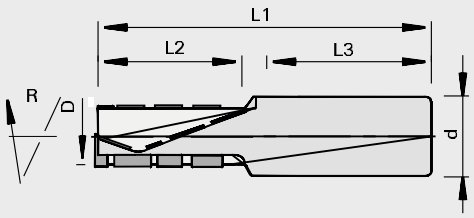
229022

High-Performance Shank-Type Cutters DP - Z=2+1+2

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- high-performance tool for rough and finish milling
- Z=1 in middle layer and Z=2 in covering layer
- face cutting for diagonal plunge-cutting
- with shear angle
- resharpening area 3.0 mm
- n max = 24,000 min-1

Advantages

- good cutting quality on top and bottom edge thanks to opposing shear angle
- reduced vibrations thanks to variable pitch
- optimum good chip disposal thanks to open arrangement of cutting edges

Notes

- feed speed up to 20 m/min when jointing
- feed speed up to 12 m/min when sizing
- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	H	Ident-No. [L]	Ident-No. [R]
20	28	25	60	100	2+1+2	12-25		181481 C
25	35	25	60	110	2+1+2	18-32		181483 C
25	42	25	60	120	2+1+2	25-40		181485 C
25	48	25	62	120	2+1+2	32-45	181486 C	181487 C
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

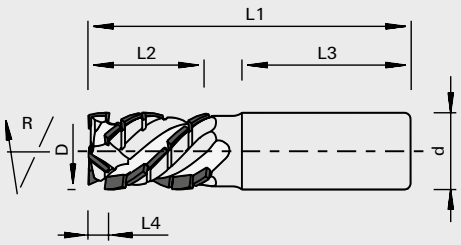
229322

High-Performance Shank-Type Cutters DP - Z=3+3

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels
- high-performance tool for pre- and finish-milling

Design

- with DP plunge tip for diagonal plunge-cutting
- with shear angle
- resharpening area 3.0 mm
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to shear angle, alternating top and bottom
- smooth running thanks to spiral cut configuration

Notes

- feed rates up to 30 m/min
- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with thread for length adjusting screw

Ø D	L2	L4	Ø d	L3	L1	Z		Ident-No.
18	28	7	25	55	95	3+3	L	186665 C
18	28	7	25	55	95	3+3	R	186118 L
20	38	7	20	55	105	3+3	L	186666 C
20	38	7	20	55	105	3+3	R	186119 L
25	28	7	25	55	95	3+3	L	186121 L
25	28	7	25	55	95	3+3	R	186120 L
25	38	7	25	55	105	3+3	L	186123 L
25	38	7	25	55	105	3+3	R	186122 L
25	48	7	25	55	115	3+3	L	186125 L
25	48	7	25	55	115	3+3	R	186124 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

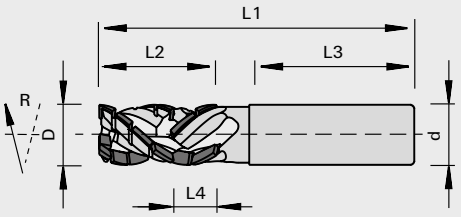
229322

High-Performance Shank-Type Cutters CM DP - Z=3+3

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels
- high-performance tool for rough and finish milling

Design

- with DP plunge tip for diagonal plunge-cutting
- with shear angle
- resharpening area approx. 3 mm
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to shear angle, alternating top and bottom
- smooth running thanks to spiral cut configuration
- optimum chip removal thanks to topward spiral and ChipMeister version

Notes

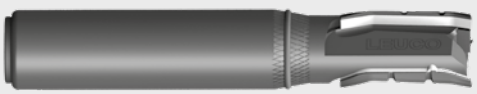
- feed rates up to 30 m/min
- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with thread for length adjusting screw

Ø D	L2	L4	Ø d	L3	L1	Z		Ident-No.
20	28	12	25	55	95	3+3	L	186127 L
20	28	12	25	55	95	3+3	R	186126 L
25	28	12	25	55	95	3+3	R	186130 L
20	38	15	20	55	105	3+3	L	186129 L
20	38	15	20	55	105	3+3	R	186128 L
25	38	15	25	55	105	3+3	L	186132 C
25	38	15	25	55	105	3+3	R	186131 L
25	52	16.5	25	55	120	3+3	L	186134 L
25	52	16.5	25	55	120	3+3	R	186133 L
25	65	18	25	55	133	3+3	L	186136 C
25	65	18	25	55	133	3+3	R	186135 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

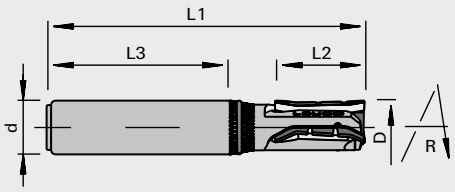
229542

DIACURVE Shank-Type Cutters DP Nesting

Product



Drawing



LEUCO diacurve

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for panel sizing with Nesting Technology
- processing of raw and laminated wood-based materials

Design

- unique cutting edge design
- One-way tool (not resharpenable)
- large, continuous gullets with alternating shear angles
- with DP plunge tip for diagonal plunge-cutting
- Soft chip breaker grooves, exception 187691

Advantages

- high cutting quality and high-quality cutting edges on both sides thanks to specially adapted arrangement of cutting edges
- favorable purchase price
- constant cutting diameter (user-friendly since no diameter corrections are necessary)
- no division of cut
- no undesirable lines
- no chip congestion

Notes

- clamping elements: use in high-precision clamping elements recommended (e.g. TRIBOS, ps-System)
- Z=2 solid wood
- adapt the cutting length to the panel thickness (H)!

Ø D	L2	Ø d	L3	L1	Z	H		Ident-No.
12	16	12	40	65	2	12-15	R	187687 L
12	20	12	40	70	3	16-19	R	187688 L
12	20	12	40	70	4	16-19	R	187689 L
12	26	12	40	75	3	22-25	R	187690 L
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Ø D	L2	Ø d	L3	L1	Z	H		Ident-No.
3/8	20	12	40	70	3	16-19	R	187691 L
[inch]	[mm]	[mm]	[mm]	[mm]		[mm]		

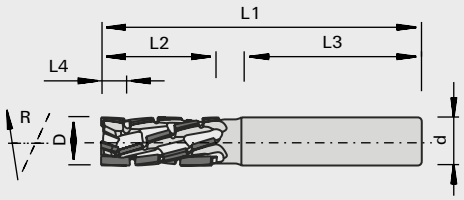
229022

Shank-Type Cutters DP Nesting - Fibonacci

Product



Drawing



Fibonacci

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for panel sizing with Nesting Technology
- for jointing, rabbeting and grooving in raw and laminated panels

Design

- With DP plunge tip
- Face cutting for diagonal plunge-cutting
- Feed rates up to 28 m/min
- Resharpening area: 1.6 mm
- n max=24,000 min-1

Advantages

- natural arrangement of the cutting edges according to Fibonacci ensures the minimization of vibrations
- Tools require up to 15% less power than other tools with the same number of teeth
- a special Fibonacci arrangement of blades makes the base body more robust
- No overlapping cuts with Fibonacci nesting cutters, which results in a significant improvement of the cutting quality
- basic cutting edge is more stable

Notes

- clamping elements: use in high-precision clamping elements recommended (e.g. TRIBOS, ps-System)
- with thread for length adjusting screw

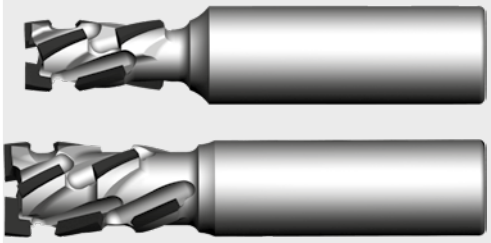
Ø D	L2	L4	Ø d	L3	L1	Z		Ident-No.	
12	23,1	7.2	12	45	75	2+2	R	80479463	L
12	28,7	7.2	12	45	80	2+2	R	80479464	L
12	23	8.1	12	45	75	3+3	R	80479465	L
12	29	8.1	12	45	80	3+3	R	80479466	L
16	29	8.6	16	45	80	3+3	R	80479467	L
12	23	8.6	12	45	75	4+4	R	80469992	L
12	28	8.6	12	45	80	4+4	R	80479468	L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]				

Ø D	L2	L4	Ø d	L3	L1	Z		Ident-No.	
1/2	24	7.1	1/2	45	75	4+4	R	80479471	L
1/2	30	7.1	1/2	45	80	4+4	R	80479472	L
[inch]	[mm]	[mm]	[inch]	[mm]	[mm]				

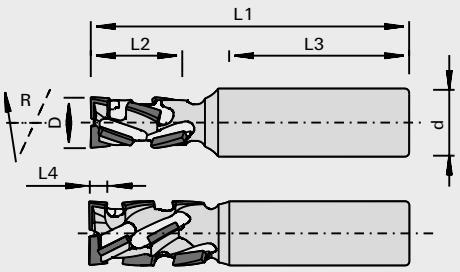
229022

High-Performance Shank-Type Cutters CM DP Nesting - Z=2+2

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for panel sizing with Nesting Technology
- for jointing, rabbeting and *grooving (*negative design)
- particularly for processing MDF panels and Multiplex

Design

- with DP plunge tip
- face cutting for diagonal plunge-cutting
- Ø D=12 mm with highly stiff tool body
- resharpening area 1.6 mm
- n max = 24,000 min-1

Advantages

- high cutting quality and high-quality cutting edges on both sides thanks to specially adapted arrangement of cutting edges
- positive spiral: optimum upward chip evacuation towards the dust extraction
- negative spiral: downward chip evacuation and cutting pressure
- negative spiral especially suitable for smaller or narrow workpieces and for grooving
- Z=2+2 = bigger gullets for better chip removal (MDF) and for reducing heat generation, particularly when processing Multiplex

Notes

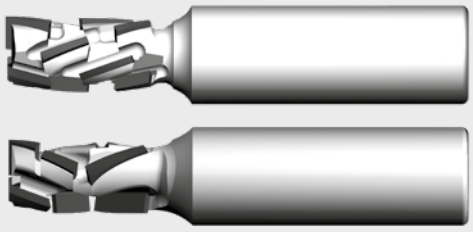
- clamping elements: use in high-precision clamping elements recommended (e.g. TRIBOS, ps-System)
- with thread for length adjusting screw
- in case of higher feed rates and thicker boards choose the higher diameter
- adapt the cutting length to the panel thickness (H)
- * indicate “H” in case of Nesting with protection board

Ø D	L2	L4	Ø d	L3	L1	Z	H	Helical direction	Ident-No. [R]
12	22		16	45	75	2+2	16-19 *	positive	187075 L
12	22	4.5	16	45	75	2+2	-19	negative	187076 L
16	28	4.5	16	45	80	2+2	-25	negative	187077 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

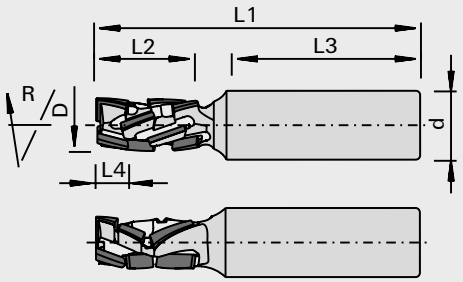
229022

High-Performance Shank-Type Cutters CM DP Nesting - Z=3+3

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for panel sizing with Nesting-Technology
- for jointing, rabbeting and *grooving (*negative version) in raw and laminated panels

Design

- with DP plunge tip
- face cutting for diagonal plunge-cutting
- Ø D=12+14 mm with highly stiff tool body
- feed rates up to 25 m/min
- resharpening area 1.6 mm
- n max = 24,000 min-1

Advantages

- high cutting quality and high-quality cutting edges thanks to specially adapted cutting edge configuration
- positive spiral: optimum upward chip evacuation towards the exhaustion
- negative spiral: downward chip evacuation and cutting pressure
- negative spiral especially for smaller or narrow workpieces and for grooving

Notes

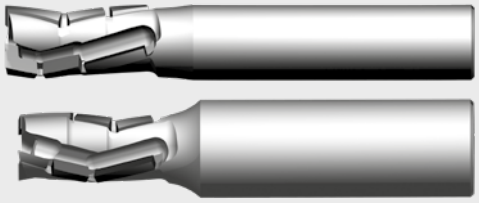
- clamping elements: use in high-precision clamping elements recommended (e.g. TRIBOS, ps-System)
- with thread for length adjusting screw
- in case of higher feed rates and thicker boards choose the higher diameter
- adapt the cutting length to the panel thickness (H)
- * indicate "H" in case of Nesting with protection board

Ø D	L2	L4	Ø d	L3	L1	Z	H	Helical direction	Ident-No. [R]
12	22		16	45	75	3+3	16-19 *	positive	186571 L
12	28		16	45	80	3+3	22-25 *	positive	186572 L
16	22		16	45	75	3+3	16-19 *	positive	186573 L
16	28		16	45	80	3+3	22-25 *	positive	186574 L
12	23	7.2	16	45	75	3+3	-19	negative	187281 L
14	33	7.2	16	45	85	3+3	-30	negative	187282 L
16	28	7.2	16	45	80	3+3	-25	negative	185519 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

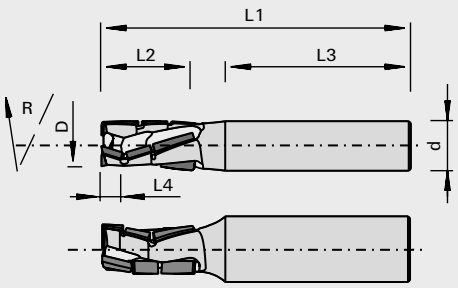
229022

Shank-Type Cutters CM DP Nesting - Z=3+3

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for panel sizing with Nesting-Technology
- for jointing, rabbeting and *grooving (*negative version) in raw and laminated panels

Design

- With DP plunge tip
- Face cutting for diagonal plunge-cutting
- Steel body
- Feed rates up to 20 m/min
- Resharpening area: 1.5 mm
- n max=24,000 min-1

Advantages

- high cutting quality and high-quality cutting edges thanks to specially adapted cutting edge configuration
- positive spiral: optimum upward chip evacuation towards the exhaustion
- negative spiral: downward chip evacuation and cutting pressure
- negative spiral especially for smaller or narrow workpieces and for grooving

Notes

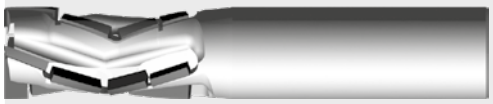
- clamping elements: use in high-precision clamping elements recommended (e.g. TRIBOS, ps-System)
- with thread for length adjusting screw

Ø D	L2	L4	L3	Ø d	L1	Z	H	Helical direction	Ident-No. [R]
12	22	10	45	12	75	3+3	-19	negative	187240 L
12	22		45	16	75	3+3	16-19	positive	184185 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

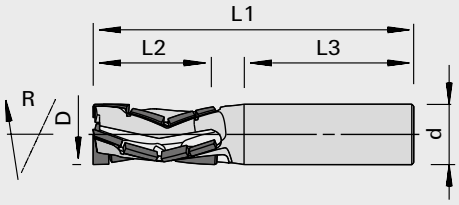
229022

High-Performance Shank-Type Cutters CM DP - Z=4+4

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels
- high-performance tool for rough and finish milling

Design

- with DP plunge tip for diagonal plunge-cutting
- with alternating shear angle
- resharpening area approx. 1.6 mm
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to shear angle, alternating top and bottom
- high hogging volume
- optimized chip removal

Notes

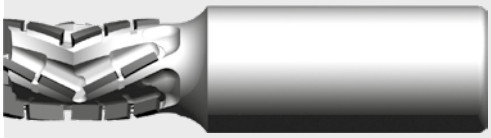
- clamping elements: use in high-precision clamping elements recommended (e.g. TRIBOS, hydro expansion chuck ps-System, heat shrink-fit chuck)

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [R]
16	32	16	45	85	4+4	185499 L
[mm]	[mm]	[mm]	[mm]	[mm]		

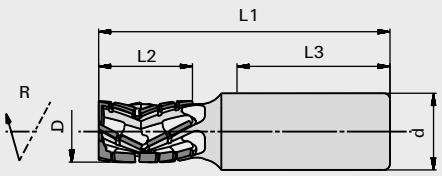
229322

High-Performance Shank-Type Cutters DP - Z=5+5

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels
- high-performance tool for rough and finish milling

Design

- arrow-shaped toothing
- with DP plunge tip for diagonal plunge-cutting
- with shear angle
- resharpening area approx. 2 mm
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to shear angle, alternating top and bottom
- very long edge lives and continuous high cutting quality
- smooth running thanks to spiral cut configuration

Notes

- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [R]
25	30	25	55	95	5+5	186137 L
25	45	25	55	115	5+5	186138 S
[mm]	[mm]	[mm]	[mm]	[mm]		

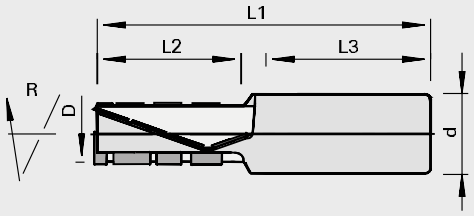
229022

High-Performance Shank-Type Cutters with solid carbide body DP - Z=3

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- solid carbide design of tool body
- high-performance tool for rough and finish milling, as well as panel sizing with Nesting-Technology
- with DP plunge tip
- face cutting for diagonal plunge-cutting
- feed rates up to 25 m/min
- resharpening area 2.0 mm
- n max = 24,000 min-1

Advantages

- high cutting quality and smooth running thanks to spiral design of cutting edges
- optimum good chip disposal thanks to open arrangement of cutting edges
- optimum cutting lengths suitable for most popular panel thicknesses

Notes

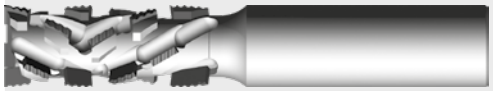
- clamping elements: ps-System, TRIBOS , draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	H	Ident-No.
12	21	16	45	73	3	16-19	181935 L
12	28	16	45	80	3	22-25	181936 L
12	30	16	45	82	3	28	181937 L
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

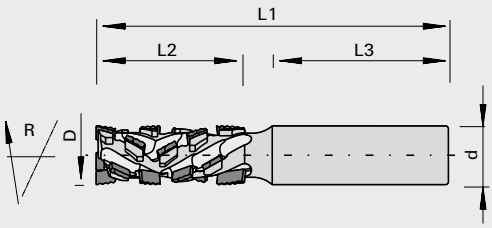
229041

Shank-Type Roughing Cutters DP

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application
- CNC routers
- for sizing in roughing quality with chip-free cutting edges on both sides in solid woods and plywood, laminated wood-based panels and sandwich materials
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design
- with alternating shear angle
- with DP plunge tip
- face cutting for diagonal plunge-cutting
- resharpening area ≥ 2.0 mm
- n max = 24,000 min-1

Advantages
- for long edge lives also in abrasive materials
- chip-free cutting edges on both sides
- high hogging volume

Notes
- slightly rough cutting surface due to fine cut division
- clamping elements: we recommend the use of the tools in high precision clamping chucks such as hydro expansion chucks "ps-System", TRIBOS or heat shrink-fit chucks

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [R]
20	35	20	60	105	2+2	185026 L
20	50	20	60	120	2+2	185027 L
[mm]	[mm]	[mm]	[mm]	[mm]		

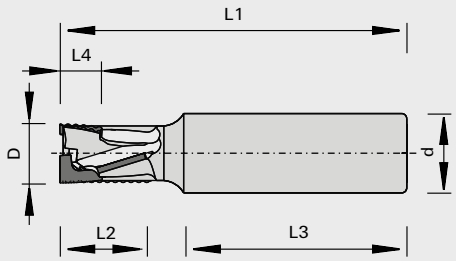
229021

Shank-Type Roughing-Finishing Cutters DP - Z=2+2

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application
- CNC routers
- for sizing in almost finishing quality with chip-free cutting edges on both sides in solid woods and plywood, laminated wood-based panels and sandwich materials
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design
- With reinforced body
- With alternating shear angle
- With DP plunge tip
- Face cutting for diagonal plunge-cutting
- Resharpening area: 0.5 mm
- n max=24,000 min-1

Advantages
- Suitable for contours with a small inside radius
- Chip-free cutting edges on both sides
- Reduced cutting pressure

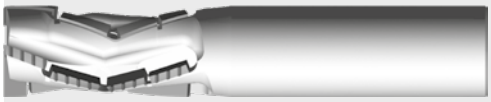
Notes
- clamping elements: it is recommended to use the tools in high precision clamping chucks such as hydro expansion chucks "ps-System", TRIBOS

Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
12	5.0	12	16	45	65	2+2	187835 L
12	8.6	17	16	45	70	2+2	187837 L
12	12.3	24	16	45	75	2+2	187839 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

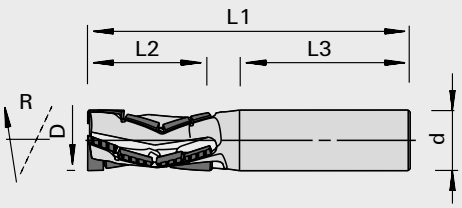
229021

Shank-Type Roughing-Finishing Cutters DP - Z=4 (2+2)

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for sizing in almost finishing quality with chip-free cutting edges on both sides in solid woods and plywood, laminated wood-based panels and sandwich materials
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- with alternating shear angle
- with DP plunge tip
- face cutting for diagonal plunge-cutting
- resharpening area ≥ 1.6 mm
- n max = 30,000 min-1

Advantages

- for long edge lives also in abrasive materials
- chip-free cutting edges on both sides
- high hogging volume

Notes

- slightly rough cutting surface due to fine cut division
- clamping elements: we recommend the use of the tools in high precision clamping chucks such as hydro expansion chucks "ps-System", TRIBOS or heat shrink-fit chucks

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [R]
16	32	16	45	85	4 (2+2)	185498 L
16	36	16	45	90	4 (2+2)	186990 L
18	45	20	45	100	4 (2+2)	186991 L
[mm]	[mm]	[mm]	[mm]	[mm]		

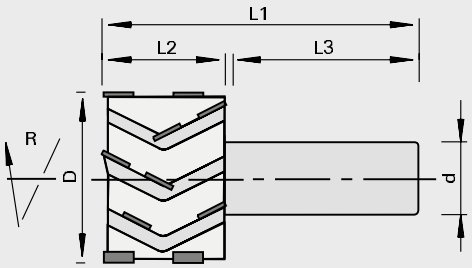
229320

High-Performance Trimming Router Bits DP - Z=4+2+4

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for sizing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- high-performance tool for finish cuts
- with shear angle
- resharpening area 3.0 mm

Advantages

- high feed rates (up to 35 m/min) and good edge quality thanks to 4 cutting edges working in top layer
- minimized formation of dust thanks to 2 cutting edges working in core of board
- very good surface thanks to large cutting circle diameter
- good cutting quality on top and bottom edge thanks to opposing shear angle

Notes

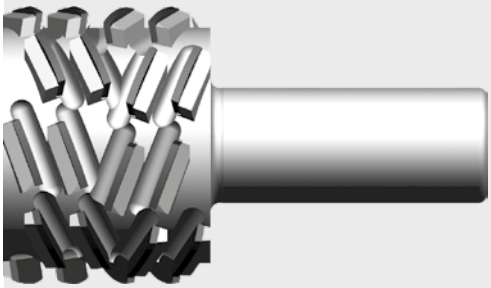
- preferably for finish-cut operations on pre-sized workpieces
- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	H		Ident-No.
48	22	25	62	85	4+2+4	16-19	L	186139 C
48	22	25	62	85	4+2+4	16-19	R	186140 L
48	28	25	62	91	4+2+4	22-25	L	186141 C
48	28	25	62	91	4+2+4	22-25	R	186142 L
48	35	25	62	98	4+2+4	28-32	L	186143 C
48	35	25	62	98	4+2+4	28-32	R	186144 L
48	48	25	55	110	4+2+4	35-45	R	186145 L
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

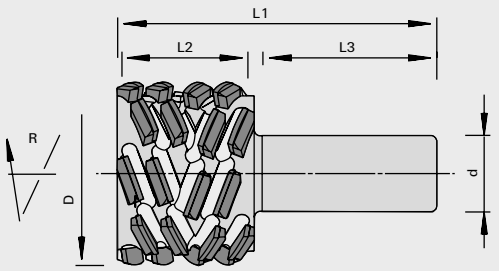
229324

p-System High-Performance Jointing Shank-Type Cutters CM DP

Product



Drawing



LEUCO topline

LEUCO ps-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC stationary machines
- for chip-free high-performance jointing of solid woods (free of knots) along and accross the grain
- for jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- symmetrical and asymmetrical design
- non-convex design
- extremely scoring cut
- resharpening area 4 mm

Advantages

- maximum cutting quality and edge lives
- large depth of cut possible
- chip-free cuts even on the exit side
- perfectly suitable for laser-edge-technology

Notes

- with thread for length adjusting screw
- recommended feed rate per tooth: wood-based panels 0.55 mm, solid wood 0.28 mm
- crowned design on request
- clamping element: precision clamping element e.g. ps-System, TRIBOS
- sense of rotation according to VDMA 8849

Ø D	L2	Ø d	L3	L1	Z	Shear∢		Ident-No. [R]
48	28,2	25	62.2	100	3+3	70	symmetrical	184081 L
48	38	25	57.4	105	3+3	70	symmetrical	184082 L
60	38	25	57.4	105	3+3	70	symmetrical	184083 C
60	38	25	57.4	105	4+4	70	symmetrical	184084 L
60	42,9	25	57.5	110	3+3	70	quasi symmetrical	185821 L
60	47,8	25	57.6	115	3+3	70	symmetrical	185819 C
60	57,6	25	57.8	125	3+3	70	symmetrical	185820 C
60	67,4	25	56.8	135	3+3	70	symmetrical	184080 C
[mm]	[mm]	[mm]	[mm]	[mm]		[°]		

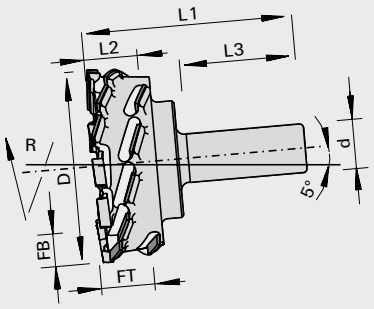
229324

p-System High-Performance Rabbeting Shank-Type Cutter CM DP

Product



Drawing



LEUCO topline

LEUCO p-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- 5-axis machining centers
- for chip-free high-performance rabbeting of solid woods (free of knots) along and accross the grain
- for high-performance rabbeting of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- extremely scoring cut
- tool to be used on spindle tilted by 5°
- resharpening area front 2.5 mm, peripheral side 3 mm

Advantages

- maximum cutting quality on both rabbeting sides and maximum edge lives
- chip-free cuts even on the exit side

Notes

- recommended feed rate per tooth: wood-based panels 0.5 - 0.8 mm, solid wood 0.25 - 0.4 mm
- clamping element: precision clamping element e.g. ps-System, TRIBOS, heat shrink-fit chuck
- with thread for length adjusting screw
- sense of rotation according to VDMA 8849

Ø D	L2	Ø d	L3	L1	Z	FB	FT	Shear∢	Ident-No. [R]
100	18,6	25	65	99	3+3	10	15	70	184731 C
100	28,3	25	65	110	3+3	16	25	70	184732 C
100	43	25	65	120	3+3	16	38	70	184733 C
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[°]	

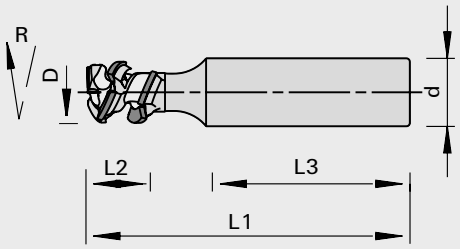
229344

p-System High-Performance Grooving Shank-Type Cutters CM DP

Product



Drawing



LEUCO topline

LEUCO p-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC stationary machines
- for grooves, cut outs, pockets and as forend cutter
- for chip-free high-performance grooving of solid woods (free of knots) along and accross the grain
- for high-performance grooving of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- extremely scoring cut

Advantages

- maximum cutting quality and edge lives
- chip-free cuts even on the exit side

Notes

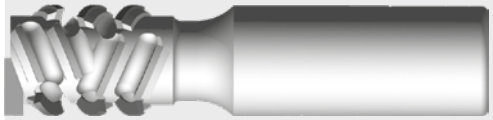
- minimal grooving depth 0.5 mm
- as from 25 mm Z=2 is possible, bottom cutting edge is Z=1 always
- convex bottom cutting edge for better bottom quality of rabbet, however corner of rabbet not absolutely sharp
- for ramping or circular plungeing only
- clamping element: precision clamping element e.g. ps-System, TRIBOS, heat shrink-fit chuck
- with thread for length adjusting screw
- sense of rotation according to VDMA 8849

Ø D	L2	Ø d	L3	L1	Z	Shear◁	Resharpening area	Ident-No. [R]
8.0	3,3	8,0	50	65	1+1	70	0.4	187844 L
8.0	3,3	10	50	65	1+1	70	0.4	186095 L
10	4,8	12	45	65	1+1	70	0.9	186096 C
10	10,4	12	45	70	1+1	70	0.9	186097 L
12	21,4	12	50	90	1+1	70	1.4	185506 C
12	10,2	16	45	80	1+1	70	1.4	185505 L
12	21,4	16	45	90	1+1	70	1.4	185507 L
16	14	16	45	85	1+1	70	1.9	185508 L
16	24,4	16	45	90	1+1	70	1.9	185509 C
16	32,2	16	45	90	1+1	70	1.9	186098 L
18	19	16	55	95	1+1	70	2.4	185612 L
18	7,0	20	55	90	1+1	70	2.4	185613 L
18	19	20	55	95	1+1	70	2.4	185614 L
25	9,4	25	50	95	1+1	70	2.4	185615 C
25	18	25	50	100	1+1	70	2.4	185616 C
[mm]	[mm]	[mm]	[mm]	[mm]		[°]	[mm]	

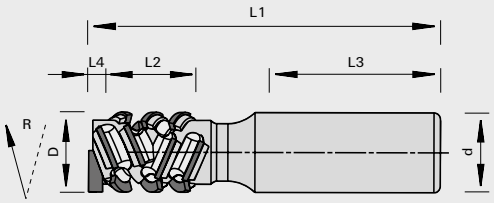
229324

p-System High-Performance Shank-Type Cutters CM DP

Product



Drawing



LEUCO topline

LEUCO p-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC stationary machines
- for chip-free high-performance jointing and dividing of solid woods (free of knots) along and accross the grain
- for jointing and dividing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- extremely scoring cut
- DP plunge tip

Advantages

- maximum cutting quality and edge lives
- large depth of cut possible
- chip-free cuts even on the exit side
- perfectly suitable for laser-edge-technology

Notes

- Adjust the tool to run centrally to the workpiece
- Tools with plunge tip (L4) must project at least 4.5 mm on bottom side of workpiece in order to bring p-System cutting edges into action
- for inclined or circular plunge-cutting only
- recommended feed rate per tooth (depending on the diameter): wood-based panels 0.2 - 0.3 mm, solid wood 0.15 - 0.2 mm
- Clamping element: precision clamping element e.g. ps-System, TRIBOS
- with thread for length adjusting screw
- Sense of rotation according to VDMA 8849

Ø D	L4	L2	Ø d	L3	L1	Z	H	Shear∢	Resharpening area	Ident-No. [R]
12	3.1	13,5	16	45	85	1+1	10,5	70	1.5	185500 C
12	3.1	21,5	16	45	90	1+1	18,5	70	1.5	185501 L
14	3.4	27	16	45	100	1+1	24	70	1.8	185502 L
16	3.4	20,9	16	45	90	1+1	17,9	70	2.0	185503 L
16	3.4	26,1	16	45	100	1+1	23,1	70	2.0	185504 L
20	3.8	25,9	25	55	105	1+1	22,9	70	2.5	184379 L
20	3.8	29,5	25	55	110	1+1	26,5	70	2.5	184380 L
20	3.8	33,1	25	55	115	1+1	30,1	70	2.5	184381 L
25	3.8	26,5	25	55	105	2+2	23,5	70	2.5	184382 L
25	3.8	30,8	25	55	110	2+2	27,8	70	2.5	184383 L
25	3.8	48	25	55	130	2+2	45	70	2.5	184384 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[°]	[mm]	

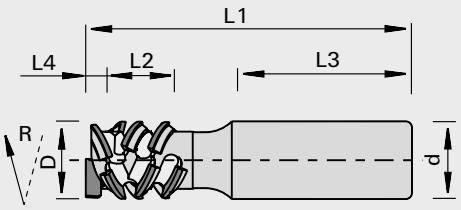
229324

p-System High-Performance Shank-Type Cutters CM DP - Weeke BHX 050/055

Product



Drawing



LEUCO topline

LEUCO p-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- WEEKE BHX 050 and BHX 055 with delivery date as from Sept. 01, 2015
- BHX 50/055 machines with CNC controlled clamping devices (servo) and with delivery date as from 01.01.2014 only can be updated by the manufacturer (Note: Service charges will occur)
- for chip-free high-performance jointing and dividing of solid woods (free of knots) along and accross the grain
- for jointing and dividing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- extremely scoring cut
- asymmetrical design
- DP plunge tip

Advantages

- maximum cutting quality and edge lives
- chip-free cuts even on the exit side
- increased contact pressure than conventional shank-type cutters

Notes

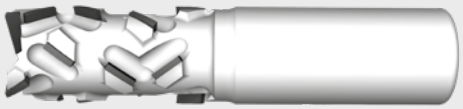
- Tools with plunge tip (L4) must project at least 4,5 mm on bottom side of workpiece in order to bring p-System cutting edges into action. D 30 is without plunge tip
- for ramping or circular plungeing only
- recommended feed rate per tooth: wood-based panels 0.3 - 0.35 mm, solid wood 0.15 - 0.2 mm
- clamping element: precision clamping element e.g. ps-System, TRIBOS
- with thread for length adjusting screw
- sense of rotation according to VDMA 8849

Ø D	L4	L2	Ø d	L3	L1	Z	Shear	Resharpening area	Ident-No. [R]
20	4.0	25,1	25	51	105	1+1	70	2.5	185664 L
25	4.0	25,7	25	53	105	2+2+1	70	2.5	185663 L
25	4.0	30	25	53	110	2+2+1	70	2.5	185823 C
25	4.0	47,2	25	53	125	2+2+1	70	2.5	185824 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[°]	[mm]	

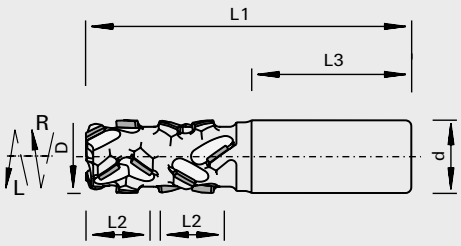
229122

DIAREX Combination Shank-Type Router Bits RH-LH DP - Z=2+2

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- For sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered wood-based materials

Design

- The shank-type cutters have both a counter-clockwise rotating and clockwise rotating cutting segment, each of which can be used by shifting along the Z-axis and changing the direction of rotation
- Resharpening area: 1.2 mm

Advantages

- When routing workbench board corner connections in particular, this guarantees chip-free cutting of the visible edge by routing both sides with a conventional cut using only one router.
- Less tool change
- Two functions in one tool, which allows for more space in the tool changer

Notes

- Workpiece clamping on suction devices required
- Clamping elements: ps-System, TRIBOS, heat-shrinking chuck
- With thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [R]
25	2x22	25	55	125	2+2	186992 L
25	2x34	25	55	135	2+2	186993 C
[mm]	[mm]	[mm]	[mm]	[mm]		

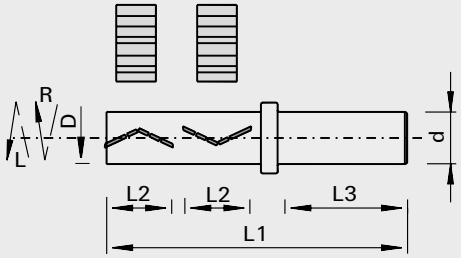
229022

Combination Shank-Type Router Bits RH-LH DP - Z=3/1

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels
- high-performance tool for pre- and finish-milling

Design

- Z=3 on right hand cutting section for highest feed rates
- Z=1 on left hand cutting section
- resharpenable area 3.2 mm

Advantages

- lower part of the cutter can be run in left hand rotation by adjusting the Z-axis and changing the direction of rotation; this allows optimum machining of frail edges utilizing only one spindle

Notes

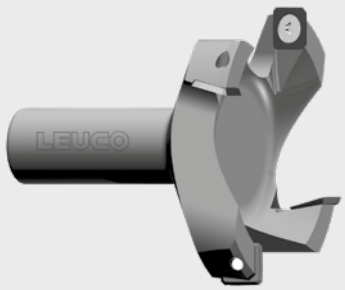
- L2 eff. = L2 eff. = real cutting length; this tool has Z=3 the difference to L2 is Z=2; this allows the machining of all current panel boards
- workpiece secured on clamping blocks
- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with thread for length adjusting screw

Ø D	L2		Ø d	L3	L1	Z	Ident-No.
25	2x22	L2 eff. 19.5 mm	25	62	129	3/1	179497 C
25	2x26	L2 eff. 23.3 mm	25	62	137	3/1	179498 C
25	2x30	L2 eff. 27 mm	25	62	145	3/1	179499 L
25	2x34	L2 eff. 31 mm	25	62	153	3/1	179500 C
[mm]	[mm]		[mm]	[mm]	[mm]		

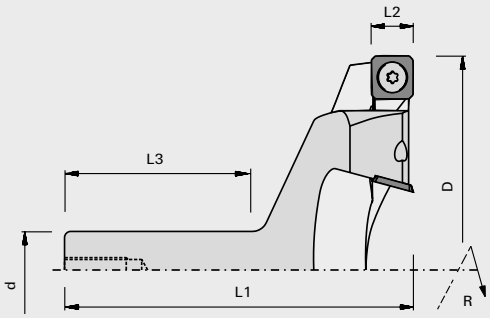
128200

Planing Shank-Type Cutterheads HW

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application
- CNC routers
- for planing and panel raising in wood-based materials
- not suitable for rabbeting

Design
- cutting material: HL Solid 20

Advantages
- high milling performance when dressing the workbench boards, e.g. with Nesting technology
- smooth surface thanks to special cutting edge geometry

Notes
- with thread for length adjusting screw
- sense of rotation according to VDMA 8849

Ø D	L2	Ø d	L3	L1	Z	nmax	Ident-No. [R]
100	14	20	45	96	4	15200	182619 C
100	14	25	55	96	4	15200	182620 L
150	14	25	55	113	4	10100	182621 C
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

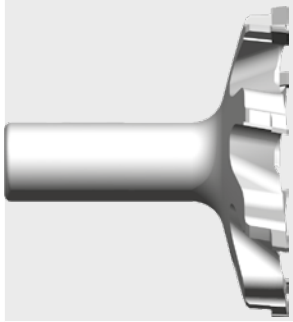
Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	14	14	2.0	150557	10	182441 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x6 T20 D=Ø9,3	995125	10	176199 L
Screwdrivers	T20x100	985730	1	166092 L
	[mm]		[pc.]	

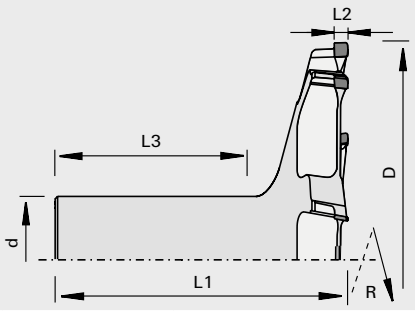
229020

Planing and Rabbeting Cutters DP

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application
- CNC routers
- for planing, rabbeting and panel raising in wood-based panels

Design
- resharpening area 3.5 mm

Advantages
- high milling performance when dressing the workbench boards, e.g. with Nesting technology
- smooth surface thanks to special cutting edge geometry

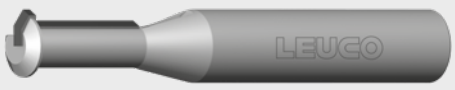
Notes
- with thread for length adjusting screw
- sense of rotation according to VDMA 8849

Ø D	L2	Ø d	L3	L1	Z	nmax	Ident-No. [R]
80	5,6	20	61.3	90	6	24000	182660 C
80	5,6	25	62	90	6	24000	182659 C
100	5,6	20	58.6	90	8	18000	182658 L
100	5,6	25	59.3	90	8	18000	182657 C
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

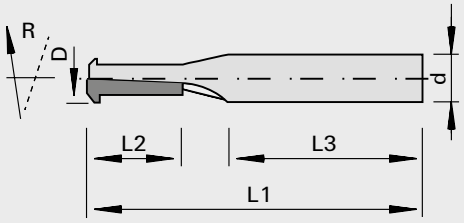
129610

Profile Grooving Shank-Type Cutters HW - for Lamello Clamex P®

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- 5-axis CNC machines
- for the milling of Lamello Clamex P® profile grooves
- particularly for profile grooves to be cut into the panel surface further away from the panel edge and if the housing of the angular aggregate does not allow the use of bore type tool for Lamello Clamex P®

Design

- HW-tipped
- disposable tool

Advantages

- problem solution if space problems occur with angular aggregates (touching of the panel with the aggregate's bottom side when using bore-type cutters with DØ100,4 mm)

Notes

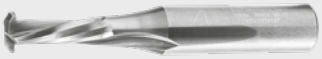
- depending on the type of workpiece a pre-grooving operation with a negative solid carbide finishing spiral cutter can make sense (reduced risk of chipping of sensitive laminations) resp. reduces the cutting pressure when milling the profile grooves

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	20	10	40	70	1	185368 L
[mm]	[mm]	[mm]	[mm]	[mm]		

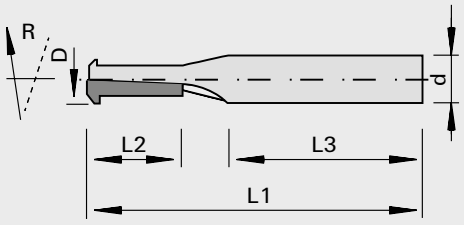
129650

Profile Grooving Shank-Type Cutters VHW - for Lamello Clamex P®

Product



Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application

- 5-axis CNC machines
- for the milling of Lamello Clamex P® profile grooves
- particularly for profile grooves to be cut into the panel surface further away from the panel edge and if the housing of the angular aggregate does not allow the use of bore type tool for Lamello Clamex P®

Design

- Massive solid tungsten carbide
- Spiral design Z=2
- TC 104 topcoat coating
- Disposable tool
- Not resharpenable

Advantages

- High rigidity = low vibration even with difficult materials
- Low cutting pressure and good cutting quality thanks to spiral design
- Hard coating and additionally low coefficient of friction for longer edge life

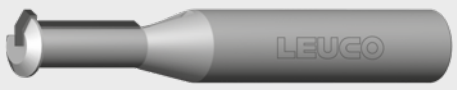
Notes

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
9.8	23	12	36	80	2	186879 L
[mm]	[mm]	[mm]	[mm]	[mm]		

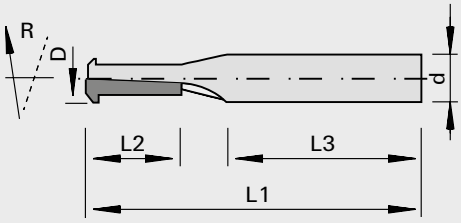
229268

Profile Grooving Shank-Type Cutters DP - for Lamello Clamex P®

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- 5-axis CNC machines
- for the milling of Lamello Clamex P® profile grooves
- particularly for profile grooves to be cut into the panel surface further away from the panel edge and if the housing of the angular aggregate does not allow the use of Lamello Clamex P® bore type tool

Design

- DP-tipped
- disposable tool

Advantages

- problem solution if space problems occur with angular aggregates (touching of the panel with the aggregate's bottom side when using bore-type cutters with DØ100,4 mm)

Notes

- depending on the type of workpiece a pre-grooving operation with a negative solid carbide finishing spiral cutter can make sense (reduced risk of chipping of sensitive laminations) resp. reduces the cutting pressure when milling the profile grooves

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	20	12	40	70	1	185703 L
[mm]	[mm]	[mm]	[mm]	[mm]		

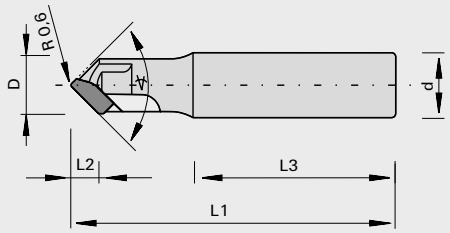
229360

Relief-Picture Shank-Type Cutter DP - 90°

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC machines
- for grooving operations in relief-picture technique (i.e. Pic2Plate)

Design

- cutting material: DP
- topline design
- resharpening area 2 mm

Advantages

- very long edge lives particularly in hard panel materials
- optimal cutting quality thanks to specialized blade preparation

Notes

- the relief-picture technique is a computer-based method to transfer image information by milling onto board materials
- clamping systems : precision clamping element e.g. TRIBOS or heat shrink-fit chuck

Ø D	L2	L3	Ø d	L1	Z	◁	Ident-No.
14	7,0	50	16	80	1	90	185156 L
[mm]	[mm]	[mm]	[mm]	[mm]		[°]	

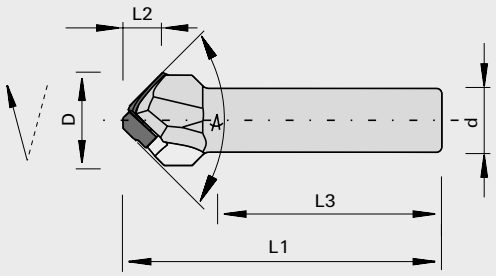
229460

V-Groove Cutter DP for aluminum composite materials

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC machines
- for V-grooves in aluminum composite materials (Alucobond, Dibond, etc.)

Design

- cutting material: DP
- topline design
- resharpening area 2 mm

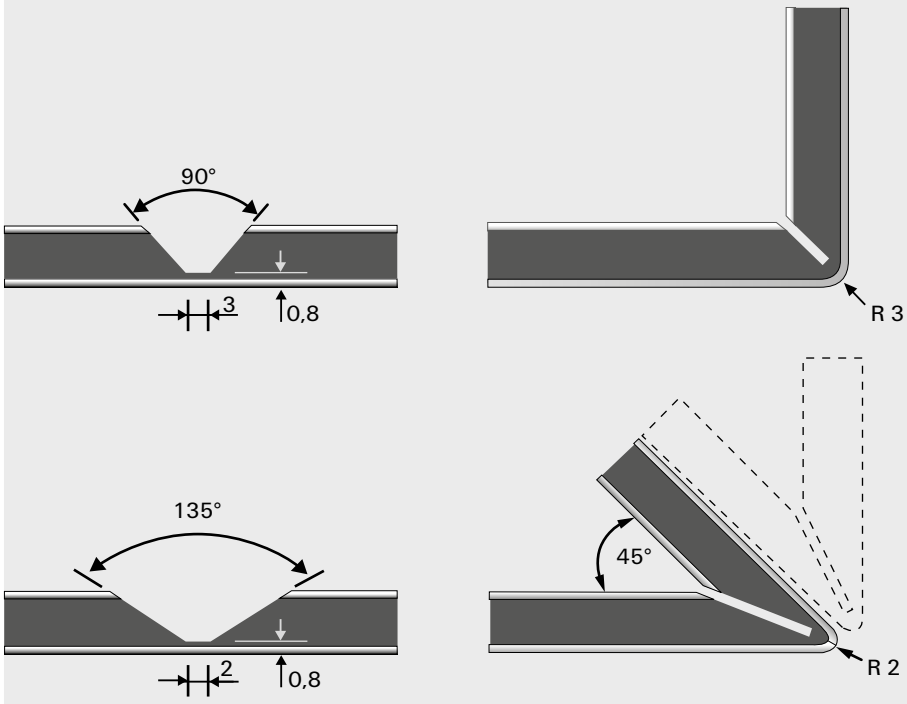
Advantages

- very long edge lives particularly in composite materials with mineral core
- optimal cutting quality thanks to polished face and special division of cut

Notes

- clamping elements: ideal use in precision clamping elements e.g. ps-System, TRIBOS or heat-shrinking chuck

Ø D	L2	L3	Ø d	L1	Z	◁	Ident-No.
18	7,5	40	12	60	1+1	90	186499 L
32	6,2	40	12	60	1+1	135	186500 L
[mm]	[mm]	[mm]	[mm]	[mm]		[°]	



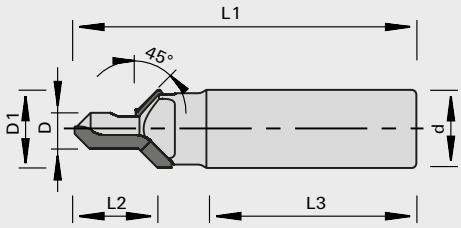
229332

Multi-purpose Drill-Chamfer Router DP - for the machining of solid core panels

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application
- CNC routers
- chip-free drilling and countersinking as well as milling of larger hole diameters and cutouts particularly in plastic solid core panels (e.g. Trespa®, Corian®, Varicor®, LG-HiMacs, etc.) and fiber cement boards

Design
- special PCD type in topline design
- with alternating shear angle and DP plunge tip

Advantages
- flexible multi-function tool
- vertical boring and through-drilling
- milling of any hole diameters >Ø8 mm and cutouts
- drilling and countersinking 45°
- only 1 tool change location required

Notes
- Clamping elements: ps-System, TRIBOS, heat-shrinking chuck

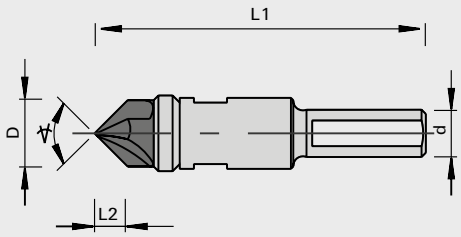
Ø D1	Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	8	17	16	41	70	1+2	187374 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

130610

VHW countersink - Z=3

Product

Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application
- CNC machines
- For subsequent countersinking of predrilled holes
- For use in the drilling units of CNC machines
- Also suitable for milling of V-grooves, ornamental grooves and letters as well as for chamfering of solid wood and wood-based panel materials

Design
- VHW cutting head Z=3
- Special grind
- Shank with clamping surface and length adjusting screw
- For mechanical feed
- Righthand rotation

Advantages
- VHW cutting edge
- Good concentricity and drilling properties due to special geometry

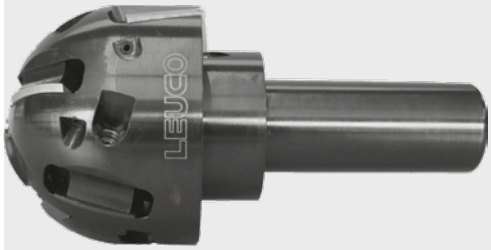
Notes
- recommended RPM for countersinking: 2,500 - 3,000 min-1

Ø D	L2	Ø d	L1	Z	Wedge◁	Ident-No.
18	9,0	10	70	3	90	80487758 L
[mm]	[mm]	[mm]	[mm]		[°]	

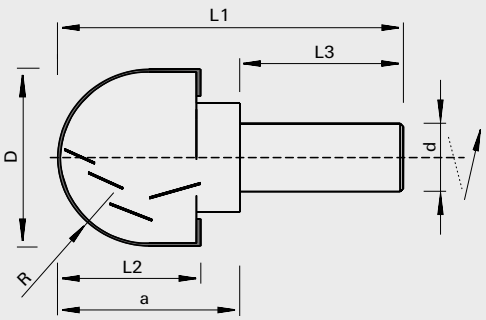
128660

Spherical Cutterhead HW

Product



Drawing



LEUCO CNC

Tungsten Carbide [HW]

MEC

Machine / Application
- CNC 5-axis routers
- for milling shapes and contours in solid wood and wood-based panels
- ideal for forms

Design
- with shank
- n max = 15,000 min-1

Advantages
- high volume to be removed
- simple tool change

Notes
- ideal for the basic equipment of a 5-axis machine
- clamping elements: ps-System, TRIBOS, heat-shrinking chuck, draw-in collet chucks

R	Ø D	L2	Ø d	L3	L1	Z	a	Ident-No.
32,5	65	52	25	60	127	2+2	67	185082 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

Turnover Knives	B	H	S	R	Class-No.	PU	Ident-No.
	20	12	1.5		150515	10	003082 L
	20	11.5	1.5	30,7	151521	10	185083 L
	[mm]	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screwdrivers	T15x80	985730	1	171188 L
Screwdrivers	SW3x100	985730	1	166090 L
	[mm]		[pc.]	

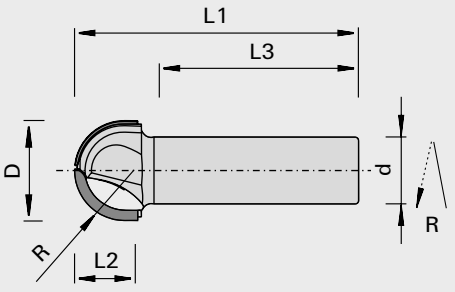
229560

DIAMAX Spherical Shank-Type Cutters DP

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application
- CNC machines
- for contour milling and template copying
- for 3D-milling work, 3D-models, relief-milling work

Design
- TOPLINE design
- resharpening area 1.5 mm
- n max = 24,000 min-1

Advantages
- long edge lives
- high quality of cut thanks to polished cutting edges and ultra-fine eroding of back of the tooth

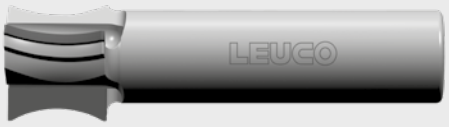
Notes
- clamping elements: we recommend the use of the tools in high precision clamping chucks such as hydro expansion chucks "ps-System", TRIBOS or heat shrink-fit chucks

R	Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	20	14	20	55	85	2	185240 L
15	30	19	20	55	85	2	185241 L
20	40	24	20	55	85	2	185242 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

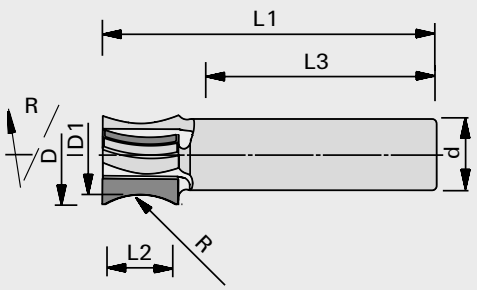
229360

High-Performance Radius Shank-Type Cutters DP - for the machining of solid core panels

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for slight rounding of wood-based panels, solid wood and plastic
- especially suited for the machining of plastic solid core panels (e.g. Trespa®, Corian®, Varicor®, LG-HiMacs, etc.)
- for panel thickness up to14 mm

Design

- high-performance tool for finish milling, Z=3
- with alternating shear angle
- without plunge tip
- polished face
- radius R=16
- n max = 24,000 min-1

Advantages

Notes

- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with thread for length adjusting screw

R	Ø D	Ø D1	L2	Ø d	L3	L1	Z	Resharpening area		Ident-No.
16	22.3	18	14	16	55	75	3	1.5	R	186578 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

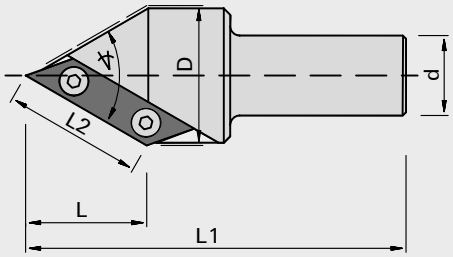
128410

Folding Chamfering Cutterheads HW - Z=1

Product



Drawing



LEUCO CNC

Tungsten Carbide [HW]

MEC

Machine / Application
- CNC 5-axis routers
- for picking of internal corners and for chamfering, for the cutting of ornamental grooves and folding cuts in solid wood and wood-based panels

Design
- with shank
- n max = 18,000 min-1

Advantages
- Angle of attack for corner scribing: 45°

Notes
- please order adapters separately
- clamping elements: ps-System, TRIBOS, heat-shrinking chuck, draw-in collet chucks

Wedge	Ø D	L2	L	Ø d	L1	Z	Ident-No.
60	41.5	41,3	35.5	20	118	1	185459 L
60	41.5	41,3	35.5	25	118	1	185138 L
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	50	12	1.5	150515	10	185140 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M3,5x4 T15	995195	10	168893 L
Screwdrivers	T15	985730	1	163161 L
	[mm]		[pc.]	

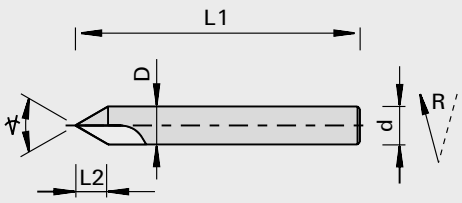
129310

Folding Chamfering Shank-Type Cutters VHW - Z=2

Product



Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application
- CNC 5-axis routers
- for picking of internal corners especially in small, narrow cut-outs
- for chamfering, for ornamental grooves and folding cuts in solid wood and wood-based panels

Design
- throughout cylindrical solid carbide body
- for mechanical feed
- righthand rotation
- n max = 20,000 min-1

Advantages
- Angle of attack for corner scribing: 45°

Notes
- clamping elements: we recommend the use of the tools in high precision clamping chucks such as hydro expansion chucks "ps-System", TRIBOS or heat shrink-fit chucks

Wedge	Ø D	L2	Ø d	L1	Z	Ident-No. [L]	Ident-No. [R]
60	16	14	16	120	2	185793 L	185794 L
[°]	[mm]	[mm]	[mm]	[mm]			

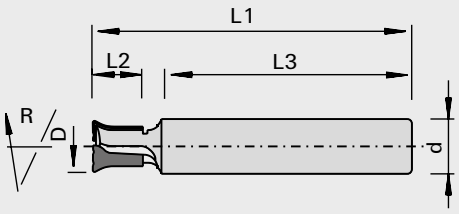
229262

Shank-Type Cutters DP for fischer® undercut anchors

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC machining centers
- 187246 especially for copy wheels aggregates Homag Nr. 2-017-95-7130 / BENZ Nr. 000WTA04205G00S3
- for production of undercut bore holes for the fischer® undercut anchor type FZP II- (T) M6 (fischer Zykon panel anchors)
- for facade materials made of mineral based materials, high-pressure laminate (HPL) or fiber cement boards (FC)

Design

- high-strength tool body
- special cutting edge geometry
- cutting material: DP
- LEUCO topline version
- not resharpenable
- n max = 24,000 min-1

Advantages

- very long edgelife and thus considerably lower costs per hole compared to conventional solid carbide cutters
- reduced coefficient of friction for lowest possible heat generation
- high stiffness for excellent stability
- optimum cutting quality thanks to special tooth geometry

Notes

- Information regarding the application conditions (e.g. of floating milling aggregates), inspection and measuring tools, test instructions regarding the drilling holes and the safe fit of the anchors are available from ACT@ fischer.de upon request
- if the cutter is not used in a floating trimming unit but in a main spindle, the use of highly precise clamping devices such as the hydro expansion chuck “ps-System”, the Power Shrink Chuck TRIBOS or the a heat-shrinking chuck is recommended

Ø D	L2	Ø d	L3	L1	Z			Ident-No.	
11.2	11	12	41.9	57	2	Homag Nr. 2-017-95-7130 / BENZ Nr. 000WTA04205G00S3	R	187246	L
11.2	11	12	53	70	2		R	185869	L
[mm]	[mm]	[mm]	[mm]	[mm]					

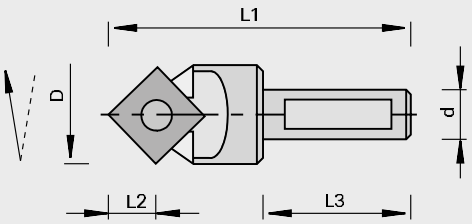
128415

Ornamental Groove Cutters with HW turnover knives

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable routers
- CNC routers
- for cutting of ornamental grooves, inscriptions and engravings in solid woods and wood-based panels

Design

- with negative shear angle

Advantages

- chip-free cutting of laminated panels thanks to negative shear angle

Notes

- clamping elements: ps-System, draw-in collet chuck
- included in delivery: Ident-No. 186880 SP16 cutter assembly with TOK Ident-No. 003080 or set Ident-No. 171217 see profile drawings

Ø D	L2	Ø d	L3	L1	Z	Drawing	Ident-No.
17	8,3	10	40	67	1	SP 16	186880 L
						Set	171217 O
[mm]	[mm]	[mm]	[mm]	[mm]		[Foil]	

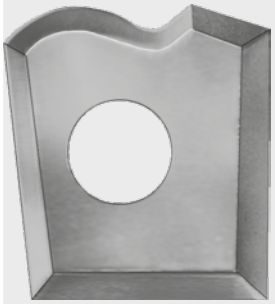
Turnover Knives	B	H	S	Drawing/Foil	Class-No.	PU	Ident-No.
	12	12	1.5	SP 16	150515	10	003080 L
	[mm]	[mm]	[mm]			[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Head Cap Screws	M3,5x6,5 T15	995115	10	163223 L
Screwdrivers	T15	985730	1	163161 L
	[mm]		[pc.]	

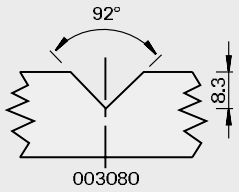
150514 / 151521

Profile Knives HW for ornamental groove cutterheads

Product

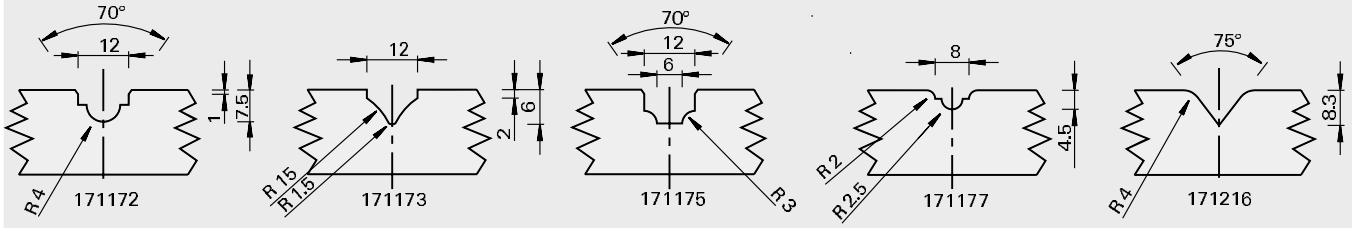


Drawing



LEUCO DUR

Tungsten Carbide [HW]



Machine / Application

Design

Advantages

Notes

I included in delivery of set Ident-No.171217: 1 piece ornamental groove cutter with shank (Ident-No.186880) / 1 piece turnover knife 12x12x1.5 (Ident-No.003080) / 2 pieces each double-sided profile knives Class-No. 151521 (Ident- No. and drawing as shown)

B	H	S	Drawing	Ident-No.
12	12	1.5	SP 16	003080 L
11	12	1.5		171172 L
11	12	1.5		171173 L
11	12	1.5		171175 L
12	12	1.5		171177 L
12	12	1.5		171216 L
[mm]	[mm]	[mm]	[Foil]	

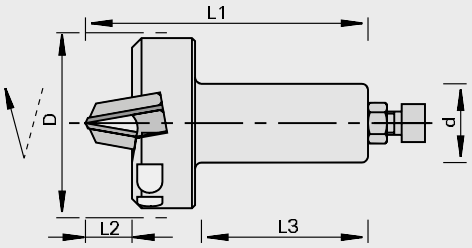
128612

Ornamental Groove Shank-Type Cutterheads SuperProfiler HW

Product



Drawing



SUPER PROFILER

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for cutting of ornamental grooves in solid woods and wood-based panels

Design

- with positive shear angle
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods
- n max = 18,000 min-1

Advantages

- cutterhead for mounting of several profile knives

Notes

- profile knife can be profiled according to customer specifications
- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- included in delivery: cutterhead body with clamping elements without profile knives and support plates

Ø D	L2	Ø d	L3	L1	Z	Drawing	Ident-No. unprofiled	
59	13	25	62	97	2	SP 17	173268	L
[mm]	[mm]	[mm]	[mm]	[mm]		[Foil]		

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No.	
SP blanks	30,6	25.5	HL Board 06	SP 17	152526	10	179114	L
SP blanks	30,6	25.5	HL Solid 60	SP 17	152529	10	177369	L
support plates	30	18		SP 17	925402	2	178017	L
	[mm]	[mm]				[pc.]		

Spare parts	Dimension	Class-No.	PU	Ident-No.	
Pressure Bars	B=24	925300	2	173276	L
Set Screws	M6x10 DIN EN ISO 4028	995161	10	180002	L
Screwdrivers	SW3x100	985730	1	166090	L
	[mm]		[pc.]		

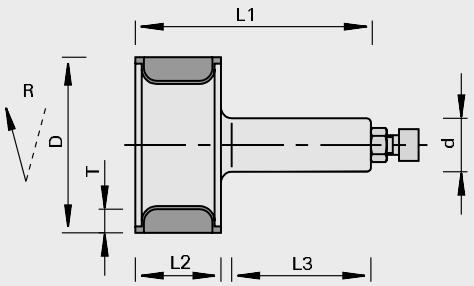
128612

SuperProfiler Shank-Type Cutterheads HW

Product



Drawing



SUPER PROFILER

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for profiling of solid woods and wood materials

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods

Advantages

- cutterhead for mounting of several profile knives

Notes

- profile knife can be profiled according to customer specifications
- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- included in delivery: cutterhead body with clamping elements without profile knives and support plates

Ø D	L2	Ø d	L3	L1	Tmax	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
82	40	20	55	110	11	2	12000	SP 19		167479 C
82	40	25	55	110	11	2	18000	SP 19	167835 C	167834 L
82	40	MK 2	55	127	11	2	18000	SP 19		167483 S
86	60	25	55	130	13	2	10000	SP 31		176241 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No.
SP blanks	40,6	28.2	HL Board 06	SP 19	152526	10	179112 L
SP blanks	40,6	28.2	HL Solid 60	SP 19	152529	10	177367 L
SP blanks	60,8	30.2	HL Board 06	SP 31	152526	10	179113 L
SP blanks	60,8	30.2	HL Solid 60	SP 31	152529	10	177368 L
support plates	40	26.5		SP 19	925402	2	178007 L
support plates	60	28.5		SP 31	925402	2	178008 L
	[mm]	[mm]				[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	36x12x8	167835	925300	2	166736 L
Pressure Bars	36x12x8	167479, 167483, 167834	925300	2	166737 L
Pressure Bars	58x12x8	176241	925300	2	166738 L
Set Screws	M8x16 DIN EN ISO 4028	For all	995161	10	164422 L
Screwdrivers	SW4x100	For all	985730	1	166091 L
	[mm]			[pc.]	

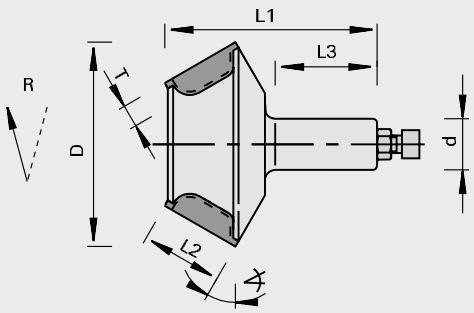
128612

SuperProfiler Shank-Type Cutterheads HW - cranked

Product



Drawing



SUPER PROFILER

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for profiling of solid woods and wood materials

Design

- cranked body
- cutting edges parallel to cutter axis
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods
- Ø 100 mm and 110 mm: n max = 12,000 min-1
- Ø 125 mm: n max = 8,000 min-1

Advantages

- for deep profiles

Notes

- profile knife can be profiled according to customer specifications
- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- included in delivery: cutterhead body with clamping elements without profile knives and support plates

Ø D	L2	Ø d	L3	L1	Tmax	Z	Drawing	Ident-No. unprofiled
100	40	25	55	119	11	2	SP 18	168184 C
110	40	25	55	120	11	2	SP 27	176235 C
125	60	25	55	140	13	2	SP 28	176237 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[Foil]	

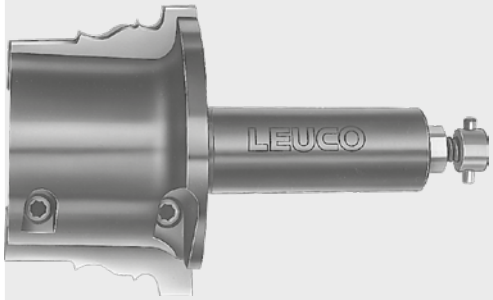
Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No.
SP blanks	40,6	28.2	HL Board 06	SP 18 / 27	152526	10	179112 L
SP blanks	40,6	28.2	HL Solid 60	SP 18 / 27	152529	10	177367 L
SP blanks	60,8	30.2	HL Board 06	SP 28	152526	10	179113 L
SP blanks	60,8	30.2	HL Solid 60	SP 28	152529	10	177368 L
support plates	40	26.5		SP 18 / 27	925402	2	178007 L
support plates	60	28.5		SP 28	925402	2	178008 L
	[mm]	[mm]				[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	36x12x8	168184, 176235	925300	2	166737 L
Pressure Bars	58x12x8	176237	925300	2	166738 L
Set Screws	M8x16 DIN EN ISO 4028	For all	995161	10	164422 L
Screwdrivers	SW4x100	For all	985730	1	166091 L
	[mm]			[pc.]	

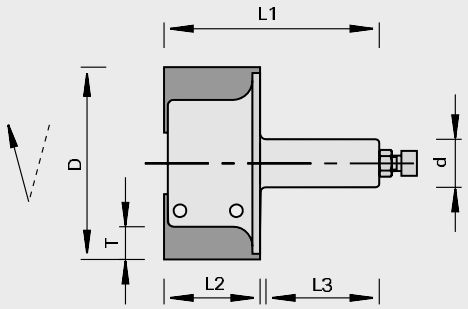
128612

SuperProfiler Shank-Type Cutterheads HW - open on one side

Product



Drawing



SUPER PROFILER

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for profiling of solid woods and wood materials

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods

Advantages

- cutterhead for mounting of several profile knives

Notes

- for profiles requiring a cutter body which is open on one side
- profile knife can be profiled according to customer specifications
- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- included in delivery: cutterhead body with clamping elements without profile knives and support plates

Ø D	L2	Ø d	L3	L1	Tmax	Z	nmax	Drawing	Ident-No. [R] unprofiled
60	30	16	43	89.6	11	2	12000	SP 23	171033 C
100	50	25	55	112	16	2	9500	SP 21	171143 C
120	50	25	55	109	22	2	6500	SP 20	173271 C
120	60	25	55	118	22	2	6000	SP 22	173270 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]	

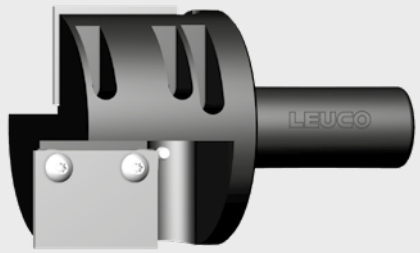
Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No.
SP blanks	30,6	25.5	HL Board 06	SP 23	152526	10	179114 L
SP blanks	30,6	25.5	HL Solid 60	SP 23	152529	10	177369 L
SP blanks	49,3	33.7	HL Board 06	SP 21	152526	10	180199 L
SP blanks	49,4	44.5	HL Board 06	SP 20	152526	10	180218 L
SP blanks	60,6	45.6	HL Board 06	SP 22	152526	10	179999 L
SP blanks	60,6	45.6	HL Solid 60	SP 22	152529	10	178845 L
support plates	30	23.8		SP 23	925402	2	178016 L
support plates	48	33		SP 21	925402	2	178015 L
support plates	47	43		SP 20	925402	2	178014 L
support plates	56	43		SP 22	925402	2	178010 L
	[mm]	[mm]				[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	28x10x7	171033	925300	2	171035 L
Pressure Bars	48x12x8	171143	925300	2	171147 L
Pressure Bars	47x14x8	173271	925300	2	171140 S
Pressure Bars	56x15x8	173270	925300	2	167055 L
Set Screws	M6x10 DIN EN ISO 4028	171033	995161	10	180002 L
Set Screws	M8x16 DIN EN ISO 4028	171143, 173270, 173271	995161	10	164422 L
Screwdrivers	SW3x100	171033	985730	1	166090 L
Screwdrivers	SW4x100	171143, 173270, 173271	985730	1	166091 L
	[mm]			[pc.]	

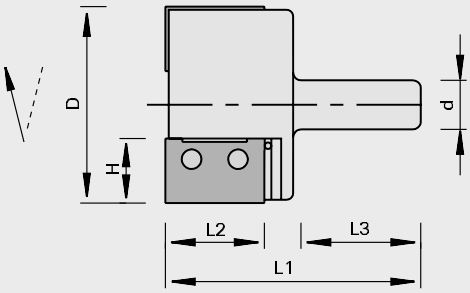
128613

EcoPro-Shank-Type Cutterheads HW

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for profiling of solid woods and wood-based panels

Design

- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods
- shank with internal thread M8 for attachment screw

Advantages

- cutterhead body and knives will be profiled according to customer specifications

Notes

- profile knives can be profiled according to customer specifications
- cutterhead body can be used only for one profile
- please order stop screw separately

Ø D	L2	H	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
62	30	25	25	60	107	2	18000	EP 375	178594 S	178375 S
75	30	30	25	60	107	2	16000	EP 376	178597 S	178376 S
62	40	20	25	60	117	2	18000	EP 377	178592 S	178377 S
75	40	30	25	60	117	2	14000	EP 378	178598 S	178378 S
62	50	20	25	60	127	2	16000	EP 379	178593 S	178379 S
75	50	33	25	60	127	2	12000	EP 380	178600 S	178380 S
85	50	33	25	60	127	2	12000	EP 386	178603 S	178386 S
75	40	32.5	25	60	118	2	12300	EP 478	180332 S	180328 S
85	60	34	25	60	137	2	10000	EP 405	181247 S	181246 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

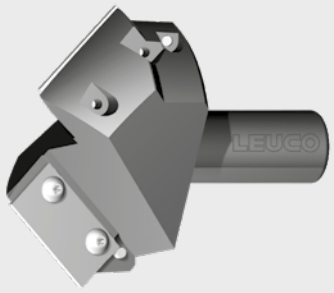
Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	PU	Ident-No.
178375, 178376, 178594, 178597	30,2	30.4	HL Board 06	152586	10	178528 L
178375, 178376, 178594, 178597	30,2	30.4	HL Solid 60	152589	10	179528 L
180328, 180332	41	32.5	HL Board 06	152536	10	180197 L
178377, 178378, 178592, 178598	40,1	30.4	HL Board 06	152586	10	178534 L
178377, 178378, 178592, 178598	40,1	30.4	HL Solid 60	152589	10	179534 L
178379, 178380, 178386, 178593, 178600, 178603	49,9	33	HL Board 06	152586	10	178540 L
178379, 178380, 178386, 178593, 178600, 178603	49,9	33	HL Solid 60	152589	10	179540 L
181246, 181247	61	34	HL Board 06	152536	10	180198 L
178594, 178597	30,2	30.4	HL Board 06 topline	152786	10	179585 L
178375, 178376	30,2	30.4	HL Board 06 topline	152786	10	179586 O
178594, 178597	30,2	30.4	HL Solid 60 topline	152789	10	179659 O
178375, 178376	30,2	30.4	HL Solid 60 topline	152789	10	179660 O
178592, 178598	40,1	30.4	HL Board 06 topline	152786	10	179597 L
178377, 178378	40,1	30.4	HL Board 06 topline	152786	10	179598 O
178592, 178598	40,1	30.4	HL Solid 60 topline	152789	10	179671 S
178377, 178378	40,1	30.4	HL Solid 60 topline	152789	10	179672 S
178593, 178600, 178603	49,9	33	HL Board 06 topline	152786	10	179609 L
178379, 178380, 178386	49,9	33	HL Board 06 topline	152786	10	179610 O
178593, 178600, 178603	49,9	33	HL Solid 60 topline	152789	10	179683 L
178379, 178380, 178386	49,9	33	HL Solid 60 topline	152789	10	179684 L
181247	61	34	HL Board 06 topline	152736	10	181259 S
181246	61	34	HL Board 06 topline	152736	10	181258 S
	[mm]	[mm]				

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M4,5x4,6x9 T15	995195	10	178239 L
Screwdrivers	T15x80	985730	1	171188 L
	[mm]		[pc.]	

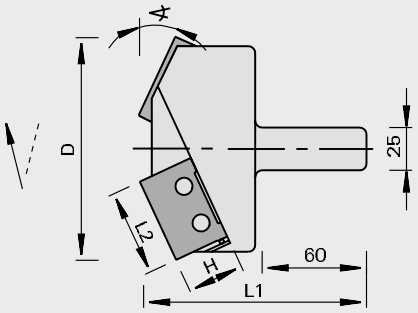
128663

EcoPro-Shank-Type Cutterheads HW - cranked

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application
- CNC routers
- for profiling of solid woods and wood-based panels

Design
- with shear angle
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods
- shank with internal thread M8 for attachment screw

Advantages
- optimum cutting quality even when cutting across the grain of solid woods thanks to shear angle
- cutterhead body and knives will be profiled according to customer specifications

Notes
- profile knives can be profiled according to customer specifications
- cutterhead body can be used only for one profile
- please order stop screw separately

Crank∢	Ø D	L2	H	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
60	100	30	25	104	2	11000	EP 387	178604 S	178387 S
60	100	30	30	107	2	9500	EP 388	178606 S	178388 S
60	100	40	20	110	2	13000	EP 389	178605 S	178389 S
60	100	50	20	119	2	11000	EP 391	178607 S	178391 S
60	125	50	33	127	2	7500	EP 392	178609 S	178392 S
45	100	30	25	104	2	10000	EP 393	178610 S	178393 S
45	100	30	30	107	2	9000	EP 394	178611 S	178394 S
45	100	40	20	110	2	13000	EP 395	178612 S	178395 S
45	125	50	20	114	2	10000	EP 397	178614 S	178397 S
45	125	50	33	121	2	7500	EP 398	178615 S	178398 S
45	125	40	32.5	115	2	11000	EP 496	180335 S	180331 S
25	140	60	34	137	2	10000	EP 410	181249 S	181248 S
45	145	60	34	132	2	10000	EP 408	181251 S	181250 S
60	145	60	34	137	2	10000	EP 407	181253 S	181252 S
75	125	60	34	133	2	10000	EP 406	181255 S	181254 S
[°]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	PU	Ident-No. [L]
178387, 178388, 178393, 178394, 178604, 178606, 178610, 178611	30,2	30.4	HL Board 06	152586	10	178528 L
178387, 178388, 178393, 178394, 178604, 178606, 178610, 178611	30,2	30.4	HL Solid 60	152589	10	179528 L
178389, 178395, 178605, 178612	40,1	30.4	HL Board 06	152586	10	178534 L
178389, 178395, 178605, 178612	40,1	30.4	HL Solid 60	152589	10	179534 L
180331, 180335	41	32.5	HL Board 06	152536	10	180197 L
178391, 178392, 178397, 178398, 178607, 178609, 178614, 178615	49,9	33	HL Board 06	152586	10	178540 L
	[mm]	[mm]				

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	PU	Ident-No. [L]
178391, 178392, 178397, 178398, 178607, 178609, 178614, 178615	49,9	33	HL Solid 60	152589	10	179540 L
181248, 181249, 181250, 181251, 181252, 181253, 181254, 181255	61	34	HL Board 06	152536	10	180198 L
178387, 178388, 178393, 178394	30,2	30.4	HL Board 06 topline	152786	10	179586 O
178604, 178606, 178610, 178611	30,2	30.4	HL Board 06 topline	152786	10	179585 L
178387, 178388, 178393, 178394	30,2	30.4	HL Solid 60 topline	152789	10	179660 O
178604, 178606, 178610, 178611	30,2	30.4	HL Solid 60 topline	152789	10	179659 O
178389, 178395	40,1	30.4	HL Board 06 topline	152786	10	179598 O
178605, 178612	40,1	30.4	HL Board 06 topline	152786	10	179597 L
178389, 178395	40,1	30.4	HL Solid 60 topline	152789	10	179672 S
178605, 178612	40,1	30.4	HL Solid 60 topline	152789	10	179671 S
178391, 178392, 178397, 178398	49,9	33	HL Board 06 topline	152786	10	179610 O
178607, 178609, 178614, 178615	49,9	33	HL Board 06 topline	152786	10	179609 L
178391, 178392, 178397, 178398	49,9	33	HL Solid 60 topline	152789	10	179684 L
178607, 178609, 178614, 178615	49,9	33	HL Solid 60 topline	152789	10	179683 L
181248, 181250, 181252, 181254	61	34	HL Board 06 topline	152736	10	181258 S
181249, 181251, 181253, 181255	61	34	HL Board 06 topline	152736	10	181259 S
	[mm]	[mm]				

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M4,5x4,6x9 T15	995195	10	178239 L
Screwdrivers	T15x80	985730	1	171188 L
	[mm]		[pc.]	

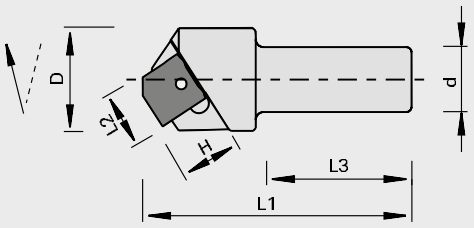
128663

EcoPro-Shank-Type Cutterheads HW for ornamental grooves - Z1

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for cutting of ornamental grooves in solid woods and wood-based panels

Design

- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods
- shank with internal thread M8 for attachment screw
- with shear angle

Advantages

- optimum cutting quality even when cutting across the grain of solid woods thanks to shear angle
- cutterhead body and knives will be profiled according to customer specifications

Notes

- profile knives can be profiled according to customer specifications
- cutterhead body can be used only for one profile
- please order stop screw separately

Ø D	L2	H	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [R] unprofiled
35	20	20	25	60	98.5	1	24000	EP 400	180539 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]	

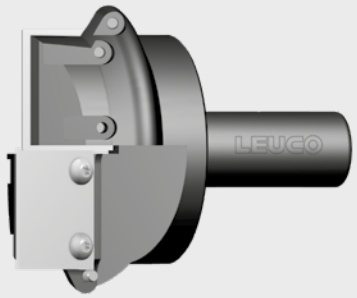
Blanks	B	H	LEUCODUR	Class-No.	PU	Ident-No.
	20,3	30.4	HL Board 06	152586	10	178519 L
	20,3	30.4	HL Solid 60	152589	10	179519 L
	20,3	30.4	HL Board 06 topline	152786	10	179568 O
	20,3	30.4	HL Solid 60 topline	152789	10	179642 S
	[mm]	[mm]				

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M4,5x4,6x9 T15	995195	10	178239 L
Screwdrivers	T15x80	985730	1	171188 L
	[mm]		[pc.]	

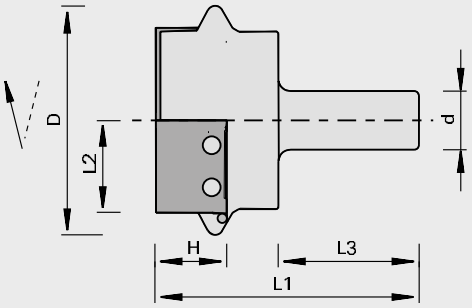
128663

EcoPro-Shank-Type Cutterheads HW for large ornamental grooves - Z2

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for cutting of big ornamental grooves in solid woods and wood-based panels

Design

- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods
- shank with internal thread M8 for attachment screw
- with shear angle

Advantages

- optimum cutting quality even when cutting across the grain of solid woods thanks to shear angle
- cutterhead body and knives will be profiled according to customer specifications

Notes

- profile knives can be profiled according to customer specifications
- cutterhead body can be used only for one profile
- please order stop screw separately

Ø D	L2	H	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
76	30	25	25	60	101	2	18000	EP 401	180298 S	180299 S
76	30	30	25	60	109	2	18000	EP 403	180296 S	180297 S
100	40	30	25	60	112	2	14000	EP 402	178401 S	178402 S
120	50	33	25	60	122	2	9000	EP 404	178403 S	178404 S
143	60	34	25	60	122	2	12000	EP 409	181257 S	181256 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

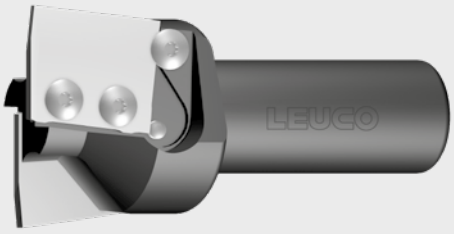
Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	PU	Ident-No.
180296, 180297, 180298, 180299	30,2	30.4	HL Board 06	152586	10	178528 L
180296, 180297, 180298, 180299	30,2	30.4	HL Solid 60	152589	10	179528 L
178401, 178402	40,1	30.4	HL Board 06	152586	10	178534 L
178401, 178402	40,1	30.4	HL Solid 60	152589	10	179534 L
178403, 178404	49,9	33	HL Board 06	152586	10	178540 L
178403, 178404	49,9	33	HL Solid 60	152589	10	179540 L
181256, 181257	61	34	HL Board 06	152536	10	180198 L
180296, 180298	30,2	30.4	HL Board 06 topline	152786	10	179585 L
180297, 180299	30,2	30.4	HL Board 06 topline	152786	10	179586 O
180296, 180298	30,2	30.4	HL Solid 60 topline	152789	10	179659 O
180297, 180299	30,2	30.4	HL Solid 60 topline	152789	10	179660 O
178401	40,1	30.4	HL Board 06 topline	152786	10	179597 L
178402	40,1	30.4	HL Board 06 topline	152786	10	179598 O
178401	40,1	30.4	HL Solid 60 topline	152789	10	179671 S
178402	40,1	30.4	HL Solid 60 topline	152789	10	179672 S
178403	49,9	33	HL Board 06 topline	152786	10	179609 L
178404	49,9	33	HL Board 06 topline	152786	10	179610 O
178403	49,9	33	HL Solid 60 topline	152789	10	179683 L
178404	49,9	33	HL Solid 60 topline	152789	10	179684 L
181257	61	34	HL Board 06 topline	152736	10	181259 S
181256	61	34	HL Board 06 topline	152736	10	181258 S
	[mm]	[mm]				

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M4,5x4,6x9 T15	995195	10	178239 L
Screwdrivers	T15x80	985730	1	171188 L
	[mm]		[pc.]	

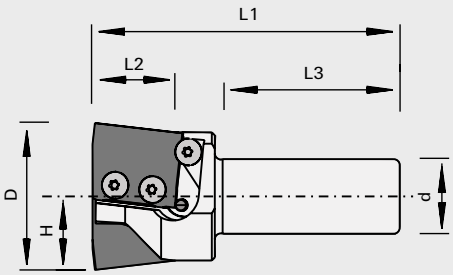
128663

EcoPro-Shank-Type Cutterheads HW - Z2

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for cutting of ornamental grooves in solid woods and wood-based panels

Design

- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods
- shank with internal thread M8 for attachment screw

Advantages

- cutterhead body and knives will be profiled according to customer specifications
- inserts cutting beyond center

Notes

- profile knives can be profiled according to customer specifications
- cutterhead body can be used only for one profile
- please order stop screw separately

Ø D	L2	H	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
44	28	25	25	60	103.5	2	24000	EP 399	181839 S	181838 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks	B	H	LEUCODUR	Class-No.	PU	Ident-No.
For all	30,2	30.4	HL Board 06	152586	10	178528 L
For all	30,2	30.4	HL Solid 60	152589	10	179528 L
181839	30,2	30.4	HL Board 06 topline	152786	10	179585 L
181838	30,2	30.4	HL Board 06 topline	152786	10	179586 O
181839	30,2	30.4	HL Solid 60 topline	152789	10	179659 O
181838	30,2	30.4	HL Solid 60 topline	152789	10	179660 O
	[mm]	[mm]				

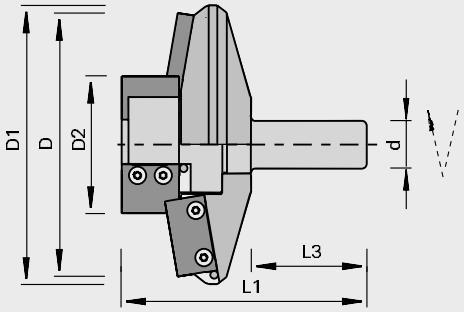
Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M4x5,9 T15	995195	10	167966 L
Screwdrivers	T15x80	985730	1	171188 L
	[mm]		[pc.]	

128913

EcoPro-Shank-Type Cutterheads HW for panel raising top side

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for profiling of solid woods and wood-based panels

Design

- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods
- shank with internal thread M8 for attachment screw

Advantages

- optimum cutting quality even when cutting across the grain of solid woods
- for panel raising profiles
- cutterhead body and knives will be profiled according to customer specifications

Notes

- profile knives can be profiled according to customer specifications
- cutterhead body can be used only for one profile
- please order stop screw separately

Ø D	Ø D1	Ø D2	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
140	150	82	25	60	122	2+2	7600	EP 751 (EP 754+757)	179369 S	178751 S
137	145	71.6	25	60	122	2+2	11500	EP 752 (EP 755+758)	179370 S	178752 S
137	145	71.2	25	60	127	2+2	11500	EP 753 (EP 756+758)	179371 S	178753 S
142	144	82	25	60	123	2+2	10000	EP 849 (EP 754+855)	179372 S	178849 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	PU	Ident-No.
For all	30,2	30.4	HL Board 06	152586	10	178528 L
For all	30,2	30.4	HL Solid 60	152589	10	179528 L
178751, 178752, 178753, 179369, 179370, 179371	40,1	30.4	HL Board 06	152586	10	178534 L
178751, 178752, 178753, 179369, 179370, 179371	40,1	30.4	HL Solid 60	152589	10	179534 L
178849, 179372	49,9	33	HL Board 06	152586	10	178540 L
178849, 179372	49,9	33	HL Solid 60	152589	10	179540 L
179369, 179370, 179371, 179372	30,2	30.4	HL Board 06 topline	152786	10	179585 L
178751, 178752, 178753, 178849	30,2	30.4	HL Board 06 topline	152786	10	179586 O
179369, 179370, 179371, 179372	30,2	30.4	HL Solid 60 topline	152789	10	179659 O
178751, 178752, 178753, 178849	30,2	30.4	HL Solid 60 topline	152789	10	179660 O
179369, 179370, 179371	40,1	30.4	HL Board 06 topline	152786	10	179597 L
178751, 178752, 178753	40,1	30.4	HL Board 06 topline	152786	10	179598 O
179369, 179370, 179371	40,1	30.4	HL Solid 60 topline	152789	10	179671 S
178751, 178752, 178753	40,1	30.4	HL Solid 60 topline	152789	10	179672 S
179372	49,9	33	HL Board 06 topline	152786	10	179609 L
178849	49,9	33	HL Board 06 topline	152786	10	179610 O
179372	49,9	33	HL Solid 60 topline	152789	10	179683 L
178849	49,9	33	HL Solid 60 topline	152789	10	179684 L
	[mm]	[mm]				

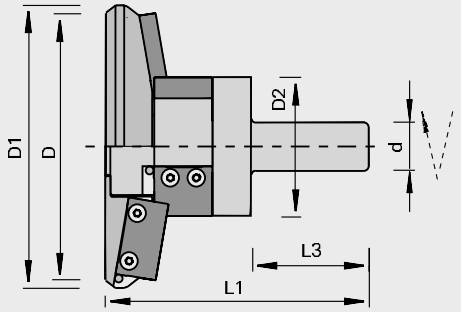
Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M4,5x4,6x9 T15	995195	10	178239 L
Screwdrivers	T15x80	985730	1	171188 L
	[mm]		[pc.]	

128913

EcoPro-Shank-Type Cutterheads HW for panel raising bottom side

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for profiling of solid woods and wood-based panels

Design

- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods
- shank with internal thread M8 for attachment screw

Advantages

- optimum cutting quality even when cutting across the grain of solid woods
- for panel raising profiles
- cutterhead body and knives will be profiled according to customer specifications

Notes

- profile knives can be profiled according to customer specifications
- cutterhead body can be used only for one profile
- please order stop screw separately

Ø D	Ø D1	Ø D2	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
142	144	82	25	60	143	2+2	10000	EP 853 (EP 854+855)	178853 S	179373 S
150	140	82	25	60	143	2+2	7600	EP 848 (EP 854+757)	178848 S	179374 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

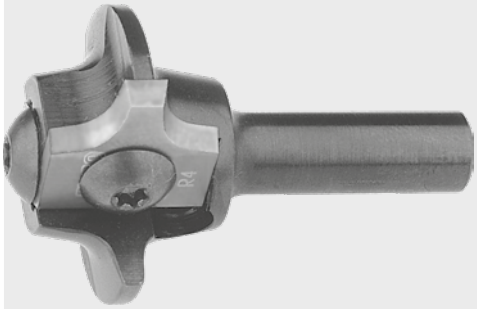
Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	PU	Ident-No.
For all	30,2	30.4	HL Board 06	152586	10	178528 L
For all	30,2	30.4	HL Solid 60	152589	10	179528 L
178848, 179374	40,1	30.4	HL Board 06	152586	10	178534 L
178848, 179374	40,1	30.4	HL Solid 60	152589	10	179534 L
178853, 179373	49,9	33	HL Board 06	152586	10	178540 L
178853, 179373	49,9	33	HL Solid 60	152589	10	179540 L
178848, 178853	30,2	30.4	HL Board 06 topline	152786	10	179585 L
179373, 179374	30,2	30.4	HL Board 06 topline	152786	10	179586 O
178848, 178853	30,2	30.4	HL Solid 60 topline	152789	10	179659 O
179373, 179374	30,2	30.4	HL Solid 60 topline	152789	10	179660 O
178848	40,1	30.4	HL Board 06 topline	152786	10	179597 L
179374	40,1	30.4	HL Board 06 topline	152786	10	179598 O
178848	40,1	30.4	HL Solid 60 topline	152789	10	179671 S
179374	40,1	30.4	HL Solid 60 topline	152789	10	179672 S
178853	49,9	33	HL Board 06 topline	152786	10	179609 L
179373	49,9	33	HL Board 06 topline	152786	10	179610 O
178853	49,9	33	HL Solid 60 topline	152789	10	179683 L
179373	49,9	33	HL Solid 60 topline	152789	10	179684 L
	[mm]	[mm]				

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M4,5x4,6x9 T15	995195	10	178239 L
Screwdrivers	T15x80	985730	1	171188 L
	[mm]		[pc.]	

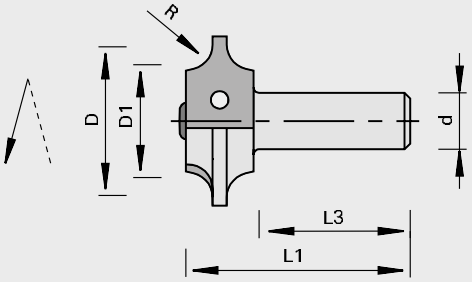
128310

Rounding Cutterheads HW - HOLZ-HER

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- edgebanders HOLZ-HER
- for rounding and chamfering of solid wood, veneer and plastic edge bands

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 05
- n max = 30,000 min-1

Advantages

- same cutter head body for radius 1 - 5 mm and chamfer

Notes

- clamping elements: draw-in collet chuck

R	Ø D	Ø D1	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
2,0	30.8	18,85	8,0	22	43	2	170315 L	170316 C
3,0	30.8	18,85	8,0	22	43	2	170317 C	170318 C
4,0	30.8	18,85	8,0	22	43	2		170320 C
5,0	30.8	18,85	8,0	22	43	2		170322 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

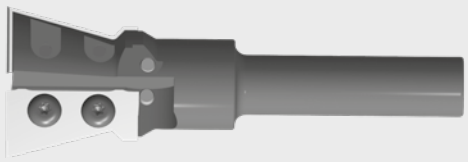
Knives	Chamfer◁	R	B	H	S	Class-No.	PU	Ident-No.
Chamfering Knives	45		16	17.5	2.0	151545	10	170329 L
Radius Knives		1,0	16	17.5	2.0	151545	10	186745 L
Radius Knives		2,0	16	17.5	2.0	151545	10	163489 L
Radius Knives		3,0	16	17.5	2.0	151545	10	163490 L
Radius Knives		4,0	16	17.5	2.0	151545	10	163491 L
Radius Knives		5,0	16	17.5	2.0	151545	10	163492 L
	[°]	[mm]	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M4x5,9 T15	995195	10	167966 L
Screwdrivers	T15	985730	1	163161 L
	[mm]		[pc.]	

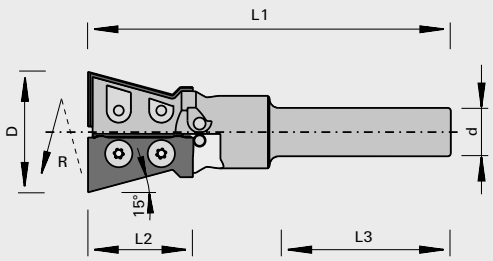
128610

Dove-tail Cutterheads with HW Knives

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- joinery machines Weinmann
- for joining of construction timber and for machining of solid wood

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Solid 20
- n max = 17,800 min-1

Advantages

Notes

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]
40	34,7	16	56	120	2	185617 L
[mm]	[mm]	[mm]	[mm]	[mm]		

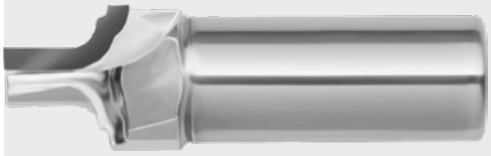
Knives	B	H	S	Class-No.	PU	Ident-No.
without serration	34,9	18.6	2.0	151587	2	185363 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M4x5,9 T15	995195	10	167966 L
Screwdrivers	T15	985730	1	163161 L
	[mm]		[pc.]	

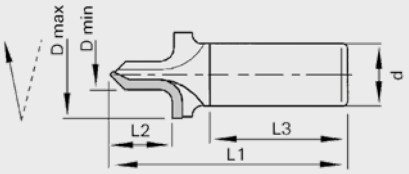
229063 / 229363

LEUCODIA Profiler

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for profiling of raw and laminated panels

Design

- resharpenable area 2.0mm
- with shear angle

Advantages

- overlap-free cut thanks to continuons PCD tablets
- optimum cutting quality in MDF thanks to polished cutting edge face
- optimum edge quality thanks to shear angle

Notes

- further options are possible at a surcharge: opposing shear angle version (Z = 1+1), Z = 2 version, different shank length, topline with ultra fine eroded cutting edge

Ø Dmax	ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
35	12	25	12	45	85	1	18000	DP1A
35	12	25	16	45	85	1	24000	DP1A
35	12	25	20	45	95	1	24000	DP1A
35	12	25	25	55	95	1	24000	DP1A
26	10	25	12	35	75	1	24000	DP1AK
26	10	25	16	45	85	1	24000	DP1AK
26	10	25	20	45	85	1	24000	DP1AK
26	10	25	25	55	95	1	24000	DP1AK
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]

Ø Dmax	ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
35	12	12.5	25	55	90	1	24000	DP1M
35	12	12.5	20	45	90	1	24000	DP1M
35	12	12.5	16	45	80	1	24000	DP1M
35	12	12.5	12	45	70	1	24000	DP1M
26	10	12.5	25	55	90	1	24000	DP1MK
26	10	12.5	20	45	80	1	24000	DP1MK
26	10	12.5	16	45	80	1	24000	DP1MK
26	10	12.5	12	35	70	1	24000	DP1MK
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]

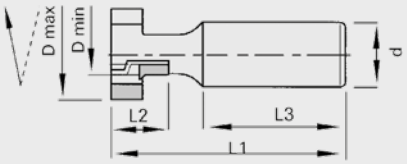
229063 / 229363

LEUCODIA Profiler - T-groove profiles

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application
- CNC routers
- for profiling of raw and laminated panels

Design
- resharpenable area 2.0 mm
- with shear angle

Advantages
- overlap-free cut thanks to continuons PCD tablets
- optimum cutting quality in MDF thanks to polished cutting edge face
- optimum edge quality thanks to shear angle

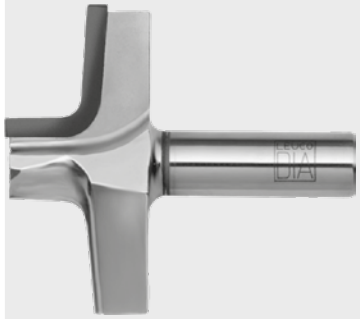
Notes
- further options are possible at a surcharge: opposing shear angle version (Z = 1+1), Z = 2 version, different shank length, topline with ultra fine eroded cutting edge

Ø Dmax	ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
35	10	22	25	55	90	2+1	24000	DP1B
35	10	22	20	45	80	2+1	24000	DP1B
35	10	22	16	45	80	2+1	24000	DP1B
35	10	22	12	35	70	2+1	15700	DP1B
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]

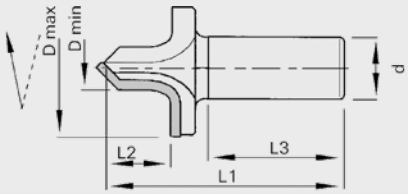
229063 / 229363

LEUCODIA Profiler - large profile depth

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application
- CNC routers
- for profiling of raw and laminated panels

Design
- resharpenable area 2.0 mm
- with shear angle

Advantages
- overlap-free cut thanks to continuons PCD tablets
- optimum cutting quality in MDF thanks to polished cutting edge face
- optimum edge quality thanks to shear angle

Notes
- further options are possible at a surcharge: opposing shear angle version (Z = 1+1), Z = 2 version, different shank length, topline with ultra fine eroded cutting edge

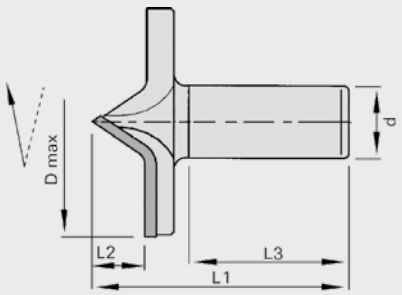
Ø Dmax	ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
55	16	15	25	55	100	1	24000	DP1CK
55	16	15	20	45	90	1	24000	DP1CK
55	16	15	16	45	90	1	24000	DP1CK
75	18	30	25	55	120	1	24000	DP1D
75	18	30	20	45	110	1	20500	DP1D
75	18	30	16	45	110	1	11200	DP1D
75	18	15	25	55	100	1	17000	DP1DK
75	18	15	20	45	90	1	12900	DP1DK
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]

229063 / 229363

LEUCODIA Profiler - panel raising profiles

Product

Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for profiling of raw and laminated panels

Design

- resharpenable area 2.0 mm
- with shear angle

Advantages

- overlap-free cut thanks to continuons PCD tablets
- optimum cutting quality in MDF thanks to polished cutting edge face
- optimum edge quality thanks to shear angle

Notes

- further options are possible at a surcharge: opposing shear angle version (Z = 1+1), Z = 2 version, different shank length, topline with ultra fine eroded cutting edge

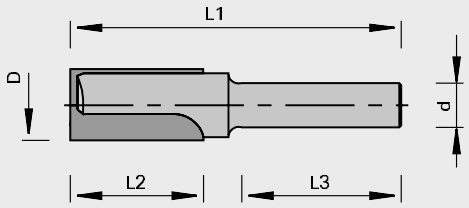
Ø Dmax	ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
55	18	25	25	55	110	1	24000	DP1F
55	18	25	20	45	100	1	22000	DP1F
55	18	25	16	45	100	1	12000	DP1F
79		18	25	55	88	1	22000	DP1G
79		18	20	45	78	1	22000	DP1G
79		18	16	45	78	1	15000	DP1G
99		13	25	55	98	1	18000	DP1H
99		13	20	45	88	1	16300	DP1H
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]

129415

Grooving Cutters HW-tipped - Z=2

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable routers
- for jointing, rabbeting and grooving in solid woods

Design

- cutting edges parallel to cutter axis
- HW-tipped

Advantages

Notes

- face cutting design allows plunge-cuts
- clamping elements: draw-in collet chuck

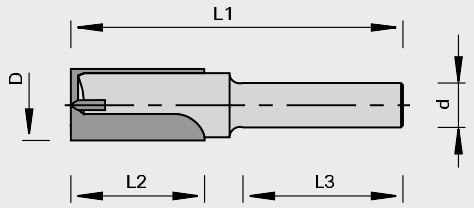
Ø D	L2	Ø d	L1	Z	Ident-No.
3.0	6,0	6,0	39	2	172430 O
4.0	8,0	6,0	40	2	164193 O
4.0	8,0	8,0	40	2	172431 O
5.0	12	6,0	42	2	164194 O
5.0	12	8,0	42	2	172432 C
6.0	14	6,0	49	2	160364 L
6.0	16	8,0	46	2	167521 L
8.0	20	6,0	50	2	160365 C
8.0	20	8,0	48	2	167522 L
10	20	8,0	48	2	167523 L
12	20	8,0	48	2	167524 L
14	20	6,0	48	2	160368 O
14	20	8,0	48	2	167525 C
16	20	8,0	48	2	167526 L
18	20	8,0	48	2	167527 O
20	20	8,0	48	2	167528 L
[mm]	[mm]	[mm]	[mm]		

129415

Grooving Cutters HW-tipped - Z=2 with plunge tip

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application
- portable routers
- for jointing, rabbeting and grooving in solid woods

Design
- brazed VHW cutting edge for ØD < 8 mm
- cutting edges parallel to cutter axis
- HW-tipped

Advantages

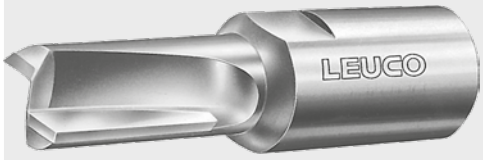
Notes
- face cutting design allows plunge-cuts
- clamping elements: draw-in collet chuck

Ø D	L2	Ø d	L1	Z		Ident-No.
3.0	8,0	8,0	55	2		167529 L
4.0	10	8,0	55	2		167530 L
5.0	12	8,0	55	2		167531 L
6.0	14	8,0	55	2		167532 L
8.0	20	8,0	55	2		167533 L
8.0	30	8,0	90	2		180823 L
10	20	8,0	60	2		167535 L
10	40	10	97	2		167552 L
12	20	8,0	60	2		167536 L
12	40	10	97	2		167553 L
16	20	8,0	70	2		167538 O
18	20	8,0	70	2		167539 L
[mm]	[mm]	[mm]	[mm]			

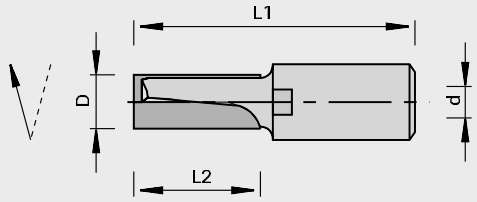
129425

Grooving Cutters HW-tipped - Z=2 with internal thread

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application
- portable routers
- for jointing, rabbeting and grooving in solid woods

Design
- cutting edges parallel to cutter axis
- internal thread allows direct attachment on the machine spindle

Advantages

Notes
- face cutting design allows plunge-cuts

Ø D	L2	Ø d	L1	Z		Ident-No.
18	60	M12x1	92	2	ELU, Striffler	178968 L
[mm]	[mm]	[mm]	[mm]			

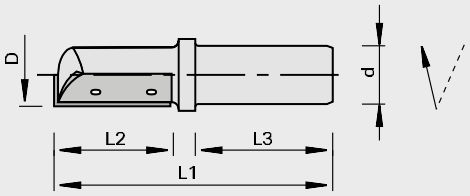
128415

Grooving Cutters with HW Turnover Knives - Z=1

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis

Advantages

Notes

- face cutting design allows plunge-cuts to Ø 12.7 mm
- clamping elements: draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
8.0	20	8,0	30	60	1	175673 L
10	20	8,0	30	60	1	175674 C
12	20	8,0	30	60	1	175675 C
14	30	8,0	30	70	1	175676 C
10	25	10	40	75	1	175678 L
12	30	10	40	80	1	175679 L
12.7	30	12,7	40	80	1	175672 C
14	30	10	40	80	1	175680 C
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
for Ø D = 8	20	4.1	1.1	150535	10	173480 L
for Ø D = 10+12	20	5.5	1.1	150535	10	173481 L
for Ø D = 10	25	5.5	1.1	150535	10	173793 L
for Ø D = 12+12,7+14	30	5.5	1.1	150535	10	173482 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Clamping Wedges	B=20	175673	925500	2	175722 L
Clamping Wedges	B=20	175674	925500	2	175723 S
Clamping Wedges	B=25	175678	925500	2	175724 C
Clamping Wedges	B=20	175675	925500	2	175725 S
Clamping Wedges	B=30	175672	925500	2	175727 C
Clamping Wedges	B=30	175679	925500	2	175726 C
Clamping Wedges	B=30	175676, 175680	925500	2	175728 C
Head Cap Screws	M2,5x3 T8	175673	995115	10	168237 L
Head Cap Screws	M2,5x4 T8	175674, 175678	995115	10	168238 L
Head Cap Screws	M3x5,5 T8	175672, 175675, 175676, 175679, 175680	995115	10	168239 L
Screwdriver with flag	T8	For all	985730	1	166499 L
	[mm]			[pc.]	

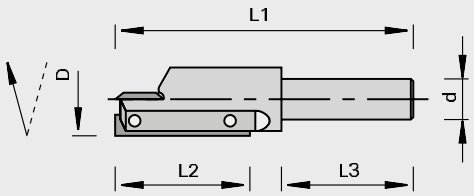
128415

Grooving Cutters with HW Turnover Knives - Z=1 with plunge tip

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application
- portable routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels

Design
- cutting edges parallel to cutter axis

Advantages

Notes
- face cutting design allows plunge-cuts
- clamping elements: draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	30	8,0	30	71	1+1	175689 C
18	30	8,0	30	71	1+1	175690 C
20	30	8,0	30	71	1+1	175691 C
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Turnover Knives	12	12	1.5	150515	10	003080 L
Mini Turnover Knives	30	5.5	1.1	150535	10	173482 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Clamping Wedges	B=30	175689	925500	2	169280 C
Clamping Wedges	B=30	175691	925500	2	169282 C
Clamping Wedges	B=30	175690	925500	2	169281 O
Head Cap Screws	M3,5x6,5 T15	175691	995115	10	163223 L
Head Cap Screws	M3,5x5,5 T15	175690, 175689	995115	10	168236 L
Round Head Screws	M4x5,9 T15	For all	995195	10	167966 L
Screwdrivers	T15	For all	985730	1	163161 L
	[mm]			[pc.]	

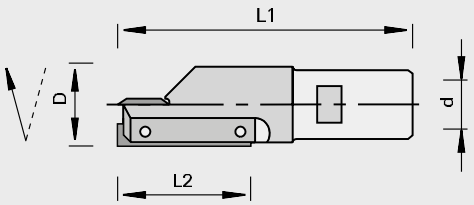
128425

Grooving Cutters with HW Turnover Knives - Z=1 with plunge tip and internal thread

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- internal thread allows direct attachment on the machine spindle

Advantages

Notes

- face cutting design allows plunge-cuts

Ø D	L2	Ø d	L1	Z	Ident-No.
18	30	M10	65	1+1	175698 C
20	30	M10	65	1+1	175699 C
16	30	M12x1	65	1+1	175701 C
18	30	M12x1	65	1+1	175702 C
20	30	M12x1	65	1+1	175703 C
22	30	M12x1	65	1+1	175704 C
[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Turnover Knives	12	12	1.5	150515	10	003080 L
Mini Turnover Knives	30	5.5	1.1	150535	10	173482 L
	[mm]	[mm]	[mm]		[pc.]	

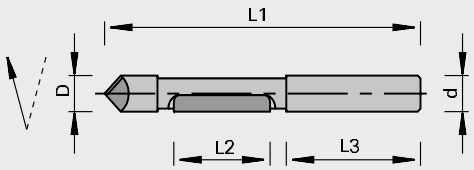
Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Clamping Wedges	B=30	175697, 175701	925500	2	169280 C
Clamping Wedges	B=30	175702, 175698	925500	2	169281 O
Clamping Wedges	B=30	175699, 175703	925500	2	169282 C
Clamping Wedges	B=30	175704, 175700	925500	2	169283 S
Head Cap Screws	M3,5x5,5 T15	175697, 175702, 175701, 175698	995115	10	168236 L
Head Cap Screws	M3,5x6,5 T15	175704, 175700, 175699, 175703	995115	10	163223 L
Round Head Screws	M4x5,9 T15	For all	995195	10	167966 L
Screwdrivers	T15	175704, 175700, 175702, 175701, 175699, 175698, 175703	985730	1	163161 L
	[mm]			[pc.]	

129418

Plunge Cutters HW-tipped

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable routers
- for cutting of cut-outs in solid woods

Design

- cutting edges parallel to cutter axis

Advantages

Notes

- face cutting design allows plunge-cuts
- clamping elements: draw-in collet chuck

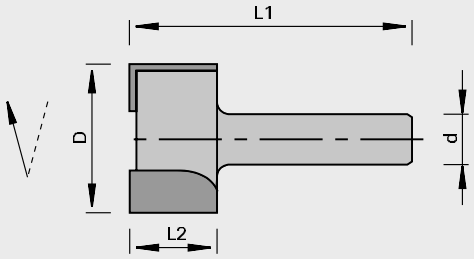
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
6.0	19	6,0	25	65	1+1	006453 L
6.35	20	6,35	25	63	1+1	167661 O
[mm]	[mm]	[mm]	[mm]	[mm]		

129215

Edge Trimming Cutters HW-tipped

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable routers
- for jointing and rabbeting in solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- face cutting and peripheral cutting

Advantages

Notes

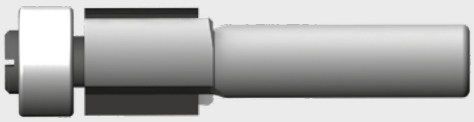
- clamping elements: draw-in collet chuck

Ø D	L2	Ø d	L1	Z	Ident-No.
24	16	6,0	41	2	167573 C
31	16	6,0	41	2	167574 S
20	16	8,0	41	2	160357 S
24	16	8,0	41	2	167575 C
31	16	8,0	41	2	167576 C
24	16	10	41	2	167577 C
31	16	10	41	2	167578 S
24	16	12	41	2	167579 C
31	16	12	41	2	167580 C
[mm]	[mm]	[mm]	[mm]		

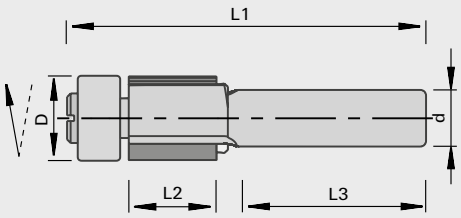
229226

Edge Trimming Cutters DP-tipped with thrust ring

Product



Drawing



Polycrystalline diamond [DP]

MAN

Machine / Application
- portable routers
- for flush cutting of solid wood edge bands, plastic edge bands and copying in solid woods, wood-based and abrasive materials

Design
- DP-tipped
- cutting edges parallel to cutter axis
- thrust ring with ball-bearing

Advantages
- very long edge lives, even in abrasive workpiece materials

Notes
- template copying
- clamping elements: draw-in collet chuck

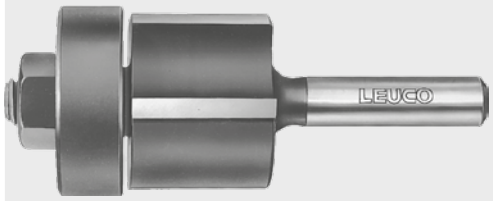
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
12	12,4	8,0	25	50.7	2	187371 L
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Ball Bearings	Ø12	997500	1	167923 L
	[mm]		[pc.]	

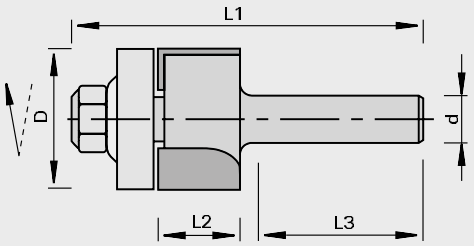
129216

Edge Trimming Cutters HW-tipped with thrust ring

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application
- portable routers
- for flush-cutting of solid wood, veneer and plastic edge bands and copying in solid woods and wood-based panels

Design
- cutting edges parallel to cutter axis
- flush-cutting with ball-bearing mounted rub collar

Advantages

Notes
- template copying
- clamping elements: draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
12.7	25	8,0	25	58	2	180822 L
22	16	6,35	25	58	2	167585 S
22	16	8,0	25	58	2	164215 O
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Ball Bearings	12,7x5x4,76	997500	1	164920 L
Ball Bearings	22x7,5x6,35	997500	1	164228 L
Ball Bearings	22x7,5x8	997500	1	180838 L
Hexagon Nuts	M4 DIN EN ISO 4032	995210	1	009631 L
Hexagon Nuts	M6 DIN EN ISO 4032	995210	1	009633 L
	[mm]		[pc.]	

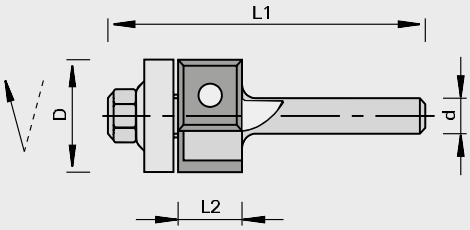
128216

Edge Trimming Cutters with HW Turnover Knives with thrust ring

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable routers
- for flush-cutting of solid wood, veneer and plastic edge bands and copying in solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- flush-cutting with ball-bearing mounted rub collar

Advantages

Notes

- template copying
- clamping elements: draw-in collet chuck

Ø D	L2	Ø d	L1	Z	Ident-No.
19	12	8,0	56	2	164916 L
19	30	8,0	74	2	183398 L
19	50	12	112	2	183399 L
[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	12	12	1.5	150515	10	003080 L
	30	12	1.5	150515	10	003083 L
	50	12	1.5	150515	10	003085 L
	[mm]	[mm]	[mm]		[pc.]	

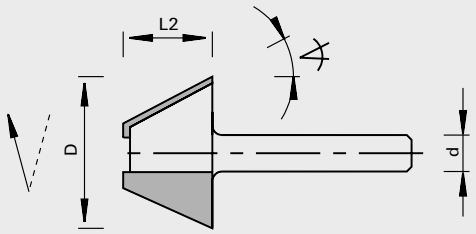
Spare parts	Dimension	Class-No.	PU	Ident-No.
Ball Bearings	19x6x6	997500	1	164922 L
Round Head Screws	M4x5,9 T15	995195	10	167966 L
Screwdrivers	T15	985730	1	163161 L
	[mm]		[pc.]	

129315

Edge Chamfering Cutters HW-tipped

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application
- portable routers
- for chamfering in solid woods and wood-based panels

Design
- cutting edges parallel to cutter axis

Advantages

Notes
- clamping elements: draw-in collet chuck

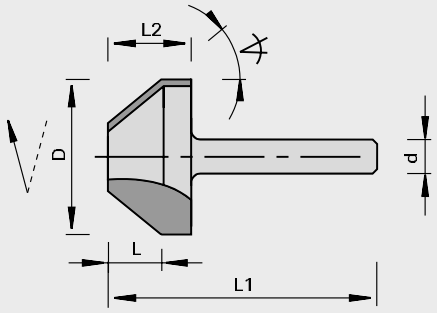
Chamfer	Ø D	L2	Ø d	Z	Ident-No.
15	24	12	8,0	2	164220 O
30	24	12	8,0	2	164221 O
[°]	[mm]	[mm]	[mm]		

129315

Edge Chamfering Cutters HW-tipped - chamfer angle 45°, changeable shank design

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application
- portable routers
- for chamfering in solid woods and wood-based panels

Design
- cutting edges parallel to cutter axis
- changeable shank design

Advantages

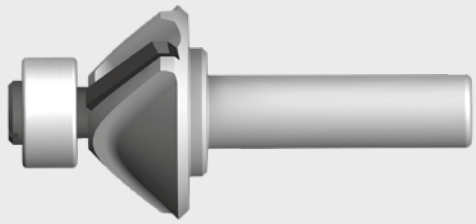
Notes
- clamping elements: draw-in collet chuck

Chamfer	Ø D	L2	L	Ø d	Z	Ident-No.
45	31	15	10	6,0	2	167589 C
45	31	15	10	8,0	2	167591 C
45	31	15	10	10	2	167592 C
45	31	15	10	12	2	167593 C
[°]	[mm]	[mm]	[mm]	[mm]		

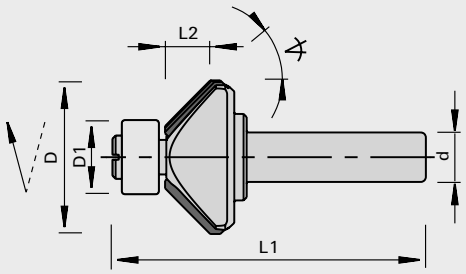
229236

Edge Chamfering Cutters DP-tipped with thrust ring

Product



Drawing



LEUCO DUR

Polycrystalline diamond [DP]

MAN

Machine / Application
- portable routers
- for chamfering of solid wood edge bands, plastic edge bands and copying in solid woods, wood-based and abrasive materials

Design
- DP-tipped
- cutting edges parallel to cutter axis
- thrust ring with ball-bearing

Advantages
- very long edge lives, even in abrasive workpiece materials

Notes
- template copying with chamfer
- clamping elements: draw-in collet chuck

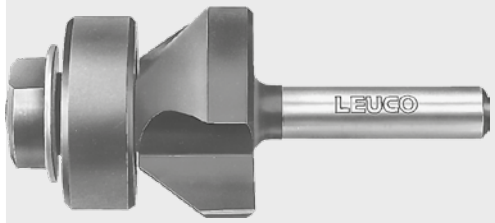
Cham-fer◁	Ø D	Ø D1	L2	Ø d	L1	Z	Ident-No.
45	25	12	7,3	8	50.7	2	187372 L
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Ball Bearings	Ø12	997500	1	167923 L
	[mm]		[pc.]	

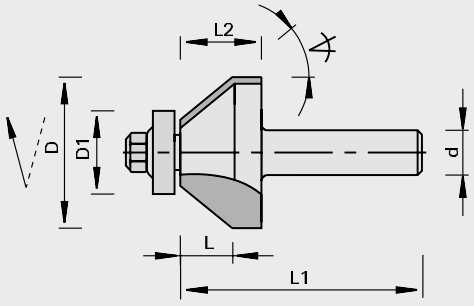
129316

Edge Chamfering Cutters HW-tipped with thrust ring

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application
- portable routers
- for chamfering of solid wood, veneer and plastic edge bands and copying in solid woods and wood-based panels

Design
- cutting edges parallel to cutter axis
- flush-cutting with ball-bearing mounted rub collar

Advantages

Notes
- template copying with chamfer
- clamping elements: draw-in collet chuck

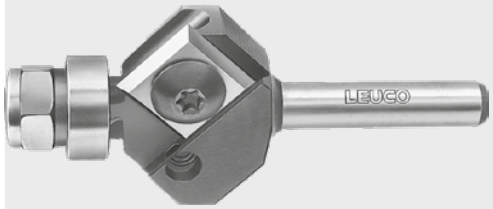
Cham-fer◁	Ø D	Ø D1	L2	L	Ø d	L1	Z	Ident-No.
45	25	15,9	12	6.0	6,0	37	2	160361 O
45	25	15,9	12	6.0	8,0	37	2	167597 L
30	26	15,9	12	12	8,0	37	2	167596 O
[°]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Ball Bearings	15,9x5x6,35	997500	1	164921 L
Hexagon Nuts	M6 DIN EN ISO 4032	995210	1	009633 L
	[mm]		[pc.]	

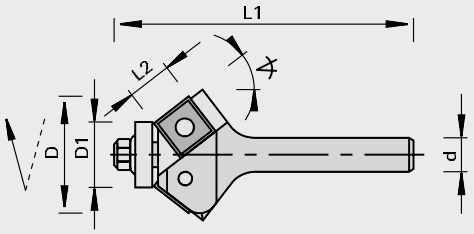
128316

Edge Chamfering Cutters with HW Turnover Knives with thrust ring

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable routers
- for chamfering of solid wood, veneer and plastic edge bands and copying in solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- flush-cutting with ball-bearing mounted rub collar

Advantages

Notes

- template copying
- clamping elements: draw-in collet chuck

Chamfer◁	Ø D	Ø D1	L2	Ø d	L1	Z	Ident-No.
45	29	12,7	12	8,0	64	2	185493 L
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		

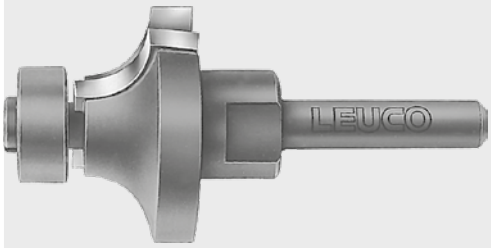
Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	12	12	1.5	150515	10	003080 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Ball Bearings	13x5x4	997500	1	185494 L
Round Head Screws	M4x5,9 T15	995195	10	167966 L
Screwdrivers	T15	985730	1	163161 L
	[mm]		[pc.]	

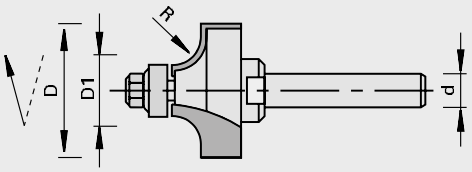
129616

Rounding Cutters HW-tipped with thrust ring

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable routers
- for rounding of solid wood, veneer and plastic edge bands as well as solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- rounding with ball-bearing mounted rub collar

Advantages

Notes

- template copying
- clamping elements: draw-in collet chuck

R	Ø D	Ø D1	Ø d	Z		Ident-No.
2,0	16	12	8,0	2		180824 L
2,0	18	12	6,0	2	EBM	816995 L
3,0	18	12	6,0	2		167598 L
3,0	18	12	6,35	2		167599 C
3,0	18	12	8,0	2		167600 L
4,0	20	12	6,0	2		167601 C
4,0	20	12	6,35	2		167602 C
4,0	20	12	8,0	2		167603 L
5,0	22	12	6,0	2		167604 C
5,0	22	12	6,35	2		167605 C
5,0	22	12	8,0	2		167606 L
6,3	24	12	6,35	2		167608 C
6,3	24.6	12	6,0	2		167607 C
6,3	24.6	12	8,0	2		167609 L
8,0	30	14	6,0	2		167610 C
8,0	30	14	6,35	2		167611 S
8,0	30	14	8,0	2		167612 L
9,5	33	14	6,0	2		167613 C
9,5	33	14	6,35	2		167614 S
9,5	33	14	8,0	2		167615 L
12,7	39.4	14	6,0	2		167616 C
12,7	39.4	14	6,35	2		167617 S
12,7	39.4	14	8,0	2		167618 L
[mm]	[mm]	[mm]	[mm]			

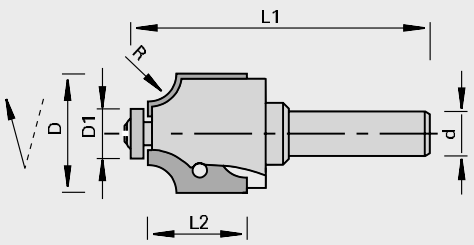
Spare parts	Dimension	Class-No.	PU	Ident-No.
Ball Bearings	Ø12	997500	1	167923 L
Ball Bearings	Ø14	997500	1	169314 L
	[mm]		[pc.]	

128616

Rounding and Quarter Round Cutterheads HW

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable routers
- for rounding and quarter round cutting in solid woods and wood-based panels

Design

- with ball-bearing spacer ring
- profiled turnover knives
- face cutting and peripheral cutting

Advantages

Notes

- included in delivery: 2 ball bearing sets (see D1)
- included in delivery Ident-No. 180947: 1 ball bearing set
- exchangeable ball bearing sets: 1. with big spacer set / 2. with small spacer set/ 3. without spacer set

R	Ø D	Ø D1	L2	Ø d	L1	Z	Ident-No.
2,0	26	22	19.5	8,0	70	2	180947 C
3,0	26	20/18	19.5	8,0	70	2	180948 C
4,0	26	18/14	19.5	8,0	70	2	180949 C
5,0	26	16/12	19.5	8,0	70	2	180950 C
6,0	32	20/16	26	8,0	76	2	180951 C
8,0	32	16/12	26	8,0	76	2	180952 C
10	36	16/12	30	8,0	80	2	180953 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Knives	R	B	H	S	Class-No.	PU	Ident-No.
	2,0	19,5	9.0	1.5	151555	2	180991 O
	3,0	19,5	9.0	1.5	151555	2	180992 O
	4,0	19,5	9.0	1.5	151555	2	180993 O
	5,0	19,5	9.0	1.5	151555	2	180994 O
	6,0	26	12.5	1.5	151555	2	180995 O
	8,0	26	12.5	1.5	151555	2	180996 O
	10	30	14.5	1.5	151555	2	180997 O
	[mm]	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Ball Bearings	Ø12	997500	1	167923 L
Ball Bearings	Ø14	997500	1	169314 L
Ball Bearings	Ø16	997500	1	180985 O
Ball Bearings	Ø18	997500	1	180986 O
Ball Bearings	Ø20	997500	1	180987 O
Ball Bearings	Ø22	997500	1	180988 O
Head Cap Screws	M4x6 T15	995115	10	180989 O
Round Head Screws	M4x5,9 T15	995195	10	167966 L
Cover Screws	M3,5	995192	10	180990 O
Screwdrivers	T15	985730	1	163161 L
	[mm]		[pc.]	

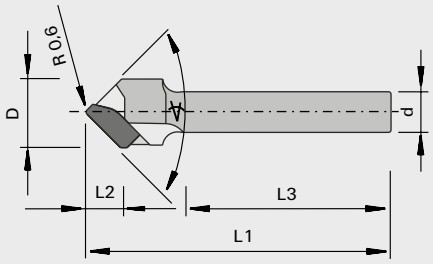
229065

V-Groove Cutter DP

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

MAN

Machine / Application

- Portable routers, hand-operated CNC portable routers (e.g. Shaper Origin), portable CNC router (e.g. Goliath CNC)
- 90° V groove cuttings or profile grooves (R=0.6 in the bottom of the groove) as well as chamfering (45°) in solid wood, wood-based materials and thermosets

Design

- cutting material: DP
- topline design
- resharpening area 2 mm

Advantages

- very long edge lives particularly in hard panel materials
- optimal cutting quality thanks to specialized blade preparation

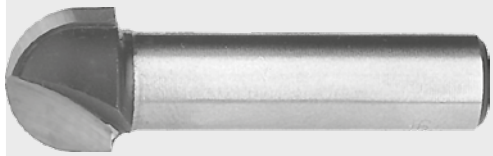
Notes

Ø D	L2	L3	Ø d	L1	Z	◁	Ident-No.
14	7,0	41.2	8,0	60	1	90	187846 L
[mm]	[mm]	[mm]	[mm]	[mm]		[°]	

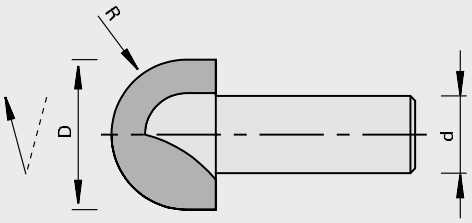
129615

Concave Cutters HW-tipped

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable routers
- for cutting of coves and semi-coves in solid woods and wood-based panels

Design

- 2 cutting edges parallel to cutter axis

Advantages

Notes

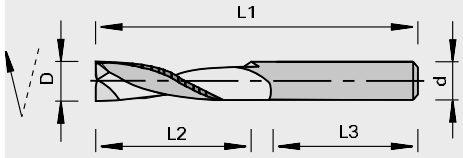
- clamping elements: collet chuck

R	Ø D	Ø d	L1	Z	Ident-No.
4,75	9.5	8,0	60	2	167633 O
5,5	11	8,0	60	2	167634 O
6,35	12.7	8,0	60	2	167635 L
[mm]	[mm]	[mm]	[mm]		

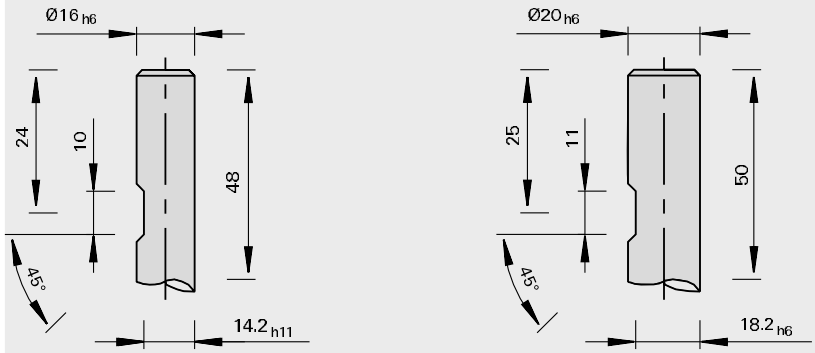
Solid Tungsten Carbide Shank-Type Cutters

Shank design for finishing cutter with chip breakers Class-No. 129460

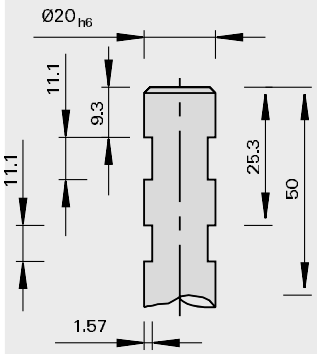
Cylindrical shank without clamping surface



For clamping in spacer sleeves according to DIN 6359 also called Weldon chuck

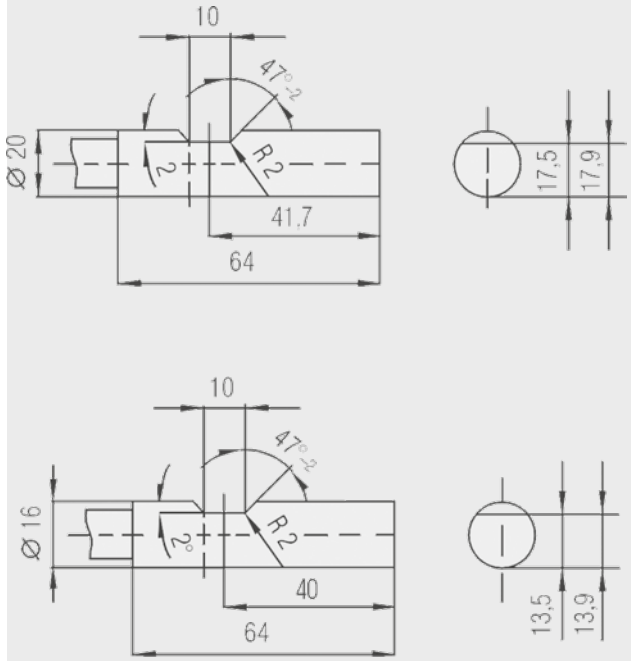


For clamping in special clamping chucks by MAKA

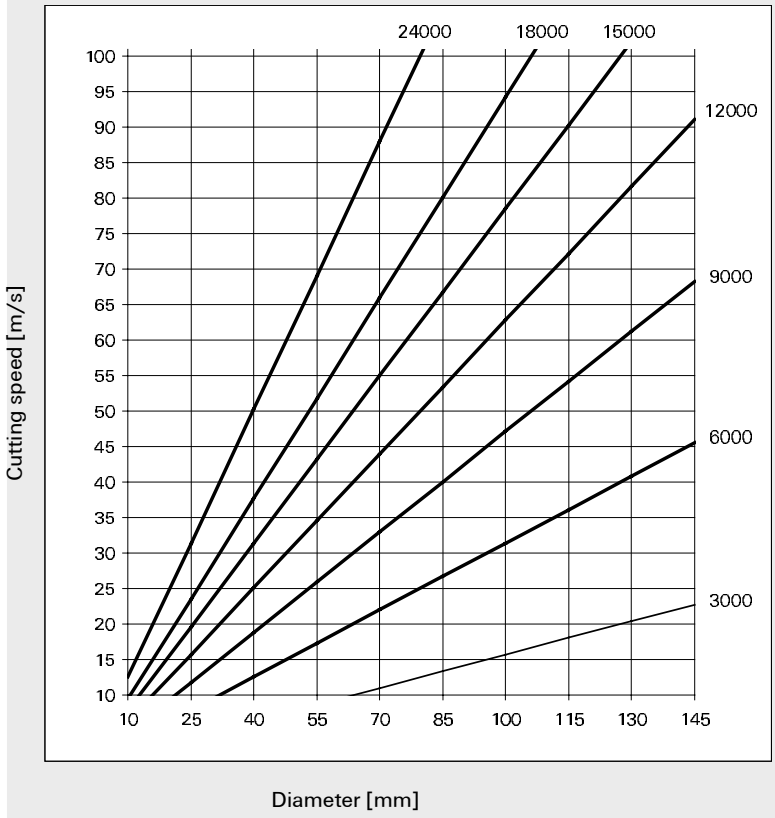


Clamping surface on Shank-Type Cutters

Particularily for solid carbide Lock-Case Cutters used in horizontal drilling/-milling aggregates of Homag and Weeke.



Determination of RPM [min-1]



Order / Inquiry for Special Tools: Shank-Type Cutters

Please copy and send the completed form to one of the LEUCO sales offices. (Only one tool description per form)

Customer-no.: _____
Company: _____
Plant: _____
Street: _____
Zip / City: _____
Country: _____
Contact partner: _____
Phone: _____
City and Date: _____

Order: o
Inquiry: o

Delivery (week no.): _____
(Not binding)
No. of pieces: _____

Fax: _____
Signature: _____

Machine

Maker: _____
Model: _____
Motor output [kW]: _____
RPM range [min-1]: _____
Feed rate [m/min]: _____

Type of feed: MAN o
Sense of rotation: Left o Right o

Only solid carbide cutters: spiral
Positive o
Negative o

Workpiece material

Description: _____

Cutting quality: Trimming cut o
Finish cut o

Direction of cut: With grain o
Across grain o

Coating

Yes o No o

Description: _____
Further Information _____

No. of teeth [pcs.]:
Rakers: _____
Spur: _____
Grooving knives: _____
Edge breaker: _____

Arrangement of cutting edges:
Only peripheral cutting o
With face cutting edge o
With plunge tip o

Shear angle: Single-sided o Alternate o

Tool

With tipped cutting edges: o

With exchangeable cutting edges:
EcoPro Cutterhead o
SuperProfiler o
UltraProfiler o
Standard o

Cutting diameter D [mm]: _____
Cutting length L2 [mm]: _____
Cutting width B [mm]: _____
Overall length L1 [mm]: _____
Shank length L3 [mm]: _____
Shank design:
Cylindrical shank [Ø]: _____
Other shank types [MK2, HSK F63, ...] _____ _____
Only solid carbide cutters: shank design [no.]

Cutting material

Carbide o Diamond o
Stellite o HS o

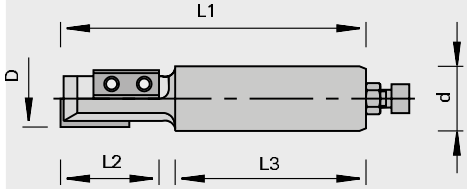
Face side: Top o Bottom o

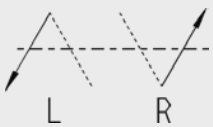
o check if applicable

Please indicate the following on workpiece samples or drawings:
Bottom side of workpiece
Sense of rotation
Motor spindle
Workpiece support
Dimension
Application conditions
Profile drawing
Tool drawing

Please indicate clearly if the workpiece or the tool is shown.

Please indicate additional dimension and markings in the tool drawing.





519-01.0708



Drill Bits

Product	Page
Twist Drills	5–1
Through-Hole Bits	5–6
Dowel Bits	5–13
Boring Spikes	5–24
Countersink	5–25
Cylinder Boring Bits	5–29
Technical Information	5–35

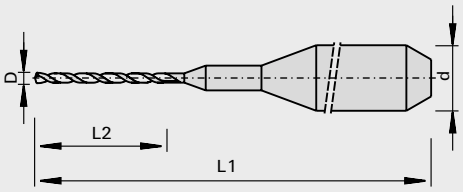
130010

Micro Twist Drills with solid carbide body

Product



Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application
- automatic boring machines
- CNC machining centers
- for drilling micro bores in wood-based materials, particularly acoustic plates

Design
- specific tip and spiral geometry
- design in solid tungsten carbide
- drill bits for left sense of rotation with color marking for easier identification

Advantages
- good stability and hole quality
- good chip evacuation

Notes
- clamping element: adapter Ident-No. 186165
- packing unit 10 pieces

Ø D	L2	Ø d	L1	Ident-No. [L]	Ident-No. [R]
1.0	8,5	3,175	38.2	186167 L	186166 L
[mm]	[mm]	[mm]	[mm]		

Accessories	Dimension	Class-No.	PU	Ident-No.
Adapters for micro twist drills	Ø3,175x52xØ10	933389	1	186165 L
	[mm]		[pc.]	

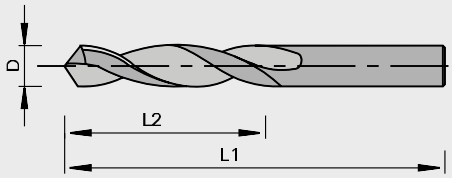
130010

Twist Drills with solid carbide body

Product



Drawing



LEUCO DUR

Solid Tungsten Carbide

MAN

Machine / Application
- portable boring machines
- automatic boring machines
- CNC machining centers
- for drilling of through holes and dowel holes in solid woods and wood-based panels

Design
- 2 v-point cutting edges
- solid carbide design
- cutting Ø = shank Ø
- tip angle 120°

Advantages
- high feed rates possible
- large resharpenable area

Notes
- clamping element: draw-in collet chuck, adapter Class-No. 933389, drill chuck

Ø D	L2	L1	Ident-No. [L]	Ident-No. [R]
2.0	25	50	182625 L	182626 L
2.5	27	55	182627 L	182628 L
3.0	27	55	182629 L	182630 L
3.5	27	52	182631 L	182632 L
4.0	27	55	182633 L	182634 L
5.0	28	60	182635 L	182636 L
[mm]	[mm]	[mm]		

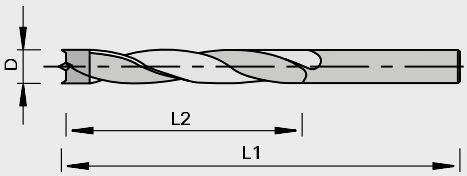
130010

Twist Drills HW

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- centering point
- cutting Ø = shank Ø
- 2 negative spurs
- spiral with back-guide
- plastic coated
- HW-tipped

Advantages

- safe drilling thanks to centering point
- protection of the hole edge upon exiting thanks to spiral with back guide
- optimum chip evacuation thanks to plastic coating
- chip-free hole edges thanks to negative spurs

Notes

- clamping element: draw-in collet chuck, drill chuck

Ø D	L2	L1	Ident-No. [L]	Ident-No. [R]
5.0	35	70	173145 C	167929 L
6.0	35	70		167930 C
8.0	35	70		167932 C
10	35	70	173150 C	167934 C
4.0	55	80		160503 L
4.5	60	85		160504 O
5.0	60	90		160505 L
5.5	65	100		164243 O
6.0	65	100		160506 L
6.5	70	110		164244 O
7.0	70	110		160507 O
8.0	75	120		160508 L
8.5	80	130		164245 O
9.0	80	130		160509 O
10	90	140		160510 L
11	95	150		160511 O
12	100	155		160512 L
[mm]	[mm]	[mm]		

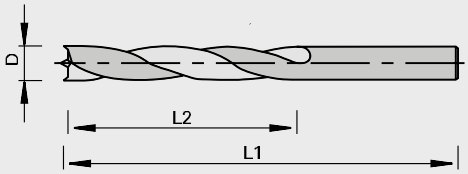
330010

Twist Drills HS

Product



Drawing



High Speed Steel [HS]

MAN

Machine / Application

- portable boring machines
- automatic boring machines
- for drilling of dowel holes in solid woods

Design

- 2 spurs
- centering point
- special coating
- cutting Ø = shank Ø
- HS design

Advantages

- chip-free hole edges thanks to spurs
- safe drilling thanks to centering point
- long edge lives thanks to special coating

Notes

- clamping element: draw-in collet chuck, drill chuck

Ø D	L2	L1	Ident-No. [L]	Ident-No. [R]
2.0	22	49	167671 L	167669 L
2.5	25	57	167672 L	167670 L
3.0	30	61	160530 L	160518 L
3.5	35	70	160531 O	160519 O
4.0	40	75	160532 L	160520 L
4.5	45	80	160533 O	160521 L
5.0	45	83	160534 L	160522 L
5.5	50	90	160535 C	160523 O
6.0	50	90	160536 O	160524 O
6.5	55	98		160525 O
7.0	60	105		160526 O
7.5	60	105		177177 C
8.0	70	113	160539 O	160527 L
8.5	70	113		177178 C
9.0	75	120		160528 O
10	80	130		160529 O
[mm]	[mm]	[mm]		

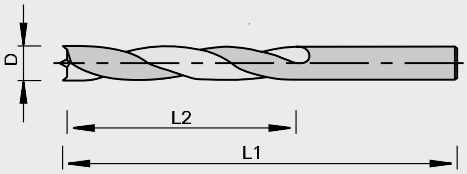
330010

Twist Drills HS - joinery machines

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- Joinery machines
- also for Weinmann and Hundegger
- for precise holes in all wood-based materials

Design

- 2 spurs
- Centering point
- special coating
- Deep hole spiral

Advantages

- chip-free hole edges thanks to spurs
- centering point for safe spot drilling
- long edge lives thanks to special coating
- very good chip evacuation thanks to a deep hole spiral and a special coating

Notes

- clamping element: draw-in collet chuck, drill chuck

Ø D	L2	Ø d	L3	L1	Ident-No.
3.0	200	3,0	50	250	80484170 O
4.0	200	4,0	50	250	80484171 O
5.0	200	5,0	50	250	80484172 O
6.0	200	6,0	50	250	80484173 O
7.0	200	7,0	50	250	80484174 O
8.0	200	8,0	50	250	80484175 O
9.0	200	9,0	50	250	80484176 O
10	200	10	50	250	80484177 O
11	200	11	50	250	80484178 O
12	200	12	50	250	80484179 O
13	200	13	50	250	80484180 O
14	200	13	50	250	80484181 O
15	200	13	50	250	80484182 O
16	200	13	50	250	80484183 O
18	200	13	50	250	80484184 O
20	200	13	50	250	80484185 O
22	200	13	50	250	80484186 O
24	200	13	50	250	80484187 O
25	200	13	50	250	80484188 O
3.0	250	3,0	65	315	80484189 O
4.0	250	4,0	65	315	80484190 O
5.0	250	5,0	65	315	80484191 O
6.0	250	6,0	65	315	80484192 O
7.0	250	7,0	65	315	80484193 O
8.0	250	8,0	65	315	80484194 O
9.0	250	9,0	65	315	80484195 O
10	250	10	65	315	80484196 O
11	250	11	65	315	80484197 O
12	250	12	65	315	80484198 O
13	250	13	65	315	80484199 O
14	250	13	65	315	80484200 O
15	250	13	65	315	80484201 O
16	250	13	65	315	80484202 O
3.0	380	3,0	80	460	80484203 O
4.0	380	4,0	80	460	80484204 O
5.0	380	5,0	80	460	80484205 O
6.0	380	6,0	80	460	80484206 O
7.0	380	7,0	80	460	80484207 O
[mm]	[mm]	[mm]	[mm]	[mm]	

Ø D	L2	Ø d	L3	L1	Ident-No.
8.0	380	8,0	80	460	80484208 O
9.0	380	9,0	80	460	80484209 O
10	380	10	80	460	80484210 O
11	380	11	80	460	80484211 O
12	380	12	80	460	80484212 O
13	380	13	80	460	80484213 O
14	380	13	80	460	80484214 O
15	380	13	80	460	80484215 O
16	380	13	80	460	80484216 O
[mm]	[mm]	[mm]	[mm]	[mm]	

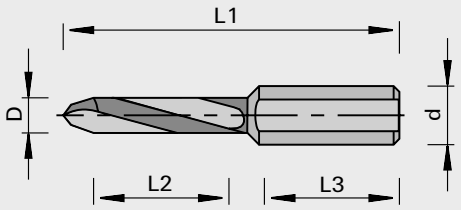
130012

Through-Hole Bits VHW - topline

Product



Drawing



LEUCO topline

LEUCO DUR

Solid Tungsten Carbide

MAN

Machine / Application

- automatic boring machines
- CNC machining centers
- for drilling of through-holes in solid woods and wood-based panels

Design

- cylindrical shank with clamping surface
- special cutting edge geometry
- boring part made from fine-grain solid tungsten carbide

Advantages

- considerably increased edge lives compared to traditional through-hole bits thanks to special HW and special grinding
- chip-free hole edges thanks to special cutting edge geometry

Notes

- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-change chuck
- other dimensions possible; price and delivery time on request

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	25	10	25	57.5	185738 L	185737 L
8.0	25	10	25	57.5	185740 L	185739 L
5.0	30	10	30	70	185742 L	185741 L
8.0	30	10	30	70	185744 L	185743 L
[mm]	[mm]	[mm]	[mm]	[mm]		

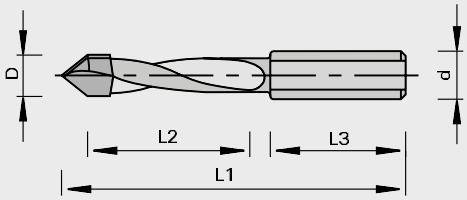
130013

Mosquito Through-Hole Bits HW

Product



Drawing



MOSQUITO

Tungsten Carbide [HW]

MAN

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of through-holes in solid woods and wood-based panels

Design

- special cutting edge geometry
- HW-plunging tip made from super-fine grain material

Advantages

- chip-free hole edges thanks to special cutting edge geometry
- long edge lives thanks to HW plunging tip
- high process safety thanks to constant quality of the bores for a long time

Notes

- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	27	10	26	57.5	182458 L	182459 L
8.0	27	10	26	57.5	182460 C	182461 C
5.0	35	10	26	70	182462 L	182463 L
6.0	35	10	26	70	183689 L	183688 L
7.0	35	10	26	70	183691 L	183690 L
8.0	35	10	26	70	182464 L	182465 L
10	35	10	26	70	183693 L	183692 L
[mm]	[mm]	[mm]	[mm]	[mm]		

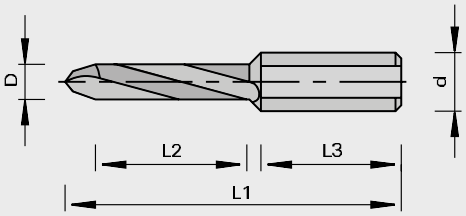
130013

Mosquito Through-Hole Bits with solid carbide body

Product



Drawing



MOSQUITO

Solid Tungsten Carbide

MAN

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of through-holes in solid woods and wood-based panels

Design

- special cutting edge geometry
- boring part made from fine-grain solid tungsten carbide

Advantages

- chip-free hole edges thanks to special cutting edge geometry
- high feed rates and edge lives increased up to sixfold compared to traditional dowel bits thanks to solid carbide design
- high process safety thanks to constant quality of the bores for a long time

Notes

- adjusting screw Ident-No. 001600 M5x10 DIN 551 included in delivery
- through-hole bit with shank length L3=24 mm is not suitable for Weeke adjusting screw
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke must be ordered separately
- clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
3.0	27	10	30	70	183687 L	183686 L
4.0	35	10	24	70	183167 L	183166 L
4.5	35	10	24	70	80356921 L	80356920 L
5.0	35	10	24	70	183153 L	183152 L
6.0	35	10	24	70	183155 L	183154 L
8.0	35	10	24	70	183157 L	183156 L
10	35	10	24	70	186523 L	186524 L
[mm]	[mm]	[mm]	[mm]	[mm]		

Ø D	L2	Ø d	L3	L1		Ident-No. [R]
6.0	35	10	50	100	for Lamello Clamex P®	184289 L
[mm]	[mm]	[mm]	[mm]	[mm]		

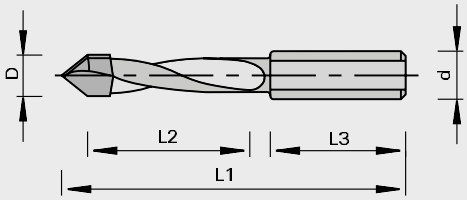
130011

EcoLine Through-Hole Bits HW

Product



Drawing



LEUCO ecoline

LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for drilling of through-holes in solid woods and wood-based panels

Design

- 2 v-point cutting edges with 60 degrees
- HW-tipped
- cylindrical shank with clamping surface
- spiral without back guide

Advantages

- Standard quality at low price

Notes

- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	40	10	20	70	186481 L	186480 L
6.0	40	10	20	70	186483 L	186482 L
7.0	40	10	20	70	186485 L	186484 L
8.0	40	10	20	70	186487 L	186486 L
10	40	10	20	70	186489 L	186488 L
5.0	44	10	20	77	186491 L	186490 L
8.0	44	10	20	77	186493 L	186492 L
[mm]	[mm]	[mm]	[mm]	[mm]		

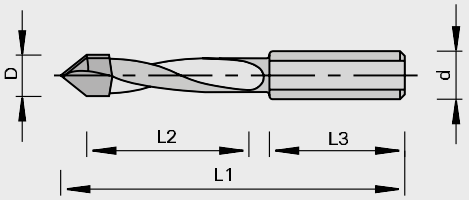
130015 / 130017

Through-Hole Bits HW - without back-guide

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for drilling of through-holes in solid woods and wood-based panels

Design

- 2 v-point cutting edges with 60 degrees, Ø 3 mm with 120 degrees
- HW-tipped
- Ø 3 mm with VHW spiral section
- Cylindrical shank with clamping surface
- Spiral without back guide

Advantages

Notes

- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
4.0	27	10	25	57.5	182239 O	182240 O
5.0	25	10	25	57.5	055827 L	055823 L
5.1	25	10	25	57.5	176473 O	176472 O
6.0	25	10	25	57.5	176475 L	176474 L
7.0	27	10	25	57.5	182245 O	182246 O
8.0	22	10	25	57.5	055830 L	055826 L
3.0	27	10	25	70	182237 O	182238 O
4.0	35	10	25	70	182241 L	182242 L
5.0	35	10	25	70	176505 L	176504 L
5.5	35	10	25	70	182243 O	182244 O
6.0	35	10	25	70	176259 L	176258 L
7.0	35	10	25	70	181581 L	181582 L
8.0	35	10	25	70	176507 L	176506 L
10	35	10	25	70	182669 L	182670 L
11	35	10	25	70	182249 O	182250 O
5.0	45	10	25	77	176477 L	176476 L
6.0	45	10	25	77	176479 L	176478 L
7.0	45	10	25	77	182251 O	182252 O
8.0	43	10	25	77	176481 L	176480 L
9.0	42	10	25	77	182253 O	182254 O
10	42	10	25	77	176483 L	176482 L
11	45	10	25	77	182255 O	182256 O
12	45	10	25	77	176485 L	176484 L
[mm]	[mm]	[mm]	[mm]	[mm]		

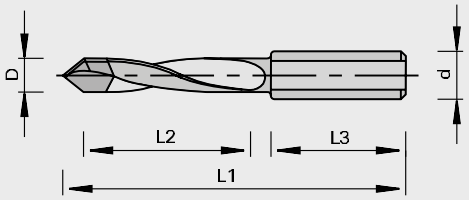
130015 / 130016 / 130017

Through-Hole Bits HW - with back-guide

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for drilling of through-holes in solid woods and wood-based panels

Design

- 2 v-point cutting edges (60 degree angle)
- HW-tipped
- cylindrical shank with clamping surface
- spiral with back-guide

Advantages

- protection of the hole edge upon exiting thanks to spiral with back guide

Notes

- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- adjustable countersink attachment on the boring spiral for simultaneous chamfering of the hole
- shell countersink Class-No. 130660
- clamping elements: combi chuck, quick-change chuck

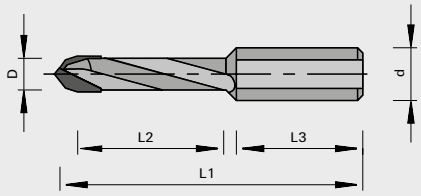
Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	25	8,0	20	55.5	176497 S	176496 S
8.0	25	8,0	20	55.5	176499 S	176498 S
5.0	25	10	20	57.5	173604 L	173595 L
8.0	25	10	20	57.5	173611 S	173596 S
5.0	35	8,0	20	67	176501 L	176500 L
8.0	35	8,0	20	67	176503 C	176502 L
5.0	35	10	25	70	176255 L	176254 L
8.0	35	10	25	70	176257 L	176256 L
[mm]	[mm]	[mm]	[mm]	[mm]		

230012

Through-Hole Bits DP

Product

Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- automatic boring machines
- CNC machining centers
- for chip-free drilling in raw and laminated panels and composite materials

Design

- special cutting edge geometry, roof-shaped tip and double chamfer
- spiral without back guide
- DP-tipped

Advantages

- long edge life when machining extremely abrasive materials
- chip-free hole edges thanks to special cutting edge geometry

Notes

- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
5.0	27	10	26	57.5	1	183015 O	183014 O
5.0	35	10	26	70	1	183017 O	183016 O
8.0	35	10	26	70	2	183021 O	183020 O
10	35	10	26	70	2		183050 O
[mm]	[mm]	[mm]	[mm]	[mm]			

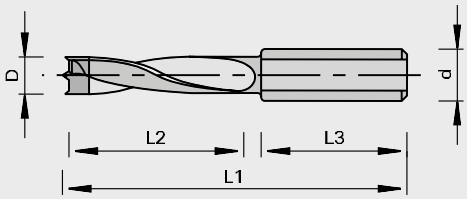
130215/130216/130217

Dowel Bits HW - with back-guide

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- 2 negative spurs
- centering point
- spiral with back-guide
- plastic coated
- HW-tipped

Advantages

- chip-free hole edges thanks to spurs
- safe drilling thanks to centering point
- protection of the hole edge upon exiting thanks to spiral with back guide
- optimum chip evacuation thanks to plastic coating

Notes

- adjusting screw: Ident-No. 001600 M5x10 DIN 551 for precise length adjustment
- adjustable countersink attachment on the boring spiral for simultaneous chamfering of the hole
- shell countersink Class-No. 130660
- clamping element: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
4.0	30	8,0	19	55.5	166107 O	166106 O
5.0	30	8,0	19	55.5	011543 L	011542 L
6.0	30	8,0	19	55.5	054884 L	054883 L
8.0	30	8,0	19	55.5	054892 L	054891 L
10	30	8,0	19	55.5	054896 L	054895 L
12	30	8,0	20	55.5	166113 C	166112 C
4.0	40	8,0	19	67		167154 L
5.0	40	8,0	19	67	057494 L	057493 L
6.0	40	8,0	19	67	057496 L	057495 L
7.0	40	8,0	19	67	167167 L	167157 C
8.0	40	8,0	19	67	057498 L	057497 L
9.0	40	8,0	19	67	167169 C	167159 C
10	40	8,0	19	67	057500 L	057499 L
12	40	8,0	19	67	167172 C	167162 O
[mm]	[mm]	[mm]	[mm]	[mm]		

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	30	10	19	57.5	167184 L	167174 L
6.0	30	10	20	57.5	167185 L	167175 L
7.0	30	10	20	57.5	167186 L	167176 L
8.0	30	10	20	57.5	167187 L	167177 L
10	30	10	20	57.5	167188 L	167178 L
12	30	10	20	57.5	167189 L	167179 L
13	30	10	20	57.5	167190 C	167180 L
14	30	10	20	57.5	167191 L	167181 L
15	30	10	20	57.5	167192 L	167182 L
16	30	10	20	57.5	167193 C	167183 C
5.0	43	10	19	70	167203 L	167194 L
6.0	43	10	19	70	167204 L	167195 L
8.0	43	10	19	70	167205 L	167196 L
9.0	43	10	19	70	167206 O	167197 L
10	43	10	19	70	167207 L	167198 L
12	43	10	19	70	167208 L	167199 L
[mm]	[mm]	[mm]	[mm]	[mm]		

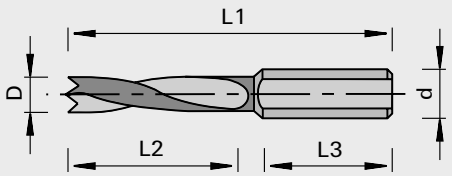
130212

Dowel Bits VHW - topline

Product



Drawing



LEUCO topline

LEUCO DUR

Solid Tungsten Carbide

MAN

Machine / Application

- automatic boring machines
- CNC machining centers
- for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- special cutting edge geometry
- centering point
- boring part made from fine-grain solid tungsten carbide
- enhancement of the previous topline HW design

Advantages

- tool life increased up to twelve-fold compared to traditional dowel bits thanks to special HW and special grinding
- chip-free hole edges thanks to special cutting edge geometry
- safe drilling thanks to centering point
- excellent chip evacuation thanks to optimized spiral design

Notes

- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-change chuck
- other dimensions possible; price and delivery time on request

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	30	8,0	19	57.5	185746 L	185745 L
4.0	20	10	27	57.5	185748 L	185747 L
5.0	25	10	27	57.5	185750 L	185749 L
6.0	25	10	27	57.5	185752 L	185751 L
8.0	25	10	27	57.5	185754 L	185753 L
10	30	10	27	57.5	185756 L	185755 L
4.0	20	10	30	70	185758 L	185757 L
5.0	35	10	30	70	185760 L	185759 L
6.0	35	10	30	70	185762 L	185761 L
8.0	35	10	30	70	185764 L	185763 L
10	35	10	30	70	185766 L	185765 L
[mm]	[mm]	[mm]	[mm]	[mm]		

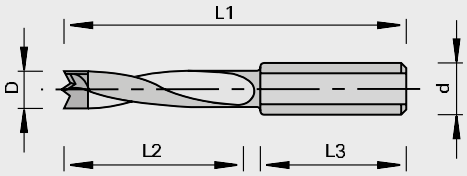
130213

Mosquito Dowel Bits HW

Product



Drawing



MOSQUITO

Tungsten Carbide [HW]

MAN

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- special cutting edge geometry
- 2 spurs
- centering point
- HW-tipped

Advantages

- chip-free hole edges thanks to special cutting edge geometry with spurs
- safe drilling thanks to centering point
- high process safety thanks to constant quality of the bores for a long time
- tool life increased up to sixfold compared to traditional dowel bits thanks to wear-resistant HW plunging tip

Notes

- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	25	10	27	57.5	181168 L	181167 L
6.0	25	10	27	57.5	181522 L	181521 L
7.0	27	10	27	57.5	183159 O	183158 O
8.0	25	10	27	57.5	181170 L	181169 L
9.0	27	10	27	57.5	183161 O	183160 O
10	25	10	27	57.5	181524 L	181523 L
5.0	35	10	30	70	181172 L	181171 L
6.0	35	10	30	70	181526 L	181525 L
7.0	35	10	30	70	183163 L	183162 L
8.0	35	10	30	70	181174 L	181173 L
9.0	35	10	30	70	183165 O	183164 O
10	35	10	30	70	181528 L	181527 L
[mm]	[mm]	[mm]	[mm]	[mm]		

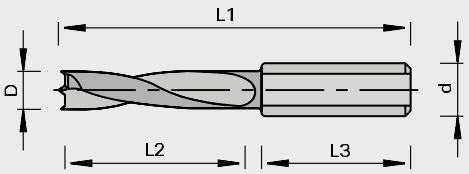
130213

Mosquito Dowel Bits with solid carbide body

Product



Drawing



MOSQUITO

Solid Tungsten Carbide

MAN

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- special cutting edge geometry
- 2 spurs
- centering point
- boring part made from fine-grain solid tungsten carbide

Advantages

- chip-free hole edges thanks to special cutting edge geometry with spurs
- safe drilling thanks to centering point
- high feed rates and edge lives increased up to sixfold compared to traditional dowel bits thanks to solid carbide design
- high process safety thanks to constant quality of the bores for a long time

Notes

- adjusting screw Ident-No. 001600 M5x10 DIN 551 included in delivery
- through-hole bit with shank length L3=22 mm is not suitable for Weeke adjusting screw
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke must be ordered separately
- clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
3.0	9,0	10	35	57.5	183143 O	183142 O
3.0	18	10	31	57.5	182380 L	182381 L
4.0	20	10	29	57.5	182382 C	182383 O
5.0	22	10	27	57.5	182384 L	182385 L
6.0	22	10	25	57.5	183145 O	183144 O
8.0	22	10	25	57.5	183147 O	183146 O
3.0	18	10	43.5	70	182386 L	182387 L
4.0	30	10	31.5	70	182388 L	182389 L
5.0	30	10	31.5	70	182390 L	182391 L
6.0	30	10	30	70	183149 L	183148 L
8.0	35	10	22	70	183151 L	183150 L
[mm]	[mm]	[mm]	[mm]	[mm]		

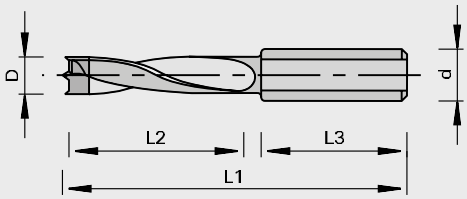
130218 / 130219

Dowel Bits HW - with back-guide, long version

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- long cutting length
- 2 negative spurs
- centering point
- spiral with back-guide
- plastic coated
- HW-tipped

Advantages

- deep holes thanks to long cutting length
- chip-free hole edges thanks to negative spurs
- safe drilling thanks to centering point
- protection of the hole edge upon exiting thanks to spiral with back guide
- optimum chip evacuation thanks to plastic coating

Notes

- adjustable countersink attachment on the boring spiral for simultaneous chamfering of the hole
- shell countersink Class-No. 130660
- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	50	10	30	85	177194 L	177193 L
5.0	65	10	30	105	177206 L	177205 L
6.0	50	10	30	85	177196 L	177195 L
6.0	65	10	30	105	177208 L	177207 L
7.0	50	10	30	85	177198 L	177197 L
7.0	65	10	30	105	177210 L	177209 L
8.0	50	10	30	85	177200 L	177199 L
8.0	65	10	30	105	177212 L	177211 L
10	50	10	30	85	177202 L	177201 L
10	65	10	30	105	177214 L	177213 L
12	50	10	30	85	177204 L	177203 L
12	65	10	30	105	177216 C	177215 L
[mm]	[mm]	[mm]	[mm]	[mm]		

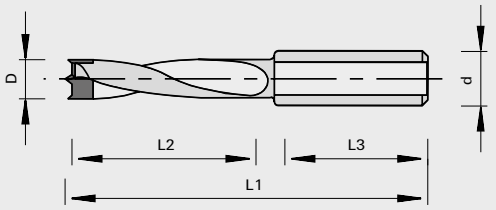
130211

EcoLine Dowel Bits HW

Product



Drawing



LEUCO ecoline

LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- 2 negative spurs
- centering point
- spiral without back guide
- plastic coated
- plunging tip with HW plate for reduced demands

Advantages

- chip-free hole edges thanks to negative spurs
- safe drilling thanks to centering point
- optimum chip evacuation thanks to plastic coating

Notes

- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	26	10	20	57.5	183375 L	183374 L
8.0	31	10	20	57.5	183377 L	183376 L
10	32	10	20	57.5	183379 L	183378 L
5.0	39	10	20	70	183381 L	183380 L
6.0	40	10	20	70	183383 L	183382 L
8.0	44	10	20	70	183385 L	183384 L
10	45	10	20	70	183387 L	183386 L
[mm]	[mm]	[mm]	[mm]	[mm]		

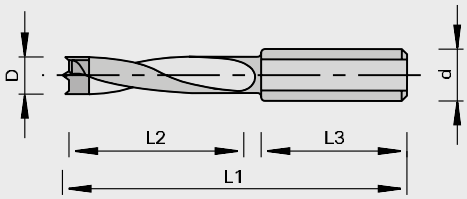
130215/130217

Dowel Bits HW - without back-guide

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- 2 negative spurs
- centering point
- spiral without back guide
- plastic coated
- HW-tipped

Advantages

- chip-free hole edges thanks to negative spurs
- safe drilling thanks to centering point
- optimum chip evacuation thanks to plastic coating

Notes

- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
4.0	27	10	27	57.5	003175 L	003174 L
4.5	27	10	27	57.5	177228 L	177227 L
5.0	27	10	27	57.5	003179 L	003178 L
5.1	27	10	27	57.5	177230 L	177229 L
5.2	27	10	27	57.5	167707 O	167708 O
6.0	27	10	27	57.5	003183 L	003182 L
7.0	27	10	27	57.5	003187 L	003186 L
8.0	27	10	27	57.5	003191 L	003190 L
8.2	27	10	27	57.5	167216 L	167213 L
9.0	27	10	27	57.5	003195 L	003194 L
10	27	10	27	57.5	003199 L	003198 L
10.5	27	10	27	57.5	182261 O	182262 O
11	27	10	27	57.5	177232 C	177231 L
12	27	10	27	57.5	003207 L	003206 L
4.0	35	10	30	70	173175 L	173174 L
4.5	35	10	30	70	182263 L	182264 L
5.0	35	10	30	70	003231 L	003230 L
5.1	35	10	30	70	182265 O	182266 O
5.5	35	10	30	70	182267 L	182268 L
6.0	35	10	30	70	003235 L	003234 L
7.0	35	10	30	70	167224 L	167219 L
7.5	35	10	30	70	182271 O	182272 O
8.0	35	10	30	70	003243 L	003242 L
8.1	35	10	30	70	182273 O	182274 O
8.2	35	10	30	70	182275 L	182276 L
8.5	35	10	30	70	182277 O	182278 O
9.0	35	10	30	70	167225 L	167220 L
10	35	10	30	70	003251 L	003250 L
10.2	35	10	30	70	182279 O	182280 O
11	35	10	30	70	167226 L	167221 L
12	35	10	30	70	167227 L	167222 L
13	35	10	30	70	183042 L	183043 L
14	35	10	30	70	183044 L	183045 L
16	35	10	30	70	183046 L	183047 L
5.0	44	10	30	77	167233 L	167228 L
6.0	44	10	30	77	167234 L	167229 L
8.0	44	10	30	77	167235 L	167230 L
[mm]	[mm]	[mm]	[mm]	[mm]		

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
10	44	10	30	77	167236 L	167231 L
12	44	10	30	77	173181 O	173180 O
[mm]	[mm]	[mm]	[mm]	[mm]		

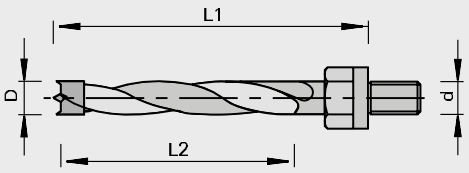
130226

Dowel Bits HW - without back-guide, with threaded shank

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable boring machines
- automatic boring machines
- for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- 2 negative spurs
- centering point
- spiral without back guide
- plastic coated
- threaded shank
- HW-tipped

Advantages

- chip-free hole edges thanks to negative spurs
- safe drilling thanks to centering point
- optimum chip evacuation thanks to plastic coating
- high stability thanks to threaded shank for direct clamping onto the boring spindle

Notes

- for coordination with machines see section Clamping Systems

Ø D	L2	Ø d	L1	Ident-No. [L]	Ident-No. [R]
5.0	45	M8	63	160570 O	160566 O
5.0	45	M10	63	167697 L	167698 L
6.0	45	M10	63	160576 O	160574 O
8.0	45	M8	63	160572 O	160568 O
8.0	45	M10	63	160577 L	160575 L
10	45	M10	63	167699 C	167700 C
12	45	M8	63	167691 C	167692 C
12	45	M10	63	167701 C	167702 C
[mm]	[mm]	[mm]	[mm]		

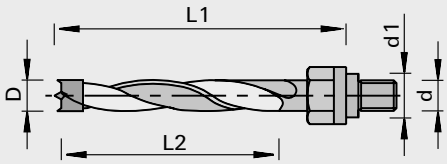
130226

Dowel Bits HW - with back-guide and threaded shank

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable boring machines
- automatic boring machines
- for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- 2 negative spurs
- centering point
- spiral with back-guide
- plastic coated
- shank with thread and passfit
- HW-tipped

Advantages

- chip-free hole edges thanks to negative spurs
- safe drilling thanks to centering point
- optimum chip evacuation thanks to plastic coating
- high stability thanks to threaded shank for direct clamping onto the boring spindle

Notes

- for coordination with machines see section Clamping Systems

Ø D	L2	Ø d1	Ø d	L1	Ident-No. [L]	Ident-No. [R]
5.0	45	11	M10	63	167703 C	167704 C
6.0	45	11	M10	63		167706 O
8.0	45	11	M10	63	160584 L	160582 L
10	45	11	M10	63	160585 O	160583 O
[mm]	[mm]	[mm]	[mm]	[mm]		

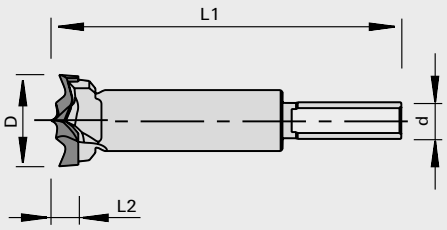
130214

Drill Bits HW for Lamello Cabineo® pockets

Product



Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application

- CNC machining centers with 3-fold drilling aggregates e.g. BENZ MULTI V3 CABINEO, ATEMAG Verti-Line Cabineo
- Boring machines with special boring heads e.g. Gannomat Basica
- for drilling of machining pockets system Lamello Cabineo® in one machining step (3 in 1)

Design

- 2 spurs
- Centering point
- high-quality cutting material
- Tool shank with clamping surface

Advantages

- special LEUCO tooth and spur geometry for minimal cutting force and cutting pressure
- high balancing quality
- adapted design for "3 in 1" or multispindle aggregates

Notes

Ø D	L2	Ø d	L1	Ident-No. [L]	Ident-No. [R]
15	4,5	6	57.5	186737 L	186736 L
[mm]	[mm]	[mm]	[mm]		

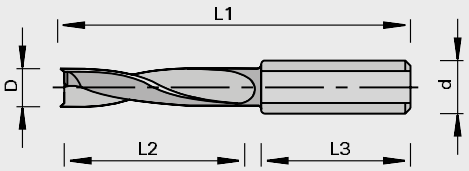
130214

High-Performance Dowel Bits with solid carbide body

Product



Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application

- stationary boring machines
- automatic boring machines
- CNC machining centers
- for drilling of through holes and dowel holes in solid woods, wood-based panels and composite materials

Design

- special cutting edge geometry
- 2 spurs
- spiral with back-guide
- boring part made from solid tungsten carbide

Advantages

- special tooth geometry and spurs for minimal cutting force and cutting pressure
- protection of the hole edge upon exiting thanks to spiral with back guide
- high feed rates and large resharpenable area thanks to solid carbide bit

Notes

- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-change chuck
- patended tooth geometry
- change of grinding or reduction of diameter ist not possible

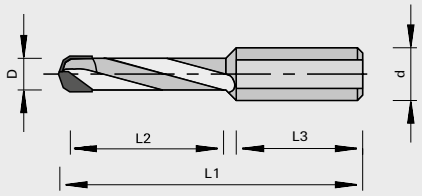
Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	32	10	22	57.5	185768 L	185767 L
8.0	32	10	22	57.5	185770 L	185769 L
5.0	36	10	30	70	185772 L	185771 L
6.0	36	10	30	70	185774 L	185773 L
8.0	36	10	30	70	185776 L	185775 L
10	36	10	30	70	185778 L	185777 L
[mm]	[mm]	[mm]	[mm]	[mm]		

230215

Dowel Bits DP

Product

Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- automatic boring machines
- CNC machining centers
- for chip-free drilling in raw and laminated panels and composite materials

Design

- special cutting edge geometry, 2 DP rakers which form a double chamfer
- spiral without back guide
- DP-tipped

Advantages

- long edge life when machining extremely abrasive materials
- chip-free hole edges thanks to special cutting edge geometry

Notes

- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-change chuck

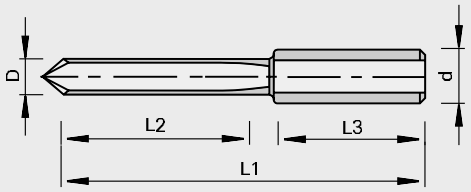
Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
8.0	27	10	26	57.5	2	183009 S	183008 S
8.0	35	10	30	70	2	183013 C	183012 C
10	35	10	30	70	2	183053 C	183054 C
[mm]	[mm]	[mm]	[mm]	[mm]			

130010

Boring Spikes with solid carbide body

Product

Drawing



LEUCO DUR

Solid Tungsten Carbide

MAN

Machine / Application

- automatic boring machines
- CNC machining centers
- for drilling of dowel holes in wood-based panels

Design

- cylindrical shank Ø 10 mm with clamping surface and adjusting screw
- solid carbide design

Advantages

- large resharpenable area
- long edge lives

Notes

- for clockwise and counter-clockwise rotation
- clamping element: combi chuck, quick-clamping chuck

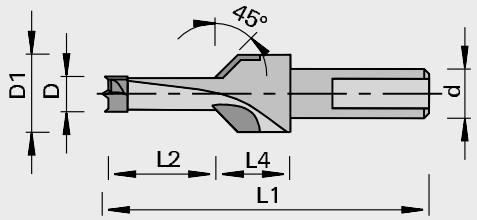
Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Ident-No.
2.0	12	2,0		38	183059 C
2.5	12	2,5		45	180942 L
3.0	12	3,0		45	180943 L
3.5	15	3,5		45	183060 C
4.0	12	4,0		45	180944 C
2.5	15	10	33	57.5	183061 C
3.0	15	10	33	57.5	183062 C
5.0	25	10	25	57.5	180945 O
3.5	30	10	24	70	183063 C
4.0	32	10	25	70	183064 C
5.0	35	10	25	70	180946 C

130710

Boring Countersink HW

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- portable boring machines
- automatic boring machines
- for drilling and countersinking in solid woods and wood-based panels

Design

- spiral PTFE coated
- 2 spurs
- centering point

Advantages

- for drilling and countersinking in one pass
- safe drilling thanks to centering point

Notes

- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-clamping chuck

Ø D	L2	Ø D1	L4	Ø d	L1	Ident-No. [L]	Ident-No. [R]
8.0	12	16	15	10	57.5	180847 L	180846 L
8.0	15	16	15	10	57.5	180849 C	180848 L
10	12	16	15	10	57.5	180853 L	180852 L
10	15	16	15	10	57.5	180855 C	180854 O
8.0	12	16	15	10	70	180859 L	180858 L
8.0	15	16	15	10	70	180861 C	180860 C
8.0	20	16	15	10	70	180863 L	180862 L
10	12	16	15	10	70	180865 L	180864 L
10	15	16	15	10	70	180867 C	180866 C
10	20	16	15	10	70	180869 O	180868 O
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

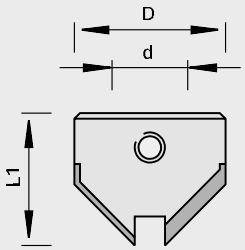
130660

Countersink Parts HW to be mounted on Twist Drills and Dowel Bits

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- for drilling of countersinks in solid woods and wood-based panels
- for chip-free countersink holes at 90 degree angle

Design

- HW-tipped

Advantages

Notes

- for installation on twist drills and dowel bits with back-guide on the drill spiral with set screw
- continuous adjustment of the countersink diameter and the boring depth

Ø D	Ø d	L1	Ident-No. [L]	Ident-No. [R]
15.5	3,0	17.5		177291 L
16	4,0	15	183811 C	183812 L
16	5,0	15	183174 L	183175 L
16	6,0	15	183176 L	183177 L
16	7,0	15	183178 L	183179 L
18	8,0	15	183180 L	183181 L
18	9,0	15	183813 C	183814 C
20	10	15	183182 L	183183 L
20	12	15	183815 C	183816 L
[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M5x5 DIN EN ISO 4029	995161	10	001609 L
Cranked Wrench Keys	SW2,5 DIN ISO 2936	985730	1	009671 L
	[mm]		[pc.]	

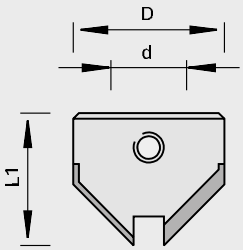
130660

Countersink Parts HW to be mounted on Dowel Bits

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- for drilling of countersinks in solid woods and wood-based panels
- for chip-free countersink holes at 90 degree angle

Design

- HW-tipped

Advantages

Notes

- for installation on elongated shank of dowel bits Ø 5 - 10 mm with setscrew
- continuous adjustment of the countersink diameter and the boring depth

Ø D	Ø d	L1	Ident-No. [L]	Ident-No. [R]
15.5	10	16.5	177294 L	177293 L
20	10	16	183184 L	183185 L
[mm]	[mm]	[mm]		

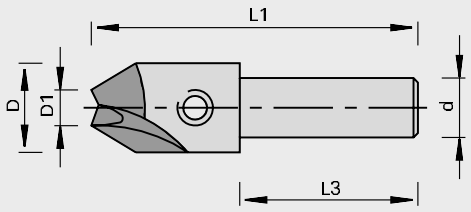
Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M6x4 DIN EN ISO 4029	995161	10	167068 L
Cranked Wrench Keys	SW3 DIN ISO 2936	985730	1	009672 L
	[mm]		[pc.]	

130660

Countersink Bits HW for Twist Drills

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- for drilling of countersinks in solid woods and wood-based panels
- for chip-free countersink holes at 90 degree angle

Design

- HW-tipped

Advantages

Notes

- for mounting of twist drills with Ø 3 - 6 mm
- continuous adjustment of the countersink diameter and the boring depth

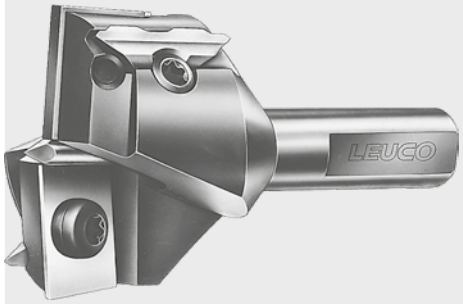
Ø D	Ø D1	Ø d	L3	L1		Ident-No.	
15	3.0	10	30	58	R	173190	L
15	3.0	10	30	58	L	173191	C
15	3.5	10	30	58	R	173192	L
15	4.0	10	30	58	R	173194	L
15	4.0	10	30	58	L	173195	L
15	4.5	10	30	58	R	173196	L
15	4.5	10	30	58	L	173197	C
15	5.0	10	30	58	R	173198	L
15	5.0	10	30	58	L	173199	L
15	6.0	10	30	58	R	173202	O
15	6.0	10	30	58	L	173203	C
[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M6x6 DIN EN ISO 4029	995161	10	180003 L
	[mm]		[pc.]	

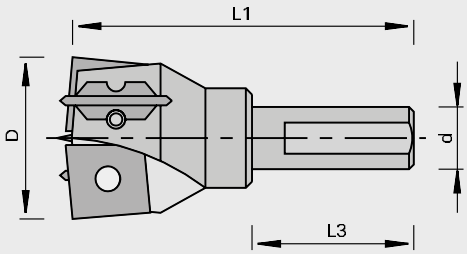
130135

Cylinder Boring Bits with HW Turnover Knives

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- hardware hinge machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of hinge hardware holes in solid woods and wood-based panels

Design

- 2 rakers, 2 turnover spurs and centering point

Advantages

- long edge lives thanks to wear-resistant HW grade
- chip-free hardware hinge holes thanks to scoring cut of the turnover spurs

Notes

- replaceable and adjustable centering point
- cylindrical shank with clamping surface
- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-clamping chuck

Ø D	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
25	10	26	57.5		162612 S
26	10	26	57.5		162614 L
30	10	26	57.5		162616 C
35	10	26	57.5	162619 L	162618 L
25	10	26	70		182570 C
26	10	26	70		182571 C
30	10	26	70		182572 C
35	10	26	70	184896 L	182573 L
[mm]	[mm]	[mm]	[mm]		

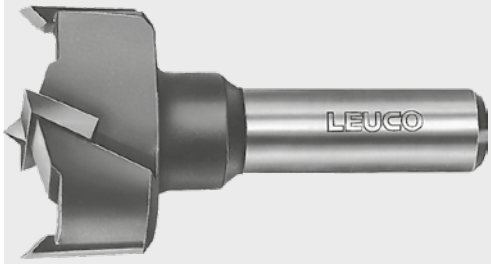
Turnover Knives	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Turnover Knives	11x12x1,5	162614, 182571	150515	10	162637 L
Turnover Knives	15,7x12x1,5	162619, 162618, 182573	150515	10	163846 L
Turnover Knives	13x12x1,5	162616, 182572	150515	10	162638 L
Turnover Knives	10,5x12x1,5	162612, 182570	150515	10	162636 L
Spurs	18x5,7x3,5	For all	150556	10	187303 L
Centering Points	3x33,5	For all	165512	10	162624 L
	[mm]			[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Set Screws	M6x6 DIN EN ISO 4028	For all	995161	10	163841 L
Countersunk Screws	M3,5x6 T15 D=Ø5,4	162619, 162618, 182573, 162614, 162616, 182571, 182572, 184896	995125	10	162648 L
Countersunk Screws	M3,5x5,5 T15 D=Ø5,4	162612, 182570	995125	10	162649 L
Head Cap Screws	M3,5x3,8 T15	162612, 162614, 162616, 182570, 182571, 182572	995115	10	162645 L
Head Cap Screws	M3,5x6,5 T15	162619, 162618, 182573, 184896	995115	10	162644 L
	[mm]			[pc.]	

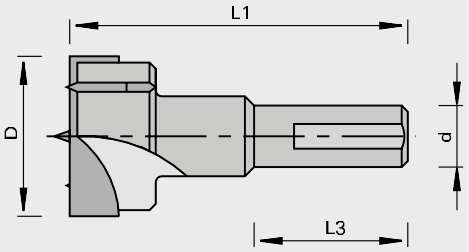
130115 / 130117

Cylinder Boring Bits HW - Z=2+2

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- hardware hinge machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of hinge hardware holes in solid woods and wood-based panels

Design

- 2 rakers, 2 spurs and centering point
- HW-tipped

Advantages

- chip-free holes thanks to scoring cut of the spurs

Notes

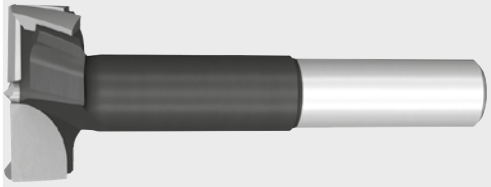
- cylindrical shank with clamping surface
- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-clamping chuck

Ø D	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
15	10	26	57.5	003303 L	003302 L
16	10	26	57.5	003305 L	003304 L
18	10	26	57.5	003309 L	003308 L
20	10	26	57.5	003313 L	003312 L
22	10	26	57.5	003315 L	003314 L
25	10	26	57.5	003319 L	003318 L
26	10	26	57.5	003321 L	003320 L
30	10	26	57.5	003327 L	003326 L
35	10	26	57.5	003333 L	003332 L
40	10	26	57.5	003337 L	003336 L
15	10	26	70	178978 L	172250 L
18	10	26	70	178983 L	178984 L
20	10	26	70	178979 L	172251 L
22	10	26	70	182257 L	182258 L
25	10	26	70	178980 L	172252 L
26	10	26	70	182374 L	182375 L
30	10	26	70	178981 L	172253 L
35	10	26	70	178982 L	172254 L
40	10	26	70	182259 L	182260 L
[mm]	[mm]	[mm]	[mm]		

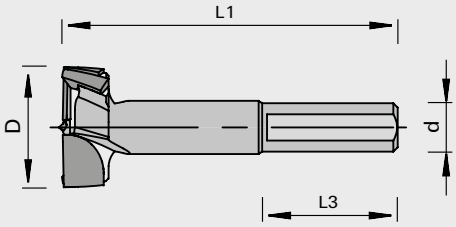
130115 / 130117

Cylinder Boring Bits HW - “Light”

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- hardware hinge machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of hinge hardware holes in solid woods and wood-based panels

Design

- 2 rakers, 2 spurs and centering point
- HW-tipped

Advantages

- chip-free bore holes even on partly open holes near the edge of the panel thanks to particular geometry of spurs
- excellent chip removal thanks to big gullets
- the shorter center point allows for drilling deep holes close to the bottom of panel
- low cutting pressure

Notes

- cylindrical shank with clamping surface
- with length adjusting screw M5x10 DIN 551
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-clamping chuck

Ø D	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
15	10	26	57.5	184677 L	184676 L
18	10	26	57.5	185029 L	185028 L
20	10	26	57.5	185031 L	185030 L
25	10	26	57.5	184679 L	184678 L
26	10	26	57.5	185033 L	185032 L
35	10	26	57.5	184681 L	184680 L
[mm]	[mm]	[mm]	[mm]		

Ø D	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
15	10	26	70	184685 L	184684 L
18	10	26	70	185035 L	185034 L
20	10	26	70	185037 L	185036 L
25	10	26	70	184687 L	184686 L
26	10	26	70	185039 L	185038 L
35	10	26	70	184689 L	184688 L
[mm]	[mm]	[mm]	[mm]		

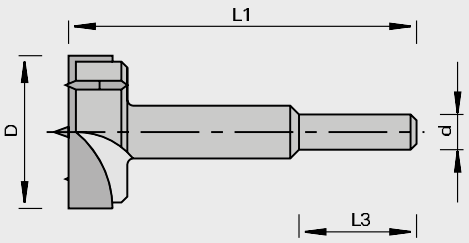
130119 / 130110

Cylinder Boring Bits HW - portable boring machines

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable boring machines
- for chip-free drilling in solid woods and wood-based panels

Design

- 2 rakers, 2 spurs and centering point
- HW-tipped
- Ø 12: spurs in rakers
- cylindrical shank

Advantages

- chip-free holes thanks to scoring cut of the spurs

Notes

- diameter of the cylindrical shank is adapted to the cutting pressure
- clamping elements: drill chuck

Ø D	Ø d	L3	L1	Ident-No.
12	10	30	90	173204 O
14	10	30	90	167685 L
15	10	30	90	160424 L
16	10	30	90	160425 L
17	10	30	90	167686 L
18	10	30	90	160426 L
19	10	30	90	167687 L
20	10	30	90	160427 L
21	10	30	90	173205 L
22	10	30	90	160428 L
23	10	30	90	167688 L
24	10	30	90	160429 L
25	10	30	90	160430 L
26	10	30	90	160431 L
27	10	30	90	173206 C
28	10	30	90	160432 L
30	10	30	90	160433 L
32	10	30	90	160434 L
34	10	30	90	167689 O
35	10	30	90	160435 L
36	10	30	90	160436 C
38	10	30	90	160437 O
40	10	30	90	160438 L
42	10	30	90	167690 O
45	10	30	90	173207 L
50	10	30	90	173208 L
[mm]	[mm]	[mm]	[mm]	

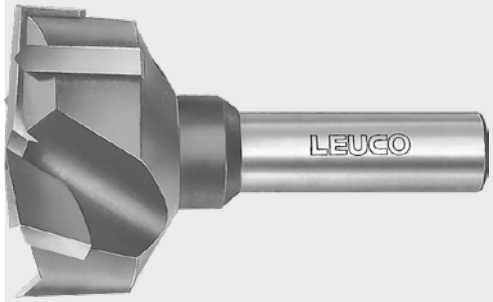
Ø D	Ø d	L3	L1	Ident-No.
15	13	50	140	173210 C
16	13	50	140	173211 C
18	13	50	140	160388 C
20	13	50	140	160389 C
22	13	50	140	160390 C
24	13	50	140	173212 C
25	13	50	140	160392 C
26	13	50	140	160393 C
28	13	50	140	160394 C
30	13	50	140	160395 C
32	13	50	140	160396 C
34	16	50	140	173213 C
35	16	50	140	160398 C
[mm]	[mm]	[mm]	[mm]	

Ø D	Ø d	L3	L1	Ident-No.
38	16	50	140	173215 C
40	16	50	140	160401 C
42	16	50	140	160402 C
44	16	50	140	173216 C
45	16	50	140	180742 S
46	16	50	140	173217 C
48	16	50	140	173218 C
50	16	50	140	160407 C
52	16	50	140	160408 C
54	16	50	140	173219 C
55	16	50	140	160409 O
56	16	50	140	173220 C
58	16	50	140	173221 C
60	16	50	140	160410 C
63	16	50	140	173228 C
65	16	50	140	160411 O
68	16	50	140	173222 C
70	16	50	140	160412 S
75	20	50	140	173223 C
80	20	50	140	160414 C
[mm]	[mm]	[mm]	[mm]	

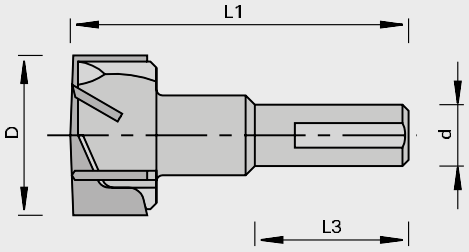
130115

Cylinder Boring Bits HW - Z=3+3

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- hardware hinge machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling in solid woods and wood-based panels

Design

- 3 rakers, 3 spurs, without centering point
- HW-tipped

Advantages

- boring depths close to the bottom-side laminate
- chip-free holes thanks to scoring cut of the spurs
- high feed rates thanks to Z = 3+3

Notes

- cylindrical shank with clamping surface
- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-clamping chuck

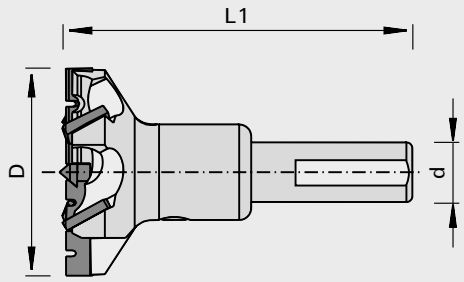
Ø D	Ø d	L3	L1		Ident-No. [L]	Ident-No. [R]
25	10	26	57.5			160384 C
26	10	26	57.5			003278 C
30	10	26	57.5			003280 C
35	10	26	57.5		003285 L	003284 L
35	10	26	57.5	With chip breakers		80459873 L
40	10	26	57.5			713347 C
[mm]	[mm]	[mm]	[mm]			

230115

Cylinder Boring Bits DP

Product

Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- automatic boring machines
- CNC machining centers
- for chip-free drilling in raw and laminated panels

Design

- 2 DP rakers with chip breakers
- 4 DP spurs
- HW centering point
- Multiple resharpening

Advantages

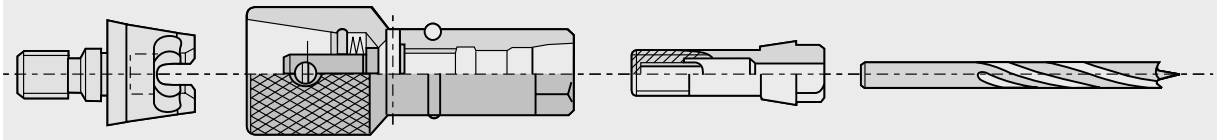
- Long edge life when machining abrasive materials
- Economic efficiency thanks to possibility of multiple resharpening
- Clean holes with no tear out thanks to the special geometry of the 4 spurs
- Centering point for safe spot drilling

Notes

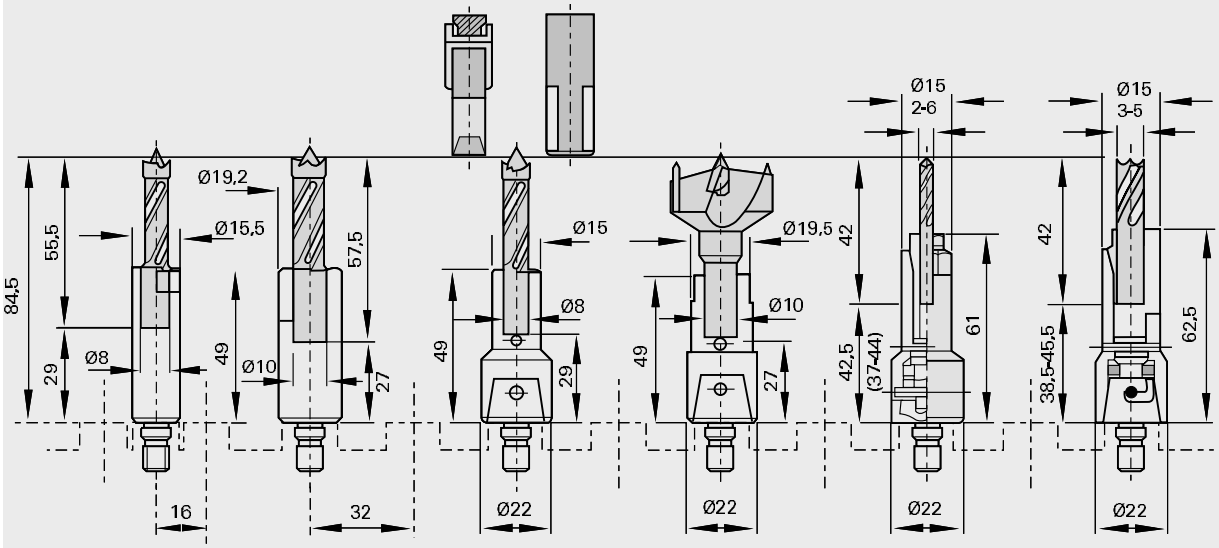
- cylindrical shank with clamping surface
- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-clamping chuck

Ø D [mm]	Ø d [mm]	L1 [mm]	Z	Ident-No. [R]
35	10	57.5	2+4	186782 L
35	10	70	2+4	186783 L

Quick-Change Systems for Boring Bits



Features	Advantages	Benefit
precise tapered adapter	precise radial running accuracy of the boring bit	improved product quality
tight connection	tight connection between boring bit and machine	safe operation
simple locking	quick change of the boring bit	short downtimes
color-coded top part to mark the direction of rotation	quick and easy recognition of the direction of rotation	no high demands on the machine operators
compatible with old "Klack" and combi chuck	upgrading and partial equipping of existing machines possible	low cost



Order / Inquiry for Special Tools: Drill Bits / Plunge Cutters

Please copy and send the completed form to one of the LEUCO sales offices. (Only one tool description per form)

Customer-no.: _____
Company: _____
Plant: _____
Street: _____
Zip / City: _____
Country: _____
Contact partner: _____
Phone: _____

City and Date: _____

Order: o
Inquiry: o

Delivery (week no.): _____
(Not binding)
No. of pieces: _____

Fax: _____

Signature: _____

Machine

Maker: _____
Model: _____
Type: _____
Operating RPM [min-1]: _____
Feed rate [m/min]: _____

Workpiece material

Description: _____

Through hole: o
Blind hole: o
Boring depth [mm]: _____

Coating

Yes o No o

Description: _____
Further Information _____

Product line

topline o
Standard o

Cutting material

Carbide o
Diamond o
HS o

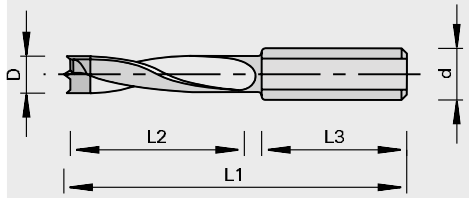
Tool

Twist Drills o
Through-Hole Bits o
Dowel Bits o
Shell countersink o
Countersink for twist drill bits o
Cylinder boring bit Brazed o
With turnover knives o

Bore diameter D [mm]: _____
Effective length L2 [mm]: _____
Overall length L1 [mm]: _____
Shank length L3 [mm]: _____
Shank design d:
Cylindrical shank [Ø]: _____
Other shank types: _____
Type (per enclosure): _____
No. of cutting edges: _____
Rakers: _____
Spur: _____
Sense of rotation: Right o Left o

o check if applicable

Please indicate additional dimension and markings in the tool drawing.

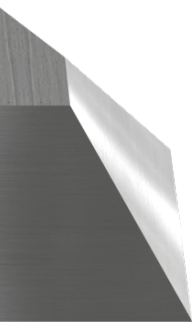


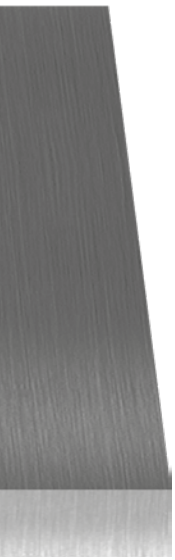


520-01.0708



Turnover Knives, Profile Knives, Knives





Product	Page
Turnover Knives, Profile Knives	6–1
Turnover Spurs	6–13
Centering point	6–14
Radius and Chamfering Turnover Knives / Profile Knives	6–15
Profile Knives / Turnover Knives	6–23
Profile Turnover Knives	6–33
Scraper Turnover Knives / Knives	6–36
Cup Knives	6–56
Cutting edges	6–57
Saw Teeth	6–60
Planing Knives	6–61
Blanks	6–82

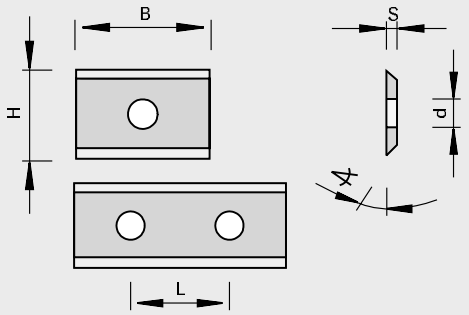
150511 / 150512 / 150515 / 150516 / 150517 / 150717

Turnover Knives HW with 2 cutting edges

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

Design

- topline (polished face and micro-ground clearance angle)
- cutting material: HW
- HW HL Board 01 for wood-based panels and plastics
- HW HL Board 02 for wood-based panels and plastics
- HL Board 06 for wood-based panels, plastics, hard and soft woods
- HL Board 05 for wood-based panels, plastics and hard woods
- HL Solid 20 for hard and soft woods
- HL Solid 20 topline for hard and soft woods

Advantages

- long edge lives and optimum cutting quality in solid woods
- EcoKnife: turnover knife with less weight, less unbalance

Notes

- packing unit: 10 pieces

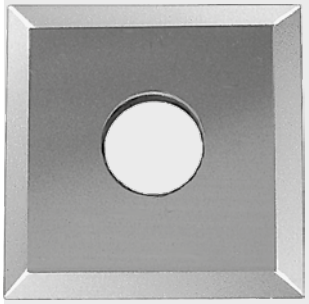
B	H	S	Ø d	L	Wedge◁	LEUCODUR	Ident-No.
7,5	12	1.5	4,0		55	HL Board 05	052543 L
7,5	12	1.5	4,0		45	HL Solid 20	173473 L
9,6	12	1.5	4,0		55	HL Board 05	171163 L
10,5	12	1.5	4,0		55	HL Board 05	162636 L
11	12	1.5	4,0		55	HL Board 05	162637 L
13	12	1.5	4,0		55	HL Board 05	162638 L
15	12	1.5	4,0		55	HL Board 05	003081 L
15	12	1.5	4,0		45	HL Solid 20	173467 C
15,7	12	1.5	4,0		55	HL Board 05	163846 L
17	12	1.5	4,0		55	HL Board 05	162639 L
18	12	1.5	4,0		55	HL Board 05	162520 L
19	12	1.5	4,0		55	HL Board 05	164242 L
20	12	1.5	4,0		55	HL Board 02	176469 L
20	12	1.5	4,0		55	HL Board 06	178287 L
20	12	1.5	4,0		55	HL Board 05	003082 L
20	12	1.5	4,0		45	HL Solid 20 topline	176265 L
20	14.3	2.5	6,3		55	HL Solid 20	168509 L
30	12	1.5	4,0	14	55	HL Board 02	176470 L
30	12	1.5	4,0	14	55	HL Board 06	178288 L
30	12	1.5	4,0	14	55	HL Board 05	003083 L
30	12	1.5	4,0	14	55	HL Board 05 plus	187325 L
30	12	1.5	4,0	14	45	HL Solid 20 topline	176266 L
40	12	1.5	4,0	26	55	HL Board 02	182191 L
40	12	1.5	4,0	26	55	HL Board 05	164078 L
40	12	1.5	4,0	26	45	HL Solid 20 topline	176267 L
50	12	1.5	4,0	26	55	HL Board 02	176471 L
50	12	1.5	4,0	26	55	HL Board 06	178289 L
50	12	1.5	4,0	26	55	HL Board 05	003085 L
50	12	1.5	4,0	26	55	HL Board 05 plus	187326 L
50	12	1.5	4,0	26	45	HL Solid 20 topline	176268 L
60	12	1.5	4,0	26	55	HL Board 05	003086 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

B	H	S	Ø d	L	Wedge◁	LEUCODUR	Ident-No.
60	12	1.5	4,0	26	45	HL Solid 20	173472 C
60	12	1.5	4,0	26	45	HL Solid 20 topline	176269 L
80	13	2.2	4,0	59-61	55	HL Board 06	003087 L
80	13	2.2	4,0	59-61	45	HL Solid 20 topline	181677 L
100	13	2.2	4,0	59-61	55	HL Board 06	003088 L
120	13	2.2	4,0	59-61	55	HL Board 06	003089 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

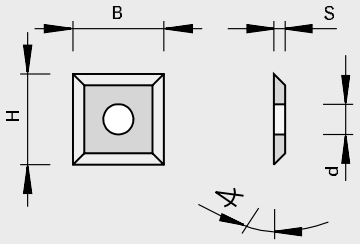
150513 / 150515 / 150516 / 150517 / 150717

Turnover Knives HW with 4 cutting edges

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

Design

- topline (polished face and micro-ground clearance angle)
- cutting material: HW
- HL Board 03 for wood-based panels and plastics
- HL Board 05 for wood-based panels, plastics and hard woods
- HL Board 06 for wood-based panels, plastics, hard and soft woods
- HL Solid 20 topline for hard and soft woods

Advantages

- long edge lives and optimum cutting quality in solid woods

Notes

- packing unit: 10 pieces

B	H	S	Ø d	Wedge◁	LEUCODUR		Ident-No.
10,5	10.5	1.5	4,0	55	HL Board 06		162316 L
12	12	1.5	4,0	55	HL Board 03	*	180820 L
12	12	1.5	4,0	55	HL Board 05	*	003080 L
12	12	1.5	4,0	45	HL Solid 20 topline	*	176340 L
17	17	2.0	4,0	55	HL Board 05	Weinig	162581 L
19	19	2.0	4,0	55	HL Board 05		162582 L
[mm]	[mm]	[mm]	[mm]	[°]			

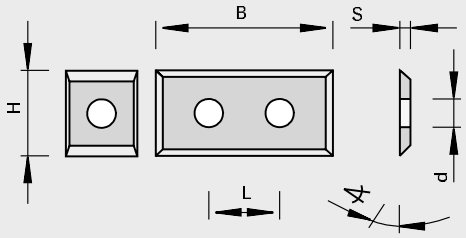
150513 / 150515

Turnover Knives HW with 2 cutting edges, end sharpened

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in shank-type cutters

Design

- cutting material: HW
- HL Board 02 for wood-based panels and plastics
- HL Board 03 for wood-based panels and plastics
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

- packing unit: 10 pieces

B	H	S	Ø d	L	Wedge∢	LEUCODUR	Ident-No.
17,5	7.0	1.5			55	HL Board 05	184257 L
29,5	7.0	1.5	3,3	16	55	HL Board 05	184258 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

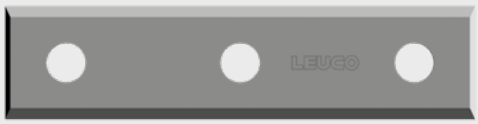
B	H	S	Ø d	L	Wedge∢	LEUCODUR	Ident-No.
29,5	9.0	1.5	4,0	14	55	HL Board 03	180807 L
29,5	9.0	1.5	4,0	14	55	HL Board 05	180821 L
39,5	9.0	1.5	4,0	26	55	HL Board 05	180815 L
49,2	9.0	1.5	4,0	26	55	HL Board 03	180808 L
49,2	9.0	1.5	4,0	26	55	HL Board 05	180806 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

B	H	S	Ø d	L	Wedge∢	LEUCODUR	Ident-No.
9	12	1.5	4,0		55	HL Board 05	167256 L
10	12	1.5	4,0		55	HL Board 05	165914 L
19,5	12	1.5	4,0		55	HL Board 05	183777 L
29,5	12	1.5	4,0	14	55	HL Board 02	181160 L
29,5	12	1.5	4,0	14	55	HL Board 05	180825 L
39,5	12	1.5	4,0	26	55	HL Board 05	171149 L
49,5	12	1.5	4,0	26	55	HL Board 05	180826 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

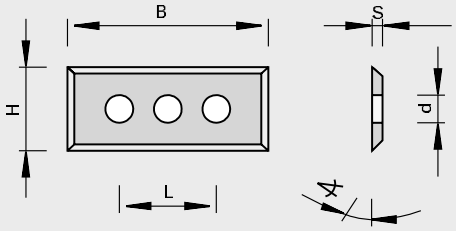
150513 / 150516

Turnover Knives HW with 2 cutting edges, end sharpened - 3 holes

Product



Drawing



LEUCODUR: Tungsten Carbide [HW]

Machine / Application

Design
- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods
- HW HL Board 03 for wood-based panels and plastics

Advantages

Notes
- packing unit: 10 pieces

B	H	S	Ø d	L	Wedge∢	LEUCODUR	Ident-No.
50	9.0	1.5	3,7	37	55	HL Board 03	181982 L
50	12	1.7	4,0	37	55	HL Board 06	179994 L
50	12	1.7	4,0	37	55	HL Board 03	182456 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

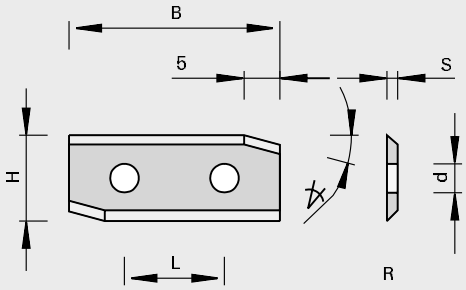
150515

Turnover Knives HW with 2 cutting edges and chamfer - HOLZ-HER

Product



Drawing



LEUCODUR: Tungsten Carbide [HW]

Machine / Application
- machines HOLZ-HER
- for use in edge banding / jointing cutterheads

Design
- grinding angle 55 degrees
- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods

Advantages

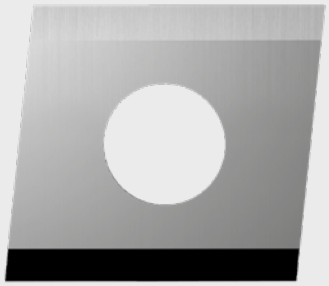
Notes
- packing unit: 10 pieces

Chamfer∢	B	H	S	Ø d	L	Ident-No. [L]	Ident-No. [R]
15	29,5	12	1.5	4,0	14	160118 L	160618 L
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		

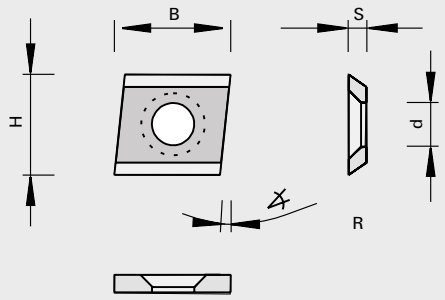
150516

Turnover Knives HW with 2 cutting edges, edge bevel - Brandt, Ott

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- machines Brandt, Ott
- Brandt: for use in grooving cutterheads and prism cutterheads or as flat scraper
- Ott: for the use as flat scraper

Design

- grinding angle 55 degrees
- cutting material: HW
- HL Board 06 for hard and soft woods

Advantages

Notes

- packing unit: 10 pieces

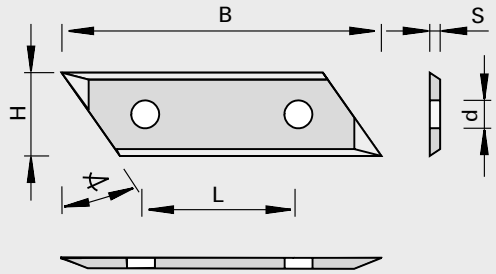
B	H	S	Ø d	Clearance ◁ 1	Ident-No. [L]	Ident-No. [R]
15	14.3	2.5	6,3	6	186195 L	186196 L
[mm]	[mm]	[mm]	[mm]	[°]		

150515

Turnover Knives HW with 2 cutting edges, edge bevel for scribing cutterheads

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in scribing cutters

Design

- grinding angle 55 degrees
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

- packing unit: 10 pieces

B	H	S	Ø d	L	◁	Ident-No.
40	12	1.5	4,0	25,1	15	185369 L
50	12	1.5	4,0	26	35	185140 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	

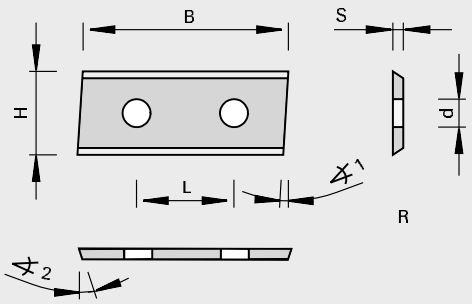
150515

Turnover Knives HW with 2 cutting edges, edge bevel and end sharpened

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- for use in V-grooving cutter-heads and prism cutterheads

Design

- grinding angle 55 degrees
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

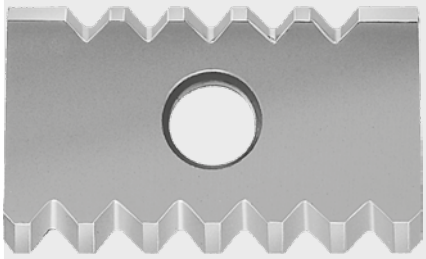
- packing unit: 10 pieces

B	H	S	Ø d	L	Clearance ◁ 1	Clearance ◁ 2	Ident-No. [L]	Ident-No. [R]
19,5	12	1.5	4,0		3.5	10	160626 L	160625 L
29,5	12	1.5	4,0	14	5		003119 L	003118 L
49,2	12	1.5	4,0	26	5		003121 L	003120 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	[°]		

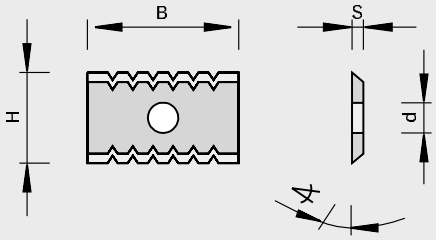
150515

Turnover Knives HW with 2 cutting edges - interrupted cutting edges

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- for use in hoggers

Design

- chip breakers for optimum cut division
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

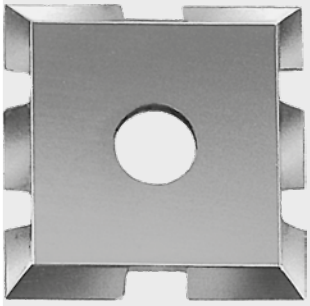
- packing unit: 10 pieces

B	H	S	Ø d	Wedge◁	Ident-No.
20	12	1.5	4,0	55	055905 C
[mm]	[mm]	[mm]	[mm]	[°]	

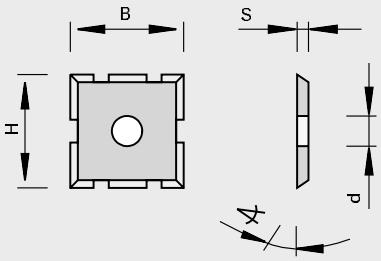
150517

Turnover Knives HW with 4 cutting edges - interrupted cutting edges

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

Design

- chip breakers for optimum cut division
- cutting material: HW
- HL Solid 20 for hard and soft woods

Advantages

Notes

- packing unit: 10 pieces

B	H	S	Ø d	Wedge◁	Ident-No.
15 [mm]	15 [mm]	2.0 [mm]	4,0 [mm]	55 [°]	167873 L

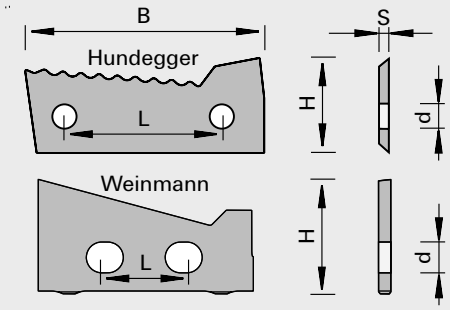
151587

Profile knives HW - for dove-tail profiles

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- for dove-tail cutterheads by Hundegger, Weinmann
- joinery machining

Design

- cutting material: HW
- HL Solid 20 for hard and soft woods

Advantages

Notes

- packing unit see table

B	H	S	Ø d	L	Wedge◁	Profile		PU	Ident-No. [L]	Ident-No. [R]
39,5	15.7	1.5	4,0	26	55	A	Hundegger	3	185205 L	185510 L
39,5	15.7	1.5	4,0	26	55	B	Hundegger	3	185206 L	185511 L
39,5	15.7	1.5	4,0	26	55	C	Hundegger	3	185207 L	185512 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]			[pc.]		

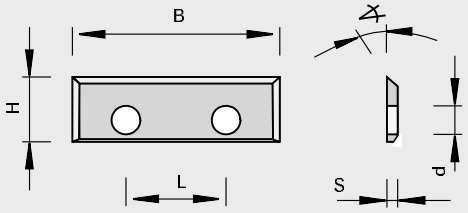
B	H	S	Ø d	L	Wedge◁			PU	Ident-No.
34,9	18.6	2.0	5,0	13,8	55	without serration	Weinmann	2	185363 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]			[pc.]	

150523 / 150525

Profile Knives HW with 1 cutting edge, end sharpened

Product

Drawing



Tungsten Carbide [HW]

Machine / Application
- for use in shank-type cutters

Design
- cutting material: HW
- HW HL Board 03 for wood-based panels and plastics
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes
- packing unit: 10 pieces

B	H	S	Ø d	L	Wedge∢	LEUCODUR	Ident-No.
16	7.0	1.5	3,4	7,0	55	HL Board 03	180262 L
23	7.0	1.5	3,4	14	55	HL Board 05	182697 L
28	7.0	1.5	3,4	14	55	HL Board 03	180260 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

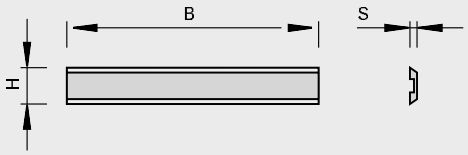
150515

Turnover Knives HW with 2 cutting edges - Leitz

Product



Drawing



Tungsten Carbide [HW]

Machine / Application
- for use in Leitz cutterheads

Design
- cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods

Advantages

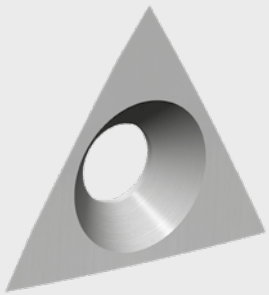
Notes
- packing unit: 10 pieces

B	H	S	Ident-No.
14,7	8.0	1.5	181504 L
19,7	8.0	1.5	181505 L
30	8.0	1.5	181506 L
35	8.0	1.5	181507 L
40	8.0	1.5	181508 L
50	8.0	1.5	181509 L
60	8.0	1.5	181510 L
80	8.0	1.5	181511 C
[mm]	[mm]	[mm]	

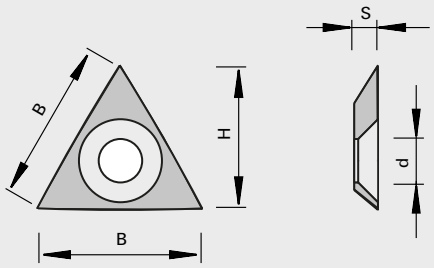
150567

Turnover Knives HW with 3 cutting edges and countersink - with rounded edges

Product



Drawing



LEUCODUR

Tungsten Carbide [HW]

Machine / Application

- for use in t3-System cutter-heads

Design

- Cutting material: HW
- HL Solid 20 for hard wood and soft wood
- HL Board 06 for wood-based materials, plastics and hard woods
- topcoat coating for increased edge lives

Advantages

Notes

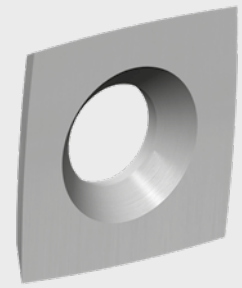
- Turnover knife 9209773 scoring without projection, suitable for jointing without groove

B	H	S	Ø d	LEUCODUR	PU	Ident-No.
20,38	17.9	3.0	5,5	HL Solid 20	10	9209773 O
20,88	18.3	3.0	5,5	HL Board 06	10	187692 L
20,88	18.3	3.0	5,5	HL Solid 20	10	187251 L
20,88	18.3	3.0	5,5	HL Solid 20 topcoat	10	187694 L
[mm]	[mm]	[mm]	[mm]		[pc.]	

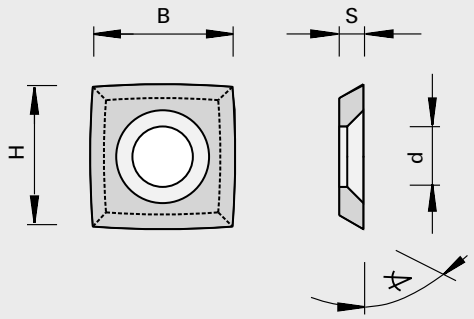
150566 / 150567 / 150568

Turnover Knives HW with 4 cutting edges and countersink - with rounded edges

Product



Drawing



LEUCODUR

Tungsten Carbide [HW]

Machine / Application

- 187252 for use on SCM MBM planing shaft
- 187253 for use on format 4 Silent-Power® planing shafts with spiral blades
- 187254 for use on Martin Xplane planing shafts

Design

- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods
- HL Solid 20 for hard and soft woods
- HL Solid 30 for hard and soft woods

Advantages

Notes

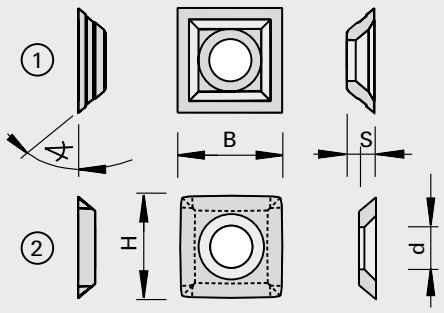
B	H	S	Ø d	Wedge◁		LEUCODUR	PU	Ident-No.
13,81	13.81	2.5	6,2	60	with rounded edges (R=150 mm)	HL Board 06	10	187253 L
15	15	2.5	6,25	60	with rounded edges (R=95 mm)	HL Solid 30	10	187252 L
15	15	2.5	6,7	50	with rounded edges (R=100 mm)	HL Solid 20	10	187254 L
[mm]	[mm]	[mm]	[mm]	[°]			[pc.]	

150557 / 150566 / 150567 / 150568

Turnover Knives HW with 4 cutting edges with countersink - Hundegger, surfCut cutterhead

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application
- machines Hundegger
- for use in cutterheads

Design
- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods
- HL Solid 20 for hard and soft woods
- HL Solid 30 for hard and soft woods

Advantages
- compared to uncoated HW-Turnover Knives the edge lives is 2 - 3 times as long

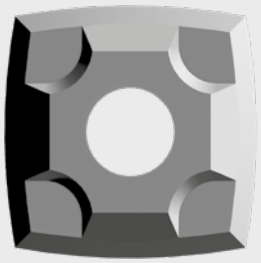
Notes
- packing unit 10 pieces
- Attention! it is not permitted to mount Ident-No. 186667 + 186668 togehter in one cutterhead. Danger of unbalance!

Type	B	H	S	Ø d	Wedge◁			LEUCODUR	Ident-No.
1	20,6	20.6	5.5	7,3	50	with rounded edges (R=172 mm) for Ø D=250-350 mm	surfCut cutterhead	HL Solid 30	186667 L
1	21	21	5.5	7,3	50	with groove	Hundegger	HL Solid 30	186668 L
2	11,95	11.95	1.5	4,0	55	with rounded edges (R=70 mm)	Hundegger	HL Board 06	186448 L
2	13,8	13.8	2.5	6,2	60	with rounded edges (R=180 mm) for Ø D=300-350 mm	surfCut cutterhead	HL Solid 20	184942 L
2	15	15	2.5	6,2	50	with rounded edges (R=170 mm)	Hundegger	HL Solid 20	185367 L
2	15	15	2.5	6,2	50	with rounded edges (R=170 mm)	Hundegger	HL Solid 20 topcoat	80475550 L
	[mm]	[mm]	[mm]	[mm]	[°]				

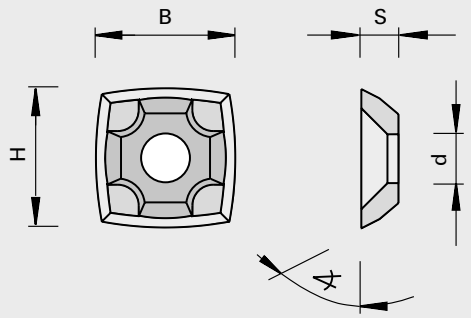
150569

Turnover Knives HW with 4 cutting edges with countersink - EWD, Linck

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application
- machines EWD, Linck
- for use in cutterheads

Design
- Cutting material: HW
- HL Solid 20 for hard wood and soft wood
- HL Board 06 for wood-based materials, plastics and hard woods
- topcoat coating for increased edge lives

Advantages

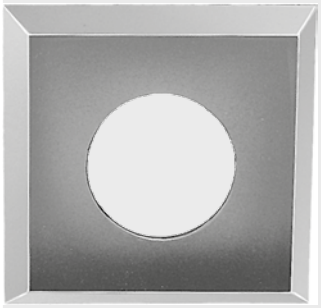
Notes
- packing unit 10 pieces

B	H	S	Ø d	Wedge◁		LEUCODUR	Ident-No.
21	21	5.5	7,3	63	for Ø D=402 mm	HL Solid 60	186111 L
21	21	5.5	7,3	63	for Ø D=360 mm	HL Solid 60	186110 L
[mm]	[mm]	[mm]	[mm]	[°]			

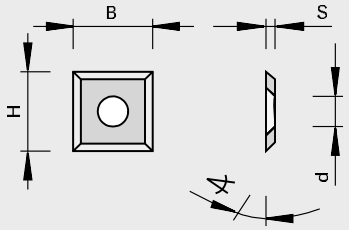
15...

Turnover Knives HW with 4 cutting edges and countersink

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- machines Homag, Fischer Brugg, IMA, Weinig, Lestro, HOLZ-HER
- for the use as flat scraper on Homag edge banding machines FA20 + FA21
- for use in edge jointing cutterheads
- for use in spiral cutterheads
- for use in cutterheads

Design

- topline (polished face and micro-ground clearance angle)

Advantages

Notes

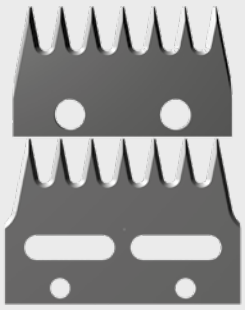
- Ident-No. 167777 for scoring device of the HOLZ-HER vertical panel sizing saw
- * marking for easier mounting
- packing unit: 10 pieces

B	H	S	Ø d	Wedge◁	LEUCODUR		Ident-No.
10,5	10.5	1.5	4,0	55	HL Solid 20	Lestro	176719 L
13,6	13.6	2.0	6,3	45	HL Solid 30	Fischer Brugg	163829 L
14	14	1.2	8,6	60	HL Solid 30		163701 L
14	14	1.2	8,6	60	HL Solid 30	HOLZ-HER	167777 L
14	14	2.0	6,3	60	HL Solid 20 topline		176341 L
14	14	2.0	6,3	60	HL Solid 30	Weinig	003079 L
14	14	2.0	6,3	60	HL Board 05		180954 L
14	14	2.0	6,3	60	HL Board 03		180646 L
14,3	14.3	2.5	6,3	45	HL Solid 20	IMA	183828 L
14,3	14.3	2.5	6,3	55	HL Solid 20	Homag (FA20 + FA21)	170248 L
15	15	2.5	6,2	50	HL Solid 20	Chamfering Cutterhead	181243 L
15	15	2.5	6,2	60	HL Solid 20	Weinig	185276 C
15	15	2.5	6,2	60	HL Solid 20	with rounded edges (R=50 mm for Spiral Cutterheads)	180454 L
15	15	2.5	6,4	60	HL Solid 60	with rounded edges (R=115 mm)	185950 C
15	15	2.5	6,4	60	HL Solid 20	with rounded edges (R=150)	185274 L
15	15	2.5	6,2	60	HL Board 06	with rounded edges (R=150 mm)	187324 L
15	15	2.5	6,2	60	HL Solid 20	with rounded edges (R=150 mm)	187323 L
15	15	2.5	6,4	50	HL Solid 20	with rounded edges (R=190 mm for Weinig Powerlock Dual Tools Ø D=125 mm 541/542)	185865 L
22	22	2.0	6,5	60	HL Solid 20	Weinig	185277 L
[mm]	[mm]	[mm]	[mm]	[°]			

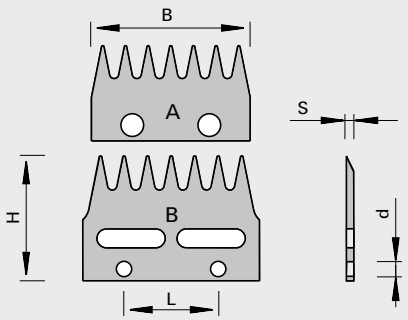
151586

Chip wiper insert knives HW - IMA

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- machines IMA

Design

- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods

Advantages

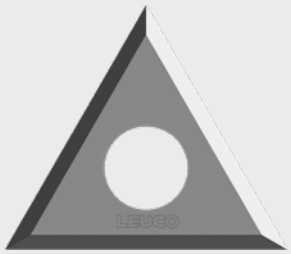
Notes

B	H	S	Ø d	L	Type	PU	Ident-No.
70	42	2.0	10	34	A	2	185872 C
75	53	2.0	6,5	40	B	2	185873 C
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

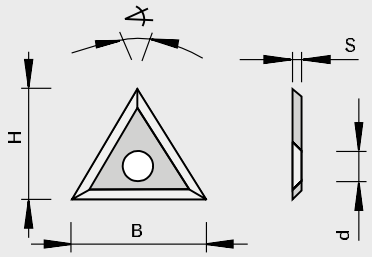
150557

Triangular Spur HW with 3 cutting edges

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- for use in Leitz cutterheads

Design

- cutting material: HW
- HL Solid 20 for hard and soft woods

Advantages

Notes

B	H	S	Ø d	Corner◁	LEUCODUR	PU	Ident-No.
22	19.05	2.0	6,5	60	HL Solid 20	10	180779 L
[mm]	[mm]	[mm]	[mm]	[°]		[pc.]	

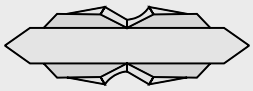
150556

Turnover spurs HW

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

Design

- cutting edge with scoring cut
- cutting material: HW
- HL Board 06 for wood-based panels, hard and soft woods

Advantages

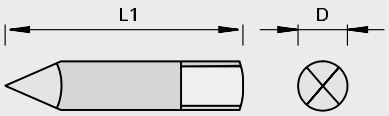
- chip-free hole edges thanks to cutting edge with scoring cut

Notes

Dimension	LEUCODUR	PU	Ident-No.
18x5,7x3,5	HL Board 06	10	187303 L
18x5,7x3,5	HL Solid 20	10	181263 L
[mm]		[pc.]	

165512

Centering points HW

Product	Drawing		
			LEUCO DUR Tungsten Carbide [HW]

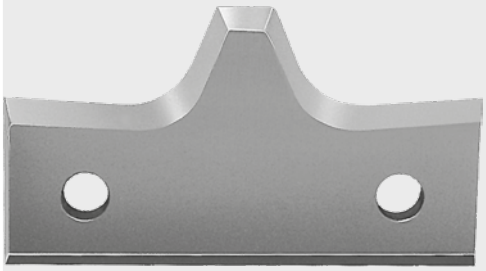
Machine / Application	Design	Advantages	Notes
	l with surface on shank for set screw l cutting material: HW l HL Solid 40 for hard and soft woods		l packing unit: 10 pieces

Ø D	L1	Ident-No.
3.0 [mm]	33.5 [mm]	162624 L

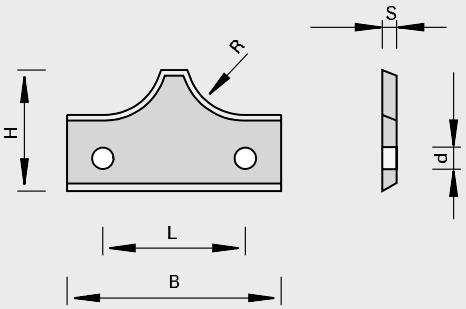
151545

Radius Profile Knives HW with 2 cutting radii and bottom chamfer - Homag, IMA

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in edge rounding cutterheads

Design

- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

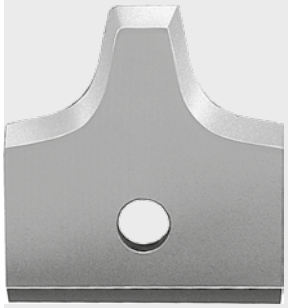
- packing unit: 10 pieces

R	B	H	S	Ø d	L		Ident-No.
4,0	20,8	15	2.0	3,0	12	Homag	163064 C
2,0	20,8	14.7	2.0	3,0	12	IMA	164166 S
3,0	20,8	14.7	2.0	3,0	12	IMA	164167 S
4,0	20,8	14.7	2.0	3,0	12	IMA	164168 S
5,0	30,5	16.5	2.0	3,0	20	IMA	164169 S
6,0	30,5	16.5	2.0	3,0	20	IMA	164170 S
7,0	30,5	16.5	2.0	3,0	20	IMA	164171 S
8,0	30,5	16.5	2.0	3,0	20	IMA	164172 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

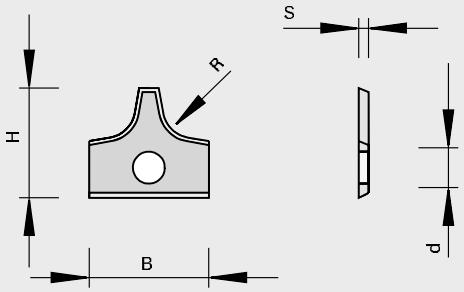
151545 / 151585

Radius Profile Knives HW with 2 cutting radii and bottom chamfer

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- type A for use in edge rounding cutterheads
- type B for use in scraper holders

Design

- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

R	B	H	S	Ø d	Profile run-out	Type		PU	Ident-No.
2,0	12	12	1.5	4,0	5	A	HOLZ-HER	10	170340 L
3,0	12	12	1.5	4,0	5	A	HOLZ-HER	10	170341 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]			[pc.]	

R	B	H	S	Ø d	Profile run-out	Type		PU	Ident-No.
2,0	16	15.5	2.0	4,4	10	A	Brandt	10	182087 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]			[pc.]	

R	B	H	S	Ø d	Profile run-out	Type		PU	Ident-No.
1,0	16	17.5	2.0	4,4	10	A	HOLZ-HER, Homag, Ott, IMA, Wilmsmeyer, Brandt	10	186745 L
1,5	16	17.5	2.0	4,4	10	A	HOLZ-HER, Homag, Ott, IMA, Wilmsmeyer, Brandt	10	176583 L
2,0	16	17.5	2.0	4,4	10	A	HOLZ-HER, Homag, Ott, IMA, Wilmsmeyer, Brandt	10	163489 L
2,0	16	17.5	2.0	4,4	10	A	Brandt	10	180153 L
2,5	16	17.5	2.0	4,4	10	A		10	171178 C
3,0	16	17.5	2.0	4,4	10	A	HOLZ-HER, Homag, Ott, IMA, Wilmsmeyer, Brandt	10	163490 L
3,0	16	17.5	2.0	4,4	10	A	Brandt	10	180154 L
4,0	16	17.5	2.0	4,4	10	A	HOLZ-HER, Homag, Ott, IMA, Wilmsmeyer, Brandt	10	163491 L
5,0	16	17.5	2.0	4,4	10	A	HOLZ-HER, Homag, Ott, IMA, Wilmsmeyer, Brandt	10	163492 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]			[pc.]	

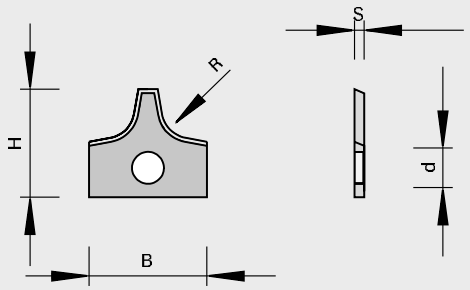
R	B	H	S	Ø d	Profile run-out	Type		PU	Ident-No.
2,0	16	17.5	2.0	3,0	10	B	IMA, Wilmsmayer, Torwegge	10	173475 L
2,5	16	17.5	2.0	3,0	10	B	IMA, Wilmsmayer, Torwegge	10	173476 C
3,0	16	17.5	2.0	3,0	10	B	IMA, Wilmsmayer, Torwegge	10	173477 L
4,0	16	17.5	2.0	3,0	10	B	IMA, Wilmsmayer, Torwegge	10	173478 C
5,0	16	17.5	2.0	3,0	10	B	IMA, Wilmsmayer, Torwegge	10	173479 C
[mm]	[mm]	[mm]	[mm]	[mm]	[°]			[pc.]	

151545 / 151585

Radius Profile Knives HW with 2 cutting radii

Product

Drawing



Tungsten Carbide [HW]

Machine / Application
- for use in edge rounding cutterheads

Design
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes
- packing unit: 10 pieces

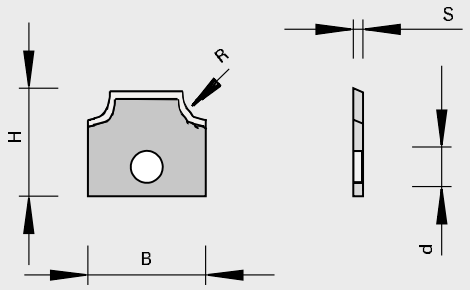
R	B	H	S	Ø d	Profile run-out		Ident-No.
2,0	12	13	2.0	5,0	10	Brandt	177033 L
2,5	12	13	2.0	4,0	10		173707 L
3,0	12	13	2.0	5,0	10	Brandt	177032 L
6,0	24	22	2.0	4,4	10	Homag, Ott	170258 L
8,0	24	22	2.0	4,4	10	Homag, Ott	170260 L
9,0	24	22	2.0	4,4	10	Homag, Ott	170261 S
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

151586

Radius Profile Knives HW with 2 cutting radii - EBM, Hebrock

Product

Drawing



Tungsten Carbide [HW]

Machine / Application
- edge banding machines EBM, Hebrock
- for use in edge rounding cutterheads

Design
- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods

Advantages

Notes
- packing unit: 10 pieces

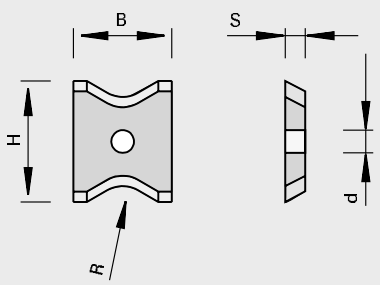
R	B	H	S	Ø d	Profile run-out		Ident-No.
2,0	16	13.5	2.0	5,0	5	EBM, Hebrock	180151 C
3,0	16	13.5	2.0	5,0	5	EBM, Hebrock	180152 C
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

151555

Radius Profile Knives HW symmetrical with 2 cutting radii

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in edge banding / rounding cutterheads

Design

- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

- packing unit: 10 pieces

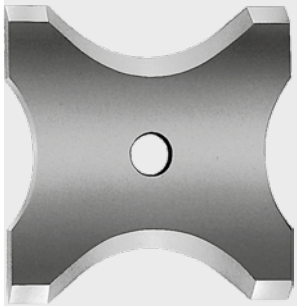
R	B	H	S	Ø d	Profile run-out		Ident-No.
2,0	13	16	2.0	4,0	5		162794 L
3,0	13	16	2.0	4,0	5		162795 L
4,0	13	16	2.0	4,0	5		162565 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

R	B	H	S	Ø d	Profile run-out		Ident-No.
2,0	13	16	2.0	4,0	15	IMA	172713 L
3,0	13	16	2.0	4,0	15	IMA	172714 C
4,0	13	16	2.0	4,0	15	IMA	172715 C
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

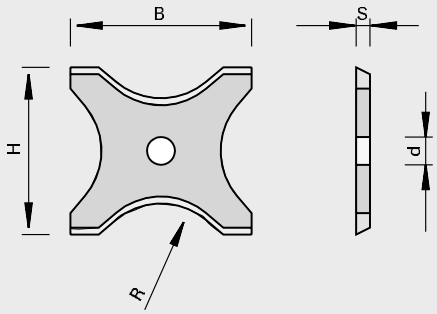
151555

Radius Turnover Knives HW symmetrical with 2 cutting radii

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in edge banding / rounding cutterheads

Design

- 5 degree profile run-out
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

- packing unit: 10 pieces

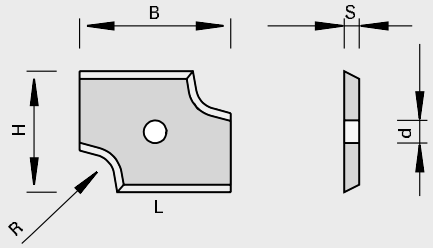
R	B	H	S	Ø d	Ident-No.
5,0	20	21	2.0	4,0	162566 L
6,0	20	21	2.0	4,0	162567 S
7,0	20	21	2.0	4,0	162568 C
8,0	20	21	2.0	4,0	162569 L
9,0	26	24	2.0	4,0	162796 C
10	26	24	2.0	4,0	162570 L
11	26	24	2.0	4,0	162571 S
12	26	24	2.0	4,0	162572 L
[mm]	[mm]	[mm]	[mm]	[mm]	

151555

Radius Turnover Knives HW with 2 cutting radii

Product

Drawing



Tungsten Carbide [HW]

Machine / Application
- for use in edge rounding cutterheads

Design
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

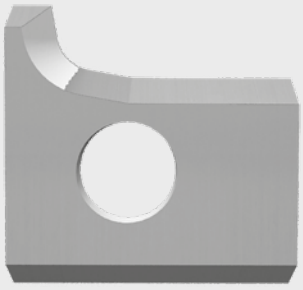
Notes
- packing unit: 10 pieces

R	B	H	S	Ø d		Ident-No. [L]	Ident-No. [R]
3,0	20	16	2.0	3,0		168355 L	168356 L
2,0	30	14	2.0	4,0	Reich	177136 C	177135 C
2,5	30	14	2.0	4,0	Reich	177138 C	177137 C
3,0	30	14	2.0	4,0	Reich	177140 C	177139 C
[mm]	[mm]	[mm]	[mm]	[mm]			

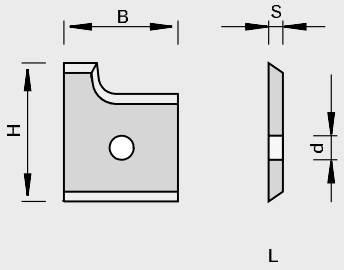
151545 / 151546

Radius Profile Knives HW with 1 cutting radius and bottom chamfer

Product



Drawing



Tungsten Carbide [HW]

Machine / Application
- for use in edge rounding cutterheads

Design
- cutting material: HW
- HL Board 05 and HL Board 06 for wood-based panels, plastics and hard woods

Advantages

Notes
- packing unit: 10 pieces

R	B	H	S	Ø d	LEUCODUR	Ident-No. [L]	Ident-No. [R]
1,0	12	14.5	2.0	4,0	HL Board 05	187335 C	187336 C
1,5	12	14.5	2.0	4,0	HL Board 05	187337 C	187338 C
2,0	12	14.5	2.0	4,0	HL Board 05	172142 L	172141 L
2,5	12	14.5	2.0	4,0	HL Board 05	171224 C	171223 L
3,0	12	14.5	2.0	4,0	HL Board 05	172144 L	172143 L
1,0	14,5	14.5	2.0	5,0	HL Board 06	187331 L	187332 L
1,5	14,5	14.5	2.0	5,0	HL Board 06	187333 L	187334 L
2,0	14,5	14.5	2.0	5,0	HL Board 06	185377 L	185376 L
2,5	14,5	14.5	2.0	5,0	HL Board 06	181657 L	181658 L
[mm]	[mm]	[mm]	[mm]	[mm]			

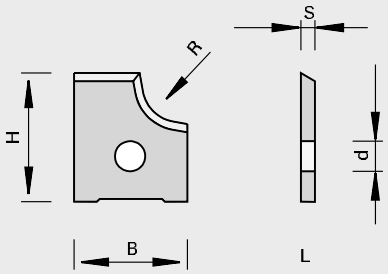
151545/151546/151586

Radius Profile Knives HW with 1 cutting radius

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in rounding cutterheads

Design

- cutting material: HW
- HL Board 05 and HL Board 06 for wood-based panels, plastics and hard woods

Advantages

Notes

- packing unit: 10 pieces

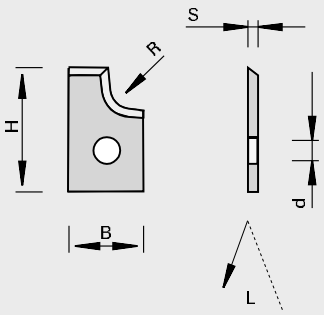
R	B	H	S	Ø d	Profile run-out		LEUCODUR	Ident-No. [L]	Ident-No. [R]
2,0	12	15	2.0	4,0	10		HL Board 06	177034 L	177038 L
1,5	12	17	2.0	5,0	13	Homag	HL Board 06	177605 L	177606 L
2,0	12	17	2.0	5,0	13	Homag	HL Board 06	177607 L	177608 L
2,5	12	17	2.0	5,0	13	Homag	HL Board 06	177609 C	177610 C
3,0	12	17	2.0	5,0	13	Homag	HL Board 06	177611 L	177612 L
2,0	12	18	2.0	4,0	11		HL Board 05		172725 C
3,0	12	18	2.0	4,0	11		HL Board 05		172726 C
1,0	13	15	2.0	4,0	10		HL Board 05	180722 L	180721 L
1,5	13	15	2.0	4,0	10		HL Board 05	181954 L	181953 L
2,0	13	15	2.0	4,0	10		HL Board 05	181956 L	181955 L
2,5	13	15	2.0	4,0	10		HL Board 05	180728 C	180727 C
3,0	13	15	2.0	4,0	10		HL Board 05	181957 L	181958 L
4,0	14	17	2.0	4,0	10		HL Board 06	177036 C	177040 C
2,0	15	14.5	2.0	4,0	15		HL Board 05	177317 L	177318 L
2,5	15	14.5	2.0	4,0	15		HL Board 05	177319 L	177320 L
3,0	15	14.5	2.0	4,0	15		HL Board 05	177321 L	177322 L
5,0	15	17	2.0	4,0	10		HL Board 05	177037 L	177041 C
3,0	15	18.4	2.0	4,0	5		HL Board 06	168272 C	168279 C
4,0	15	18.4	2.0	4,0	5		HL Board 06	168273 C	168280 C
5,0	15	18.4	2.0	4,0	5		HL Board 06	168274 C	168281 C
6,0	15	21.6	2.0	4,0	5		HL Board 06	168286 C	168293 S
8,0	15	21.6	2.0	4,0	5		HL Board 06	168288 C	168295 C
2,0	16,1	14	2.0	4,0	15		HL Board 06	178219 L	178218 L
3,0	16,1	14	2.0	4,0	15		HL Board 06	178221 L	178220 L
2,0	19,6	15.2	2.0	4,0	15		HL Board 05	173817 L	173816 L
3,0	19,6	15.2	2.0	4,0	15		HL Board 05	173393 L	173392 L
9,0	20	25.8	2.0	4,0	5		HL Board 06	168301 S	168310 S
10	20	25.8	2.0	4,0	5		HL Board 06	168302 S	168311 S
12	20	25.8	2.0	4,0	5		HL Board 06	168304 S	168313 S
[mm]	[mm]	[mm]	[mm]	[mm]	[°]				

151545

Radius Profile Knives HW with 1 cutting radius - IMA

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application
- machines IMA
- for use in rounding cutterheads

Design
- 15 degree profile run-out
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

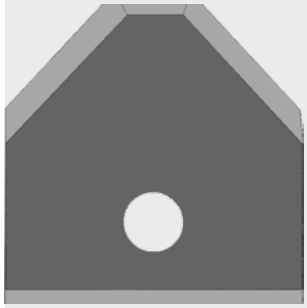
Notes
- packing unit: 10 pieces

R	B	H	S	Ø d	Ident-No. [L]	Ident-No. [R]
2,0	12	18	2.0	5,0	180174 L	180173 L
3,0	12	18	2.0	5,0	180176 L	180175 L
[mm]	[mm]	[mm]	[mm]	[mm]		

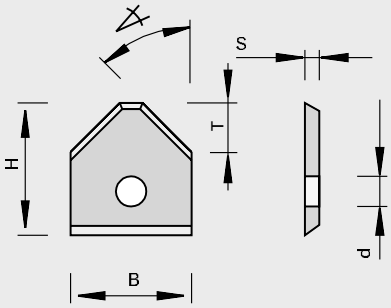
151545

Chamfering Knives HW with 2 cutting radii

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application
- for use in edge rounding cutterheads

Design
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

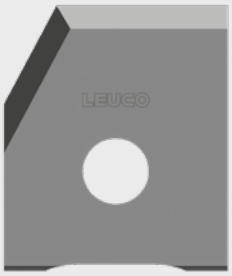
Notes
- Ident-No. 180792 for Modula
- packing unit: 10 pieces

Chamfer◁	B	H	S	Ø d	T	Ident-No.
45	12	12	1.5	4,0	4,2	171190 L
45	12	12	1.5	4,0	5,5	180792 L
45	16	17.5	2.0	3,0	5,9	169292 L
45	16	17.5	2.0	4,3	6,4	170329 L
[°]	[mm]	[mm]	[mm]	[mm]	[mm]	

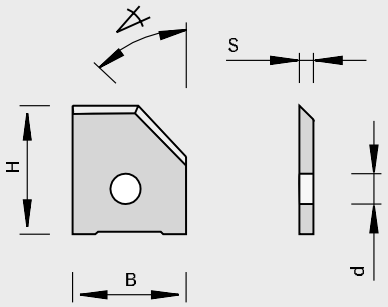
151586

Chamfering Knives HW with 1 cutting radius

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- machining centers Homag
- for use in chamfering cutter-heads

Design

- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods

Advantages

Notes

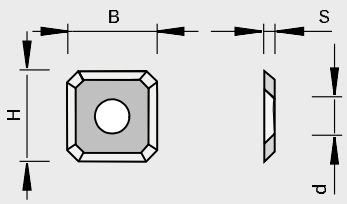
Chamfer	B	H	S	Ø d	LEUCODUR	PU	Ident-No. [L]	Ident-No. [R]
5	12	16	2.0	5,0	HL Board 06	10	179174 C	179173 C
15	11,7	16	2.0	4,0	HL Board 06	10	177042 L	177045 L
30	13,5	16	2.0	4,0	HL Board 06	10	177043 L	177046 L
45	12,2	16	2.0	4,0	HL Board 06	10	177822 L	177823 L
45	15	16	2.0	4,0	HL Board 06	10	177044 C	177047 C
[°]	[mm]	[mm]	[mm]	[mm]		[pc.]		

151553

Profile Turnover Knives HW for aluminum composite materials - HOLZ-HER, 90 degrees

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- vertical panel sizing saws HOLZ-HER
- for use in 90 degree Folding cutterhead Ident-No. 182616 for the machining of aluminum composite materials

Design

- cutting material: HW
- HL Board 03 for hard and soft woods

Advantages

Notes

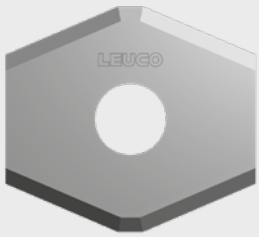
- packing unit: 10 pieces

B	H	S	Ø d	◁	Ident-No.
14 [mm]	14 [mm]	2.0 [mm]	6,4 [mm]	90 [°]	182079 L

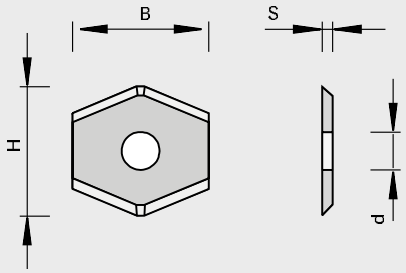
151516

Profile Turnover Knives HW for aluminum composite materials - HOLZ-HER, 135 degrees

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- vertical panel sizing saws HOLZ-HER
- for use in 135 degree Folding cutterhead Ident-No. 703144 for the machining of aluminum composite materials

Design

- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods

Advantages

Notes

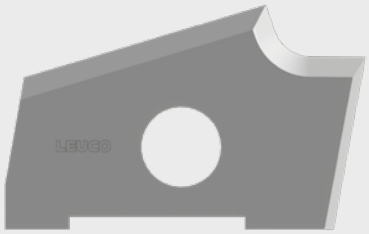
- packing unit: 10 pieces

B	H	S	Ø d	◁	Ident-No.
20 [mm]	18 [mm]	2.0 [mm]	5,7 [mm]	135 [°]	182080 C

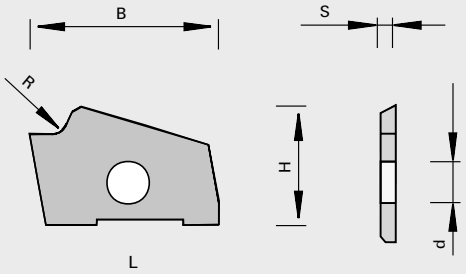
151586

Radius Profile Knives HW - Brandt

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- edge banding machines Brandt since date of fabrication 2005
- for use in rounding cutterheads with special chip removing design

Design

- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods

Advantages

Notes

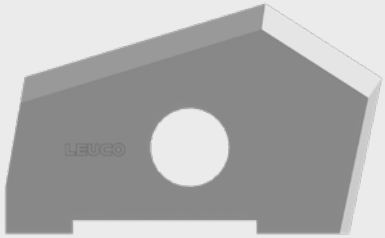
- packing unit: 10 pieces

R	B	H	S	Ø d	Ident-No. [L]	Ident-No. [R]
1,0	22,32	14	2.0	5,0	185238 L	185239 L
1,5	22,32	14	2.0	5,0	183068 C	183067 C
2,0	22,32	14	2.0	5,0	182332 L	182331 L
2,5	22,32	14	2.0	5,0	182368 C	182367 C
3,0	22,32	14	2.0	5,0	182334 L	182333 L
[mm]	[mm]	[mm]	[mm]	[mm]		

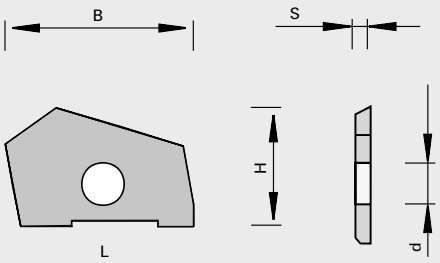
151586

Chamfering Profile Knives HW - Brandt

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- edge banding machines Brandt since date of fabrication 2005
- for use in rounding cutterheads with special chip removing design

Design

- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods

Advantages

Notes

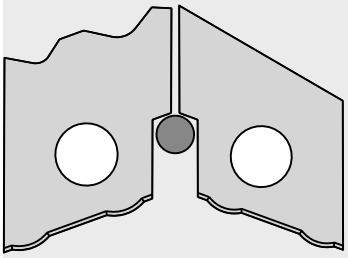
- packing unit: 10 pieces

Chamfer∢	B	H	S	Ø d	Ident-No. [L]	Ident-No. [R]
45	22,32	14	2.0	5,0	182667 L	182666 L
[°]	[mm]	[mm]	[mm]	[mm]		

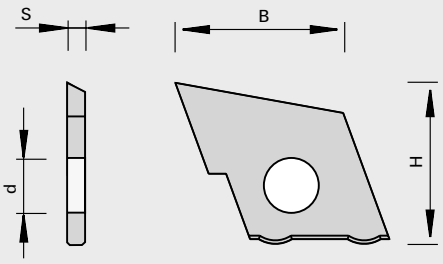
151546

Multi Profile Knives HW - Homag (Brandt) - up to 2022

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

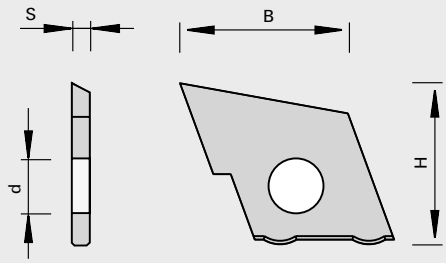
- edge banding machines Homag (Brandt) - up to 2022
- for use in chip-optimized multi-profile cutterheads
- for profiling of soft-wood, hard-wood, veneer and plastic edge bands

Design

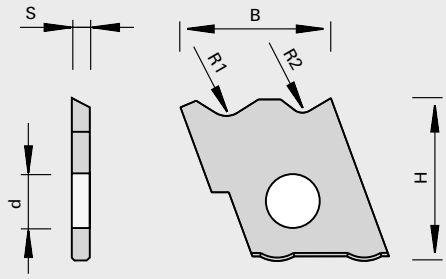
- Cutting material: HW
- HL Board 05 for wood-based materials, plastics and hard woods
- 2 different profile combinations on one plate

Advantages

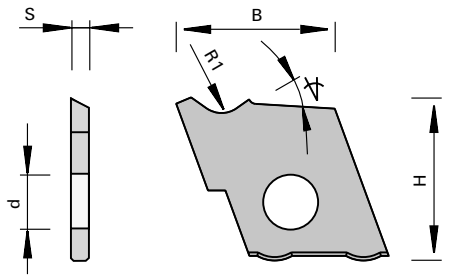
Notes



	B	H	S	Ø d	PU	Ident-No. [L]	Ident-No. [R]
	14,37	13.78	2.0	4,7	10	187218 L	187219 L
	[mm]	[mm]	[mm]	[mm]	[pc.]		



R1	R2	B	H	S	Ø d	PU	Ident-No. [L]	Ident-No. [R]
2.0	1.0	13,13	14.5	2.0	4,7	10	187220 L	187221 L
2.0	1.3	13,13	14.5	2.0	4,7	10	187222 L	187223 L
2.0	1.5	13,13	14.5	2.0	4,7	10	187228 L	187229 L
3.0	1.0	13,13	14.5	2.0	4,7	10	187226 L	187227 L
3.0	1.3	13,14	14.5	2.0	4,7	10	187224 L	187225 L
3.0	2.0	13,13	14.5	2.0	4,7	10	187230 C	187231 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]		



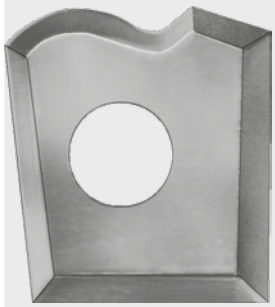
R1	Chamfer◁	B	H	S	Ø d	PU	Ident-No. [L]	Ident-No. [R]
1.0	45	13,57	13.75	2.0	4,7	10	187234 C	187235 C
1.3	45	13,56	13.75	2.0	4,7	10	187236 C	187237 C
1.5	45	13,57	13.75	2.0	4,7	10	187238 C	187239 C
2.0	45	13,58	13.75	2.0	4,7	10	187232 C	187233 C
[mm]	[°]	[mm]	[mm]	[mm]	[mm]	[pc.]		

Spare parts / Accessories	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M4x5,9 T15	995195	10	167966 L
Screwdrivers	T15	985730	1	163161 L
	[mm]		[pc.]	

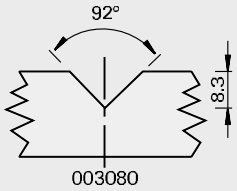
150515 / 151545

Profile Knives HW for ornamental groove cutterheads

Product

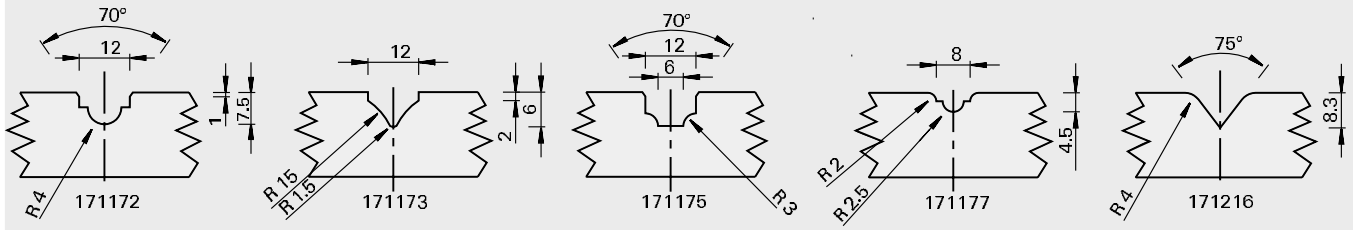


Drawing



LEUCO DUR

Tungsten Carbide [HW]



Machine / Application

- for use in ornamental groove cutterheads

Design

- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

- packing unit: 10 pieces

B	H	S	Ø d	Ident-No.
12	12	1.5	4,0	003080 L
12	12	1.5	4,0	171177 L
11	12	1.5	4,0	171175 L
11	12	1.5	4,0	171172 L
12	12	1.5	4,0	171216 L
11	12	1.5	4,0	171173 L
[mm]	[mm]	[mm]	[mm]	

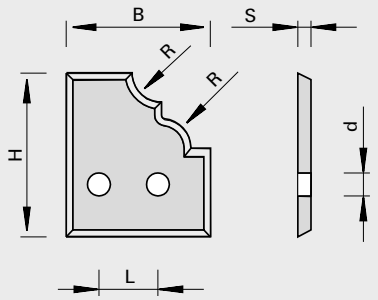
151547

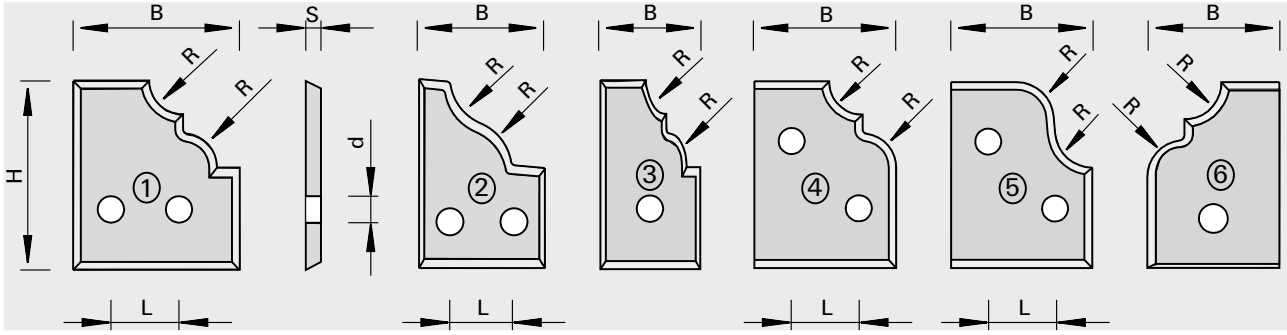
Profile Knives HW for stile-and-rail profile cutterheads and panel raising cutterheads

Product



Drawing





Tungsten Carbide [HW]

Machine / Application
- type 1, 2, 3 for use in stile-and-rail profile cutterheads
- type 4, 5, 6 for use in panel-raising cutterheads

Design
- cutting material: HW
- HL Solid 20 for hard and soft woods

Advantages

Notes

R	B	H	S	Ø d	L	Type	Ident-No.
4,5	19,3	24.5	2.0	3,5	11,2	1	165912 C
6,5	16,3	24.5	2.0	3,5	8,3	2	166127 C
7,0	13,3	24.5	2.0	3,5		3	167469 S
4,5	19	25	2.0	3,5	9,0	4	165930 C
5,0	19	25	2.0	3,5	9,0	5	165932 C
4,5	16	22.5	2.0	4,0		6	168883 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

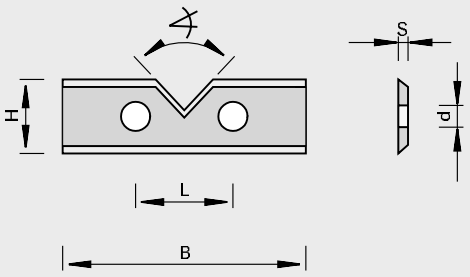
151547

Miter Glue Joint Profile Knives HW

Product



Drawing



Tungsten Carbide [HW]

Machine / Application
- for use in miter glue joint cutterheads

Design
- cutting material: HW
- HL Solid 20 for hard and soft woods

Advantages
- very accurate profiling for optimum glue joints

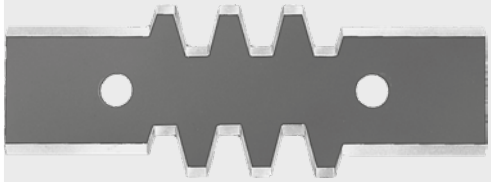
Notes
- packing unit: 10 pieces

Chamfer∢	B	H	S	Ø d	L	Ident-No.
86	39,5	12	1.5	4,0	26	165916 L
[°]	[mm]	[mm]	[mm]	[mm]	[mm]	

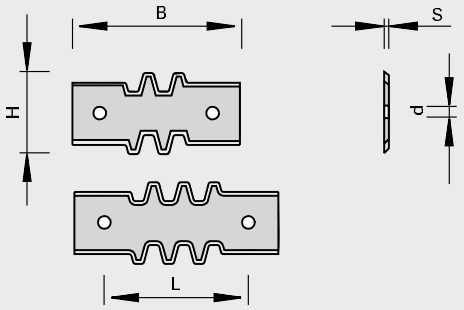
151555 / 151557

Glue Joint Profile Turnover Knives HW

Product



Drawing



Tungsten Carbide [HW]

Machine / Application
- for use in glue joint cutterheads

Design
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods
- HL Solid 20 for hard and soft woods

Advantages
- very accurate profiling for optimum glue joints

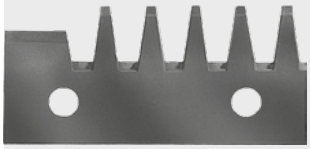
Notes
- packing unit: 10 pieces

B	H	S	Ø d	L	Ident-No.
50	21.6	2.0	4,0	26	165911 L
60	21.6	2.0	4,0	32	165909 S
50	23	2.0	4,0	26	180431 L
60	23	2.0	4,0	36	180432 L
[mm]	[mm]	[mm]	[mm]	[mm]	

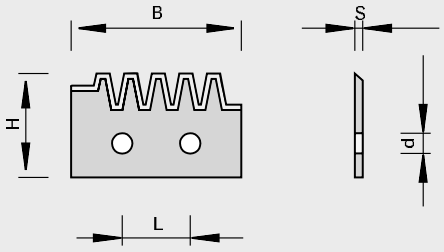
151597

Glue Joint Profile Turnover Knives HW Set

Product



Drawing



Tungsten Carbide [HW]

Machine / Application
- for use in adjustable glue joint cutterheads

Design
- cutting material: HW
- HL Solid 20 for hard and soft woods

Advantages
- very accurate profiling for optimum glue joints

Notes
- set consists of 4 pieces Ident-No. 167977, 4 pieces Ident-No. 167976

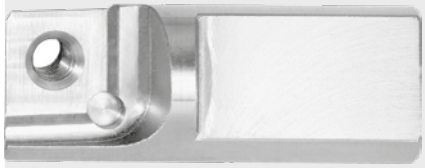
B	H	S	Ø d	L	Ident-No.
42	20	2.0	4,0	26	168240 C
[mm]	[mm]	[mm]	[mm]	[mm]	

Accessories	B	H	S	Class-No.	PU	Ident-No.
Glue Joint Profile Knives HW	43,5	20	2.0	151547	1	167976 C
Glue Joint Profile Knives HW	42	20	2.0	151547	1	167977 C
	[mm]	[mm]	[mm]		[pc.]	

132891

Turnover Knive Holders - Ledinek Rotoles

Product



Drawing

Tungsten Carbide [HW]

Machine / Application	Design	Advantages	Notes
l planing machines Ledinek Rotoles l for LEUCODUR turnover knives straight and with chamfer	l for mounting of LEUCODUR turnover knives 14 x 14 mm and 14.3 x 14.3 mm		

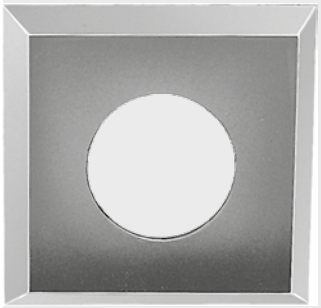
	Ident-No.
for thicknesser (TOK 14x14x2) top	182082 C
for service planing rotor (TOK 14x14x2) bottom	182083 C
for thicknesser segments (TOK 14,3x14,3x2,5) top	182084 C
for service planing rotor segments (TOK 14,3x14,3x2,5) bottom	182085 C

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x9 T20 D=Ø9,3	995125	10	827277 L
	[mm]		[pc.]	

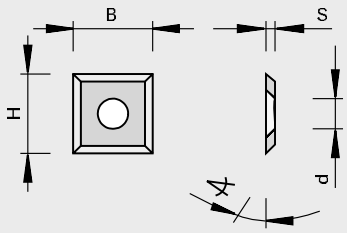
150517 / 150553 / 150555 / 150558

Profile Turnover Knives HW with 4 cutting edges - Ledinek Rotoles

Product



Drawing



Tungsten Carbide [HW]

Machine / Application	Design	Advantages	Notes
l planing machines Ledinek Rotoles l for use in turnover knife holders for plain milling	l cutting material: HW l HL Board 03 for wood-based panels and plastics l HL Board 05 for wood-based panels, plastics and hard woods l HL Solid 20 for wood-based panels, hard and soft woods l HL Solid 30 for hard and soft woods		l packing unit: 10 pieces

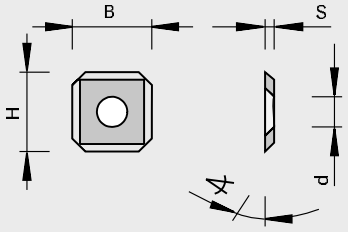
B	H	S	Ø d	Wedge◁	LEUCODUR	Ident-No.
14	14	2.0	6,3	60	HL Solid 30	003079 L
14	14	2.0	6,3	60	HL Board 05	180954 L
14	14	2.0	6,3	60	HL Board 03	180646 L
14,3	14.3	2.5	6,3	55	HL Solid 20	170248 L
[mm]	[mm]	[mm]	[mm]	[°]		

150557

Profile Turnover Knives HW with 4 cutting edges and chamfer - Ledinek Rotoles

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- planing machines Ledinek Rotoles
- for use in turnover knife holders for plain milling

Design

- cutting material: HW
- HL Solid 20 for wood-based panels, hard and soft woods

Advantages

Notes

- packing unit: 10 pieces

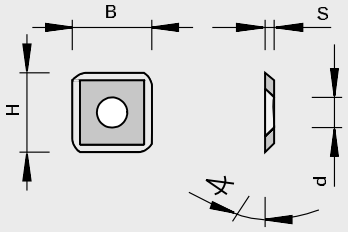
B	H	S	Ø d	Wedge◁	LEUCODUR	Ident-No. [L]	Ident-No. [R]
14	14	2.0	6,4	60	HL Solid 20	180933 L	180932 L
14,3	14.3	2.5	6,4	55	HL Solid 20	181144 C	181143 C
[mm]	[mm]	[mm]	[mm]	[°]			

150557

Profile Turnover Knives HW with 4 cutting edges and radius - Ledinek Rotoles

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- planing machines Ledinek Rotoles
- for use in turnover knife holders for plain milling

Design

- cutting material: HW
- HL Solid 20 for wood-based panels, hard and soft woods

Advantages

Notes

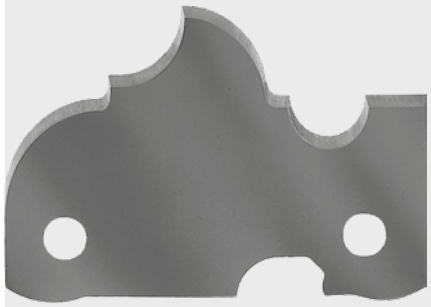
- packing unit: 10 pieces

B	H	S	Ø d	Wedge◁	LEUCODUR	Ident-No. [L]	Ident-No. [R]
14	14	2.0	6,4	60	HL Solid 20	182442 L	182441 L
14,3	14.3	2.5	6,4	55	HL Solid 20	182444 L	182443 L
[mm]	[mm]	[mm]	[mm]	[°]			

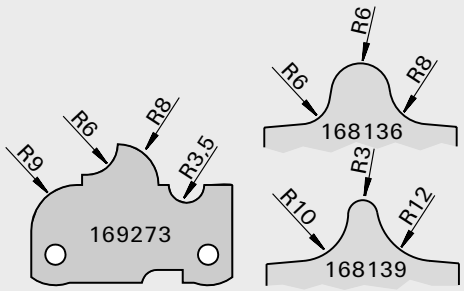
151526

SuperProfiler Knives HW “Multi-Profile”

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- table shapers
- for use in SuperProfiler cutterheads Ident-No. 167897 and 167894

Design

- cutting material: HW
- HL Board 06 for hard and soft woods

Advantages

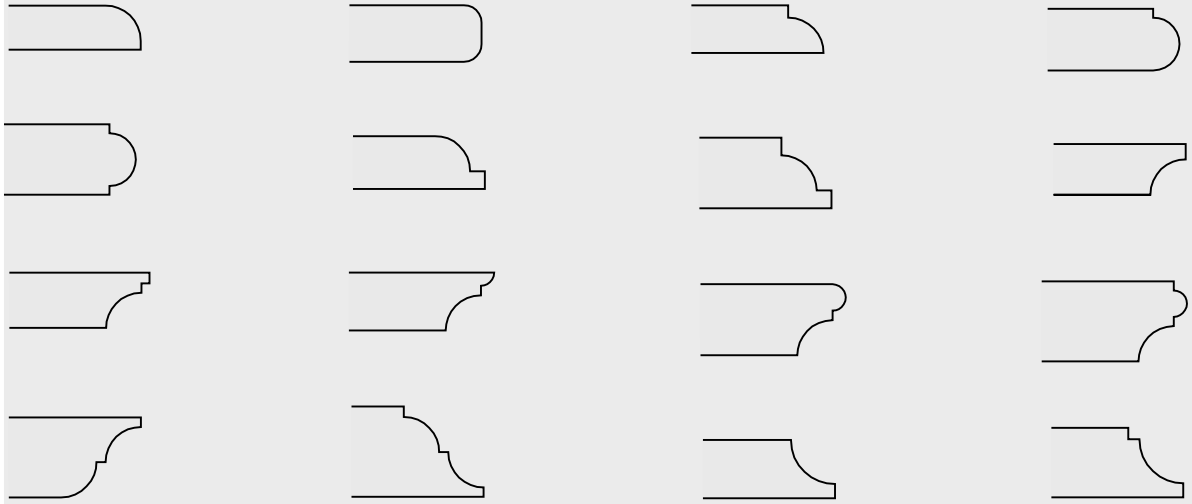
Notes

- for cutting of various profiles in one or more steps
- profile examples see Technical Appendix

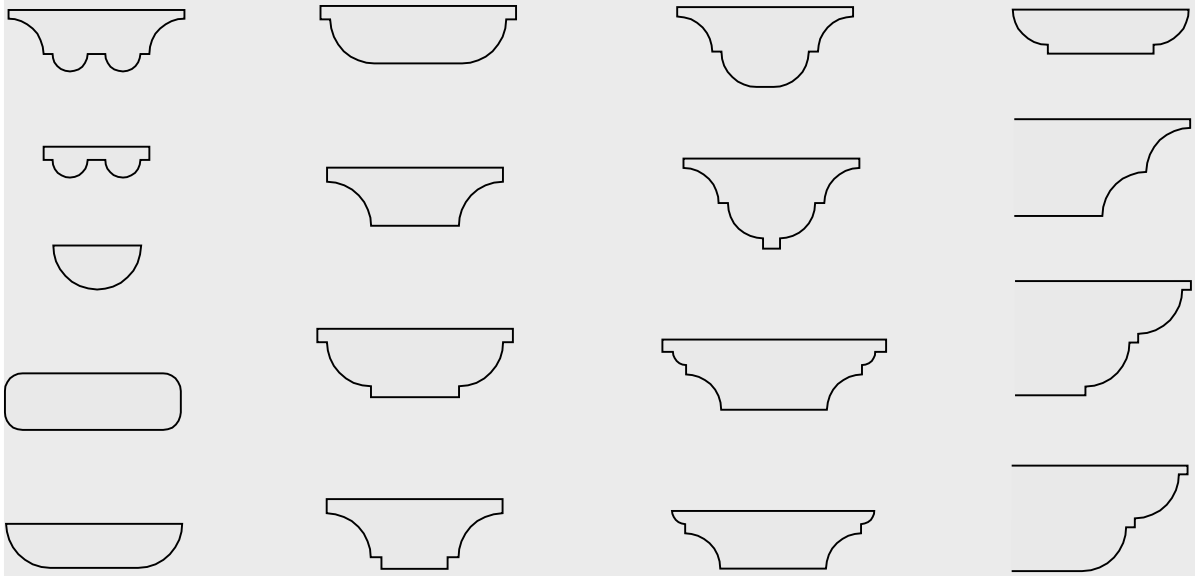
B	PU	Ident-No.
40	10	169273 S
39,5	10	168136 C
39,5	10	168139 C
[mm]	[pc.]	

SuperProfiler “Multi-Profile”

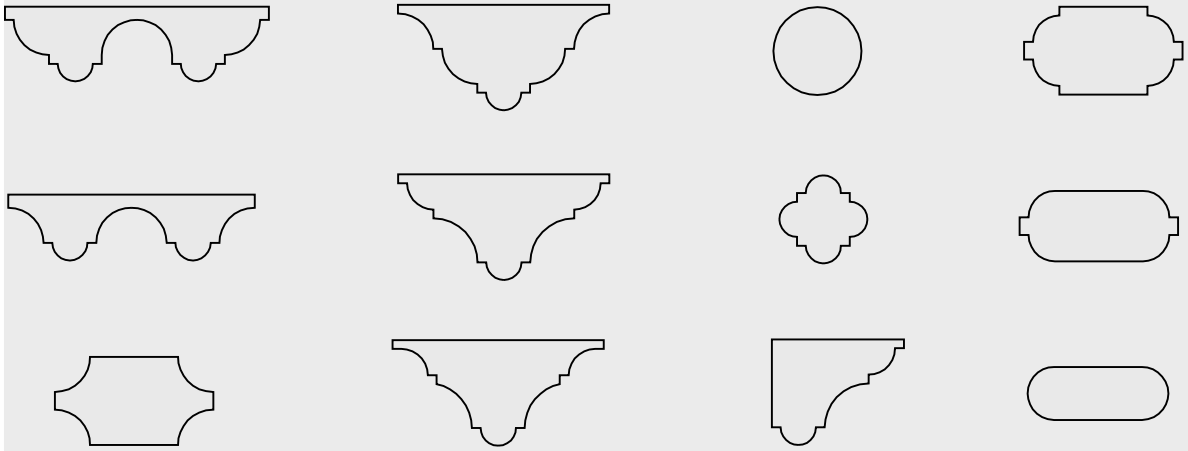
1 Operation



2 Operations



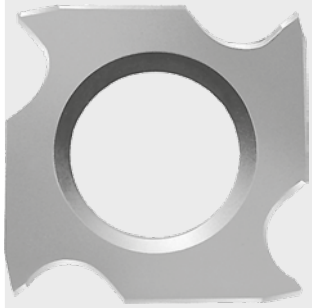
Several operations



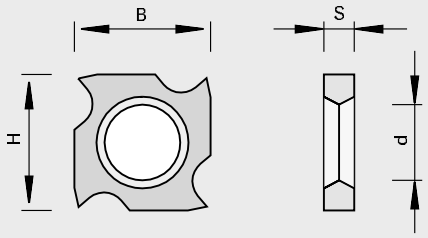
150508

Grooving Turnover Knives HW with 4 cutting edges - grooving cutterheads

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in grooving cutterheads

Design

- cutting material: HW
- HL Solid 30 for wood-based panels, hard and soft woods

Advantages

Notes

- Ident-No. 163699 for groove width 4 mm
- Ident-No. 165906 for groove width 5 mm
- Ident-No. 169250 for groove width > 7 mm
- packing unit: 10 pieces

B	H	S	Ø d	Ident-No.
18	18	1.95	10	163699 L
18	18	2.5	10	165906 L
18	18	3.7	10	169250 L
[mm]	[mm]	[mm]	[mm]	

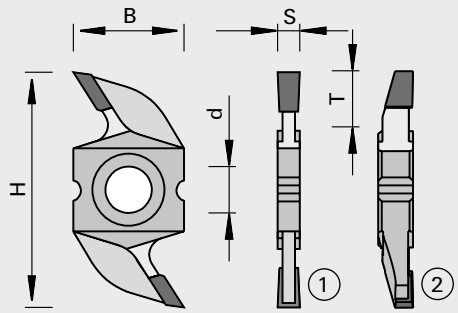
150508/150509

Grooving Turnover Knives HW with 2 cutting edges and positioning groove

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in cutterheads for grooving

Design

- bore countersunk 90 degrees
- cutting material: HW
- HL Solid 30 and HL Solid 40 for hard and soft woods

Advantages

- high accuracy thanks to radial positioning
- more simple handling

Notes

- spacer rings for the adjustment of the rounding knives see chapter replacement parts

B	H	S	Ø d	Tmax	LEUCODUR		PU	Ident-No.
13	36	3.5	7,4	10	HL Solid 30	no radial positioning	5	165968 C
16	34	3.2	6,7	8,0	HL Solid 30		5	183663 L
16	34	3.5	6,7	8,0	HL Solid 30		5	183664 C
16	34	4.0	6,7	8,0	HL Solid 30		5	183665 L
16	34	5.0	6,7	8,0	HL Solid 30		5	183666 L
[mm]	[mm]	[mm]	[mm]	[mm]			[pc.]	

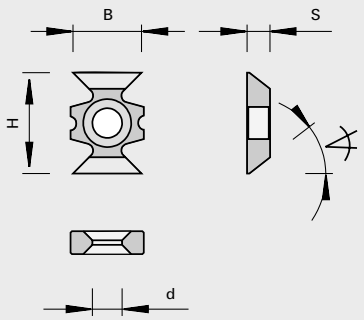
150577

Chamfering Turnover Knives HW with 4 cutting edges and positioning groove

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- for use in cutterheads for chamfering

Design

- cutting material: HW
- HL Solid 20 for wood-based panels, hard and soft woods

Advantages

- high accuracy thanks to radial positioning
- more simple handling

Notes

- for clockwise and counter-clockwise rotation
- spacer rings for the adjustment of the chamfer knives see chapter replacement parts
- packing unit: 10 pieces

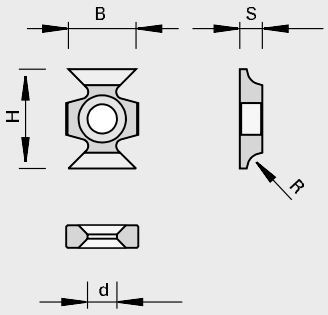
Chamfer	B	H	S	Ø d	Ident-No.
45 [°]	16 [mm]	22 [mm]	5.0 [mm]	6,5 [mm]	183668 L

150577

Rounding Turnover Knives HW with 4 cutting edges

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- for use in cutterheads for rounding

Design

- cutting material: HW
- HL Solid 20 for wood-based panels, hard and soft woods

Advantages

Notes

- for clockwise and counter-clockwise rotation
- spacer rings for the adjustment of the rounding knives see chapter replacement parts
- packing unit: 10 pieces

R	B	H	S	Ø d	Ident-No.
1,5	16	22	5.0	6,5	176417 C
2,0	16	22	5.0	6,5	176418 C
2,5	16	22	5.0	6,5	176419 C
3,0 [mm]	16 [mm]	22 [mm]	5.0 [mm]	6,5 [mm]	176420 C

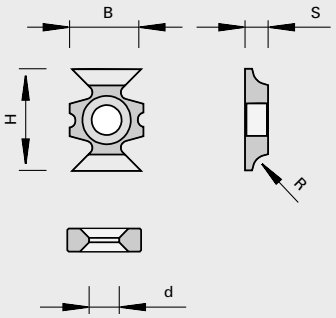
150577

Rounding Turnover Knives HW with 4 cutting edges and positioning groove

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in cutterheads for rounding

Design

- cutting material: HW
- HL Solid 20 for wood-based panels, hard and soft woods

Advantages

- high accuracy thanks to radial positioning
- radii are interchangeable
- more simple handling

Notes

- for clockwise and counter-clockwise rotation
- spacer rings for the adjustment of the rounding knives see chapter replacement parts
- packing unit: 10 pieces

R	B	H	S	Ø d	Ident-No.
1,5	16	22	5.0	6,5	183669 L
2,0	16	22	5.0	6,5	183670 L
2,5	16	22	5.0	6,5	183671 C
3,0	16	22	5.0	6,5	183672 L
[mm]	[mm]	[mm]	[mm]	[mm]	

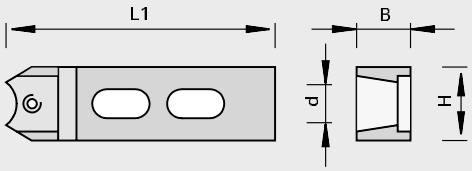
132891

Scraper Holders - Homag, Reich, IMA

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- edge banding machines Homag, Reich
- for installation of LEUCODUR radius-, chamfering- and scraper turnover knives

Design

Advantages

Notes

	B	H	Ø d	L1		Ident-No.
for R <= 5	22	14	6,5	118	Homag	179463 C
	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M4x5,9 T15	995195	10	167966 L
Screwdrivers	T15	985730	1	163161 L
Screwdrivers	T15x80	985730	1	171188 L
	[mm]		[pc.]	

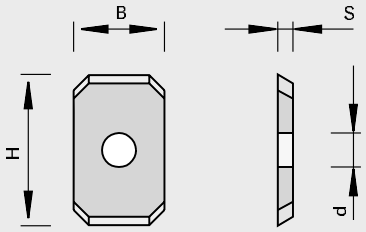
151555

Scraper Turnover Knives HW with 2 cutting edges and chamfer - Homag, IMA, Reich

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- edge banding machines Homag, IMA, Reich
- for use in scraper holders

Design

- chamfer angle 45 degrees
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

B	H	S	Ø d	PU	Ident-No.
12	20	2.0	4,0	2	171180 L
[mm]	[mm]	[mm]	[mm]	[pc.]	

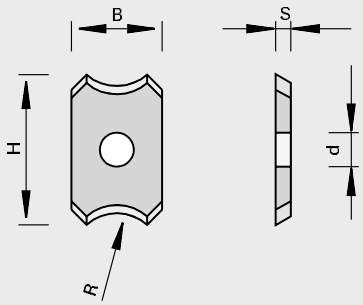
151555

Scraper Turnover Knives HW with 2 cutting edges and radius - Homag, HOLZ-HER, Brandt

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge banding machines Homag PN10, Homag PN20 (to 2015-12-31), HOLZ-HER 1927/1929, Brandt Ambition - 1110 F (KDF110) / 1120 FC (KDF120C)
- for use in scraper holders

Design

- 6 degree profile run-out
- cutting material: HW
- HL Board 05 for wood-based panels and plastics

Advantages

Notes

R	B	H	S	Ø d		PU	Ident-No.
0,8	12	20	2.0	4,0	Homag, HOLZ-HER	2	171401 L
1,0	12	20	2.0	4,0	Homag, HOLZ-HER	2	169253 L
1,3	12	20	2.0	4,0	Homag, HOLZ-HER	2	185454 L
1,5	12	20	2.0	4,0	Homag, HOLZ-HER	2	169254 L
2,0	12	20	2.0	4,0	Homag, HOLZ-HER	2	169255 L
2,5	12	20	2.0	4,0	Homag, HOLZ-HER	2	169256 L
3,0	12	20	2.0	4,0	Homag, HOLZ-HER	2	169257 L
4,0	12	20	2.0	4,0	Homag, HOLZ-HER	2	169259 C
5,0	12	20	2.0	4,0	Homag, HOLZ-HER	2	169261 C
1,2	12	20	2.0	4,0	Brandt	2	186102 C
2,0	12	20	2.0	4,0	Brandt	2	186103 C
3,0	12	20	2.0	4,0	Brandt	2	186104 C
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

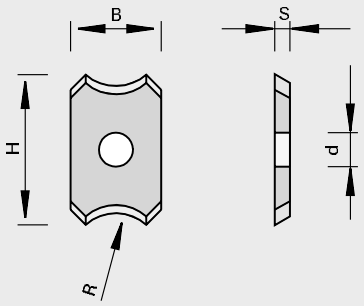
151755

Scraper Turnover Knives HW with 2 cutting edges and radius - Homag,HOLZ-HER, Reich for high gloss finish (on PE/PVC/ABS)

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge banding machines Homag PN10, Homag PN20 (to 2015-12-31), HOLZ-HER 1927/1929, Reich
- for use in scraper holders

Design

- 6 degree profile run-out
- special scraper which avoids material fracturing
- cutting material: HW
- HL Board 05 for wood-based panels and plastics

Advantages

- no material fracturing
- no additional work steps needed
- for high gloss finish

Notes

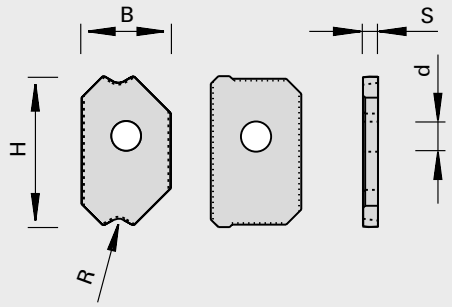
R	B	H	S	Ø d	PU	Ident-No.
1,0	12	20	2.0	4,0	2	186433 L
1,3	12	20	2.0	4,0	2	186434 L
1,5	12	20	2.0	4,0	2	181234 L
2,0	12	20	2.0	4,0	2	181235 L
3,0	12	20	2.0	4,0	2	181237 L
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

151545

Scraper Turnover Knives HW with 2 cutting edges - Homag (non-symmetrical location of positioning hole)

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge banding machines Homag Flexblade PN21

Design

- non-symmetrical profile and location of positioning hole
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

R	B	H	S	Ø d	PU	Ident-No.
1,0	12	20	2.0	4,0	2	185378 L
1,5	12	20	2.0	4,0	2	185379 L
2,0	12	20	2.0	4,0	2	185380 L
2,5	12	20	2.0	4,0	2	185850 C
3,0	12	20	2.0	4,0	2	185851 C
4,0	12	20	2.0	4,0	2	185852 S
5,0	12	20	2.0	4,0	2	185853 S
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

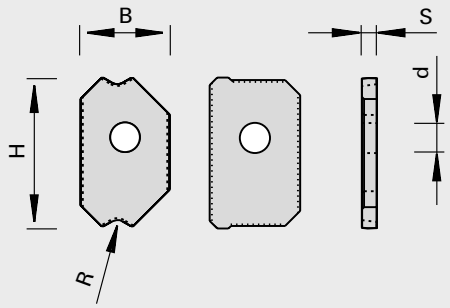
Chamfer◁	B	H	S	Ø d	PU	Ident-No.
45	12	20	2.0	4,0	2	187127 L
[°]	[mm]	[mm]	[mm]	[mm]	[pc.]	

151545

Scraper Turnover Knives HW with 2 cutting edges - Homag (non-symmetrical location of positioning hole, chamfer to prevent material fracturing)

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge banding machines Homag Flexblade PN21

Design

- non-symmetrical profile and location of positioning hole
- special scraper which avoids material fracturing
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

- no material fracturing also in the case of PP-edges
- no additional work steps needed

Notes

R	B	H	S	Ø d	PU	Ident-No.
1,0	12	20	2.0	4,0	2	185854 C
1,5	12	20	2.0	4,0	2	185855 C
2,0	12	20	2.0	4,0	2	185856 C
2,5	12	20	2.0	4,0	2	185857 C
3,0	12	20	2.0	4,0	2	185858 C
4,0	12	20	2.0	4,0	2	185859 C
5,0	12	20	2.0	4,0	2	185860 C
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

Chamfer◁	B	H	S	Ø d	PU	Ident-No.
45	12	20	2.0	4,0	2	187128 L
[°]	[mm]	[mm]	[mm]	[mm]	[pc.]	

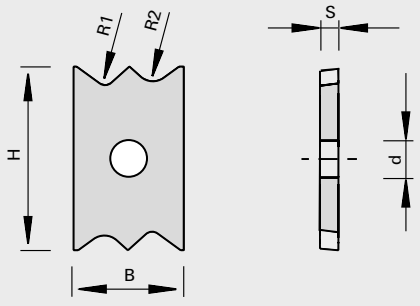
151586

Multi Scraper Knives HW - EBM

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- EBM edge banding machine with dual-profile technology
- for use in scraper holders
- for scraping of standard edge bandings such as PP / PVC / ABS

Design

- 2 different radius combinations in one scraper
- Cutting material: HW
- HL Board 06 for wood-based materials, plastic and hard wood

Advantages

- Combination of up to 2 different profiles in one tool

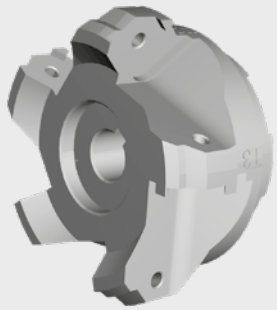
Notes

R1	R2	B	H	S	Ø d	PU	Ident-No.
1.0	2.0	12	20	2.0	4,0	2	187133 L
3.0	2.0	12	20	2.0	4,0	2	187134 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

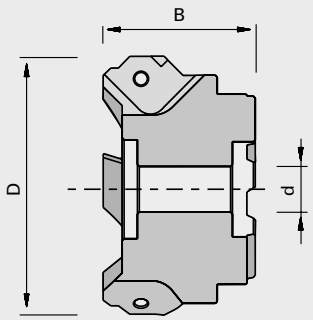
132891

Scraper-holder, 5 times - HOLZ-HER, aggregate ZK701

Product



Drawing



Alloyed Steel

Machine / Application
- edge banding machines HOLZ-HER aggregate ZK701
- for mounting of up to 5 radius or chamfering scraper turnover knives

Design
- Scraper holder (turret) 5-times, without scraper knives
- burnished

Advantages
- individual mounting of up to 5 different scraper knives
- very suitable for batch size 1, as no expenditure of time for setup
- increase of productivity

Notes
- rotating direction left can be used on bottom side, rotating direction right on top side

Ø D	B	Ø d	Z	Ident-No. bottom	Ident-No. top
70	40	12	5	185716 L	185717 L
[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M4x10,5 T15	995195	10	179475 L
Toothed ring	Ø50x9xØ20	997300	1	185719 L
	[mm]		[pc.]	

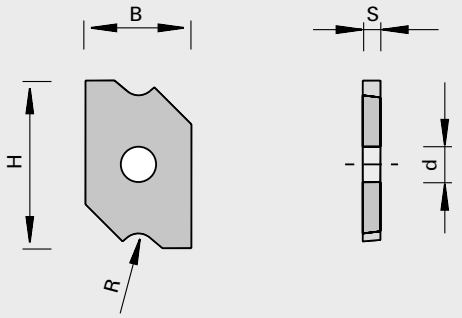
151586

Scraper Turnover Knives HW - HOLZ-HER, aggregate ZK501 / ZK701 (chamfer to prevent material fracturing)

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application
- edge banding machines HOLZ-HER aggregate ZK501 / ZK701
- for use in scraper-holders (turret)

Design
- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods

Advantages

Notes
- rotating direction left can be used on bottom side, rotating direction right on top side

R	B	H	S	PU	Ident-No. [L]	Ident-No. [R]
1,0	12	19	2.0	2	185720 C	185721 C
1,3	12	19	2.0	2	185722 C	185723 C
2,0	12	19	2.0	2	185724 L	185725 L
3,0	12	19	2.0	2	185726 C	185727 C
[mm]	[mm]	[mm]	[mm]	[pc.]		

Chamfer◁	B	H	S	PU	Ident-No. [L]	Ident-No. [R]
10	12	19	2.0	2	185728 C	185729 C
45	12	19	2.0	2	185730 C	185731 C
[°]	[mm]	[mm]	[mm]	[pc.]		

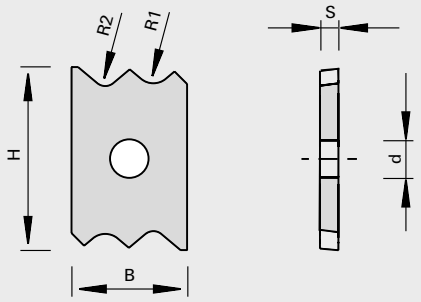
151555

Multi Scraper Knives HW - HOLZ-HER, aggregate ZK502

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge banding machines HOLZ-HER aggregate ZK502
- for use in scraper holders
- for scraping of standard edge bandings such as PP / PVC / ABS

Design

- 2 different radius combinations in one scraper
- Cutting material: HW
- HL Board 05 for wood-based materials, plastic and hard wood

Advantages

Notes

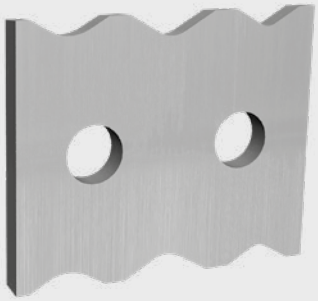
- Sense of rotation right is mounted at the top
- Sense of rotation left is mounted at the bottom

R1	R2	Chamfer◁	B	H	S	Ø d	PU	Ident-No. [L]	Ident-No. [R]
2.0	1.3		12	19	2.0	4,0	2	186887 L	186788 L
2.0		45	12	19	2.0	4,0	2	186919 L	186918 L
[mm]	[mm]	[°]	[mm]	[mm]	[mm]	[mm]	[pc.]		

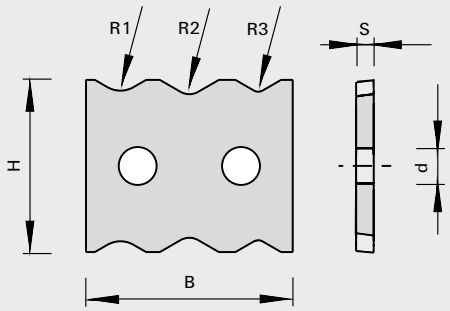
151586

Multi Scraper Knives HW - IMA

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge banding machines IMA - Aggregate 08.516
- for use in scraper holders
- for scraping of standard edge bandings such as PP / PVC / ABS

Design

- up to 4 different profile combinations in one scraper
- cutting material: HW
- HL Board 06 for wood-based materials, plastics and hard woods

Advantages

- up to 4 profiles without tool change

Notes

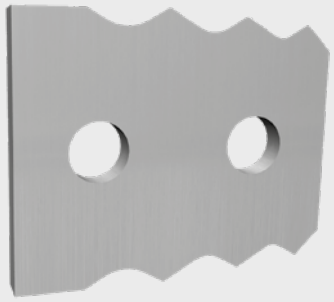
- other special profile combinations are available!

R1	R2	R3	Chamfer◁	B	H	S	Ø d	PU	Ident-No.
3.0	2.0	1.0		24	20	2.0	4,4	2	187339 L
2.0	1.5	1.0	45	24	20	2.0	4,4	2	187340 C
[mm]	[mm]	[mm]	[°]	[mm]	[mm]	[mm]	[mm]	[pc.]	

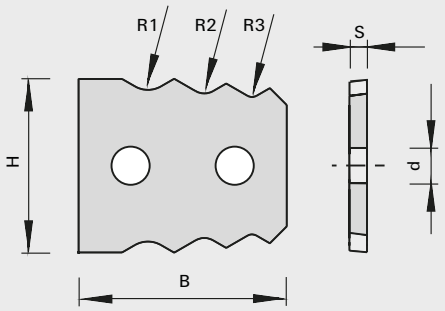
151586

Multi Scraper Knives HW - IMA (chamfer to prevent material fracturing)

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge banding machines IMA - Aggregate 08.516
- for use in scraper holders
- for scraping of standard edge bandings such as PP / PVC / ABS

Design

- up to 4 different profile combinations in one scraper
- cutting edge with chamfer to prevent material fracturing
- cutting material: HW
- HL Board 06 for wood-based materials, plastics and hard woods

Advantages

- up to 4 profiles without tool change
- no material fracturing
- avoids rework

Notes

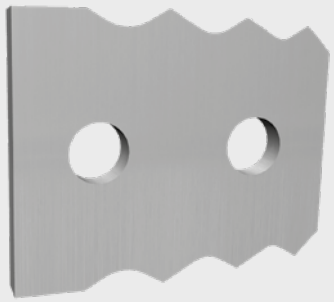
- other special profile combinations are available!

R1	R2	R3	Chamfer	B	H	S	Ø d	PU	Ident-No.
3.0	2.0	1.0		24	20	2.0	4,4	2	187341 L
2.0	1.5	1.5	45	24	20	2.0	4,4	2	187342 C
[mm]	[mm]	[mm]	[°]	[mm]	[mm]	[mm]	[mm]	[pc.]	

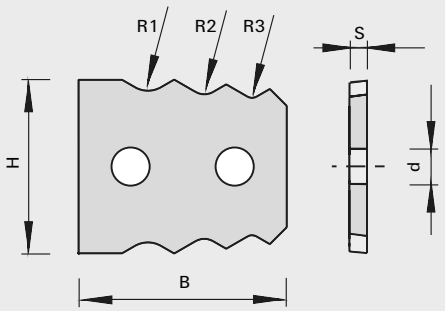
151786

Multi Scraper Turnover Knives HW - for high gloss finish on PE/PVC/ABS - IMA

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge banding machines IMA - Aggregate 08.516
- for use in scraper holders
- for scraping of standard edge bandings such as PP / PVC / ABS

Design

- up to 4 different profile combinations in one topline scraper (polished face and micro-cut clearance face)
- cutting edge with chamfer to prevent material fracturing
- cutting material: HW
- HL Board 06 for wood-based materials, plastics and hard woods

Advantages

- up to 4 profiles without tool change
- no material fracturing
- avoids rework
- for high gloss finish

Notes

- other special profile combinations are available!

R1	R2	R3	Chamfer	B	H	S	Ø d	PU	Ident-No.
3.0	2.0	1.0		24	20	2.0	4,4	2	187344 C
2.0	1.5	1.0	45	24	20	2.0	4,4	2	187346 C
[mm]	[mm]	[mm]	[°]	[mm]	[mm]	[mm]	[mm]	[pc.]	

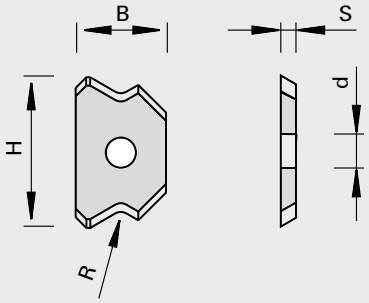
151555

Scraper Turnover Knives HW with 2 cutting edges and radius or chamfer - IMA (asymmetrical)

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge banding machines IMA - Aggregate 08.516 and 08.519
- for use in scraper holders
- or scraping of standard edge bandings such as PP / PVC / ABS

Design

- non-symmetrical profile
- 15 degree profile run-out
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

R	B	H	S	Ø d	PU	Ident-No.
0,8	12	20	2.0	4,0	2	184796 C
1,0	12	20	2.0	4,0	2	184798 L
1,3	12	20	2.0	4,0	2	184800 C
1,5	12	20	2.0	4,0	2	184802 L
2,0	12	20	2.0	4,0	2	184804 L
2,5	12	20	2.0	4,0	2	184807 C
3,0	12	20	2.0	4,0	2	184809 L
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

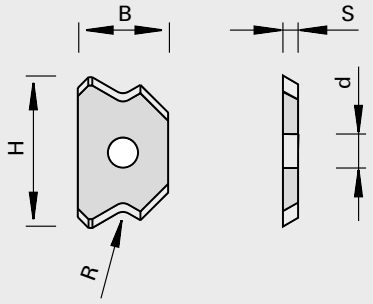
Chamfer◁	B	H	S	Ø d	PU	Ident-No.
20	12	20	2.0	4,0	2	187349 C
45	12	20	2.0	4,0	2	187347 C
[°]	[mm]	[mm]	[mm]	[mm]	[pc.]	

Scraper Turnover Knives HW with 2 cutting edges and radius or chamfer - IMA (asymmetrical) chamfer to prevent material fracturing

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge banding machines IMA - Aggregate 08.516 and 08.519
- for use in scraper holders
- For scraping of standard edge bandings such as PP / PVC / ABS
- no material fracturing

Design

- non-symmetrical profile
- 15 degree profile run-out
- cutting edge with chamfer to prevent material fracturing
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

- no material fracturing also in the case of PP-edges
- no additional work steps needed

Notes

R	B	H	S	Ø d	PU	Ident-No.
0,8	12	20	2.0	4,0	2	187350 C
1,0	12	20	2.0	4,0	2	187351 C
1,3	12	20	2.0	4,0	2	187352 C
1,5	12	20	2.0	4,0	2	187353 L
2,0	12	20	2.0	4,0	2	187354 L
2,5	12	20	2.0	4,0	2	187355 C
3,0	12	20	2.0	4,0	2	187356 C
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

Chamfer◁	B	H	S	Ø d	PU	Ident-No.
20	12	20	2.0	4,0	2	187358 C
45	12	20	2.0	4,0	2	187357 C
[°]	[mm]	[mm]	[mm]	[mm]	[pc.]	

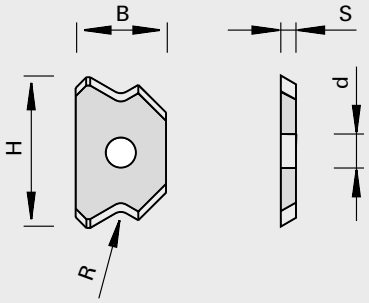
151755

Scraper Turnover Knives HW with 2 cutting edges and radius - IMA (asymmetrical, chamfer to prevent material fracturing for high gloss finish on PE/PVC/ABS)

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge banding machines IMA - Aggregate 08.516 and 08.519
- for use in scraper holders
- for scraping of standard edge bandings such as PP / PVC / ABS
- no material fracturing

Design

- non-symmetrical profile
- 15 degree profile run-out
- cutting edge with chamfer to prevent material fracturing
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

- no material fracturing
- no additional work steps needed
- for high gloss finish

Notes

R	B	H	S	Ø d	PU	Ident-No.
0,8	12	20	2.0	4,0	2	184797 C
1,0	12	20	2.0	4,0	2	184799 C
1,3	12	20	2.0	4,0	2	184801 C
1,5	12	20	2.0	4,0	2	184803 C
2,0	12	20	2.0	4,0	2	184806 C
2,5	12	20	2.0	4,0	2	184808 C
3,0	12	20	2.0	4,0	2	184810 C
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

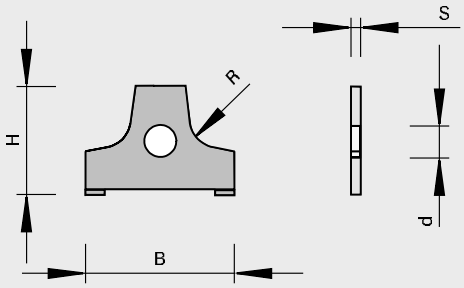
151586 / 151786

Scraper Knives HW with 2 cutting edges and radius - working centers (topcoat, avoids material fracturing)

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- machines Homag combined with flush-cutting unit No. 1-056-11-0621

Design

- 6 degree profile run-out
- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods
- topcoat coating
- cutting edge with chamfer to prevent material fracturing

Advantages

- no material fracturing also in the case of PP-edges
- no additional work steps needed

Notes

R	B	H	S	Ø d		PU	Ident-No.
1,0	20	11.5	2.0	5,0		2	185667 C
1,5	20	11.5	2.0	5,0		2	180025 L
2,0	20	11.5	2.0	5,0		2	180020 L
2,5	20	11.5	2.0	5,0		2	180021 C
3,0	20	11.5	2.0	5,0		2	180022 L
4,0	20	11.5	2.0	5,0		2	185295 S
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

R	B	H	S	Ø d		PU	Ident-No.
2,0	20	11.5	2.0	5,0	topcoat	2	185387 L
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

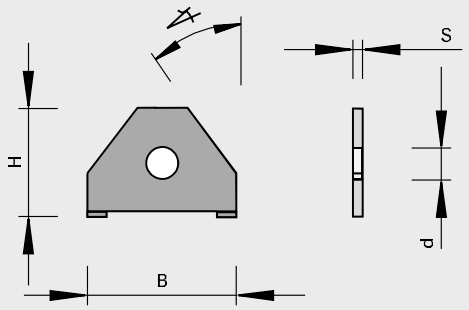
R	B	H	S	Ø d		PU	Ident-No.
1,0	20	11.5	2.0	5,0	topcoat + chamfer to prevent material fracturing	2	185159 C
1,5	20	11.5	2.0	5,0	topcoat + chamfer to prevent material fracturing	2	185160 C
2,0	20	11.5	2.0	5,0	topcoat + chamfer to prevent material fracturing	2	185161 C
2,5	20	11.5	2.0	5,0	topcoat + chamfer to prevent material fracturing	2	185162 S
3,0	20	11.5	2.0	5,0	topcoat + chamfer to prevent material fracturing	2	185163 C
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

151586

Scraper Knives HW with 2 cutting edges and chamfer (glue joint) - working centers

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- machines Homag combined with flush-cutting unit No. 1-056-11-0621

Design

- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods

Advantages

Notes

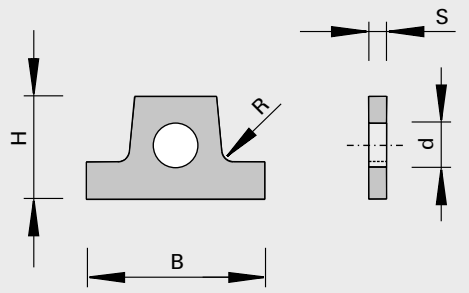
Chamfer	B	H	S	Ø d	PU	Ident-No.
3	20	11.5	2.0	5,0	2	180023 C
15	20	11.5	2.0	5,0	2	180210 C
30	20	11.5	2.0	5,0	2	180211 C
45	20	11.5	2.0	5,0	2	185296 C
[°]	[mm]	[mm]	[mm]	[mm]	[pc.]	

151586

Chip Breakers HW for Scraper Knives

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- machines Homag combined with flush-cutting unit No. 1-056-11-0621

Design

- 6 degree profile run-out
- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods

Advantages

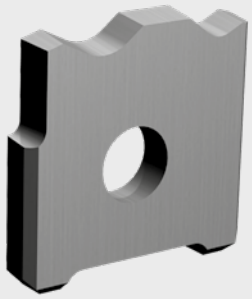
Notes

R	B	H	S	Ø d	PU	Ident-No.
1,3	20	11.5	2.0	5,0	2	180024 S
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

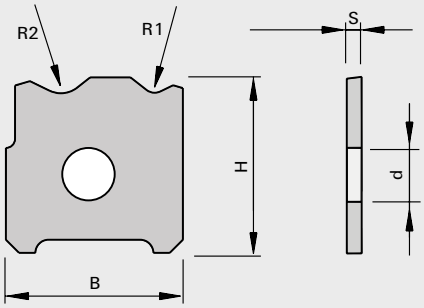
151586

Multi Scraper Knives HW - Homag (Brandt)

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge banding machines Homag (Brandt)
- for use in scraper holders
- for scraping of standard edge bandings such as PP / PVC / ABS

Design

- 2 different radius combinations in one scraper
- Cutting material: HW
- HL Board 06 for wood-based materials, plastic and hard wood

Notes

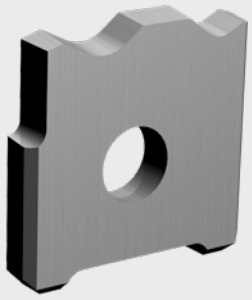
- Sense of rotation right is mounted at the top
- Sense of rotation left is mounted at the bottom

R1	R2	B	H	S	Ø d	PU	Ident-No. [L]	Ident-No. [R]
1.0	2.0	13,5	13.38	2.0	4,0	2	186451 L	186450 L
1.3	2.0	13,5	13.38	2.0	4,0	2	186457 C	186456 C
1.3	3.0	13,5	13.38	2.0	4,0	2	186453 C	186452 C
1.5	2.0	13,5	13.38	2.0	4,0	2	186455 C	186454 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]		

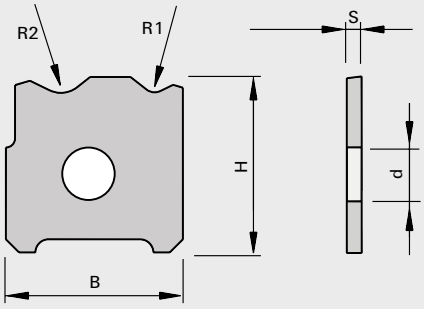
151846

Multi Scraper Knives HW - to prevent material fracturing for high gloss finish on PE/PVC/ABS - Homag (Brandt)

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge banding machines Homag (Brandt)
- for use in scraper holders
- for scraping of standard edge bandings such as PP / PVC / ABS

Design

- 2 different radius combinations in one scraper
- Cutting edge with chamfer to prevent material fracturing
- Cutting material: HW
- HL Board 06 for wood-based materials, plastic and hard wood

Advantages

- no material fracturing
- avoids rework
- for high gloss finish

Notes

- Sense of rotation right is mounted at the top
- Sense of rotation left is mounted at the bottom

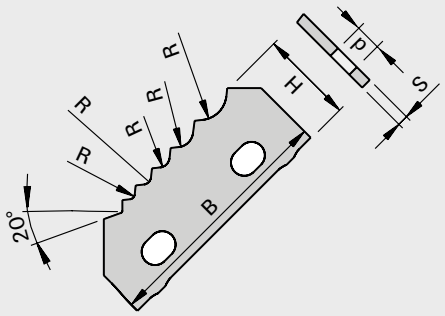
R1	R2	B	H	S	Ø d	PU	Ident-No. [L]	Ident-No. [R]
1.0	2.0	13,5	13.38	2.0	4,0	2	186459 C	186458 C
1.3	2.0	13,5	13.38	2.0	4,0	2	186465 C	186464 C
1.3	3.0	13,5	13.38	2.0	4,0	2	186461 S	186460 S
1.5	2.0	13,5	13.38	2.0	4,0	2	186463 S	186462 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]		

151586

Multi Scraper Knives HW

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- machines Homag with scraping unit Type MN 20 / MN 21

Design

- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods

Advantages

Notes

- Ident-No. [L] can be applied on the left lower or the right upper side
- Ident-No. [R] can be applied on the left upper or the right lower side

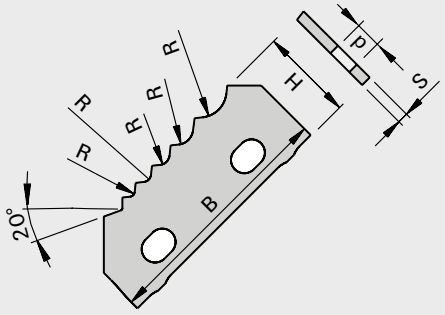
R	B	H	S	Ø d		PU	Ident-No. [L]	Ident-No. [R]
20°; 1; 1,5; 2; 3; 5	45,8	17.98	2.0	5,0	Profile: 6-fold	1	180755 L	180754 L
45°; 20°; 1; 1,3; 1,5; 2; 3	45,8	17.23	2.0	5,0	Profile: 7-fold	1	186681 L	186680 L
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]		

151786

Multi Scraper Turnover Knives HW - to prevent material fracturing for high gloss finish on PP/PVC/ABS

Product

Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- machines Homag with scraping unit Type MN 20 / MN 21

Design

- cutting edge with chamfer to prevent material fracturing
- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods

Advantages

- no material fracturing also in the case of PP-edges
- no additional work steps needed
- for high gloss finish

Notes

- Ident-No. [L] can be applied on the left lower or the right upper side
- Ident-No. [R] can be applied on the left upper or the right lower side

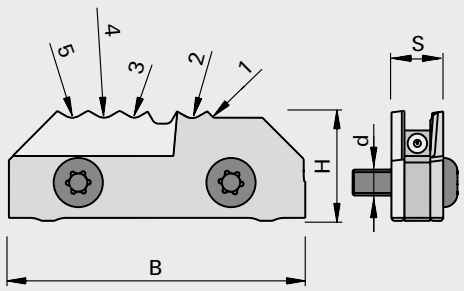
R	B	H	S	Ø d		PU	Ident-No. [L]	Ident-No. [R]
1; 1,5; 2; 3; 5	45,8	17.98	2.0	5,0	Profile: 6-fold	1	181239 L	181240 L
1; 1,5; 2; 2,5; 3	45,8	17.02	2.0	5,0	Profile: 6-fold	1	184670 L	184669 L
45°; 20°; 1; 1,3; 1,5; 2; 3	45,8	17.23	2.0	5,0	Profile: 7-fold	1	186683 L	186682 L
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]		

151786

TwinBlade Scraper Turnover Knives HW - to prevent material fracturing - Homag

Product

Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- machines Homag with scraping unit Type PN 21

Design

- cutting edge with chamfer to prevent material fracturing
- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods
- topline (polished face and micro-ground clearance angle)

Advantages

- no material fracturing
- no additional work steps needed
- high-gloss edges in acrylic are possible

Notes

- Position 1 + 2 TwinBlade
- Position 3 - 5 high gloss

R	B	H	S	Ø d		Ident-No. [L]	Ident-No. [R]
1; 2; 1; 1,5; 2	45,8	17	8.0	5,0	topline	185322 C	185323 C
45°; 1,6; 1; 1,6; 2	45,8	17	8.0	5,0	topline	185324 S	185325 S
1; 2; 1; 2; 3	45,8	17	8.0	5,0	topline	185326 C	185327 C
1,5; 2; 45°; 1,5; 2	45,8	17	8.0	5,0	topline	185328 C	185329 C
1,5; 2; 1; 1,5; 2	45,8	17	8.0	5,0	topline	185331 C	185330 C
1; 1,5; 1; 1,5; 2	45,8	17	8.0	5,0	topline	185332 C	185333 C
45°; 2; 1,5; 2; 2	45,8	17	8.0	5,0	topline	185334 C	185335 C
1; 2; 20°; 2; 2,5	45,8	17	8.0	5,0	topline	185336 C	185337 C
1,3; 2; 1; 1,3; 2	45,8	17	8.0	5,0	topline	185338 C	185339 C
1; 2; 20°; 1; 2	45,8	17	8.0	5,0	topline	185340 C	185341 C
2; 2; 45°; 20°; 2	45,8	17	8.0	5,0	topline	185342 S	185343 S
1,3; 2; 20°; 2; 3	45,8	17	8.0	5,0	topline	185344 C	185345 C
1,3; 3; 1,3; 2; 3	45,8	17	8.0	5,0	topline	185346 C	185347 C
1; 1,5; 1; 1,2; 2	45,8	17	8.0	5,0	topline	185348 S	185349 S
1,5; 2,2; 1,5; 2; 3	45,8	17	8.0	5,0	topline	185350 C	185351 C
1; 1,5; 20°; 1,2; 2	45,8	17	8.0	5,0	topline	185352 S	185353 S
45°; 1,6; 2; 1,6; 2	45,8	17	8.0	5,0	topline	185354 S	185779 S
[mm]	[mm]	[mm]	[mm]	[mm]			

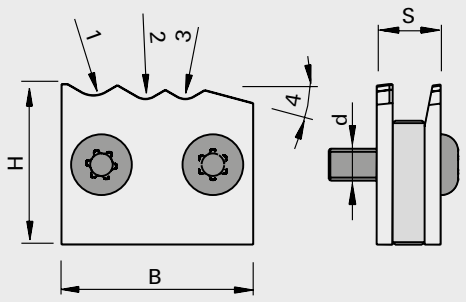
Spare parts	Dimension	Class-No.	PU	Ident-No.
Sealing Rings	1,78x1,02 NBR872	955510	1	185004 L
Panhead Screws	M4x14 T15	995195	1	185005 L
	[mm]		[pc.]	

151786

TwinBlade Scraper Turnover Knives HW - to prevent material fracturing - IMA

Product

Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- machines IMA

Design

- cutting edge with chamfer to prevent material fracturing
- cutting material: HW
- HL Board 06 for plastics
- topline (polished face and micro-ground clearance angle)

Advantages

- no material fracturing
- no additional work steps needed
- high-gloss edges in acrylic are possible

Notes

R	B	H	S	Ø d			Ident-No.
3; 2; 2; 30°	24	20.1	8.0	5,0	topline	R	80327522 C
3; 2; 2; 30°	24	20.1	8.0	5,0	topline	L	80327255 C
2; 1,5; 1; 45°	24	20.1	8.0	5,0	topline	R	80327183 C
2; 1,5; 1; 45°	24	20.1	8.0	5,0	topline	L	80327184 C
2; 1,2; 1; 45°	24	20.1	8.0	5,0	topline	R	80328447 C
2; 1,2; 1; 45°	24	20.1	8.0	5,0	topline	L	80328448 C
2; 1; 1; 45°	24	20.1	8.0	5,0	topline	R	80337118 C
2; 1; 1; 45°	24	20.1	8.0	5,0	topline	L	80337119 C
1,3; 1; 1; 15°	24	20.1	8.0	5,0	topline	R	80342343 S
1,3; 1; 1; 15°	24	20.1	8.0	5,0	topline	L	80342344 S
3; 1,5; 1,5; 45°	24	20.1	8.0	5,0	topline	L	80343463 S
3; 2,5; 1,5; 45°	24	20.1	8.0	5,0	topline	R	80350594 S
3; 2,5; 1,5; 45°	24	20.1	8.0	5,0	topline	L	80350593 S
2,5; 1,5; 30°	24	20.1	8.0	5,0	topline	R	80355718 S
2,5; 1,5; 30°	24	20.1	8.0	5,0	topline	L	80355719 S
2; 1,5; 1	24	20.1	8.0	5,0	topline	R	80357038 C
2; 1,5; 1	24	20.1	8.0	5,0	topline	L	80357039 C
2; 2; 1; 1	24	20.1	8.0	5,0	topline	R	80356483 S
2; 2; 1; 1	24	20.1	8.0	5,0	topline	L	80357389 S
3; 2; 1; 15°	24	20.1	8.0	5,0	topline	R	80357926 C
3; 2; 1; 15°	24	20.1	8.0	5,0	topline	L	80357927 C
3; 2; 1	24	20.1	8.0	5,0	topline	R	80360627 C
3; 2; 1	24	20.1	8.0	5,0	topline	L	80360628 C
3; 2; 1,5	24	20.1	8.0	5,0	topline	R	80361148 C
3; 2; 1,5	24	20.1	8.0	5,0	topline	L	80361149 C
0,8; 1,5; 1,2; 1,2	24	20.1	8.0	5,0	topline	R	80365346 S
2,5; 1,5; 1,2; 1,2	24	20.1	8.0	5,0	topline	L	80365348 S
2; 2; 1	24	20.1	8.0	5,0	topline	R	80370785 C
2; 2; 1	24	20.1	8.0	5,0	topline	L	80370786 C
[mm]	[mm]	[mm]	[mm]	[mm]			

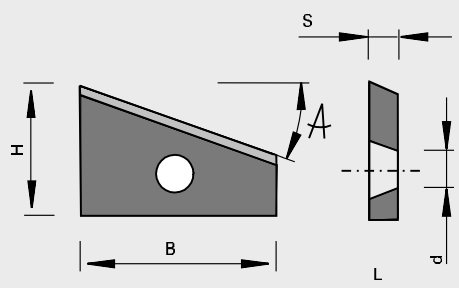
Spare parts	Dimension	Class-No.	PU	Ident-No.
Panhead Screws	M4x14 T15	995195	1	185005 L
	[mm]		[pc.]	

151547

Scraper Knives HW with 1 cutting edge and chamfer

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- machines IMA units 181.91 and 0.6126 (BAZ) with 30 mm width, unit 08.50 with 55 mm width

Design

- cutting material: HW
- HL Solid 20 for wood-based panels, hard and soft woods

Advantages

Notes

Chamfer	B	H	S	Ø d	PU	Ident-No. [L]	Ident-No. [R]
15	30	22.5	3.0	5,8	2	178859 L	178858 L
15	55	25	3.0	5,8	2	178861 L	178860 L
[°]	[mm]	[mm]	[mm]	[mm]	[pc.]		

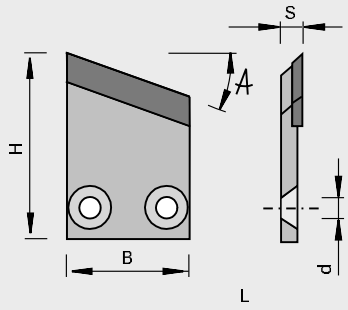
Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws - with Torx	M5x10 T20 D=Ø10	995125	10	171236 L
	[mm]		[pc.]	

151548

Glue Joint Scraper Turnover Knives (flat scraper) HW - Homag aggregate FA10, FA11, FA12

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- machines Homag aggregate FA10, FA11, FA12

Design

- HW-tipped
- cutting material: HW
- HL Solid 20 for wood-based panels, hard and soft woods

Advantages

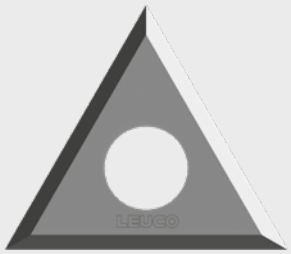
Notes

Chamfer	B	H	S	Ø d	PU	Ident-No. [L]	Ident-No. [R]
15	32	55	4.5	5,8	1	178223 L	178224 L
[°]	[mm]	[mm]	[mm]	[mm]	[pc.]		

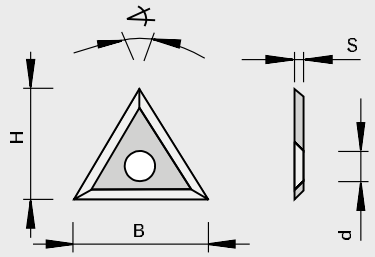
150558

Scraper Turnover Knives HW with 3 cutting edges - Biesse

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- machines Biesse-Polymac

Design

- cutting material: HW
- HL Solid 30 for wood-based panels, hard and soft woods

Advantages

Notes

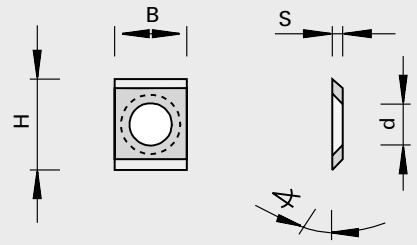
B	H	S	Ø d	Corner◁	LEUCODUR	PU	Ident-No.
22,9	19.8	2.5	6,4	60	HL Solid 30	10	183685 C
[mm]	[mm]	[mm]	[mm]	[°]		[pc.]	

150517

Scraper Turnover Knives HW with 2 cutting edges - IMA

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- machining centers IMA

Design

- cutting material: HW
- HL Solid 20 for hard and soft woods

Advantages

Notes

B	H	S	Ø d	PU	Ident-No.
11	14.3	2.5	6,3	2	184350 L
[mm]	[mm]	[mm]	[mm]	[pc.]	

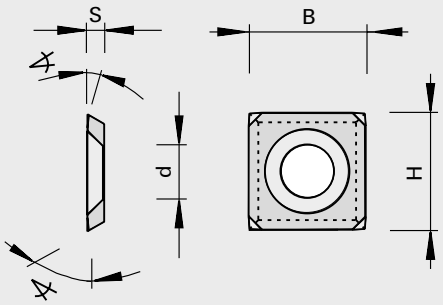
151555

Scraper Turnover-Knives HW with 4 cutting edges - HOLZ-HER

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge banding machines HOLZ-HER

Design

- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

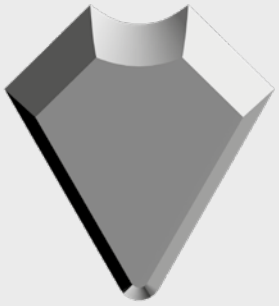
Notes

B	H	S	Ø d	Wedge◁	◁	PU	Ident-No.
14	14	2.0	6,4	60	10	2	185180 L
[mm]	[mm]	[mm]	[mm]	[°]	[°]	[pc.]	

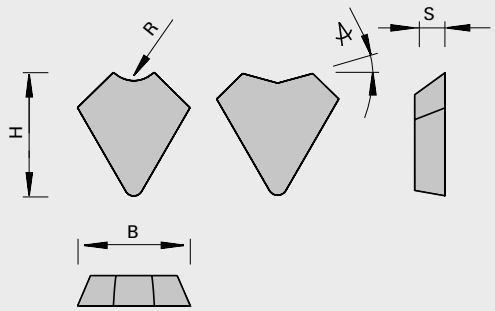
151586

Scraper Knives HW with 1 cutting edge and radius or chamfer - Ott

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge banding machines Ott

Design

- 10 degree profile run-out
- cutting material: HW
- HL Board 05 for plastics

Advantages

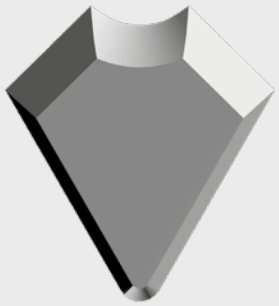
Notes

R	Chamfer◁	B	H	S	PU	Ident-No.
1,0		12,29	13.49	3.3	2	185019 L
2,0		12,29	13.49	3.3	2	185020 L
3,0		12,29	13.49	3.3	2	185021 S
4,0		12,31	12.69	3.3	2	185022 S
5,0		12,31	12.4	3.3	2	185023 S
	30	12,83	12.86	3.3	2	185024 C
[mm]	[°]	[mm]	[mm]	[mm]	[pc.]	

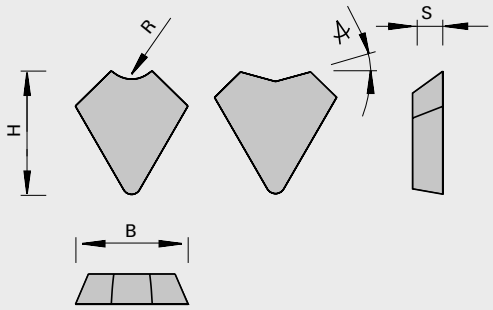
151786

Scraper Knives HW with 1 cutting edge and radius or chamfer - polished, Ott

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge banding machines Ott

Design

- 10 degree profile run-out
- cutting material: HW
- HL Board 05 for plastics

Advantages

- Less material fracturing
- Better chip evacuation

Notes

R	Chamfer◁	B	H	S	PU	Ident-No.
1,0		12,29	13.49	3.3	2	186189 C
2,0		12,29	13.49	3.3	2	186190 C
3,0		12,29	13.49	3.3	2	186191 S
4,0		12,31	12.69	3.3	2	186192 S
5,0		12,31	12.4	3.3	2	186193 S
	30	12,83	12.86	3.3	2	186194 S
[mm]	[°]	[mm]	[mm]	[mm]	[pc.]	

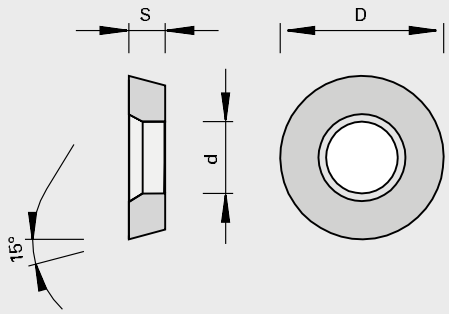
150503

Cup Knives HW

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in side-and-face cutterheads

Design

- cutting material: HW
- HL Board 03 for wood-based panels and plastics

Advantages

- extremely long edge lives

Notes

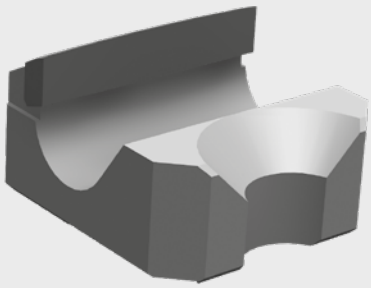
- packing unit: 10 pieces

Ø D	S	Ø d	Ident-No.
11	4.0	5,0	173396 L
[mm]	[mm]	[mm]	

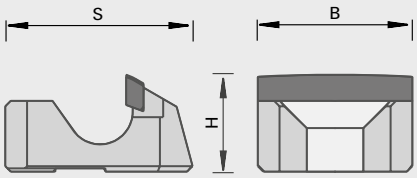
232239

Cutting edges DP for SmartJointer airFace

Product



Drawing



LEUCO DIA

Polycrystalline diamond [DP]

Machine / Application

- for use in DIAMAX SmartJointer airFace jointing cutterheads
- new replacement segments for a SmartJointer airFace with constant diameter

Design

- DP cutting edges with integrated stainless steel gullet
- Resharpening area: 1.5 mm
- highly precise with the same weight
- 187243+187244 have a reduced cutting width to process 8-mm panels on OTT machines

Advantages

- with integrated stainless steel gullet - no washing out!
- highly precise with the same weight
- Constant diameter of the tool after having inserted a new segment
- protected against corrosion

Notes

- ATTENTION! When replacing the segments, please observe the operating instructions
- ATTENTION! Segment 187243 suitable for tools 186057 and 187244 suitable for tools 186058 for Ott machines.

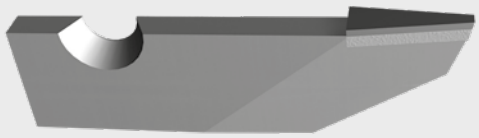
B	H	S	PU	Ident-No. [L]	Ident-No. [R]
8,2	8.9	17.2	3	187244 L	187243 L
[mm]	[mm]	[mm]	[pc.]		

B	H	S		PU	Ident-No.
14,2	8.9	17.2	Ø D=60 / 35°	4	187743 L
14,2	8.9	17.2	Ø D=70 / 35°	4	186076 L
14,2	8.9	17.2	Ø D=80 / 35°	4	186077 L
14,2	8.9	17.2	Ø D=85 / 35°	4	186078 L
14,2	8.9	17.2	Ø D=100 / 35°	4	185250 L
14,2	8.9	17.2	Ø D=125 / 35°	4	185974 L
14,2	8.9	17.2	Ø D=125 / 43°	4	186075 L
14,2	8.9	17.2	Ø D=150 / 35°	4	187245 L
[mm]	[mm]	[mm]		[pc.]	

232921

LEUCODIA cutting inserts

Product



Drawing

LEUCO DIA

Polycrystalline diamond [DP]

Machine / Application

- postforming machines HOMAG, IMA
- to be inserted in scribing cutterheads for the postforming process

Design

- LEUCODIA cutting inserts with different profiles
- suitable countersunk screws included in delivery

Advantages

Notes

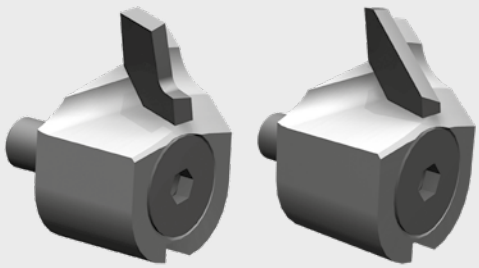
- LEUCODIA cutting inserts only to be installed blockwise (packing unit 4 pieces)
- B=0.5 mm not recommended for butted-up workpieces; in this case B=1.2 mm should be used instead

B	PU	Ident-No. [L]	Ident-No. [R]
0,5	4	180063 L	180064 L
1,2	4	180834 C	180835 C
0,8	4	180959 C	180960 C
[mm]	[pc.]		

232269

Replacement profile segment DP for multi-profile cutter OTT-AKF

Product



Drawing

LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

Machine / Application

- for use in multi-profile cutter - OTT-AKF

Design

- with shear angle
- polished face
- high-finish clearance face

Advantages

- replacement of a whole set of individual profiles is possible
- further profile combinations are available upon request

Notes

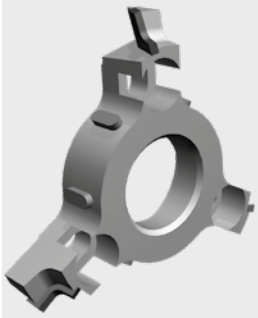
- segments are not intended for resharpening
- Attention: please observe the operating instruction of the milling head during installation
- the profile change must always be coordinated between the tool manufacturer and the machine manufacturer
- tools are delivered with mounting screws

R	Chamfer∢	B	H	S	PU	Ident-No. [L]	Ident-No. [R]
1		17,2	8.9	14.2	3	187080 L	187084 L
	45	17,2	8.9	14.2	3	187079 L	187083 L
[mm]	[°]	[mm]	[mm]	[mm]	[pc.]		

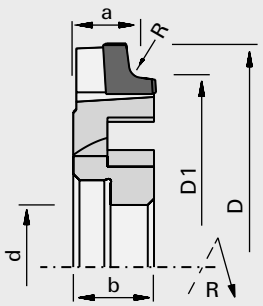
222280

Profile cutter DP for use in multi-profile cutters - OTT-AKF

Product



Drawing



LEUCO topline

LEUCO DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- for use in multi-profile cutter - OTT-AKF

Design

- with shear angle
- polished face
- high-finish clearance face

Advantages

- replacement of individual profiles in the set is possible
- further profile combinations are available upon request

Notes

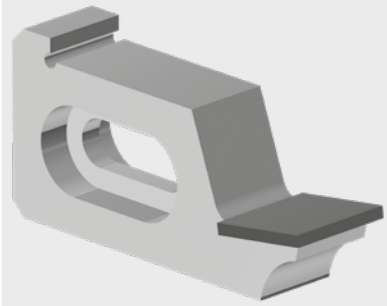
- not intended for resharpening
- please observe the operating instruction of the milling head during installation
- the profile change must always be coordinated between the tool manufacturer and the machine manufacturer
- tool must always have the largest profile in the set - max. radius = 3
- tools are delivered with mounting screws

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
2	73	61	10.72	13	20	3	187073 L	187082 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

232094

Cutting edges DP-tipped for profile cutterhead sets DP - flooring

Product



Drawing

LEUCO DIA

Polycrystalline diamond [DP]

Machine / Application

- to be inserted in profile cutterhead sets DP for the flooring process

Design

- cutting edges DP-tipped unprofiled

Advantages

Notes

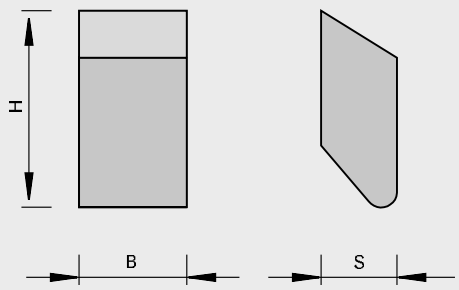
B	H	S	PU	Ident-No.
10	51.3	25	4	186888 L
15	51.3	25	4	185045 L
20	56	25	4	185370 L
[mm]	[mm]	[mm]	[pc.]	

153301

Saw Teeth HW for Circular Saw Blades - with solder coating

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

Design

- Solder-coated
- Cutting material: HW
- HL Board 06 for wood-based panels, MDF, plastics, particle boards, and exotic wood
- HL Solid 15 for wood-based panels and hard wood
- HL Solid 20 for hard wood and soft wood

Advantages

- easy soldering during tooth installation thanks to solder coating

Notes

- packing unit: 500 pieces

B	H	S	LEUCODUR	Ident-No.
2,7	7.1	2.0	HL Board 06	177493 C
2,8	8.0	2.3	HL Solid 15	177500 C
3,6	8.0	2.3	HL Board 06	177494 L
4,3	10.5	3.0	HL Board 06	177496 L
4,5	8.0	2.3	HL Board 06	177495 L
5,0	10.5	3.0	HL Board 06	177497 L
5,0	10.5	3.5	HL Solid 15	80318077 C
5,4	10.5	3.0	HL Board 06	177498 L
5,6	10.5	4.0	HL Solid 20	80369454 C
5,8	10.5	3.5	HL Solid 25	80325122 S
6,0	10.5	3.5	HL Solid 15	80304506 C
6,0	10.5	4.0	HL Solid 15	80352231 S
6,0	12.5	4.0	HL Solid 15	80225542 S
6,0	12.5	4.0	HL Solid 15	177586 L
6,0	12.5	4.0	HL Solid 25	80356362 C
6,0	13	4.0	HL Solid 15	80344985 C
6,5	10.5	3.5	HL Solid 15	80357275 S
6,5	12.5	3.0	HL Solid 15	80373746 O
6,5	13	4.0	HL Solid 15	80344986 C
6,8	12.5	4.0	HL Board 06	177499 L
7,5	10.5	3.5	HL Solid 25	80325124 C
7,5	12.5	3.0	HL Solid 15	80373745 O
7,5	12.5	4.0	HL Solid 15	80282311 S
7,5	13	4.0	HL Board 20	80369455 C
[mm]	[mm]	[mm]		

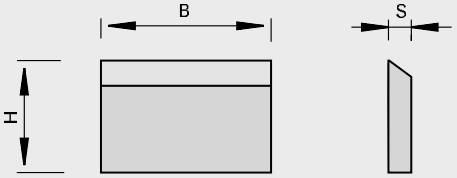
332121/332124

Planing Knives HS

Product



Drawing



High Speed Steel [HS]

Machine / Application

- for use in planing cutterheads

Design

- cutting material: high speed steel (HS 18%) for soft woods
- wedge angle 40°
- topcoat coating

Advantages

Notes

- from safety reasons please always mount knives with equal weight (packing unit VE) opposite each other

B	H	S	PU	Ident-No.
60	30	3.0	2	160593 L
80	30	3.0	2	160594 L
100	30	3.0	2	055647 L
110	30	3.0	2	160595 C
120	30	3.0	2	160596 L
130	30	3.0	2	006139 L
150	30	3.0	2	160597 L
170	30	3.0	2	160598 L
180	30	3.0	2	160599 L
210	30	3.0	2	160600 L
230	30	3.0	2	160601 L
260	30	3.0	2	006485 L
310	30	3.0	2	160602 L
310	35	3.0	2	165310 L
320	30	3.0	2	160603 L
320	35	3.0	2	165311 C
330	30	3.0	2	160604 C
330	35	3.0	2	165312 L
360	30	3.0	2	160605 C
360	35	3.0	2	165313 C
400	30	3.0	2	165307 L
400	35	3.0	2	165314 C
410	30	3.0	2	006486 L
410	35	3.0	2	006487 L
450	30	3.0	2	160606 C
450	35	3.0	2	165315 C
460	30	3.0	2	160607 C
460	35	3.0	2	165316 C
500	30	3.0	2	165308 L
500	35	3.0	2	165317 L
510	30	3.0	2	006488 L
510	35	3.0	2	006489 L
600	30	3.0	2	165309 C
600	35	3.0	2	165318 C
610	30	3.0	2	006490 L
610	35	3.0	2	006491 L
630	30	3.0	2	160608 L
630	35	3.0	2	165319 L
635	35	3.0	2	165320 C
640	30	3.0	2	160609 L
640	35	3.0	2	165321 L
700	35	3.0	2	165322 C
710	30	3.0	2	160610 C
[mm]	[mm]	[mm]	[pc.]	

B	H	S		PU	Ident-No.
710	35	3.0		2	165323 C
740	35	3.0		2	165324 C
810	30	3.0		2	160612 L
810	35	3.0		2	165325 L
840	30	3.0		2	160613 C
1050	25	3.0		2	185843 C
1050	30	3.0		2	176331 L
1050	35	3.0		2	176332 L
[mm]	[mm]	[mm]		[pc.]	

B	H	S		PU	Ident-No.
60	30	3.0	topcoat	10	185554 C
80	30	3.0	topcoat	10	185555 C
100	30	3.0	topcoat	10	185556 C
120	30	3.0	topcoat	10	185558 C
130	30	3.0	topcoat	10	185559 C
150	30	3.0	topcoat	10	185560 C
170	30	3.0	topcoat	10	185561 C
180	30	3.0	topcoat	10	185562 C
210	30	3.0	topcoat	10	185563 C
230	30	3.0	topcoat	10	185564 C
260	30	3.0	topcoat	10	185565 C
310	30	3.0	topcoat	10	185566 C
310	35	3.0	topcoat	10	185567 C
320	30	3.0	topcoat	10	185568 C
330	35	3.0	topcoat	10	185571 C
400	30	3.0	topcoat	10	185574 C
410	30	3.0	topcoat	10	185576 C
410	35	3.0	topcoat	10	185577 C
500	30	3.0	topcoat	10	185582 C
500	35	3.0	topcoat	10	185583 C
510	30	3.0	topcoat	10	185584 C
510	35	3.0	topcoat	10	185585 C
610	30	3.0	topcoat	10	185588 C
610	35	3.0	topcoat	10	185589 C
630	30	3.0	topcoat	10	185590 C
630	35	3.0	topcoat	10	185591 C
640	30	3.0	topcoat	10	185593 C
640	35	3.0	topcoat	10	185594 C
[mm]	[mm]	[mm]		[pc.]	

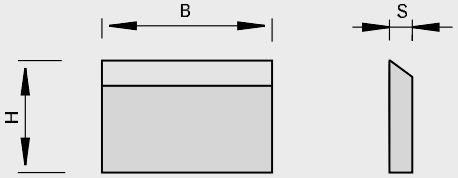
332121/332124

Planing knife HS for hydro and jointing

Product



Drawing



High Speed Steel [HS]

Machine / Application

- for use in hydro planing cutterheads

Design

- cutting material: HS for soft woods
- wedge angle 30° for jointing
- topcoat coating

Advantages

- high run-out accuracy due to grinding the knives in the hydro planing cutterhead with following jointing process in the machine

Notes

- from safety reasons please always mount knives with equal weight (packing unit VE) opposite each other

B	H	S		PU	Ident-No.
130	30	3.0		2	182759 C
150	30	3.0		2	182760 C
170	30	3.0		2	182761 S
180	30	3.0		2	182762 C
190	30	3.0		2	182763 C
210	30	3.0		2	182764 S
230	30	3.0		2	182765 C
240	30	3.0		2	182766 C
270	30	3.0		2	182767 C
310	30	3.0		2	182768 S
[mm]	[mm]	[mm]		[pc.]	

B	H	S		PU	Ident-No.
130	30	3.0	topcoat	10	186007 S
150	30	3.0	topcoat	10	186008 S
170	30	3.0	topcoat	10	186009 S
180	30	3.0	topcoat	10	186010 S
190	30	3.0	topcoat	10	186011 S
210	30	3.0	topcoat	10	186012 S
230	30	3.0	topcoat	10	186013 C
240	30	3.0	topcoat	10	186014 S
270	30	3.0	topcoat	10	186015 S
310	30	3.0	topcoat	10	186016 S
[mm]	[mm]	[mm]		[pc.]	

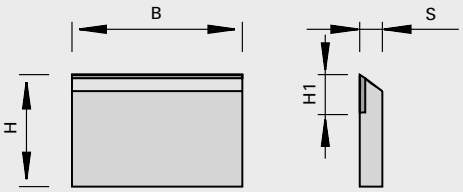
132121

Planing Knives HW

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in planing cutterheads

Design

- cutting material: HW-tipped for hard woods

Advantages

Notes

- from safety reasons please always mount knives with equal weight (packing unit VE) opposite each other

B	H	S	H1	PU	Ident-No.
60	30	3.0	11	2	160586 L
80	30	3.0	11	2	006204 L
100	30	3.0	11	2	006205 L
110	30	3.0	11	2	165329 O
120	30	3.0	11	2	006206 C
130	30	3.0	11	2	006207 L
150	30	3.0	11	2	006208 L
170	30	3.0	11	2	006209 L
180	30	3.0	11	2	055649 L
210	30	3.0	11	2	006210 C
230	30	3.0	11	2	160588 L
240	30	3.0	11	2	182641 L
260	30	3.0	11	2	160589 O
310	30	3.0	11	2	055648 L
310	35	3.0	11	2	165338 O
320	30	3.0	11	2	165330 O
320	35	3.0	11	2	165339 S
330	30	3.0	11	2	165331 O
330	35	3.0	11	2	165340 S
360	30	3.0	11	2	165332 O
360	35	3.0	11	2	165341 S
400	35	3.0	11	2	165342 O
410	30	3.0	11	2	006211 L
410	35	3.0	11	2	165343 O
450	30	3.0	11	2	165333 O
450	35	3.0	11	2	165344 S
460	30	3.0	11	2	165334 O
460	35	3.0	11	2	165345 O
500	35	3.0	11	2	165346 O
510	30	3.0	11	2	006212 L
510	35	3.0	11	2	165347 O
600	35	3.0	11	2	165348 O
610	30	3.0	11	2	006704 O
610	35	3.0	11	2	165349 O
630	30	3.0	11	2	165335 O
630	35	3.0	11	2	165350 O
635	35	3.0	11	2	165351 O
640	30	3.0	11	2	165336 O
640	35	3.0	11	2	165352 O
700	35	3.0	11	2	165353 O
710	30	3.0	11	2	160590 O
710	35	3.0	11	2	165354 S
740	30	3.0	11	2	165337 O
[mm]	[mm]	[mm]	[mm]	[pc.]	

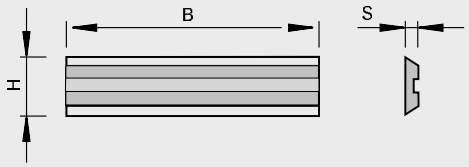
B	H	S	H1	PU	Ident-No.
740	35	3.0	11	2	165355 S
810	30	3.0	11	2	160592 L
810	35	3.0	11	2	165356 O
[mm]	[mm]	[mm]	[mm]	[pc.]	

332121

Turnover Knives HS with 2 cutting edges - Weinig

Product

Drawing



High Speed Steel [HS]

Machine / Application

- for use in Weinig planing cutterheads Centrolock for planing of soft woods

Design

- cutting material: high speed steel (HS 18%) for soft woods

Advantages

- high planing quality and long edge lives

Notes

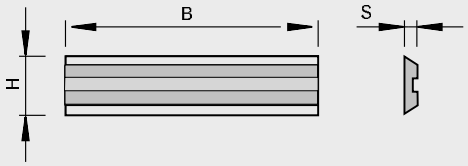
B	H	S	PU	Ident-No.
20	16	3.0	2	184334 S
60	16	3.0	2	184335 C
80	16	3.0	2	184336 C
100	16	3.0	2	184337 C
130	16	3.0	2	184338 L
150	16	3.0	2	184339 C
170	16	3.0	2	184340 L
180	16	3.0	2	184341 C
190	16	3.0	2	184342 C
210	16	3.0	2	184343 S
230	16	3.0	2	184344 C
240	16	3.0	2	184345 L
260	16	3.0	2	184346 S
270	16	3.0	2	184347 C
285	16	3.0	2	184331 C
310	16	3.0	2	184348 C
460	16	3.0	2	184349 S
[mm]	[mm]	[mm]	[pc.]	

150517

Turnover Knives HW with 2 cutting edges - Weinig

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- for use in Weinig planing cutterheads Centrolock for planing of glued soft woods, hard woods and MDF

Design

- cutting material: HW
- HL Solid 20 for hard and soft woods

Advantages

- high planing quality and long edge lives

Notes

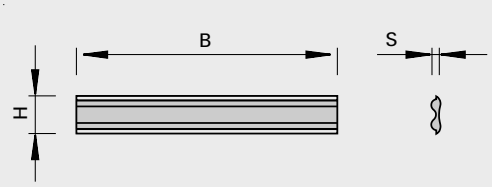
B	H	S	PU	Ident-No.
20	16	3.0	2	181593 S
60	16	3.0	2	181594 C
80	16	3.0	2	181595 C
100	16	3.0	2	181596 C
130	16	3.0	2	181597 L
150	16	3.0	2	181598 C
170	16	3.0	2	181599 L
180	16	3.0	2	181600 C
190	16	3.0	2	181601 C
210	16	3.0	2	181602 C
230	16	3.0	2	181603 C
240	16	3.0	2	181604 L
260	16	3.0	2	181605 S
270	16	3.0	2	181606 C
285	16	3.0	2	186575 C
310	16	3.0	2	181607 C
460	16	3.0	2	181608 S
[mm]	[mm]	[mm]	[pc.]	

332751

Turnover Knives HS with 2 cutting edges - Tersa

Product

Drawing



High Speed Steel [HS]

Machine / Application

- for use in Tersa planing cutterheads

Design

- cutting material: HS for soft woods

Advantages

Notes

B	H	S	PU	Ident-No.
60	10	2.3	2	175305 S
80	10	2.3	2	175307 C
90	10	2.3	2	175308 S
100	10	2.3	2	175309 C
110	10	2.3	2	175310 C
120	10	2.3	2	175311 C
130	10	2.3	2	175312 C
140	10	2.3	2	175313 S
150	10	2.3	2	175314 C
160	10	2.3	2	175315 S
170	10	2.3	2	175316 C
180	10	2.3	2	175317 C
185	10	2.3	2	175318 C
190	10	2.3	2	175319 C
200	10	2.3	2	175320 C
210	10	2.3	2	175321 S
220	10	2.3	2	175322 C
230	10	2.3	2	175323 C
240	10	2.3	2	175324 S
250	10	2.3	2	175325 C
260	10	2.3	2	175326 S
265	10	2.3	2	175327 C
270	10	2.3	2	175328 S
280	10	2.3	2	175329 C
300	10	2.3	2	175331 C
310	10	2.3	2	175332 L
320	10	2.3	2	175334 S
330	10	2.3	2	175335 C
350	10	2.3	2	175337 C
360	10	2.3	2	175338 S
400	10	2.3	2	175342 C
410	10	2.3	2	175343 L
420	10	2.3	2	175344 S
430	10	2.3	2	175345 C
450	10	2.3	2	175347 S
500	10	2.3	2	175352 C
510	10	2.3	2	175353 L
520	10	2.3	2	175354 L
530	10	2.3	2	175355 C
540	10	2.3	2	175356 C
610	10	2.3	2	175363 C
630	10	2.3	2	175365 L
635	10	2.3	2	175366 S
640	10	2.3	2	175368 L
[mm]	[mm]	[mm]	[pc.]	

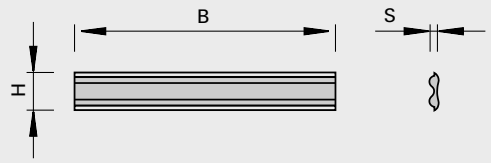
B	H	S	PU	Ident-No.
650	10	2.3	2	175369 S
[mm]	[mm]	[mm]	[pc.]	

132751

Turnover Knives HW with 2 cutting edges - Tersa

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in Tersa planing cutterheads

Design

- cutting material: HW for hard and exotic woods

Advantages

- optimal precision as manufactured from one piece up to B=650 mm

Notes

B	H	S	PU	Ident-No.
60	10	2.3	2	175205 S
80	10	2.3	2	175207 S
90	10	2.3	2	175208 C
100	10	2.3	2	175209 C
110	10	2.3	2	175210 C
120	10	2.3	2	175211 S
130	10	2.3	2	175212 C
140	10	2.3	2	175213 S
150	10	2.3	2	175214 S
160	10	2.3	2	175215 C
170	10	2.3	2	175216 C
180	10	2.3	2	175217 C
185	10	2.3	2	175218 C
190	10	2.3	2	175219 S
200	10	2.3	2	175220 S
210	10	2.3	2	175221 S
220	10	2.3	2	175222 S
230	10	2.3	2	175223 C
240	10	2.3	2	175224 S
250	10	2.3	2	175225 S
260	10	2.3	2	175226 S
265	10	2.3	2	175227 C
270	10	2.3	2	175228 S
280	10	2.3	2	175229 S
300	10	2.3	2	175231 S
310	10	2.3	2	175232 C
320	10	2.3	2	175234 C
330	10	2.3	2	175235 C
350	10	2.3	2	175237 S
360	10	2.3	2	175238 S
400	10	2.3	2	175242 C
410	10	2.3	2	175243 C
420	10	2.3	2	175244 S
430	10	2.3	2	175245 S
450	10	2.3	2	175247 S
500	10	2.3	2	175252 S
510	10	2.3	2	175253 C
520	10	2.3	2	175254 C
[mm]	[mm]	[mm]	[pc.]	

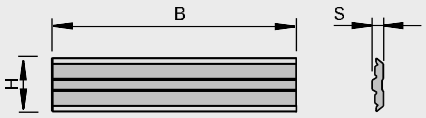
B	H	S	PU	Ident-No.
530	10	2.3	2	175255 C
540	10	2.3	2	175256 S
600	10	2.3	2	175262 C
610	10	2.3	2	175263 S
630	10	2.3	2	175265 C
635	10	2.3	2	175266 C
640	10	2.3	2	175268 C
650	10	2.3	2	175269 S
[mm]	[mm]	[mm]	[pc.]	

332121

Turnover Knives HS with 2 cutting edges - Centrostar, Centrofix, Quickfix

Product

Drawing



High Speed Steel [HS]

Machine / Application

- for use in planing cutterhead systems Centrostar, Centrofix and Quickfix for planing of soft woods

Design

- cutting material: HS for soft woods
- constant diameter

Advantages

- high planing quality and long edge lives

Notes

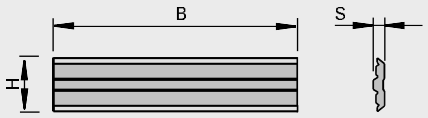
B	H	S	PU	Ident-No.
80	12	2.7	4	182769 C
100	12	2.7	4	182770 C
130	12	2.7	4	182771 C
150	12	2.7	4	182772 S
170	12	2.7	4	182773 C
180	12	2.7	4	182774 C
190	12	2.7	4	182775 C
210	12	2.7	4	182776 C
230	12	2.7	4	182777 C
240	12	2.7	4	182778 C
310	12	2.7	4	182779 C
410	12	2.7	4	182780 C
520	12	2.7	4	182781 C
510	12	2.7	4	182782 C
640	12	2.7	4	182783 C
[mm]	[mm]	[mm]	[pc.]	

150517

Turnover Knives HW with 2 cutting edges - Centrostar, Centrofix, Quickfix

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- for use in planing cutterhead systems Centrostar, Centrofix and Quickfix for planing of hard woods and MDF

Design

- cutting material: HW
- HL Solid 20 for hard and exotic woods
- constant diameter

Advantages

- high planing quality and long edge lives

Notes

- a cutting length of more than 630 mm is reached by means of several knives

B	H	S	PU	Ident-No.
100	12	2.7	2	182784 C
130	12	2.7	2	182785 C
150	12	2.7	2	182786 C
170	12	2.7	2	182787 S
180	12	2.7	2	182788 C
190	12	2.7	2	182789 S
210	12	2.7	2	182790 C
230	12	2.7	2	182791 C
240	12	2.7	2	182792 C
410	12	2.7	2	182793 S
510	12	2.7	2	182794 C
640	12	2.7	2	182795 S
[mm]	[mm]	[mm]	[pc.]	

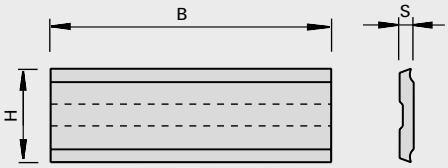
150613 / 150617

Turnover Knives HW with 2 cutting edges - Versofix

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- for use in planing cutterhead systems Versofix for planing of hard woods and MDF

Design

- cutting material: HW
- HL Board 03 for wood-based
- HL Solid 20 for hard and soft woods
- constant diameter

Advantages

- high planing quality and long edge lives

Notes

- topcoat coating are possible

B	H	S	LEUCODUR	PU	Ident-No.
20	5.5	1.1	HL Board 03	10	186244 S
20	5.5	1.1	HL Solid 20	10	186245 S
20	10	1.5	HL Board 03	10	186246 C
20	10	1.5	HL Solid 20	10	186247 S
30	6.5	1.1	HL Board 03	10	186248 S
30	6.5	1.1	HL Solid 20	10	186249 S
30	10	1.5	HL Board 03	10	186250 C
30	10	1.5	HL Solid 20	10	186251 C
50	6.5	1.1	HL Board 03	10	186252 S
50	6.5	1.1	HL Solid 20	10	186253 S
50	10	1.5	HL Board 03	10	186254 C
50	10	1.5	HL Solid 20	10	186256 C
[mm]	[mm]	[mm]		[pc.]	

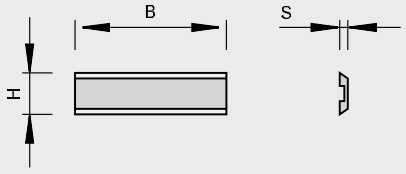
150535

Mini Turnover Knives HW with 2 cutting edges

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in shank-type cutterheads

Design

- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

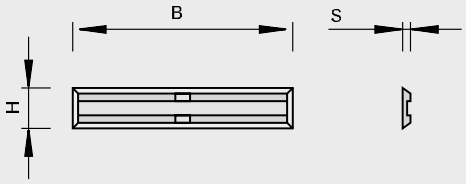
B	H	S	PU	Ident-No.
12	5.5	1.1	10	162670 L
20	5.5	1.1	10	160623 L
40	5.5	1.1	10	160674 C
50	5.5	1.1	10	163572 C
[mm]	[mm]	[mm]	[pc.]	

150535

Mini Turnover Knives HW with 2 cutting edges, end sharpened

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- for use in shank-type cutters

Design

- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

B	H	S	PU	Ident-No.
12	5.5	1.1	10	168696 S
20	4.1	1.1	10	173480 L
20	5.5	1.1	10	173481 L
25	5.5	1.1	10	173793 L
30	5.5	1.1	10	173482 L
50	5.5	1.1	10	173483 L
[mm]	[mm]	[mm]	[pc.]	

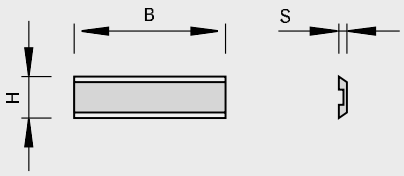
332121

Mini Turnover Knives HW with 2 cutting edges - for planing cutterheads with centrifugal clamping

Product



Drawing



High Speed Steel [HS]

Machine / Application

- for use in planing cutterheads with centrifugal clamping

Design

- cutting material: HS-TRI or HW

Advantages

Notes

Turnover Knives	B	Cutting material	Class-No.	PU	Ident-No.
	60	HS-TRI	332121	2	70469707 S
	80	HS-TRI	332121	2	70469708 S
	100	HS-TRI	332121	2	70469710 S
	120	HS-TRI	332121	2	70469712 S
	130	HS-TRI	332121	2	70469713 S
	136	HS-TRI	332121	2	70469736 S
	140	HS-TRI	332121	2	70469714 S
	150	HS-TRI	332121	2	70469715 S
	160	HS-TRI	332121	2	70469716 S
	180	HS-TRI	332121	2	70469718 S
	186	HS-TRI	332121	2	70469786 S
	190	HS-TRI	332121	2	70469719 S
	200	HS-TRI	332121	2	70469720 S
	[mm]			[pc.]	

Turnover Knives	B	Cutting material	Class-No.	PU	Ident-No.
	210	HS-TRI	332121	2	70469721 S
	220	HS-TRI	332121	2	70469722 S
	230	HS-TRI	332121	2	70469723 S
	240	HS-TRI	332121	2	70469724 S
	260	HS-TRI	332121	2	70469726 S
	300	HS-TRI	332121	2	70469730 S
	310	HS-TRI	332121	2	70469731 S
	400	HS-TRI	332121	2	70469740 S
	410	HS-TRI	332121	2	70469741 S
	430	HS-TRI	332121	2	70469743 S
	500	HS-TRI	332121	2	70469750 S
	510	HS-TRI	332121	2	70469751 S
	610	HS-TRI	332121	2	70469761 S
	630	HS-TRI	332121	2	70469763 S
	640	HS-TRI	332121	2	70469764 S
	710	HS-TRI	332121	2	70469771 S
	1350	HS-TRI	332121	2	70469798 S
	[mm]			[pc.]	

Turnover Knives	B	Cutting material	Class-No.	PU	Ident-No.
	80	HW	132121	2	70469908 S
	100	HW	132121	2	70469951 O
	120	HW	132121	2	70469912 S
	130	HW	132121	2	70469953 S
	140	HW	132121	2	70469914 S
	150	HW	132121	2	70469915 S
	160	HW	132121	2	70469916 S
	200	HW	132121	2	70469920 S
	210	HW	132121	2	70469921 S
	220	HW	132121	2	70469922 S
	230	HW	132121	2	70469923 S
	240	HW	132121	2	70469924 S
	250	HW	132121	2	70469925 S
	260	HW	132121	2	70469926 S
	300	HW	132121	2	70469930 S
	610	HW	132121	2	70469999 S
	[mm]			[pc.]	

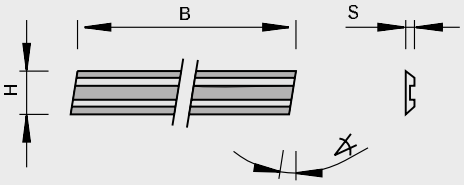
150549

Portable Planer Turnover Knives HW with 2 cutting edges and edge bevel

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- portable planers

Design

- cutting material: HW
- HL Solid 40 for hard and soft woods

Advantages

Notes

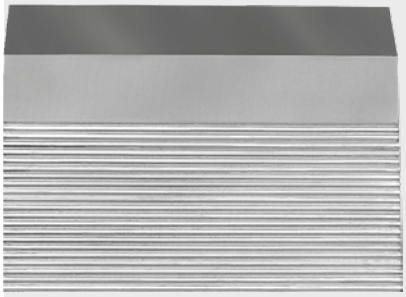
- Ident-No. 166381 can only be used in the original ELU clamping element
- packing unit: 10 pieces

B	H	S	Clearance ◁ 1		PU	Ident-No.
75,5	5.5	1.1	1.5	AEG HTH 75, Bosch 0590, P400, 1590, 1591, Festo REP 75, Haffner FH 222, HOLZ-HER 2223, 2286, 2320, Kress Jet Star 6701, Mafell HU 75, Metabo 6375, Scheer MH 80, MH 75/3, Skil 98 H	10	162439 L
80,5	5.9	1.2	8	ELU MFF 80	10	166381 L
82	5.5	1.1	3	AEG, Fein, Haffner, Hitachi, Mafell, Makita, Metabo, Bosch, Black&Decker DN712	10	165617 L
102	5.5	1.1	3	AEG EH 102, HB 750	10	419671 C
[mm]	[mm]	[mm]	[°]		[pc.]	

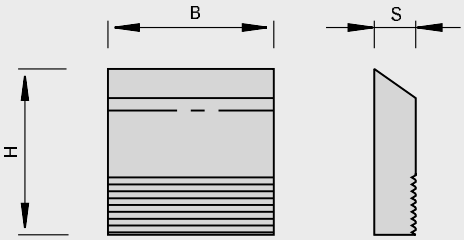
332511

Back-serrated HS Planing Knives

Product



Drawing



High Speed Steel [HS]

Machine / Application

- also for Weinig Powermat machines, RPM up to 12,000 min-1
- for use in cutterheads with serration

Design

- cutting material: HS for soft woods

Advantages

Notes

- from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other

B	H	S		PU	Ident-No.
100	38	5.0		2	182096 C
130	38	5.0		2	182097 C
170	38	5.0		2	182098 C
190	38	5.0		2	182099 C
230	38	5.0		2	182100 C
240	38	5.0		2	182101 C
[mm]	[mm]	[mm]		[pc.]	

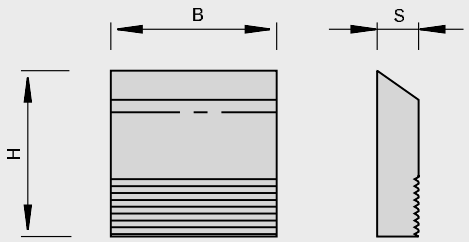
332511

Back-serrated HS Planing Knives - Quicklock

Product



Drawing



High Speed Steel [HS]

Machine / Application

- for use in hydro planing cutterheads Quicklock with serration

Design

- cutting material: HS for soft woods

Advantages

Notes

- from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other

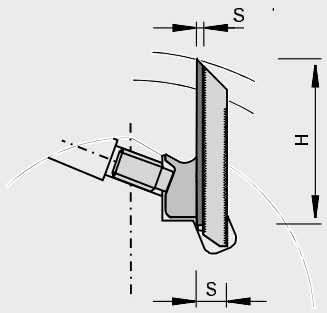
B	H	S	PU	Ident-No.
100	30	4.0	2	183354 S
130	30	4.0	2	183355 C
150	30	4.0	2	183356 S
180	30	4.0	2	183357 S
210	30	4.0	2	183358 S
230	30	4.0	2	183359 S
240	30	4.0	2	183360 C
270	30	4.0	2	183361 S
310	30	4.0	2	183362 S
320	30	4.0	2	183363 S
100	35	4.0	2	183364 S
130	35	4.0	2	183365 S
150	35	4.0	2	183366 C
180	35	4.0	2	183367 C
210	35	4.0	2	183368 S
230	35	4.0	2	183369 S
240	35	4.0	2	183370 S
270	35	4.0	2	183371 S
310	35	4.0	2	183372 C
320	35	4.0	2	183373 S
[mm]	[mm]	[mm]	[pc.]	

152548

SetProfiler set - planing

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- molders
- for use in profile cutterheads with serration

Design

- n max = 12,000 min-1
- cutting material: HW
- HL Solid 30 topline for hard and soft woods
- HW topcoat
- topline (polished face)

Advantages

- significantly improved cutting edges
- excellent cutting quality
- compared to uncoated HW-Blanks the edge lives is 2 - 3 times as long
- adjustable knives by means of serration between knive and support plate; 5 adjustments of 1,6 mm = 8 mm sharpening area

Notes

- from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other

B	H	S	PU	Ident-No.
310	38	10	2	181974 S
[mm]	[mm]	[mm]	[pc.]	

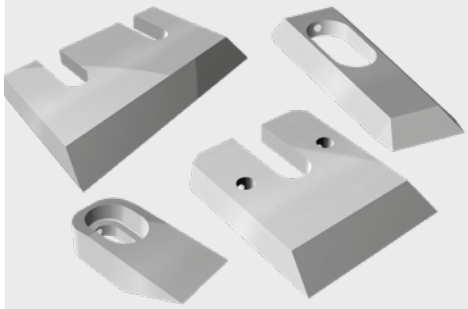
Blanks	B	H	S	Class-No.	PU	Ident-No.
HW Blanks	310	38	3.2	152548	2	181975 L
HW topcoat Blanks	250	38	3.2	152548	2	181976 S
	[mm]	[mm]	[mm]		[pc.]	

Support plates	B	Suitable for blank height	Class-No.	PU	Ident-No.
	250	38	925400	2	181977 S
	310	38	925400	2	181978 L
	[mm]	[mm]		[pc.]	

332321

Knives - Linck

Product

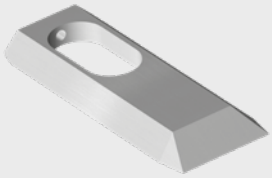


Drawing

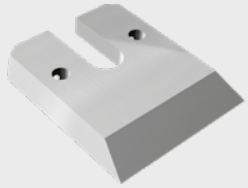
LEUCO DUR

High Speed Steel [HS]

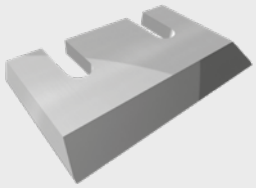
Machine / Application	Design	Advantages	Notes
l Linck l for hogger lines	l cutting material: HS for the machining of soft woods		l packing unit 10 pieces



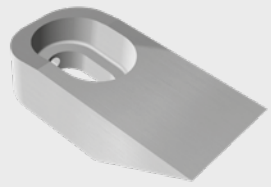
	Dimension		LEUCODUR	Ident-No.
Chipping knives - Linck	105x41x8 [mm]	1 long hole 1 threads M5 on the back	HS	185542 S



	Dimension		LEUCODUR	Ident-No.
Chipping knives - Linck	105x92x12 [mm]	1 opening 2 threads M6 on the back	HS	185540 C



	Dimension		LEUCODUR	Ident-No.
Chipping knives - Linck	184x108x14 [mm]	2 openings 2 threads M6 on the back	HS	185541 S

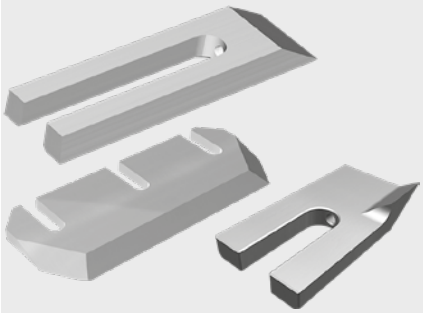


	Dimension		LEUCODUR	Ident-No.
Finishing knives - Linck	76x35x20 [mm]	1 thread M6 on back with chamfer edge of 20 mm/8° sides straight	HS	185543 S

332321

Knives - EWD

Product



Drawing

LEUCO DUR

High Speed Steel [HS]

Machine / Application

- EWD
- for hogger lines

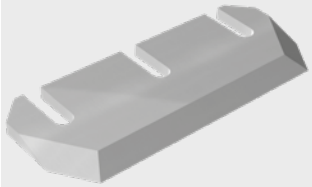
Design

- cutting material: HS for the machining of soft woods

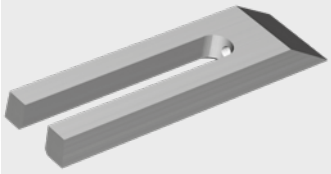
Advantages

Notes

- packing unit 2 pieces



	Dimension		LEUCODUR		Ident-No.
Rotor knives - EWD	289x115x12	3 openings 2 threads M6 on the back side chamfer 29° side bevel 34°	HS		185544 L
	[mm]				



	Dimension		LEUCODUR		Ident-No.
Chipping knives - EWD	153x40x14,5	1 openings 1 threads M6	HS		186494 L
	[mm]				

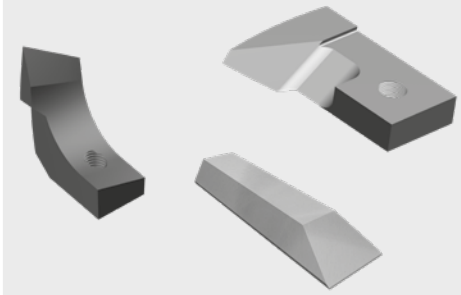


	Dimension		LEUCODUR		Ident-No.
Chipper Knives - EWD	15,9/9x75x39	1 openings 1 threads M5	HS	R	186514 S
Chipper Knives - EWD	15,9/9x75x39	1 openings 1 threads M5	HS	L	186515 S
	[mm]				

332321

Knives - Veisto HewSaw

Product

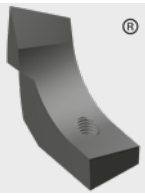


Drawing

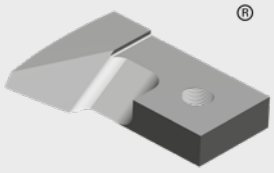
LEUCO DUR

High Speed Steel [HS]

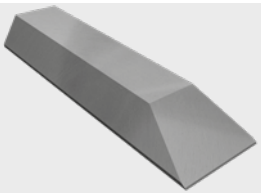
Machine / Application	Design	Advantages	Notes
I Veisto HewSaw I for hogger lines	I cutting material: HS for the machining of soft woods		I packing unit 2 pieces



	Dimension		LEUCODUR		Ident-No.
Knives - Veisto HewSaw	72x53x34/27,9	1 threads M12	HS	R	185882 C
Knives - Veisto HewSaw	72x53x34/27,9	1 threads M12	HS	L	185883 C
	[mm]				



	Dimension		LEUCODUR		Ident-No.
Knives - Veisto HewSaw	94,5x19,9x74,5/45	1 threads M16	HS	R	185884 C
Knives - Veisto HewSaw	94,5x19,9x74,5/45	1 threads M16	HS	L	185885 C
	[mm]				

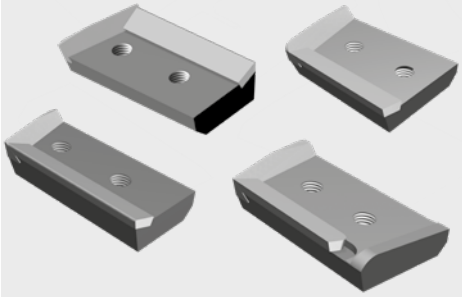


	Dimension		LEUCODUR		Ident-No.
Chipping knives - Veisto HewSaw	82x25x10	1 threads M6 on the back	HS		186449 S
	[mm]				

132321

Peel Knives HW

Product



Drawing

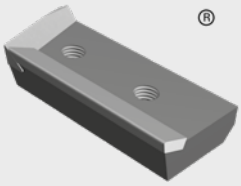
Tungsten Carbide [HW]

Machine / Application
- for hogger lines

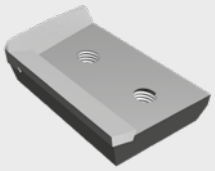
Design
- cutting material: HW HL Solid 20 for hard and soft woods

Advantages

Notes
- packing unit 2 pieces



	Dimension		LEUCODUR		Ident-No.
Peel Knives	49,5x103x23	2 threads M12	HW	R	185886 S
Peel Knives	49,5x103x23	2 threads M12	HW	L	185887 S
	[mm]				

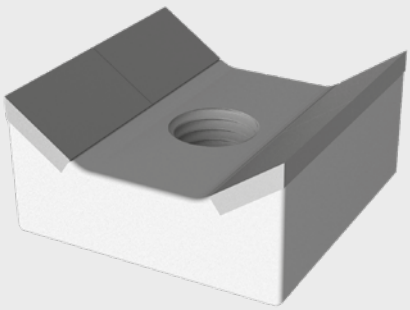


	Dimension		LEUCODUR		Ident-No.
Peel Knives	90x60x21	2 threads M12	HW	R	185889 C
Peel Knives	105x60x20	2 threads M12	HW	R	185888 C
	[mm]				

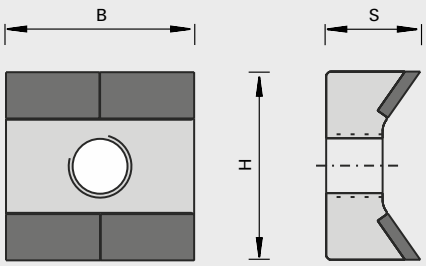
132271

Chipping knives HW

Product



Drawing



Tungsten Carbide [HW]

Machine / Application
- Shredding machines for particle boards
- for shredding of scrap panels to reuse the chips

Design
- HW design to shred particle boards

Advantages
- HW design with a higher edge life than conventional steel cutting knives

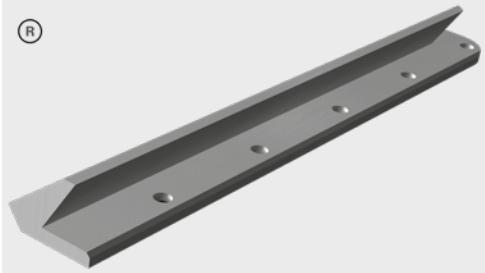
Notes
- Other versions available on request

B	H	S	PU	Ident-No.
60	60	30	80	80479564 C
[mm]	[mm]	[mm]	[pc.]	

332321

Chip Breakers - EWD

Product



Drawing

High Speed Steel [HS]

Machine / Application

I EWD systems

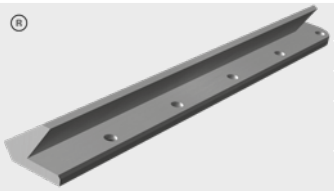
Design

Advantages

I optimized chip breaking

Notes

I packing unit 2 pieces



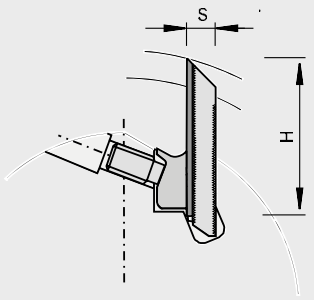
	Dimension	LEUCODUR		Ident-No.
Chip Breakers - EWD	274x43x25	HS	R	186470 S
Chip Breakers - EWD	274x43x25	HS	L	186469 S
	[mm]			

152548

SetProfiler set - profiling

Product

Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- molders
- for use in profile cutterheads with serration

Design

- cutting material: HW
- HL Solid 30 for hard and soft woods
- HW topcoat
- topline (polished face)

Advantages

- significantly improved cutting edges
- excellent cutting quality
- compared to uncoated HW-Blanks the edge lives is 2 - 3 times as long
- high economic efficiency thanks to reduced use of grinding wheels, as knives and support plates are profiled separately whereas only the knives are re-ground
- adjustable knives by means of serration between knive and support plate; 5 adjustments of 1,6 mm = 8 mm sharpening area

Notes

- serration 60 degrees and partition 1,6 mm for profiling of solid woods and wood-based panels
- blank height 50 and 60 mm for RPM up to 12,000 min-2
- T = profile depth
- from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other

B	H	S	Tmax	PU	Ident-No.
40	50	10	14	2	181637 C
50	50	10	14	2	181638 S
60	50	10	14	2	181639 C
70	50	10	14	2	181640 C
80	50	10	14	2	181641 C
100	50	10	14	2	182182 C
130	50	10	14	2	182183 C
150	50	10	14	2	182184 C
250	50	10	14	2	181642 C
40	60	10	24	2	181643 C
50	60	10	24	2	181644 C
60	60	10	24	2	181645 C
70	60	10	24	2	181646 C
80	60	10	24	2	181647 C
100	60	10	24	2	182322 C
130	60	10	24	2	182323 C
150	60	10	24	2	182324 C
250	60	10	24	2	181648 C
40	70	10	34	2	181649 C
50	70	10	34	2	181650 S
60	70	10	34	2	181651 C
70	70	10	34	2	181652 S
80	70	10	34	2	181653 C
250	70	10	34	2	181654 C
[mm]	[mm]	[mm]	[mm]	[pc.]	

HW Blanks topline	B	H	S	T	Class-No.	PU	Ident-No.
	40	50	3.2	14	152548	2	181619 L
	50	50	3.2	14	152548	2	181620 C
	60	50	3.2	14	152548	2	181621 L
	70	50	3.2	14	152548	2	181622 C
	[mm]	[mm]	[mm]	[mm]		[pc.]	

HW Blanks topline	B	H	S	T	Class-No.	PU	Ident-No.
	80	50	3.2	14	152548	2	181623 L
	100	50	3.2	14	152548	2	182179 L
	130	50	3.2	14	152548	2	182180 L
	150	50	3.2	14	152548	2	182181 C
	250	50	3.2	14	152548	2	181624 L
	40	60	3.2	24	152548	2	181625 L
	50	60	3.2	24	152548	2	181626 S
	60	60	3.2	24	152548	2	181627 L
	70	60	3.2	24	152548	2	181628 C
	80	60	3.2	24	152548	2	181629 L
	100	60	3.2	24	152548	2	182319 L
	130	60	3.2	24	152548	2	182320 C
	150	60	3.2	24	152548	2	182321 C
	250	60	3.2	24	152548	2	181630 L
	40	70	3.2	34	152548	2	181631 C
	50	70	3.2	34	152548	2	181632 S
	60	70	3.2	34	152548	2	181633 C
	70	70	3.2	34	152548	2	181634 C
	80	70	3.2	34	152548	2	181635 C
	250	70	3.2	34	152548	2	181636 L
	[mm]	[mm]	[mm]	[mm]		[pc.]	

HW topcoat Blanks	B	H	S	T	Class-No.	PU	Ident-No.
	40	50	3.2	14	152548	2	181665 C
	50	50	3.2	14	152548	2	181666 S
	60	50	3.2	14	152548	2	181667 C
	70	50	3.2	14	152548	2	181668 S
	80	50	3.2	14	152548	2	181669 C
	100	50	3.2	14	152548	2	182188 S
	130	50	3.2	14	152548	2	182189 S
	150	50	3.2	14	152548	2	182190 S
	250	50	3.2	14	152548	2	181670 L
	40	60	3.2	24	152548	2	181671 S
	50	60	3.2	24	152548	2	181672 S
	60	60	3.2	24	152548	2	181673 S
	70	60	3.2	24	152548	2	181674 S
	80	60	3.2	24	152548	2	181675 C
	100	60	3.2	24	152548	2	182328 C
	130	60	3.2	24	152548	2	182329 C
	150	60	3.2	24	152548	2	182330 C
	250	60	3.2	24	152548	2	181676 L
	[mm]	[mm]	[mm]	[mm]		[pc.]	

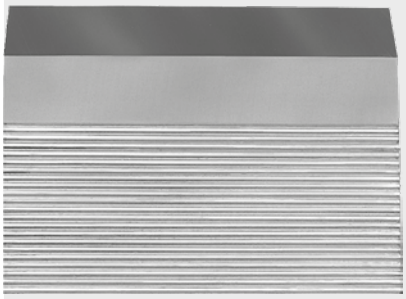
Support plates	B	Suitable for blank height	Class-No.	PU	Ident-No.
	40	50	925400	2	181820 L
	50	50	925400	2	181821 S
	60	50	925400	2	181822 L
	70	50	925400	2	181823 C
	80	50	925400	2	181824 L
	100	50	925400	2	182185 L
	130	50	925400	2	182186 L
	150	50	925400	2	182187 C
	250	50	925400	2	181825 L
	40	60	925400	2	181826 L
	50	60	925400	2	181827 S
	60	60	925400	2	181828 L
	70	60	925400	2	181829 S
	80	60	925400	2	181830 L
	100	60	925400	2	182325 L
	130	60	925400	2	182326 C
	150	60	925400	2	182327 C
	250	60	925400	2	181831 L
	40	70	925400	2	181832 C
	[mm]	[mm]		[pc.]	

Support plates	B	Suitable for blank height	Class-No.	PU	Ident-No.
	50	70	925400	2	181833 S
	60	70	925400	2	181834 C
	70	70	925400	2	181835 S
	80	70	925400	2	181836 C
	250	70	925400	2	181837 L
	[mm]	[mm]		[pc.]	

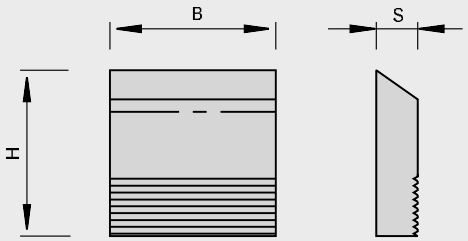
332511

Back-serrated HS blanks for profiling

Product



Drawing



High Speed Steel [HS]

Machine / Application

- for use in profile cutterheads with serration

Design

- cutting material: HS for soft woods

Advantages

Notes

- T = profile depth
- from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other

B	H	S	Tmax	PU	Ident-No.
40	50	8.0	12	2	163385 L
40	60	8.0	20	2	163386 L
40	70	8.0	30	2	163387 L
50	50	8.0	12	2	180533 C
50	60	8.0	20	2	180534 L
60	50	8.0	12	2	163388 L
60	60	8.0	20	2	163389 L
60	70	8.0	30	2	163390 L
80	50	8.0	12	2	163391 L
80	60	8.0	20	2	163392 L
80	70	8.0	30	2	163393 L
100	50	8.0	12	2	163394 L
100	60	8.0	20	2	163395 L
100	70	8.0	30	2	163396 L
130	50	8.0	12	2	163397 L
130	60	8.0	20	2	163398 L
130	70	8.0	30	2	163399 C
150	50	8.0	12	2	163400 L
150	60	8.0	20	2	163401 L
150	70	8.0	30	2	163402 L
180	50	8.0	12	2	163403 C
180	60	8.0	20	2	163404 C
180	70	8.0	30	2	163405 C
230	50	8.0	12	2	164495 L
230	60	8.0	20	2	164496 C
650	50	8.0	12	2	176318 L
650	60	8.0	20	2	176319 L
650	70	8.0	30	2	176320 L
[mm]	[mm]	[mm]	[mm]	[pc.]	

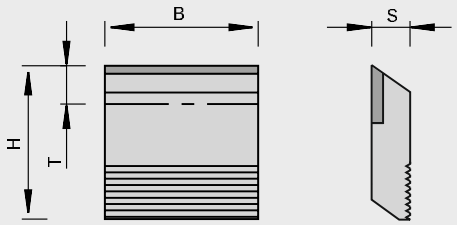
132511

Back-serrated HW blanks for profiling

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in profile cutterheads with serration

Design

- HW-tipped for hard and exotic woods
- tipping height 14 mm for blank height 50 mm, tipping height 20 mm for blank height 60 mm

Advantages

Notes

- T = profile depth
- from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other

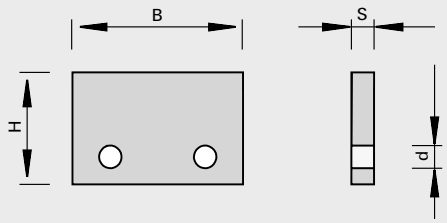
B	H	S	Tmax	PU	Ident-No.
40	50	10	13	2	165357 C
40	60	10	18	2	165365 L
60	50	10	13	2	165358 L
60	60	10	18	2	165366 L
80	50	10	13	2	165359 O
80	60	10	18	2	165367 L
100	50	10	13	2	165360 C
100	60	10	18	2	165368 L
130	50	10	13	2	165361 O
130	60	10	18	2	165369 C
150	50	10	13	2	165362 L
150	60	10	18	2	165370 C
180	50	10	13	2	165363 S
180	60	10	18	2	165371 O
230	50	10	13	2	165364 O
230	60	10	18	2	165372 O
[mm]	[mm]	[mm]	[mm]	[pc.]	

332521

Blanks HS and Deflector Blanks for profiling

Product

Drawing



High Speed Steel [HS]

Machine / Application
- for use in safety cutterheads

Design
- cutting material: HS for soft woods
- profile depth 15 mm max.

Advantages

Notes
- special steel deflector blanks

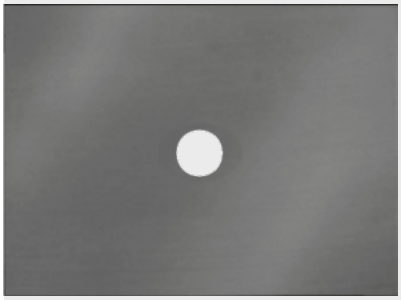
B	H	S	Ø d	Tmax	PU	Ident-No.
40	45	4.0	6,0	15	2	186686 L
50	45	4.0	6,0	15	2	186688 L
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

Deflectors for profiling	B	H	S	Ø d	T	Class-No.	PU	Ident-No.
deflector blanks	40	45	4.0	6,0	15	925400	2	186687 S
deflector blanks	50	45	4.0	6,0	15	925400	2	186689 S
	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

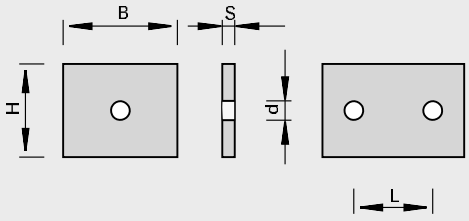
152555

Blanks HW - central bore

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application
- for use in profile cutterheads

Design
- width, height, and thickness precision ground
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

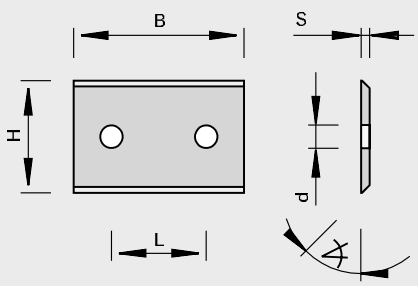
B	H	S	Ø d	L	PU	Ident-No.
24	22	2.0	4,2		10	168821 L
28	24	2.0	4,2		10	168822 S
32	24	2.0	4,2		10	168823 S
36	28	2.0	4,2		10	168824 L
40	26	2.0	4,2		10	168825 L
42	32	2.0	4,2	24	10	168826 L
52	34	2.0	4,2	24	10	168828 S
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

152555

Blanks HW - central bore, ground on both sides

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- for use in profile cutterheads

Design

- width, height, and thickness precision ground
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

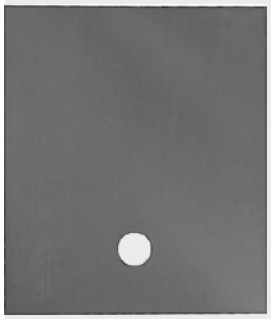
Notes

B	H	S	Ø d	L	Wedge◁	PU	Ident-No.
30	25	2.0	4,2	20	55	10	168871 S
40	30	2.0	4,2	20	55	10	168872 C
50	45	2.0	4,2	34	55	10	168873 S
60	25	2.0	4,2	26	55	10	168836 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	[pc.]	

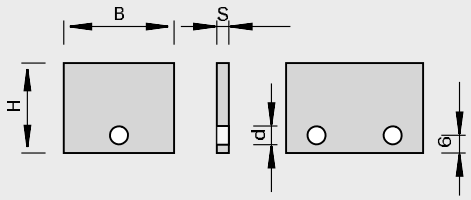
152545

Blanks HW - bore not central

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- for use in profile cutterheads

Design

- width, height, and thickness precision ground
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

B	H	S	Ø d	L	PU	Ident-No.
18	18.3	2.0	4,2		10	168829 L
20	25.3	2.0	4,2		10	168830 L
24	28.3	2.0	4,2		10	168831 S
32	22.3	2.0	4,2		10	168832 L
40	30.3	2.0	4,2		10	168833 S
50	32.3	2.0	4,2	24	10	168834 S
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

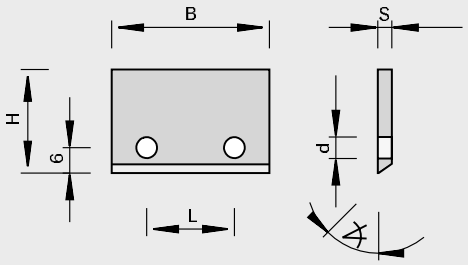
152545

Blanks HW - bore not central, ground seating surface

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in profile cutterheads

Design

- width, height, and thickness precision ground
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

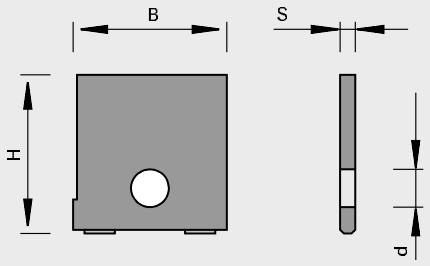
B	H	S	Ø d	L	Wedge◁	PU	Ident-No.
52	27.5	2.0	4,2	26	55	10	168839 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	[pc.]	

152586 / 152589

3P-Blanks HW (upright format)

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in LEUCO EcoPro and special cutterheads

Design

- two-point seating surface and point-stop
- optionally topline (polished face)
- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods
- HL Solid 60 for soft woods

Advantages

- precise positioning of the blanks for profiling and of the single-sided profile knife in the cutterhead
- topline design: highest cutting quality and significantly improved cutting edges

Notes

- profile knife can be profiled per customer specifications

B	H	S	Ø d	LEUCODUR	PU	Ident-No.
12,5	20.5	2.0	5,0	HL Board 06	10	178509 L
15,5	25.5	2.0	5,0	HL Board 06	10	178511 L
16,7	25.9	2.0	5,0	HL Board 06	10	178513 L
18,4	36.3	2.0	5,0	HL Board 06	10	178516 L
20,3	30.4	2.0	5,0	HL Board 06	10	178519 L
22,3	25.5	2.0	5,0	HL Board 06	10	178520 L
24,3	28.4	2.0	5,0	HL Board 06	10	178522 L
25,3	35.3	2.0	5,0	HL Board 06	10	178524 L
28,2	35.3	2.0	5,0	HL Board 06	10	178526 L
12,5	20.5	2.0	5,0	HL Solid 60	10	179509 L
15,5	25.5	2.0	5,0	HL Solid 60	10	179511 L
16,7	25.9	2.0	5,0	HL Solid 60	10	179513 L
18,4	36.3	2.0	5,0	HL Solid 60	10	179516 L
20,3	30.4	2.0	5,0	HL Solid 60	10	179519 L
24,3	28.4	2.0	5,0	HL Solid 60	10	179522 L
25,3	35.3	2.0	5,0	HL Solid 60	10	179524 L
28,2	35.3	2.0	5,0	HL Solid 60	10	179526 L
[mm]	[mm]	[mm]	[mm]		[pc.]	

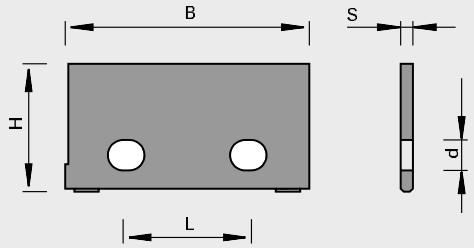
B	H	S	Ø d	LEUCODUR	PU	Ident-No. [L]	Ident-No. [R]
12,5	20.5	2.0	5,0	HL Board 06 topline	10	179547 S	179548 L
15,5	25.5	2.0	5,0	HL Board 06 topline	10	179551 O	179552 O
16,7	25.9	2.0	5,0	HL Board 06 topline	10	179555 O	179556 S
18,4	36.3	2.0	5,0	HL Board 06 topline	10	179561 O	179562 O
20,3	30.4	2.0	5,0	HL Board 06 topline	10	179567 O	179568 O
22,3	25.5	2.0	5,0	HL Board 06 topline	10	179569 O	179570 O
24,3	28.4	2.0	5,0	HL Board 06 topline	10	179573 O	179574 O
25,3	35.3	2.0	5,0	HL Board 06 topline	10	179577 O	179578 S
28,2	35.3	2.0	5,0	HL Board 06 topline	10	179581 O	179582 O
12,5	20.5	2.0	5,0	HL Solid 60 topline	10	179621 O	179622 O
15,5	25.5	2.0	5,0	HL Solid 60 topline	10	179625 O	179626 O
16,7	25.9	2.0	5,0	HL Solid 60 topline	10	179629 S	179630 O
18,4	36.3	2.0	5,0	HL Solid 60 topline	10	179635 O	179636 O
20,3	30.4	2.0	5,0	HL Solid 60 topline	10	179641 O	179642 S
22,3	25.5	2.0	5,0	HL Solid 60 topline	10	179643 O	179644 S
24,3	28.4	2.0	5,0	HL Solid 60 topline	10	179647 O	179648 O
25,3	35.3	2.0	5,0	HL Solid 60 topline	10	179651 O	179652 O
28,2	35.3	2.0	5,0	HL Solid 60 topline	10	179655 O	179656 O
[mm]	[mm]	[mm]	[mm]		[pc.]		

152586 / 152589

3P-Blanks HW (horizontal format)

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in LEUCO EcoPro and special cutterheads

Design

- two-point seating surface and point-stop
- optionally topline (polished face)
- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods
- HL Solid 60 for soft woods

Advantages

- precise positioning of the blanks for profiling and of the single-sided profile knife in the cutterhead
- topline design: highest cutting quality and significantly improved cutting edges

Notes

- profile knife can be profiled per customer specifications

B	H	S	Ø d	L	LEUCODUR	PU	Ident-No.
24	20.9	2.0	4,4	10-14	HL Board 06	10	185948 L
30,2	30.4	2.0	5,0	11,8-13,8	HL Board 06	10	178528 L
32,2	35.4	2.0	5,0	11,8-13,8	HL Board 06	10	178530 L
32,8	47.2	2.0	5,0	11,8-13,8	HL Board 06	10	178531 L
35,2	26	2.0	5,0	11,8-13,8	HL Board 06	10	178532 L
40,1	30.4	2.0	5,0	21,7-25,5	HL Board 06	10	178534 L
40,8	36	2.0	5,0	21,7-25,5	HL Board 06	10	178535 L
42,8	36	2.0	5,0	21,7-25,5	HL Board 06	10	178537 L
45,8	36	2.0	5,0	21,7-25,5	HL Board 06	10	178538 L
49,9	33	2.0	5,0	21,7-25,5	HL Board 06	10	178540 L
49,9	40.2	2.0	5,0	21,7-25,5	HL Board 06	10	178541 L
60,6	25.8	2.0	5,0	26 - 22	HL Board 06	10	178542 L
59,8	35.4	2.0	5,0	25,5+43,2	HL Board 06	10	178543 L
80,6	35.8	2.0	5,0	44	HL Board 06	10	178544 L
30,2	30.4	2.0	5,0	11,8-13,8	HL Solid 60	10	179528 L
32,2	35.4	2.0	5,0	11,8-13,8	HL Solid 60	10	179530 L
32,8	47.2	2.0	5,0	11,8-13,8	HL Solid 60	10	179531 L
35,2	26	2.0	5,0	11,8-13,8	HL Solid 60	10	179532 L
40,1	30.4	2.0	5,0	21,7-25,5	HL Solid 60	10	179534 L
40,8	36	2.0	5,0	21,7-25,5	HL Solid 60	10	179535 S
42,8	36	2.0	5,0	21,7-25,5	HL Solid 60	10	179537 L
45,8	36	2.0	5,0	21,7-25,5	HL Solid 60	20	179538 C
49,9	33	2.0	5,0	21,7-25,5	HL Solid 60	10	179540 L
49,2	40.2	2.0	5,0	21,7-25,5	HL Solid 60	20	179541 C
60,6	25.8	2.0	5,0	26 - 22	HL Solid 60	10	179542 S
59,8	35.4	2.0	5,0	25,5+43,2	HL Solid 60	10	179543 S
80,6	35.8	2.0	5,0	44	HL Solid 60	10	179544 S
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

B	H	S	Ø d	L	LEUCODUR	PU	Ident-No. [L]	Ident-No. [R]
30,2	30.4	2.0	5,0	11,8-13,8	HL Board 06 topline	10	179585 L	179586 O
32,2	35.4	2.0	5,0	11,8-13,8	HL Board 06 topline	10	179589 C	179590 C
32,8	47.2	2.0	5,0	11,8-13,8	HL Board 06 topline	10	179591 O	179592 O
35,2	26	2.0	5,0	11,8-13,8	HL Board 06 topline	10	179593 C	179594 O
40,1	30.4	2.0	5,0	21,7-25,5	HL Board 06 topline	10	179597 L	179598 O
40,8	36	2.0	5,0	21,7-25,5	HL Board 06 topline	10	179599 O	179600 O
42,8	36	2.0	5,0	21,7-25,5	HL Board 06 topline	10	179603 S	179604 S
45,8	36	2.0	5,0	21,7-25,5	HL Board 06 topline	10	184895 L	179606 L
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]		

B	H	S	Ø d	L	LEUCODUR	PU	Ident-No. [L]	Ident-No. [R]
49,9	33	2.0	5,0	21,7-25,5	HL Board 06 topline	10	179609 L	179610 O
49,9	40.2	2.0	5,0	21,7-25,5	HL Board 06 topline	10	179611 O	179612 O
60,6	25.8	2.0	5,0	22-26	HL Board 06 topline	10	179613 O	179614 O
59,8	35.4	2.0	5,0	25,5+43,2	HL Board 06 topline	10	179615 O	179616 O
80,6	35.8	2.0	5,0	44	HL Board 06 topline	10	179617 O	179618 S
30,2	30.4	2.0	5,0	11,8-13,8	HL Solid 60 topline	10	179659 O	179660 O
32,2	35.4	2.0	5,0	11,8-13,8	HL Solid 60 topline	10	179663 S	179664 O
32,8	47.2	2.0	5,0	11,8-13,8	HL Solid 60 topline	10	179665 O	179666 O
35,2	26	2.0	5,0	11,8-13,8	HL Solid 60 topline	10	179667 O	179668 S
40,1	30.4	2.0	5,0	21,7-25,5	HL Solid 60 topline	10	179671 S	179672 S
40,8	36	2.0	5,0	21,7-25,5	HL Solid 60 topline	10	179673 S	179674 O
42,8	36	2.0	5,0	21,7-25,5	HL Solid 60 topline	10	179677 S	179678 S
45,8	36	2.0	5,0	21,7-25,5	HL Solid 60 topline	10	179679 S	179680 S
49,9	33	2.0	5,0	21,7-25,5	HL Solid 60 topline	10	179683 L	179684 L
49,9	40.2	2.0	5,0	21,7-25,5	HL Solid 60 topline	10	179685 O	179686 C
60,6	25.8	2.0	5,0	22-26	HL Solid 60 topline	10	179687 S	179688 S
59,8	35.4	2.0	5,0	25,5+43,2	HL Solid 60 topline	10	179689 O	179690 O
80,6	35.8	2.0	5,0	44	HL Solid 60 topline	10	179691 S	179692 S
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]		

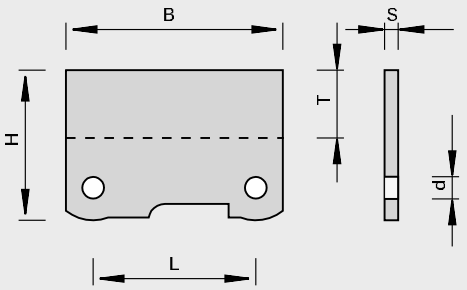
152526 / 152529

SuperProfiler Blanks HW

Product



Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in LEUCO SuperProfiler cutterheads

Design

- thickness ground
- optionally topline (polished face)
- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods
- HL Solid 60 for soft woods

Advantages

- topline design: highest cutting quality and significantly improved cutting edges

Notes

- for concave and convex profiles
- T = maximum profile depth

B	H	S	Ø d	L	Tmax	LEUCODUR	PU	Ident-No.
30,6	25.5	1.5	4,0	16-20	13	HL Board 06	10	179114 L
30,6	25.5	1.5	4,0	16-20	13	HL Solid 60	10	177369 L
40,6	28.2	1.5	4,0	28	13	HL Board 06	10	179112 L
40,6	28.2	1.5	4,0	28	13	HL Solid 60	10	177367 L
40,6	40.6	2.0	5,0	28	20	HL Board 06	10	179115 L
40,6	40.6	2.0	5,0	28	20	HL Solid 60	10	178844 L
49,3	33.7	1.5	4,0	35	16	HL Board 06	10	180199 L
60,8	30.2	1.5	4,0	48	15	HL Board 06	10	179113 L
60,8	30.2	1.5	4,0	48	15	HL Solid 60	10	177368 L
60,6	45.6	2.0	5,0	45	25	HL Board 06	10	179999 L
60,6	45.6	2.0	5,0	45	25	HL Solid 60	10	178845 L
80,6	45.6	2.0	6,0	65	25	HL Board 06	10	180016 L
80,6	45.6	2.0	6,0	65	25	HL Solid 60	10	180017 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

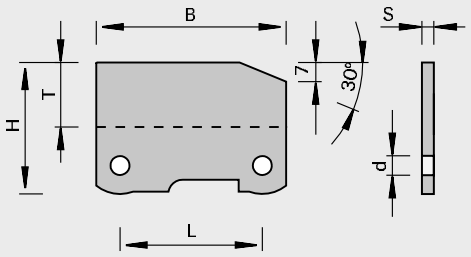
B	H	S	Ø d	L	Tmax	LEUCODUR	PU	Ident-No. [L]	Ident-No. [R]
30,6	25.5	1.5	4,0	16-20	13	HL Board 06 topline	10	178701 C	178702 L
30,6	25.5	1.5	4,0	16-20	13	HL Solid 60 topline	10	177789 S	177790 L
40,6	28.2	1.5	4,0	28	13	HL Board 06 topline	10	178627 L	178626 L
40,6	28.2	1.5	4,0	28	13	HL Solid 60 topline	10	177791 S	177808 L
40,6	40.6	2.0	5,0	28	20	HL Board 06 topline	10	180030 S	180031 S
40,6	40.6	2.0	5,0	28	20	HL Solid 60 topline	10	180032 O	180033 S
49,3	33.7	1.5	4,0	35	16	HL Board 06 topline	10	180208 S	180209 L
60,8	30.2	1.5	4,0	48	15	HL Board 06 topline	10	178643 L	178628 L
60,8	30.2	1.5	4,0	48	15	HL Solid 60 topline	10	177809 S	177810 S
60,6	45.6	2.0	5,0	45	25	HL Board 06 topline	10	180034 S	180035 L
60,6	45.6	2.0	5,0	45	25	HL Solid 60 topline	10	180040 O	180041 S
80,6	45.6	2.0	6,0	65	25	HL Board 06 topline	10	180042 S	180043 S
80,6	45.6	2.0	6,0	65	25	HL Solid 60 topline	10	180044 L	180045 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]		

152526 / 152726

SuperProfiler Blanks HW - B=50 mm

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in LEUCO SuperProfiler cutterheads

Design

- optionally topline (polished face)
- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods

Advantages

- topline design: highest cutting quality and significantly improved cutting edges

Notes

- T = maximum profile depth

B	H	S	Ø d	L	Tmax	LEUCODUR	PU	Ident-No.
49,4	44.5	2.0	5,0	35	22	HL Board 06	10	180218 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

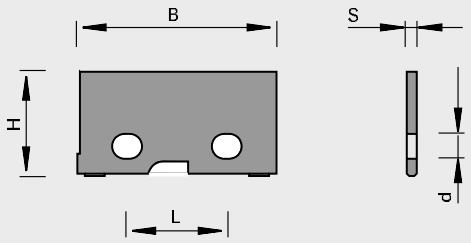
B	H	S	Ø d	L	Tmax	LEUCODUR	PU	Ident-No. [L]	Ident-No. [R]
49,4	44.5	2.0	5,0	35	22	HL Board 06 topline	10	180219 C	180220 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]		

152536

PolyProfiler- / EcoPro-Blanks HW - B=40 mm

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in LEUCO PolyProfiler and EcoPro cutterheads

Design

- two-point seating surface and center stop for axial positioning
- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods

Advantages

- precise positioning of the blanks for profiling and of the single-sided profile knife in the cutterhead

Notes

- profile knife can be profiled per customer specifications

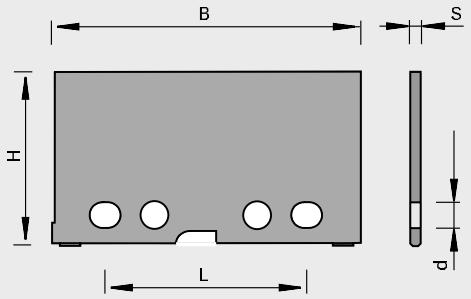
B	H	S	Ø d	L	PU	Ident-No.
41 [mm]	32.5 [mm]	2.0 [mm]	5,0 [mm]	21,7-25,5 [mm]	10 [pc.]	180197 L

152536 / 152736

PolyProfiler- / EcoPro-Blanks HW - B=60 mm

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in LEUCO PolyProfiler and EcoPro cutterheads

Design

- two-point seating surface and center stop for axial positioning
- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods

Advantages

- precise positioning of the blanks for profiling and of the single-sided profile knife in the cutterhead

Notes

- profile knife can be profiled per customer specifications

B	H	S	Ø d	L	PU	Ident-No.
61 [mm]	34 [mm]	2.0 [mm]	5,0 [mm]	41,7-45,5 [mm]	10 [pc.]	180198 L

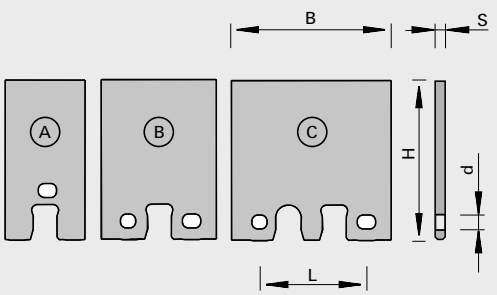
B	H	S	Ø d	L	Tmax	LEUCODUR	PU	Ident-No. [L]	Ident-No. [R]
61 [mm]	34 [mm]	2.0 [mm]	5,0 [mm]	41,7-45,5 [mm]	13 [mm]	HL Board 06 topline	10 [pc.]	181259 S	181258 S

152516

UltraProfiler Blanks HW

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for use in LEUCO UltraProfiler cutterheads

Design

- two-point seating and automatic positioning (axial and radial)
- optionally topline (polished face)
- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods

Advantages

- precise and automatic positioning of the blanks for profiling and when changing the knives
- no stop screw necessary
- topline design: highest cutting quality and significantly improved cutting edges

Notes

- profile knife can be profiled per customer specifications

B	H	S	Ø d	L	Type	LEUCODUR	PU	Ident-No.
15	30.4	2.0	3,5		A	HL Board 06	10	183056 L
20	40.4	2.0	3,5		A	HL Board 06	10	183057 L
25	40.4	2.0	3,5		A	HL Board 06	10	183058 L
32	40.4	2.0	3,5	15,8	B	HL Board 06	10	182419 L
40	40.4	2.0	3,5	26,8	C	HL Board 06	10	182420 L
50	40.4	2.0	3,5	32,8	C	HL Board 06	10	182421 L
60	40.4	2.0	3,5	36,8	C	HL Board 06	10	182422 L
[mm]	[mm]	[mm]	[mm]	[mm]			[pc.]	

B	H	S	Ø d	L	Type	LEUCODUR	PU	Ident-No. [L]	Ident-No. [R]
15	30.4	2.0	3,5		A	HL Board 06 topline	10	183680 S	183680 S
20	40.4	2.0	3,5		A	HL Board 06 topline	10	183681 S	183681 S
25	40.4	2.0	3,5		A	HL Board 06 topline	10	183682 S	183682 S
32	40.4	2.0	3,5	15,8	B	HL Board 06 topline	10	182563 C	182562 C
40	40.4	2.0	3,5	26,8	C	HL Board 06 topline	10	182565 S	182564 S
60	40.4	2.0	3,5	36,8	C	HL Board 06 topline	10	182569 S	182568 S
[mm]	[mm]	[mm]	[mm]	[mm]			[pc.]		


LEUCO



Clamping Systems

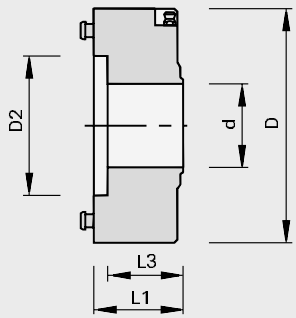
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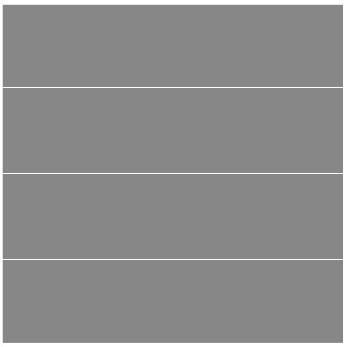
933011

Clamping Systems Ø 110 mm

Product

Drawing





Machine / Application

- double end tenoners
- through feed machines
- for mounting of tools with bore and for combination with mounting flanges Ø 110 mm

Design

- hardened tool mounting area
- n max = 9,000 min-1

Advantages

- excellent balance quality
- long tool life
- consistent runout accuracy after each tool change
- minimization of setup-times thanks to easy and quick tool change
- maintenance-free and protected from dust

Notes

- for clockwise and counter-clockwise rotation
- indicate machine type and shaft design when placing an order
- required tool adapters Class-No. 997370
- for changing the tools the pneumatic part Ident-No. 058250 is necessary
- operational pressure 6 bar
- included in delivery: clamping part incl. cap for attachment on the machine spindle

Ø D	Ø D2	Ø d	L1	L3	DKN		Ident-No.
110	50	30	63	47.5	8x3		172399 O
110	50	30	63	47.5	8x3	Homag, Lehbrink, Torwegge, SPA, Wilms-meyer	160836 L
110	50	35	63	47.5	10x4	Spanevello	162599 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Head Cap Screws	M12x30 DIN EN ISO 4762	172399	995111	10	001917 L
Lid		172399	997370	1	172397 L
Lid		160836	997370	1	181802 L
Spacers	55x23,5x30	172399	955520	1	172398 L
Pneumatic hose		For all	994200	1	058250 L
	[mm]			[pc.]	

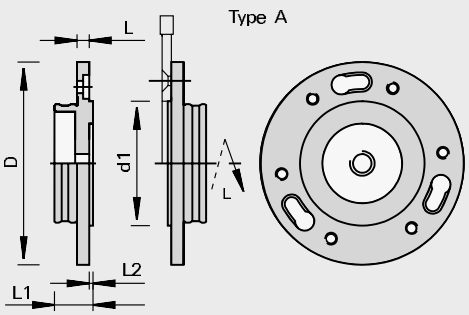
997370

Mounting Flanges for Clamping System Ø 110 mm - saw blades d=65 mm

Product



Drawing



Machine / Application

- for the mounting of saw blades up to Ø 250 mm with bore Ø 65 mm, 6 countersunk holes TK 90 mm for screw M 5

Design

Advantages

Notes

- for clockwise and counter-clockwise rotation
- especially suited for the mounting of scoring saw blades
- at least two separate tool/ flange assemblies should be used per clamping element (reduced downtimes)
- for DP circular saw blades the cylindrical head screw Ident-No. 001869 is necessary (to be ordered separately)

Ø D	Ø d1	L2	L	L1	Ident-No. [L]	Ident-No. [R]
110	65	2,5	10	27	164770 L	164758 L
[mm]	[mm]	[mm]	[mm]	[mm]		

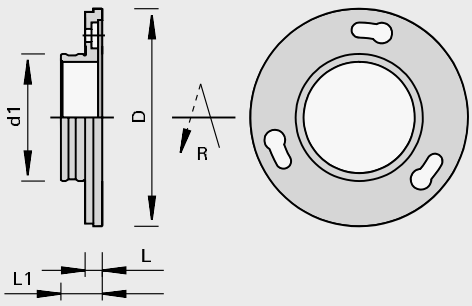
Spare parts	Dimension		Class-No.	PU	Ident-No.
Countersunk Screws	M5x12-5.8 DIN 87	for mounting of saw blade	995122	10	180007 L
Head Cap Screws	M5x12-8.8 DIN EN ISO 4762	for mounting of DP saw blades	995111	10	001869 L
	[mm]			[pc.]	

997370

Mounting Flanges for Clamping System Ø 110 mm - saw blades d=50 mm

Product

Drawing



Machine / Application

- for the mounting of saw blades up to Ø 250 mm and saw plate thickness 1.8 - 2.2 mm with bore Ø 50 mm, 3 NL - Ø 22 mm, TK Ø 80 mm

Design

Advantages

Notes

- for clockwise and counter-clockwise rotation
- especially suited for the mounting of scoring saw blades

Ø D	Ø d1	L	L1	Ident-No.
107	50	10	26.5	160849 L
[mm]	[mm]	[mm]	[mm]	

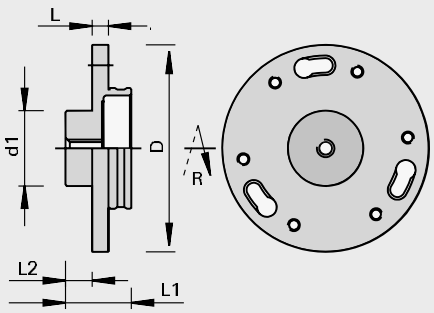
997370

Mounting Flanges for Clamping System Ø 110 mm - tools with bore d=30 mm

Product



Drawing



Machine / Application

- for mounting of light tools with bore Ø 30 mm, 6 countersunk holes for M 5, TK Ø 90 mm

Design

Advantages

Notes

- for clockwise and counter-clockwise rotation
- at least two separate tool/ flange assemblies should be used per clamping element (reduced downtimes)

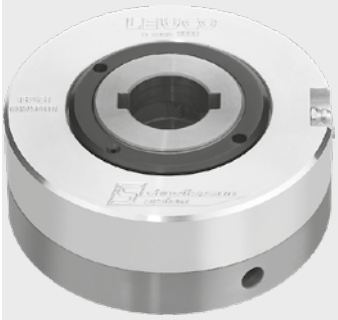
Ø D	Ø d1	L2	L	L1	Ident-No. [L]	Ident-No. [R]
110	30	15,5	10	40	163705 L	163226 L
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x12-5.8 DIN 87	995122	10	180007 L
Head Cap Screws	M5x12-8.8 DIN EN ISO 4762	995111	10	001869 L
	[mm]		[pc.]	

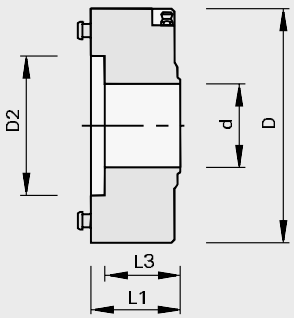
933011

Clamping Systems Ø 140 mm

Product



Drawing



Machine / Application

- double end tenoners
- through feed machines
- for mounting of tools with bore and for combination with mounting flanges Ø 140 mm

Design

- n max = 9,000 min-1

Advantages

- excellent balance quality
- long tool life thanks to hardened tool mounting area
- consistent runout accuracy after each tool change
- minimization of setup-times thanks to easy and quick tool change
- maintenance-free and protected from dust

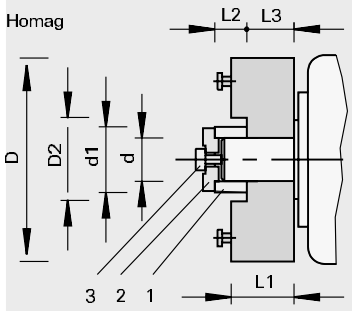
Notes

- for clockwise and counter-clockwise rotation
- mounting examples (see drawings): shaft with internal thread, shaft with external thread
- indicate machine type and shaft design when placing an order
- required tool adapters Class-No. 997370
- for changing the tools the pneumatic part Ident-No. 058250 is necessary
- operational pressure 6 bar
- included in delivery: clamping part incl. cap for attachment on the machine spindle (spare parts for Homag and IMA not included in delivery)

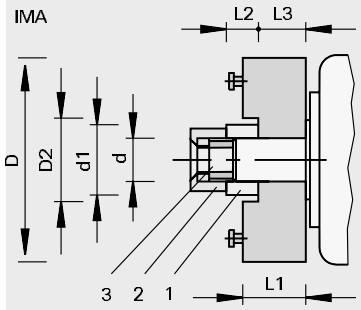
Ø D	Ø D2	Ø d	L1	L3	DKN		Ident-No.
140	80	35	57	41.5	10x4	Homag, IMA	167451 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Ø D	Ø D1	Ø d	Class-No.	PU	Ident-No.
Lid	45	35	22	997370	1	180082 L
Special Nuts	58		M30x1,5	995290	1	170364 S
	[mm]	[mm]	[mm]		[pc.]	

Homag



Spare parts	Dimension	Ø D	Ø d1	Ø D	Class-No.	PU	Ident-No.
1 centering adapter				35	997370	1	180540 L
2 caps		45	35	22	997370	1	180082 L
3 cylindrical head screws for Ød=35	M16x55R				995111	1	185693 L
3 cylindrical head screws for Ød=35	M20x35L				995111	1	185694 L
	[mm]	[mm]	[mm]	[mm]		[pc.]	



Spare parts	Ø D	Ø d	Dimension	Class-No.	PU	Ident-No.
1 centering adapter		35		997370	1	180540 L
2 special nuts			M35x1,5	995290	1	IMA3 S
3 countersunk flat headed screws				995121	10	IMA4 S
4 spacers	70	35	Ø70x25xØ35	955520	1	170363 C
	[mm]	[mm]	[mm]		[pc.]	

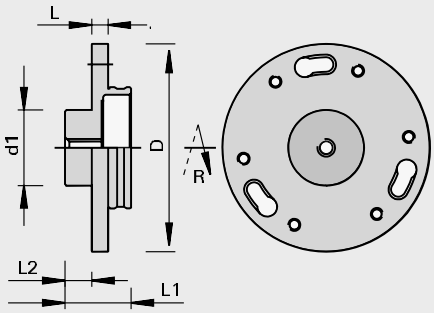
997370

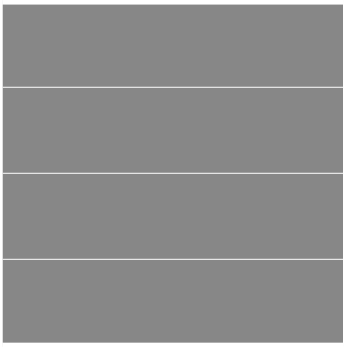
Mounting Flanges for Clamping System Ø 140 mm - tools with bore d=30 mm

Product



Drawing





Machine / Application

- for mounting of medium-weight tools with bore Ø 30 mm, 6 countersunk holes for M 8, TK Ø 110 mm

Design

Advantages

Notes

- for clockwise and counter-clockwise rotation
- for s-System on shaft with internal thread
- indicate shaft design when placing an order
- at least two separate tool/flange assemblies should be used per clamping element (reduced downtimes)

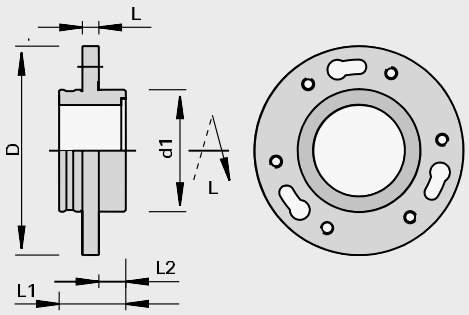
Ø D	Ø d1	L2	L	L1	Ident-No. [L]	Ident-No. [R]
137	30	17,4	10.8	43.4	163946 L	163945 L
[mm]	[mm]	[mm]	[mm]	[mm]		

997370

Mounting Flanges for Clamping System Ø 140 mm - tools with bore d=80 mm

Product

Drawing



Machine / Application

- for mounting of medium-weight tools with bore Ø 80 mm, 6 countersunk holes for M 8, TK Ø 110 mm

Design

Advantages

Notes

- for clockwise and counter-clockwise rotation
- for s-System on shafts with external thread
- indicate shaft design when placing an order
- at least two separate tool/flange assemblies should be used per clamping element (reduced downtimes)

Ø D	Ø d1	L2	L	L1	Ident-No. [L]	Ident-No. [R]
137	80	17,5	11.8	44.7	168401 C	168400 L
[mm]	[mm]	[mm]	[mm]	[mm]		

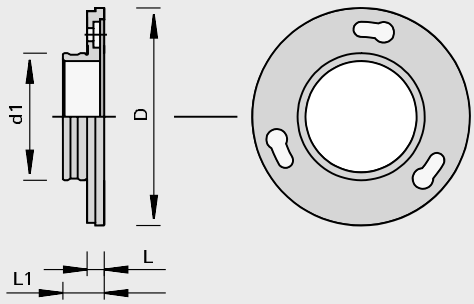
997370

Mounting Flanges for Clamping System Ø 140 mm - saw blades d=80 mm

Product



Drawing



Machine / Application

- for the mounting of saw blades up to Ø 400 mm and saw plate thickness 1.8 - 2.2 mm with bore Ø 80 mm, 3 NL - Ø 22 mm, TK Ø 110 mm

Design

Advantages

Notes

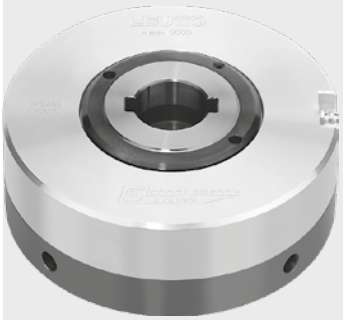
- for clockwise and counter-clockwise rotation

Ø D	Ø d1	L	L1	Ident-No.
137	80	10	28	177050 C
[mm]	[mm]	[mm]	[mm]	

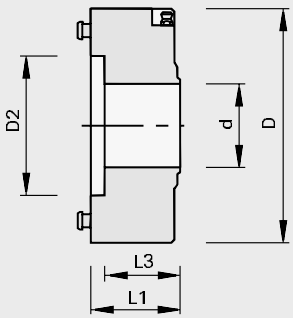
933011

Clamping Systems Ø 160 mm

Product



Drawing



Machine / Application

- double end tenoners
- through feed machines
- for mounting of tools with bore

Design

- n max = 9,000 min-1

Advantages

- excellent balance quality
- long tool life thanks to hardened tool mounting area
- consistent runout accuracy after each tool change
- minimization of setup-times thanks to easy and quick tool change
- maintenance-free and protected from dust

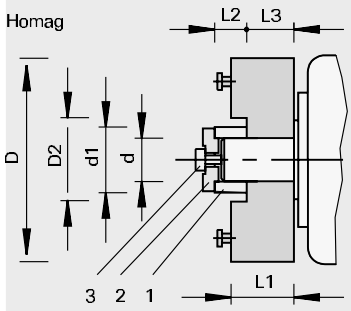
Notes

- for clockwise and counter-clockwise rotation
- mounting examples (see drawing): shaft with internal thread, shaft with external thread
- indicate machine type and shaft design when placing an order
- required tool adapters Class-No. 997370
- for changing the tools the pneumatic part Ident-No. 058250 is necessary
- operational pressure 6 bar
- included in delivery: clamping part incl. cap for attachment on the machine spindle (spare parts for Homag and IMA not included in delivery)

Ø D	Ø D2	Ø d	L1	L3	DKN		Ident-No.
160	80	35	60	44.5	10x4	Homag, IMA	167462 L
160	80	40	60	44.5	12x4		167463 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

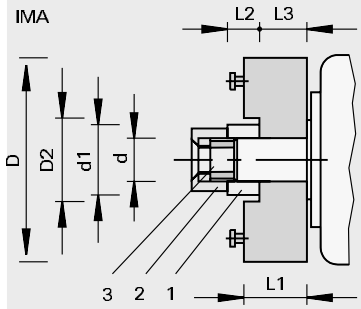
Spare parts	Ø D	Ø D1	Ø d	Class-No.	PU	Ident-No.
Lid	40	30	17	997370	1	181802 L
Lid	45	35	22	997370	1	180082 L
Lid	48	40	22	997370	1	180121 L
Special Nuts	58		M30x1,5	995290	1	170364 S
	[mm]	[mm]	[mm]			

Homag



Spare parts	Dimension	Ø D	Ø D1	Ø d	Class-No.	PU	Ident-No.
1 centering adapter				30	997370	1	168457 S
2 caps		40	30	17	997370	1	181802 L
1 centering adapter				35	997370	1	180540 L
2 caps		45	35	22	997370	1	180082 L
	[mm]	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Ø D	Ø D1	Ø d	Class-No.	PU	Ident-No.
3 cylindrical head screws for Ød=35	M16x55R				995111	1	185693 L
3 cylindrical head screws for Ød=35	M20x35L				995111	1	185694 L
4 spacers		60		35	955520	1	180647 L
	[mm]	[mm]	[mm]	[mm]		[pc.]	

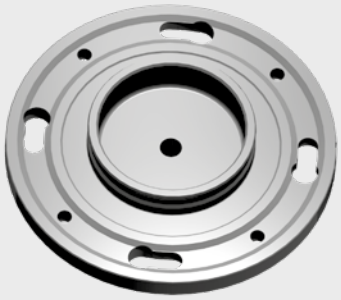


Spare parts	Ø D	Ø d	Dimension	Class-No.	PU	Ident-No.
1 centering adapter		35		997370	1	180540 L
2 special nuts			M35x1,5	995290	1	IMA3 S
3 countersunk flat headed screws				995121	10	IMA4 S
4 spacers	70	35	Ø70x25xØ35	955520	1	170363 C
	[mm]	[mm]	[mm]		[pc.]	

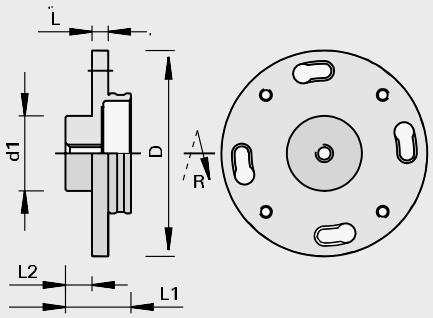
997370

Mounting Flanges for Clamping System Ø 160 mm - tools with bore d=30 mm

Product



Drawing



Machine / Application

- for mounting of heavy tools with bore Ø 30 mm with 4 countersunk holes M 8, TK Ø 130 mm

Design

Advantages

Notes

- for s-System on shaft with external thread
- for clockwise and counter-clockwise rotation
- indicate shaft design when placing an order
- at least two separate tool/ flange assemblies should be used per clamping element (reduced downtimes)
- sense of rotation see drawing

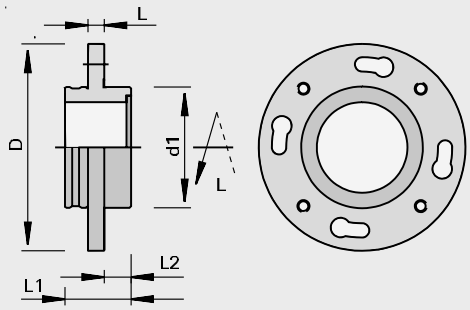
Ø D	Ø d1	L2	L	L1	Ident-No. [L]	Ident-No. [R]
157	30	17,4	10.8	43.4	167465 L	167464 L
[mm]	[mm]	[mm]	[mm]	[mm]		

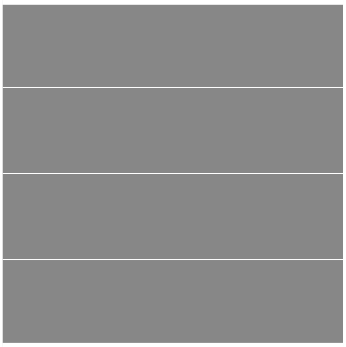
997370

Mounting Flanges for Clamping System Ø 160 mm - tools with bore d=80 mm

Product

Drawing





Machine / Application

- for mounting of heavy tools with bore Ø 80 mm with 4 countersunk holes M 8, TK Ø 130 mm

Design

Advantages

Notes

- for s-System on shaft with external thread
- for clockwise and counter-clockwise rotation
- indicate shaft design when placing an order
- at least two separate tool/ flange assemblies should be used per clamping element (reduced downtimes)
- sense of rotation see drawing

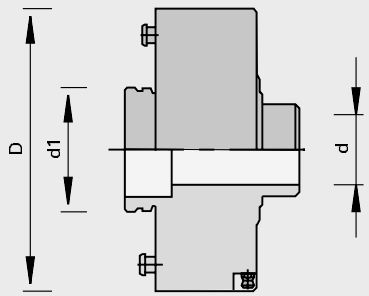
Ø D	Ø d1	L2	L	L1	Ident-No. [L]	Ident-No. [R]
157	80	18	11.8	45	168399 L	168398 L
[mm]	[mm]	[mm]	[mm]	[mm]		

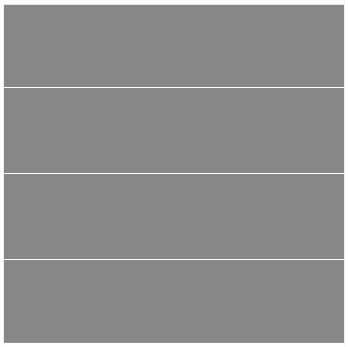
933011

Clamping Systems Ø 192 mm

Product

Drawing





Machine / Application

- double end tenoners
- through feed machines
- for mounting of hoggers with Ø 250 mm

Design

- n max = 7,200 min-1

Advantages

- excellent balance quality
- long tool life thanks to hardened tool mounting area
- consistent runout accuracy after each tool change
- minimization of setup-times thanks to easy and quick tool change
- maintenance-free and protected from dust

Notes

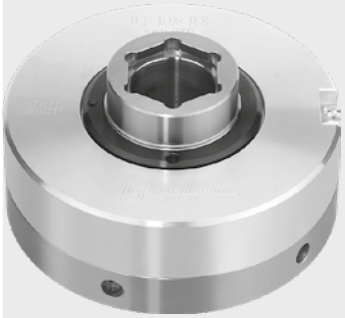
- for clockwise and counter-clockwise rotation
- mounting example (see drawing)
- indicate machine type and shaft design when placing an order
- for changing the tools the pneumatic part Ident-No. 058250 is necessary
- operational pressure 6 bar
- included in delivery: see table

Ø D	Ø d	Ø d1	DKN			Ident-No.
192	35	80	10x4	clamping part, spacer ring	IMA, B+G, Hüllhorst	161363 O
192	35	80	10x4	clamping part, spacer ring, cover disk	Danckaert	161367 O
192	35	80	10x4	clamping part	Homag, Lehbrink, Torwegge, SPA, Wilms-meyer	161259 L
[mm]	[mm]	[mm]	[mm]			

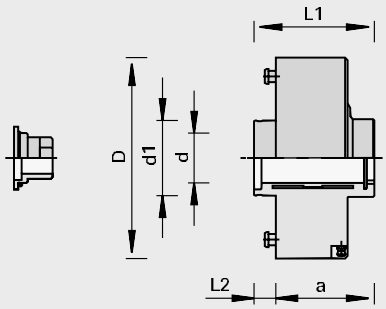
933011

Hydro Clamping System Ø 160 mm - hoggers

Product



Drawing



Machine / Application

- for mounting of tools with bore

Design

- hardened tool mounting area
- n max = 9,000 min-1
- closed hydraulic expansion clamping chuck with one clamping zone for tight-tolerance fit on the motor shaft

Advantages

- high cutting quality thanks to distinctly increased runout accuracy and concentricity
- consistent runout accuracy after each tool change
- minimization of setup-times thanks to easy and quick tool change
- maintenance-free

Notes

- for clockwise and counter-clockwise rotation
- specifically designed for high-precision motors with hexagonal spindle base
- for changing the tools the pneumatic part Ident-No. 058250 is necessary
- operational pressure 6 bar
- included in delivery: hydro quick-clamping system incl. Screwdrivers

Ø D	Ø d	Ø d1	L2	L1	a		Ident-No.
160	40	60	17,5	96	78.5	Hoggers	172677 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Class-No.	PU	Ident-No.
Lids with O-Rings	997300	1	172679 L
Head Cap Screws	995111	1	184251 L
Pneumatic hose	994200	1	058250 L
Screwdrivers	985730	1	167817 L
Cranked Wrench Keys	985730	1	177106 C
		[pc.]	

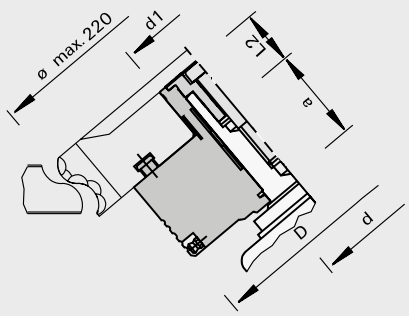
933011

Hydro Clamping System Ø 160 mm - cutters

Product



Drawing



Machine / Application

- for mounting of tools with bore

Design

- hardened tool mounting area
- n max = 9,000 min-1
- closed hydraulic system with two clamping zones
- clamping zone 1: for tight-tolerance fit on the motor shaft (runout)
- clamping zone 2: for tight-tolerance fit of milling tools on the clamping element (concentricity)

Advantages

- high cutting quality thanks to distinctly increased runout accuracy and concentricity
- consistent runout accuracy after each tool change
- minimization of setup-times thanks to easy and quick tool change
- maintenance-free

Notes

- for clockwise and counter-clockwise rotation
- specifically designed for high-precision motors with hexagonal spindle base
- for changing the tools the pneumatic part Ident-No. 058250 is necessary
- operational pressure 6 bar
- included in delivery: hydro quick-clamping system incl. Screwdrivers

Ø D	Ø d	Ø d1	L2	a		Ident-No.
160	40	60	35	53	milling tools	176829 L
[mm]	[mm]	[mm]	[mm]	[mm]		

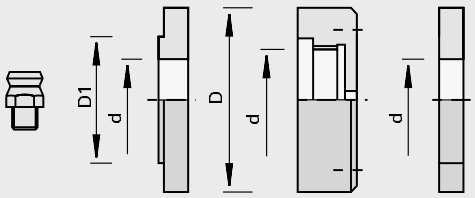
Spare parts	Class-No.	PU	Ident-No.
Lids with O-Rings	997300	1	172679 L
Head Cap Screws	995111	1	184251 L
Pneumatic hose	994200	1	058250 L
Screwdrivers	985730	1	167817 L
Cranked Wrench Keys	985730	1	177106 C
		[pc.]	

Accessories for Quick-Clamping Systems

Product



Drawing



Machine / Application

- for engaging or releasing the LEUCO quick-clamping systems

Design

Advantages

Notes

- anti-twist bolt Ident-No. 160875 for mounting
- ring Ident-No. 170363 is required for L = 68 mm if no centering adapter is used
- nut Ident-No. 170364 is required for IMA machines with short shaft
- the pneumatic hose is required to change the tools; must be ordered separately before first delivery of clamping systems

	Class-No.	Ident-No.
hydraulic connector M10x1 (new design)	994400	180084 L
fitting	997800	161289 L
pneumatic hose complete	994200	058250 L

Spare parts	For s-Sytem Ø D/d	Ø D	Ø D1	Ø d	Class-No.	PU	Ident-No.
Lid	110/140/160/30	40	30	17	997370	1	181802 L
Lid	140/160/35	45	35	22	997370	1	180082 L
Lid	140/160/40	48	40	22	997370	1	180121 L
Special Nuts	140/160/35	58		M30x1,5	995290	1	170364 S
Spacers	140/160/35	70		35	955520	1	170363 C
Bolts	110/140/160			10x120	995322	10	160875 L
		[mm]	[mm]	[mm]		[pc.]	

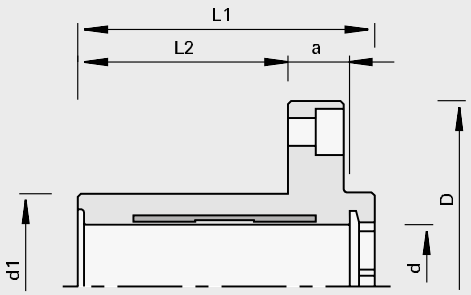
933030

Hydro Clamping Bushings with hexagonal adapter bottom- tools with bore

Product



Drawing



Machine / Application
- for mounting of tools with bore

Design
- hardened tool mounting area
- with one clamping zone
- closed hydraulic expansion clamping chuck for tight-tolerance fit on the motor shaft
- n max = 9,000 min-1

Advantages
- optimum cutting quality when milling and hogging
- maintenance-free and inured to dirt

Notes
- for clockwise and counter-clockwise rotation
- specifically designed for high-precision motors with hexagonal spindle base
- included in delivery: hydro clamping bushing without screwdrivers

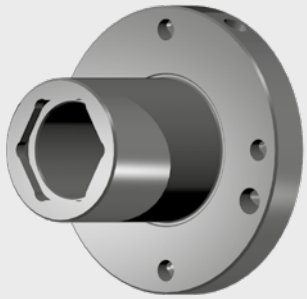
Ø D	Ø d	Ø d1	L2	L1	a	NL	Ident-No.
120	40	60	68	96	20	4/M8/100	172678 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts		Class-No.	PU	Ident-No.
Lids with O-Rings	for axial locking or bores 40 mm	997300	1	172679 L
Head Cap Screws	M14x60 DIN 6912 for 172679	995111	1	184251 L
Screwdrivers	SW6 for hydro pressure build-up	985730	1	167817 L
Cranked Wrench Keys	SW12 DIN 6911	985730	1	177106 C
Spacers	119,5x51x60 NL	955520	1	179471 L
			[pc.]	

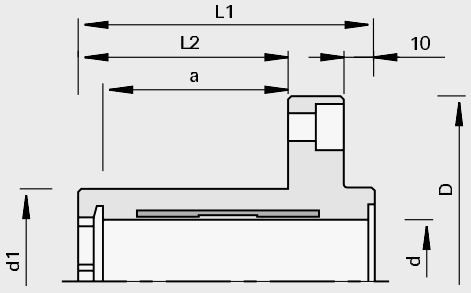
933030

Hydro Clamping Bushings with hexagonal adapter top- tools with bore

Product



Drawing



Machine / Application
- for mounting of tools with bore and for combination with Postforming radius panel raising cutters und LEUCODIA CompactTec hoggers

Design
- hardened tool mounting area
- with one clamping zone
- closed hydraulic expansion clamping chuck for tight-tolerance fit on the motor shaft
- n max = 9,000 min-1

Advantages
- excellent cutting quality when milling and hogging
- maintenance-free

Notes
- for clockwise and counter-clockwise rotation
- specifically designed for high-precision motors with hexagonal spindle base
- included in delivery: Hydro Clamping Bushing incl. screwdriver SW 6

Ø D	Ø d	Ø d1	L2	L1	a	NL	Ident-No.
120	40	60	68	96	60	4/M8/100	173724 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts		Class-No.	PU	Ident-No.
Lids with O-Rings	for axial locking or bores 40 mm	997300	1	172679 L
Head Cap Screws	M14x60 DIN 6912 for 172679	995111	1	184251 L
Screwdrivers	SW6 for hydro pressure build-up	985730	1	167817 L
Cranked Wrench Keys	SW12 DIN 6911	985730	1	177106 C
Spacers	119,5x51x60 NL	955520	1	179471 L
			[pc.]	

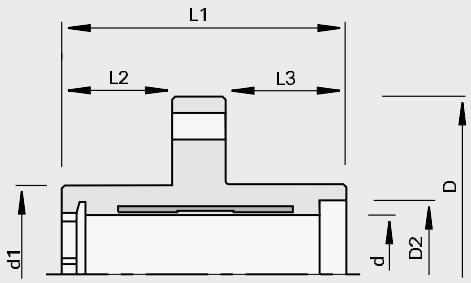
933030

Hydro Clamping Bushings - tools with bore progressively adjustable

Product



Drawing



Machine / Application

- for mounting of milling tools with progressive adjustment of the cutting width

Design

- hardened tool mounting area
- with one clamping zone
- closed hydraulic expansion clamping chuck for tight-tolerance fit on the motor shaft
- n max = 9,000 min-1

Advantages

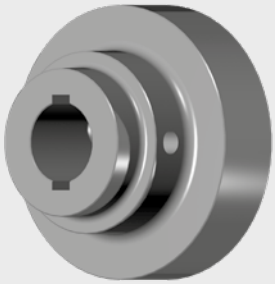
- excellent cutting quality when milling
- maintenance-free
- for clockwise and counter-clockwise rotation
- specifically designed for high-precision motors with hexagonal spindle base

Ø D	Ø D2	Ø d	Ø d1	L2	L1	L3	NL	Ident-No.
120	50	40	60	39	101	44	4/M8/100	180181 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

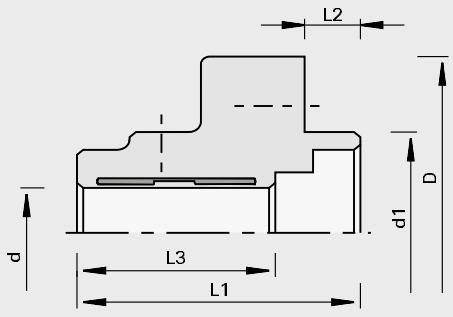
933030

Hydro Clamping Bushings - hoggers

Product



Drawing



Machine / Application

- for mounting of tools with bore with LEUCO hoggers Ø 200 mm and Ø 250 mm

Design

- hardened tool mounting area
- with one clamping zone
- closed hydraulic expansion clamping chuck for tight-tolerance fit on the motor shaft
- n max = 9,000 min-1

Advantages

Notes

- for clockwise and counter-clockwise rotation
- fits conventional motors with shaft 35 mm and keyway

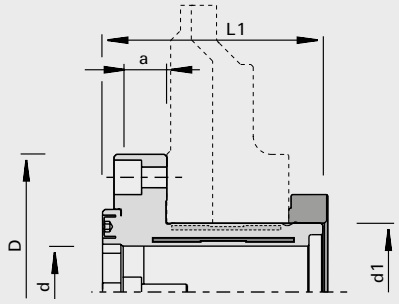
Ø D	Ø d	Ø d1	L2	L1	L3	DKN	NL	Ident-No.
120	35	80	17,7	90	63	10x4	4/M8/100	170264 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

933030

Adjustment unit - ecoline - flooring

Product

Drawing



Machine / Application
- through-feed machines
- double end tenoners
- for profiling of the longitudinal and transverse profiles in machining of flooring (laminate, parquet and LVT)

Design
- unit for adjustable 2-piece profile tool
- single (184765) and double (184770) pressure zone
- impressurement hydro bushing radial

Advantages
- system independent from tools, reusable
- adjustable from top via adjustment nut

Notes
- starter model
- version without tool
- included in delivery: bushing, nut, spring assembly

Ø D	Ø d	Ø d1	a	L1		Ident-No.
120	40	60	20	98	with one clamping zone	184765 L
120	40	60	20	98	with two pressure zones	184770 L
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Hydro Clamping Bushings	Ø120x96xØ60/40	184765	933030	1	184766 L
Hydro Clamping Bushings	Ø120x96xØ60/40	184770	933030	1	184771 L
Adjustment Nuts	M60x0,5x20,5	For all	997300	1	184767 L
	[mm]			[pc.]	

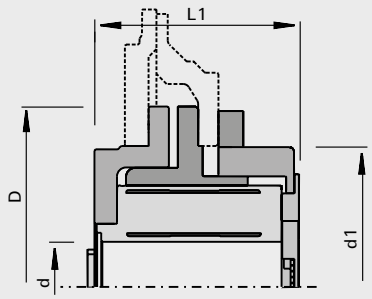
933030

Adjustment unit - topline - flooring

Product



Drawing



Machine / Application
- through-feed machines
- double end tenoners
- for profiling of the longitudinal and transverse profiles in machining of flooring (laminate, parquet and LVT)

Design
- unit for adjustable 2-part profiling tools
- double clamping zone
- pressurization through axial hydrobushing

Advantages
- tool-independent system, reusable
- adjustment from the top via nut
- concentricity tolerance / run-out tolerance 0.03 mm

Notes
- topline model
- version without tool
- included in delivery: bushing, flanges

Ø D	Ø d	Ø d1	L1		Ident-No.
160	40	125	93.7		186416 L
[mm]	[mm]	[mm]	[mm]		

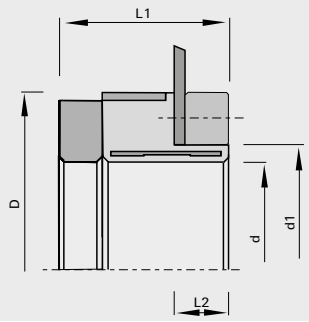
Spare parts	Dimension	Class-No.	PU	Ident-No.
Hydro Clamping Bushings	Ø90x82xØ40	933030	1	186417 L
	[mm]		[pc.]	

933030

Hydro Clamping Bushings - gang-rip saw blades and hoggers (Paul, Homag)

Product

Drawing



Machine / Application
- machines Paul, Homag
- for mounting of multi-rip saw blades and hoggers

Design
- hardened tool mounting area
- with one clamping zone
- closed hydraulic expansion clamping chuck for tight-tolerance fit on the motor shaft
- n max = 9,000 min-1

Advantages
- high smoothness of running
- short retool-times of panel-widths thanks to quick adjustment of tools
- maintenance-free

Notes
- for clockwise and counter-clockwise rotation
- mounting arrangements: 1. saw blade with spacer, 2. hogger without spacer
- positive locking between machine and sleeve
- tap holes on PCD for fixing of tools

Ø D	Ø d	Ø d1	L2	L1	NL		Ident-No.
145	100	110	18	65.5	4/M8/130	Paul	183829 C
145	100	110	14,2	49.5	4/M8/130	Paul	183821 C
145	100	110	18	65.5	4/M8/130	Homag	187112 L
145	100	110	14,2	49.5	4/M8/130	Homag	187111 C
[mm]	[mm]	[mm]	[mm]	[mm]			

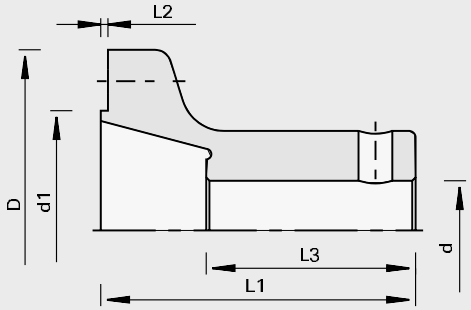
997300

Mounting Flanges - scoring saw blades (Homag, Brandt, IMA)

Product



Drawing



Machine / Application
- double end tenoners
- edge banding machines Homag, Brandt, IMA
- for mounting of HW scoring saw blades and DP scoring saw blades

Design
- tempered design
- mating and seating surfaces ground

Advantages

Notes
- for clockwise and counter-clockwise rotation
- for DP circular saw blades the cylindrical head screw Ident-No. 001869 is necessary (to be ordered separately)
- countersink screw included in delivery

Ø D	Ø d	Ø d1	L2	L1	L3	DKN	NL	Ident-No.
109	30	65	2,2	95	63	8x4	6/M5/90	006480 L
109	35	65	2,2	95	75	10x3,3	6/M5/90	182128 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts		Ø D	Ø D1	Ø d	For Ident-No.	Class-No.	PU	Ident-No.
Lid		40	30	17	006480	997370	1	181802 L
Lid		45	35	22	182128	997370	1	180082 L
Countersunk Screws	for mounting of saw blade				For all	995122	10	180007 L
Head Cap Screws	for mounting of DP saw blades				For all	995111	10	001869 L
		[mm]	[mm]	[mm]			[pc.]	

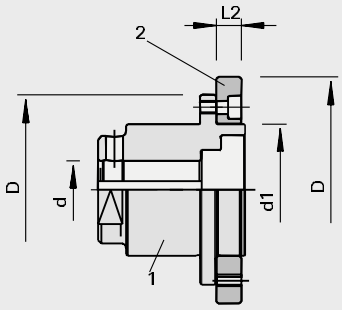
997300

Attachment Sleeves and Flanges - grooving saw blades, scoring saw blades, clipping saw blades and hoggers

Product



Drawing



Machine / Application

- for mounting of grooving saw blades, scoring saw blades, clipping saw blades and hoggers

Design

Advantages

Notes

- for clockwise and counter-clockwise rotation
- 1 = hogger sleeve
- 2 = flange
- for horizontally tilted motor when working in small distance to chain track

Ø D	Ø d	Ø d1	L2	L1	DKN	NL	Ident-No.
115	30	80	17,7	96	8x3	8/M8/100	006309 L
115	35	60	17,7	90	10x3,3	8/M8/100	180062 L
115	35	80	17,7	90	10x3,3	8/M8/100	055997 L
115	40	60	17,7	90	12x3,3	8/M8/100	180120 S
115	40	80	17,7	96	12x3,3	8/M8/100	006308 L
145	35	110	17	89.4	10x3,3	4/M8/130	189750 S
158	40	80	21	96	12x5	8/M8/130	008507 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Flange	Ø D	B	Ø d	Ø NL	Class-No.	PU	Ident-No.
	137	80	15	6/M5/105	955520	1	819300 C
	[mm]	[mm]	[mm]			[pc.]	

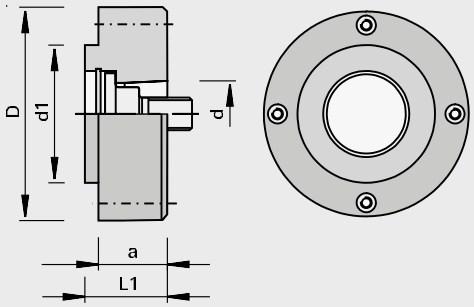
997300

Mounting Flanges - clipping saw blades (Homag, IMA)

Product



Drawing



Machine / Application

- edge banding machines Homag, IMA
- for mounting of clipping saw blades

Design

- machine interface HSK 25R

Advantages

- optimum cutting quality thanks to high radial running accuracy and precise tool balancing

Notes

- for clockwise and counter-clockwise rotation
- countersunk screw and screwdrivers are not included in delivery

Ø D	Ø d	Ø d1	L1	a	NL	Ident-No.
55	HSK 25R	34	22	20	4/M4/44 + 4/M5/42	179025 L
62	HSK 25R	40	24	20	4/M5/52	177788 L
66	HSK 25R	40	24	15	4/M5/52	183817 L
[mm]	[mm]	[mm]	[mm]	[mm]		

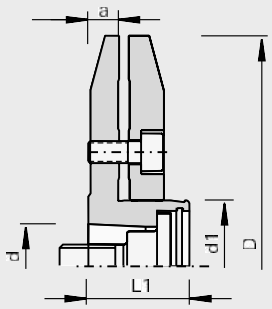
Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
Countersunk Screws	M5x10 T20 D=Ø10	995125	10	171236 L
Screwdrivers	T20x100	985730	1	166092 L
	[mm]		[pc.]	

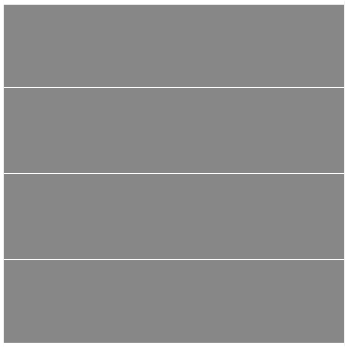
997300

Mounting Flanges - clipping saw blades (Homag Power-Line)

Product

Drawing





Machine / Application
- machines Power-Line Homag
- for mounting of clipping saw blades

Design
- machine interface HSK 25R

Advantages
- optimum cutting quality thanks to high radial running accuracy and precise tool balancing

Notes
- for clockwise and counter-clockwise rotation

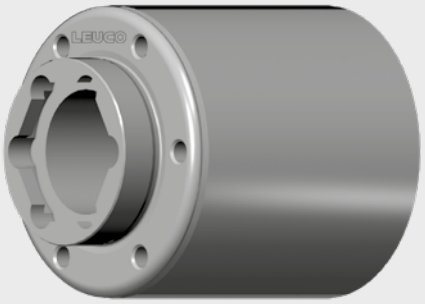
Ø D	Ø d	Ø d1	L1	a	NL	Ident-No.
105	HSK 25R	30	23	14	4/M5/52	181590 L
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780 L
Shim Rings	18x25x1,0 DIN 988	995440	10	177781 L
Locking Rings	25x1,2 DIN 472	995460	10	177782 L
Head Cap Screws	M5x12-8.8 DIN EN ISO 4762	995111	10	001869 L
Screwdrivers	SW4x100	985730	1	166091 L
	[mm]		[pc.]	

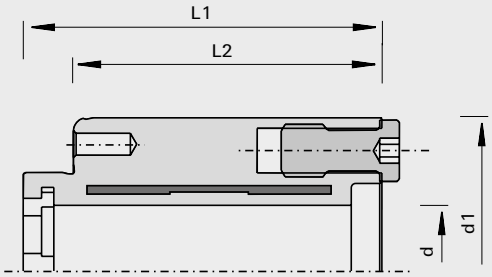
933030

Hydro Clamping Bushings - tools with bore on spindle 30 mm

Product



Drawing



Machine / Application

- for Homag and IMA jointing aggregat with spindle 30 mm and hexagon adapter
- for mounting of tools with bore

Design

- hardened tool mounting area
- with one clamping zone
- axial pressurization
- closed hydraulic expansion clamping chuck for tight-tolerance fit on the 30 mm motor shaft
- n max = 9,000 min-1

Advantages

- reduced machine downtimes thanks to axial pressurization
- excellent cutting quality when milling and hogging
- maintenance-free

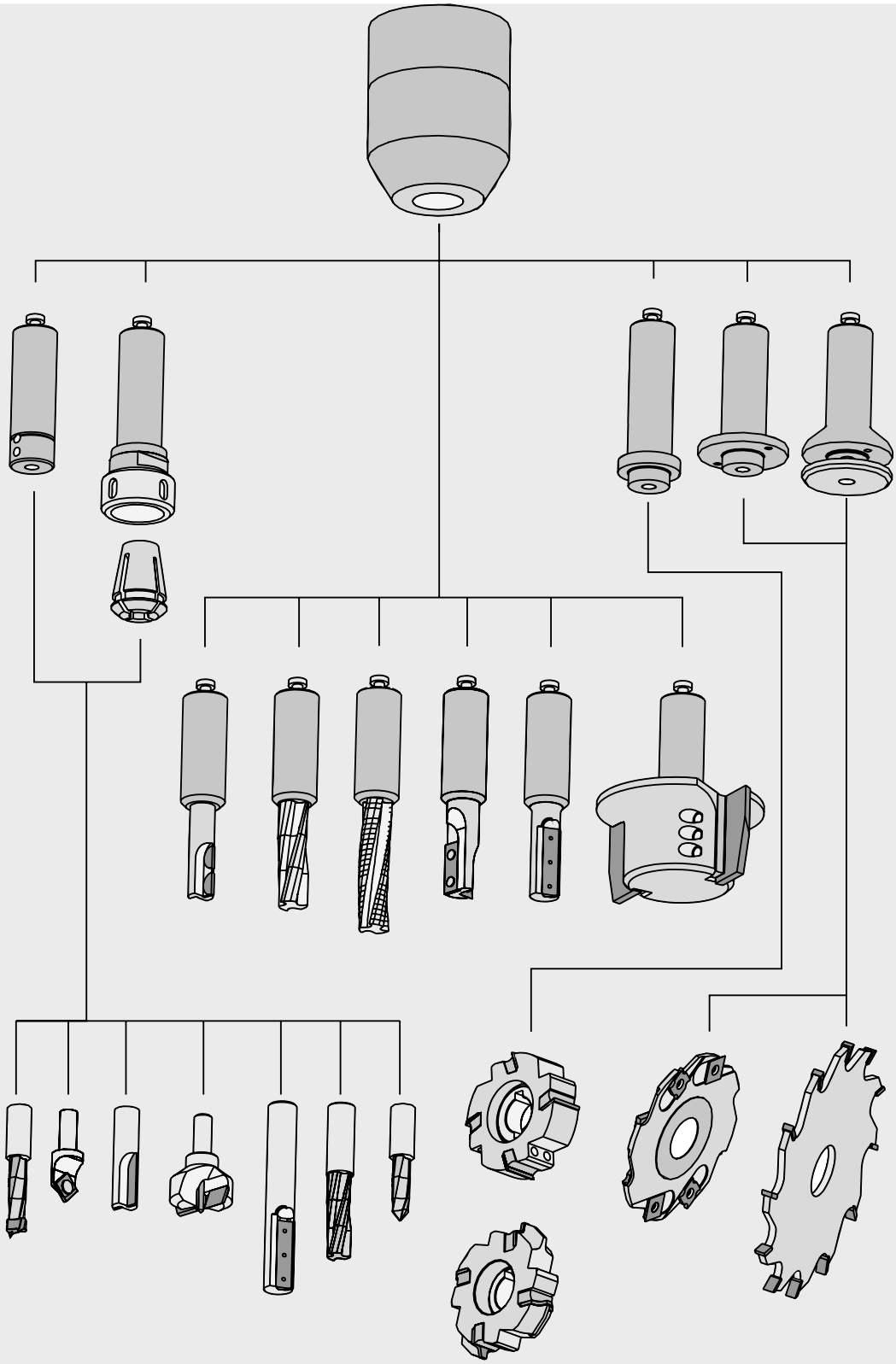
Notes

- for clockwise and counter-clockwise rotation
- specifically designed for high-precision motors with hexagonal spindle base
- included in delivery: hydro clamping bushing without screwdrivers

Ø d	Ø d1	L2	L1	NL	Ident-No.
30 [mm]	70 [mm]	70,5 [mm]	86 [mm]	6/M6/58	184310 L

Spare parts		Class-No.	PU	Ident-No.
Lids with O-Rings	for axial locking or bores 30 mm	997300	1	184317 L
Head Cap Screws	M10x50 DIN EN ISO 4762 for 184317	995111	10	001909 L
Screwdrivers	SW6/4 for hydro pressure build-up	985730	1	184707 L
Cranked Wrench Keys	SW8 DIN ISO 2936	985730	1	009677 C
			[pc.]	

Chart Tool Holders machine interface PS 2000-E



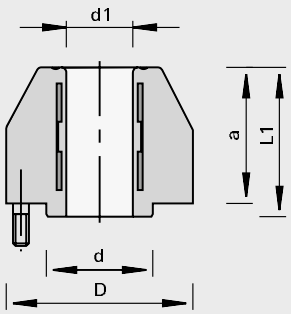
933240

Hydro Clamping Chucks PS 2000-E - tool directly attached by screws

Product



Drawing



Machine / Application

- for precise clamping of shank-type tools with cylindrical shank

Design

- n max = 25,000 min -1

Advantages

- optimum cutting quality and long tool life thanks to exact radial running accuracy
- minimization of setup-times thanks to easy and quick tool change

Notes

- for clockwise and counter-clockwise rotation
- integral part of machine spindle
- initial purchase through the machine manufacturers
- axial locking of the tools

Ø D	Ø d	Ø d1	L1	a	Weight	Ident-No.
70	40	25	56	51	1.327	173752 L
[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Accessories	Dimension	Class-No.	PU	Ident-No.
Safety Screws	M8x19	995190	1	172921 L
	[mm]		[pc.]	

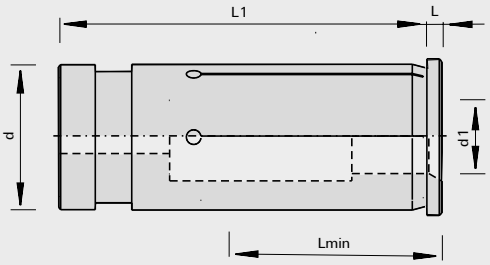
933280

Universal Reducing Bushings, highly precise

Product



Drawing



LEUCO CNC

Machine / Application

- for holding shank tools in TRIBOS, ps-System and all standard hydro expansion chuck

Design

- concentric accuracy ≤ 0.003 mm
- shank diameter tolerance h7 or g7
- coolant-tight up to 80 bar

Advantages

- permanent concentricity and tool-change repeat accuracy ≤ 0.003 mm

Notes

- Lmin minimum clamping length = minimum shaft length

Ø d1	Ø d1	Lmin	Ø d	L1	L	Ident-No.
3		27	12	45	2.0	183022 O
4		27	12	45	2.0	183023 C
5		27	12	45	2.0	183024 O
6		27	12	45	2.0	183025 L
8		27	12	45	2.0	183026 L
8		27	16	47.5	2.5	186099 L
10		32	16	47.5	2.5	186100 L
12		37	16	47.5	2.5	186101 L
3		27	20	50.5	2.0	183027 O
	1/8	27	20	50.5	2.0	186914 O
4		27	20	50.5	2.0	183028 O
5		27	20	50.5	2.0	183029 O
6		27	20	50.5	2.0	183030 C
8		27	20	50.5	2.0	183032 L
10		32	20	50.5	2.0	183034 L
12		37	20	50.5	2.0	183036 L
14		37	20	50.5	2.0	183038 O
16		38	20	50.5	2.0	183040 L
6		27	25	54.5	3.0	182304 L
8		27	25	54.5	3.0	182305 L
10		32	25	54.5	3.0	182306 L
12		37	25	54.5	3.0	182307 L
14		37	25	54.5	3.0	182308 L
16		38	25	54.5	3.0	182309 L
18		38	25	54.5	3.0	182310 L
20		42	25	54.5	3.0	182311 L
	1/2″	37	25	54.5	3.0	182653 L
	3/4″	42	25	54.5	3.0	182655 L
[mm]	[inch]	[mm]	[mm]	[mm]	[mm]	

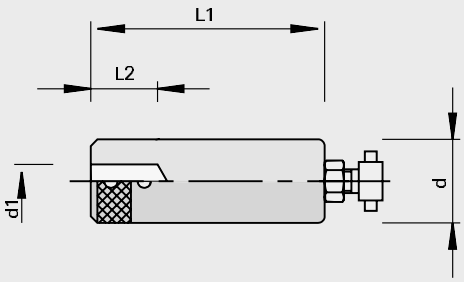
933243

Adapters with cylindrical shank - shank-type tools

Product



Drawing



Machine / Application

- for mounting of shank-type tools in PS 2000-E for shank diameter 6 - 12 mm

Design

Advantages

Notes

- the tool shanks must feature a flat clamping area
- length adjusting screw Ident-No. 172921 is required for PS 2000-E
- without length adjusting screw for ps-System Ø 16 mm Ident-No. 172115, Ø 25 mm Ident-No. 172113

Ø d	Ø d1	L2	L1	Ident-No.
16	8	20	61	172117 L
16	10	20	61	172119 L
25	6	20	70	172103 L
25	8	20	70	172104 L
25	10	20	70	172101 L
25	12	20	70	172102 L
[mm]	[mm]	[mm]	[mm]	

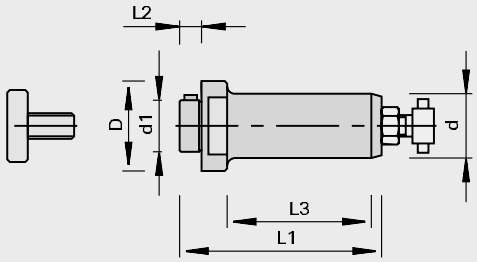
933069

Adapters with cylindrical shank - tools with bore

Product



Drawing



LEUCO CNC

Machine / Application

- for PS 2000-E and draw-in collet chuck for the mounting of tools with bore

Design

- tool held in place by set screws

Advantages

Notes

- for clockwise and counter-clockwise rotation
- length adjusting screw Ident-No. 172921 is required for PS 2000-E
- included in delivery: mounting arbor, set screws and length adjusting screw for ps-System for shank Ø 16 Ident-No. 172115, shank Ø 25 Ident-No. 172113

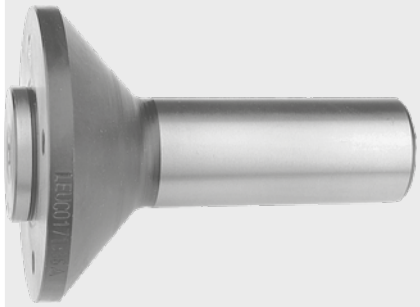
Ø D	Ø d	Ø d1	L2	L1	L3	Ident-No.
35	16	20	8,5	68	43	171389 O
35	25	20	8,5	78.5	55	171391 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Cutter Retaining Bolts	M10x18xØ28	995190	1	171392 L
Engineers Wrenches	24x27 DIN 3110	985730	1	009193 C
	[mm]		[pc.]	

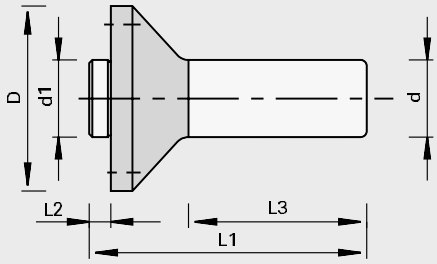
933061

Adapters with cylindrical shank - saw blades, grooving cutters and cutters

Product



Drawing



Machine / Application

- for PS 2000-E and draw-in collet chuck for the mounting of tools with bore

Design

- tool attached and secured against rotation with screws

Advantages

Notes

- for right-hand and left-hand rotation
- for PS 2000-E, the length adjusting screw ID no. 172921 is required
- clamping length L2 = 30 and 36 mm for one-piece and multi-piece cutters and cutterheads
- clamping length L2 = 4 an 5 mm for circular saw blades and grooving tools
- Scope of delivery: Adapter for Lamello Clamex P® including 4 countersunk screws, all other adapters without countersunk screws. Screws of the required length must be ordered separately depending on the application.

Ø D	Ø d	Ø d1	L2	L1	L3	NL		Ident-No.
50	16	22	4,0	68	45	4/M5/34 + 4/M4/36		184277 L
50	25	22	4,0	92	60	4/M5/34 + 4/M4/36		184276 L
60	16	30	4,0	80	60	4/M6/48	Lamello Clamex P®	184304 L
60	25	30	4,0	90	70	4/M6/48	Lamello Clamex P®	184305 L
60	25	25	30	111	60	6/M6/48		168814 C
60	25	30	36	117	60	6/M6/48		168815 L
66	25	30	5,0	92	60	4/M5/48		171386 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Countersunk Screws	M6x10 T20 D=Ø8,8	184304, 184305	995125	10	181244 L
Screwdrivers	T20x100	184304, 184305	985730	1	166092 L
	[mm]			[pc.]	

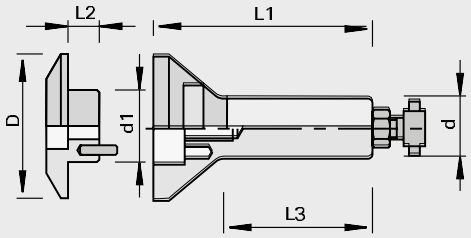
933069

Adapters with cylindrical shank - saw blades and grooving cutters

Product



Drawing



Machine / Application

- for PS 2000-E and draw-in collet chuck for mounting of circular saw blades and grooving cutters

Design

- secured against rotation with drive pin

Advantages

Notes

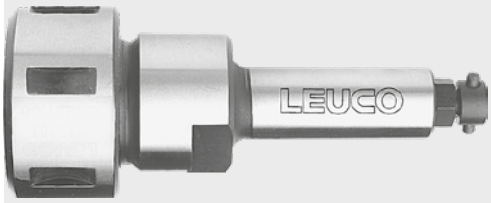
- for clockwise and counter-clockwise rotation
- length adjusting screw Ident-No. 172921 is required for PS 2000-E
- included in delivery: clamping arbor, clamping flange, cap screw and length adjusting screw for ps-System for shank Ø 16 Ident-No. 172115, shank Ø 25 Ident-No. 172113

Ø D	Ø d	Ø d1	L2	L1	L3		Ident-No.
60	16	30	8,0	78	43	for plate thickness max. 6 mm	171394 L
60	25	30	9,0	94	55	for plate thickness max. 8 mm	167826 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

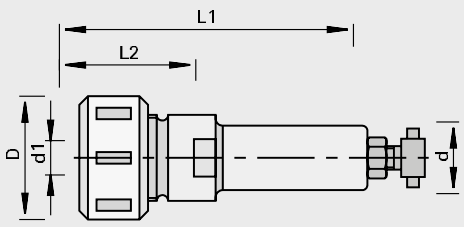
933250

Draw-In Collet Chucks with cylindrical shank

Product



Drawing



Machine / Application

- for mounting of shank-type tools in PS 2000-E

Design

- for shank diameter 2-16 mm
- collet chucks DIN 6388 Type 415E/OZ16
- lock nut with sleeve bearing

Advantages

Notes

- for clockwise and counter-clockwise rotation
- length adjusting screws are not included in delivery

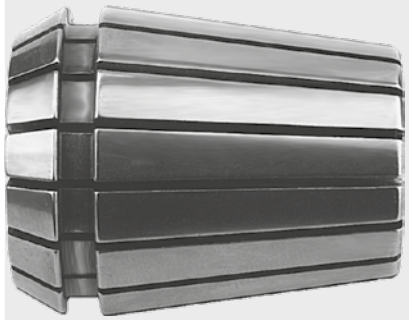
Ø D	Ø d	Ø d1	L2	L1	Ident-No.
43	16	2-16	50	95	170181 L
43	25	2-16	50	105	170182 L
[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Clamping Nuts	M30x1,5R	995290	1	178763 O
Hook Wrenches	40/42 DIN 1810	985720	1	169298 L
Hook wrenches adapter	40/43 DIN 1810	985300	1	186466 C
Engineers Wrenches	24x27 DIN 3110	985730	1	009193 C
Torque wrench	40-200 Nm	985300	1	184890 L
	[mm]		[pc.]	

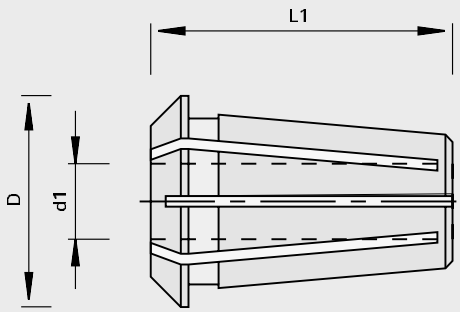
933280

Precision collets - 415E/OZ16

Product



Drawing



Machine / Application

- for use in draw-in collet chucks Type 415E/OZ16

Design

- slotted from top and bottom
- clamping tolerance 0.5 mm
- according to DIN 6388 415E/OZ16

Advantages

Notes

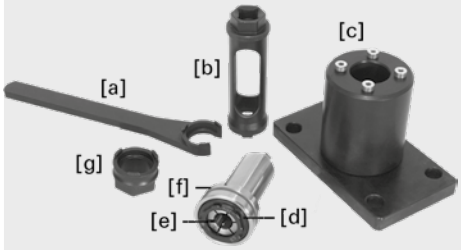
- for Ident-No. 170181, 170182

Ø D	Ø d1	L1	Ident-No.
25.5	2,5	40	820753 O
25.5	3	40	820754 C
25.5	4	40	820494 C
25.5	4,5	40	830236 C
25.5	5	40	820495 O
25.5	6	40	170779 O
25.5	6,35	40	821421 C
25.5	7	40	829692 S
25.5	8	40	170780 L
25.5	9	40	825190 C
25.5	9,5	40	168739 C
25.5	10	40	170781 L
25.5	12	40	168740 L
25.5	12,7	40	830156 C
25.5	13	40	821221 O
25.5	16	40	168741 L
[mm]	[mm]	[mm]	

933250

StarterKit for Weeke BHX series

Product



Drawing

Machine / Application
- for use in hydro expansion chuck on WEEKE BHX machines, expecially BHX 050/055 series
- for tools with shank diameter up to 1-16 mm

Design
- adapters with high-precision collet chucks, especially adapted to the hydro clamping system of the BHX milling spindle
- with internal lock nut

Advantages
- flexible, quick clamping
- low building height
- individual tool pre-setting outside of the machine is possible
- time saving tool changes

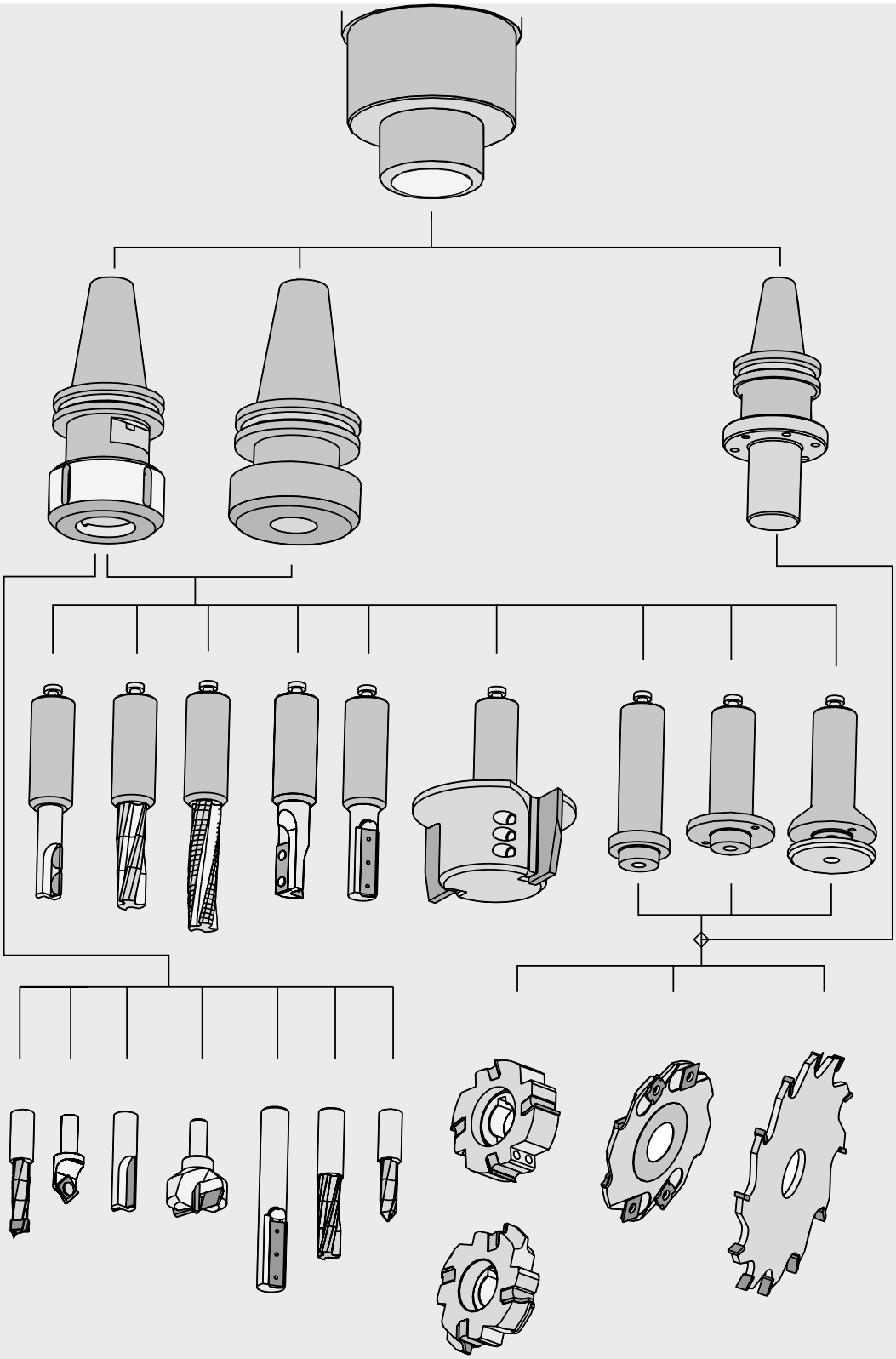
Notes
- for Weeke BHX machines grooving cutters HW "g5-System" are also available
- torque: 90 Nm (74 Lbf.ft)

		Ident-No.
StarterKit SET1	[d]+[f] 3 clamping adapter incl. lock nuts [e] 3 collet chucks (8, 10, 12 mm) [c] 1 mounting device [a] 1 hook wrench [g] 1 wrench	184359 C
StarterKit SET2	[d]+[f] 5 clamping adapter incl. lock nuts [e] 5 collet chucks (6, 8, 10, 12, 16 mm) [c] 1 mounting device [a] 1 hook wrench [b] 1 wrench socket	184360 C

Spare parts	Content StarterKit	Dimension	Class-No.	PU	Ident-No.
[f]+[d] clamping adapter incl. lock nut	For all	ØD25x16	933250	1	184362 C
[c] mounting devices	For all		985202	1	184363 C
[a] Hook Wrench	For all	ØD=25, L=200	985720	1	184364 C
[g] Wrench	184359	ØD=30, SW27, H20	985720	1	184365 C
[b] Wrench Socket	184360	ØD=30, SW22, H96	985720	1	184366 L
[e] collet chucks	184360	411E ØD=6	933280	1	184372 L
[e] collet chucks	For all	411E ØD=8	933280	1	184373 L
[e] collet chucks	For all	411E ØD=10	933280	1	184374 L
[e] collet chucks	For all	411E ØD=12	933280	1	184375 L
[e] collet chucks	184360	411E ØD=16	933280	1	184376 L
		[mm]		[pc.]	

Accessories	Dimension	Class-No.	PU	Ident-No.
[e] collet chucks	411E ØD=1	933280	1	184367 S
[e] collet chucks	411E ØD=2	933280	1	184368 S
[e] collet chucks	411E ØD=3	933280	1	184369 S
[e] collet chucks	411E ØD=4	933280	1	184370 C
[e] collet chucks	411E ØD=5	933280	1	184371 C
[e] collet chucks	411E ØD=6	933280	1	184372 L
[e] collet chucks	411E ØD=16	933280	1	184376 L
[d] Clamping Nuts	M32x1,5	995290	1	184378 L
	[mm]		[pc.]	

Chart Tool Holders machine interface SK- and BT-Mounting



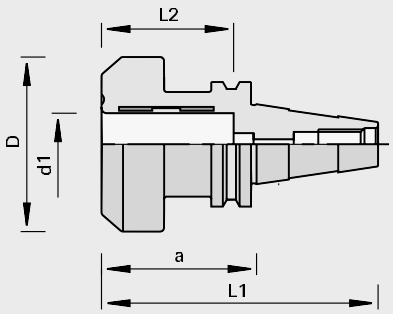
933240

Hydro Clamping Chucks PS 2000-E - tool changer

Product



Drawing



Machine / Application

- CNC machining centers with automatic tool changer
- for precise clamping of shank-type tools with cylindrical shank

Design

- n max = 25,000 min -1
- quick-release taper BT 30 and quick-release taper BT 35 with retaining bolt according to standard MAS 403
- quick-release taper SK 30 according to DIN ISO 7388 (without retaining bolt - must be ordered separately)
- quick-release taper SK 30 and SK 40 according to DIN ISO (with retaining bolt)

Advantages

- minimization of setup-times thanks to easy and quick tool change
- high cutting quality and long edge lives thanks to high concentricity

Notes

- for clockwise and counter-clockwise rotation

Ø D	Ø d	Ø d1	L2	L1	a	Weight		Ident-No.
70	SK 30 (DIN ISO)	25	55	111	63	1.1	IMA, Maka, Biesse, Reichenbacher, Weeke, CMS	173754 L
70	SK 40 (DIN ISO)	25	55	128	60	1.39	IMA, Maka, Reichenbacher, Stegherr	173756 C
70	BT 35	25	55	120	63	1.25	Heian	175796 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]		

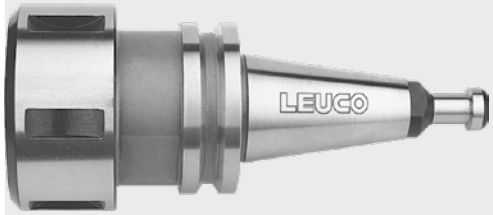
Ø D	Ø d	Ø d1	L2	L1	a	Weight		Ident-No.
53	SK 30 (DIN ISO)	3/8	41	110.6	63	1.1	Without retaining bolts	187756 L
[mm]	[mm]	[inch]	[mm]	[mm]	[mm]	[kg]		

Retaining Bolts	Mach.	Class-No.	PU	Ident-No.
for SK 30	IMA, Maka, Reichenbacher, Weeke	997870	1	169293 L
for SK 40	IMA, Reichenbacher, Stegherr	997870	1	169294 C
for SK 30	CMS, Masterwood	997870	1	177021 L
for SK 30	Rover old, Biesse up to 08/92	997870	1	175637 O
for SK 30	Rover new, Biesse (HSD motor) from 09/92, Masterwood (Colombo motor)	997870	1	173641 L
for SK 30	Alberti	997870	1	177020 O
for BT 35	Heian	997870	1	176103 L
			[pc.]	

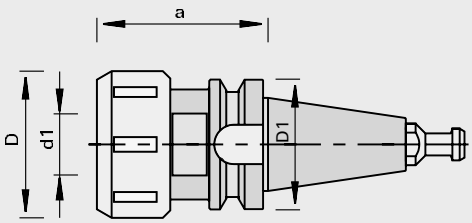
933289

Draw-In Collet Chucks with SK shank

Product



Drawing



Machine / Application

- CNC machining centers with automatic tool changer
- for clamping of shank-type tools with cylindrical shank

Design

- quick-release taper according to DIN ISO 7388 (without dog and locating grooves)
- BT quick-release taper according to Japanese standard MAS - 403 (for Ident-No. 176102)
- lock nut with sleeve bearing (except for Ident-No. 177304 with ball bearing)

Advantages

- minimization of setup-times thanks to easy and quick tool change
- high cutting quality and long edge lives thanks to high concentricity

Notes

- for clockwise and counter-clockwise rotation
- included in delivery:collet chuck, clamping nut and retaining bolt

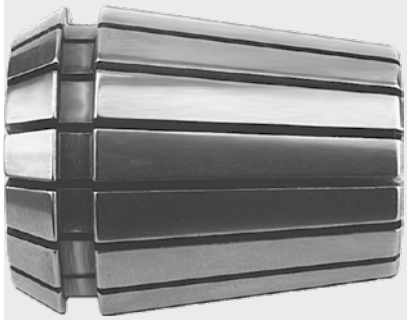
Ø D	Ø d	Ø D1	Ø d1	a	Norm number			Ident-No.	
43	SK 30 (DIN ISO)	50	2-16	55	415E/OZ16	SW 41	Weeke	177304	C
60	SK 30 (DIN ISO)	50	2-25	70	462E/OZ25	SW 41	IMA, Maka, Reichenbacher	173794	L
50	SK 30 (DIN ISO)	46	2-20	58	470E/ER32	SW 41	CMS	180360	O
60	SK 40 (DIN ISO)	63	2-25	70	462E/OZ25	SW 46	IMA, Maka, Stegherr, Reichenbacher	173795	L
60	BT 35	53	2-25	70	462E/OZ25	SW 41	Heian	176102	L
[mm]	[mm]	[mm]	[mm]	[mm]					

Spare parts	Dimension		Class-No.	PU	Ident-No.	
Clamping Nuts	M30x1,5R	177304	995290	1	178763	O
Clamping Nuts	M48x2R	173794, 173795, 176102	995290	1	178764	L
Retaining Bolts		173794, 177304	997870	1	169293	L
Retaining Bolts		173795	997870	1	179339	L
Retaining Bolts		180360	997870	1	177021	L
Retaining Bolts		176102	997870	1	176103	L
Single-Head Engineers Wrenches	SW41 DIN 894	177304	985720	1	169297	S
Single-Head Engineers Wrenches	SW46x10 DIN 894	173794, 173795, 176102	985720	1	178760	L
Hook Wrenches	40/42 DIN 1810	177304	985720	1	169298	L
Hook Wrenches	58/62 DIN 1810	173794, 173795, 176102	985720	1	169299	L
Hook wrenches adapter	40/43 DIN 1810	177304	985300	1	186466	C
Hook wrenches adapter	58/62 DIN 1810	173794, 173795, 176102	985300	1	186765	L
Torque wrench	40-200 Nm	173794, 173795, 176102, 177304	985300	1	184890	L
	[mm]			[pc.]		

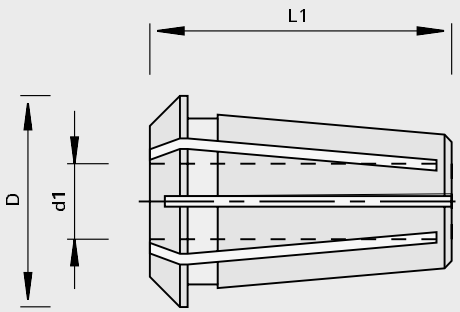
933280

Precision collets - 462E/OZ25

Product



Drawing



Machine / Application

- for use in draw-in collet chuck Type 462E/OZ25

Design

- clamping tolerance 0.5 mm
- according to DIN 6388 Type 462E/OZ25

Advantages

- optimum transmission of clamping force thanks to 12 slots from top and bottom

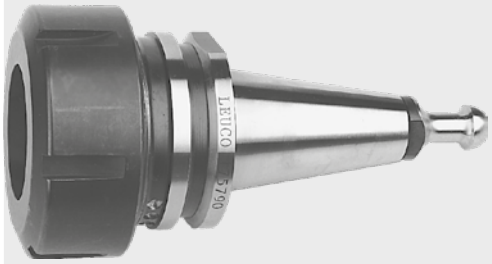
Notes

Ø d1	Ø d1	Ø D	L1	Ident-No.
2		35.05	52	183803 O
3		35.05	52	183804 L
4		35.05	52	183805 L
5		35.05	52	183806 L
6		35.05	52	180213 L
	1/4″	35.05	52	175815 L
7		35.05	52	183807 O
8		35.05	52	180358 L
	3/8″	35.05	52	185275 L
10		35.05	52	170782 L
12		35.05	52	168742 L
	1/2″	35.05	52	175820 L
13		35.05	52	180215 L
14		35.05	52	170783 L
	5/8″	35.05	52	175823 L
15		35.05	52	183808 O
16		35.05	52	168743 L
18		35.05	52	180216 L
	3/4″	35.05	52	175826 L
20		35.05	52	168744 L
25		35.05	52	168745 L
[mm]	[inch]	[mm]	[mm]	

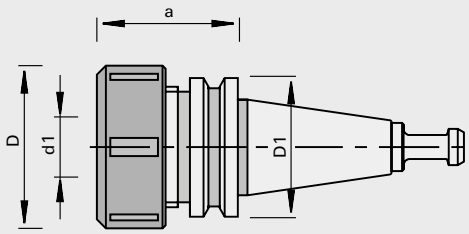
933289

Draw-In Collet Chucks with SK shank - Biesse, CMS

Product



Drawing



LEUCO CNC

Machine / Application

- CNC machining centers with automatic tool changer
- for clamping of shank-type tools with cylindrical shank

Design

- quick-release taper according to DIN ISO 7388 (without dog and locating grooves)
- lock nut with sleeve bearing

Advantages

- minimization of setup-times thanks to easy and quick tool change
- high cutting quality and long edge lives thanks to high concentricity

Notes

- for clockwise and counter-clockwise rotation
- collet chucks according to Type 470E/ER32 Ø 2..20 mm
- collet chucks according to Type 472E/ER40 Ø 4..25 mm
- included in delivery:collet chuck, clamping nut and retaining bolt (Biesse 173641)

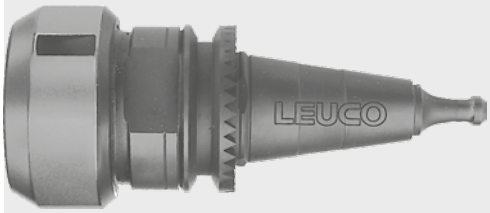
Ø D	Ø d	Ø D1	Ø d1	a	Type		Ident-No.
50	SK 30 (DIN ISO)	50	2-20	50	470E/ER32	Biesse	173639 L
63	SK 30 (DIN ISO)	50	4-25	57	472E/ER40	Biesse	175790 L
63	SK 30 (DIN ISO)	46	4-25	64	472E/ER40	CMS	180361 L
[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension		Class-No.	PU	Ident-No.
Clamping Nuts	M40x1,5R	for Ø D = 50	995290	1	178761 L
Clamping Nuts	M50x1,5R	for Ø D = 63	995290	1	178762 O
Retaining Bolts		HSD motor for Biesse as from 09/92	997870	1	173641 L
Retaining Bolts		for Biesse up to 08/92	997870	1	175637 O
Retaining Bolts		for CMS	997870	1	177021 L
Hook Wrenches	45/50 DIN 1810	for Ø D = 50	985720	1	175851 L
Hook Wrenches	58/62 DIN 1810	for Ø D = 63	985720	1	169299 L
Hook wrenches adapter	45/50 DIN 1810	for Ø D = 50	985300	1	186467 C
Hook wrenches adapter	58/62 DIN 1810	for Ø D = 63	985300	1	186765 L
Torque wrench	40-200 Nm		985300	1	184890 L
	[mm]			[pc.]	

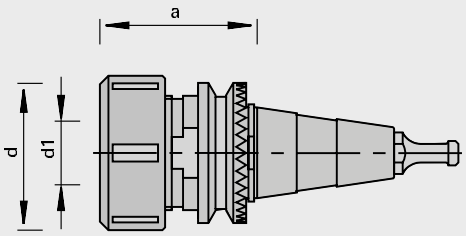
933289

Draw-In Collet Chucks with SK shank with ring gear

Product



Drawing



Machine / Application

- CNC machining centers with automatic tool changer
- for clamping of shank-type tools with cylindrical shank

Design

- quick-release taper according to SK 30 with ring gear
- lock nut with sleeve bearing

Advantages

- minimization of setup-times thanks to easy and quick tool change
- high cutting quality and long edge lives thanks to high concentricity

Notes

- for clockwise and counter-clockwise rotation
- replaceble retaining bolt
- collet chucks according to Type 462E/OZ25 Ø 4..25 mm
- collet chucks according to Type 470E/ER32 Ø 2..20 mm
- included in delivery:collet chuck, clamping nut and retaining bolt

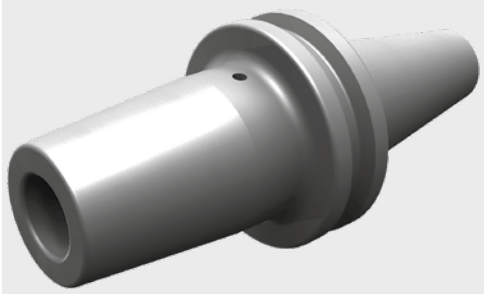
Ø D	Ø d	Ø d1	a	Type		Ident-No.
50	SK 30	2-20	55	470E/ ER32	SCM, Morbidelli	173644 L
60	SK 30	4-25	72	462E/ OZ25	SCM, Morbidelli	175792 L
[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension		Class-No.	PU	Ident-No.
Clamping Nuts with sleeve bearing	M40x1,5R	for Ø D = 50	995290	1	178761 L
Clamping Nuts with sleeve bearing	M48x2R	for Ø D = 60	995290	1	178764 L
Retaining Bolts	Ø8,5		997870	1	173646 L
Hook Wrenches	45/50 DIN 1810	for Ø D = 50	985720	1	175851 L
Hook Wrenches	58/62 DIN 1810	for Ø D = 60	985720	1	169299 L
Single-Head Engineers Wrenches	SW36 DIN 894	for Ø D = 50	985720	1	169296 O
Single-Head Engineers Wrenches	SW46x10 DIN 894	for Ø D = 60	985720	1	178760 L
	[mm]			[pc.]	

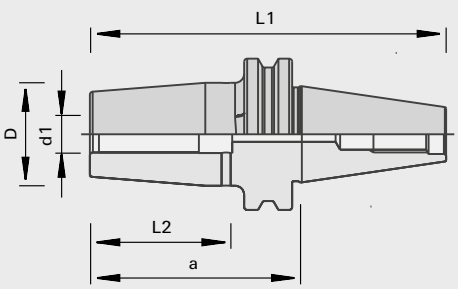
933297

Heat-Shrinking Chucks with SK shank

Product



Drawing



Machine / Application

- CNC machining centers with automatic tool changer
- for precise clamping of shank-type tools with cylindrical shank

Design

- n max = 30,000 min-1
- interface DIN ISO 7388-1 SK 30 AD
- from high-quality hot work tool steel

Advantages

- increased process safety, long edge lives and high machining quality thanks to very high concentricity and repeating accuracy (< 0.003 mm)

Notes

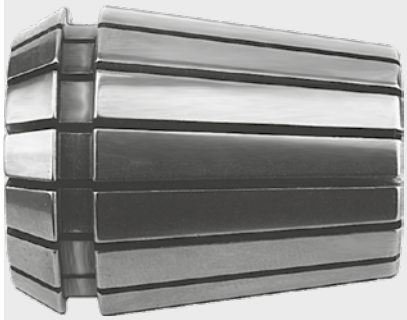
- for clockwise and counter-clockwise rotation
- can be clamped and unclamped with all conventional shrinking devices
- delivery without retaining bolts

Ø d1	L2	Ø d	Ø D	L1	a	Weight	Ident-No.
12	47	SK 30	34	117.8	70	0.64	187214 L
16	51	SK 30	34	117.8	70	0.61	187215 L
20	51	SK 30	42	117.8	70	0.72	187216 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

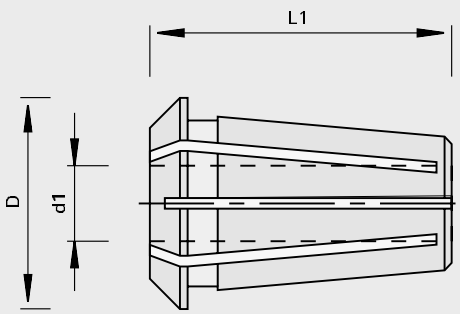
933280

Precision collets - 430E/ER25, 470E/ER32, 472E/ER40

Product



Drawing



Machine / Application

- for use in draw-in collet chuck Type 430E/ER25, 470E/ER32, 472E/ER40

Design

- slotted from top and bottom
- clamping tolerance 1 mm

Advantages

Notes

- Type 430E/ER25 Ø 6 - 16 mm for special chuck
- Type 470E/ER32 Ø 3 - 20 mm
- Type 472E/ER40 Ø 6 - 25 mm

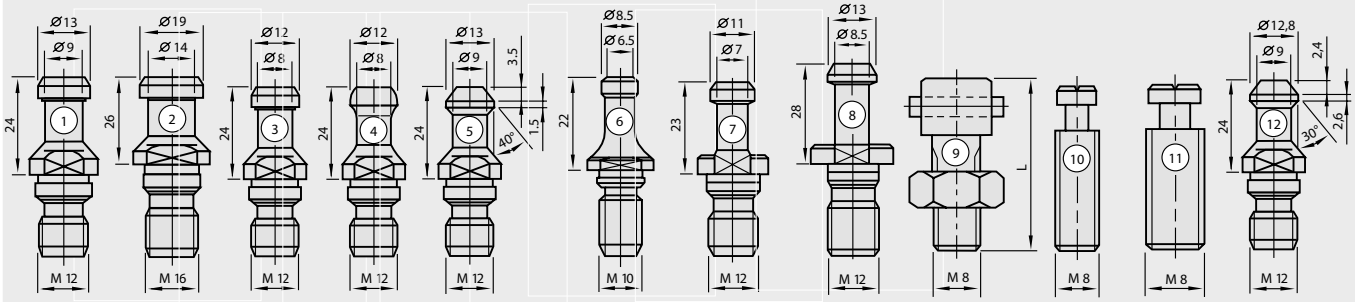
Ø D	Ø d1	Ø d1	L1	Type	Ident-No.
33	3		40	470E/ER32	173647 C
33	4		40	470E/ER32	173648 C
33	5		40	470E/ER32	173649 C
33	6		40	470E/ER32	173650 L
33	7		40	470E/ER32	173651 C
33	8		40	470E/ER32	173652 L
33	10		40	470E/ER32	173653 L
33	12		40	470E/ER32	173654 L
33	13		40	470E/ER32	173655 C
33	14		40	470E/ER32	173656 C
33	16		40	470E/ER32	173657 L
33	18		40	470E/ER32	173658 C
33	19		40	470E/ER32	173659 C
33	20		40	470E/ER32	173660 L
33		1/4″	40	470E/ER32	175829 L
33		1/2″	40	470E/ER32	175830 L
33		5/8″	40	470E/ER32	175831 S
33		3/4″	40	470E/ER32	175832 C
41	6		46	472E/ER40	180912 O
41	8		46	472E/ER40	180913 L
41	10		46	472E/ER40	180914 O
41	12		46	472E/ER40	175833 L
41	16		46	472E/ER40	175834 L
41	18		46	472E/ER40	175835 O
41	20		46	472E/ER40	175836 L
41	25		46	472E/ER40	175837 L
41	30		46	472E/ER40	80329695 C
41		1/4″	46	472E/ER40	175838 C
41		1/2″	46	472E/ER40	175839 O
41		5/8″	46	472E/ER40	175840 C
41		3/4″	46	472E/ER40	175841 C
41		1″	46	472E/ER40	175842 S
26	6		34	430E/ER25	181986 C
26	8		34	430E/ER25	181987 L
26	10		34	430E/ER25	181988 L
26	12		34	430E/ER25	181989 L
26	14		34	430E/ER25	181990 C
26	16		34	430E/ER25	181991 L
[mm]	[mm]	[inch]	[mm]		

997870

Retaining Bolts

Product

Drawing



Machine / Application

- for use in Hydro clamping chuck PS 2000-E, adapter and draw-in collet chuck with SK + BT-shank

Design

Advantages

Notes

- attachment screw for tools with shank diameter 25 mm

	Type		Ident-No.
for SK 30	1	IMA, Maka, Reichenbacher, Weeke	169293 L
for SK 40 with ventilation	2	IMA, Reichenbacher, Stegherr	169294 C
for SK 40	2	IMA, Reichenbacher, Stegherr, Maka	179339 L
for SK 30	3	Rover old, Biesse up to 08/92	175637 O
for SK 30	4	Rover new, Biesse (HSD motor) from 09/92, Masterwood (Colombo motor)	173641 L
for SK 30	5	Alberti	177020 O
for CMS	12	CMS, Masterwood	177021 L
Retaining Bolt Ø 8.5 mm	6	Morbidelli, SCM	173646 L
for BT 30	7	Shoda	176200 C
for BT 35	8	Heian	176103 L
for ps-System 25 mm Ident-No. 173752	9	ps-System	172113 L
for PS-2000 E Ident-No. 173352	10	PS 2000-E	172921 L
stop screw	11	draw-in collet chuck	172828 L

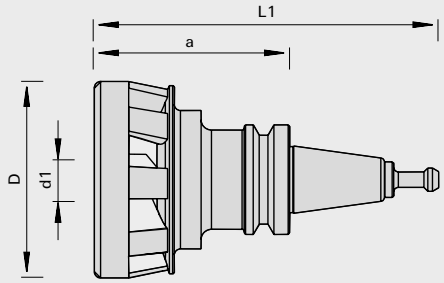
933285

AEROTECH-System with SK30 (DIN ISO) with hydro expansion clamping

Product



Drawing



Aerotech® System

Machine / Application

- CNC machining centers
- for clamping of shank-type tools and simultaneous chip guide when working
- for grooving, rabbeting in the case of pocket milling and dividing cuts as well as for the optimization of production processs e.g. with Nesting applications

Design

- monolithic tool clamping system
- 9 wing design for the machining of particle board, MDF, OSB, hard wood etc.
- tool mounting by means of hydro expansion clamping technology
- balance quality G<2,5

Advantages

- stopping of the chip flow
- cooling of the tool
- reduction of the dust quantity
- reduced efforts for cleaning and maintenance
- minimization of setup-times thanks to easy and quick tool change with hydro expansion clamping
- high cutting quality and long edge lives thanks to high concentricity
- optimum torque transfer

Notes

- sufficient vacuum performance is necessary
- pressurization via hexagonal screwdriver (included in delivery)
- delivery with retaining bolts for Biesse Ident-No. 173641
- retaining boltt Ident-No. 169293 for IMA, Maka, Reichenbacher and Weeke must be ordered separately
- please observe the information in the Operating Instructions

Ø d1	Ø d	Ø D	L1	a		Ident-No.
20	SK 30 (DIN ISO)	95	143.2	92.2	9 wings	185153 L
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screwdrivers with sliding handle for hexagon socket	SW4x100 [mm]	985730	1 [pc.]	166091 L

Ø d1	Ø d	Ø D	L1	a	x	Type		Ident-No.
3-30	HSK 80A	80	110	85	18	2	Joinery machines by Weinmann and Hundegger	80480510 C
3-30	HSK 80C	80	101	76	18	2	Joinery machines by Weinmann and Hundegger	80480509 C
3-30	HSK 80E	80	101	76	18	2	Joinery machines by Weinmann and Hundegger	80480508 C
3-30	HSK 80F	80	93	76	18	2	Joinery machines by Weinmann and Hundegger	80480507 C
3-30	HSK 100A	100	120	85	18	2	Joinery machines by Weinmann and Hundegger	80480511 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

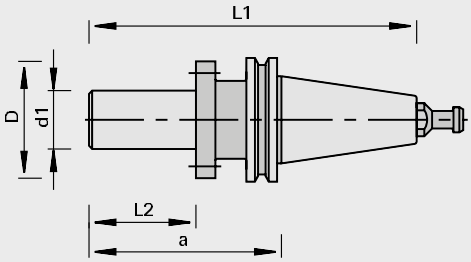
933061

Adapters with SK shank

Product



Drawing



Machine / Application

- CNC machining centers with automatic tool changer
- for precise mounting of tools with bore

Design

- clamping length L2 = 50 mm for multiple-part cutters and cutterheads
- quick-release taper according to DIN ISO 7388 (without dog and locating grooves)
- tool attached and secured against rotation with screws

Advantages

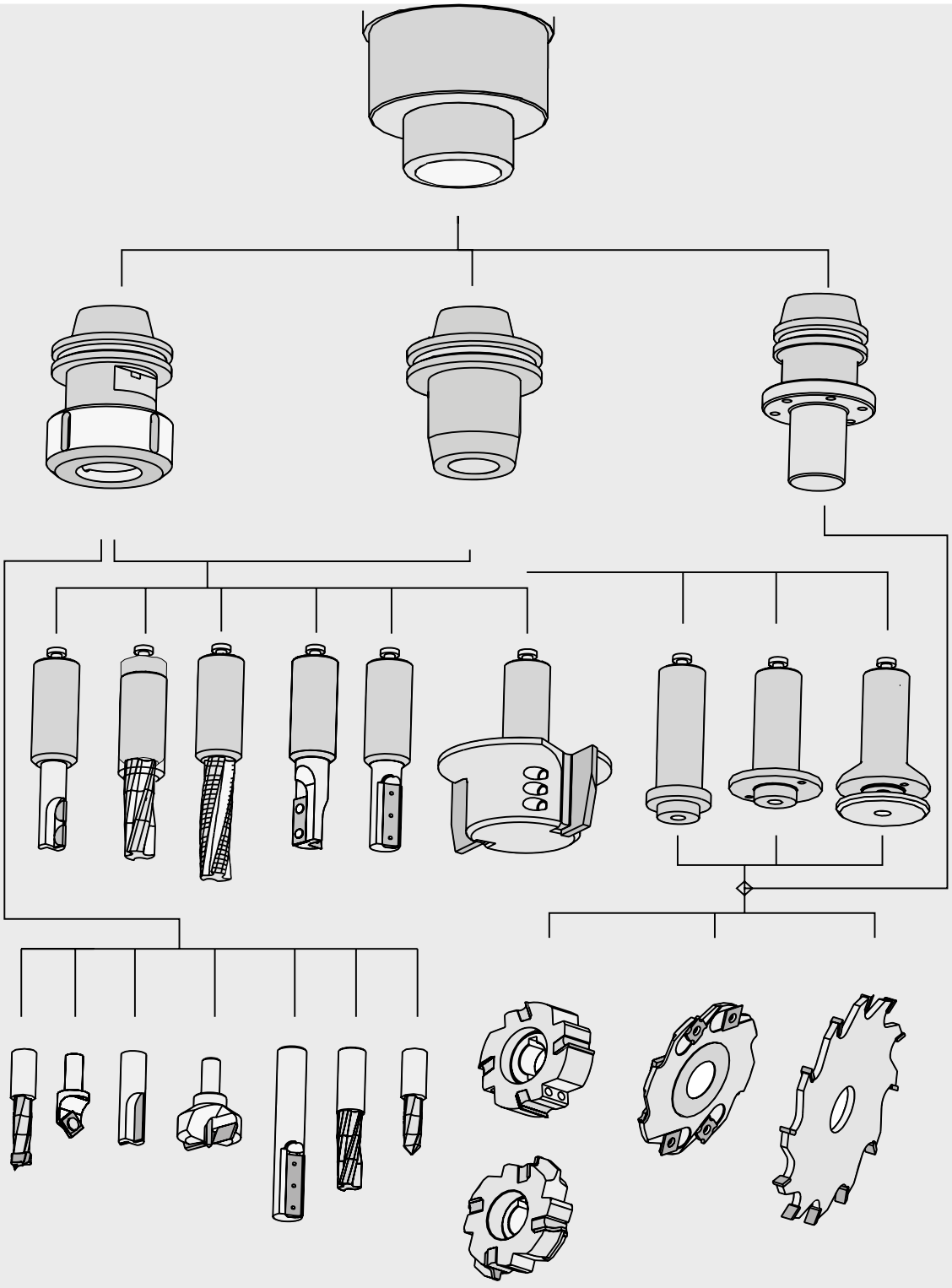
Notes

- for clockwise and counter-clockwise rotation

Ø D	Ø d	Ø d1	L2	L1	a	NL	Ident-No.
60	SK 30	30	55	147.8	100	2/M6/48 + 2/6/48	182167 O
60	SK 40	30	55	168.4	100	2/M6/48 + 2/6/48	182168 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts		Class-No.	PU	Ident-No.
Retaining Bolts	for SK 30	997870	1	169293 L
Retaining Bolts	for SK 40	997870	1	179339 L
			[pc.]	

Chart Tool Holders machine interface HSK-Mounting



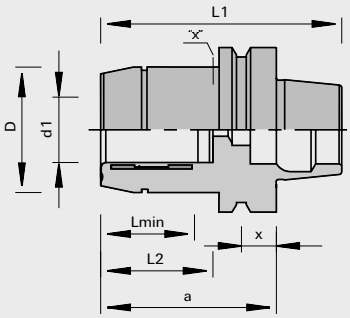
933240

Hydro Clamping Chuck ps-System with HSK 63F

Product



Drawing



Machine / Application

- CNC machining centers with automatic tool changer
- for precise clamping of shank-type tools with cylindrical shank

Design

- n max = 30,000 min -1
- interface DIN 69893 HSK 63 F

Advantages

- minimization of setup-times thanks to easy and quick tool change
- high cutting quality and long edge lives thanks to high concentricity
- optimum torque transfer

Notes

- for right- and lefthand rotation
- with bore for installation of micro chips for electronic tool detection
- x = pressurization by means of screwdriver
- hexagonal screwdriver is not included in delivery
- Lmin minimum clamping length = minimum shaft length

Ø d1	Lmin	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
10	31	41	HSK 63F	30	105	80	18	1.2	184725 L
12	36	46	HSK 63F	32	105	80	18	1.16	184306 L
16	39	49	HSK 63F	38	105	80	18	1.20	184307 L
20	41	51	HSK 63F	52.5	105	80	18	1.30	184308 L
25	47	57	HSK 63F	52.5	109	84	18	1.28	184309 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Ø d1	Lmin	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
3/8"	31	41	HSK 63F	30	105	80	18	1.2	184724 L
1/2"	36	47,5	HSK 63F	32	105	80	18	1.2	184726 L
[inch]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Suitable for	Class-No.	PU	Ident-No.
Screwdrivers	SW4x100	184306, 184724, 184725, 184726	985730	1	166091 L
Screwdrivers	SW5x150	184307, 184308, 184309	985730	1	168703 L
	[mm]			[pc.]	

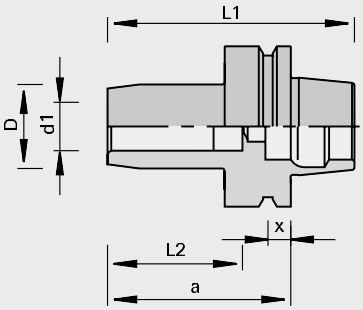
933299

TRIBOS Power Shrink Chucks

Product



Drawing



LEUCO CNC

Machine / Application

- CNC machining centers with automatic tool changer
- for precise clamping of shank-type tools with cylindrical shank

Design

- n max = 40,000 min-1

Advantages

- low weight is easy on machine bearing
- suitable for high RPM´s
- optimum chip extraction thanks to slim design
- increased process safety, long edge lives and high machining quality thanks to very high concentricity and repeating accuracy (< 0.003 mm)

Notes

- for right- and lefthand rotation
- different diameters upon request
- allowed projection: 4 x d1
- clamping of the tools by means of the clamping device
- can also be done at LEUCO upon request
- TRIBOS chuck with reinforced design especially for heavy roughing can be delivered upon request
- delivery without retaining bolts; please choose retaining bolts according to the machine (see page with retaining bolts)

Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
12	48,5	HSK 63F	19	100	75	18	0.69	180257 L
16	48,5	HSK 63F	26	100	75	18	0.74	180899 L
20	52,9	HSK 63F	30	100	75	18	0.77	180258 L
25	55	HSK 63F	35	100	75	18	0.79	180710 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Ø d1	L2	Ø d	Ø D	L1	a	Ident-No.
20	55	SK 30 (DIN)	30	127	80	180888 L
25	55	SK 30 (DIN)	35	127	80	180836 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

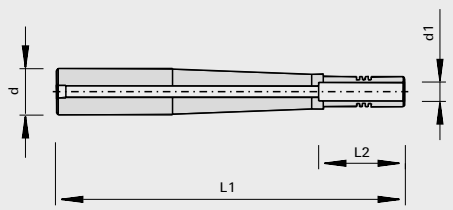
Spare parts		Class-No.	PU	Ident-No.
Mounting Devices (manual)		985201	1	180261 L
Mounting Devices (automatic)		985201	1	181159 S
Reducing inserts for Mounting Device	for Ø d = 6	955530	1	183719 C
Reducing inserts for Mounting Device	for Ø d = 8	955530	1	183720 C
Reducing inserts for Mounting Device	for Ø d = 10	955530	1	183721 C
Reducing inserts for Mounting Device	for Ø d = 12	955530	1	180263 L
Reducing inserts for Mounting Device	for Ø d = 16	955530	1	180902 L
Reducing inserts for Mounting Device	for Ø d = 20	955530	1	180264 L
Reducing inserts for Mounting Device	for Ø d = 25	955530	1	180711 C
Length Adjustment Gauge TRIBOS system	without interface cable	985300	1	180828 C
Interface Cables for Adjusting Gauges	for RS 232C interface	985300	1	180829 S
			[pc.]	

933299

TRIBOS extension

Product

Drawing



Machine / Application

- for mounting of shank-type tools with cylindrical shank in Sino, TRIBOS, PS 2000-E

Design

- shank diameter tolerance h7 or g7

Advantages

Notes

- minimum clamping length = L2
- clamping and unclamping of the tools with TRIBOS clamping device

Ø d1	L2	Ø d	L1	nmax	Ident-No.
6	27	20	100	40000	182800 O
8	27	20	100	40000	182801 O
10	32	20	100	40000	182802 O
12	37	20	100	40000	182803 O
6	27	20	150	24000	182804 O
8	27	20	150	24000	182805 O
10	32	20	150	24000	182806 O
12	37	20	150	24000	182807 O
6	27	20	250	6000	182808 O
8	27	20	250	6000	182809 O
10	32	20	250	6000	182810 O
12	37	20	250	6000	182811 O
[mm]	[mm]	[mm]	[mm]	[min-1]	

Spare parts		Class-No.	PU	Ident-No.
Reducing inserts for Mounting Device	for Ø d = 6	955530	1	183719 C
Reducing inserts for Mounting Device	for Ø d = 8	955530	1	183720 C
Reducing inserts for Mounting Device	for Ø d = 10	955530	1	183721 C
Reducing inserts for Mounting Device	for Ø d = 12	955530	1	180263 L
			[pc.]	

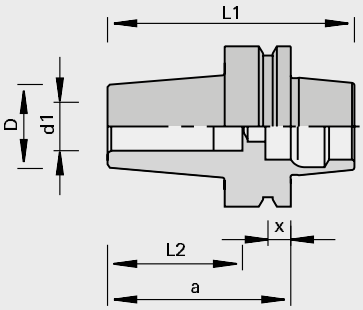
933297

Heat-Shrinking Chucks

Product



Drawing



LEUCO CNC

Machine / Application

- CNC machining centers with automatic tool changer
- for precise clamping of shank-type tools with cylindrical shank

Design

- n max = 30,000 min-1
- interface DIN 69893 HSK 63F
- from high-quality hot work tool steel

Advantages

- increased process safety, long edge lives and high machining quality thanks to very high concentricity and repeating accuracy (< 0.003 mm)

Notes

- for clockwise and counter-clockwise rotation
- can be clamped and unclamped with all conventional shrinking devices

Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
6,0	36	HSK 63F	20	100	75	18	0.81	186684 L
8,0	36	HSK 63F	20	100	75	18	0.81	186685 L
10	41	HSK 63F	26	100	75	18	0.88	183081 L
12	47	HSK 63F	28	100	75	18	0.830	183082 L
14	47	HSK 63F	28	100	75	18	0.91	183083 L
16	51	HSK 63F	28	100	75	18	0.850	183084 L
18	51	HSK 63F	30	100	75	18	1.01	183085 L
20	51	HSK 63F	30	100	75	18	0.930	183086 L
25	51	HSK 63F	30	100	75	18	0.91	183087 L
25	134	HSK 63F	36	185	160	18	1.96	185520 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

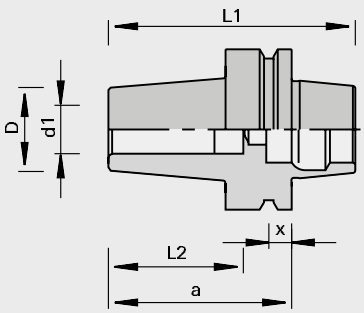
933297

Heat-Shrinking Chucks - joinery machines

Product



Drawing



LEUCO CNC

Machine / Application

- joinery machines
- for precise clamping of shank-type tools with cylindrical shank and reduced Hundegger shaft

Design

- n max = 30,000 min-1
- interface DIN 69893 HSK 63F, HSK 63E, HSK 80A, HSK 80E, HSK 80F, HSK 100A
- from high-quality hot work tool steel

Advantages

- increased process safety, long edge lives and high machining quality thanks to very high concentricity and repeating accuracy (< 0.003 mm)

Notes

- for clockwise and counter-clockwise rotation
- can be clamped and unclamped with all conventional shrinking devices

Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
20	52	HSK 63E	33	112	80	18	1.5	80483321 S
20	52	HSK 63E	33	112	85	18	1.6	80483322 S
20	52	HSK 63E	33	132	100	18	1.2	80483319 C
20	52	HSK 63E	33	192	160	18	1.8	80483305 O
20	52	HSK 63E	33	207	175	18	2.5	80483323 S
25	58	HSK 63E	44	112	85	18	1.6	80483341 S
25	58	HSK 63E	44	147	115	18	1.8	80483334 C
25	58	HSK 63E	44	192	160	18	2.5	80483313 O
30	62	HSK 63E	44	132	100	18	1.5	80483361 S
30	62	HSK 63E	44	177	145	18	3.6	80483362 S
30	62	HSK 63E	44	217	185	18	2.8	80483363 S
30	62	HSK 63E	44	242	210	18	2.8	80483364 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
20	52	HSK 63F	33	100	75	18	0.9	80483302 O
20	52	HSK 63F	33	185	160	18	1.8	80483301 O
20	52	HSK 63F	33	210	185	18	2.6	80483320 S
25	58	HSK 63F	44	100	75	18	1.0	80483311 O
25	58	HSK 63F	44	160	135	18	3.0	80483335 S
25	58	HSK 63F	44	185	160	18	2.5	80483332 C
25	58	HSK 63F	44	210	185	18	2.7	80483336 S
25	58	HSK 63F	44	225	200	18	3.2	80483310 O
30	62	HSK 63F	44	100	75	18	0.9	80483317 O
30	62	HSK 63F	44	120	95	18	1.7	80483355 S
30	62	HSK 63F	44	225	200	18	3.2	80483354 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
20	52	HSK 80A	33	145	105	18	1.6	80483306 O
20	52	HSK 80A	33	200	160	18	2.2	80483307 O
20	52	HSK 80A	33	240	200	18	2.6	80483308 O
25	58	HSK 80A	44	155	115	18	2.2	80483314 O
25	58	HSK 80A	44	200	160	18	2.9	80483352 C
25	58	HSK 80A	44	240	200	18	3.5	80483353 C
30	62	HSK 80A	44	115	75	18	1.6	80483368 S
30	62	HSK 80A	44	135	95	18	1.8	80483369 S
30	62	HSK 80A	44	135	95	18	1.7	80483378 C
30	62	HSK 80A	44	152	112	18	2.1	80483370 S
30	62	HSK 80A	44	185	145	18	3.8	80483371 S
30	62	HSK 80A	44	215	175	18	4.1	80483372 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
30	62	HSK 80A	44	225	185	18	4.3	80483373 S
30	62	HSK 80A	44	245	205	18	4.5	80483374 S
40	62	HSK 80A	58	135	95	18	2.0	80483379 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
20	52	HSK 80E	33	115	75	18	1.4	80483324 S
20	52	HSK 80E	33	225	185	18	3.0	80483325 S
25	58	HSK 80E	44	115	75	18	1.5	80483342 S
25	58	HSK 80E	44	160	120	18	3.0	80483343 S
25	58	HSK 80E	44	225	185	18	3.8	80483344 S
25	58	HSK 80E	44	245	205	18	4.5	80483345 S
30	62	HSK 80E	44	115	75	18	1.6	80483365 S
30	62	HSK 80E	44	225	185	18	3.0	80483366 S
30	62	HSK 80E	44	245	205	18	3.1	80483367 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
20	52	HSK 80F	33	112	80	18	1.4	80483303 O
20	52	HSK 80F	33	192	160	18	2.2	80483304 O
25	58	HSK 80F	44	112	80	18	1.5	80483333 C
25	58	HSK 80F	44	117	85	18	1.6	80483337 S
25	58	HSK 80F	44	177	145	18	3.4	80483338 S
25	58	HSK 80F	44	192	160	18	2.9	80483312 O
25	58	HSK 80F	44	207	175	18	2.4	80483339 S
25	58	HSK 80F	44	237	205	18	2.5	80483340 S
30	62	HSK 80F	44	107	75	18	1.2	80483356 S
30	62	HSK 80F	44	144	112	18	1.8	80483357 S
30	62	HSK 80F	44	207	175	18	2.5	80483358 S
30	62	HSK 80F	44	217	185	18	2.8	80483359 S
30	62	HSK 80F	44	237	205	18	3.2	80483360 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
20	52	HSK 100A	33	125	75	18	1.8	80483326 S
20	52	HSK 100A	33	135	85	18	1.7	80483327 S
20	52	HSK 100A	33	155	105	18	2.5	80483331 C
20	52	HSK 100A	33	195	145	18	4.0	80483328 S
20	52	HSK 100A	33	210	160	18	3.1	80483309 O
20	52	HSK100A	33	225	175	18	2.7	80483329 S
20	52	HSK 100A	33	235	185	18	2.8	80483330 S
25	58	HSK 100A	44	125	75	18	1.8	80483346 S
25	58	HSK 100A	44	145	90	18	1.8	80483347 S
25	58	HSK 100A	44	165	115	18	3	80483315 O
25	58	HSK 100A	44	195	145	18	4.0	80483348 S
25	58	HSK 100A	44	210	160	18	3.7	80483316 O
25	58	HSK 100A	44	225	175	18	4.5	80483349 S
25	58	HSK 100A	44	235	185	18	2.9	80483350 S
25	58	HSK 100A	44	255	205	18	3.7	80483351 S
30	62	HSK 100A	44	125	75	18	1.9	80483375 S
30	62	HSK 100A	44	195	145	18	4.0	80483376 S
30	62	HSK 100A	44	235	185	18	3.0	80483377 S
40	90	HSK 100A	90	200	150	18	6.4	80483318 O
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

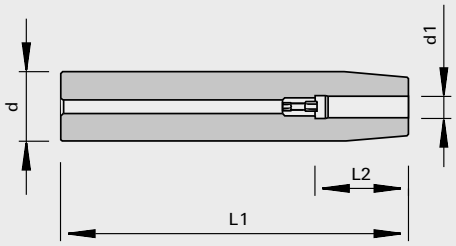
933297

Heat-shrinking chuck extensions CELSIO

Product



Drawing



Machine / Application

- CNC machining centers
- for milling applications with difficult to reach workpiece areas

Design

- hot work tool steel with special surface treatment process for particularly long tool life, temperature resistance and form stability
- run-out accuracy < 0.003 measured in the clamping diameter
- with adjusting screw for length adjustment

Advantages

- also shanks with Weldon or Whistle notch can be used
- best clamping results are achieved with fully cylindrical shanks with tolerance h6
- slim construction according to DIN 69882-8
- shrinking of HW and HS tools with shank tolerance h6

Notes

- clamping elements: we recommend hydro expansion chuck ps-System, TRIBOS or heat shrink-fit chuck

Ø d1 [mm]	L2 [mm]	Ø d [mm]	L1 [mm]	nmax [min-1]	Ident-No.
8	34	25	160	8000	185243 S
10	42	25	160	8000	185244 C
12	47	25	160	8000	185245 C
16	50	25	160	8000	185246 O

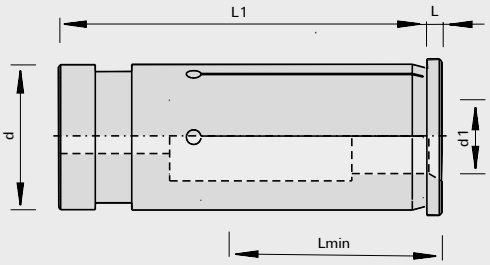
933280

Universal Reducing Bushings, highly precise

Product



Drawing



LEUCO CNC

Machine / Application

- for holding shank tools in TRIBOS, ps-System and all standard hydro expansion chuck

Design

- concentric accuracy ≤ 0.003 mm
- shank diameter tolerance h7 or g7
- coolant-tight up to 80 bar

Advantages

- permanent concentricity and tool-change repeat accuracy ≤ 0.003 mm

Notes

- Lmin minimum clamping length = minimum shaft length

Ø d1	Ø d1	Lmin	Ø d	L1	L	Ident-No.
3		27	12	45	2.0	183022 O
4		27	12	45	2.0	183023 C
5		27	12	45	2.0	183024 O
6		27	12	45	2.0	183025 L
8		27	12	45	2.0	183026 L
8		27	16	47.5	2.5	186099 L
10		32	16	47.5	2.5	186100 L
12		37	16	47.5	2.5	186101 L
3		27	20	50.5	2.0	183027 O
	1/8	27	20	50.5	2.0	186914 O
4		27	20	50.5	2.0	183028 O
5		27	20	50.5	2.0	183029 O
6		27	20	50.5	2.0	183030 C
8		27	20	50.5	2.0	183032 L
10		32	20	50.5	2.0	183034 L
12		37	20	50.5	2.0	183036 L
14		37	20	50.5	2.0	183038 O
16		38	20	50.5	2.0	183040 L
6		27	25	54.5	3.0	182304 L
8		27	25	54.5	3.0	182305 L
10		32	25	54.5	3.0	182306 L
12		37	25	54.5	3.0	182307 L
14		37	25	54.5	3.0	182308 L
16		38	25	54.5	3.0	182309 L
18		38	25	54.5	3.0	182310 L
20		42	25	54.5	3.0	182311 L
	1/2″	37	25	54.5	3.0	182653 L
	3/4″	42	25	54.5	3.0	182655 L
[mm]	[inch]	[mm]	[mm]	[mm]	[mm]	

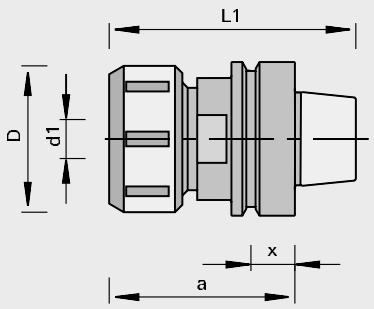
933289

Draw-In Collet Chucks with HSK shank

Product



Drawing



Machine / Application

- CNC machining centers with automatic tool changer
- Use on joinery machines
- for precise clamping of shank-type tools with cylindrical shank

Design

- interface according to DIN 69893 HSK 50F, HSK 63F, HSK 63E, HSK 80A, HSK 80C, HSK 80E, HSK 80F and HSK 100A
- lock nut with sleeve bearing

Advantages

- flexible utilization by collet chucks

Notes

- for right- and lefthand rotation
- Ident-No. 175795 for IMA (up to 12/94) similar to DIN 69893
- Ø d1 = collet chuck diameter 2 - 25 mm and 3 - 30 mm
- collet chucks according to DIN 6388: 1) type 462E/OZ25/ 2) type 472E/ER40
- included in delivery: collet chuck, clamping nut without spanner wrench
- attention: different interfaces in case of CMS machines, according to spindle performance (KW)

Ø d1	Ø d	Ø D	L1	a	x	Type		Ident-No.
2-25	HSK 63F	60	101	76	18	1	Homag, IMA from 01/95, Weeke from 03/98, HOLZ-HER, SCM, CMS (12+15 KW)	173293 L
3-30	HSK 63E	63	103	78	18	2	CMS (18 KW), joinery machines by Weinmann and Hundegger	180359 O
2-25	HSK 63F	60	101	76	9.0	1	IMA up to 12/94	175795 L
2-25	HSK 63F	60	140	115	18	1	Homag, IMA from 01/95, Weeke from 03/98, HOLZ-HER, CMS (12+15 KW)	179170 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

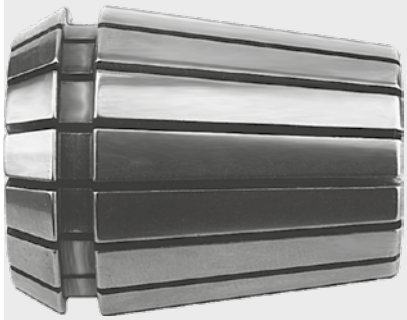
Spare parts	Dimension	Class-No.	PU	Ident-No.
Clamping Nuts	M48x2R	995290	1	178764 L
Hook Wrenches	58/62 DIN 1810	985720	1	169299 L
Hook wrenches adapter	58/62 DIN 1810	985300	1	186765 L
Torque wrench	40-200 Nm	985300	1	184890 L
Single-Head Engineers Wrenches	SW46x10 DIN 894	985720	1	178760 L
Blind plug with screw	11,9x6,9xM5	995300	1	185610 L
	[mm]		[pc.]	

Ø d1	Ø d	Ø D	L1	a	x	Type		Ident-No.
3-30	HSK 80A	80	110	85	18	2	Joinery machines by Weinmann and Hundegger	80480510 C
3-30	HSK 80C	80	101	76	18	2	Joinery machines by Weinmann and Hundegger	80480509 C
3-30	HSK 80E	80	101	76	18	2	Joinery machines by Weinmann and Hundegger	80480508 C
3-30	HSK 80F	80	93	76	18	2	Joinery machines by Weinmann and Hundegger	80480507 C
3-30	HSK 100A	100	120	85	18	2	Joinery machines by Weinmann and Hundegger	80480511 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

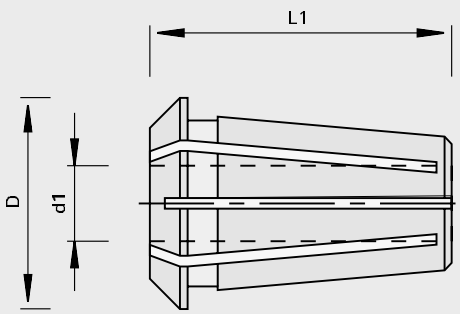
933280

Precision collets - 462E/OZ25

Product



Drawing



Machine / Application

- for use in draw-in collet chuck Type 462E/OZ25

Design

- clamping tolerance 0.5 mm
- according to DIN 6388 Type 462E/OZ25

Advantages

- optimum transmission of clamping force thanks to 12 slots from top and bottom

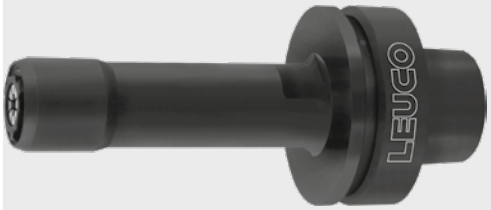
Notes

Ø d1	Ø d1	Ø D	L1	Ident-No.
2		35.05	52	183803 O
3		35.05	52	183804 L
4		35.05	52	183805 L
5		35.05	52	183806 L
6		35.05	52	180213 L
	1/4″	35.05	52	175815 L
7		35.05	52	183807 O
8		35.05	52	180358 L
	3/8″	35.05	52	185275 L
10		35.05	52	170782 L
12		35.05	52	168742 L
	1/2″	35.05	52	175820 L
13		35.05	52	180215 L
14		35.05	52	170783 L
	5/8″	35.05	52	175823 L
15		35.05	52	183808 O
16		35.05	52	168743 L
18		35.05	52	180216 L
	3/4″	35.05	52	175826 L
20		35.05	52	168744 L
25		35.05	52	168745 L
[mm]	[inch]	[mm]	[mm]	

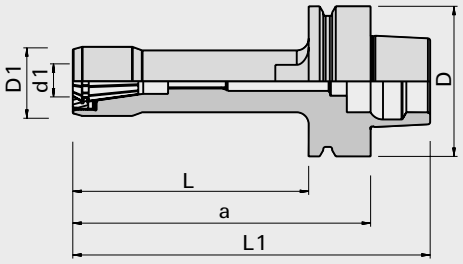
933289

Draw-in collet chuck system 426E/ER16 with HSK 63F - clamping zone Ø 1-10 mm

Product



Drawing



Machine / Application

- CNC machining centers, especially 5-axis
- for precise clamping of shank-type tools with cylindrical shank

Design

- internal collet nut
- hardened and ground
- for double-slotted collets
- n max = 24,000 min-1

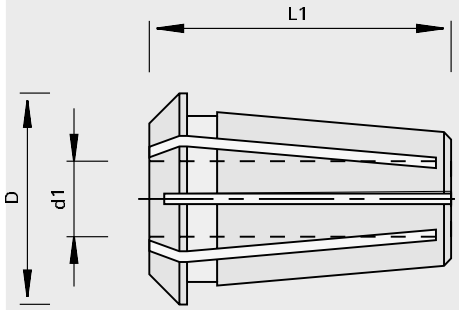
Advantages

- slim design
- high stability even with large projection
- high concentric accuracy
- high clamping force

Notes

- also available for left-hand sense of rotation
- included in delivery: collet chuck with clamping nut, without collet and mounting accessories
- torques: 426E/ER16: 50 Nm (44 Lbf.ft)

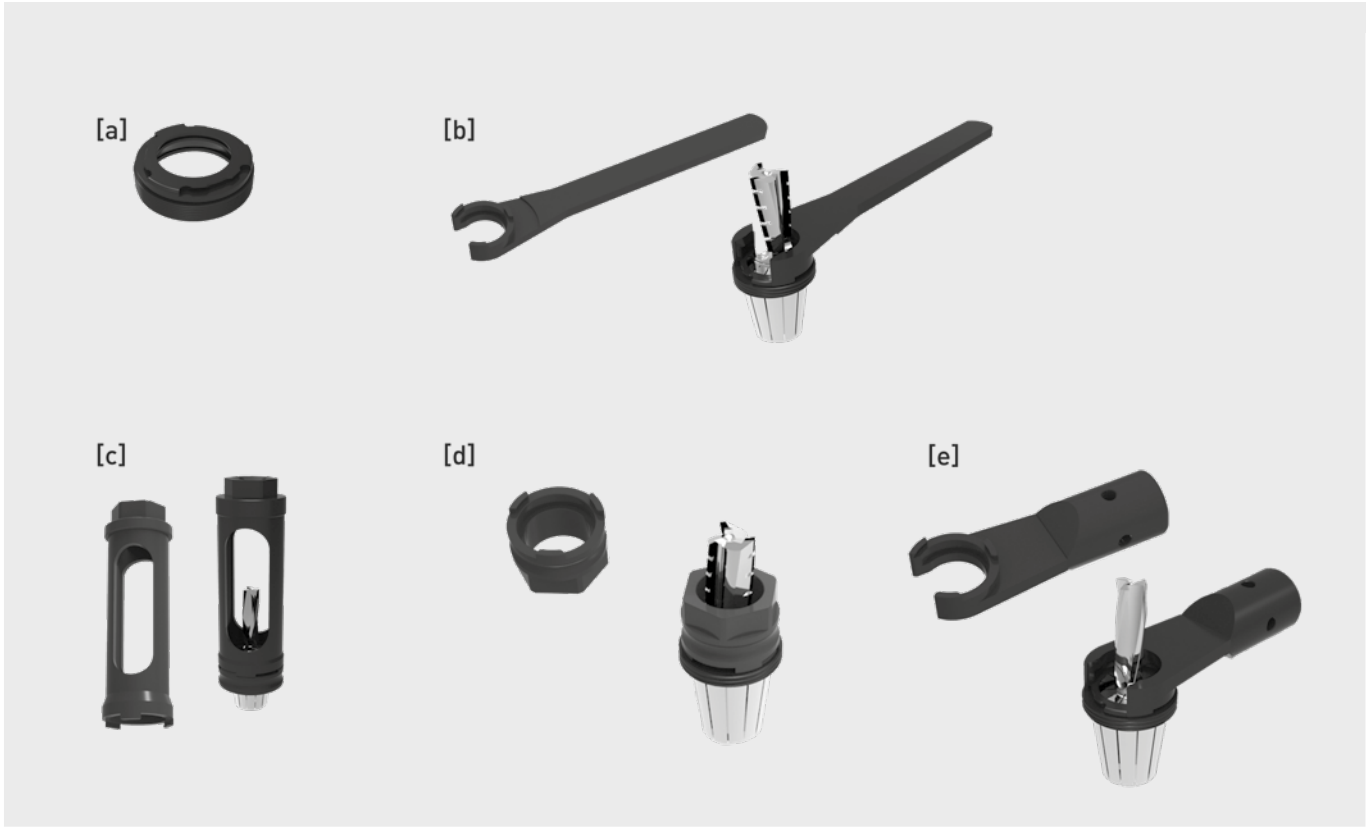
Ø d1	Ø D1	Ø d	Ø D	L	L1	a	Ident-No.
1-10	29	HSK 63F	63	50	101	76	184847 L
1-10	29	HSK 63F	63	74	125	100	184848 L
1-10	29	HSK 63F	63	99	150	125	184849 L
1-10	29	HSK 63F	63	124	175	150	184850 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	



Collets 426E / ER 16

Ø d1	Ø D	L1	Ident-No.
1	17.25	27.5	184865 O
2	17.25	27.5	184866 O
3	17.25	27.5	184867 O
4	17.25	27.5	184868 O
5	17.25	27.5	184869 O
6	17.25	27.5	184870 L
7	17.25	27.5	184871 O
8	17.25	27.5	184872 L
9	17.25	27.5	184873 O
10	17.25	27.5	184874 L
[mm]	[mm]	[mm]	

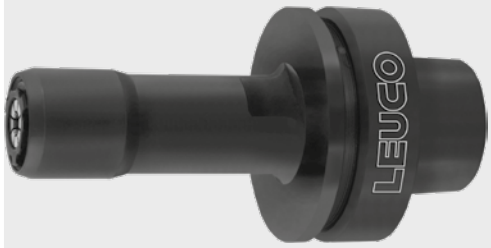
Accessories	Dimension	Class-No.	PU	Ident-No.
[a] Clamping Nuts		995290	1	184875 L
[b] Hand Spanner		985720	1	184878 L
[c] Torque Nut		985720	1	184884 L
[d] Screw-in aid		985720	1	184881 L
[e] torque adapter		985300	1	184887 L
[f] torque wrench	40-200 Nm	985300	1	184890 L
	[mm]		[pc.]	



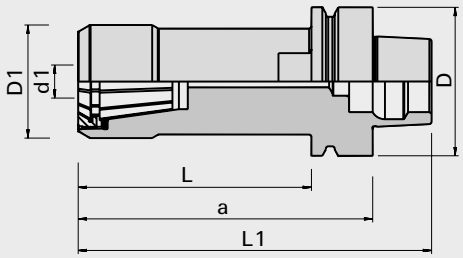
933289

Draw-in collet chuck system 470E/ER32 with HSK 63F - clamping zone Ø 2-20 mm

Product



Drawing



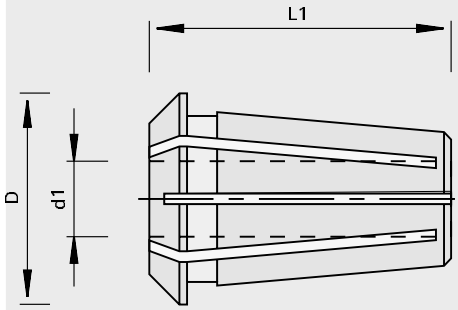
Machine / Application
- CNC machining centers, especially 5-axis
- for precise clamping of shank-type tools with cylindrical shank

Design
- internal collet nut
- hardened and ground
- for double-slotted collets
- n max = 24,000 min-1

Advantages
- slim design
- high stability even with large projection
- high concentric accuracy
- high clamping force

Notes
- also available for left-hand sense of rotation
- included in delivery: collet chuck with clamping nut, without collet and mounting accessories
- torque: 470E/ER32:130 Nm (96 Lbf.ft)

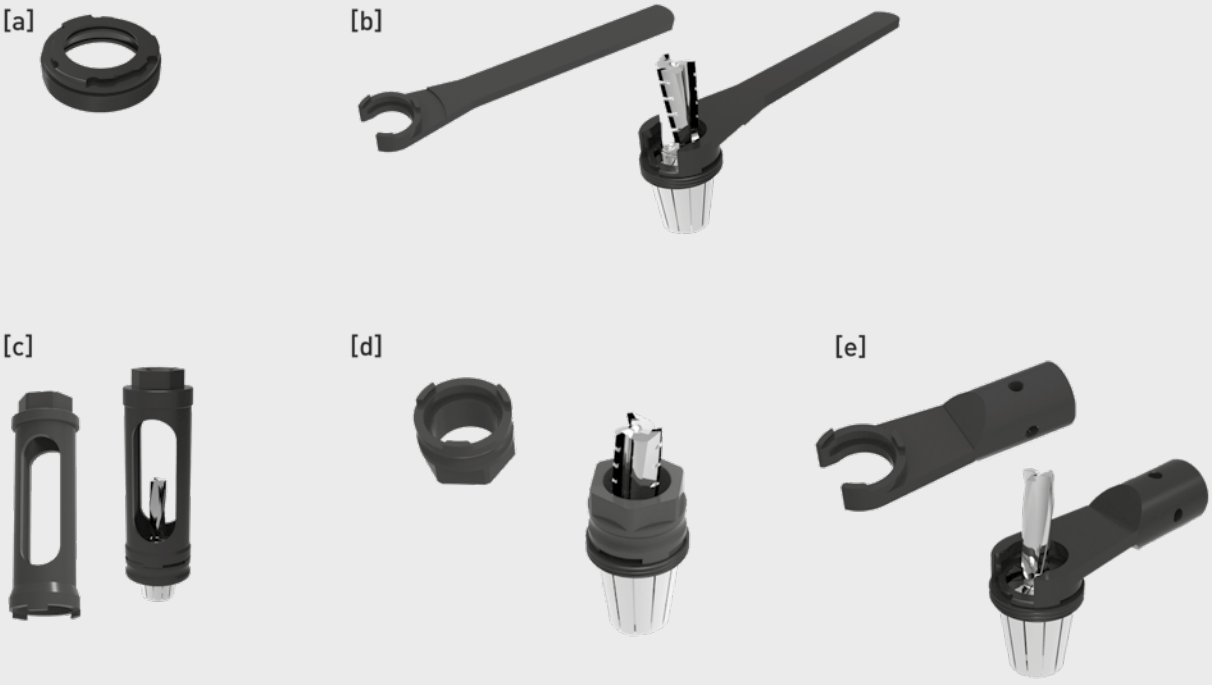
Ø d1	Ø D1	Ø d	Ø D	L	L1	a	Ident-No.
2-20	48	HSK 63F	63	34	85	60	184851 L
2-20	48	HSK 63F	63	44	95	70	184852 C
2-20	48	HSK 63F	63	89	140	115	184853 L
2-20	48	HSK 63F	63	99	150	125	184854 L
2-20	48	HSK 63F	63	124	175	150	184855 C
2-20	48	HSK 63F	63	154	205	180	184856 L
2-20	48	HSK 63F	63	174	225	200	184857 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	



Collets 470E / ER 32

Ø d1	Ø D	L1	Ident-No.
3	33	40	173647 C
4	33	40	173648 C
5	33	40	173649 C
6	33	40	173650 L
7	33	40	173651 C
8	33	40	173652 L
10	33	40	173653 L
12	33	40	173654 L
13	33	40	173655 C
14	33	40	173656 C
16	33	40	173657 L
18	33	40	173658 C
19	33	40	173659 C
20	33	40	173660 L
[mm]	[mm]	[mm]	

Accessories	Dimension	Class-No.	PU	Ident-No.
[a] Clamping Nuts		995290	1	184876 L
[b] Hand Spanner		985720	1	184879 L
[c] Torque Nut		985720	1	184885 L
[d] Screw-in aid		985720	1	184882 L
[e] torque adapter		985300	1	184888 L
[f] torque wrench	40-200 Nm	985300	1	184890 L
	[mm]		[pc.]	



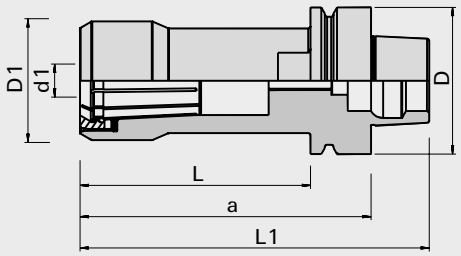
933289

Draw-in collet chuck system 462E/OZ25 with HSK 63F - clamping zone Ø 2-25 (1″) mm

Product



Drawing



Machine / Application

- CNC machining centers, especially 5-axis
- for precise clamping of shank-type tools with cylindrical shank

Design

- internal collet nut
- hardened and ground
- for double-slotted collets
- n max = 24,000 min-1

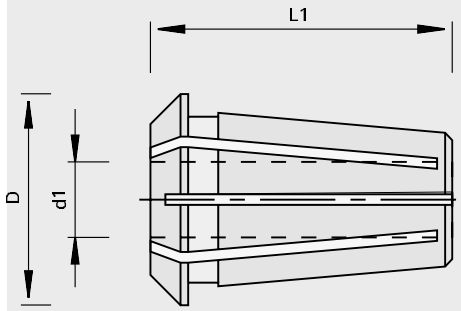
Advantages

- slim design
- high stability even with large projection
- high concentric accuracy
- high clamping force

Notes

- also available for left-hand sense of rotation
- included in delivery: collet chuck with clamping nut, without collet and mounting accessories
- torques: 462E/OZ25: 150 Nm (110 Lbf.ft)

Ø d1	Ø D1	Ø d	Ø D	L	L1	a	Ident-No.
2-25	51	HSK 63F	63	50	101	76	184858 L
2-25	51	HSK 63F	63	89	140	115	184860 L
2-25	51	HSK 63F	63	124	175	150	184861 C
2-25	51	HSK 63F	63	149	200	175	184862 C
2-25	51	HSK 63F	63	174	225	200	184863 O
2-25	51	HSK 63F	63	199	250	225	184864 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	



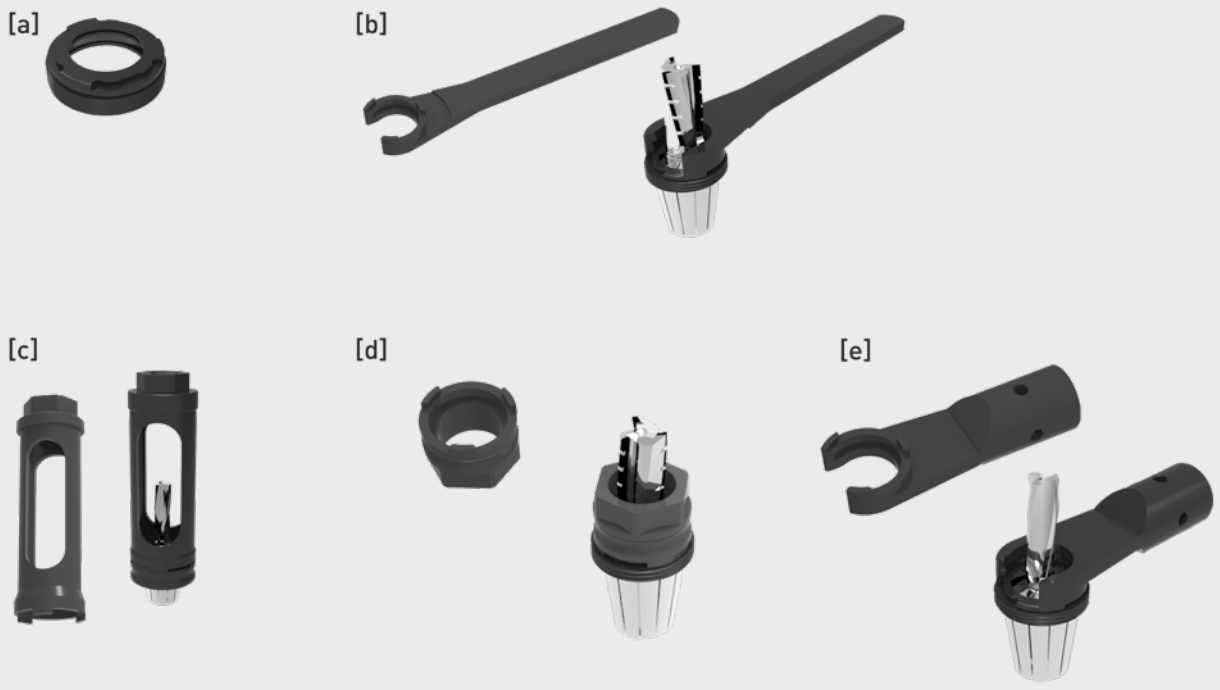
HSK-F63 Collet chucks 462E / OZ 25 /

Ø d1	Ø d1	Ø D	L1	Ident-No.
2		35.05	52	183803 O
3		35.05	52	183804 L
4		35.05	52	183805 L
5		35.05	52	183806 L
6		35.05	52	180213 L
	1/4″	35.05	52	175815 L
7		35.05	52	183807 O
8		35.05	52	180358 L
	3/8″	35.05	52	185275 L
10		35.05	52	170782 L
12		35.05	52	168742 L
	1/2″	35.05	52	175820 L
13		35.05	52	180215 L
14		35.05	52	170783 L
	5/8″	35.05	52	175823 L
15		35.05	52	183808 O
[mm]	[inch]	[mm]	[mm]	

HSK-F63 Collet chucks 462E / OZ 25 /

Ø d1	Ø d1	Ø D	L1	Ident-No.
16		35.05	52	168743 L
18		35.05	52	180216 L
	3/4"	35.05	52	175826 L
20		35.05	52	168744 L
25		35.05	52	168745 L
[mm]	[inch]	[mm]	[mm]	

Accessories	Dimension	Class-No.	PU	Ident-No.
[a] Clamping Nuts		995290	1	184877 L
[b] Hand Spanner		985720	1	184880 L
[c] Torque Nut		985720	1	184886 L
[d] Screw-in aid		985720	1	184883 L
[e] torque adapter		985300	1	184889 L
[f] torque wrench	40-200 Nm	985300	1	184890 L
	[mm]		[pc.]	



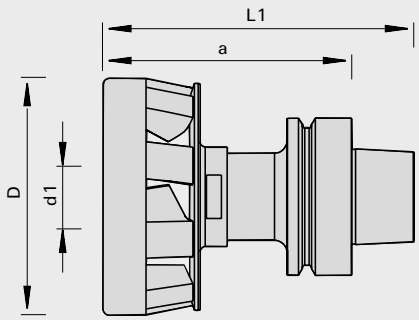
933285

AEROTECH-System Uni-T with HSK 63F with collet chuck adapter

Product



Drawing



Aerotech System

Machine / Application

- CNC machining centers
- for grooving, rabbeting in the case of pocket milling and dividing cuts as well as for the optimization of production processs e.g. with Nesting applications
- for tools with shank diameter up to 16 mm

Design

- tool adapter with internal clamping nut
- 9 wing design for the processing of particle board, MDF, OSB, hard wood etc.
- balance quality G=2.5
- n max. = 24,000 rpm

Advantages

- stopping of the chip flow
- cooling of the tool
- reduction of the dust quantity
- reduced efforts for cleaning and maintenance

Notes

- required for tool assembly: Wrench socket no. 184366 and torque wrench
- recommended: commercial torque wrench ½", alternatively torque wrench Z16 (No. 184890) and clip-on ratchet Z16 – ½" (No. 186109)
- tightening torque: 80 Nm
- sufficient vacuum performance is necessary for Nesting
- please observe the information in the operating instructions

Ø d1	Ø d	Ø D	L1	a		Ident-No.
6-16	HSK 63F	105	125	100	Standard	186107 L
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Collet Chucks	411E ØD=1	933280	1	184367 S
Collet Chucks	411E ØD=2	933280	1	184368 S
Collet Chucks	411E ØD=3	933280	1	184369 S
Collet Chucks	411E ØD=4	933280	1	184370 C
Collet Chucks	411E ØD=5	933280	1	184371 C
Collet Chucks	411E ØD=6	933280	1	184372 L
Collet Chucks	411E ØD=8	933280	1	184373 L
Collet Chucks	411E ØD=10	933280	1	184374 L
Collet Chucks	411E ØD=12	933280	1	184375 L
Collet Chucks	411E ØD=16	933280	1	184376 L
Clamping Nuts	M32x1,5	995290	1	184378 L
Ratchet	12Zx1/2"	985720	1	186109 L
Wrench socket	ØD=30, SW22, H96	985720	1	184366 L
Torque wrench	40-200 Nm	985300	1	184890 L
	[mm]		[pc.]	

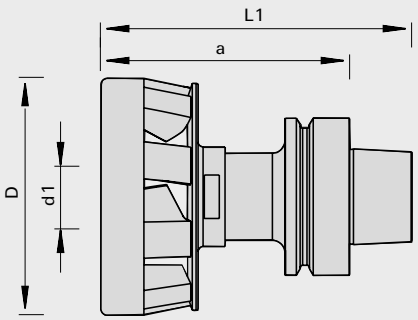
933285

AEROTECH-System with HSK 63F with hydro expansion clamping

Product



Drawing



Aerotech® System

Machine / Application

- CNC machining centers
- for clamping of shank-type tools and simultaneous chip guide when working
- for grooving, rabbeting in the case of pocket milling and dividing cuts as well as for the optimization of production processs e.g. with Nesting applications

Design

- Monolithic tool clamping system
- 7-wing design for machining of low-density wood and wood-based materials
- 9-wing design for machining of particle boards, MDF, OSB, hard wood, etc.
- Tool mounting by means of hydro expansion clamping technology
- Balance quality G<2.5

Advantages

- stopping of the chip flow
- cooling of the tool
- reduction of the dust quantity
- reduced efforts for cleaning and maintenance
- minimization of setup-times thanks to easy and quick tool change with hydro expansion clamping
- high cutting quality and long edge lives thanks to high concentricity
- optimum torque transfer

Notes

- sufficient vacuum performance is necessary
- pressurization via hexagonal screwdriver (included in delivery)
- clamping of smaller shank diameters is possible by means of LEUCO universal reducing sleeves
- please observe the information in the Operating Instructions

Ø d1	Ø d	Ø D	L1	a		Ident-No.
6-16	HSK 63F	95	122.6	97.6	9 wings	185018 L
6-25	HSK 63F	105	131	106	7 wings	186517 S
6-25	HSK 63F	105	131	106	9 wings	184757 L
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screwdrivers with sliding handle for hexagon socket	SW4x100	985730	1	166091 L
	[mm]		[pc.]	

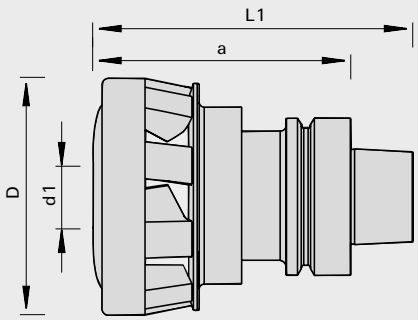
933285

AEROTECH-System FacePlate with HSK 63F with hydro expansion clamping

Product



Drawing



Aerotech System

Machine / Application

- CNC machining centers
- AEROTECH versions also permitted for new HOMAG machines
- can be used on all machine brands
- for clamping of shank-type tools and simultaneous chip guide when working
- for grooving, rabbeting in the case of pocket milling and dividing cuts as well as for the optimization of production processs e.g. with Nesting applications

Design

- AEROTECH-System FacePlate: particularly for nesting applications
- patented monolithic tool clamping system
- 9 wing design for the machining of particle board, MDF, OSB, hard wood etc.
- tool mounting by means of hydro expansion clamping technology
- balance quality G<2.5

Advantages

- stopping of the chip flow
- cooling of the tool
- reduction of the dust quantity
- reduced efforts for cleaning and maintenance
- drawn-in, loose debris can not be trapped in the wing openings
- this reduces the risk that the turbine is clogged which would lead to an imbalance

Notes

- sufficient vacuum performance is necessary
- pressurization via hexagonal screwdriver (included in delivery)
- please observe the information in the Operating Instructions

Ø d1	Ø d	Ø D	L1	a		Ident-No.
6-16	HSK 63F	95	127	102	9 wings	185551 C
6-25	HSK 63F	105	135	110	9 wings	185550 C
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screwdrivers with sliding handle for hexagon socket	SW4x100	985730	1	166091 L
	[mm]		[pc.]	

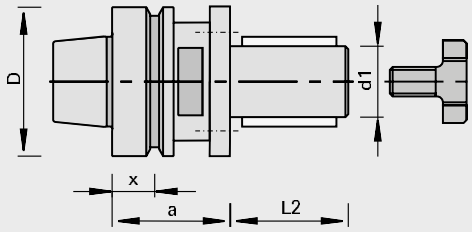
933069

Mounting Arbors with HSK shank

Product



Drawing



Machine / Application

- CNC machining centers with automatic tool changer
- for precise mounting of tools with bore with double keyway

Design

- with 6 pin holes M6 - 8 mm deep TK 48 mm
- interface DIN 69893 HSK 63 F
- clamping length L2 = 50 mm for multiple-part cutters and cutterheads
- secured against rotation with double key

Advantages

- high feed rates thanks to optimum torque transfer

Notes

- for clockwise and counter-clockwise rotation
- spacer ring Ident-No. 181193 consists of: 1 piece 20 mm thick, 1 piece 10 mm thick, 3 piece 5 mm thick, 2 piece 2 mm thick, 1 piece 1 mm thick
- spacer ring set Ident-No. 181194 additionally 1 piece 20 mm thick, 1 piece 10 mm thick
- tool attached with retaining bolt
- included in delivery: clamping arbor with retaining bolt

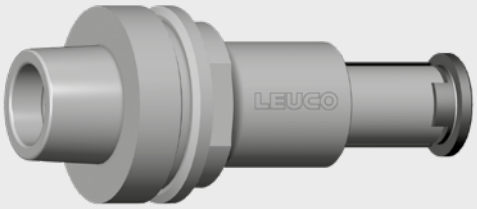
Ø D	Ø d	Ø d1	L2	a	x	DKN	Weight		Ident-No.
63	HSK 63F	30	50	45	18	8x3	1.4	Homag, IMA from 01/95	183748 L
63	HSK 63F	30	80	45	18	8x3	1.5	Homag, IMA from 01/95, HOLZ-HER	183749 L
63	HSK 63F	30	110	45	18	8x3	1.8	Homag, IMA from 01/95, HOLZ-HER	183747 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Single-Head Engineers Wrenches	SW46x10 DIN 894	985720	1	178760 L
Spacer Sets	60x50x30	955521	1	181193 L
Spacer Sets	60x80x30	955521	1	181194 L
Cutter Retaining Bolts with centering ring	M16x38xØ48	995190	1	184061 L
	[mm]		[pc.]	

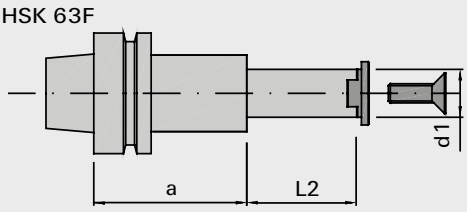
933069

Mounting Arbors HSK 63F

Product



Drawing



Machine / Application

- CNC machining centers with automatic tool changer
- for mounting of Modula sets or single cutters

Design

- interface DIN 69893 HSK 63 F
- secured against rotation with double key

Advantages

Notes

- for right- and lefthand rotation
- included in delivery: mounting arbor with cover and countersunk screw

Ø d	Ø d1	L2	a	Weight	Ident-No.
HSK 63F	25	37	45	1.1	183768 L
HSK 63F	25	85	45	1.2	183769 L
HSK 63F	25	37	80	1.3	183770 S
HSK 63F	25	75	80	1.5	183771 L
[mm]	[mm]	[mm]	[mm]	[kg]	

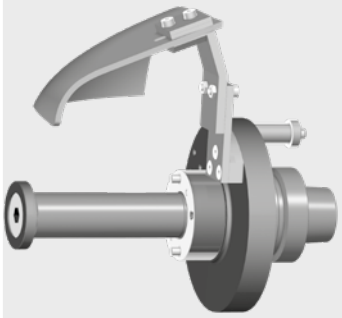
Accessories	Dimension	Class-No.	PU	Ident-No.
Spacers	Ø40x0,1xØ25	955520	1	183756 C
Spacers	Ø40x0,2xØ25	955520	1	183757 C
Spacers	Ø40x0,5xØ25	955520	1	183758 C
Spacers	Ø40x1,0xØ25	955520	1	183759 C
Spacers	Ø40x2,0xØ25	955520	1	183760 C
Spacers	Ø40x4,0xØ25	955520	1	183761 C
Spacers	Ø40x6,0xØ25	955520	1	183762 C
Spacers	Ø40x10xØ25	955520	1	183763 C
Spacers	Ø40x20xØ25	955520	1	183764 C
	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Lid	33x11x25	997300	1	183772 S
Countersunk Screws	M10x30 DIN EN ISO 10642	995121	10	183773 S
Screwdrivers	SW6x200	985730	1	167817 L
	[mm]		[pc.]	

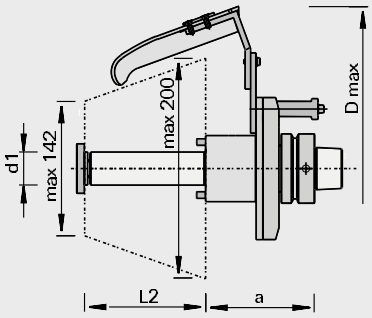
933069

Milling Assemblies with chip directing steel sheet

Product



Drawing



LEUCO CNC

Machine / Application

- CNC-machining centers with C-axis Homag
- for precise mounting of tools with bore

Design

- milling aggregate with integrated chip guiding plate
- Ident-No. 182049 and 182050 with double keyway
- Ident-No. 182075 and 182076 with lid and retaining bolt; 2 carrier pins Ø6 TK 48
- n max = 11,000 min-1 (stock design)
- shank 30 mm, shank length 105 mm

Advantages

- optimized chip removal

Notes

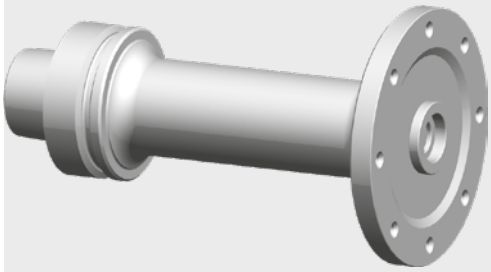
- weight of the component approx. 2 kg (depending on design)
- max. weight of the clamped tool 3,8 kg

Ø Dmax	Ø d	Ø d1	L2	a	DKN		Ident-No. [L]	Ident-No. [R]
300	HSK 63F	30	105	80	8x4	Homag	182049 S	182050 S
300	HSK 63F	30	105	80		Homag	182075 C	182076 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

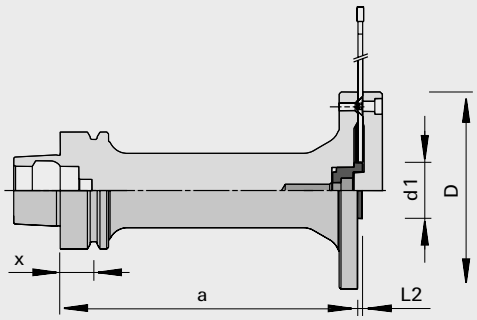
933061

CNC Combi Saw Blade Adapters HSK 63F

Product



Drawing



LEUCO CNC

Machine / Application

- CNC machining centers with automatic tool changer
- for precise mounting of circular saw blades

Design

- interface DIN 69893 HSK 63 F for high-precision adapter to the machine spindle

Advantages

- exchangeable centering adapter can be obtained separately; thus saw blades with different bore diameters can be used on the same mounting device
- the mounting of the saw blade can be made with or without lid
- adapter available with different a measures

Notes

- for right-hand and left-hand rotation
- mounting of the saw directly by means of countersunk screws or lid by means of cylinder head screw
- included in delivery: lid, countersunk screws, cylinder head screws and centering adapter for saw blade bore Ø 30 mm with retaining ring
- Recommendation of the max. saw blade diameter: without lid - Dmax = 360 mm, with lid - Dmax = 430 mm

Ø D	Ø d	Ø d1	L2	a	x	NL	Ident-No.
106	HSK 63F	30	2,5	40	18	8/M5/90	184835 L
106	HSK 63F	30	2,5	50	18	8/M5/90	184836 L
106	HSK 63F	30	2,5	56	18	8/M5/90	187760 L
106	HSK 63F	30	2,5	100	18	8/M5/90	184837 L
106	HSK 63F	30	2,5	130	18	8/M5/90	184838 L
106	HSK 63F	30	2,5	160	18	8/M5/90	184839 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Options	Dimension	Class-No.	PU	Ident-No.
Lid	106x15x20	997300	1	184845 L
Adapter for body thickness 2.0 or 2.2 mm	Ø30	997300	1	185666 L
Adapter	Ø30	997300	1	184840 L
Adapter	Ø31,75	997300	1	184841 S
Adapter	Ø32	997300	1	184842 L
Adapter	Ø35	997300	1	184843 L
Adapter	Ø40	997300	1	184844 L
	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x12 T20 D=Ø9,3	995125	10	166709 L
Head Cap Screws	M5x16 DIN EN ISO 4762	995111	10	001870 L
Head Cap Screws for adapters	M8x12 DIN 7984	995111	10	184846 L
Locking Rings	8/13x8,4x0,7	995460	1	185497 L
	[mm]		[pc.]	

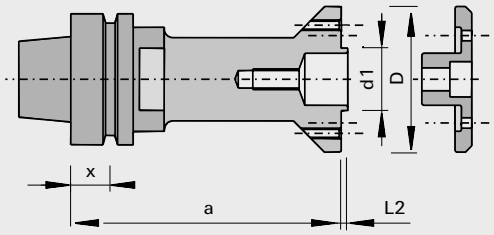
933061

Saw Blade Adapters HSK 63F

Product



Drawing



LEUCO CNC

Machine / Application

- CNC machining centers with automatic tool changer
- for precise mounting of circular saw blades and grooving cutters

Design

- interface DIN 69893 HSK 63 F for high-precision adapter to the machine spindle

Advantages

Notes

- for right-hand and left-hand rotation
- mounting of the saw directly by means of countersunk screws or with lid 183310 by means of cylinder head screw
- included in delivery:
- support with countersunk screw
- lid with cylinder head screws to be ordered separately, if required
- Recommendation of the max. saw blade diameter: without lid - Dmax = 210 mm, with lid - Dmax = 280 mm

Ø D	Ø d	Ø d1	L2	a	NL	Ident-No.
70	HSK 63F	30	1,8	55	8/M5/52 + 2/6/42	187639 L
70	HSK 63F	30	1,8	70	8/M5/52 + 2/6/42	186083 L
70	HSK 63F	30	1,8	130	8/M5/52 + 2/6/42	186432 L
[mm]	[mm]	[mm]	[mm]	[mm]		

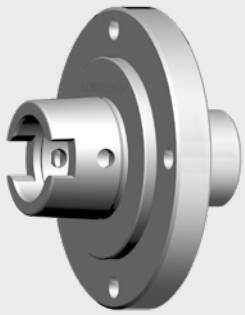
Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x8 T20 D=Ø10	995125	10	164005 L
	[mm]		[pc.]	

Accessories	Dimension	Class-No.	PU	Ident-No.
Cover with 2 pins as twist-lock and cylinder head screw M10	70x24x8 (2/6/42)	997300	1	183310 L
	[mm]		[pc.]	

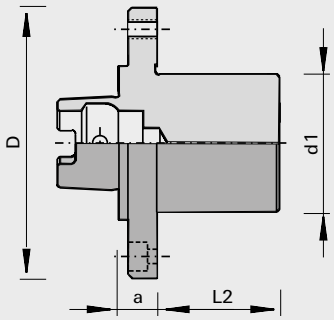
933061

Mounting Arbors HSK 63F modified - without gripper groove

Product



Drawing



Machine / Application

- through-feed machines with tool changer Homag
- d1=30 mm especially for Homag and IMA jointing aggregates
- d1=60 mm especially for flooring manufacturing
- for precise clamping of tools with bore

Design

- interface DIN 69893 HSK 63 F modified for highly precise mounting on the machine spindle

Advantages

- quick tool change
- maintenance-free

Notes

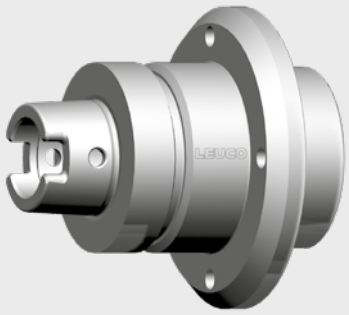
- for clockwise and counter-clockwise rotation

Ø D	Ø d	Ø d1	L2	a	NL		Ident-No.
94	HSK 63F	30	25	16	4/M8/80	furniture	184787 L
120	HSK 63F	60	68	20	4/M8/100 + 4/9/100	Flooring	183616 L
[mm]	[mm]	[mm]	[mm]	[mm]			

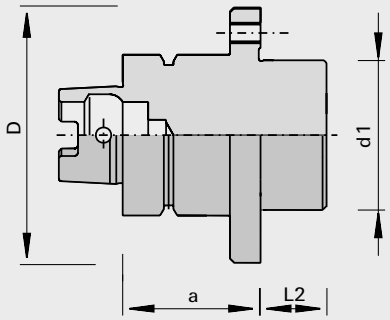
933061

Mounting Arbors HSK 63F modified - with gripper groove

Product



Drawing



Machine / Application

- through-feed machines with tool changer Homag
- for precise clamping of tools with bore

Design

- with pulling grooves
- flange with fastening screw thread
- interface DIN 69893 HSK 63 F for highly precise mounting on the machine spindle

Advantages

- quick tool change

Notes

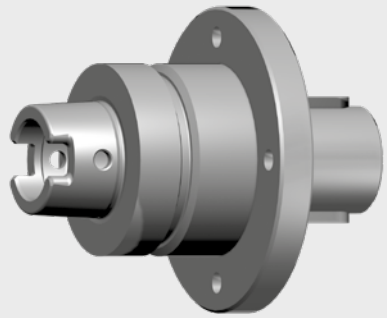
- for clockwise and counter-clockwise rotation

Ø D	Ø d	Ø d1	L2	a	NL	Ident-No.
115	HSK 63F	60	23,5	54	4/M8/80 + 4/M8/100	183615 L
[mm]	[mm]	[mm]	[mm]	[mm]		

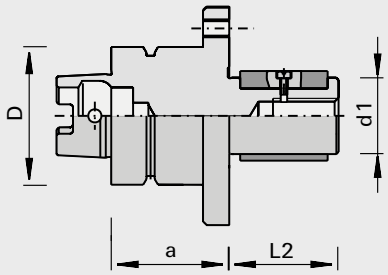
933061

Mounting Arbors HSK 63F modified - 35 DKN, with lid and screws

Product



Drawing



Machine / Application
- through-feed machines with tool changer Homag
- for precise clamping of tools with bore

Design
- with pulling grooves
- flange with fastening screw thread
- interface DIN 69893 HSK 63 F for highly precise mounting on the machine spindle

Advantages
- quick tool change

Notes
- for clockwise and counter-clockwise rotation

Ø D	Ø d	Ø d1	L2	a	NL	Ident-No.
63	HSK 63F	35	40	54	8/M8/80	182689 L
63	HSK 63F	35	50	54	8/M8/80	182124 S
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Head Cap Screws	M16x30	995111	10	182126 O
Lid	60x15x17	997370	1	182127 O
	[mm]		[pc.]	

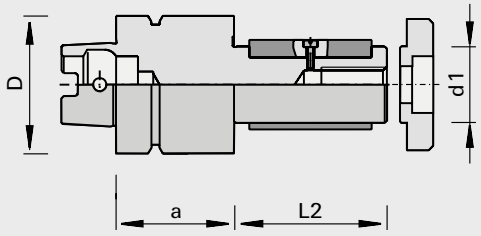
933069

Mounting Arbors HSK 63F modified - 35 DKN, tool directly attached by screws

Product



Drawing



Machine / Application
- through-feed machines with tool changer Homag
- for precise clamping of tools with bore

Design
- with pulling grooves
- with lid and screw (included in delivery)
- interface DIN 69893 HSK 63 F modified for high-precision adapter to the machine spindle

Advantages
- quick tool change

Notes
- for clockwise and counter-clockwise rotation

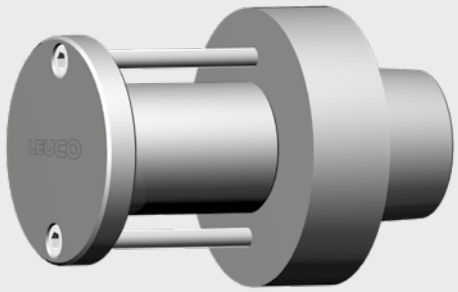
Ø D	Ø d	Ø d1	L2	a	Ident-No.
63	HSK 63F	35	40	54	182123 L
[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Head Cap Screws	M16x30	995111	10	182126 O
Lid	60x15x17	997370	1	182127 O
	[mm]		[pc.]	

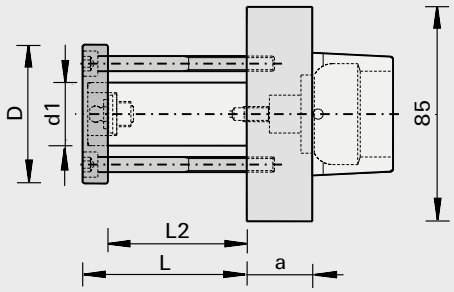
933239

Hydro Tensile Spindles Weinig HSK - clamping length 40-55 mm

Product



Drawing



Machine / Application

- planing machines Weinig Powermat
- for precise clamping of tools with bore

Design

- with hydro-tensile spindle
- n max = 6,000 min-1

Advantages

- precise mounting of tools with bore thanks to hydro-tensile spindle

Notes

- for clockwise and counter-clockwise rotation
- accessories: dummy piece for covering the HSK-interface on spindles not used

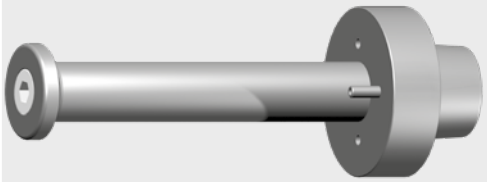
Ø D	Ø d	Ø d1	L2	a	Ident-No.
85	Weinig HSK	30	40	26	181872 S
85	Weinig HSK	30	55	26	181873 S
85	Weinig HSK	40	55	26	181874 C
[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts	Class-No.	PU	Ident-No.
Dummy Pieces (cover)	997300	1 [pc.]	182286 S

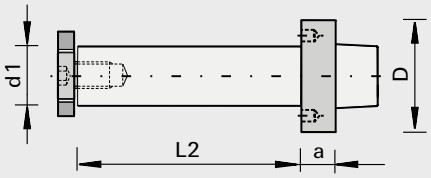
933069

Mounting Arbors Weinig HSK

Product



Drawing



Machine / Application

- profile machines Weinig Powermat
- for mounting of tools with bore

Design

Advantages

Notes

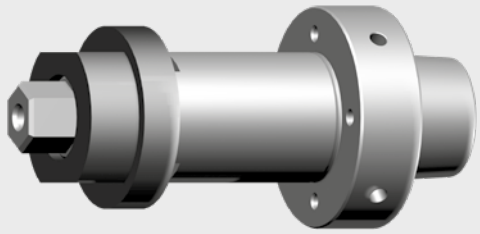
- for right- and lefthand rotation
- other dimensions on request
- for permissible RPM please refer to diagram
- attention: please observe the recommended tightening torque 80 Nm!

Ø D	Ø d	Ø d1	L2	a	NL	Weight	Ident-No.
85	Weinig HSK	30	40	26	2/6/48 + 2/M6/48	1.7	182056 L
85	Weinig HSK	30	60	26	2/6/48 + 2/M6/48	1.8	182057 O
85	Weinig HSK	30	80	26	2/6/48 + 2/M6/48	1.9	182058 O
85	Weinig HSK	30	130	26	2/6/48 + 2/M6/48	2.2	182059 C
85	Weinig HSK	30	170	26	2/6/48 + 2/M6/48	2.4	182060 O
85	Weinig HSK	30	240	26	2/6/48 + 2/M6/48	2.8	182061 O
85	Weinig HSK	40	40	26	2/6/54 + 2/M6/54	1.9	182062 L
85	Weinig HSK	40	60	26	2/6/54 + 2/M6/54	2.1	182063 L
85	Weinig HSK	40	80	26	2/6/54 + 2/M6/54	2.3	182064 L
85	Weinig HSK	40	130	26	2/6/54 + 2/M6/54	2.8	182065 L
85	Weinig HSK	40	170	26	2/6/54 + 2/M6/54	3.2	182066 O
85	Weinig HSK	40	240	26	2/6/54 + 2/M6/54	3.9	182067 O
[mm]	[mm]	[mm]	[mm]	[mm]		[kg]	

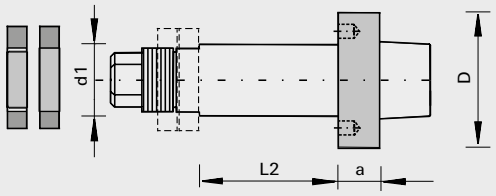
997300

Mounting Arbors Weinig HSK - with spindle nut

Product



Drawing



Machine / Application

- profile machines Weinig Powermat
- for mounting of tools with bore

Design

- with spindle nut

Advantages

- stable and secure mounting
- twist-lock

Notes

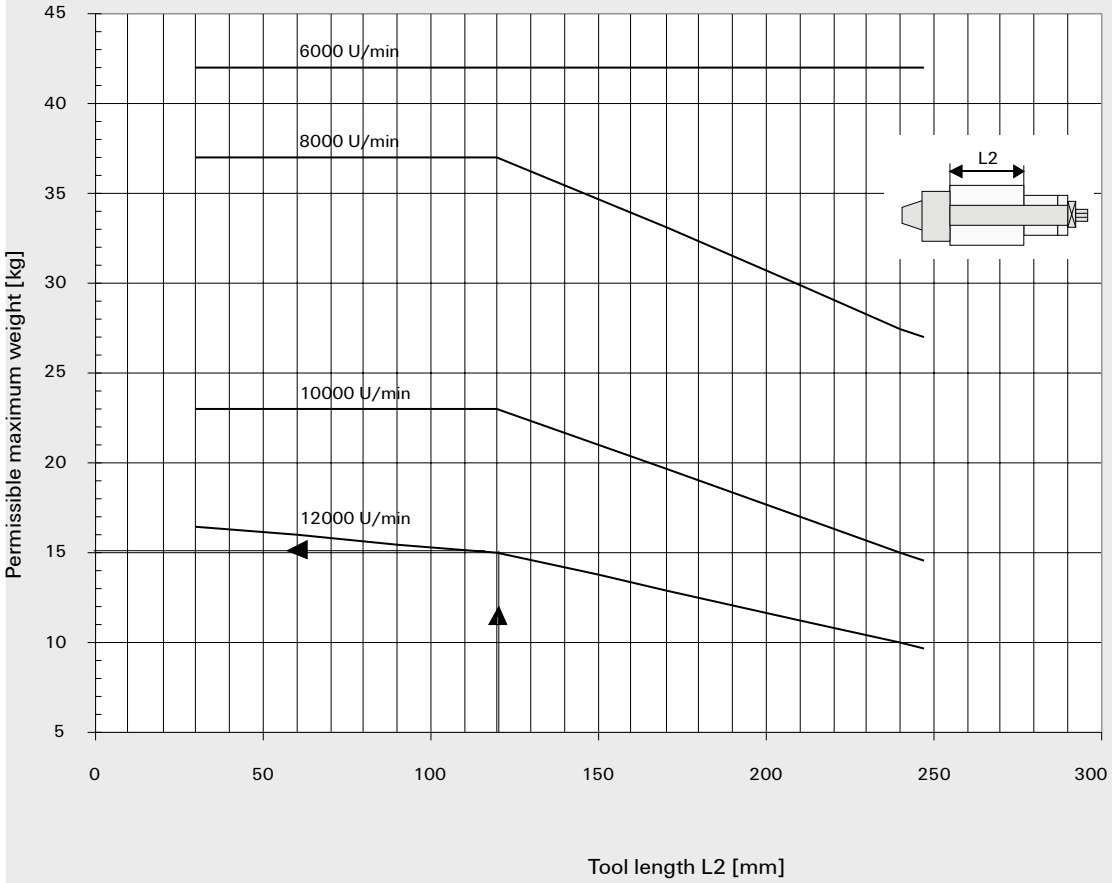
- for right- and lefthand rotation
- other dimensions on request
- for permissible RPM please refer to diagram
- attention: please observe the recommended tightening torque 80 Nm!
- included in delivery: mounting arbor incl. ring and spindle nut

Ø D	Ø d	Ø d1	L2	a	NL	Weight	Ident-No.
85	Weinig HSK	40	40	26	2/6/54 + 2/M6/54	2.48	183281 S
85	Weinig HSK	40	60	26	2/6/54 + 2/M6/54	2.68	183282 S
85	Weinig HSK	40	80	26	2/6/54 + 2/M6/54	2.88	183283 C
85	Weinig HSK	40	100	26	2/6/54 + 2/M6/54	3.08	183284 C
85	Weinig HSK	40	130	26	2/6/54 + 2/M6/54	3.37	183285 C
85	Weinig HSK	40	150	26	2/6/54 + 2/M6/54	3.56	183286 S
85	Weinig HSK	40	170	26	2/6/54 + 2/M6/54	3.76	183287 C
85	Weinig HSK	40	180	26	2/6/54 + 2/M6/54	3.86	183288 C
85	Weinig HSK	40	210	26	2/6/54 + 2/M6/54	4.15	183289 S
85	Weinig HSK	40	230	26	2/6/54 + 2/M6/54	4.35	183290 S
85	Weinig HSK	40	240	26	2/6/54 + 2/M6/54	4.45	183291 C
85	Weinig HSK	40	270	26		4.73	183292 S
85	Weinig HSK	40	310	26		5.12	183293 S
85	Weinig HSK	50	40	26	2/6/74 + 2/M6/64	2.69	183294 S
85	Weinig HSK	50	60	26	2/6/74 + 2/M6/64	3.00	183295 S
85	Weinig HSK	50	80	26	2/6/74 + 2/M6/64	3.31	183296 S
85	Weinig HSK	50	100	26	2/6/74 + 2/M6/64	3.61	183297 C
85	Weinig HSK	50	130	26	2/6/74 + 2/M6/64	4.07	183298 C
85	Weinig HSK	50	150	26	2/6/74 + 2/M6/64	4.38	183299 S
85	Weinig HSK	50	170	26	2/6/74 + 2/M6/64	4.69	183300 S
85	Weinig HSK	50	180	26	2/6/74 + 2/M6/64	4.84	183301 S
85	Weinig HSK	50	210	26	2/6/74 + 2/M6/64	5.30	183302 S
85	Weinig HSK	50	230	26	2/6/74 + 2/M6/64	5.61	183303 S
85	Weinig HSK	50	240	26	2/6/74 + 2/M6/64	5.76	183304 C
85	Weinig HSK	50	270	26		6.20	183305 C
85	Weinig HSK	50	308	26		6.82	183306 S
[mm]	[mm]	[mm]	[mm]	[mm]		[kg]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M6x16 SW3	995161	10	001617 L
	65x15x35	955520	1	80485222 S
Spindle Nuts	M33x1,5	995210	1	183307 O
	[mm]		[pc.]	

Adapter Weinig HSK

Diagram for PowerLock-Adapter



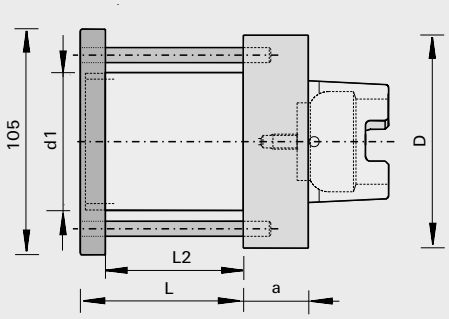
997300

Saw Blade Adapters Weinig HSK

Product



Drawing



Machine / Application

- Weinig Powermat
- for mounting of thin-kerf saw blades

Design

Advantages

Notes

- for clockwise and counter-clockwise rotation
- different diameters upon request

Ø D	Ø d	Ø d1	L2	a	NL	Ident-No.
105 [mm]	Weinig HSK [mm]	60 [mm]	68 [mm]	26 [mm]	3/8/74	182974 C

Spare parts	Dimension	Class-No.	PU	Ident-No.
Clamping Nuts	105x15xM58x1,5 [mm]	995290	1 [pc.]	182993 C

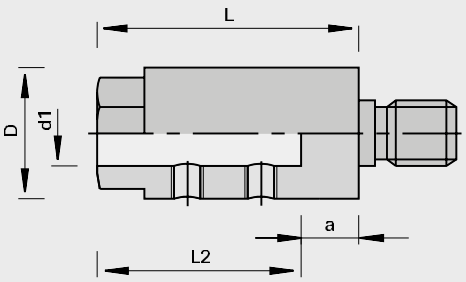
933350

Clamping Chuck Combi Systems

Product



Drawing



Machine / Application

- for mounting of drill bits with cylindrical shank and clamping surface

Design

- drill bits are clamped with setscrews

Advantages

Notes

- clamping chucks with "BSS" mark are compatible with quick-changing system for drill bits
- for threaded shank design and appropriate machines see Technical Information

Ø D	Ø d1	L2	L	a	Type		Ident-No. [L]	Ident-No. [R]
15	8	20	22	2.0	D		161282 O	161281 O
15	8	20	24.5	4.5	A		010683 C	010677 C
15	8	20	24.5	4.5	B		161285 C	161284 C
15	8	20	24.5	4.5	C		058412 C	058411 C
15	8	20	37	17	C		059300 L	059299 L
19	10	20	24.5	4.5	A		003575 L	003574 L
19	10	20	24.5	4.5	B		008003 L	008002 L
19	10	20	24.5	4.5	C		058414 L	058413 L
19	10	20	25	5.0	D		003571 L	003570 L
19	10	20	25	5.0		cyl. shank Ø 10x30	183055 O	183055 O
19	10	20	47	27	G		161287 L	161286 L
19	10	20	29.3	9.3	F		003573 L	003572 L
19	10	20	28.5	8.5	E		161987 L	161283 O
19	10	20	37	17	C		161681 L	161680 L
19	10	20	47	27	D	BSS	170372 S	170371 S
[mm]	[mm]	[mm]	[mm]	[mm]				

Spare parts	Dimension	For Ø D	Class-No.	PU	Ident-No.
Set Screws	M6x4 DIN EN ISO 4029	15	995161	10	167068 L
Set Screws	M6x5 DIN EN ISO 4029	19	995161	10	165049 L
Set Screws	M5x4 DIN EN ISO 4029	15	995161	10	001608 L
	[mm]	[mm]		[pc.]	

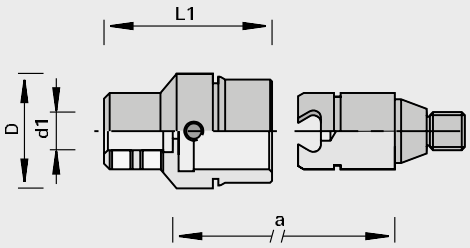
933321

Klack Quick-Changing Chucks with hole pitch 32 mm

Product



Drawing



Machine / Application

- boring machines
- for mounting of drill bits with cylindrical shank and clamping surface

Design

- for mounting of drill bits with cylindrical shank and clamping surface

Advantages

- low downtimes thanks to fast drill bit changes

Notes

- for larger hole pitch widths (32 mm)
- top part is drill bit seat
- bottom part to install on the machine spindle
- for threaded shank design and appropriate machines see technical information

Ø D	Ø d1	L1	Ident-No.
30	10	44	003567 L
[mm]	[mm]	[mm]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Reducing Bushing		955530	1	057513 S
Set Screws	M6x5 DIN EN ISO 4029	995161	10	165049 L
Set Screws	M5x8 DIN EN ISO 4028	995161	10	180015 L
Screws	M8x24L	995191	10	180013 L
Screws	M8x24R	995191	10	180012 L
	[mm]		[pc.]	

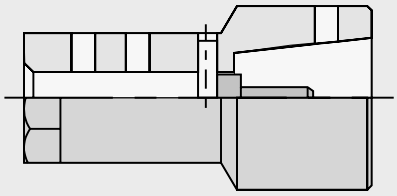
933321

Drill Bit Quick-Changing Systems - top part

Product



Drawing



Machine / Application
- boring machines
- for mounting of drill bits with cylindrical shank with clamping screws

Design
- for clamping of the drill bit with hex socket setscrews

Advantages
- low downtimes thanks to fast drill bit changes

Notes
- for larger hole pitch widths (32 mm)
- top part is drill bit seat
- bottom part to install on the machine spindle
- for threaded shank design and appropriate machines see technical information

	Dimension	Ident-No.
locating bore	Ø10	168669 L
locating bore	Ø8	168668 L
	[mm]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Engineers Wrenches	9x11 DIN 3118	985720	1	168672 S
Engineers Wrenches	11x13 DIN 3118	985720	1	168670 S
Engineers Wrenches	14x17 DIN 3118	985720	1	168671 S
	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M6x5 DIN EN ISO 4029	995161	10	165049 L
	[mm]		[pc.]	

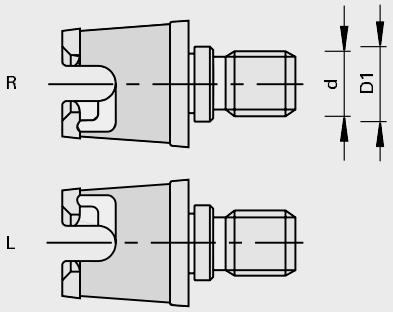
933322

Drill Bit Quick-Changing Systems - bottom part

Product



Drawing



Machine / Application

- boring machines
- for installation on the machine spindle

Design

- conical design

Advantages

Notes

- for threaded shank design and appropriate machines see technical information

Type	Ø d	Ø D1	Ident-No. [L]	Ident-No. [R]
C	M8	9.0	168662 L	168663 L
D	M10	11	170243 S	170242 S
	[mm]	[mm]		

Spare parts	Class-No.	Ident-No.
Wrench	985730	168673 O

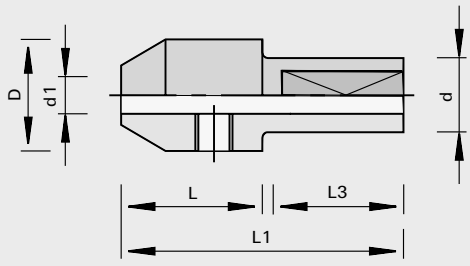
933389

Adapters

Product



Drawing



Machine / Application

- for mounting of twist drills in combi chuck and Klack chuck

Design

- shank with clamping surface
- thread M5, without screw

Advantages

Notes

- adjusting and attachment screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately

Ø d1	L	Ø d	L3	Ø D	L1	Ident-No.
2	19	10	21	15	41	183275 L
2,5	19	10	21	15	41	183276 L
3	19	10	21	15	41	183277 L
3,5	19	10	21	15	41	183278 L
4	19	10	21	15	41	183279 L
5	19	10	21	15	41	183280 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

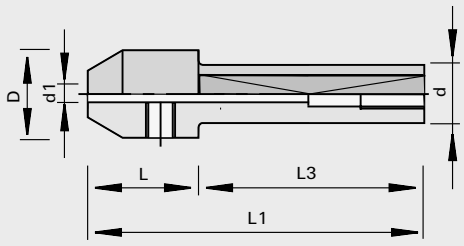
Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M6x6 DIN EN ISO 4029	995161	10	180003 L
Cranked Wrench Keys	SW3 DIN ISO 2936	985730	1	009672 L
	[mm]		[pc.]	

933389

Adapters for micro twist drills

Product

Drawing



Machine / Application
- for holding micro twist drills with a shank diameter of 3.175 mm

Design
- shank with clamping surface and length adjusting screw M5x10

Advantages

Notes
- adjusting and attachment screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately

Ø d1	L	Ø d	L3	Ø D	L1	Ident-No.
3,175	19	10	33	15	52	186165 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

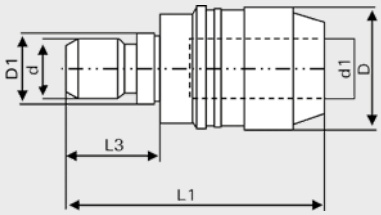
933359

Drill Bit Quick-Changing Systems

Product



Drawing



Machine / Application
- boring machines
- CNC machining centers
- for mounting of drill bits with cylindrical shank and clamping surface

Design

Advantages
- low downtimes thanks to fast drill bit changes
- no special adjusting screw necessary
- for all common drill bits with shank Ø 10 mm and boring Ø < 20 mm

Notes
- for threaded shank design and appropriate machines see Technical Information

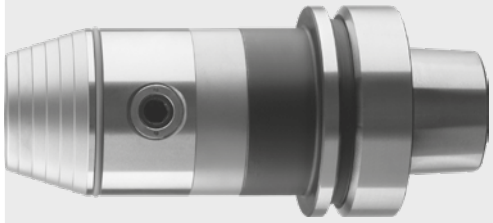
Ø D	Ø D1	Ø d	Ø d1	L1	L3	Type	Ident-No. [L]	Ident-No. [R]
20	9.0	M8	10	42	15	C	182396 O	182395 O
20		M8	10	42	15	A	182398 O	182397 O
20		10	10	45	18		182400 O	182399 O
20	11	M10	10	42	15	D	182402 O	182401 O
20		M10	10	42	15	B	182404 S	182403 O
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Class-No.	PU	Ident-No.
Wrench d10 with clamping surface	985730	1 [pc.]	182405 O

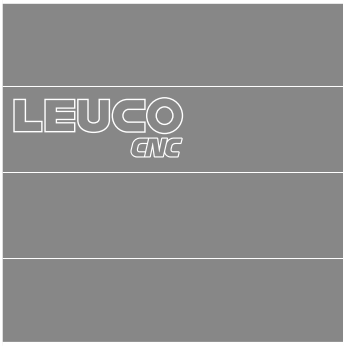
933390

Universal Drill Chucks

Product



Drawing



Machine / Application

- CNC machining centers with automatic tool changer
- for clamping of drill bits with cylindrical shank

Design

- continuously adjustable clamping area between 1-13 mm
- n max = 8,000 min-1
- hardened clamping jaws

Advantages

- fine balance is easy on spindle and spindle bearing
- high clamping accuracy over total lifetime of drill chuck thanks to hardened clamping jaws
- high holding moment
- no chips and dirt in the clamping zone thanks to special clamping jaws

Notes

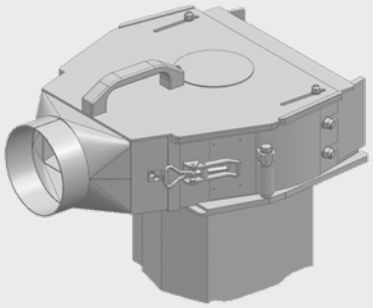
- for clockwise and counter-clockwise rotation
- included in delivery: clamping key, retaining bolts

Ø D [mm]	Ø d [mm]	Ø d1 [mm]	L1 [mm]		Ident-No.
50	SK 30 (DIN)	1-13	90	Weeke, Maka, Reichenbacher	180375 S
50	SK 30	1-13	90	Biesse from 9/92, Masterwood (HSD motors)	180376 S
50	SK 30	1-13	90	Alberti, Masterwood (Colombo motors)	180377 C
50	SK 30	1-13	90	Morbidelli, SCM (with ring gear)	180378 S
50	SK 40 (DIN)	1-13	90	Maka, Reichenbacher Stegherr	180379 O
57	SK 40 (DIN)	3-16	90	Maka, Reichenbacher Stegherr	180380 S
50	HSK 63F	1-13	97	Homag, EIMA, Weeke, IMA from 9/94	187039 L
57	HSK 63F	2-16	102	Homag, EIMA, Weeke, IMA from 9/94	187040 L

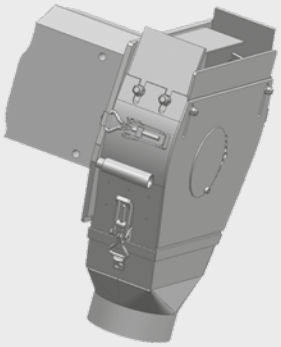
Spare parts	Dimension [mm]	Class-No.	PU [pc.]	Ident-No.
Cranked Wrench Keys	SW6x100	985730	1	180383 C

LEUCO dust hoods flooring
production series T16 ... for tools with Ø230 - Ø250 mm

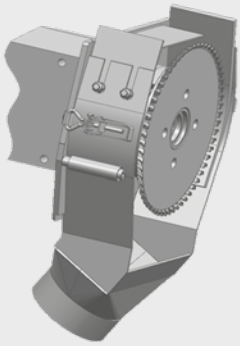
T1601



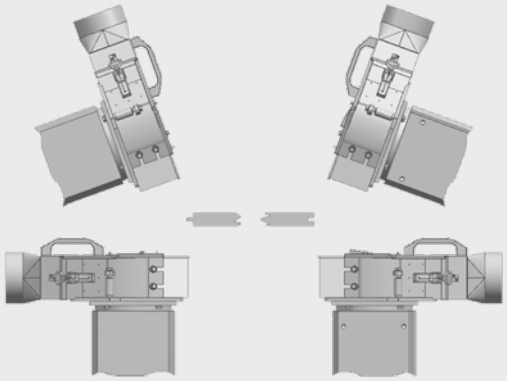
T1602



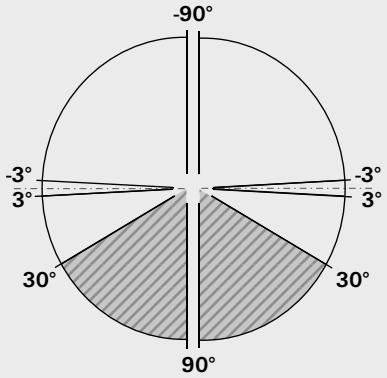
T1603



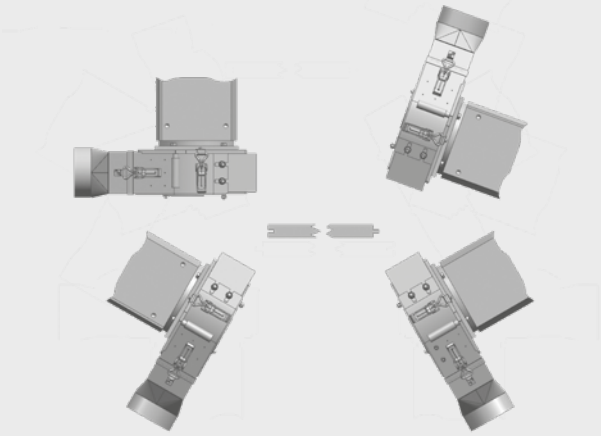
T1601 dust hood with sliding cover



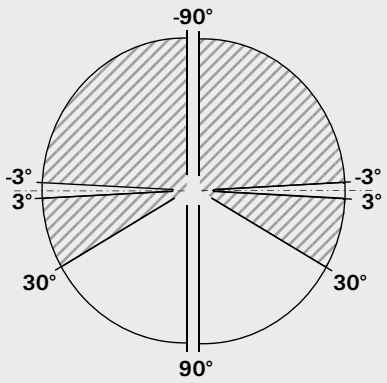
installation section 30° to 90°



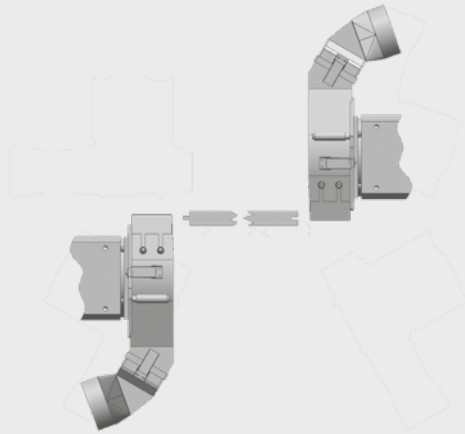
T1602 dust hood with fixed cover



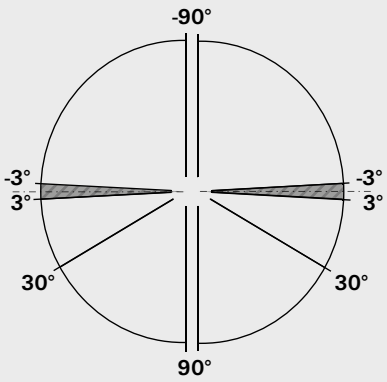
installation section 3° to -30° and -3° to -90°



T1603 dust hood without cover

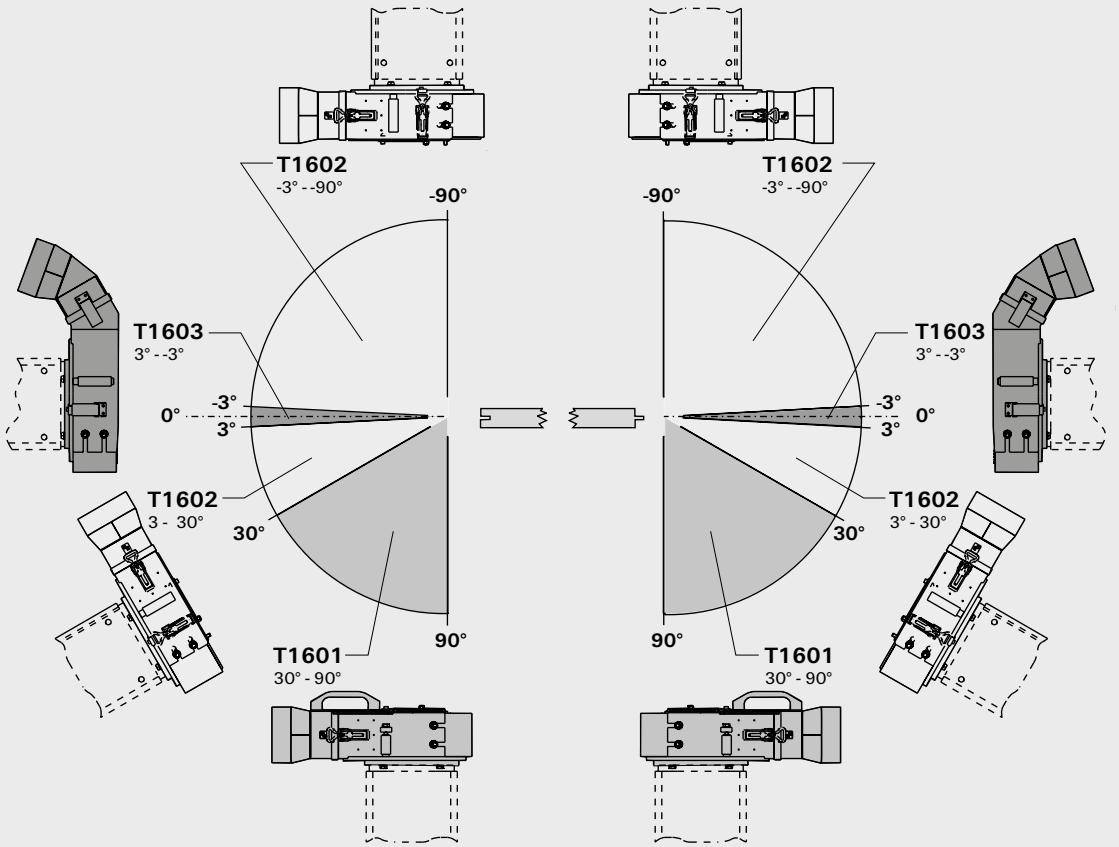


installation section 3° to -3°



Summary of installation sections

Dust hood types - T1601 / T1602 / T1603



- generally the standard differentiates between three different types of dust hoods
- the differentiation of the type of dust hood is depending on the a.m. sketched unit installation sections
- the angle designation resp. the installation angle is attributed to the motor position

Machine / Application

- double end tenoners
- especially for flooring manufacturing

Design

- LEUCO dust hood system
- symmetrical design
- wear parts made of 8 mm steel

Advantages

- optimal chip caption thanks to individual adaptation of the dust hood
- wear parts individually replaceable
- flow-optimizing design
- cover with adjustable air supply

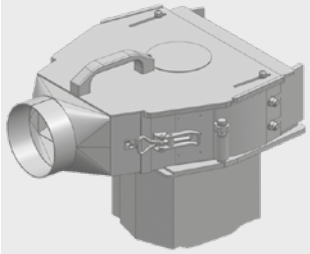
Notes

- basic plate made of steel
- wear reduction
- adjustable wear plate

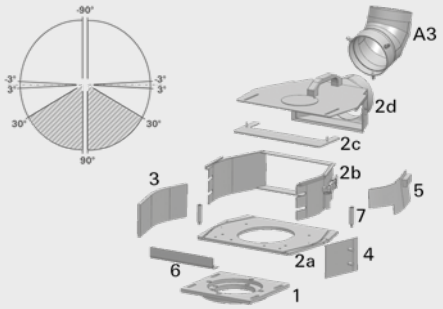
975917

LEUCO dust hood T1601 with sliding cover - flooring

Product



Drawing



Machine / Application

- double end tenoners
- especially for flooring manufacturing
- for tools with Ø230 - Ø250 mm

Design

- The LEUCO modular dust hood system consists of => flange, basic hood, wear plate, adjusting plate, chip guiding plate, C plate and thread bolt
- symmetrical design
- wear parts made of 8 mm steel
- sliding cover for easy handling

Advantages

- optimal chip caption thanks to individual adaptation of the dust hood
- wear parts individually replaceable
- flow-optimizing design
- cover with adjustable air supply

Notes

- basic plate made of steel
- wear reduction
- adjustable wear plate

		Class-No.	Ident-No.
complete dust hood T1601		975917	185862 C

1 - Flange	Dimension	Class-No.	Ident-No.
1 - flange (Perske 8 - 11 KW)	Ø180x13	975117	540301C
1 - flange (Perske 11 - 15 KW)	Ø180x13 70x105	975117	540430C
1 - Spacer	H=25	975217	540917C
	[mm]		

2a - basic plate		Class-No.	Ident-No.
2a - basic plate for basic hood		975217	541421C

2b - middle part		Class-No.	Ident-No.
2b - middle part with sliding cover for basic hood		975217	542288C

2c - sliding plate		Class-No.	Ident-No.
2c - sliding plate short for basic hood		975217	542289C
2c - sliding plate long for basic hood		975217	542692C

2d - sliding cover		Class-No.	Ident-No.
2d - sliding cover for basic hood		975217	542783C

3 - wear plate	Dimension	Class-No.	Ident-No.
3 - non-profiled wear plate for cutting with feed	S=8,0	975517	540484C
3 - non-profiled wear plate for conventional cut	S=8,0	975517	540210C
3 - non-profiled wear plate for pre-cutters against feed	S=8,0	975517	542818C
	[mm]		

4 - adjusting plate		Class-No.	Ident-No.
4 - adjusting plate standard (without profile)		975417	540209C

5 - chip guiding plate		Class-No.	Ident-No.
5 - chip directing steel sheet right		975217	542294C
5 - chip directing steel sheet left		975217	542296C

6 - C plate	Dimension	Class-No.	Ident-No.
6 - C plate 12	H=12	975417	540213C
6 - C plate 22	H=22	975417	540214C
6 - C plate 32	H=32	975417	540215C
6 - C plate 42	H=42	975417	540216C
6 - C plate 52	H=52	975417	540217C
6 - C plate 62	H=62	975417	540218C
6 - C plate 67	H=67	975417	540219C
	[mm]		

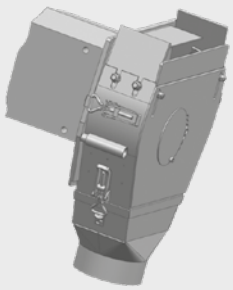
7 - thread bolt		Class-No.	Ident-No.
7 - thread bolt		975217	542286C

A - optional components for vacuum air connection	Dimension	Class-No.	Ident-No.
A1 - adapter bend	Ø120 / 30°	975317	542675C
A2 - adapter bend	Ø120 / 60°	975317	542793C
A3 - adapter bend	Ø120 / 90°	975317	542794C
A4 - reducing ring	Ø120 / Ø140	975317	542711C
	[mm]		

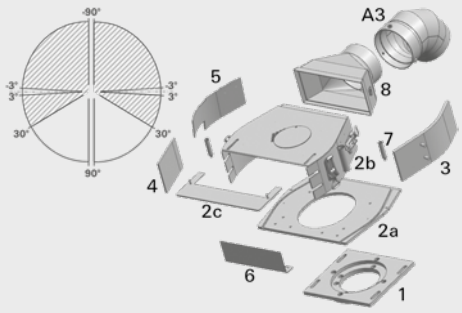
975917

LEUCO dust hood T1602 with fixed cover - flooring

Product



Drawing



Machine / Application

- double end tenoners
- especially for flooring manufacturing
- for tools with Ø230 - Ø250 mm

Design

- The LEUCO modular dust hood system consists of => flange, basic hood, wear plate, adjusting plate, chip guiding plate, C plate, thread bolt and connection
- symmetrical design
- wear parts made of 8 mm steel

Advantages

- optimal chip caption thanks to individual adaptation of the dust hood
- wear parts individually replaceable
- flow-optimizing design
- cover with adjustable air supply

Notes

- basic plate made of steel
- wear reduction
- adjustable wear plate

	Class-No.	Ident-No.
complete dust hood T1602	975917	185863 C

1 - Flange	Dimension	Class-No.	Ident-No.
1 - flange (Perske 8 - 11 KW)	Ø180x13	975117	540301C
1 - flange (Perske 11 - 15 KW)	Ø180x13 70x105	975117	540430C
1 - Spacer	H=25	975217	540917C
	[mm]		

2a - basic plate		Class-No.	Ident-No.
2a - basic plate for basic hood		975217	541421C

2b - middle part		Class-No.	Ident-No.
2b - middle part with fixed cover for basic hood		975217	542554C

2c - sliding plate		Class-No.	Ident-No.
2c - sliding plate long for basic hood		975217	542692C
2c - sliding plate short for basic hood		975217	542289C

3 - wear plate	Dimension	Class-No.	Ident-No.
3 - non-profiled wear plate for cutting with feed	S=8,0	975517	540484C
3 - non-profiled wear plate for conventional cut	S=8,0	975517	540210C
3 - non-profiled wear plate for pre-cutters against feed	S=8,0	975517	542818C
	[mm]		

4 - adjusting plate		Class-No.	Ident-No.
4 - adjusting plate standard (without profile)		975417	540209C

5 - chip guiding plate		Class-No.	Ident-No.
5 - chip directing steel sheet right		975217	542294C
5 - chip directing steel sheet left		975217	542296C

6 - C plate	Dimension	Class-No.	Ident-No.
6 - C plate 12	H=12	975417	540213C
6 - C plate 22	H=22	975417	540214C
6 - C plate 32	H=32	975417	540215C
6 - C plate 42	H=42	975417	540216C
6 - C plate 52	H=52	975417	540217C
6 - C plate 62	H=62	975417	540218C
6 - C plate 67	H=67	975417	540219C
	[mm]		

7 - thread bolt		Class-No.	Ident-No.
7 - thread bolt		975217	542286C

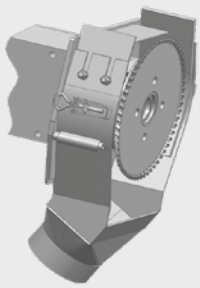
8 - connection	Dimension	Class-No.	Ident-No.
8 - connection for extraction connections (vertical)	0° - Ø120	975317	542639C
8 - connection for extraction connections (vertical)	30° - Ø120	975317	542792C
	[mm]		

A - optional components for vacuum air connection	Dimension	Class-No.	Ident-No.
A1 - adapter bend	Ø120 / 30°	975317	542675C
A2 - adapter bend	Ø120 / 60°	975317	542793C
A3 - adapter bend	Ø120 / 90°	975317	542794C
A4 - reducing ring	Ø120 / Ø140	975317	542711C
	[mm]		

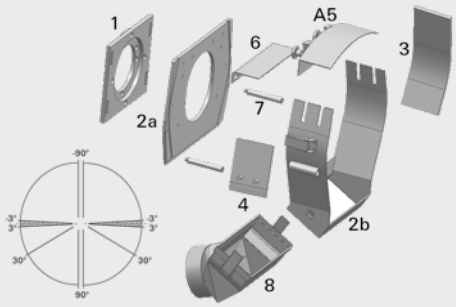
975917

LEUCO dust hood T1603 without cover - flooring

Product



Drawing



Machine / Application

- double end tenoners
- especially for flooring manufacturing
- for tools with Ø230 - Ø250 mm

Design

- The LEUCO modular dust hood system consists of => flange, basic hood, wear plate, adjusting plate, C plate, thread bolt and connection
- symmetrical design
- wear parts made of 8 mm steel
- optional with cover (component A5)

Advantages

- optimal chip caption thanks to individual adaptation of the dust hood
- wear parts individually replaceable
- flow-optimizing design

Notes

- basic plate made of steel
- wear reduction
- adjustable wear plate
- component 5 chip guiding plate is not needed

	Class-No.	Ident-No.
complete dust hood T1603	975917	185864 C

1 - Flange	Dimension	Class-No.	Ident-No.
1 - flange (Perske 8 - 11 KW)	Ø180x13	975117	540301C
1 - flange (Perske 11 - 15 KW)	Ø180x13 70x105	975117	540430C
1 - Spacer	H=25	975217	540917C
	[mm]		

2a - basic plate	Class-No.	Ident-No.
2a - basic plate for basic hood	975217	541421C

2b - middle part	Class-No.	Ident-No.
2b - middle part without cover with connection for basic hood	975217	542796C

2c - sliding plate	Dimension	Class-No.	Ident-No.
3 - non-profiled wear plate for cutting with feed	S=8,0	975517	540484C
3 - non-profiled wear plate for conventional cut	S=8,0	975517	540210C
3 - non-profiled wear plate for pre-cutters against feed	S=8,0	975517	542818C
	[mm]		

4 - adjusting plate	Class-No.	Ident-No.
4 - adjusting plate standard (without profile)	975417	540209C

6 - C plate	Dimension	Class-No.	Ident-No.
6 - C plate 12	H=12	975417	540213C
6 - C plate 22	H=22	975417	540214C
6 - C plate 32	H=32	975417	540215C
6 - C plate 42	H=42	975417	540216C
6 - C plate 52	H=52	975417	540217C
6 - C plate 62	H=62	975417	540218C
6 - C plate 67	H=67	975417	540219C
	[mm]		

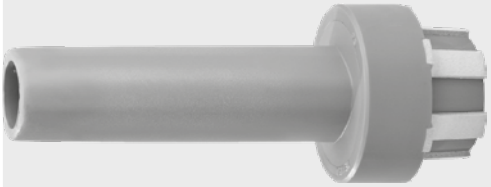
7 - thread bolt		Class-No.	Ident-No.
7 - thread bolt		975217	542286C

A - optional components for vacuum air connection	Dimension	Class-No.	Ident-No.
A1 - adapter bend	Ø120 / 30°	975317	542675C
A2 - adapter bend	Ø120 / 60°	975317	542793C
A3 - adapter bend	Ø120 / 90°	975317	542794C
A4 - reducing ring	Ø120 / Ø140	975317	542711C
A5 - cover		975217	542145C
	[mm]		

985700

Cone wiper

Product



Drawing

Machine / Application

- for cleaning of the inner cones of the cone tool adaptors

Design

Advantages

Notes

- the higly precise machine spindle and clamping chuck needs dust-free fit

Ø d [mm]	Ident-No.
SK 30	180907 O
HSK 63	180911 L

985202

Mounting devices with clamping lever

Product



Drawing

Machine / Application

- for quick and simple mounting and adjusting of cutting tools in draw-in collet chucks or on arbors and tool holders

Design

- with two-part clamping jaws made from high-quality light alloy
- mounted on stable pedestal which can be fixed onto workbench
- quick-grip lever for clamping of clamping chucks or holding arbors

Advantages

- variably applicable for all interfaces by simple exchanging of the clamping jaw

Notes

	Ø d [mm]	Ident-No.
SK 30 (DIN) / HSK 50F	50	180362 C
SK 40 (DIN)	63,5	180363 C
SK 30 with ring gear (Morbidelli, SCM)	49	180364 S
SK 30 (ISO) CMS / BT 30	46	180365 C
HSK 63F / 63E	63	180366 C
HSK 85 (Weinig)	85	182284 C

Spare parts	For Ident-No.	Class-No.	PU [pc.]	Ident-No.
Clamping Jaws (2-parts)	180362	997300	1	180368 S
Clamping Jaws (2-parts)	180363	997300	1	180369 S
Clamping Jaws (2-parts)	180364	997300	1	180370 S

Spare parts	For Ident-No.	Class-No.	PU	Ident-No.
Clamping Jaws (2-parts)	180366	997300	1	180372 S
Clamping Jaws (2-parts)	182284	997300	1	182285 S
Pedestal (without clamping jaw)	For all	997300	1	180374 S
			[pc.]	

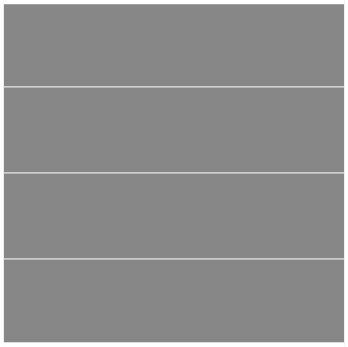
985202

Mounting devices without clamping lever

Product



Drawing



Machine / Application

- for quick and simple mounting and adjusting of cutting tools in draw-in collet chucks or on arbors and tool holders

Design

- mounted on stable pedestal which can be fixed onto workbench

Advantages

- simplest handling offering highest comfort thanks to roll clamping system, no clamping or jamming necessary

Notes

- for all adapters HSK 63 F

Ø d1 [mm]	Ident-No.
HSK 63F	182467 L

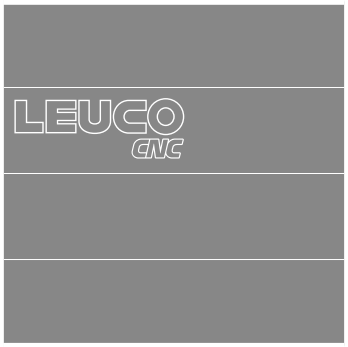
985300

Digital height measuring device

Product



Drawing



Machine / Application

- for quick and precise adjusting of cutting tools in draw-in collet chucks or on arbors and tool holders

Design

- repeating precision 0.01 mm
- tungsten carbide-tipped scriber
- digital display

Advantages

- simple adjustment and fixing of the height dimension

Notes

- battery type “LR44” not included in delivery

	Ident-No.
Digital height measuring device	183684 L

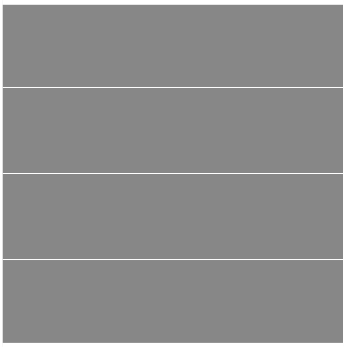
985202

Mounting Device Rigid

Product



Drawing



Machine / Application

- for quick, simple and safe mounting and adjusting of cutting tools in draw-in collet chucks or on arbors and tool holders

Design

- stable steel construction with pedestal for mounting on a workbench
- Fixation of the tool adapter by means of mounting forks
- Mounting blocks for all common interfaces

Advantages

Notes

- suitable mounting forks must be ordered separately

Ø d1	Ident-No.
HSK 63F	187270 L
HSK Weinig	187271 O
SK30	187272 O
SK40	187273 O

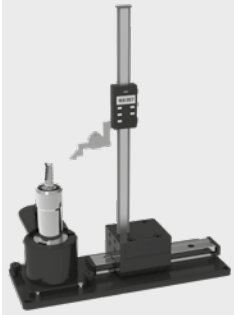
[mm]

Accessories	Dimension	suitable for	For Ident-No.	Class-No.	PU	Ident-No.
Mounting Fork	SW22	ZETA ER16	187270	997300	1	187274 L
Mounting Fork	SW32	ZETA ER16	187270	997300	1	187368 L
Mounting Fork	SW36	AEROTECH Uni-T	187270	997300	1	187275 L
Mounting Fork	SW38	ZETA ER32/OZ	187270	997300	1	187276 L
Mounting Fork	SW41	SK30	187272	997300	1	187277 O
Mounting Fork	SW46	HSK	187270, 187273	997300	1	187278 L
	[mm]					

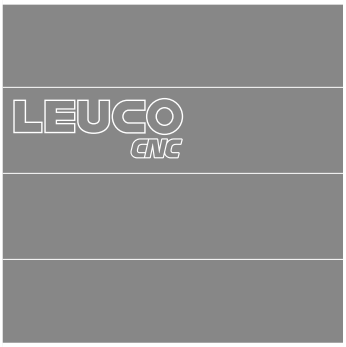
985300

Digital Mounting and Measuring Device

Product



Drawing



Machine / Application

- Mounting and measuring device for different tool adapters in combination with separately available mounting blocks

Design

- robust design
- Measuring range up to 300 mm (depending on the mounting block used)

Advantages

- easy and fast measurement and adjustment of the tool lengths

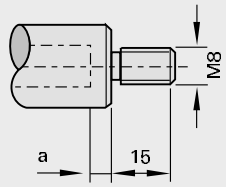
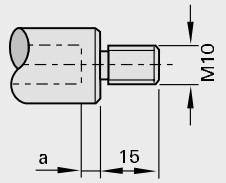
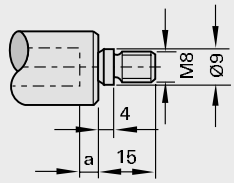
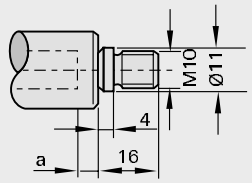
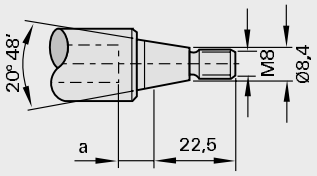
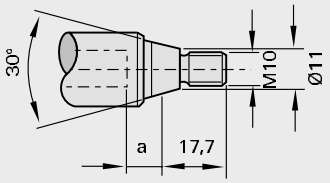
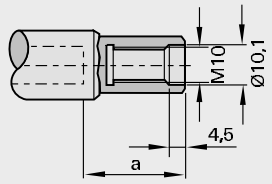
Notes

- Mounting block HSK 63A/E/F is included in delivery

	Ident-No.
Digital Mounting and Measuring Device	187279 O

Connection dimensions for Drill Bit Collet Chucks

Threaded shank design for Kombi and Klack systems with appropriate machines

Type		Machine assignment	
A		Nottmeyer Lehbrink Pankoke + Kochsiek Prieß + Horstmann	
B		Ayen Holzma Knoevenagel Mayer Brandt Reichenbacher Torwegge Zubiola	
C		Nottmeyer	
D		Böttchner + Gessner Biesse Busellato Dingenotto Hüllhorst Holz-Her Homag Koch	Morbidelli Reimall Torwegge Weeke Reich
E		Bilek Type KÜN Knoevenagel	
F		Alberti Balestrini Bilek (05 R) Busellato Dubus Goma Grotefeld Omeg	Reimall Schleicher SCM Tanzani Viciani Vitap Weingärtner
G		Scheer	



LEUCO

Spare Parts

Product	Page
Screws / Set Screws	8–1
Nuts	8–10
Spacer Rings	8–12
Reducing Bushings / Reducing Rings	8–17
Ball Bearings	8–19
Accessory Tools	8–20

Torque for Screws

Hexagon Socket Set Screws (DIN 913...916)

Thread	Width across flats [mm]	Tightening moment MA (nm) for property class 45H
M3	1.5	0.82
M4	2.0	1.90
M5	2.5	3.50
M6	3.0	5.50
M8	4.0	9.50
M10	5.0	20.0
M12	6.0	30.0

Hexagon Socket Set Screws (DIN 912)

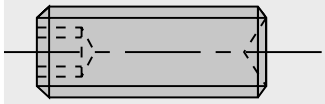
Thread	Width across flats [mm]	Tightening moment MA (nm) for property class 8.8
M3	2.5	1.1
M4	3.0	2.5
M5	4.0	5.0
M6	5.0	10.0
M8	6.0	15.0
M10	8.0	15.0
M12	10.0	15.0

Screws with Torx

Thread	Torx-Size	Torque MA [Nm] for property class	
M2.5	T8		1.31
M3	T9		2.30
M3.5	T15	2.95	
M4	T15		5.20
M4x0.5	T9		2.00
M4.5	T15		5.20
M5	T15		8.00
M5	T20	8.60	
M6	T25		15.00
M7	T30	15.00	

995161

Set Screws - with hexagon socket and cup point

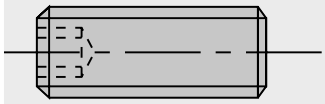
Drawing	Notes
	l with hexagon socket and cup point l packing unit 10 pieces

Dimension	Ident-No.
M5x4 DIN EN ISO 4029	001608 L
M5x5 DIN EN ISO 4029	001609 L
M6x4 DIN EN ISO 4029	167068 L
M6x6 DIN EN ISO 4029	180003 L
M6x5 DIN EN ISO 4029	165049 L

[mm]

995161

Set Screws - with hexagon socket and flat point

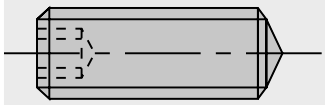
Drawing	Notes
	l with hexagon socket with flat point l packing unit 10 pieces

Dimension	Ident-No.
M5x10 DIN EN ISO 4026	180028 L
M6x6 DIN EN ISO 4026	163546 L
M6x8 DIN EN ISO 4026	180036 L

[mm]

995161

Set Screws - with hexagon socket and cone point

Drawing	Notes
	l with hexagon socket with cone point l packing unit 10 pieces

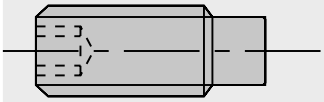
Dimension	Ident-No.
M5x10 DIN EN ISO 4027	001686 L

[mm]

995161

Set Screws - with hexagon socket and dog point

Drawing



Notes

- with hexagon socket with dog point
- packing unit 10 pieces

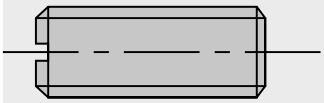
Dimension	Ident-No.
M5x8 DIN EN ISO 4028	180015 L
M5x12 DIN EN ISO 4028	050565 L
M6x6 DIN EN ISO 4028	163841 L
M6x10 DIN EN ISO 4028	180002 L
M6x12 DIN EN ISO 4028	180214 L
M6x16 SW3	001617 L
M6x25 DIN EN ISO 4028	167979 L
M8x10 DIN EN ISO 4028	001622 L
M8x12 DIN EN ISO 4028	180001 L
M8x14 SW4 DIN EN ISO 4028	168453 L
M8x16 DIN EN ISO 4028	164422 L
M8x20 DIN EN ISO 4028	001625 L
M8x35 DIN EN ISO 4028	165937 L
M10x12 DIN EN ISO 4028	001630 L
M10x16 DIN EN ISO 4028	168192 L
M10x20 DIN EN ISO 4028	815807 L
M10x25 DIN EN ISO 4028	168108 L
M12x25 DIN EN ISO 4028	181466 L

[mm]

995162

Set Screws - with flat point

Drawing



Notes

- slotted with flat point
- packing unit 10 pieces

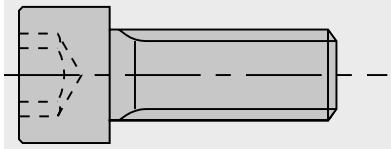
Dimension	Ident-No.
M5x10 DIN EN ISO 4766	001600 L

[mm]

995111

Head Cap Screws - with hexagon socket

Drawing



Notes

- with hexagon socket
- packing unit 10 pieces

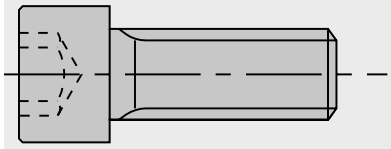
Dimension	Ident-No.
M5x12-10.9 DIN EN ISO 4762	185320 L
M5x12-8.8 DIN EN ISO 4762	001869 L
M5x16 DIN EN ISO 4762	001870 L
M5x40 DIN EN ISO 4762	001875 L
M6x16-8.8 DIN EN ISO 4762	001879 L
M6x40 DIN EN ISO 4762	001884 L
M8x10 DIN EN ISO 4762	001890 S
M8x16-8.8 DIN EN ISO 4762	001891 L
M8x70 DIN EN ISO 4762	179470 L
M10x50 DIN EN ISO 4762	001909 L
M12x30 DIN EN ISO 4762	001917 L
M12x50 DIN EN ISO 4762	001921 L
M14x60-12.9 DIN EN ISO 4762	185008 L
M14x80-12.9 DIN EN ISO 4762	185181 L
M16x50 DIN EN ISO 4762	166442 L
M16x50L DIN EN ISO 4762	166431 L
M16x55R	185693 L
M16x70 DIN EN ISO 4762	059169 L
M16x120 DIN EN ISO 4762	001938 S
M20x35L	185694 L
M20x50 DIN EN ISO 4762	166441 L
M20x50L DIN EN ISO 4762	166440 L

[mm]

995111

Head Cap Screws - with hexagon socket with low head

Drawing



Notes

- with hexagon socket with low head
- packing unit 10 pieces

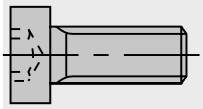
Dimension	Ident-No.
M5x12 DIN 7984	184175 L
M5x16 DIN 7984	165961 L
M6x20-8.8 DIN 6912	185355 L
M8x12 DIN 7984	184846 L
M8x16-8.8 DIN 7984	180004 L
M8x30-8.8 DIN 7984	180005 L
M8x50-8.8 DIN 7984	180006 L
M14x60-8.8 DIN 6912	184251 L
M16x30	182126 O

[mm]

995115

Head Cap Screws - with Torx

Drawing



Notes

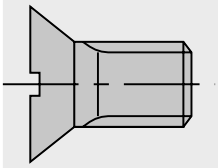
- with Torx
- packing unit 10 pieces

Dimension	Ø D	Ident-No.
M2,5x3 T8	3,45	168237 L
M2,5x4 T8	3,45	168238 L
M3x5,5 T8	4,35	168239 L
M3x10 T8	4,4	168782 L
M3,5x3,8 T15	7,0	162645 L
M3,5x5,5 T15	6,0	168236 L
M3,5x6,5 T15	6,2	163223 L
M3,5x6,5 T15	7,0	162644 L
M3,5x8 T15	6,25	163222 L
M4x5 T15	7,0	180819 C
M4x6 T15		180989 O
M5x12 T20	8,5	171237 L
[mm]	[mm]	

995122

Countersunk Screws - slotted

Drawing



Notes

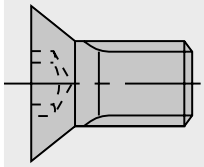
- slotted
- packing unit 10 pieces

Dimension	Ident-No.
M5x10-8.8 DIN EN ISO 2009	055881 L
M5x12-5.8 DIN 87	180007 L
M6x16 DIN EN ISO 2009	001764 L
[mm]	

995121

Countersunk Screws - with hexagon socket

Drawing



Notes

- with hexagon socket
- packing unit 10 pieces

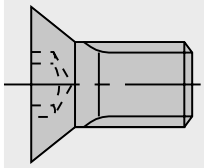
Dimension	Ident-No.
M4x8-8.8 SW2,5 DIN EN ISO 10642	183683 L
M6x10 SW4 DIN EN ISO 10642	182598 L
M6x20-8.8 SW4 DIN EN ISO 10642	183114 L
M6x30-8.8 SW4 DIN EN ISO 10642	173407 L
M6x45-10.9 SW4 DIN EN ISO 10642	180293 L
M10x40-10.9 SW6 ISO 10642	186761 L

[mm]

995125

Countersunk Screws - with Torx

Drawing



Notes

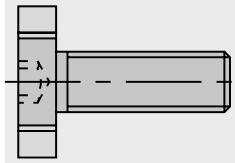
- with Torx
- packing unit 10 pieces

Dimension		Ident-No.
M2,5x5,5-12.9 T8 D=Ø3,45		167486 L
M3x7,3 T8 D=Ø4		166502 L
M3,5x5,5 T15 D=Ø5,4		162649 L
M3,5x6 T15 D=Ø5,4		162648 L
M4x0,5x3,2 T9 D=Ø6		163925 L
M4x0,5x4,2 T9 D=Ø6		165908 L
M4x0,5x5,3 T9 D=Ø6		170202 L
M5x6 T20 D=Ø9,3		176199 L
M5x6,8 T15 D=Ø9,4		180839 L
M5x8 T20 D=Ø10		164005 L
M5x9 T20 D=Ø9,3		827277 L
M5x10 T20 D=Ø10	for attaching the saw blade without flange	171236 L
M5x10,8 T15 D=Ø9,4		180840 L
M5x12 T20 D=Ø9,3		166709 L
M5x13 T20	with collar 6,0 mm	80306012 S
M5x13,5 T20 D=Ø10	with collar 6,3 mm	171238 L
M5x13,5 T20		185080 L
M5x15,5 T20 D=Ø8,5	with collar 6,0 mm	182112 L
M5x16 T20 D=Ø10	for attaching the flange	164839 L
M6x10 T20 D=Ø8,8		181244 L

[mm]

995190

Cutter Retaining Bolts

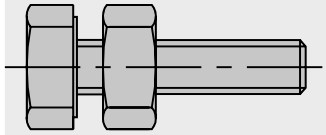
Drawing	Notes
	l with hexagon socket

Dimension		Ident-No.
M10x18xØ28		171392 L
M12x22xØ35		173591 S
M16x26xØ42		173592 L
M16x38xØ48	with centering ring	184061 L

[mm]

995190

Stop Screws

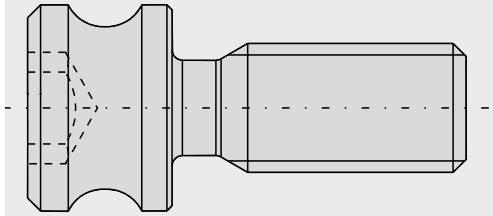
Drawing	Notes
	l attachment screw for tools with shank diameter 25 mm

Dimension		Ident-No.
M8x25	stop screw	172828 L
M6x16	for shank Ø 16	172797 L

[mm]

995195

Stop Screws - with Torx

Drawing	Notes
	l for clamping chucks Weeke l packing unit 10 pieces

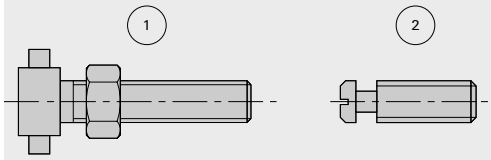
Dimension	Ident-No.
M5x17	186017 L

[mm]

995190

Safety Screws

Drawing



Notes

- for ps-System and PS 2000-E

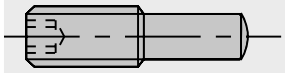
	Dimension		Ident-No.
1	M6x20	for ps-System 16 mm Ident-No. 168674	172115 L
1	M8x25	for ps-System 25 mm Ident-No. 173752	172113 L
2	M8x19	for PS-2000 E Ident-No. 173352	172921 L

[mm]

995191

Special Set Screws

Drawing



Notes

- for SuperProfiler "MAN"
- with hexagon socket
- packing unit 10 pieces

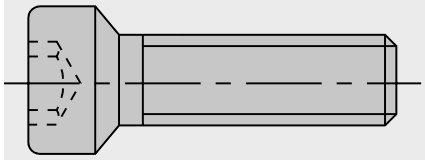
Dimension	Ident-No.
M8x24	167269 L

[mm]

995191

Screws

Drawing



Notes

- for "Klack" bottom part
- packing unit 10 pieces

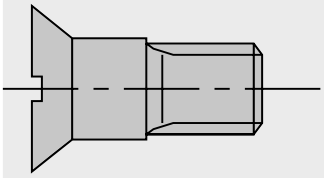
Dimension	Ident-No.
M8x24L	180013 L
M8x24R	180012 L

[mm]

995192

Countersunk Screws - with collar

Drawing



Notes

- with collar
- packing unit 10 pieces

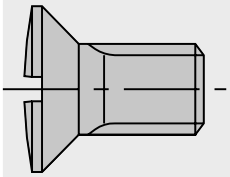
Dimension	Ident-No.
M5x12	180009 L

[mm]

995192

Countersunk Screws - for hogger segments

Drawing



Notes

- for hogger segments
- safety screws

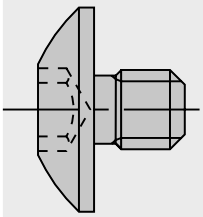
Dimension	Ident-No.
M8x12,5	180010 L
M8x17	180011 L

[mm]

995195

Round Head Screws

Drawing



Notes

- with Torx
- packing unit 10 pieces

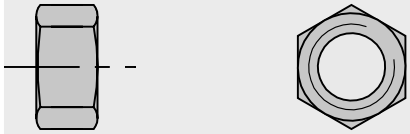
Dimension		Ident-No.
M3x4 T9		180449 L
M3,5x4 T15	head Ø 9	168893 L
M3,5x4,8 T15		180915 L
M3,5x6 T15	head Ø 9	177549 L
M3,5x12 T15	head Ø 9	171067 L
M4x5,9 T15	head Ø 9	167966 L
M4x10,5 T15	head Ø 9	179475 L

[mm]

995210

Hexagon Nuts

Drawing



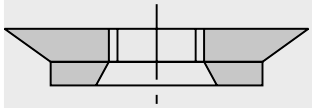
Dimension	Ident-No.
M4 DIN EN ISO 4032	009631 L
M6 DIN EN ISO 4032	009633 L

[mm]

995290

Special Nuts

Drawing



Notes

- for grooving cutterhead turnover knives
- packing unit 10 pieces

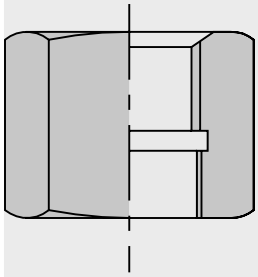
Dimension	Ident-No.
M4x0,5x1,6	163704 L
M4x0,5x2,2	163703 L
M4x0,5x2,75	165907 L
M4x0,5x4,1	170203 L

[mm]

995290

Union Nuts

Drawing



Notes

- for MK-shanks

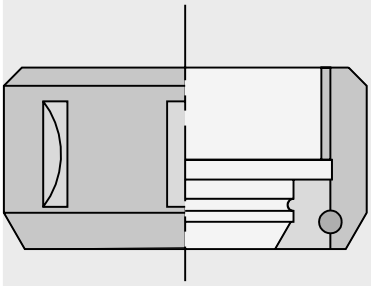
Dimension		Ident-No.
W 1 1/8"/M30x1,5	hexagonal	165561 L

[mm]

995290

Clamping Nuts

Drawing



Notes

| for draw-in collet chucks

Dimension		Ident-No.
M30x1,5R	with ball-bearing	178763 O
M40x1,5R	with slide bearing	178761 L
M48x2R	with slide bearing	178764 L
M50x1,5R	with slide bearing	178762 O

[mm]

Tightening torques for common collet chucks

Standard	Description	Collet chuck type	Thread	Key	Shank Ø	max. tightening torque [Nm]	Shank Ø	max. tightening torque [Nm]	Shank Ø	max. tightening torque [Nm]
(DIN 6499) ISO 15488-B	ER 16	426E	M24x1.0*	ZETA*	0.5 - 1.0	10	1.5 - 3.5	25 - 30	4.0 - 10.0	50 - 55
	ER 25	430E	M32x1.5	40/42	1.0 - 3.0	25 - 30	3.5 - 6.5	35 - 40	7.0 - 16.0	50 - 80
	ER 32	470E	M40x1.5	45/50	1.5 - 3.0	30 - 35	3.5 - 6.5	55 - 60	7.0 - 20.0	110 - 120
	ER 40	472E	M50x1.5	58/62	2.0 - 7.0	60 - 70	8.0 - 11.0	100 - 110	12.0 - 26.0	140 - 150
(DIN 6388) ISO 10897-B	OZ 16	415E	M33x1.5	40/42	1.0 - 3.0	25 - 30	3.5 - 6.5	35 - 40	7.0 - 16.0	50 - 80
	OZ 25	462E	M48x2.0	58/62	2.0 - 7.0	60 - 70	8.0 - 11.0	100 - 110	12.0 - 25.0	140 - 150

* = for clamping system ZETA with internal clamping nut

955520 / 955521

Spacers

Ø D	B	Ø d	DKN	NL	Ident-No.
14	0,1	6,0			176422 L
14	0,2	6,0			176423 L
14	0,5	6,0			176424 L
14	1,0	6,0			176425 L
14	2,0	6,0			176426 L
14	5,0	6,0			176427 S
40	0,1	20			000218 L
40	0,2	20			000219 L
40	0,5	20			000220 C
40	1,0	20			000221 L
40	2,0	20			000222 C
40	3,0	20			000223 C
80	0,05	22		2/4/42	017424 C
80	0,1	22		2/4/42	017425 L
80	0,2	22		2/4/42	017426 L
40	0,1	25	8x3,3		183756 C
40	0,2	25	8x3,3		183757 C
40	0,5	25	8x3,3		183758 C
40	1,0	25	8x3,3		183759 C
40	2,0	25	8x3,3		183760 C
40	4,0	25	8x3,3		183761 C
40	6,0	25	8x3,3		183762 C
40	10	25	8x3,3		183763 C
40	20	25	8x3,3		183764 C
45	0,1	25	10x3,3	2/5,5/35 + 4/6,5/36	185391 L
45	0,2	25	10x3,3	2/5,5/35 + 4/6,5/36	185392 S
45	0,5	25	10x3,3	2/5,5/35 + 4/6,5/36	185393 L
45	1,0	25	10x3,3	2/5,5/35 + 4/6,5/36	185394 L
45	2,0	25	10x3,3	2/5,5/35 + 4/6,5/36	185395 L
45	3,0	25	10x3,3	2/5,5/35 + 4/6,5/36	185396 L
50	0,1	30			000242 L
50	0,2	30			000243 L
50	0,5	30			000244 L
50	1,0	30			000245 L
50	2,0	30			000246 L
50	3,0	30			000247 L
65	0,1	30	10x3,3	2/7/45 + 8/7/48	185397 L
65	0,2	30	10x3,3	2/7/45 + 8/7/48	185398 L
65	0,5	30	10x3,3	2/7/45 + 8/7/48	185399 L
65	1,0	30	10x3,3	2/7/45 + 8/7/48	185400 L
65	2,0	30	10x3,3	2/7/45 + 8/7/48	185401 L
65	3,0	30	10x3,3	2/7/45 + 8/7/48	185402 L
65	4,0	30	10x3,3	2/7/45 + 8/7/48	185403 L
65	10	30	10x3,3	2/7/45 + 8/7/48	185404 L
90	1,0	30			000311 C
90	3,0	30			000313 S
100	0,1	30			000320 L
100	0,2	30			000321 O
100	0,5	30			000322 O
100	1,0	30			000323 O
100	2,0	30			000324 C
100	3,0	30			000325 C
175	0,1	30			000458 C
175	0,2	30			000459 S
175	0,5	30			000460 S
175	1,0	30			000461 C
70	0,1	35	12x4	4/11/54 + 6/7/58	185405 L
70	0,2	35	12x4	4/11/54 + 6/7/58	185406 L
70	0,5	35	12x4	4/11/54 + 6/7/58	185407 L
70	1,0	35	12x4	4/11/54 + 6/7/58	185408 L
[mm]	[mm]	[mm]	[mm]		

Ø D	B	Ø d	DKN	NL	Ident-No.
70	2,0	35	12x4	4/11/54 + 6/7/58	185409 L
70	3,0	35	12x4	4/11/54 + 6/7/58	185410 L
70	4,0	35	12x4	4/11/54 + 6/7/58	185411 L
70	10	35	12x4	4/11/54 + 6/7/58	185412 L
70	25	35			170363 C
100	0,1	35			000326 S
100	0,2	35			000327 C
100	0,5	35			000328 C
100	1,0	35			000329 C
100	2,0	35			000330 S
100	3,0	35			000331 L
70	0,1	40	14x3,5	4/8/55 + 4/7/58	185413 L
70	0,2	40	14x3,5	4/8/55 + 4/7/58	185414 L
70	0,5	40	14x3,5	4/8/55 + 4/7/58	185415 L
70	1,0	40	14x3,5	4/8/55 + 4/7/58	185416 L
70	2,0	40	14x3,5	4/8/55 + 4/7/58	185417 L
70	3,0	40	14x3,5	4/8/55 + 4/7/58	185418 L
70	4,0	40	14x3,5	4/8/55 + 4/7/58	185419 L
70	9	40			177308 C
70	10	40	14x3,5	4/8/55 + 4/7/58	185420 L
70	12	40			162706 O
70	9	50			177309 C
70	10	50			163886 C
70	12	50			163887 C
120	0,1	40			000344 C
120	0,2	40			000345 C
120	0,5	40			000346 C
120	1,0	40			000347 C
120	2,0	40			000348 C
90	0,1	50			000314 L
90	0,2	50			000315 L
90	0,5	50			000316 L
90	1,0	50			000317 L
90	2,0	50			000318 L
90	3,0	50			000319 C
100	0,05	50		4/9/80	177019 C
100	0,1	50		4/9/80	176835 C
100	0,2	50		4/9/80	176836 C
100	0,5	50		4/9/80	176837 C
100	1,0	50		4/9/80	176838 L
100	2,0	50		4/9/80	176839 S
100	3,0	50		4/9/80	176840 S
90	0,05	60		3/9/74	177022 L
90	0,1	60		3/9/74	177023 L
90	0,2	60		3/9/74	177024 L
90	0,5	60		3/9/74	177025 L
90	1,0	60		3/9/74	177026 L
90	2,0	60		3/9/74	177027 L
100	0,1	60			000332 L
100	0,2	60			000333 L
100	0,5	60			000334 C
100	1,0	60			000335 C
100	2,0	60			000336 S
100	3,0	60			000337 S
119	5,0	60			185365 L
119	39,5	60		6/9/100 + 2/9/100	185044 L
119,5	51	60		4/9/100	179471 L
120	0,1	60		4/9/100	176830 L
120	0,15	60		4/9/100	177018 S
120	0,2	60		4/9/100	176831 L
120	0,5	60		4/9/100	176832 L
120	1,0	60		4/9/100	176495 L
120	2,0	60		4/9/100	176833 L
120	3,0	60		4/9/100	176834 L
[mm]	[mm]	[mm]	[mm]		

Ø D	B	Ø d	DKN	NL	Ident-No.
130	4,2	60			182200 S
130	4,4	60			182202 C
130	4,5	60			182203 S
130	5,0	60			182208 S
160	0,1	60			000452 L
160	0,2	60			000453 L
160	0,5	60			000454 S
160	1,0	60			000455 L
160	2,0	60			000456 L
160	3,0	60			000457 L
115	1,0	80		4/10/100	009255 L
100	7,6	70			180940 L
100	11,4	70			180941 L
120	0,1	80		4/9/100 + 2/6,5/90	177380 L
120	0,2	80		4/9/100 + 2/6,5/90	177381 L
120	0,5	80		4/9/100 + 2/6,5/90	177382 L
120	1,0	80		4/9/100 + 2/6,5/90	177383 L
120	2,0	80		4/9/100 + 2/6,5/90	177384 L
120	3,0	80		4/9/100 + 2/6,5/90	177385 L
130	0,5	80			000450 S
145	0,2	80		4/12/100 + 4/9/120	552105 L
145	0,5	80		4/12/100 + 4/9/120	552106 L
145	1,0	80		4/12/100 + 4/9/120	552107 L
150	1,6	75		6/6,5/95	189542 L
175	7,6	70			186163 S
175	11,4	70			181034 L
[mm]	[mm]	[mm]	[mm]		

955521

Spacer Sets - 4 parts

Notes
- 4 piece set consists of: 1 piece 0.1 mm, 1 pieces 0.2 mm, 2 piece 0.3 mm

Ø D	B	Ø d	NL	Ident-No.
74	0,9	22	2/4/42	80432858 L
[mm]	[mm]	[mm]		

955521

Spacer Sets - 8 parts for milling spindles

Notes
- for milling spindles
- 8 piece set consists of: 2 pieces 5 mm, 1 piece 8 mm, 1 piece 10 mm, 2 pieces 16 mm, 1 piece 25 mm, 1 piece 40 mm

Ø D	B	Ø d	Ident-No.
50	125	30	160233 C
60	125	40	160234 C
[mm]	[mm]	[mm]	

955521

Spacer Sets - 9 parts

Notes
- 9 piece set consists of: 1 piece 0.1 mm, 2 pieces 0.2 mm, 1 piece 0.5 mm, 3 pieces 1.0 mm, 1 piece 4.0 mm, 1 piece 10 mm

Ø D	B	Ø d	Ident-No.
65	18	30	161797 L
70	18	35	161798 O
70	18	40	161799 O
[mm]	[mm]	[mm]	

995520

Spacers for s-System - Homag

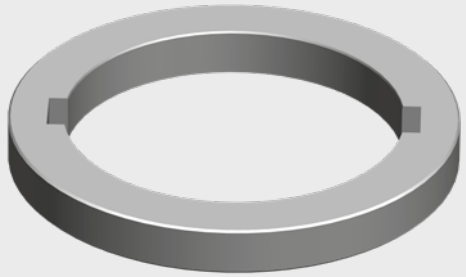
Notes
- for s-System - Homag

Ø D	B	Ø d	DKN	Ident-No.
60	11	35	10x3,3	180647 L
[mm]	[mm]	[mm]	[mm]	

955520

Spacer rings - steel

Product



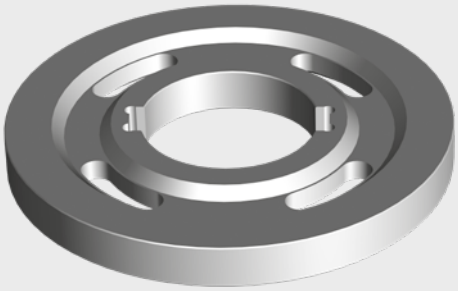
Notes
- Spacer rings for sawmills
- Other designs and dimensions on request

Ø D	B	Ø d	DKN	Ident-No.
150	0,5	115	29x131	80370453 C
150	1,0	115	29x131	80370454 C
190	2,0	150	36,3x167	80383237 O
190	3,0	150	36,3x167	80383238 O
190	5,0	150	36,3x167	80383239 O
190	10,5	150	37x170	80387052 O
190	11,5	150	37x170	80387053 O
190	12,5	150	37x170	80387054 O
190	40,4	150	37x170	80387912 C
200	1,0	150	37x157,8	80291659 C
200	2,0	150	37x157,8	80291660 C
200	3,0	150	37x157,8	80291661 C
200	6,8	150	37x157,8	80404151 C
200	21,6	150	37x157,8	80291663 C
200	31,6	150	37x157,8	80291662 S
220	10,4	150	37x170	80283020 O
270	10	150	36,3x167	80363407 O
270	30	150	36,5x168	80386011 O
270	150	150	36,3x167	80354756 S
320	10,4	150	37x170	80283019 O
[mm]	[mm]	[mm]	[mm]	

955520

Spacer rings - aluminum, stepped

Product



Notes

- Spacer rings for sawmills
- Other designs and dimensions on request

Ø D	B	Ø d	DKN	Ident-No.
380 [mm]	37,7 [mm]	150 [mm]	37x170 [mm]	80187182 S

955530

Reducing Rings

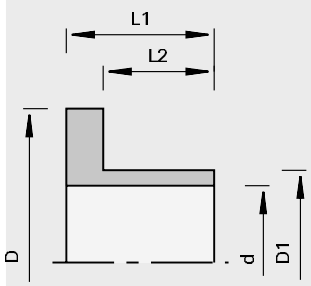
Notes

l this bore can only be reduced if the direct clamping of the saw blade via clamping rings or flanges is guaranteed

Ø D	B	Ø d	Ø d	Ident-No.
20	1,6	12,7	1/2″	161946 C
20	1,6	16		161945 L
22	2,0	20		161887 L
22	4,0	20		161830 L
25	2,2	20		000104 L
30	1,4	15		000107 C
30	1,4	16		000111 L
30	1,4	20		000117 L
30	1,4	25		000125 C
30	1,8	15,1	19/32″	161949 C
30	1,9	16		000112 L
30	1,9	20		000118 L
30	2,0	20		016848 L
30	2,0	25		000127 C
30	2,2	15,88	5/8″	000110 C
30	2,2	16		000113 L
30	2,2	18		000114 L
30	2,2	20		000119 L
30	2,2	22		000120 L
30	2,2	25		000128 L
30	2,2	25,4	1″	000130 L
30	2,2	28		000132 L
30	3,0	25		000129 L
32	2,0	16		161886 L
32	2,2	16		000134 C
32	2,2	20		000135 C
32	2,2	22		010571 C
32	2,2	30		000137 L
35	1,0	30		000145 L
35	1,4	30		000146 S
35	1,9	30		000147 L
35	2,2	20		000138 C
35	2,2	24		000139 C
35	2,2	25		000142 C
35	2,2	28		000144 S
35	2,2	30		000148 L
35	2,2	32		000150 C
40	2,0	32		161962 L
40	2,2	20		000151 L
40	2,2	30		000153 L
40	2,2	35		000154 C
45	2,5	30		161831 L
50	2,2	30		000156 L
55	2,2	30		000159 C
60	2,2	30		000161 L
60	2,2	35		000162 L
60	2,2	40		000163 S
60	2,2	50		000164 C
60	2,8	30		010577 L
70	2,2	30		000166 C
80	2,2	30		000171 L
80	2,2	35		000172 C
80	2,2	50		000175 L
80	2,2	60		000177 C
80	2,2	70		000179 C
80	2,8	60		000178 C
[mm]	[mm]	[mm]	[inch]	

956506

Reducing Bushings with collar

Drawing	Notes
	I with collar

Ø D	Ø D1	Ø d	L1	L2	Ident-No.
60 [mm]	40 [mm]	30 [mm]	24 [mm]	18 [mm]	168063 O

997500

Ball Bearings

Notes
I for shank-type tools

	Dimension	Ident-No.
ball-bearing thrust ring assy.	Ø12	167923 L
Ball Bearings	12,7x5x4,76	164920 L
Ball Bearings	13x5x4	185494 L
ball-bearing thrust ring assy.	Ø14	169314 L
Ball Bearings	15,9x5x6,35	164921 L
ball-bearing thrust ring assy.	Ø16	180985 O
ball-bearing thrust ring assy.	Ø18	180986 O
Ball Bearings	19x6x6	164922 L
ball-bearings with thrust ring	19x7,5x6,35	164229 L
ball-bearing thrust ring assy.	Ø20	180987 O
ball-bearings with thrust ring	21x7,5x6,35	170774 O
ball-bearings with thrust ring	22x7,5x6,35	164228 L
ball-bearing thrust ring assy.	22x7,5x8	180838 L
ball-bearing thrust ring assy.	Ø22	180988 O
	[mm]	

985720

Engineers Wrenches

Dimension	Ident-No.
9x11 DIN 3118	168672 S
11x13 DIN 3118	168670 S
14x17 DIN 3118	168671 S
SW10/13 DIN 895	171060 S
24x27 DIN 3110	009193 C

[mm]

985720

Single-Head Engineers Wrenches

Dimension	Ident-No.
SW36 DIN 894	169296 O
SW41 DIN 894	169297 S
SW46x10 DIN 894	178760 L

[mm]

985720

Hook Wrenches

Product	Notes
	l for draw-in collet chucks

Dimension	Ident-No.
40/42 DIN 1810	169298 L
45/50 DIN 1810	175851 L
58/62 DIN 1810	169299 L

[mm]

985300

Hook wrench adapter for torque wrench

Product	Notes
	l for draw-in collet chucks l use with torque wrench, ID No 184890

Dimension	Ident-No.
40/43 DIN 1810	186466 C
45/50 DIN 1810	186467 C
58/62 DIN 1810	186765 L

[mm]

985720

Face spanner

Notes



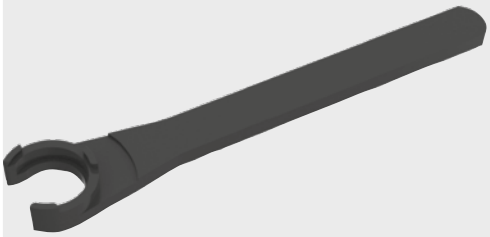
- face spanner 14-100 mm with tenon 5 mm, Lmax=215 mm
- for short-term fastening of jointing cutters with fixing bores on the shaft during the assembly of fastening means

Dimension	Ident-No.
14-100/5 [mm]	187136 L

985720

Hand spanner

Product



Notes

- for draw-in collet chucks with internal clamping nut

	Ident-No.
426E / ER 16	184878 L
470E / ER 32	184879 L
462E / OZ 25	184880 L

985300

Torque adapter for torque wrench

Product



Notes

- for draw-in collet chucks with internal clamping nut
- use with torque wrench, ID No 184890

	Ident-No.
426 E / ER 16	184887 L
470 E / ER 32	184888 L
462 E / OZ 25	184889 L

985300

Torque wrench

Dimension	Ident-No.
40-200 Nm [mm]	184890 L

985730

Cranked Wrench Keys for hexagon socket screws

Notes
- for hexagon socket screws

Dimension	Ident-No.
SW2 DIN ISO 2936	009670 S
SW2,5 DIN ISO 2936	009671 L
SW3 DIN ISO 2936	009672 L
SW4 DIN ISO 2936	009673 L
SW5 DIN ISO 2936	009674 L
SW6 DIN ISO 2936	009675 L
SW6x100	180383 C
SW8 DIN ISO 2936	009677 C
SW12 DIN 6911	177106 C

[mm]

985730

Screwdrivers with sliding handle for hexagon socket

Notes
- for hexagon socket screws
- with sliding handle

Dimension	Ident-No.
SW2,5x100	168010 L
SW3x100	166090 L
SW4x100	166091 L
SW5x150	168703 L
SW6x200	167817 L

[mm]

985730

Screwdrivers with sliding handle for Torx

Notes
- for screws with Torx
- with sliding handle

Dimension	Ident-No.
T15x140	179145 L
T20x100	166092 L
T25x100	50933169 L
T40x130	831404 O

[mm]

985730

Screwdrivers with flag for Torx

Notes
- for screws with Torx
- with flag

Dimension	Ident-No.
T7	167904 L
T8	166499 L
T9	164344 L
T15	163161 L

[mm]

985730

Cranked Wrench Keys for Torx

Notes
- for screws with Torx

Dimension		Ident-No.
T15	for adjustment unit Altendorf	181147 L
[mm]		

985730

Screwdrivers with spinner handle for Torx

Notes
- for screws with Torx
- with spinner handle

Dimension	Ident-No.
T9x60	173796 L
T15x80	171188 L
[mm]	

985730

Screwdrivers with spinner handle

Notes
- with spinner handle

Dimension		Ident-No.
8,0	for spurs	053874 L
[mm]		

985730

Screwdrivers with wooden handle

Notes
- with wooden handle

Dimension		Ident-No.
9,0	for hoggers	011088 L
[mm]		

985200

Adjusting Gauges

Dimension	Ident-No.
0,3	055883 L
0,5	50570583 L
0,7	056096 L
0,8	50570581 L
1,0	011103 L
1,8	50570582 C
[mm]	

997800

Magnetic Stops

Dimension	Ident-No.
0,0	016613 L
0,5	166093 L
1,0	166094 L

[mm]

985710

Ball hammers one sided

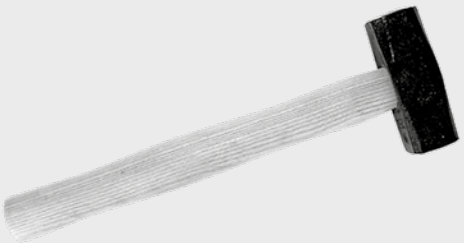
Product	Notes
	I Hand tools for straightening circular saw blades

Weight	Ident-No.
0.5	186268 S
0.75	186269 S
1.0	186270 S
1.25	186271 S
1.5	186272 S
1.75	186273 S
2.0	186274 S
2.25	186275 S
2.5	186276 S
3.0	186277 S

[kg]

985710

Ball hammers double sided

Product	Notes
	I Hand tools for straightening circular saw blades

Weight	Ident-No.
0.5	186257 S
0.75	186258 S
1.0	186259 S
1.25	186260 S
1.5	186261 S
1.75	186262 S
2.0	186263 S
2.25	186264 S
2.5	186265 S
3.0	186266 S
3.5	186267 S

[kg]

985710

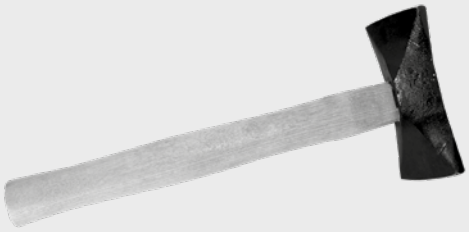
Cross hammers

Product	Notes
	I Hand tools for straightening circular saw blades

Weight [kg]	Ident-No.
0.5	186278 S
0.75	186279 S
1.0	186280 S
1.25	186281 S
1.5	186282 S
1.75	186283 S
2.0	186284 S
2.25	186285 S
2.5	186286 S

985710

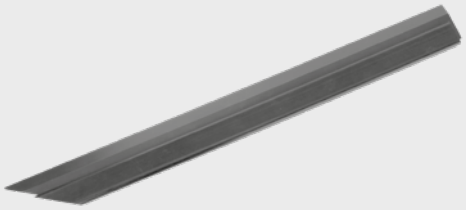
Roughing hammers

Product	Notes
	I Hand tools for straightening circular saw blades

Weight [kg]	Ident-No.
0.5	186287 S
0.75	186288 S
1.0	186289 S
1.25	186290 S
1.5	186291 S
1.75	186292 S
2.0	186293 S
2.25	186294 S
2.5	186295 S

985300

Rulers

Product	Notes
	I Hand tools for straightening circular saw blades

Total length	Ident-No.
150	186296 S
200	186297 S
300	186298 S
400	186299 S
500	186300 S
600	186301 S
800	186302 S

[mm]

985300

Dial gauges

Product



Ident-No.
186304 C

985300

Saw setting dial gauges

Product

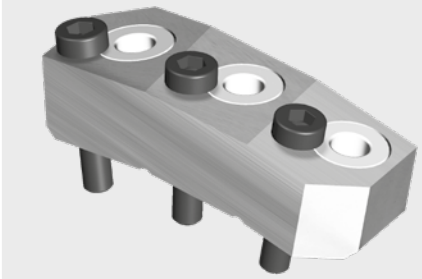


Ident-No.
186303 C

997600

Drilling fixture for p-System profile cutters

Product



Drawing

Machine / Application
- Drilling fixture to repair p-System profile cutters

Design
- with positioning screws

Advantages
- fast and easy positioning on the profile cutter
- Stable guidance of the dill bits

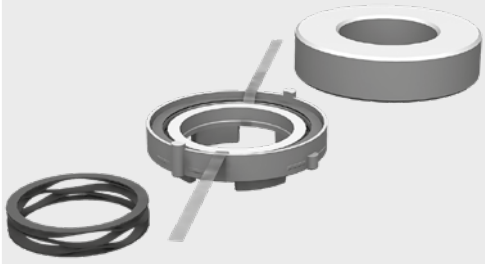
Notes
- appropriate repair set consisting of: thread inserts, twist drills, hand tap, spindle insert, tang break-off tool (identification no. 185881)

	Ident-No.
for Ø D=360 mm left and Helicoil® d=7.5 mm	186440 S
for Ø D=360 mm right and Helicoil® d=7.5 mm	186441 S
for Ø D=402 mm left and Helicoil® d=7.5 mm	186444 S
for Ø D=402 mm right and Helicoil® d=7.5 mm	186445 S
for Ø D=360 mm left and core hole d=5.5 mm	186442 S
for Ø D=360 mm right and core hole d=5.5 mm	186443 S
for Ø D=402 mm left and core hole d=5.5 mm	186446 S
for Ø D=402 mm right and core hole d=5.5 mm	186447 S

997100

Maintenance kit for edge rounding cutters - flexClick - Homag

Product



Drawing

Machine / Application
- Homag edge banding machines for shaping units MF50, MF60
- For maintenance of edge rounding cutters - flexClick

Design
- Maintenance kit consisting of: adjustment mechanism, sinuous spring, cleaning instructions, activation ring

Advantages
- Maintenance work can be carried out by the user

Notes
- Ident-No. 186981 clockwise for clockwise rotating flexClick tools
- Ident-No. 186982 counter-clockwise for counter-clockwise rotating flexClick tools
- Maintenance work can be carried out by the user or LEUCO service personnel
- VIDEOLINK: www.leuco.com/maintenance/flexclick

		Ident-No.
Maintenance kit flexClick	For flexClick edge trimming cutterheads with clockwise rotation	186981 L
Maintenance kit flexClick	For flexClick edge trimming cutterheads with counter-clockwise rotation	186982 L

1 Ordering details

1.1 Catalogue Tools

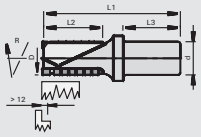
By indicating the Ident-No. the tool is described unequivocally.

The additional indication of Class-No., dimensions, sense of rotation and cutting material increases the information content and avoids wrong deliveries if the Ident-No. is false.

Please see one example each for shank-type tools and tools with bore.

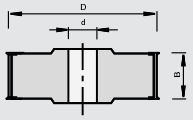
1.1.1 Shank-Type Tools

description:	LEUCODIA shank-type cutter
Class-No.:	229022
Ident-No.:	181475
dimensions:	25 x 38/120 x 25 (D X L2/L1 x d)
sense of rotation:	R (right-hand rotation)
no. of teeth:	Z3+3
cutting material:	DP (polycrystalline diamond)
Type of feed:	MEC



1.1.2 Tools with Bore

description:	chamfering cutterhead
Class-No.:	120255
Ident-No.:	167048
dimensions:	125 x 50 x 30 (D x B x d)
double keyway:	DKW 12 x 5
no. of teeth:	Z4+4 (main cutting edge knives+spurs)
cutting material:	HW (tungsten carbide)
type of feed:	MAN



1.2 Special Tools

The quick processing of inquiries and orders requires detailled information.

1.2.1 Tool Data

- tool design (one-part tool, compound tool or composed tool)
- diameter x cutting width x bore (tools with bore)
- diameter x effective length x shank dimension (shank-type tools)
- no. of teeth
- profile depth
- sense of rotation
- operating speed (RPM)
- feed rate
- dimensions of keyways
- cutting material type

1.2.2 Type of feed

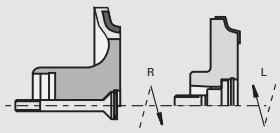
- manual feed (MAN)

- mechanical feed (MEC)

1.2.3 Sense of rotation

- right-hand rotation[R]

- left-hand rotation[L]



1.2.4 Workpiece

- workpiece material: solid woods, wood-based panels, composite materials, plastics, NF metals etc.

- surface condition of the workpiece material: veneered, plastic-laminated, melamine-faced, lacquered etc.

In the case of lack of clarity with regard to the workpiece material samples of the material to be machined can be sent.

1.2.5 Machine data

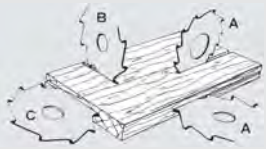
- brand and type
- range of RPM
- installed capacity
- max. tool dimensions
- interface
- type of feed etc.

1.2.6 Position of the workpiece with regard to the tool

- reference surface and reference edge of the workpiece (i.e. machine cutting table surface)
- feed direction

1.2.7 Grain direction

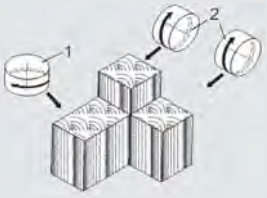
Grooving in grain-oriented materials



A along the grain
B across the grain
C end-grain cutting

Application with and across the grain

(1)
- position of workpiece is horizontal relative to the spindle
- direction of feed is across the grain
- position of the spindle is parallel to the grain
- peripheral edge cuts parallel to the grain
- end or side (flank) edge cuts vertical relative to the grain
- no preliminary cleavage



In rebating and grooving work the flank or side edges will make the separating cut

(2)
- position of workpiece is vertical relative to the spindle
- direction of feed is across the grain
- peripheral edge cuts through end grain
- flank or side edge cuts parallel to the grain
- no preliminary cleavage

In jointing, rebating and grooving work the peripheral edges will do the principal cutting.

1.2.8 Mode of application

against feed
with feed

1.2.9 Profile details

Profile drawings must clearly show whether the workpiece or the tool is shown.
Please state bearing side, sense of rotation, dimensions and application conditions on workpiece samples or drawings.

1.2.10 Information for chamfering, rabbeting and profiling tools

If no special information is available chamfering, rabbeting and profiling tools are always delivered as follows:
clockwise rotation and large diameter resp. top side spur.



2.1 Tools

One-piece tools (solid tungsten carbide tool / solid steel tool)

Tools without combined or removable parts; the body and the cutting parts are made from one piece.



Composite tools (tipped tools)

Tools with cutting parts (cutting tips) which are tightly connected with the body by means of welding, soft-soldering, hard-soldering, non-detachable bonding, etc.



Complex tools

Tools consisting of a body and one or more cutting parts (exchangeable inserts, knives) which can be changed by means of unlockable clamping elements. The cutting parts can be made in one-piece or compound design.



Tool set

Single tools which are mounted on a tool carrier and meant to work like one tool.



Tool combination

Unit consisting of multiple loose tools which can be combined with each other in diverse order or can be varied axially in different positions.



2.2 Tool bodies

Tool bodies are made from such materials that they can withstand the forces and strains to be expected during use. For this purpose steel- and aluminum materials are used. For shank-type tools supplemental materials are available.

2.3 Types of feed (according to EN 847)

2.3.1 Manual feed (MAN)

Manual feed means manually holding and guiding workpieces or machine elements with tools. Manual feed also includes using a removable feed device that is not interlocked with the tool as well as as a manual push-slide.

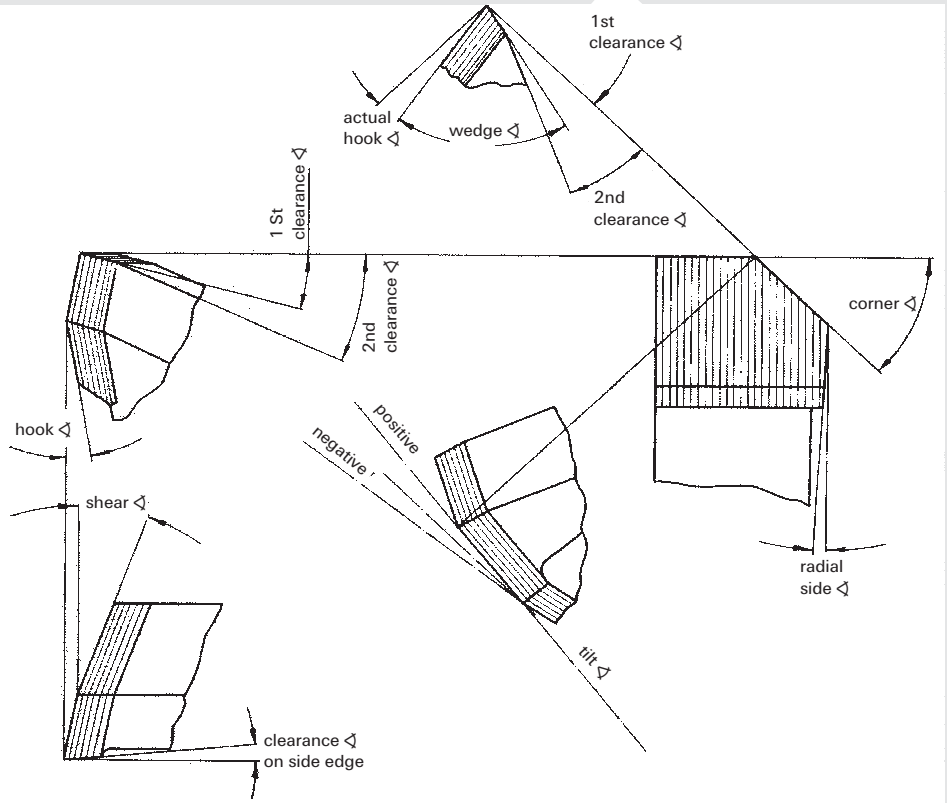
2.3.2 Mechanical feed (MEC)

Feed mechanism for the workpiece or the tool, integrated in the machine and by means of which the workpiece or machine element with tool is mechanically clamped and guided during operation.

2.4 Information with regard to the tables and charts

The working parameters for machining of wood and wood-composites are significantly co-determined by a multitude of individual factors (i.e. structure and composition of the workpiece material, machine parameters). In specific application cases there may be differences from the indications given in the tables and diagrams.

2.5 Angles and cutting edge geometries



Diameter D [mm]

Cutting width B [mm]

Hook angle [°]

Wedge angle [°]

Shear angle [°]

Corner angle [°]

3 Formulas, standard values and further information

cutting diameter D [mm]	$D = (1000 \times 60 \times v_c) / (n \times \pi)$
RPM n [dak^{-1}]	$n = v_c \times 1000 \times 60 / (\pi \times D)$
depth of knife marks t [mm]	$t = f_z^2 / (4 \times D)$
medium chip thickness h_m [mm]	$h_m = f_z \times \sqrt{(a_e/D)}$
cutting speed [m/s^{-1}]	$v_c = \pi \times D \times n / (1000 \times 60)$
depth of cut a_e [mm]	
feedrate v_f [m/dak^{-1}]	$v_f = f_z \times n \times z / 1000$
feedrate per tooth f_z [mm]	$f_z = v_f \times 1000 / (n \times z)$
number of teeth z	$z = (v_f \times 1000) / (f_z \times n)$

For safety reasons (noise emission, danger of kickback) the range of cutting speeds for tools with manual feed (MAN) lies between 40 - 70 m/s.

4 Cutting materials

4.1 General information

For woodworking the following cutting materials are used:

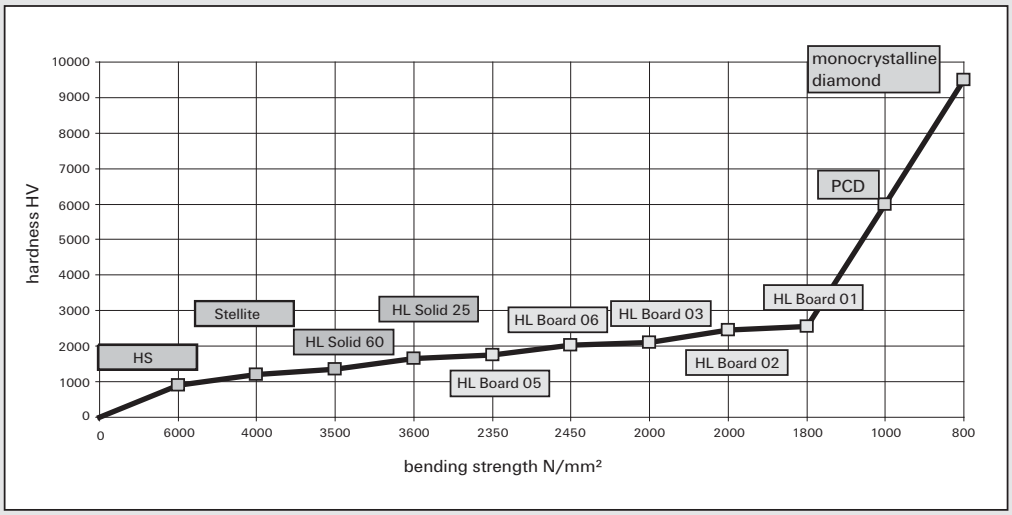
SP alloyed steel
HL high-alloyed steel
HS high-speed steel
HW uncoated tungsten carbide
HC coated tungsten carbide
ST casting alloy on cobalt basis
DP polycrystalline diamond
DM monocrystalline diamond

The multitude of materials to be machined and the various kinds of applications make different demands on the cutting edge and thus on the cutting edge material and the cutting edge geometry.

Whereas soft woods require a small hook angle, particle boards require a cutting edge which is extremely wear-resistant.

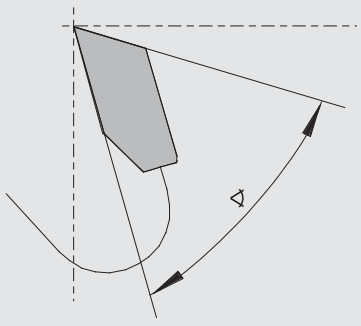
The optimum cutting material would thus be tough and hard.

The chart shows the hardness and bending strength of the most popular cutting materials.



This suggests that an increase of hardness is inevitably linked with a decrease of the bending strength. With other words: "Hard cutting materials need a large wedge angle."

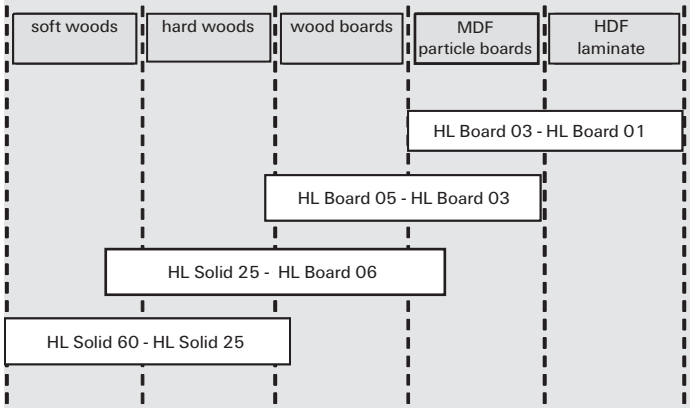
DP: ∢ = 60° - 70°
HW: ∢ = 45° - 55°
ST: ∢ = 40° - 50°
HS: ∢ = 35° - 45°



4.2 Range of application of the different cutting materials

4.2.1 Tungsten carbide cutting materials (HW, HC)

Tungsten carbide grades are destined for the use in soft woods, hard woods and laminated timbers as well as in wood-based panels.



The spectrum of tungsten carbide grades ranges from HL Board 01 to HL Solid 60. HL Board grades are hard and wear-resistant. HL Solid grades are tougher and can have a smaller wedge angle.

4.2.2 Diamond cutting materials (DP)

Diamond cutting materials have a wide range of application (from hard woods to laminate overlays).

The applied diamond grades are exclusively made by well-known manufacturers of cutting materials who guarantee a constant high quality.

Mainly the following grades are applied:

	Fine	Medium	Coarse
Advantages	l high wear resistance l excellent surface condition l excellent sharpness of cutting edges, long edge lives	l excellent wear resistance l high sharpness of cutting edges l moderate impact resistance	l extremely high wear resistance l slightly lesser impact resistance and toughness
Application area	l for moderately abrasive materials	l universally applicable	l for extremely abrasive materials

4.2.3 Monocrystalline diamond (DM)

Because of its high brittleness and hardness monocrystalline diamond is applied in the case of homogeneous and extremely abrasive workpiece materials. Application areas are for example the machining of laminate overlays and transparent plastics.

4.2.4 Casting alloy on cobalt basis (ST, Stellite)

Stellite is the ideal cutting material for the machining of humid woods.

4.2.5 High speed steel (HS)

High speed steel is chosen for the machining of soft and hard woods.

For special applications further cutting materials (e.g. CVD) and coatings (e.g. topcoat) are available.

5 Workpiece materials

Overview

Solid woods	Soft woods	
	Hard woods	
	Exotic woods	
	Veneers	
Wood-based materials	Laminated woods	Plywood etc.
	Particle materials	Particle boards
	Fiber boards	MDF etc.
	Laminates	HPL, CPL, Trespa, Multiplex etc.
	Wood wool	Heraklith etc.
Plastics	Thermoplastic	PA, PE, PMMA etc.
	Thermosets	Pertinax®, Restitex® etc.
	Fiber-reinforced plastics	CFRP, GFRP etc.
	Polymer bound plastics	Corian®, Varicor®, Noblan®, Kerrock® etc.
Composite materials	Solid wood laminated with	HDF, MDF, veneer
	Panels laminated with	HPL, cork etc.
	Gypsum boards	
	Gypsum plaster boards	
	Cement bonded boards	
	Mineral wool boards	
	Plastics with metals (Alucobond® etc.)	
NF-Metals	Pure aluminum	
	Al-Mg-Cu	
	Al-Si alloys	

® different trade marks

Tool Checklist

Imperative features for special tools

	Saw Blades / Hoggers	Cutters with Bore	Finger Joint Cutters	Shank-Type Cutters	Drill Bits / Plunge Cutters	Profile Knives
Machine data						
Flange diamteter	●					
Spindle diameter	●	●	●			
Spindle position	●	●	●	●		
RPM [n]	●	●	●	●		
Feedrate [Vf]	●	●	●	●	●	
Type of feed [MEC / MAN]	●	●	●	●		
Clamping system [e.g. TRIBOS, ps-System]	●	●	●	●	●	●
Machining data						
Workpiece material	●	●	●	●	●	●
Required cutting quality	●	●	●	●	●	●
Cutting direction [along, across, ...]	●	●		●		
Application [with feed, against feed]	●	●		●		
Design	●					
Tool data						
Product group [PHG]	●	●	●	●	●	●
Single / set tool	●	●	●	●	●	●
Outside diameter	●	●	●	●	●	●
Cutting width [B]	●	●	●	●		
Bore diameter 1, shank diameter 2 [d]	●1	●1	●1	●2	●2	
Number of teeth [T], Description of cutterhead	●	●	●	●	●	●1
Shear angle	●	●		●		
Raker 1; spur 2	●1	●2		●2	●2	
Pin holes [NL]	●	●				
Cutting material	●	●	●	●	●	●
Keyway [KN], double keyway [DKN]	●	●	●			
Plunging insert / face cutting edge				●		
Drawing						
Drawing	●	●	●	●	●	●
Tool dimension	●	●	●	●	●	●
Arrow indicating direction of rotation	●	●	●	●	●	

Tool Checklist

Imperative features for special tools

Date: _____

LEUCO sales person _____ Offer / Order no. _____

Customer _____

Address _____

Contact name _____ Phone: _____ Fax: _____

Customer no. _____ E-mail: _____

Machine data

Machine _____ Type _____

Flange Ø [mm] _____ RPM [min-1]: _____ Clamping System _____

Spindle Ø [mm] _____ Spindle position O Horizontal O Vertical O Tilted Degree of tilt [°] _____

Type of feed O MEC O MAN Feed rate [m/min]: _____

Machining data

Workpiece material _____ Mode of application: O Against feed O With feed

Cutting quality O Trimming cut O Finish cut O Pre-Trimming O Finish-Trimming

Cutting direction O With grain O Across grain O Crosscut wood O Contour O Drill

Profile as drawing no. O Drawing O Wood sample O Tool sample O Customer drawing

Version hoggers O Folding O Stepped O Circular cut O Double hogging O Scoring / Hogging

Tool data

Type of tool _____ Prod. group _____ Class-No. _____

O Single tool O Set tool O Bolted O Pinned

Ø D [mm] _____ B [mm] _____ Ø d [mm] _____ Hub diameter [mm] _____

Z [qty.] ____ Raker [qty.] ____ Spur [qty.] _____ O Plunge tip O Face cutting edge

KN [mm] _____ DKN [mm] _____ NL [mm] _____ Minor diameter [mm] _____

Shear angle O Yes O No Hook angle [°] _____ TOK runout [°] Description of cutterhead _____

Cutting material O HS O Stellite O HW O DP Cutting material quality _____

Drawing

482-01.0705

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Version 03/2024

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Code designations of the cutting materials

NEW - acc. to ISO	Meaning
SP	alloyed tool steel (minimum 0.6% and no more than 5% alloy constituents)
HS	high-alloyed steel (more than 12% alloy elements Mo, V, Co in total)
ST	casting alloy on cobalt basis e.g. Stellite
HW	uncoated tungsten carbide
VHW	solid tungsten carbide
DP	polycrystalline diamond

Tool attributes

Code designation	Meaning
NL	pin holes
KN	keyway
DKN	double keyway
n	permitted range of RPM
n max	maximum RPM
U min-1	rotations per minute
Vc	cutting speed
Vf	feed speed
Z	number of teeth

Types of feed

Code designation	Meaning
MEC	mechanical feed
MAN	manual feed

Delivery signs

Code designation	Meaning
L	available from stock
O	available on short notice
C	Delivery time on request – price scales available
S	Delivery time on request

LEUCO

MAGENTIFY WOOD PROCESSING

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