LEUCO

CATALOG
SOLID WOOD PROGRAM
SW 02

SAWING
PLANING
PROFILING
FINGER JOINTING / JOINTING

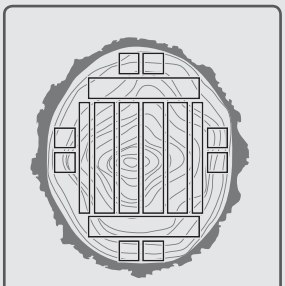
www.leuco.com

FIELDS OF APPLICATION FOR LEUCO TOOLS IN THE SOLID WOOD PROGRAM SW 02:

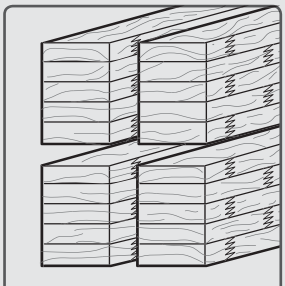
SOLID WOOD

LEUCO tools are used in the whole process chain of the woodworking industry for sawing, planing, profiling and finger jointing/jointing.

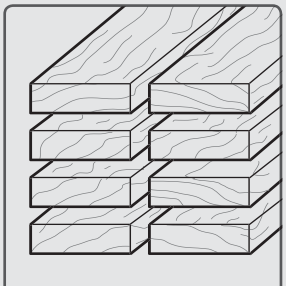
LEUCO is a manufacturer and service provider
We will be pleased to advise you: Whether it's about the selection of the most suitable tool from our standard product range or the development of customer-specific tools!
We attach great importance to offering you the best solution for your application and your machinery!



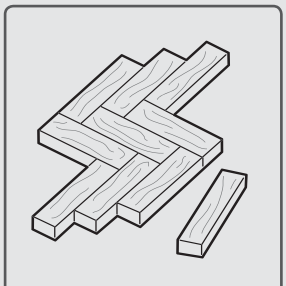
Saw mills



Beams and jointed products



Boards and planed material



Parquet

ALWAYS UP-TO-DATE: TOOLS, APPLICATION SOLUTIONS, NEWS, EVENTS ON OUR WEBSITE!

LEUCO.COM

BRANDS YOU CAN RELY ON

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 ultraprofiler plus	High-performance diamond profile cutters for customized profiles, play-free and quick knife change
LEUCO power DIAProfiler	High-performance diamond profile cutters for highest feed rates

Cutting materials, coatings, and system tools

LEUCO DUR®	LEUCO HW cutting materials
HL Solid®	LEUCO HW cutting materials for solid wood machining
LEUCO TOP COAT	Coatings for the cutting edges, adapted for each application
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

® registered trademarks by LEUCO

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MAGENTIFY WOOD PROCESSING
LEUCO – KEEPING THE WHOLE IN VIEW

LEUCO ranks among the leading international suppliers of complex tools solutions and intelligent services for the wood-working industry.

Our goal is to improve the opportunities for our customers and partners through forward-looking innovations and to open up the potential of wood and related materials as a recyclable raw material to benefit people.

In close contact with our industry, we design and develop tungsten carbide and diamond-tipped circular saw blades, hoggers, boring and shank-type tools, drill bits, turnover knives and clamping devices.

"OUR CUSTOMERS' NEEDS DRIVE OUR INNOVATION.

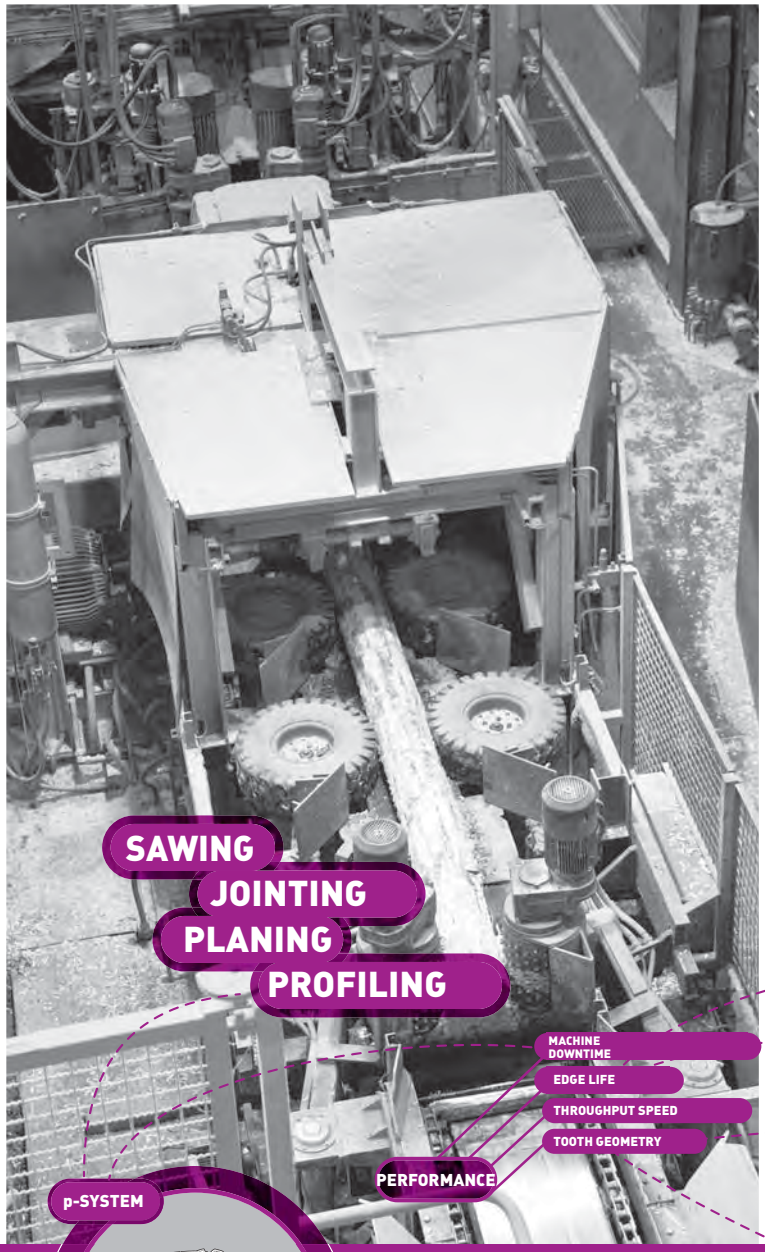
THE DIALOG WITH OUR CUSTOMERS IS THE KEY."

Our goal is to streamline the processes of our customers in the construction, furniture and panel industry, in lumber mills and interior design companies while also opening up new opportunities in working with the growing variety of materials.

Comprehensive consulting services, our sharpening service at manufacturer quality and future tool management solutions have made LEUCO a one-stop tool shop for our customers. Today, around 1,200 employees work for LEUCO worldwide. With sales subsidiaries in Australia, Belgium, England, Japan, Poland, Singapore, Thailand, Ukraine and Belarus, as well as sales and production locations in China, France, Malaysia, Russia, Switzerland, South Africa and the U.S., our company is represented on all five continents.

LEUCO
Magentify Wood Processing

MACHINING OF SOLID WOOD



SAWING
JOINTING
PLANING
PROFILING

COMPETENCE IN CUTTING MATERIALS

LEUCO SERVICE

MACHINE DOWNTIME
EDGE LIFE
THROUGHPUT SPEED
TOOTH GEOMETRY

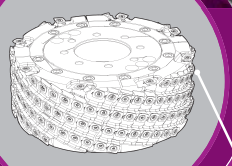
PERFORMANCE

REDUCTION OF DEPOSITS

COATING

QUALITY

p-SYSTEM



Cutting materials

CONCENTRIC ACCURACY

PRECISION
CUTTING QUALITY
NO KNIFE MARKS
SMOOTH SURFACES

CUSTOMER: "In our segment, resource saving and optimal exploitation of waste products is not only a nice savings effect but part of our overall business. Our products often are at the beginning of the process chain. If we supply good quality, the following processors will benefit."

LEUCO: "Designing our tools, we take this responsibility very seriously. Our measures for sawing, finger jointing, planing and profiling are high concentric accuracy, long edge lives, reduction of deposits. This is how you reach best quality, low machine downtimes, high through-feed speed and optimal "waste products"."

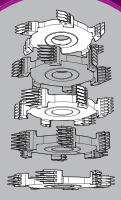
SAWING

FINGER JOINTING

PLANING

PROFILING

POWER DIA PROFILER



Finger joint cutters

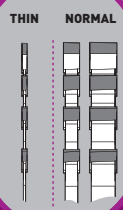
RESOURCE EFFICIENCY

THIN KERFS

CHIP OPTIMIZATION

WASTE OPTIMIZATION

THIN-KERF SAW BLADES



PLANING KNIVES WITH "LEUCO TOPCOAT" COATING FOR A TRIPLE EDGE LIFE

Since the middle of the year 2017, LEUCO planing knives have been available with the still young but proven "LEUCO topcoat" coating. The 3-times higher edge lives compared to uncoated knives convinced the users. Thanks to the new "LEUCO topcoat" coating, the planing knives have anti-adhesion properties and therefore also the undesired heating is avoided.

The coated knives can be used on all common planing cutterheads. They can be resharpened without problems and without damaging the coating. After having resharpened, the knives have again the 3 times higher edge life.

Proven coating

For more than two years, the "LEUCO topcoat" coating on finger joint cutters has convinced thanks to its triple edge life. The coated finger joint cutters are used for deciduous and coniferous wood.

Thanks to the coating of the cutting edge, a general reduction of wear can be achieved. In the future, the "LEUCO topcoat" will be part of the product range regarding tools for solid wood processing.

HIGH-PERFORMANCE PROFILE CUTTERHEAD "ULTRAPROFILER PLUS"

Cutting edges are replaced manually, quickly and with highest precision. The cutting edges of the new **high-performance cutterhead "UltraProfiler plus"** are changed manually but yet quickly with the highest level of precision. With the innovative cutting insert clamp the blades position themselves on their own without clearance. The user only requires a torque wrench and the replacement procedure lasts max. half a minute. The knives have a precise and firm seat; the safety of the head is guaranteed.

The new UltraProfiler plus reaches a cutting speed up to 80 m/min with a feed rate of up to 120 m/min at 6,000 rpm. With its aluminum base frame, the cutterhead is used in double end tenoners and moulders as well as in spindle shapers and machining centers to profile solid timber and wood materials. The cutterhead body and mounting plates will be profiled according to customer specifications with profile depths up to 26 mm.

The new LEUCO cutterhead "Ultraprofiler Plus" allows a cutting speed of up to 80 m/min. Thanks to the new clamping set-up, the user can change the cutters manually with the highest precision.

SOMETHING IS HAPPENING HERE

Timber home builder Rolf Rombach uses the "LEUCO surfCut" Jointing Cutterhead to build "wood only" premium timber homes. And for good reason.

It all really started nine years ago. Rolf Rombach began producing "wood only" elements for luxury home construction. What was new at the time was that all the prefabricated elements were produced from solid beech lumber using threaded rods and no glue. What follows is a success story. Rombach makes every effort to streamline his production processes which is why the inventive timber home builder uses the new high-performance "LEUCO surfCut" Jointing Cutterhead.

It is anything but standard.

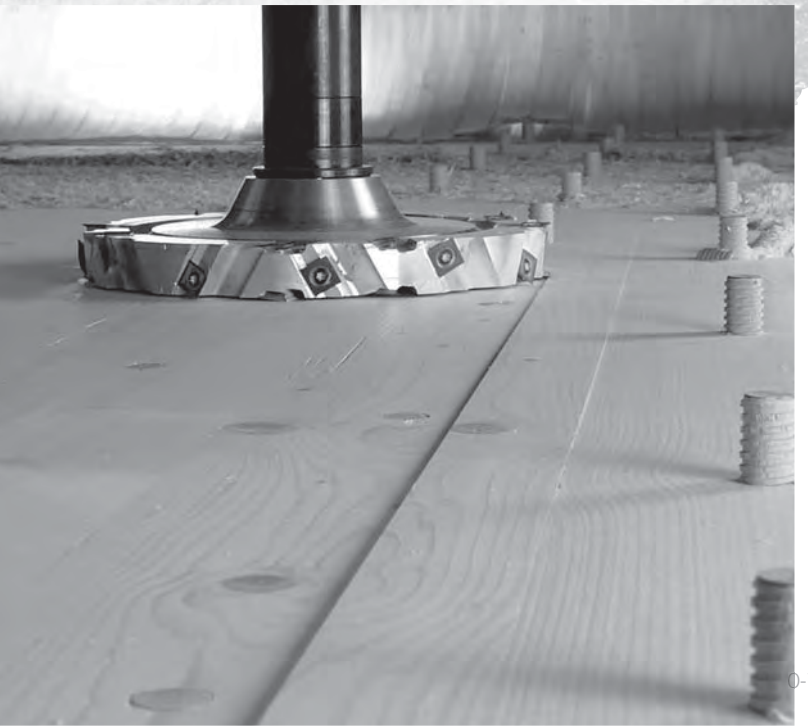
When manufacturing the sold wood elements for "wood only" homes, planed tongue and groove planks are laid in cross and diagonal layers on the assembly tables. An internally configured machine subsequently drills blind holes on the surface in defined grid patterns and screws in the solid wood threaded screws. In the meantime, the machine's counter indicates over 1.7 million. The design is patented and produces torsion-resistant components without the use of glue. The company Rombach Bauholz und Abbund GmbH has evolved into one of the leading builders of timber homes. It has been a long and intense road from a small workshop to one of the most innovative timber home construction companies with roughly 70 employees. Though the "threaded connection holds considerably better than the wooden dowels normally used for this purpose, they are not as easy to produce," explains Rombach. To produce the wood screws, Rombach himself has designed and built a machine to machine wood screws. "We have built a second one in the meantime which is three times as fast and is even more precise," says Rombach with a smile.

> »With the new plain milling cutter, we can work twice as fast compared to the conventional tools, thus reaching about 75% of the machine's potential feed speed, compared to 50% with other tools«
>
> CARPENTER FRANK SCHMID

Uniqueness is key

After stiffly jointing the pieces on the customized production system, another decisive step follows. The elements measuring 2.90 x 8.60 m in size are milled flat and evenly on a Hundegger portal machining center. First of all, this step eliminates the projections on the threaded rods; secondly, the suface is calibrated so that the other side of the element can be evenly grinded later on. With such large sizes, it is a time-intensive process, not to mention the other working steps, such as sizing, folding, grooving, and machining the cut-outs for windows and doors. These cut-outs are already taken into account when laying the boards on the assembly table and only have to be milled to a finish at a later time. The rational manufacturing method for the elements also brings with it numerous problem spots when plain milling the walls. Because each time the plain milling cutter is moved back and forth and chipping occurs with the feed and against the feed, the tool not only goes in and out of the edges numerous times, it also goes through the cut-outs for doors and windows. The cutting quality of the plain milling cutter is therefore decisive, especially because it also functions as the router, grooving cutter and folding unit. "When machining such solid wood, chipping often occurs when the tool exits the wood if moving with the feed," adds Steffen Hampel, head of tool development at LEUCO. The company has addressed these challenges by designing the "LEUCO surfCut" Jointing Cutterhead.

What is the difference ...



The "surfCut" Jointing Cutterhead was designed with a higher axis angle, the turnover knives are larger and more stable. Together with the slightly rounded cutting inserts, this considerably improves the quality of the cutting results, leads to longer edge lives with a simultaneously higher feed speed.

From the left: Company owner Rolf Rombach, carpenter Frank Schmid and Reinhold Isenmann - more info under www.nur-holz.com

What is the difference

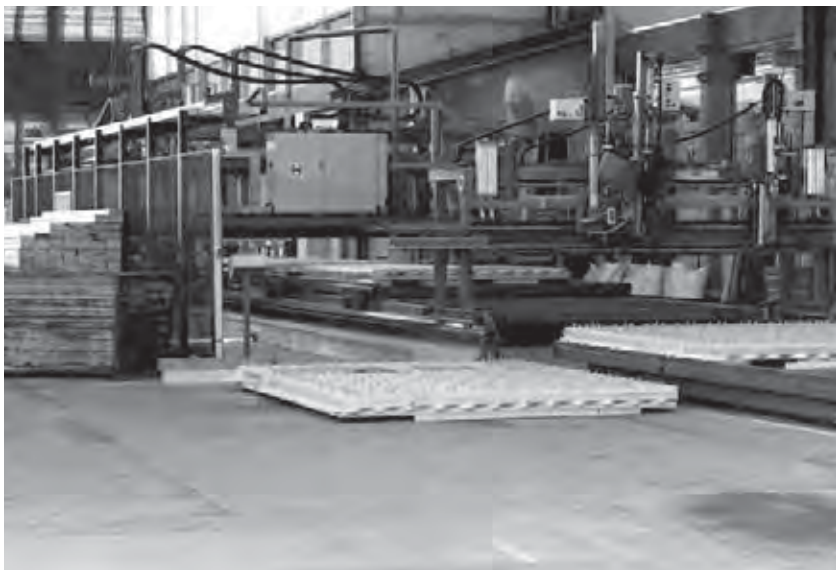
"Compared to conventional jointing cutterheads, we have created the "surfCut" cutterhead with a larger axis angle and also designed the turnover knives to be bigger and more stable," explains a product manager at LEUCO. Together with the slightly rounded cutting inserts, this considerably improves the quality of the cutting results, leads to longer edge lives with a simultaneously higher feed speed. It is no coincidence that Rombach was the first user who recognized the potential of an improved cutting head, especially since it doesn't matter who the manufacturer is when purchasing tool accessories. The company has been using the "surfCut" for roughly one and a half years and has saved time and money in the process. "With the new plain milling cutter, we can work twice as fast compared to conventional tools, thus reaching about 75% of the machine's potential feed speed, compared to 50% with other tools," explains carpenter Frank Schmid, based on his experience. Expert Steffen Hampel can explain this phenomenon: "The tool geometry is optimized specifically for machining spruce and pine. In the process, a lot of branches are chipped, in other words, milled on the front. For this work to go smoothly, the cutting pressure is crucial. And it also depends on the functioning and rapid transfer of the chips out of the tool's gullet." With "surfCut," the gullet is larger and its shape developed and optimized based on these requirements. This prevents twigs and branches from getting jammed, which can increase the cutting pressure and would result in poorly produced surfaces. "In addition, the large gullets and the solid design of the cutting edges largely prevent an edge break," adds Hampel.

The work on the portal machining center from Hundegger was improved using the "LEUCO surfCut" by woodworker Rolf Rombach. His customers now demand an outstanding surface quality. Plain milling the elements is such a basic working step that now takes less time using the new tool, Tobias Wehrle shown here.

In Oberharmersbach, Germany, Rombach produces all prefabricated elements from solid beech wood using threaded rods and no glue. The design is patented and produces torsion-resistant components without the use of glue.

Customers take a close look

The use of the "surfCut" Jointing Cutterhead has reduced the machine downtimes in the company. "Previously, when production was operating in two shifts, cutters had to be replaced every other day, but now, despite higher feed speeds, the cutters only have to be replaced every third or fourth day," explains Schmid. The reduced downtimes and smooth production processes naturally make company CEO Rolf Rombach very happy. Because the "quality demands of our customer base have increased substantially. It's not for nothing that we are always on the look out for better solutions for each working step and have invested heavily in equipping our machine fleet, which includes a grinding machine for machining the surfaces of the exposed ends. Roughly 95% of the elements will not be further planked later. Our customers want to see the wood, so the surface has to be perfect," says Rombach. That's why the surface quality produced using simple milling tools is becoming increasingly insufficient. For Rombach, it is no longer an issue. "Using the LEUCO tool, we can work faster, the edge lives are longer and, in the process, we achieve a cleanly machined surface that looks good," he adds.



Cut-outs for windows and doors are taken into account when laying the boards and only have to be milled to a finish later on. Because each time the plain milling cutter moves back and forth and chipping occurs with and against the feed, the tool goes in and out of the edges numerous times. With the LEUCO surfCut, Rombach can operate the machine with 75% if its potential feed speed.

AT A GLANCE – "LEUCO SURFCUT" JOINTING CUTTERHEAD PRODUCES A QUALITY FINISH

Planing, hemming, tenoning or grooving: The new jointing cutterhead "LEUCO surfCut" impresses wood building companies and carpentry shops.

- Very smooth, chip-free surfaces – even with branches
- Long edge lives – can be operated up to four times longer than conventional ones
- Large gullets can handle high volumes of chips, branches do not get jammed in the gullet
- Reduced machine downtimes – new jointing cutterhead comes with fewer cutters and better performance
- Compatible on all cutting centers, regardless of the machine manufacturer

TALK TO US!

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We supply you with tool solutions i.e. for cutting into wet and frozen raw woods and for finger joint cutters with various cutting edge materials/ coatings for load-bearing and non-load-bearing joints, and much more.

NEW GEOMETRY BRINGS SUCCESS

Redesigned milling cutters reduce chipping on the trailing edge and achieve longer service lives

For almost two years, machine operators at Abies Austria in Oberweis have been working with LEUCO finger jointing cutters distributed through Oertli. The goal of this collaboration right from the start was to reduce the chips on the trailing edge while also extending the service life of the cutters. And it was a resounding success reports the Abies Austria Managing Director Günter Hessenberger:

"Due to heavy chipping on the trailing edge of the cutter, the machine was no longer meeting our needs and expectations," he explained. So the company subsequently began looking for a partner that could provide a solution to this problem." Working together with Oertli, distributor of LEUCO products in Austria, engineers looked for ways to improve the machine. While redesigning and developing the new milling cutter, Oertli engineers took into account the local operating conditions, such as cycle time, the glue used and the control parameters. Ultimately, they wanted to achieve a higher processing quality but with the same production capacity.

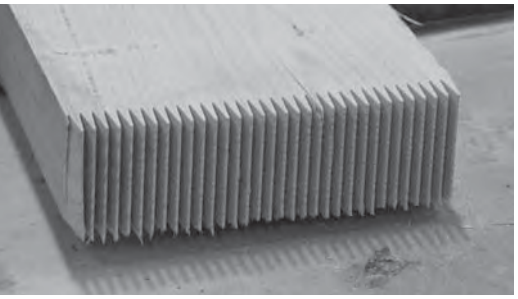
The project partners: Roman Edelhofer, key account manager at Oertli LEUCO and Günter Hessenberger, managing director of Abies Austria, with the redesigned finger joint cutter (from left)

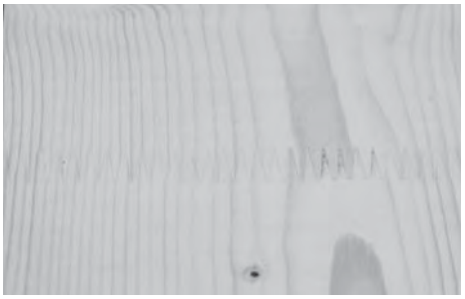
New tooth geometry

The project was divided into two phases. During the first phase, engineers worked on the tooth geometry and, during the second, LEUCO developed a new tool coating. "In changing the tooth geometry, engineers focused on making the way the cutting edge engages more efficient," adds Roman Edelhofer, key account manager at Oertli. In the process, engineers also took into account the fact that the new wedge shape facilitated sufficient clamping for fiber-free glues. These glues are used at Abies Austria because they indicate no swelling behavior and also because they extended the service lives of the planing knives. "It did not take us long to find the right tooth geometry," reports Edelhofer.

Aside from the finger joint cutters, Leuco supplies Abies Austria with circular saw blades. Hessenberger and Edelhofer with a circular saw blade in a customized design.

With the new finger joint cutters, the company has been able to reduce chipping while achieving the same high surface quality (see left photo). According to Hessenberger, the edge life increased by roughly 20%. The redesigned tooth geometry ensures sufficient clamping force between the finger joints (see photo in the middle). The company has now achieved a clean surface with the new system (see right photo).





Resilient coating

Leuco's engineers subsequently developed a new tool coating that further extends the cutter's service life. "This involved finding a middle way between coating thickness and the swelling that develops as a result and the service longevity," explains Edelhofer. During the tool production process, engineers evaporated the coating onto the cutting edge using a vacuum process which rounded the edge to a certain degree. By grinding the face of the cutting tooth, LEUCO ensured the new tool's high precision. This additional work step in producing the cutter has paid off several times over for the customer," says Edelhofer: "The finger joint cutters used always have sharply ground teeth, either as a new tool or after being sharpened." The protective coating is extending the tool's edge life and thus doing what it was designed to do. "Taking all needs into account, we succeeded in finding a good solution. As a result, we are benefiting greatly from our experiences with coatings," indicates Edelhofer.

Edge life +20 %

"We are satisfied with the result. The modifications we made have increased the service life by roughly one-fifth. At the same time, the surface quality improved. Given these improvements, we also made sure that the costs remained transparent," explains Hessenberger.

Broad range of products

The broad product portfolio from Abies Austria covers not only quality laminated timber, but includes ready-to-build construction kits for garden sheds and carports. To be able to produce the construction kits ourselves, the company invested in a refurbished Hundegger K1 joinery machine in 2014, which is used to produce any and all necessary joinery connections. In the past years, the managing director observed that a certain breadth in the range of products and services was becoming increasingly important. "Wood processing is getting increasingly complex. For certain projects, it is important to have a broad range of products because you only get the contract if you can handle the entire order," explains Hessenberger.

From finger joint cutters to joinery tools

"Since the joint development project, LEUCO now also supplies the company with circular saw blades, primarily in special dimensions. These are adjusted to the application parameters in the machine fleet. Furthermore, Leuco also supplies Abies Austria with coated and uncoated planing knives. LEUCO believes that to achieve outstanding customer satisfaction, not only good consulting prior to purchase is decisive, but also good follow-up service. Therefore, a service employee from its distributor Oertli stops by weekly and takes care of the tools by dropping off sharpened blades and picking up those that need to be sharpened. LEUCO is already developing new tools and coating systems. Oertli is also increasingly taking care of Abis Austria's CNC joinery tools. Edelhofer also mentions the LIGNA trade show where both manufacturers intend to present new products."

This article appeared in Holzkurier issue 15/2017

ABIES AUSTRIA

Location: Oberweis, Austria
Founded: 2005
Managing director: Andreas Maxwald, Günter Hessenberger
Employees: 43
Products: quality laminated timber in visible and non-visible quality, Timber framing, log-house timber and finished construction kits, carports

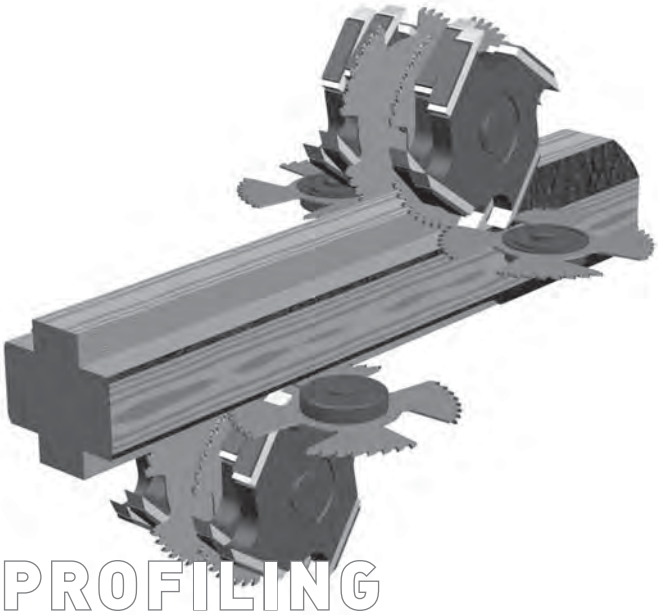
Abies Austria was founded in 2005 by Andreas Maxwald and Günter Hessenberger. It has been producing quality laminated timber in the Upper Austrian town of Oberweis since June 2006.

At the customer's request, the company order picks the goods.

After planing, the quality laminated timber is cut to the desired length.

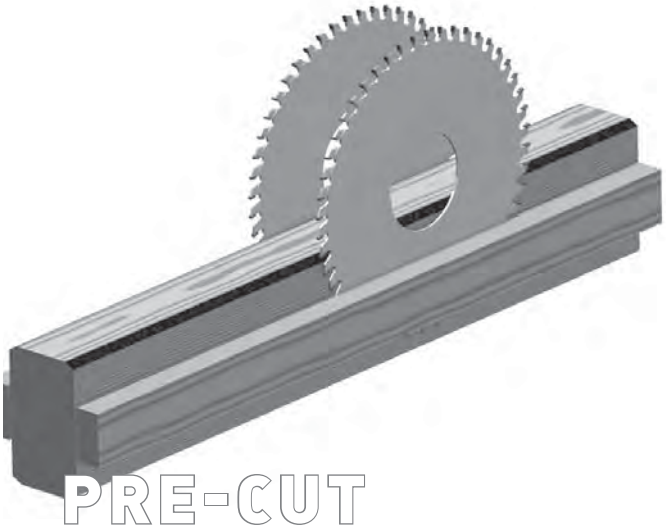
Joinery work is also part of the range of services provided by Abies Austria. For example, the company offers construction kits for garden sheds and carports.

CHIPPING

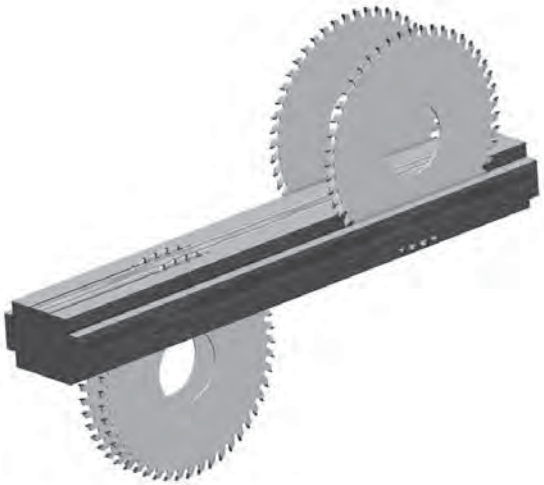


PROFILING

Sawmills



PRE-CUT



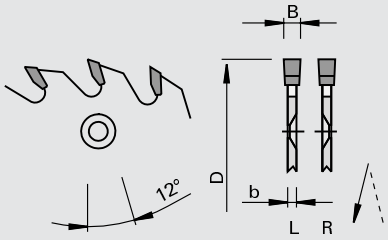
RE-CUT

116410

Hogger Rings HW “F” - Linck

Product

Drawing



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

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724	4,5	3.5	6.0	684	586	64	Linck VM45	80371095 s	80371094 s
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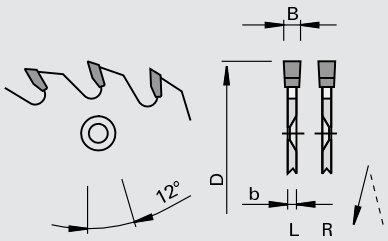
116410

Hogger Rings HW “F” - EWD

Product

Drawing



Tungsten Carbide [HW]

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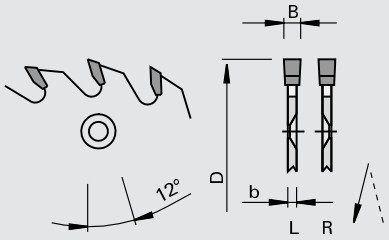
116410

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

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- Ident-No. is only for orientation

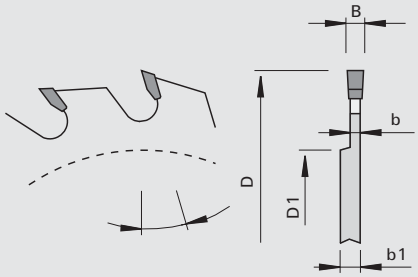
Ø D	B	b	b1	D1	Ø d	Z	Ident-No. [L]	Ident-No. [R]
560	5,0	3.6	5.8	485	405	48-4	80317242 s	80317243 s
605	4,4	3.2	6.0	540	440	48	80294208 s	80294209 s
620	5,0	3.8	5.0	540	450	60-3	80206577 s	80206581 s
630	4,4	3.2	6.0	539	440	48-3	80274257 s	80274262 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

116200

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	D1	b1	Z	Ident-No. [L]	Ident-No. [R]
414	3,5	2.5	360	8	10	80334874 s	80335077 s
[mm]	[mm]	[mm]	[mm]	[mm]			

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

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

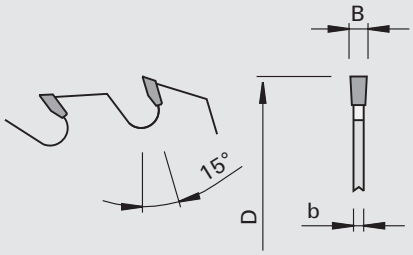
Ø D	B	b	D1	b1	Z	Ident-No. [L]	Ident-No. [R]
498.2	3,5	2.5	447	7	11	80371097 s	80371098 s
[mm]	[mm]	[mm]	[mm]	[mm]			

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

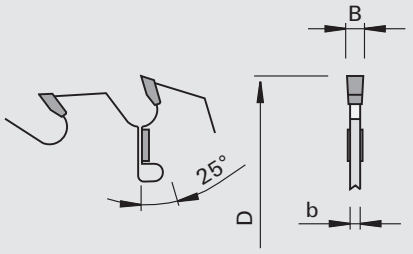
Ø D	B	b	Ø d	Z	Ident-No.
566	5,0	4.0	80	36	80350084 s
[mm]	[mm]	[mm]	[mm]		

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

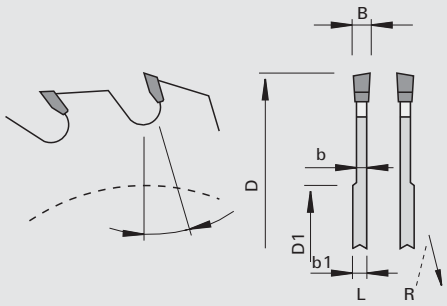
Ø D	B	b	Ø d	Z	Number of rakers	NL	Ident-No.
351	4,6	3.2	70	24	2	1/6,3/100	80366486 s
351	4,6	3.2	70	24	2	1/6,3/100	80371233 s
[mm]	[mm]	[mm]	[mm]		[pc.]		

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

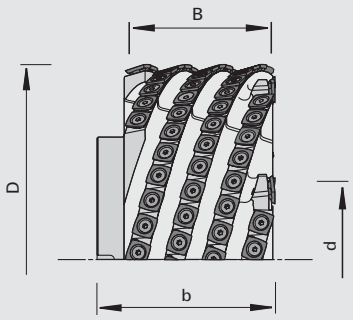
Ø D	B	b	b1	D1	Ø d	Z	DKN	Free slots	Ident-No. [L]	Ident-No. [R]
250	5,2	3.6	6.0	115	70	24-6	20x8	3	80363728 s	80363727 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[pc.]		

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	151559	10	186110
for Ø D=402 mm	21	21	5.5	HL Solid 60	151559	10	186111
	[mm]	[mm]	[mm]			[pc.]	

Spare parts		Dimension	Class-No.	PU	Ident-No.	
Head Cap Screws		M14x60 ISO 4762 12.9	995111	10	185008	
Head Cap Screws		M14x80 DIN 4762 12.9	995111	10	185181	
Conical Screws		M6x10 D7.8x20GRD 10.9	995191	10	184891	
Countersunk Screws		M7x17 T30 10.9	995125	10	185643	
Repair set	thread inserts, twist drills, hand tap, spindle insert, tang break-off tool	M7	985200	1	185881	s
Helicoil®		M7x10,5	995490	10	50930340	
		[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
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.]		

332321

Knives - Linck

Product

Drawing

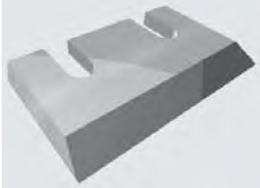
LEUCO DUR

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 #

	Dimension		LEUCODUR	Ident-No.
Chipping knives - Linck	105x92x12 [mm]	1 opening 2 threads M6 on the back	HS	185540



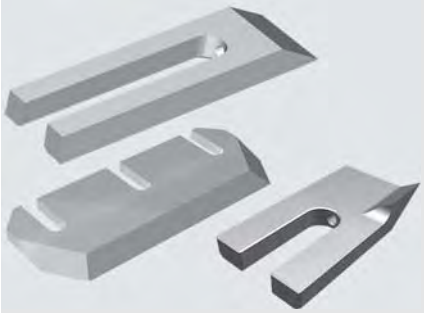
	Dimension		LEUCODUR	Ident-No.
Chipping knives - Linck	184x108x14 [mm]	2 openings 2 threads M6 on the back	HS	185541 #

	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 #

332321

Knives - EWD

Product



Drawing

LEUCO DUR

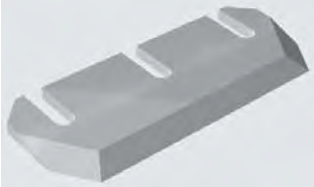
High Speed Steel [HS]

Machine / Application
- EWD
- for hogger lines

Design
- cutting material: HS for the machining of soft woods

Advantages

Notes
- packing unit 10 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
	[mm]				

	Dimension		LEUCODUR		Ident-No.
Chipping knives - EWD	153x40x14,5	1 openings 1 threads M6	HS		186494 s
	[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

Chip Breakers - EWD

Product

Drawing

LEUCO DUR

High Speed Steel [HS]

Machine / Application
- EWD systems

Design

Advantages
- optimized chip breaking

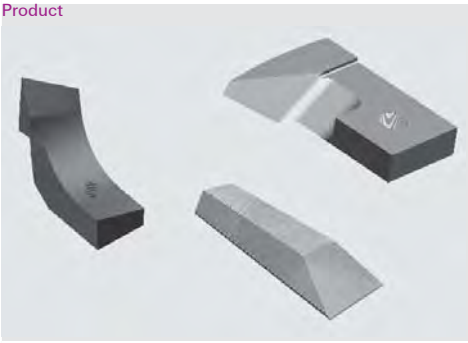
Notes
- packing unit 10 pieces

	Dimension	LEUCODUR		Ident-No.
Chip Breakers - EWD	274x43x25	HS	R	186470 s
Chip Breakers - EWD	274x43x25	HS	L	186469 s
	[mm]			

332321

Knives - Veisto HewSaw

Product



Drawing

LEUCO DUR

High Speed Steel [HS]

Machine / Application

- Veisto HewSaw
- for hogger lines

Design

- cutting material: HS for the machining of soft woods

Advantages

Notes

- packing unit 10 pieces

	Dimension		LEUCODUR		Ident-No.	
Knives - Veisto HewSaw	72x53x34/27,9	1 threads M12	HS	R	185882	s
Knives - Veisto HewSaw	72x53x34/27,9	1 threads M12	HS	L	185883	s
	[mm]					

	Dimension		LEUCODUR		Ident-No.	
Knives - Veisto HewSaw	94,5x19,9x74,5/45	1 threads M16	HS	R	185884	s
Knives - Veisto HewSaw	94,5x19,9x74,5/45	1 threads M16	HS	L	185885	s
	[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

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- for hogger lines

Design

- cutting material: HW HL Solid 20 for hard and soft woods

Advantages

Notes

- packing unit 10 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]				

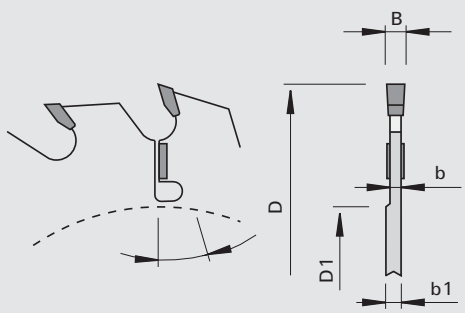
	Dimension		LEUCODUR		Ident-No.
Peel Knives	90x60x21	2 threads M12	HW	R	185889 s
Peel Knives	105x60x20	2 threads M12	HW	R	185888 s
	[mm]				

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

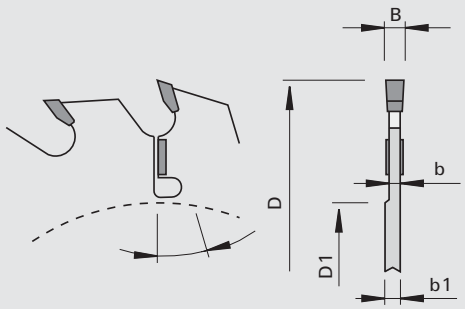
Ø D	B	b	b1	D1	Ø d	Z	Number of rakers	NL	DKN		Ident-No. [L]	Ident-No. [R]
445	4,8	3.2	6.8	190	120	28	4	4/13/156		Linck VS	80250724 s	80250723 s
470	5,0	3.6	6.8	190	120	28	6	8/13/156		Linck VS	80290358 s	80290357 s
505	5,6	3.8	6.8	190	120	28	4	8/14,5/156		Linck VS	80281372 s	80281373 s
520	5,0	3.2			110	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

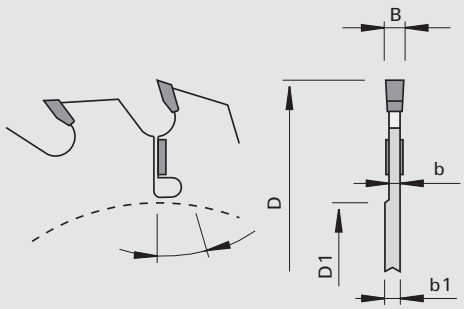
Ø D	B	b	b1	D1	Ø d	Z	Number of rakers	NL	DKN		Ident-No. [L]	Ident-No. [R]
560	4,8	3.2	7.0	220	150	32	6	6/10,25/175		EWD FR 15	80291675 s	80291674 s
565	5,2	3.4	7.0	205	160	42	6	6/11/182,5 + 12/8,5/182,5	22,2x5,4	EWD DWK	80297832 s	80297833 s
580	4,1	2.8	5.5	300	160	32	6	6/12/182,5	23x6	EWD DWK	80309039 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”

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

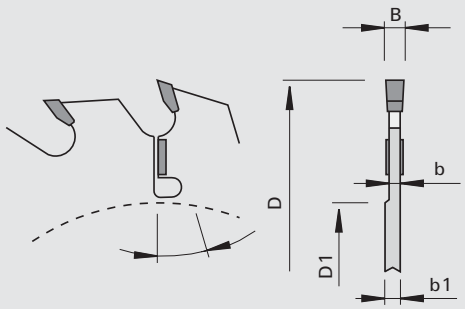
Ø D	B	b	b1	D1	Ø d	Z	Number of rakers	NL		Ident-No. [L]	Ident-No. [R]
595	5,2	3.6	6.8	190	105	20	6	8/13/156	Möhringer	80293989 s	80293990 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]				

101316

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

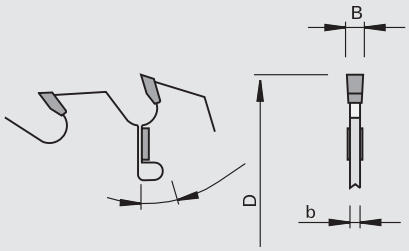
Ø D	B	b	b1	D1	Ø d	Z	Number of rakers	DKN		Ident-No.
520	3,6	2.2			150	36	4	37x10	Linck MKV	80231924 s
520	4,6	3.2			150	28	6	37x10	Linck MKV	80255324 s
540	4,8	3.4			150	24	4	37x10	Linck MKV	80254014 s
540	4,4	2.8	4.9	230	150	28	6	37x10	Linck MKV	80259614 s
540	3,2	2.0			150	46	4	37x10	Linck MKV	80273199 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]		

101316

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

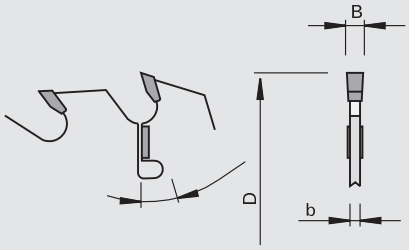
Ø D	B	b	Ø d	Z	Number of rakers	DKN		Ident-No.
450	3,8	2.5	110	24	4	17x8	EWD FR	80264025 s
450	4,2	2.7	150	36	4	37x7	EWD	80225333 s
500	4,4	3.0	150	24	4	37x7	EWD FR12	80236978 s
520	4,9	3.4	150	24	6	36,5x4	EWD FR12	80291680 s
520	4,9	3.4	150	48	6	36,5x4	EWD FR12	80291939 s
520	4,9	3.4	150	32	6	36,5x4	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
- 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		Ident-No.
351	4,4	3.2	70	24	2+2	HewSaw	192611
[mm]	[mm]	[mm]	[mm]		[pc.]		

955520

Spacer rings - steel

Product

Notes

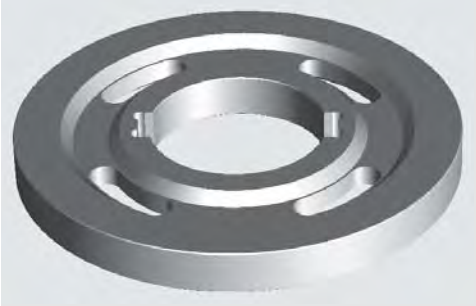
- Spacer rings for sawmills
- Other designs and dimensions on request

Ø D	B	Ø d	DKN	Ident-No.
150	0,5	115	29x131	80370453 s
150	1,0	115	29x131	80370454 s
190	2,0	150	36,3x167	80383237 s
190	3,0	150	36,3x167	80383238 s
190	5,0	150	36,3x167	80383239 s
190	10,5	150	37x170	80387052 s
190	11,5	150	37x170	80387053 s
190	12,5	150	37x170	80387054 s
190	40,4	150	37x170	80387912 s
200	1,0	150	37x157,8	80291659 s
200	2,0	150	37x157,8	80291660 s
200	3,0	150	37x157,8	80291661 s
200	6,8	150	37x157,8	80404151 s
200	21,6	150	37x157,8	80291663 s
200	31,6	150	37x157,8	80291662 s
220	10,4	150	37x170	80283020 s
270	10	150	36,3x167	80363407 s
270	30	150	36,5x168	80386011 s
270	150	150	36,3x167	80354756 s
320	10,4	150	37x170	80283019 s
[mm]	[mm]	[mm]	[mm]	

955520

Spacer rings - aluminum, stepped

Product



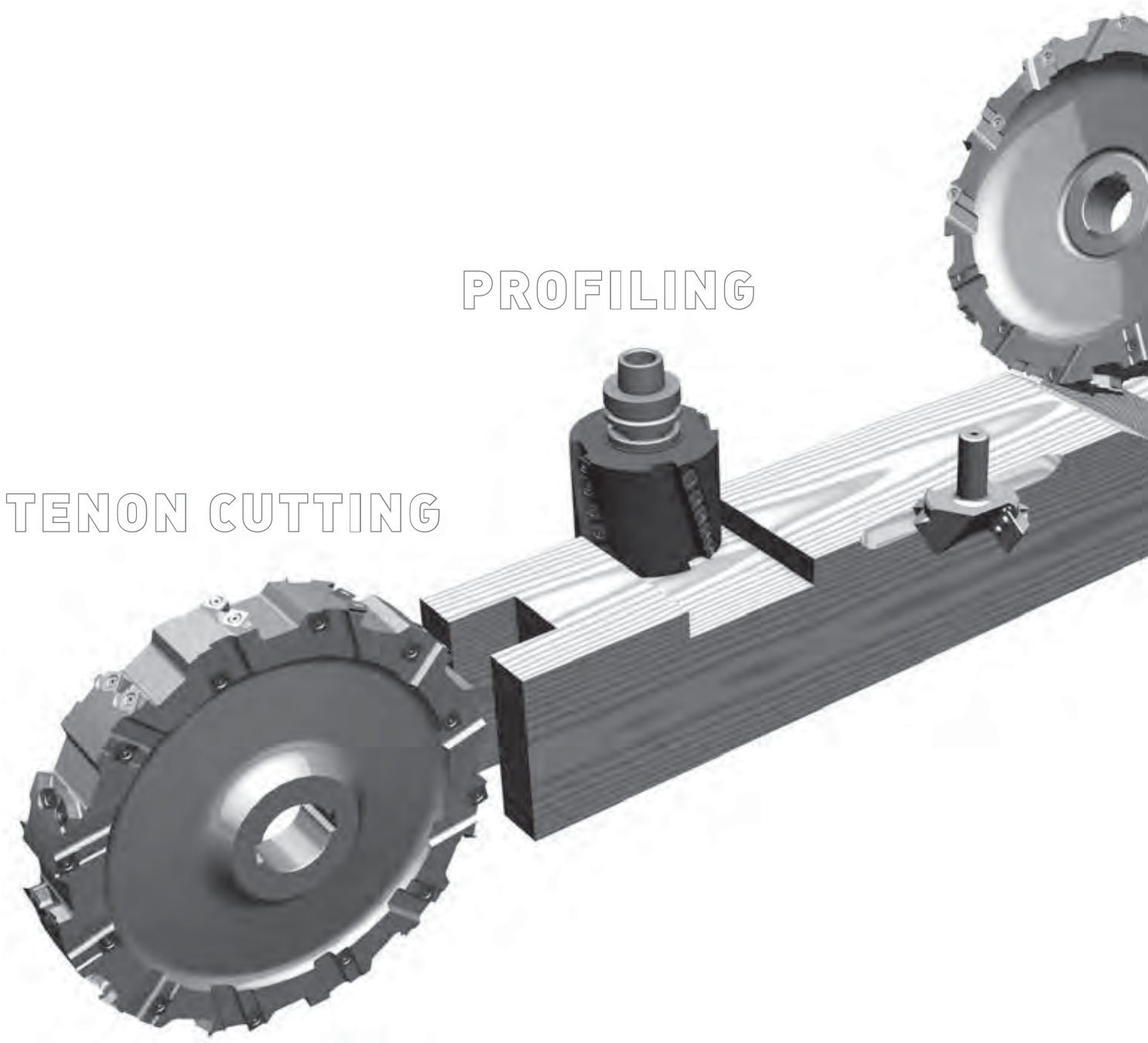
Notes

- Spacer rings for sawmills
- Other designs and dimensions on request

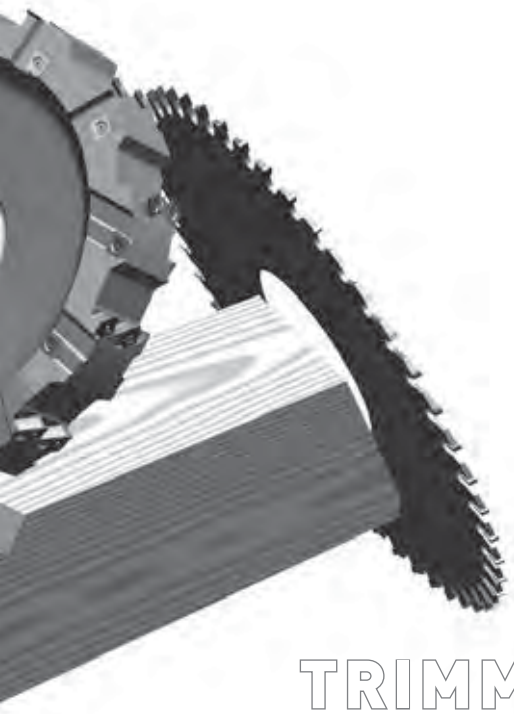
Ø D	B	Ø d	DKN	Ident-No.
380	37,7	150	37x170	80187182 s
[mm]	[mm]	[mm]	[mm]	

PROFILING

TENON CUTTING



Joinery Technique



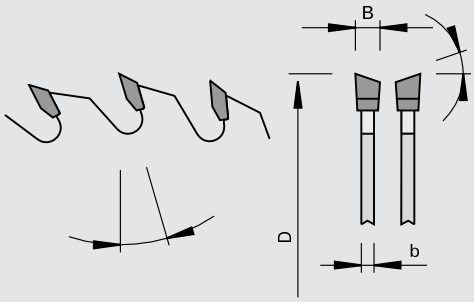
TRIMMING

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

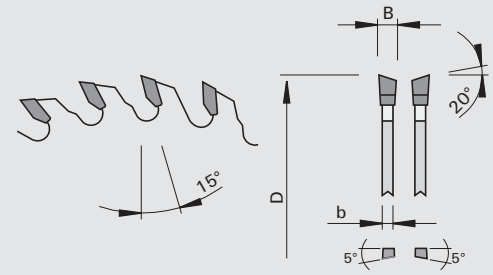
Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁		Ident-No.
230	3,2	2.2	40	40	8/5,5/52	10	15	Weinmann	192427
240	3,0	2.0	40	30	8/6/52	10	15	Weinmann	192428
[mm]	[mm]	[mm]	[mm]			[°]	[°]		

101320

Double Clipping Saw Blades HW with cooling slots “WSA”

Product

Drawing



LEUCO topline

LEUCO DUR

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

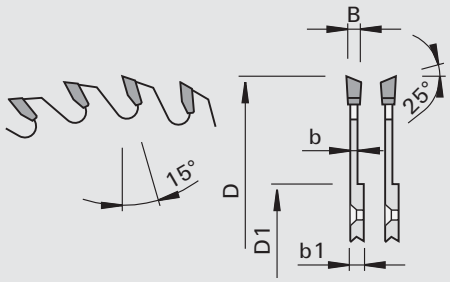
Ø D	B	b	Ø d	Z	NL		Ident-No.	
350	4,0	2.6	30	54	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42		189788	
400	4,4	3.0	30	60	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42		189789	
450	4,4	3.0	30	72	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42		189790	
500	4,8	3.2	30	72	2/10/80		189792	
500	4,8	3.2	30	108	2/10/80 + 2/15/63		189794	
550	4,8	3.2	30	72	2/10/80		189795	
600	5,4	4.0	30	72	2/10/80 + 2/15/63		189796	s
630	5,4	4.0	40	72	2/10/60		189797	
650	5,6	4.0	30	96	2/10/80 + 2/15/63		189798	
650	5,6	4.0	30	54	2/10/80 + 2/15/63		189799	s
720	6,2	4.4	30	48	2/8,5/90	Hundegger	189800	s
720	6,2	4.4	30	72	2/8,5/90	Hundegger	189801	
735	6,2	4.4	30	48	2/8,5/90	Hundegger	189802	s
735	6,2	4.4	30	72	2/8,5/90	Hundegger	189803	s
760	6,2	4.4	30	48	2/14/400 + 4/8,5/90	Hundegger	189804	s
760	6,2	4.4	30	72	2/14/400 + 4/8,5/90	Hundegger	189805	s
760	6,2	4.4	30	96	2/14/400 + 4/8,5/90	Hundegger	189806	
800	6,2	4.4	30	48		Paul	189807	s
[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

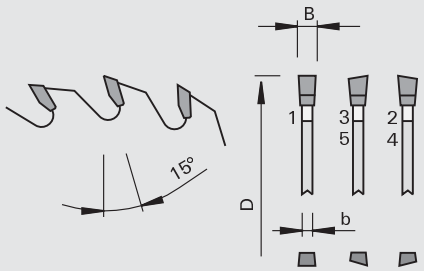
Ø D	B	b	b1	D1	Ø d	Z	NL		Ident-No.
555	5,2	3.6	6.0	115	55	54	6/6,6/75	Weinmann	192656
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]				

101380

Clipping Saw Blades HW - 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
- tooth configuration: “G5”
- cutting material: HW HL Board 10

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

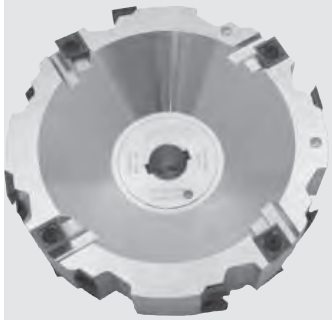
Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
800	6,5	5.0	30	80	4/9/90 + 2/14/400	Hundegger	193097
[mm]	[mm]	[mm]	[mm]				

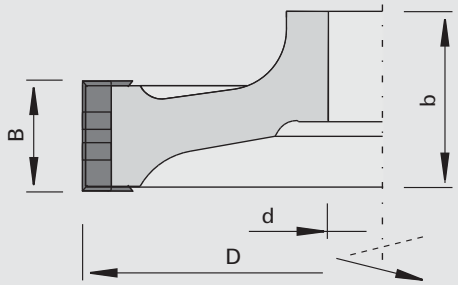
120261

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.

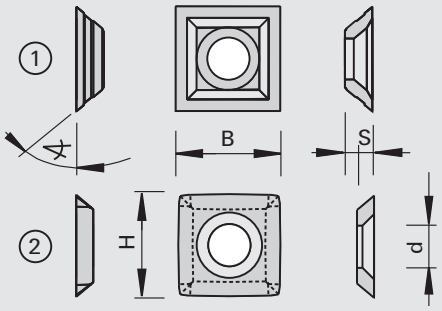
Ø D	B	b	Ø d	Z	DKN		Ident-No.
250	125	125	55	4+4		Weinmann	186169 s
300	20	80	55	4+4		Weinmann	186170 s
300	40	80	55	4+4		Weinmann	186171 s
350	40	75	55	4+4	16x4,3	Hundegger	186174 s
350	20	75	55	4+4	16x4,3	Hundegger	186175 s
350	60	75	55	4+4	16x4,3	Hundegger	186176 s
[mm]	[mm]	[mm]	[mm]		[mm]		

150516 / 150518 / 151557

Turnover Knives HW with 4 cutting edges with countersink - Hundegger

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

Notes
- packing unit 10 pieces
- Attention! it is not permitted to mount Ident-No. 186667 + 186668 togehter in one cutterhead. Danger of unbalance!

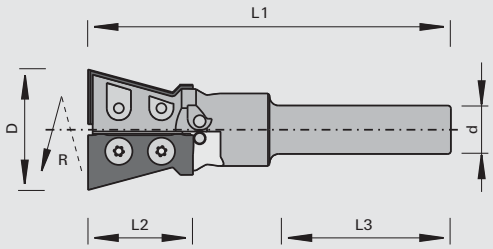
Type	B	H	S	Ø d	Wedge◁			LEUCODUR	Ident-No.
1	20,6	20.6	5.5	7,3	50	for surfCut cutterhead, with rounded edges (R=172 mm)	Hundegger	HL Solid 30	186667
1	21	21	5.5	7,3	50	with groove	Hundegger	HL Solid 30	186668
2	11,95	11.95	1.5	4,0	55	with rounded edges (R=70 mm)	Hundegger	HL Board 06	186448
2	13,8	13.8	2.5	6,2	60	with rounded edges (R=180 mm)		HL Solid 20	184942
2	15	15	2.5	6,2	50	with rounded edges (R=170 mm)	Hundegger	HL Solid 20	185367
	[mm]	[mm]	[mm]	[mm]	[°]				

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
[mm]	[mm]	[mm]	[mm]	[mm]		

Knives	B	H	S	Class-No.	PU	Ident-No.
without serration	34,9	18.6	2.0	151557	3	185363
	[mm]	[mm]	[mm]		[pc.]	

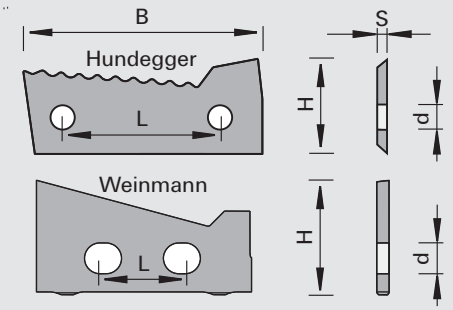
Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M4x5,9 T15	995195	10	167966
Screwdrivers	T15	985730	1	163161
	[mm]		[pc.]	

151557

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	10	185205	185510
39,5	15.7	1.5	4,0	26	55	B	Hundegger	10	185206	185511
39,5	15.7	1.5	4,0	26	55	C	Hundegger	10	185207	185512
[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	3	185363
[mm]	[mm]	[mm]	[mm]	[mm]	[°]			[pc.]	

FRAME JOINTS

DOOR LEAVES

DOOR FILLINGS

HANDLE HOLE / KEY HOLE

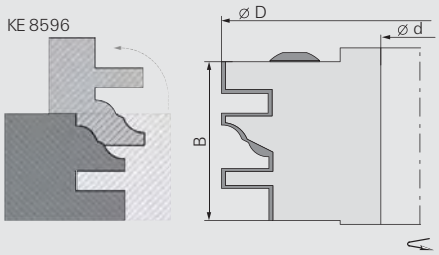
Door Manufacturing

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

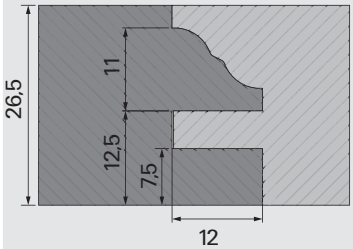
- counter profile set with profile KE8596
- alternative profiles not included in delivery

Ø D	B	Ø d	Z	nmin-nmax	Ident-No.
130 [mm]	40 [mm]	30 [mm]	2	6000-12000 [min-1]	50664637

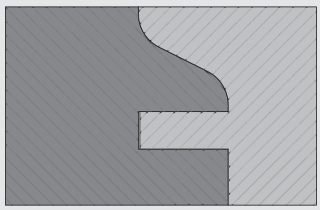
Turnover Knives	LEUCODUR	Class-No.	PU	Ident-No.	
Profile Knives KE7824	HL Board 06	151586	6	50687824	s
Profile Knives KE7826	HL Board 06	151586	2	50687826	
Profile Knives KE7828	HL Board 06	151586	6	50687828	s
Profile Knives KE8596	HL Board 06	151586	2	50688596	#
Profile Knives KE8598	HL Board 06	151586	6	50688598	s
			[pc.]		

Spare parts	Dimension	Class-No.	PU	Ident-No.	
Pressure Bars	B=36	925300	2	50773906	#
Set Screws	M6x16 SW3	995161	10	001617	
Screwdrivers	SW3x100	985730	1	166090	
	[mm]		[pc.]		

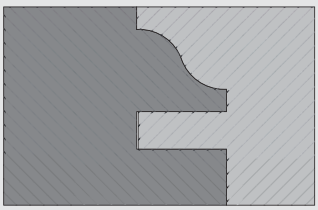
KE 8596



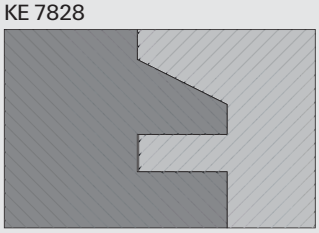
KE 7824



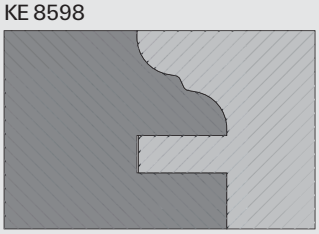
KE 7826



KE 7828



KE 8598

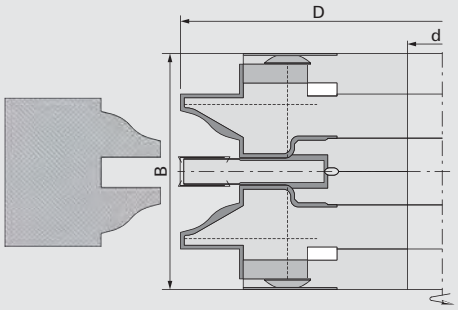


121625

Counter Profile Set HW

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- spindle moulder
- for cutting of profile and counter profile in solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- cutting material: HW
- modular combination tool

Advantages

- cutterhead for mounting of several profile knives
- universal application with low expenses

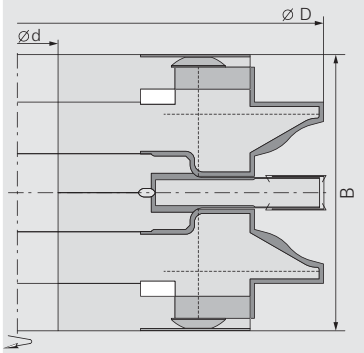
Notes

- counter profile set with profile A
- alternative profiles not included in delivery

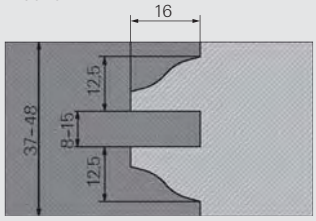
Ø D	B	Ø d	Z	Profile	nmin-nmax	Ident-No.
160	37-48	30	2	A	4800-8200	50664655
[mm]	[mm]	[mm]			[min-1]	

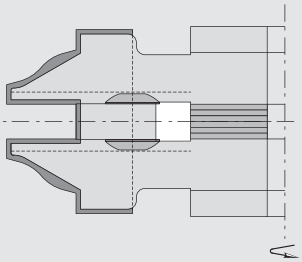
Knives	Profile	B	H	S	LEUCODUR	Class-No.	PU	Ident-No.	
Profile Knives KE8620	A	25,3	29	2.0	HL Board 06	151586	6	50688620	s
Profile Knives KE8621	A	25,3	29	2.0	HL Board 06	151586	6	50688621	s
Profile Knives KE8622	B	25,3	29	2.0	HL Board 06	151586	2	50688622	#
Profile Knives KE8623	B	25,3	29	2.0	HL Board 06	151586	6	50688623	s
Profile Knives KE8624	C	25,3	29	2.0	HL Board 06	151586	6	50688624	s
Profile Knives KE8625	C	25,3	29	2.0	HL Board 06	151586	6	50688625	s
Profile Knives KE8626	D	25,3	29	2.0	HL Board 06	151586	6	50688626	s
Profile Knives KE8627	D	25,3	29	2.0	HL Board 06	151586	6	50688627	s
Profile Knives KE8628	E	25,3	29	2.0	HL Board 06	151586	6	50688628	s
Profile Knives KE8629	E	25,3	29	2.0	HL Board 06	151586	6	50688629	s
Raker Turnover Knives		7,5	12	1.5	HL Board 05	150515	10	50820007	
Turnover Knives		14	14	2.0	HL Solid 30	150518	10	50820014	
		[mm]	[mm]	[mm]			[pc.]		

Spare parts	Dimension	Class-No.	PU	Ident-No.	
Pressure Bars	B=23	925300	2	50774798	#
Pressure Bars	B=7,2	925300	2	168074	
Set Screws	M6x16 SW3	995161	10	001617	
Set Screws	M5x12 DIN EN ISO 4028	995161	10	050565	
Countersunk Screws	M5x6 T20	995125	10	176199	
Screwdrivers	SW3x100	985730	1	166090	
Cranked Wrench Keys	SW2,5 DIN ISO 2936	985730	1	009671	
Screwdrivers	T20x100	985730	1	166092	
Adjusting Gauges	0,3	985200	1	055883	
Spacer Sets	65/30x20 TK48	955521	1	50252708	
	[mm]		[pc.]		



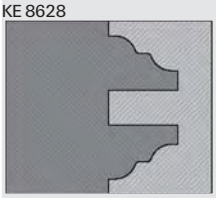
KE 8620





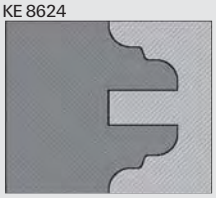
KE 8621

KE 8628



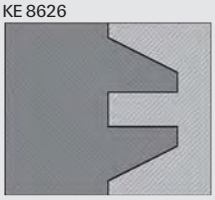
KE 8629

KE 8624



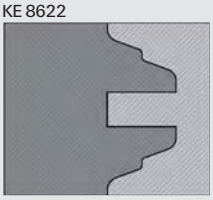
KE 8626

KE 8626



KE 8627

KE 8622



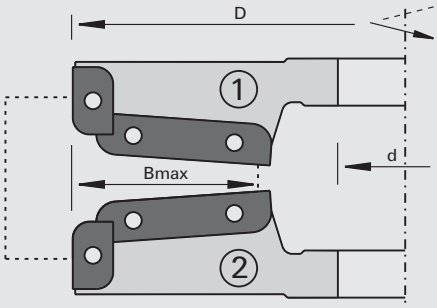
KE 8623

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

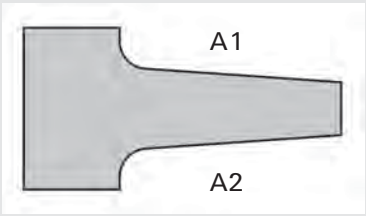
Notes

- included in delivery: 1 panel raising cutterhead with mounted knives for profile B (62556021, 62556022)
- alternative profiles not included in delivery

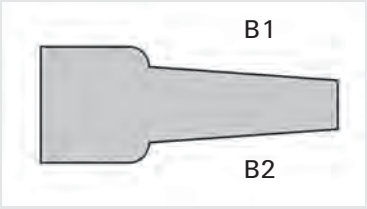
Cutter-no.	Ø D	Bmax	Ø d	Z	nmin-nmax		Ident-No.	
1	200	60	30	2+2	3800 - 6500	L	68255130	o
2	200	60	30	2+2	3800 - 6500	R	68255230	o
1	200	60	40	2+2	3800 - 6500	L	68255140	o
2	200	60	40	2+2	3800 - 6500	R	68255240	o
1	200	60	50	2+2	3800 - 6500	L	68255150	o
2	200	60	50	2+2	3800 - 6500	R	68255250	o
	[mm]	[mm]	[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	o
Profile Panel Raising Cutting Edges A2	60x12x1,5	68255230, 68255240, 68255250	151549	6	R	62556012	o
Profile Panel Raising Cutting Edges B1	60x12x1,5	68255130, 68255140, 68255150	151549	6	L	62556021	o
Profile Panel Raising Cutting Edges B2	60x12x1,5	68255230, 68255240, 68255250	151549	6	R	62556022	o
Profile Panel Raising Cutting Edges C1	60x12x1,5	68255130, 68255140, 68255150	151549	6	L	62556031	o
Profile Panel Raising Cutting Edges C2	60x12x1,5	68255230, 68255240, 68255250	151549	6	R	62556032	o
Profile Peripheral Cutting Edges T1	20x12x1,5	68255130, 68255140, 68255150	151549	6	L	62556023	o
Profile Panel Raising Cutting Edges T2	20x12x1,5	68255230, 68255240, 68255250	151549	6	R	62556024	o
Profile Peripheral Cutting Edges V1	20x12x1,5	68255130, 68255140, 68255150	151549	6	L	62556013	o
Profile Panel Raising Cutting Edges V2	20x12x1,5	68255230, 68255240, 68255250	151549	6	R	62556014	o
	[mm]			[pc.]			

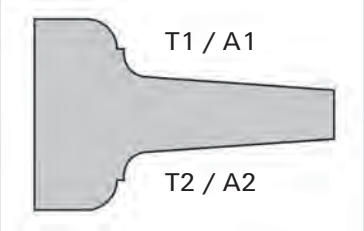
Profile combinations



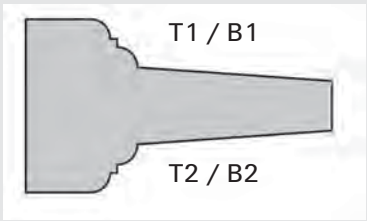
A



B



A/T



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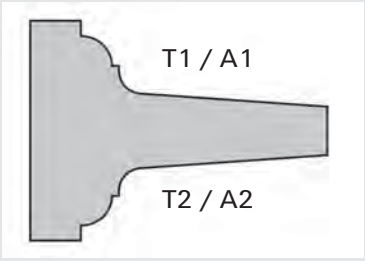
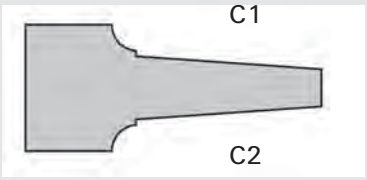
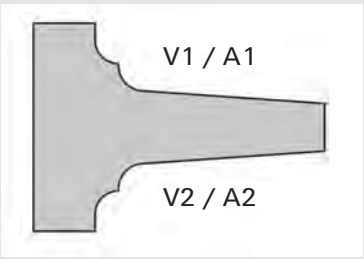


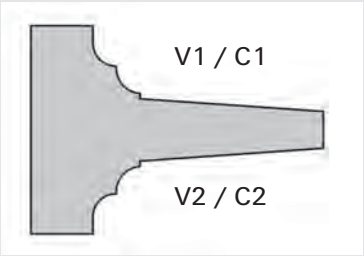
A/T



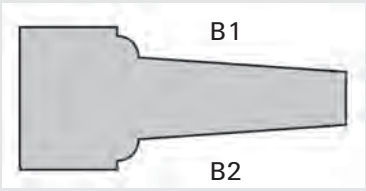
C



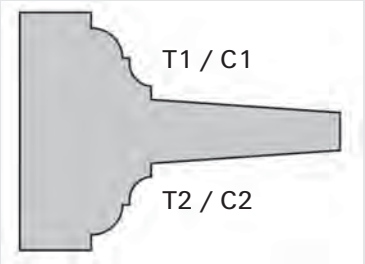
A/V



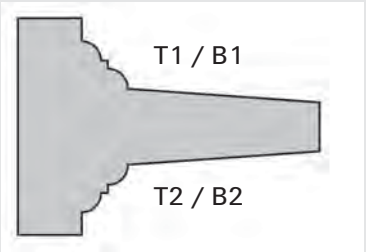
CV



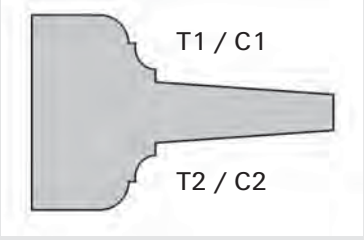
B



CT



B/T



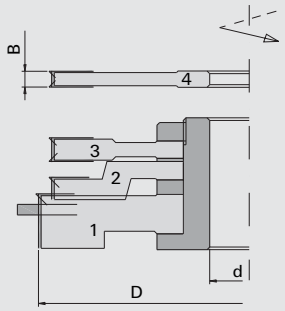
CT

120455

Door leaf set HW

Product

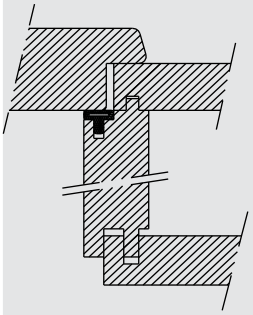
Drawing



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

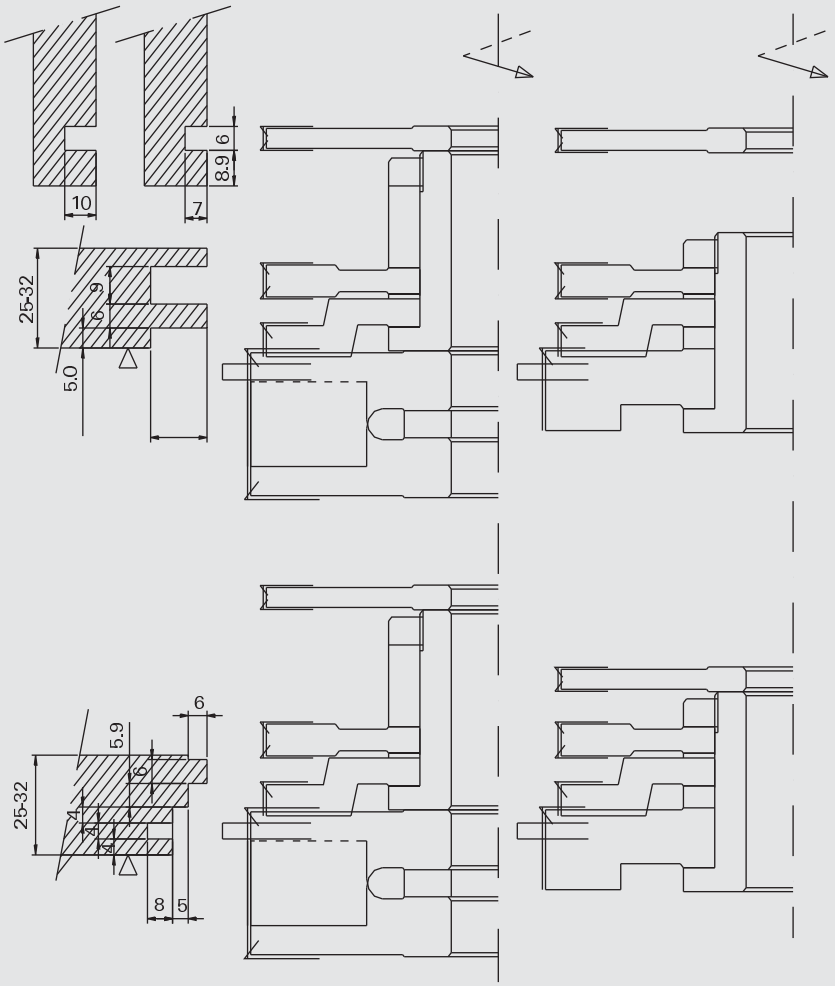
- Ident-No. 199399 with 887060 for complete processing
- Ident-No. 199398 as construction set for Poly Rabbeting Cutterhead

Ø D	B	Ø d	Z		Ident-No. top	
150		30	2+2	Cutter 2/3 on clamping bushing	199398	
150		30	2+2	Cutter 1/2/3 on clamping bushing	199399	
150	9,0	30	4+4	Cutter 3	887059	o
150	6,0	30	4+4	Cutter 4	887060	
[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	
Spurs	14	14	1.2	for cutter 4	150558	10	163701	
VHW grooving cutter	4,0			for cutter 1	151512	10	199699	
Turnover Knives	20	12	1.5	for cutter 1	150515	10	003082	
Turnover Knives	7,5	12	1.5	for cutter 2	150515	10	052543	
Turnover Knives	8,6	12	1.5	for cutter 3	150512	10	881585	
Turnover Knives	18	18	2.9	for cutter 4	150514	10	418977	
	[mm]	[mm]	[mm]			[pc.]		

Spare parts	Dimension		Class-No.	PU	Ident-No.	
Pressure Bars		for cutter 1	925300	2	882863	
Pressure Bars	B=7,2	for cutters 2/3	925100	2	870829	
Countersunk Screws	M5x7 T15	for cutters 1/2/3	995125	10	900512	
Set Screws	M6x16 SW3	for cutter 1	995161	10	001617	
Screws	M5x16	for cutter 2	995161	10	872063	
Set Screws	M5x16 DIN EN ISO 4028	for cutter 3	995161	10	873731	
Special Nuts	M4x0,5x1,6	for cutter 4 / 163701	995290	10	163704	
Special Nuts	M4x0,5x2,2	for cutter 4	995290	10	874748	
Countersunk Screws	M4x0,5x4,2 T9	for cutter 4	995125	10	165908	
Countersunk Screws	M5x13,5 T20	for cutter 1	995125	10	171238	
Screwdrivers	T15	for cutters 1/2/3	985730	1	013953	s
	[mm]			[pc.]		

Spare parts	Dimension		Class-No.	PU	Ident-No.
Screwdrivers	T20	for cutter 1	985730	1	013954
Cranked Wrench Keys	SW2,5 DIN ISO 2936	for cutters 1/2/3	985730	1	009671
Hook Wrenches	68-75	for clamping bushing	985730	1	873631
Magnetic Stops	0,5	for cutters 1/2/3	997800	1	166093
	[mm]			[pc.]	

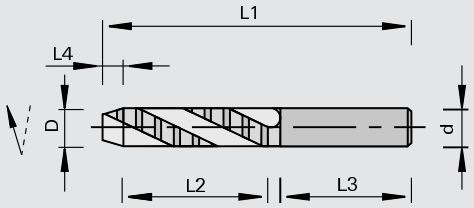


129460

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

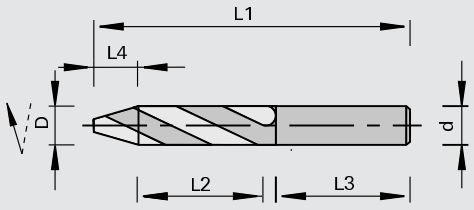
Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
16	5.0	75	16	48	130	2	185831
20	5.0	75	20	50	135	3	185832
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

129460

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

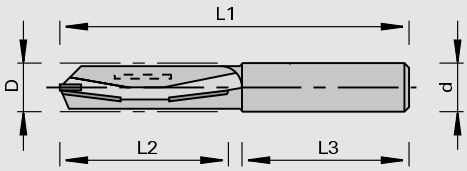
Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
12	10	47	12	53	110	2	185826
12	10	70	12	50	130	2	185828
14	10	47	14	45	110	2	185829
16	11	52	16	60	130	2	185830
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

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

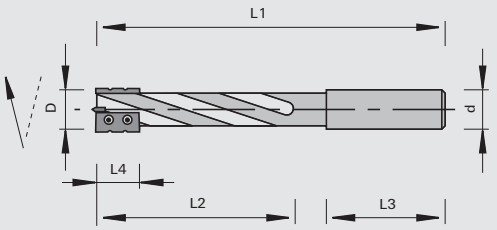
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
14	50	14	48	100	1+1+1	167662
[mm]	[mm]	[mm]	[mm]	[mm]		

129410

Lock-Case Cutters with HW Knives - door manufacturing

Product

Drawing

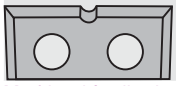


LEUCO DUR

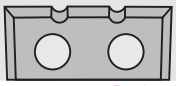
Tungsten Carbide [HW]

MEC

A



B



Machine / Application

- CNC machining centers
- for cutting of lock-cases and face-plates in doors

Design

- positive spiral
- high-tensile body (heavy metal)
- with HW-tipped (soldered) plunge tip
- knives with chip breaker form A and 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	o
16	16	105	20	55	170	2	183751	o
18	16	105	20	55	170	2	183752	o
[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
	16	7.0	1.5	B	150525	10	183754
	[mm]	[mm]	[mm]			[pc.]	

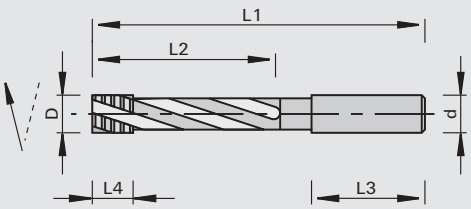
Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M3x4 T9	995195	10	180449
Screwdrivers	T9x60	985730	1	173796
	[mm]		[pc.]	

129460

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)

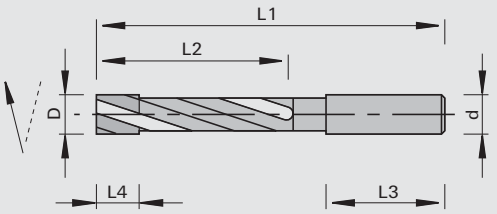
Ø D	L4	L2	Ø d	L3	L1	Z	nmax	Ident-No.
14	25	95	14	50	155	3	24000	185835
16	25	115	16	50	175	3	24000	185836
18	25	115	20	50	175	3	24000	185837
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

129460

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
16	25	115	16	50	175	2	24000	185834
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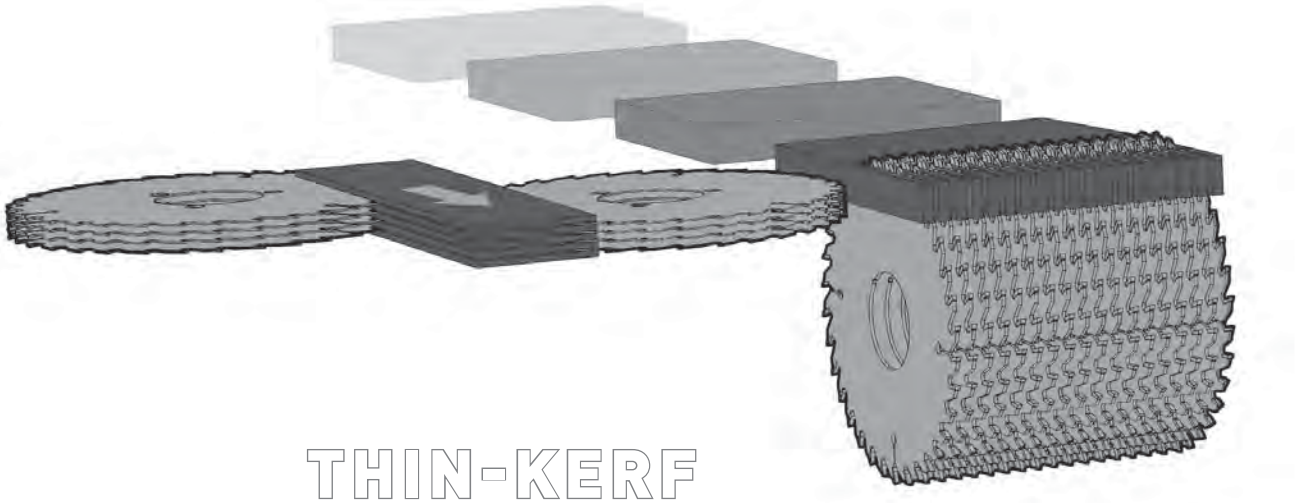
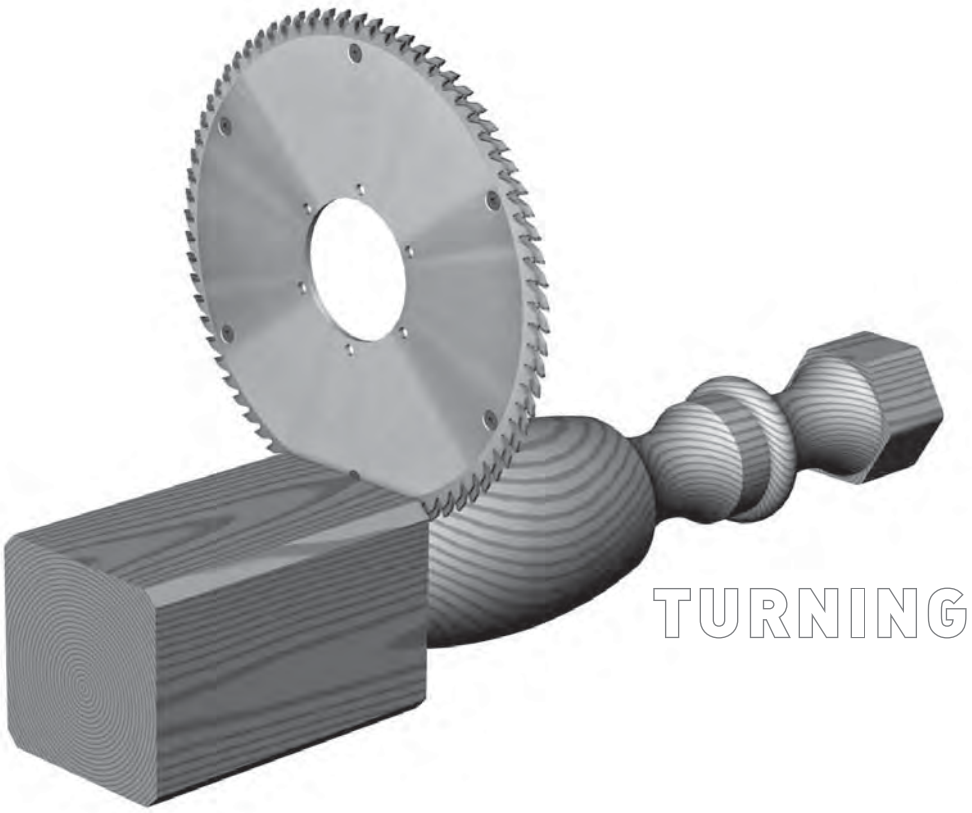


THIN-KERF PARQUET

Further Processing, Sawing in general

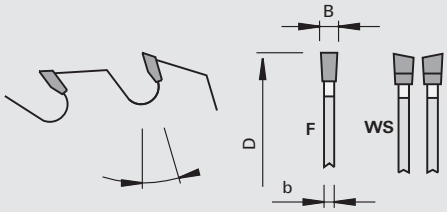


102317 / 102327

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	o
180	1,0	0.8	65	30	20	3/11/80	WS	Schröder	80254256	o
220	1,2	0.9	60	27	18	3/10/74	F	Weinig	80252288	o
220	1,2	0.9	65	27	18	3/11/80	F	Schröder	80252289	o
220	1,2	0.9	60	30	20	3/10/74	WS	Weinig	80252290	o
220	1,2	0.9	65	30	20	3/11/80	WS	Schröder	80252291	o
220	3,8/3,5	3.0	60	30	18	3/10/74 + 3/11/80	F	Weinig, Schröder	80252292	o
[mm]	[mm]	[mm]	[mm]		[°]					

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

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

Spare parts	Ø D	B	Ø d	Class-No.	PU	Ident-No.	
Spacers	94	28	60	955520	1	182198	s
Spacers	94	30	65	955520	1	182199	s
Cover flange top with handhold	130	16	60	997300	1	182194	s
Cover flange top with handhold	130	16	65	997300	1	182196	s
Cover flange bottom	130	14	60	997300	1	182195	s
Cover flange bottom	130	14	65	997300	1	182197	s
Spacers	130	4,2	60	955520	1	182200	s
Spacers	130	4,3	60	955520	1	182201	s
Spacers	130	4,4	60	955520	1	182202	s
Spacers	130	4,5	60	955520	1	182203	s
Spacers	130	4,6	60	955520	1	182204	s
Spacers	130	4,7	60	955520	1	182205	s
Spacers	130	4,8	60	955520	1	182206	s
Spacers	130	4,9	60	955520	1	182207	s
	[mm]	[mm]	[mm]				

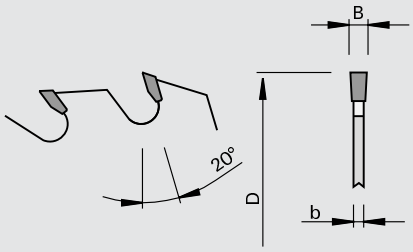
Spare parts	Ø D	B	Ø d	Class-No.	PU	Ident-No.
Spacers	130	5,0	60	955520	1	182208 s
Spacers	130	4,5	65	955520	1	182209 s
Spacers	130	4,6	65	955520	1	182210 s
Spacers	130	4,7	65	955520	1	182211 s
Spacers	130	4,8	65	955520	1	182212 s
Spacers	130	4,9	65	955520	1	182213 s
Spacers	130	5,0	65	955520	1	182214 s
	[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)

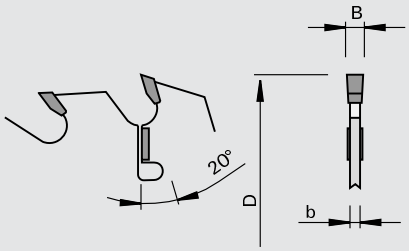
Ø D	B	b	Ø d	Z	DKN	NL	Class-No.	Ident-No.
200	2,0	1.4	40	20			101311	188029
200	2,4	1.6	40	20			101311	188148
225	2,4	1.6	40	20			101311	188150
250	2,4	1.6	40	24			101311	188151
250	3,2	2.2	70	20	20x5		101310	189300
250	2,8	1.8	70	24	20x5		101311	188030
300	3,2	2.2	70	24	20x5		101310	189301
300	3,2	2.2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

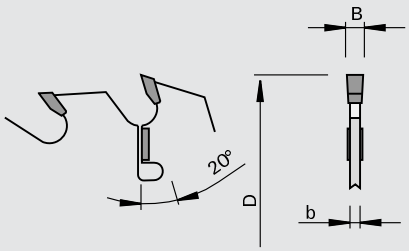
Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of rakers	Ident-No.
300	3,0	2.0	50	90	130	20	2+2	189270
350	3,5	2.4	50	100	140	20	2+2	189271
400	4,2	3.0	50	100	150	24	2+2	189272
450	4,2	3.0	50	100	160	24	2+2	189273
500	4,6	3.3	50	100	180	28	2+2+2	189274
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

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
200	2,0	1.4	40	75	115	16	2			188097
200	2,4	1.6	40	75	115	16	2			188098
225	2,4	1.6	40	80	120	16	2			188100
250	2,4	1.6	40	80	125	16	2			188101
250	2,8	1.8	70		125	24	2	20x5		189290
300	3,2	2.2	70		120	16	2+2	20,0x5		189293
300	3,4	2.2	80		120	16	2+2	12,5x4,5		189296
300	3,2	2.2	70		120	28	2+2	20,0x5		189294
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	[mm]		

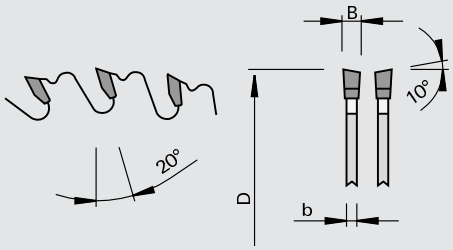
Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of rakers	DKN	NL	Ident-No.
300	3,2	2.2	80		125	16	2+2	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100	189295
350	3,5	2.5	70		120	20	2+2	20x5		189297
350	3,8	2.5	80		125	20	2+2	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100	189299
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	[mm]		

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)

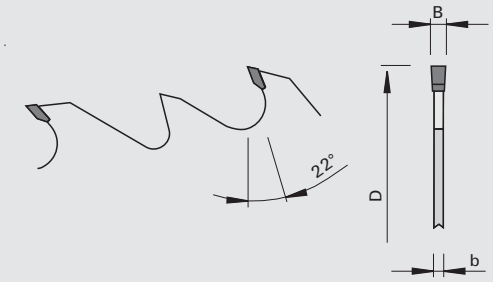
Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of rakers	NL	Ident-No.
350	3,5	2.5	30	70	140	24	2+2	2/7/42 + 2/9,5/46,5 + 2/10/60	189643
400	3,5	2.5	30	80	160	28	2+2	2/7/42 + 2/9,5/46,5 + 2/10/60	189644
450	4,2	2.8	30	80	160	36	2+2	2/7/42 + 2/9,5/46,5 + 2/10/60	189645
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]		

101715

Gang-Rip Saw Blades HW with HW-rakers - solid “F” for low feed rates

Product

Drawing



LEUCO solid

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- gang rip machine with low feed rates
- for longitudinal cuts in wet solid woods

Design

- tooth configuration: flat “F”
- cutting material: HW HL Board 10
- with internal and external HW-rakers

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

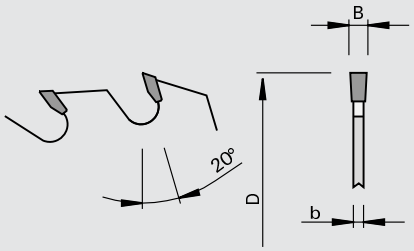
Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of rakers	Ident-No.
400	4,4	3.2	50	100	150	18	2+2	192638
450	4,8	3.2	50	100	160	18	2+2	192639
500	5,0	3.5	50	100	180	18	2+2	192640
550	5,2	3.5	50	140	180	18	4+2	192641
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

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)

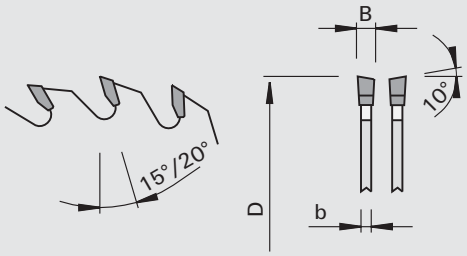
Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of cooling slots	DKN	NL	Ident-No.
250	3,4	2.2	30	80	120	24	3			189275
300	3,4	2.2	80	100	140	28	4	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100	189276
300	3,4	2.2	30	100	130	28	4			189277
350	3,6	2.4	30	100	140	32	4			189279
350	3,6	2.4	80	100	140	32	4	18,5x5	6/5,5/91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

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

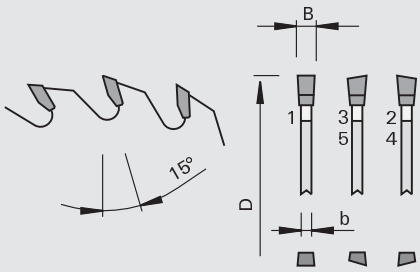
Ø D	B	b	Ø d	Z	Hook angle	NL	Class-No.	Ident-No.
200	3,2	2.2	30	24	20	2/7/42	107520	189932
250	3,2	2.2	30	24	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189933
250	4,4	2.8	30	20	15	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189934 s
300	3,2	2.2	30	24	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189935
300	3,2	2.2	30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

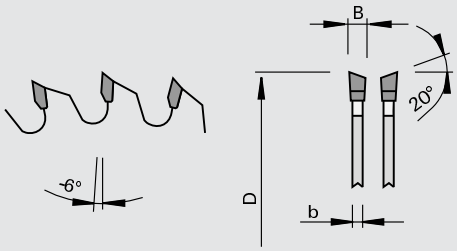
Ø D	B	b	Ø d	Z	NL**		nmax	Ident-No.
200	3,0	2.2	30	65			7630	192789
220	3,0	2.2	30	70			6940	192790
240	3,0	2.2	30	75			6360	192791
250	3,0	2.2	30	80	Combi3		6110	192792
280	3,0	2.2	30	85	Combi3		5450	192793
300	3,0	2.2	30	100	Combi3		5090	192794
303	3,2	2.2	30	100	Combi3	Striebig	5040	192795
315	3,0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

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

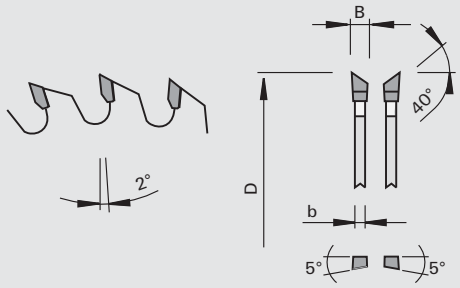
Ø D	B	b	Ø d	Z	Ident-No.
450	4,4	3.2	30	54	188045
500	4,4	3.2	30	60	188046
[mm]	[mm]	[mm]	[mm]		

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

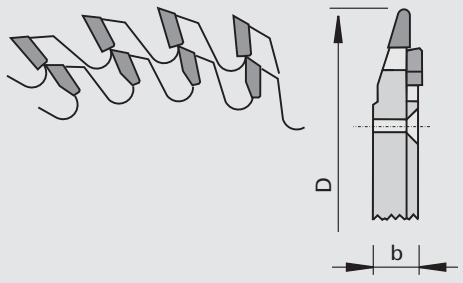
Ø D	B	b	Ø d	Z	NL		Ident-No.
400	3,4	2.8	30	120	2/10/60	DIMTER QUANTUM	189896
400	4,6	3.5	30	120	2/10/60	DIMTER	189833
450	4,6	3.5	30	132	2/15/63	DIMTER	189834
500	4,6	3.5	30	144	2/15/63	DIMTER	189835
520	4,6	3.5	30	144	2/15/63		189836
550	4,6	3.5	120	156	6/10,2/240	Paul	189837
600	5,2	3.8	30	172	2/15/63	DIMTER	189838
630	5,4	4.0	30	180	2/15/63		189839
[mm]	[mm]	[mm]	[mm]				

106352

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

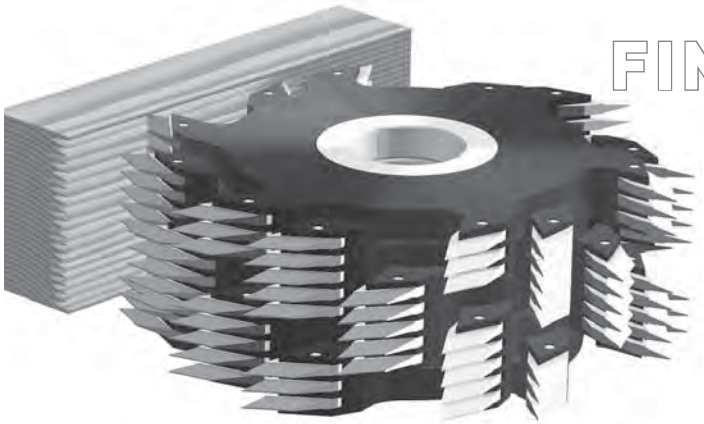
Design

- 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 s
[mm]	[mm]	[mm]			



FINGER JOINT CUTTERS

LEUCO FINGER JOINT CUTTER PROGRAM

Simple tool choice: By means of this overview you will quickly find the suitable cutter!

Application / Design		Finger joint cutters									Finger joint cutters disc-type						Cutterhead			
		Finger joint cutters HS			Finger joint cutters HS Solid 34			Finger joint cutters HW			Finger joint cutters disc-type HW soft wood		Finger joint cutters, disc-type HW hard wood		Finger joint cutters, disc-type for tropical wood		Finger joint cutterhead			
Glue-ing	normal	++			++			++			++		++		++		++			
	fiber-free	++			o			o			o		o		o		o			
Wood types	Coniferous wood	++			++			o			++		++		o		++			
	Deciduous wood	+			++			++			–		++		++		o			
	Tropical wood	o			+			+			–		+		++		o			
Dimensions on machine	Finger jointing line (with hogger)	10/11	15/16,5	20/22	10/11	15/16,5	20/22	10/11	15/16,5	–	10/11		10/11	15/16,5	–	10/11	15/16,5	–	–			
	Compact line (without hogger)	10/10	15/15	20/20	10/10	15/15	20/20	10/10	15/15	–	–		–	–	–	–			10/10	10/11	15/15	15/16,5
Coating options	Non-stick coating	–			–			–			**topcoat**		**topcoat**		–		–			
	Edge life coating	**topcoat**			**topcoat**			**topcoat**			**topcoat/ topcoat plus**		**(*)**		**(*)**		**topcoat**			
Comparison of edge lives	uncoated	100%			up to 300% – 400%			up to 400% (increased risk of breaking)			100%		100%		100%		100%			
	topcoat	up to 200% – 300%			> 500 % (*)			(*)			up to 200%		up to 200%		–		up to 200% – 300%			
	topcoat plus	–			–			–			> 400%		(*)		(*)		–			

*on request ++ very well suited + well suited o possible – not possible / not suitable

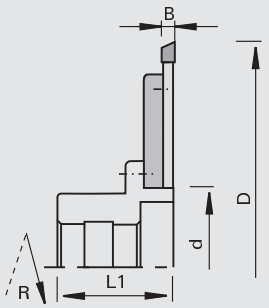
Finger Jointing Technology

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 DIN-EN 50144

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 &	182378 &
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]			

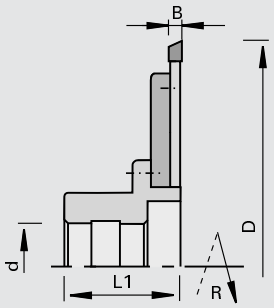
Spare parts	Dimension	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
Hogging Saw Blades	Ø250x6,3/5xØ75 Z80	102350	1	189033	189032
Hogging Saw Blades	Ø250x8,0/6,1xØ80 Z60	102350	1	189223	189222
Flanges	Ø210x8,4xØ80	997370	1		182377
Countersunk Screws	M8x20 DIN 7991-8.8	995121	10		056378
Countersunk Screws	M5x12 T20	995125	10		166709
Screwdrivers	T20x100	985730	1		166092
Bushings for Grecon	Ø113x59x40DKN	997300	1		189100
Bushings for NKT	Ø206x100,3x38 DKN	997370	1		178294
	[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 DIN-EN 50144

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 &	182600 &
350	10	44	59	40	60+12	12x3,3	Grecon	182611 &	182612 &
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]			

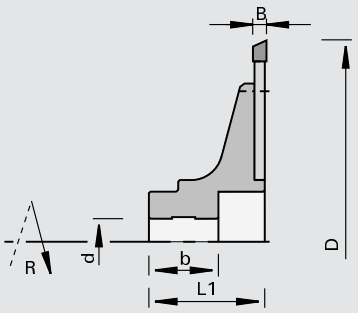
Spare parts	Dimension	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
Hogging Saw Blades	Ø250x6,3/5xØ75 Z80	102350	1	189033	189032
Hogging Saw Blades	Ø250x8,0/6,1xØ80 Z60	102350	1	189223	189222
Hogging Saw Blades	Ø350x10,0xØ80 Z60+12	102350	1	189246 s	189247 #
Flanges	Ø210x8,4xØ80	997370	1		182377
Countersunk Screws	M8x20 DIN 7991-8.8	995121	10		056378
Countersunk Screws	M5x12 T20	995125	10		166709
Screwdrivers	T20x100	985730	1		166092
Bushings for Grecon	Ø113x59x40DKN	997300	1		189100
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 DIN-EN 50144

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 &	182602 &
300	8,0	84	102	38	60	10x4	NKT	182607 &	182608 &
350	10	84	102	38	60+12	10x4	NKT	182613 &	182614 &
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]			

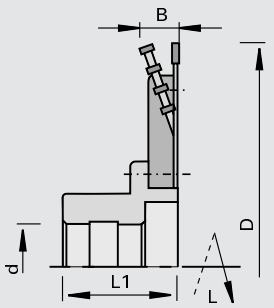
Spare parts	Dimension	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
Hogging Saw Blades	Ø250x8,0/6,1xØ80 Z60	102350	1	189223	189222
Hogging Saw Blades	Ø300x8,0/6,1xØ80 Z60	102350	1	189244	189245
Hogging Saw Blades	Ø350x10,0xØ80 Z60+12	102350	1	189246 s	189247 #
Countersunk Screws	M5x12 T20	995125	10		166709
Screwdrivers	T20x100	985730	1		166092
Bushings for NKT	Ø206x100,3x38 DKN	997370	1		178294
	[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 &	189096 &
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]			

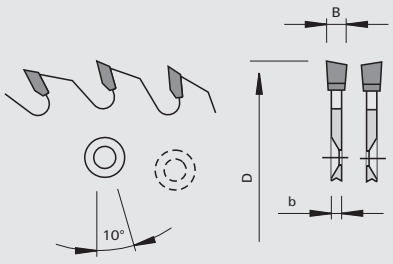
Spare parts	Dimension	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
Hogger Saw Blade	Ø250x4,0/2,8xØ120 Z48	102312	1	189092	189093
HW segments	Ø250 Z=4	116200	1	189094	189094
Bushings for Grecon	Ø113x59x40DKN	997300	1		189100
Countersunk Screws	M6x10 DIN EN ISO 10642	995121	10		182598
Countersunk Screws	M5x10-8.8 DIN EN ISO 2009	995122	10		055881
Head Cap Screws	M8x16 DIN912	995111	10		001891
Screwdrivers	SW4x100	985730	1		166091
Screwdrivers	8,0	985730	1		053874
	[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

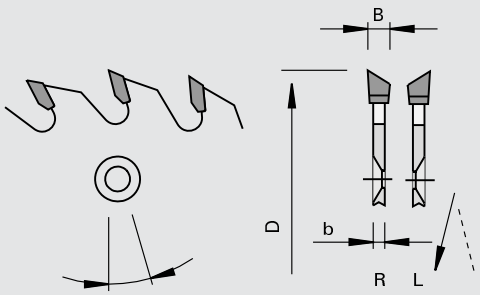
Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁		Ident-No.
200	7,0	4.0	75	48	2x6/6,5/95	10	10	Grecon	189539
[mm]	[mm]	[mm]	[mm]			[°]	[°]		

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

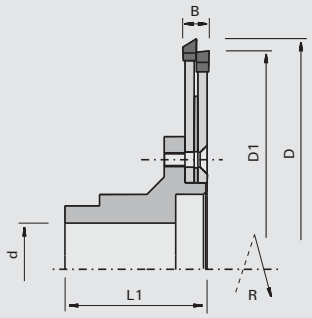
Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁		Ident-No. [L]	Ident-No. [R]
200	5,1	3.5	75	48	6/7/95	10	25	Grecon-Compipact	188947	188948
200	4,7	3.4	75	64	6/6,6/95	10	30	Grecon HS 120	189034	189035
200	6,0	4.0	75	48	6/6,5/95	10	5	Grecon	189540	
[mm]	[mm]	[mm]	[mm]			[°]	[°]			

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 DIN-EN 50144

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 &
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

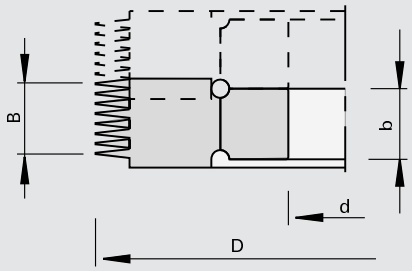
Spare parts	Dimension	Class-No.	PU	Ident-No.
Scoring Saw Blades	Ø200x6,0/4,0xØ75 Z48	105350	1	189537
Scoring Saw Blades	Ø190x6,0/4,0xØ75 Z48	105350	1	189538
Bushings for Grecon	Ø115x61xØ40DKN	997300	1	189543
Spacers	Ø150x1,5xØ75	955520	1	189542
Countersunk Screws	M6x20 DIN 7991-8.8	995121	10	183114
Screwdrivers	SW4x100	985730	1	166091
	[mm]		[pc.]	

327110 / 327140 / 327130

Finger Joint Cutters HS

Product

Drawing



High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines with and without cross-cutting device
- for longitudinal joints in soft woods

Design

- standard, for PUR glueing and topcoat

Advantages

- strong flank surface pressure for PUR glues (fiber-free)
- increased edge lives and higher wear resistance and gliding features thanks to topcoat coating

Notes

- for machines with cross-cutting device, finger length 4/4,5, 10/11, 15/16,5, 20/22
- for machines without cross-cutting device, finger length 10/10, 15/15, 20/20

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		175740 s
160	28,6	26.6	50	2+2	3.8	10/11	7	8000		175741
160	32,4	30.4	50	2+2	3.8	10/11	8	8000		178966
160	28,6	26.6	50	3+3	3.8	10/11	7	8000		181008 s
160	32,4	30.4	50	3+3	1.6	4/4,5	20	9000		182122 s
170	28,6	26.6	50	2+2	3.8	15/15	7	8000		175742
170	28,6	26.6	50	2+2	3.8	15/16,5	7	8000		175743
170	28,6	26.6	50	3+3	3.8	15/16,5	7	8000		182668 s
180	33	31	50	2+2	6.2	20/20	5	8000		175744
180	33	31	50	2+2	6.2	20/22	5	8000		175745 s
250	26	24	50	3+3	1.6	4/4,5	16	6000		182113 s
250	28,6	26.6	50	3+3	3.8	10/10	7	6000		175746 s
250	28,6	26.6	50	3+3	3.8	10/11	7	6000		175747
250	30	28	50	6+6	2.8	6/7	10	6000		192467 s
255	30	28	50	6+6	2.8	6/7	10	6000		192468 s
260	28,6	26.6	50	3+3	3.8	15/15	7	6000		175748 s
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000		175749
260	33	31	50	3+3	6.2	20/22	5	6000		175751
[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	2+2	3.8	15/15	7	8000	for PUR glueing	189715 s
180	33	31	50	2+2	6.2	20/20	5	8000	for PUR glueing	192262 s
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	for PUR glueing	189716 s
260	33	31	50	3+3	6.2	20/20	5	6000	for PUR glueing	192263 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	28,6	26.6	50	2+2	3.8	10/10	7	8000	topcoat	192190 s
160	28,6	26.6	50	2+2	3.8	10/11	7	8000	topcoat	192127 s
160	32,4	30.4	50	2+2	3.8	10/11	8	8000	topcoat	192199 s
160	28,6	26.6	50	3+3	3.8	10/11	7	8000	topcoat	192200 s
160	32,4	30.4	50	3+3	1.6	4/4,5	20	9000	topcoat	192202 s
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	topcoat	192191 s
170	28,6	26.6	50	2+2	3.8	15/16,5	7	8000	topcoat	192192
170	28,6	26.6	50	3+3	3.8	15/16,5	7	8000	topcoat	192203 s
180	33	31	50	2+2	6.2	20/20	5	8000	topcoat	192193 s
180	33	31	50	2+2	6.2	20/22	5	8000	topcoat	192194 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

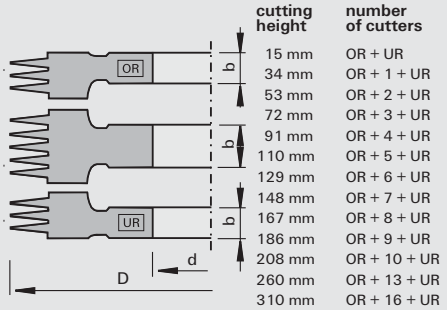
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
250	26	24	50	3+3	1.6	4/4,5	16	6000	topcoat	192201 s
250	28,6	26.6	50	3+3	3.8	10/10	7	6000	topcoat	192195 s
250	28,6	26.6	50	3+3	3.8	10/11	7	6000	topcoat	192126 s
250	30	28	50	6+6	2.8	6/7	10	6000	topcoat	192466 s
255	30	28	50	6+6	2.8	6/7	10	6000	topcoat	192469 s
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	topcoat	192196 s
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000	topcoat	192197 s
260	33	31	50	3+3	6.2	20/22	5	6000	topcoat	192198 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

327610 / 327640 / 327630

Finger Joint Cutters HS - real Z=4 resp. 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

- high-performance finger joint machines
- for longitudinal joints in soft woods

Design

- real Z=4 or Z=6 for high feed rates
- standard, for PUR glueing and topcoat

Advantages

- constant finger quality even with high feed rates thanks to double number of teeth compared to standard design
- longer edge life, higher wear resistance and gliding features thanks to topcoat coating

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	182675 s
170	41	19	50	4	3.8	15/15	5	8000	base cutter	182676 #
170	26,4	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter	182677 s
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	top finish cutter	182678 #
170	41	19	50	4	3.8	15/16,5	5	8000	base cutter	182679 #
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	bottom finish cutter	182680 #
250	26,4	15.4	50	6	3.8	10/11	3	6000	top finish cutter	189930
250	41	19	50	6	3.8	10/11	5	6000	base cutter	182682
250	26,4	15.4	50	6	3.8	10/11	3	6000	bottom finish cutter	189931
[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	26,4	14.8	50	4	3.8	15/15	3	8000	top finish cutter for PUR glueing	192264 s
170	41	19	50	4	3.8	15/15	5	8000	base cutter for PUR glueing	192265 s
170	26,4	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter for PUR glueing	192266 s
180	27,2	17.2	50	3	6.2	20/20	2	8000	top finish cutter for PUR glueing	192267 s
180	39,6	19.1	50	3	6.2	20/20	3	8000	base cutter for PUR glueing	192268 s
180	27,2	17.2	50	3	6.2	20/20	2	8000	bottom finish cutter for PUR glueing	192269 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.
170	26,4	14.8	50	4	3.8	15/15	3	8000	top finish cutter/topcoat	192204 s
170	41	19	50	4	3.8	15/15	5	8000	base cutter/topcoat	192205 s
170	26,4	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter/topcoat	192206 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

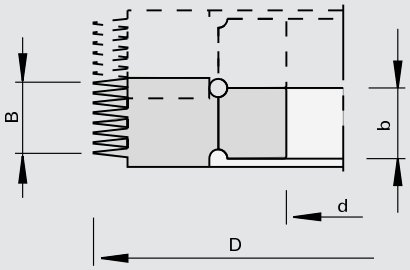
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	top finish cutter/topcoat	192207 s
170	41	19	50	4	3.8	15/16,5	5	8000	base cutter/topcoat	192208 s
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	bottom finish cutter/topcoat	192209 s
250	26,4	15.4	50	6	3.8	10/11	3	6000	top finish cutter/topcoat	192210 s
250	41	19	50	6	3.8	10/11	5	6000	base cutter/topcoat	192211 s
250	26,4	15.4	50	6	3.8	10/11	3	6000	bottom finish cutter/topcoat	192212 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

527110

Finger Joint Cutters HS - Solid 34

Product

Drawing



High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines with and without cross-cutting device
- for longitudinal joints in knotty soft woods

Design

- cutting edge: HS Solid 34

Advantages

- compared to traditional HS finger joint cutters the edge life is 2 - 3 times as long
- high bending strength
- reduced risk of tooth breaking

Notes

- for machines with cross-cutting device, finger length 10/11, 15/16,5, 20/22
- for machines without cross-cutting device, finger length 10/10, 15/15, 20/20

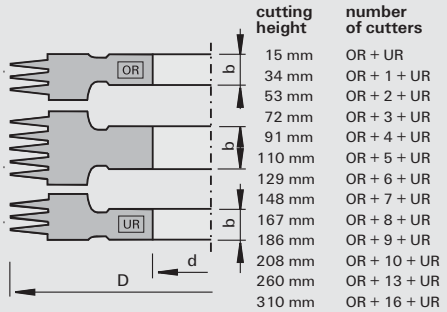
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax	Ident-No.
160	28,6	26.6	50	2+2	3.8	10/10	7	8000	183231 s
160	28,6	26.6	50	2+2	3.8	10/11	7	8000	183232 s
160	32,4	30.4	50	2+2	3.8	10/11	8	8000	183233 s
160	28,6	26.6	50	3+3	3.8	10/11	7	8000	183234 s
170	28,6	26.6	50	2+2	3.8	15/16,5	7	8000	183235 s
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	183230
170	28,6	26.6	50	3+3	3.8	15/16,5	7	8000	183236 s
180	33	31	50	2+2	6.2	20/20	5	8000	183237 s
180	33	31	50	2+2	6.2	20/22	5	8000	183238 s
250	28,6	31	50	3+3	3.8	10/10	7	6000	183239 s
250	28,6	26.6	50	3+3	3.8	10/11	7	6000	183228
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	183240 s
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000	183229 #
260	33	31	50	3+3	6.2	20/22	5	6000	183241 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]	

527610

Finger Joint Cutters HS - Solid 34 - real Z=4 or 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

- high-performance finger joint machines
- for longitudinal joints in soft woods

Design

- cutting edge: HS Solid 34
- real Z=4 or Z=6 for high feed rates

Advantages

- compared to traditional HS finger joint cutters the edge life is 2 - 3 times as long
- high bending strength
- reduced risk of tooth breaking
- constant finger quality even with high feed rates thanks to double number of teeth compared to standard design

Notes

- no. of cutters: see table

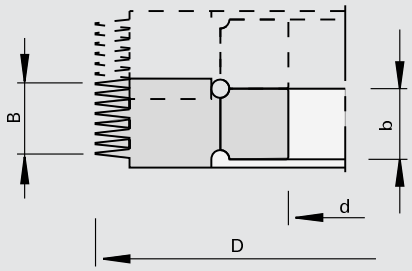
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	26,4	14.8	50	4	3.8	15/15	3	8000	top finish cutter	183242 s
170	41	19	50	4	3.8	15/15	5	8000	base cutter	183243 s
170	26,4	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter	183244 s
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	top finish cutter	183247 s
170	41	19	50	4	3.8	15/16,5	5	8000	base cutter	183245 s
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	bottom finish cutter	183246 s
250	26,4	14.8	50	6	3.8	10/11	3	6000	top finish cutter	192270
250	41	19	50	6	3.8	10/11	5	6000	base cutter	183249
250	26,4	14.8	50	6	3.8	10/11	3	6000	bottom finish cutter	192271
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

127110

Finger Joint Cutters HW

Product

Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- finger joint machines
- machines with cross-cutting device
- for longitudinal joints in hard and exotic woods

Design

Advantages

Notes

- for machines with cross-cutting device, finger length 10/11, 15/16,5
- for machines without cross-cutting device, finger length 10/10, 15/15

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	175732	s
160	28,6	26.6	50	2+2	3.8	10/11	7	8000	175733	
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	175734	s
170	28,6	26.6	50	2+2	3.8	15/16,5	7	8000	175735	s
250	28,6	26.6	50	3+3	3.8	10/10	7	6000	175736	s
250	28,6	26.6	50	3+3	3.8	10/11	7	6000	175737	
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	175738	s
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000	175739	s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

396961

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 s
HS insert topcoat 15/15	332924	4	192186 s
HS insert topcoat 15/16.5	332924	4	192187
		[pc.]	

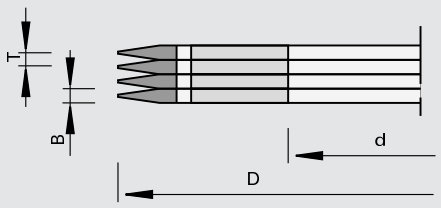
Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M8x20 DIN EN ISO 4028	995161	10	001625
	[mm]		[pc.]	

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

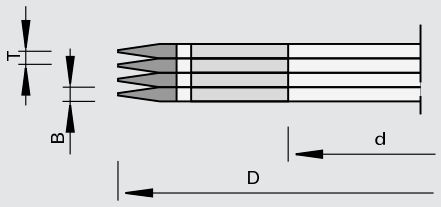
Ø D	B	Ø d	Z	Partition	Finger joint length		Ident-No.
160	3,8	70	2	3.8	10/11	Soft wood	177561 s
160	3,8	70	2	3.8	10/11	hard woods/exotic woods	177562 s
160	3,8	70	4	3.8	10/11	Soft wood	177563
160	3,8	70	4	3.8	10/11	hard woods/exotic woods	177564
250	3,8	70	6	3.8	10/11	hard woods/exotic woods	180938
250	3,8	70	6	3.8	10/11	Soft wood	180939
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

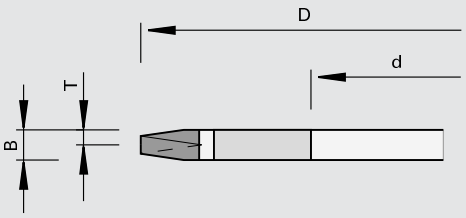
Ø D	B	Ø d	Z	Partition	Finger joint length	Ident-No.
160	3,8	70	4	3.8	10/11	181230 s
250	3,8	70	6	3.8	10/11	181233 #
[mm]	[mm]	[mm]		[mm]	[mm]	

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

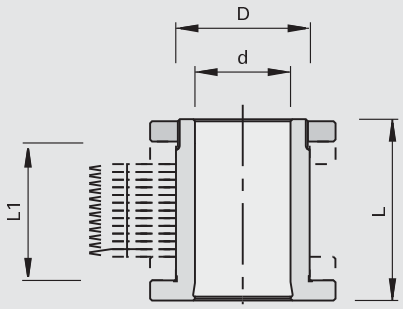
Ø D	B	Ø d	Z	Partition	Finger joint length	Ident-No.
149	3,8	70	4	3.8	5	180916 s
160	11,4	70	4	3.8	10	177574
239	3,8	70	6	3.8	10	180917 s
239	11,4	70	6	3.8	10	181245
250	11,4	70	6	3.8	10	177576
[mm]	[mm]	[mm]		[mm]	[mm]	

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
70	50	120	87	181035
70	50	130	97	178171
70	50	195	162	178172
70	50	220	187	178173
70	50	240	207	178174
[mm]	[mm]	[mm]	[mm]	

Spacer Rings	Ø D	B	Ø d	Class-No.	PU	Ident-No.	
	100	7,6	70	955520	1	180940	
	100	11,4	70	955520	1	180941	
	175	7,6	70	955520	1	186163	s
	175	11,4	70	955520	1	181034	
	[mm]	[mm]	[mm]				

Spare parts	Dimension	Class-No.	PU	Ident-No.	
Mounting Devices		997300	1	177103	
Mounting Rings	96x70x60	955520	1	177546	
Pin-type face wrenches		985720	1	177102	
Fastening Nut	M68x1,5x14	995290	1	177104	
Hydraulic Clumping Nuts	M68x1,5x56	933090	1	178787	s
Screwdrivers	SW4x100	985730	1	166091	
	[mm]		[pc.]		

Finger Joint Cutters - Calculation of cutting width

Combination of the cutter sets depending on the wood thickness

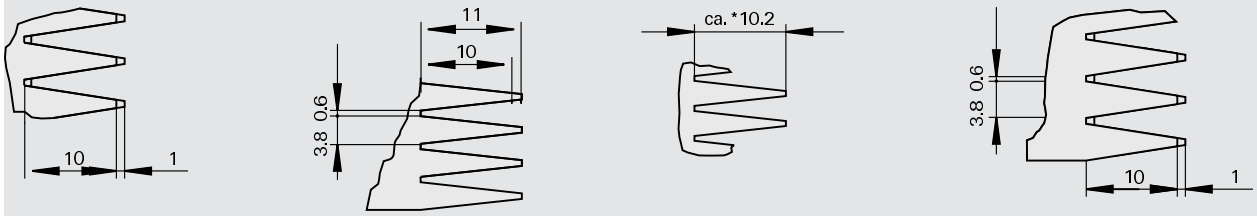
Finger length [mm]	Wood thickness [mm]	Number of cutters
10+15	24	1
10+15	51	2
10+15	77	3
10+15	104	4
10+15	131	5
10+15	157	6
10+15	184	7
10+15	210	8
10+15	237	9
10+15	264	10

Finger length [mm]	Wood thickness [mm]	Number of cutters
20	28	1
20	59	2
20	90	3
20	121	4
20	152	5
20	183	6
20	214	7
20	245	8
20	276	9
20	307	10

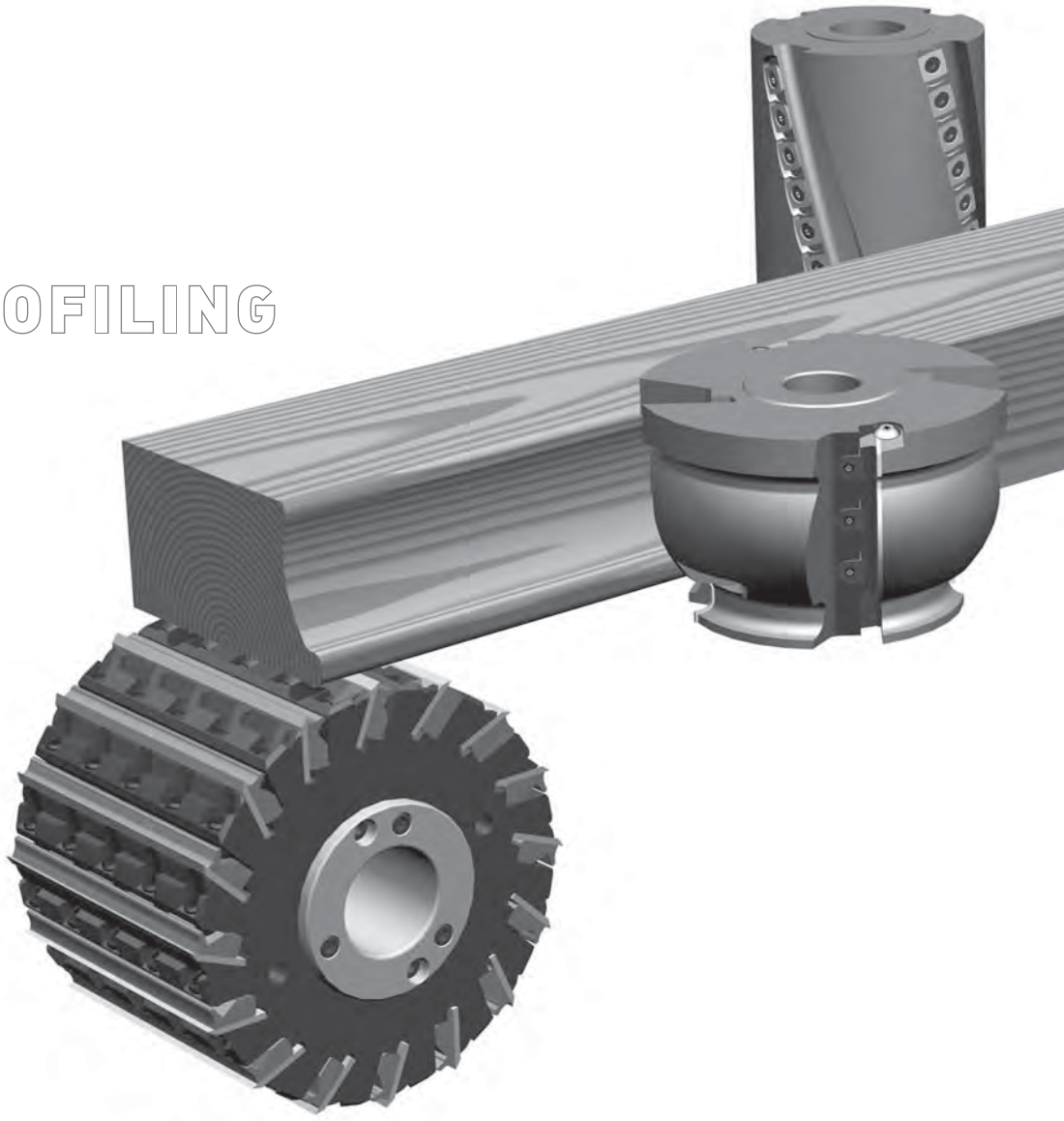
Finger joint cutters - cross cutting with extended finger joint profile

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

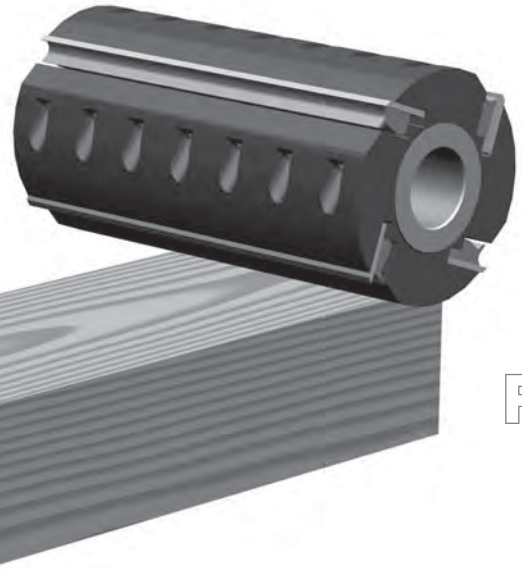
Drawing profile example



PROFILING



Planing/Profiling



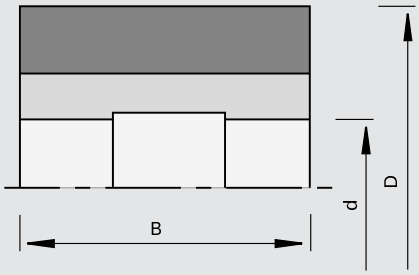
PLANING

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
125	100	40	4	181195
125	130	40	4	179194
125	150	40	4	179195
125	180	40	4	179196
125	230	40	4	181190
[mm]	[mm]	[mm]		

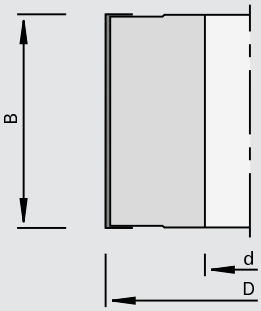
Spare parts	Dimension	Class-No.	PU	Ident-No.	
Pressure Bars	B=80	925300	2	179205	o
Pressure Bars	B=100	925300	2	181191	o
Pressure Bars	B=130	925300	2	179198	o
Pressure Bars	B=150	925300	2	179199	o
Pressure Bars	B=180	925300	2	179200	o
Pressure Bars	B=230	925300	2	181192	o
Adjustment Rings	125x40	985200	1	179201	o
Set Screws	M10x25 DIN EN ISO 4028	995161	10	168108	
Cranked Wrench Keys	SW5 DIN ISO 2936	985730	1	009674	
	[mm]		[pc.]		

320700

Planing Cutterheads HS with centrifugal clamping

Product

Drawing



High Speed Steel [HS]

MEC

Machine / Application

- molders
- four-side molders
- for planing of solid woods

Design

- aluminum body
- n max = 9,000 min-1
- spring-loaded balls (b) hold the knife before clamping

Advantages

- quick tool change with centrifugal clamping, without clamping screws and without time-consuming adjustment procedure
- tempered precision chip breaker (a) for precise positioning of the knives
- very cost effective thanks to resharpenability
- closed design for low noise level

Notes

- HS-TRI -tipped knives
- alternative cutting material: HW

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

Turnover Knives	B	Cutting material	Class-No.	PU	Ident-No.
	60	HS-TRI	332121	2	70469707 o
	80	HS-TRI	332121	2	70469708 o
	100	HS-TRI	332121	2	70469710 o
	120	HS-TRI	332121	2	70469712 o
	130	HS-TRI	332121	2	70469713 o
	136	HS-TRI	332121	2	70469736 o
	140	HS-TRI	332121	2	70469714 o
	150	HS-TRI	332121	2	70469715 o
	160	HS-TRI	332121	2	70469716 o
	180	HS-TRI	332121	2	70469718 o
	186	HS-TRI	332121	2	70469786 o
	190	HS-TRI	332121	2	70469719 o
	200	HS-TRI	332121	2	70469720 o
	[mm]			[pc.]	

Turnover Knives	B	Cutting material	Class-No.	PU	Ident-No.	
	210	HS-TRI	332121	2	70469721	o
	220	HS-TRI	332121	2	70469722	o
	230	HS-TRI	332121	2	70469723	o
	240	HS-TRI	332121	2	70469724	o
	260	HS-TRI	332121	2	70469726	o
	300	HS-TRI	332121	2	70469730	o
	310	HS-TRI	332121	2	70469731	o
	400	HS-TRI	332121	2	70469740	o
	410	HS-TRI	332121	2	70469741	o
	430	HS-TRI	332121	2	70469743	o
	500	HS-TRI	332121	2	70469750	o
	510	HS-TRI	332121	2	70469751	o
	610	HS-TRI	332121	2	70469761	o
	630	HS-TRI	332121	2	70469763	o
	640	HS-TRI	332121	2	70469764	o
	710	HS-TRI	332121	2	70469771	o
	1350	HS-TRI	332121	2	70469798	o
	[mm]			[pc.]		

Turnover Knives	B	Cutting material	Class-No.	PU	Ident-No.	
	80	HW	132121	2	70469908	o
	100	HW	132121	2	70469910	o
	120	HW	132121	2	70469912	o
	130	HW	132121	2	70469953	o
	140	HW	132121	2	70469914	o
	150	HW	132121	2	70469915	o
	160	HW	132121	2	70469916	o
	180	HW	132121	2	70469918	o
	200	HW	132121	2	70469920	o
	210	HW	132121	2	70469921	o
	220	HW	132121	2	70469922	o
	230	HW	132121	2	70469923	o
	240	HW	132121	2	70469924	o
	250	HW	132121	2	70469925	o
	260	HW	132121	2	70469926	o
	300	HW	132121	2	70469930	o
	610	HW	132121	2	70469999	o
	[mm]			[pc.]		

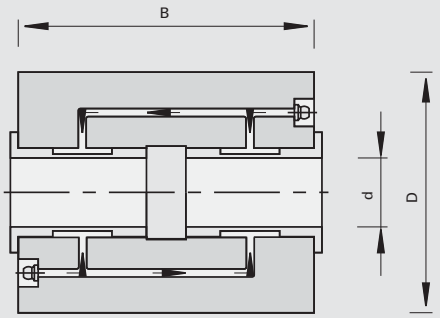
Spare parts	Class-No.	PU	Ident-No.	
Knife Changers	985720	1	70469100	o
		[pc.]		

320200

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 o
143	130	40	4	27	178105 o
143	230	40	4	27	178106 o
163	60	50	4	27	178107 o
163	100	50	4	27	178108 o
163	130	50	4	27	178109 o
163	150	50	4	27	178110 o
163	180	50	4	27	178112 o
163	230	50	4	27	178113 o
163	260	50	4	27	178115 o
163	310	50	4	27	178116 o
163	60	50	6	27	178117 o
163	100	50	6	27	178118 o
163	130	50	6	27	178119 o
163	150	50	6	27	178120 o
163	180	50	6	27	178122 o
163	230	50	6	27	178123 o
163	260	50	6	27	178125 o
163	310	50	6	27	178126 o
163	60	50	8	25	178127 o
163	100	50	8	25	178128 o
163	130	50	8	25	178129 o
163	150	50	8	25	178130 o
163	230	50	8	25	178131 o
163	260	50	8	25	178132 o
[mm]	[mm]	[mm]		[°]	

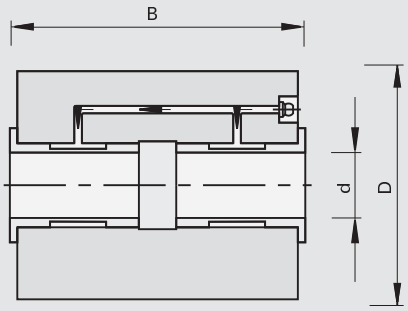
Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M12x25 DIN EN ISO 4028	995161	10	181466
Screwdrivers	SW6x200	985730	1	167817
Grease presses		993270	1	163706
Grease Cartridges		993270	1	163707
	[mm]		[pc.]	

320200

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 o
203	230	50	6	27	178134 o
203	150	50	8	27	178136 o
203	230	50	8	27	178137 o
203	310	50	8	27	178139 o
203	150	50	10	23	178141 o
203	230	50	10	23	178142 o
203	310	50	10	23	178144 o
203	100	50	12	23	178145 o
203	150	50	12	23	178146 o
203	230	50	12	23	178147 o
203	310	50	12	23	178149 o
203	100	50	16	20	178150 o
203	150	50	16	20	178151 o
[mm]	[mm]	[mm]		[°]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M12x25 DIN EN ISO 4028	995161	10	181466
Screwdrivers	SW6x200	985730	1	167817
Grease presses		993270	1	163706
Grease Cartridges		993270	1	163707
	[mm]		[pc.]	

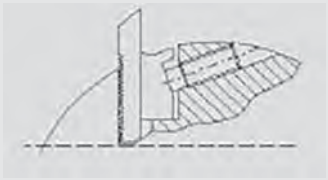
Spare parts	Class-No.	PU	Ident-No.
Hammer for Releasing the Knives	985740	1	181746 o
HSK-Mounting Device	985202	1	181747 o
		[pc.]	

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

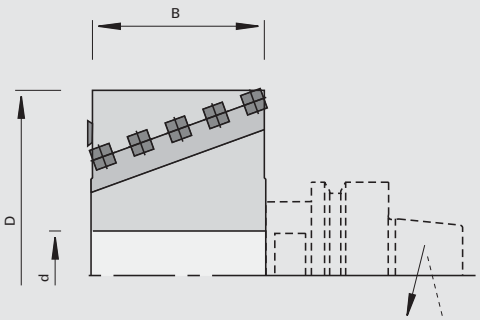
Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
90	40	Weinig-HSK	2	182312 o	182314 o
90	60	Weinig-HSK	2	181766 o	181775 o
90	80	Weinig-HSK	2	181767 o	181776 o
90	100	Weinig-HSK	2	181768 o	181777 o
90	130	Weinig-HSK	2	181769 o	181778 o
90	150	Weinig-HSK	2	181770 o	181779 o
90	170	Weinig-HSK	2	181771 o	181780 o
90	190	Weinig-HSK	2	182313 o	181781 o
90	210	Weinig-HSK	2	181773 o	181782 o
90	240	Weinig-HSK	2	181774 o	181783 o
90	80	Weinig-HSK	4	181785 o	181794 o
90	100	Weinig-HSK	4	181786 o	181795 o
90	130	Weinig-HSK	4	181787 o	181796 o
90	150	Weinig-HSK	4	181788 o	181797 o
90	170	Weinig-HSK	4	181789 o	181798 o
90	190	Weinig-HSK	4	181790 o	181799 o
90	210	Weinig-HSK	4	181791 o	181800 o
90	40	Weinig-HSK	4	182315 o	182316 o
90	60	Weinig-HSK	4	181784 o	182317 o
90	240	Weinig-HSK	4	181792 o	182318 o
[mm]	[mm]	[mm]			

120760

Spiral Cutterheads HW

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	nmax	Ident-No.	
80	80	30	2+2+V2	18000	183678	s
80	100	30	2+2+V2	18000	183679	s
[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	150517	10	180454
	[mm]	[mm]	[mm]		[pc.]	

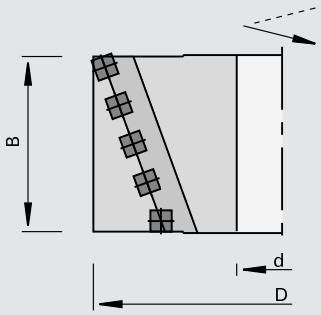
Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x15,5 T20	995125	10	182112
Screwdrivers	T20x100	985730	1	166092
	[mm]		[pc.]	

120710

Spiral Cutterheads HW - Finish

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 finished cut

Ø D	B	Ø d	Z	nmax	Ident-No.
125	100	40	2+2	12000	182091 o
125	130	40	2+2	12000	182092 o
125	150	40	3+3	12000	185960 o
125	170	40	2+2	12000	182093 o
125	230	40	2+2	12000	182094 o
125	240	40	2+2	12000	182095 o
[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	150517	10	180454
	[mm]	[mm]	[mm]		[pc.]	

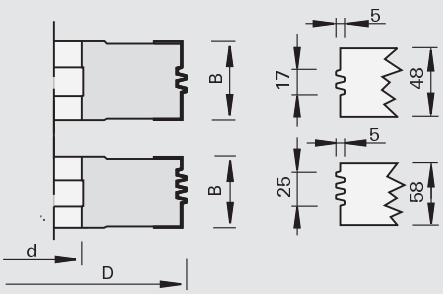
Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x15,5 T20	995125	10	182112
Screwdrivers	T20x100	985730	1	166092
	[mm]		[pc.]	

120505

Glue Joint Profile Cutterheads HW

Product

Drawing



LEUCO DUR

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
135	60	30	50	2	25-58	177008 s
[mm]	[mm]	[mm]	[mm]		[mm]	

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	50	23	2.0	151555	10	180431
	60	23	2.0	151555	10	180432
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	48x11x6	177007	925300	2	50591365
Pressure Bars	58x11x6	177008	925300	2	180434
Clamping Pieces	12x8,5/M8L	For all	925100	2	180357
Clamping Set Screws	M8x26 SW4	For all	995161	10	180340
Screwdrivers	SW4x100	For all	985730	1	166091
	[mm]			[pc.]	

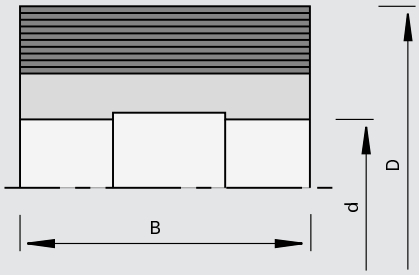
Spare parts	Dimension	Class-No.	PU	Ident-No.
Setting Discs	0,1 + 0,15	995490	1	180435
Setting Discs	0,15 + 0,2	995490	1	180436
Setting Discs	0,2 + 0,25	995490	1	180437
Setting Discs	0,25 + 0,3	995490	1	180438
Setting Discs	0,3 + 0,35	995490	1	180439
	[mm]		[pc.]	

320600

Profile Cutterheads

Product

Drawing



MEC

Machine / Application

- molders
- for profiling of solid woods

Design

- hook angle 25 degrees
- Ø 122 mm: n max = 9,000 min-1
- Ø 137 mm: n max = 8,000 min-1

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: cutter-head and wedges; for blanks see chapter Turnover knives, Profile Knives, Knives

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

Spare parts	Dimension	Class-No.	PU	Ident-No.	
Pressure Bars	B=40	925300	2	179221	o
Pressure Bars	B=60	925300	2	179222	o
Pressure Bars	B=80	925300	2	179223	o
Pressure Bars	B=100	925300	2	179224	o
Pressure Bars	B=130	925300	2	179225	o
Pressure Bars	B=150	925300	2	179226	o
Pressure Bars	B=180	925300	2	179227	o
Pressure Bars	B=230	925300	2	179228	o
Dummy Pieces	B=40	925900	2	179229	o
Dummy Pieces	B=60	925900	2	179230	o
Dummy Pieces	B=80	925900	2	179231	o
Dummy Pieces	B=100	925900	2	179232	o
Dummy Pieces	B=130	925900	2	179233	o
Dummy Pieces	B=150	925900	2	179234	o
Dummy Pieces	B=180	925900	2	179235	o
Dummy Pieces	B=230	925900	2	179236	o
Set Screws	M10x20 DIN EN ISO 4028	995161	10	815807	
Screwdrivers	SW5x150	985730	1	168703	
	[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

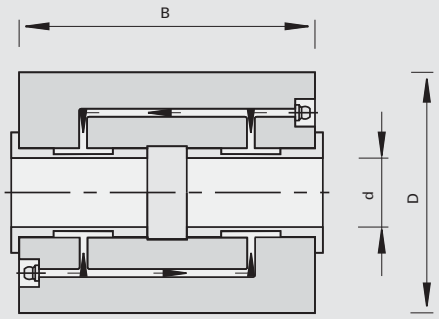
B (mm)	50	55	60	70
Dmax at D=122	161	171	181	201
Max.RPM (min-1):	9000	8400	8000	7200
Dmax at D=137	176	186	196	216
Max.RPM (min-1):	8200	7700	7300	6600

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 o
137	100	40	4	176343 o
137	130	40	4	176344 o
137	150	40	4	176345 o
137	180	40	4	176346 o
137	230	40	4	176347 o
150	60	50	4	176348 o
150	60	50	6	176349 o
150	100	50	4	176350 o
150	100	50	6	176351 o
150	130	50	4	176352 o
150	130	50	6	176353 o
150	150	50	4	176354 o
150	150	50	6	176355 o
150	180	50	4	176356 o
150	180	50	6	176357 o
[mm]	[mm]	[mm]		

Ø D	B	Ø d	Z	Ident-No.
150	230	50	4	176358 o
150	230	50	6	176359 o
150	260	50	4	176360 o
150	260	50	6	176361 o
150	310	50	4	176362 o
150	310	50	6	176363 o
163	60	50	8	176364 o
163	100	50	8	176365 o
163	130	50	8	176366 o
163	150	50	8	176367 o
163	180	50	8	176368 o
163	230	50	8	176369 o
163	260	50	8	176370 o
163	310	50	8	176371 o
195	60	50	10	176372 o
195	100	50	10	176373 o
195	130	50	10	176374 o
195	150	50	10	176375 o
215	60	50	12	176380 o
215	100	50	12	176381 o
215	130	50	12	176382 o
215	150	50	12	176383 o
[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M12x25 DIN EN ISO 4028	995161	10	181466
Screwdrivers	SW6x200	985730	1	167817
Grease presses		993270	1	163706
Grease Cartridges		993270	1	163707
	[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

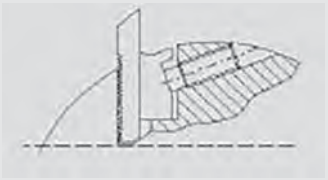
Knife height H [mm]	50	55	60	70
Dmax at D=137	174	184	194	214
Max.RPM (min-1):	8300	7800	7400	6700
Dmax at D=150	189	199	209	229
Max.RPM (min-1):	7700	7300	6900	6300
Dmax at D=163	202	212	222	242
Max.RPM (min-1):	7200	6800	6500	6000
Dmax for D=215	254	264	274	294
Max.RPM (min-1):	5700	5400	5200	4900

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

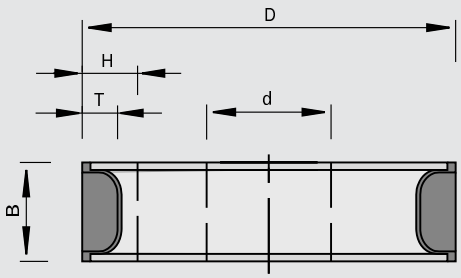
Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
90	40	Weinig-HSK	2	182312 o	182314 o
90	60	Weinig-HSK	2	181766 o	181775 o
90	80	Weinig-HSK	2	181767 o	181776 o
90	100	Weinig-HSK	2	181768 o	181777 o
90	130	Weinig-HSK	2	181769 o	181778 o
90	150	Weinig-HSK	2	181770 o	181779 o
90	170	Weinig-HSK	2	181771 o	181780 o
90	190	Weinig-HSK	2	182313 o	181781 o
90	210	Weinig-HSK	2	181773 o	181782 o
90	240	Weinig-HSK	2	181774 o	181783 o
90	80	Weinig-HSK	4	181785 o	181794 o
90	100	Weinig-HSK	4	181786 o	181795 o
90	130	Weinig-HSK	4	181787 o	181796 o
90	150	Weinig-HSK	4	181788 o	181797 o
90	170	Weinig-HSK	4	181789 o	181798 o
90	190	Weinig-HSK	4	181790 o	181799 o
90	210	Weinig-HSK	4	181791 o	181800 o
90	40	Weinig-HSK	4	182315 o	182316 o
90	60	Weinig-HSK	4	181784 o	182317 o
90	240	Weinig-HSK	4	181792 o	182318 o
[mm]	[mm]	[mm]			

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: cutter-head 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
125	60	30	35	15	2	SP 2	167264
[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
SP blanks	40,6	28.2	HL Solid 60	SP 1	152529	10	177367
SP blanks	60,8	30.2	HL Board 06	SP 2	152526	10	179113
SP blanks	60,8	30.2	HL Solid 60	SP 2	152529	10	177368
support plates	40	26.5		SP 1	925402	2	178007
support plates	60	28.5		SP 2	925402	2	178008
deflector plates	40	28		SP 1	925407	1	167267
deflector plates	60	30		SP 2	925407	1	167268
	[mm]	[mm]				[pc.]	

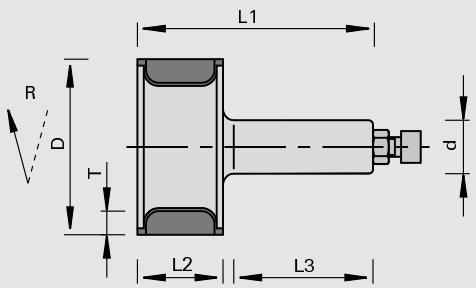
Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	36x12x8	167263	925300	2	166737
Pressure Bars	58x12x8	167264	925300	2	166738
Special Set Screws	M8x24	For all	995191	10	167269
Screwdrivers	SW4x100	For all	985730	1	166091
	[mm]			[pc.]	

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 s
82	40	25	55	110	11	2	18000	SP 19	167835 s	167834
82	40	MK 2	55	127	11	2	18000	SP 19		167483 s
86	60	25	55	130	13	2	10000	SP 31		176241
[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
SP blanks	40,6	28.2	HL Solid 60	SP 19	152529	10	177367
SP blanks	60,8	30.2	HL Board 06	SP 31	152526	10	179113
SP blanks	60,8	30.2	HL Solid 60	SP 31	152529	10	177368
support plates	40	26.5		SP 19	925402	2	178007
support plates	60	28.5		SP 31	925402	2	178008
	[mm]	[mm]				[pc.]	

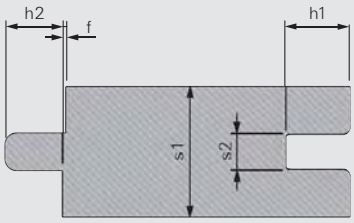
Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	36x12x8	167835	925300	2	166736
Pressure Bars	36x12x8	167479, 167483, 167834	925300	2	166737
Pressure Bars	58x12x8	176241	925300	2	166738
Set Screws	M8x16 DIN EN ISO 4028	For all	995161	10	164422
Screwdrivers	SW4x100	For all	985730	1	166091
	[mm]			[pc.]	

327300

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

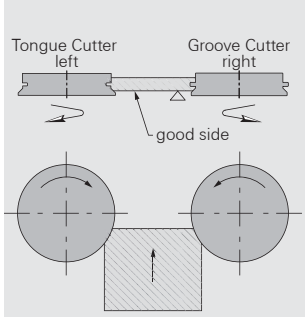
Advantages

Notes

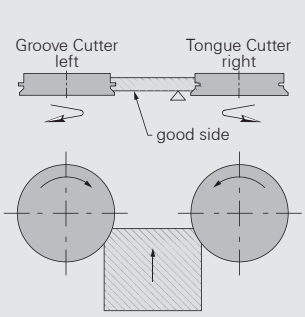
- indicate sense of rotation, direction of feed and face side according to diagram I, II, III or IV when placing an order
- without indications we will deliver according to diagram I
- delivery with HW-tipping possible with surcharge

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 s
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]		

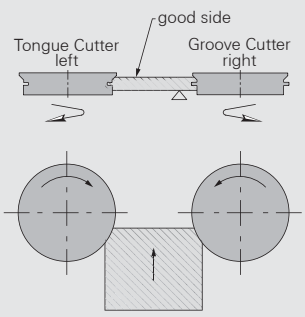
Example I



Example II



Example III



Example IV

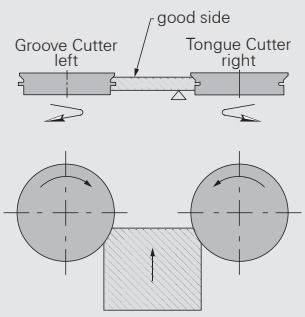
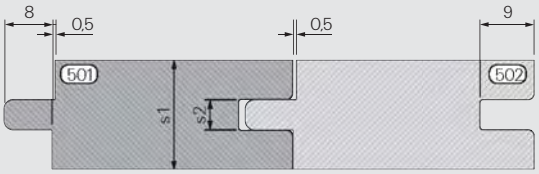


Diagram I

Tongue Cutters

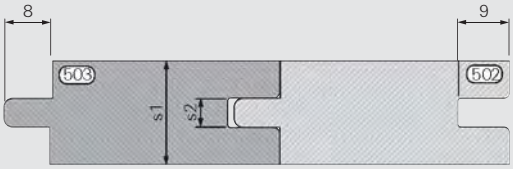
Grooving Cutters

Profile 501



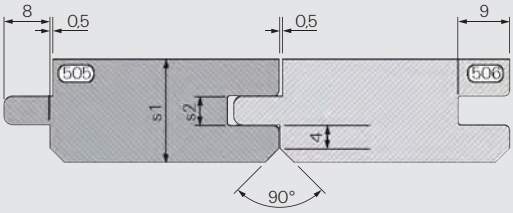
Profile 502

Profile 503



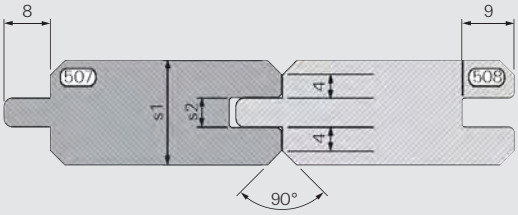
Profile 502

Profile 505



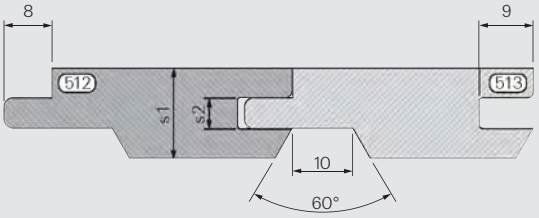
Profile 506

Profile 507



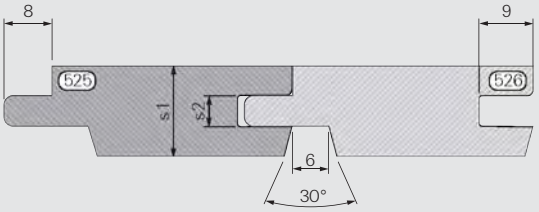
Profile 508

Profile 512



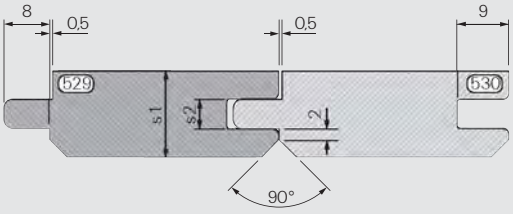
Profile 513

Profile 525



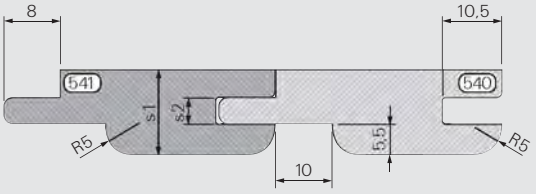
Profile 526

Profile 529



Profile 530

Profile 541



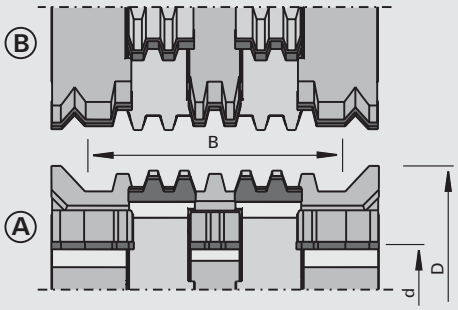
Profile 540

123600

HW Counter Profile Cutter set

Product

Drawing



LEUCO DUR

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

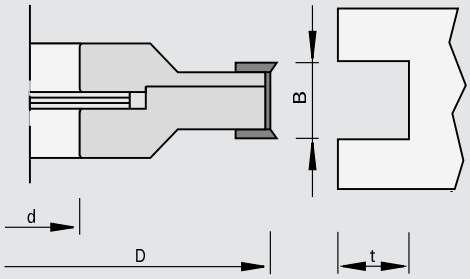
Ø D	B	Ø d	Z	nmax	Profile	Ident-No.
190	220	80	5x4	8000	A	192657 s
190	220	80	5x4	8000	B	192658 s
[mm]	[mm]	[mm]		[min-1]		

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
180	4,0-7,5	30	35	8+4		4500-7400	168081
180	4,0-7,5	35	35	8+4	10x4	4500-7400	168083 s
180	4,0-7,5	40	35	8+4	12x5	4500-7400	168085 s
180	4,0-7,5	50	30	8+4		4500-7400	168087 s
180	4,0-15	30	35	8+2+4		4500-7400	168080 s
180	4,0-15	35	35	8+2+4	10x4	4500-7400	168082 s
180	4,0-15	40	35	8+2+4	12x5	4500-7400	168084 s
[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
Spurs	14	14	1.2	For all	150558	10	163701
Turnover Knives	18	18	1.95	For all	150508	10	163699
	[mm]	[mm]	[mm]			[pc.]	

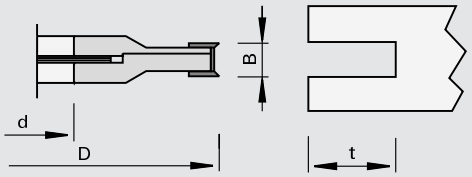
Spare parts		Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars		B=7,2	168080, 168082, 168084	925300	2	168074
Set Screws		M5x12 DIN EN ISO 4028	168080, 168082, 168084	995161	10	050565
Countersunk Screws		M4x0,5x3,2 T9	For all	995125	10	163925
Spacer Sets		50x3,5x30	166509	955521	1	166367
Spacer Sets		65x3,5x30	168080, 168081	955521	1	168075
Spacer Sets		70x3,5x35	168082, 168083	955521	1	168076
Spacer Sets		70x3,5x40	168084, 168085	955521	1	168077
Spacer Sets		90x3,5x50	168087	955521	1	168078
Special Nuts	for spurs	M4x0,5x1,6	For all	995290	10	163704
Special Nuts	for profile knives	M4x0,5x2,2	For all	995290	10	163703
Screwdrivers		SW2,5x100	168080, 168082, 168084	985730	1	168010
Screwdrivers		T9	For all	985730	1	164344
		[mm]				

121455

Grooving Cutterheads HW - adjustable 8-24 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 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
180	8,0-15	35	35	4+4	10x4	4500-7400	178726 &
180	8,0-15	40	35	4+4	12x5	4500-7400	178727 s
180	12,6-24	30	40	4+4		4500-7400	178729
180	12,6-24	35	40	4+4	10x4	4500-7400	178730 &
180	12,6-24	40	40	4+4	12x5	4500-7400	178731 s
[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
Turnover Knives	7,5	12	1.5	178725, 178726, 178727	150515	10	052543
Turnover Knives	12	12	1.5	178729, 178730, 178731	150515	10	003080
	[mm]	[mm]	[mm]			[pc.]	

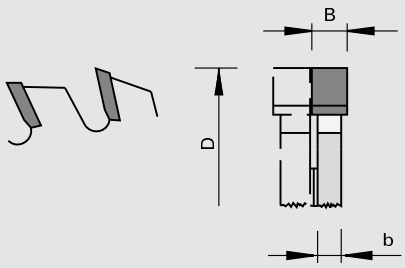
Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=10	178729, 178730, 178731	925300	2	164526
Pressure Bars	B=7,2	178725, 178726, 178727	925300	2	168074
Countersunk Screws	M5x6 T20	For all	995125	10	176199
Set Screws	M5x12 DIN EN ISO 4028	178725, 178726, 178727	995161	10	050565
Set Screws	M6x12 DIN EN ISO 4028	178729, 178730, 178731	995161	10	180214
Spacer Sets	65x11,5x30	178729	955521	1	167278
Spacer Sets	70x11,5x35	178730	955521	1	167279
Spacer Sets	70x11,5x40	178731	955521	1	167280
Spacer Sets	65x7x30	178725	955521	1	167282
Spacer Sets	70x7x35	178726	955521	1	167283
Spacer Sets	70x7x40	178727	955521	1	167284
Screwdrivers	SW3x100	178729, 178730, 178731	985730	1	166090
Screwdrivers	SW2,5x100	178725, 178726, 178727	985730	1	168010
Screwdrivers	T20x100	For all	985730	1	166092
Adjusting Gauges	0,3	For all	985200	1	055883
	[mm]			[pc.]	

109015

Grooving Cutters 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

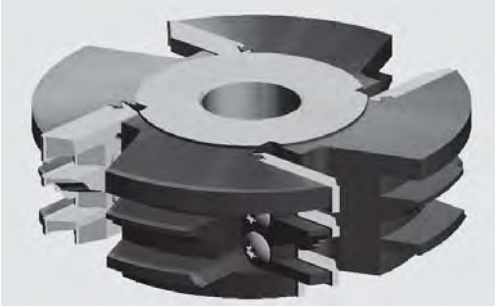
- application against feed with the grain (solid wood)
- application with feed only with MEC (wood-based panels)
- for Z = 12 and Z = 18 other groove widths are possible when tools are assembled as a set
- groove width calculation for tool sets: sum of all "b" + HW overlap left and right + shim thickness

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

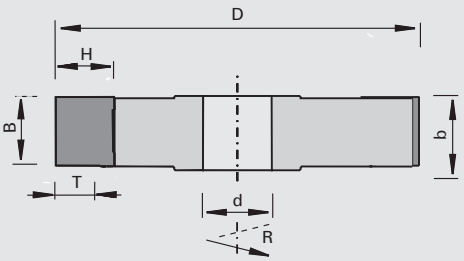
120604/120606

UltraProfiler plus - Cutterheads HW (straight) - MAN

Product



Drawing



LEUCO ultra.profiler 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 DIN-EN 50144

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
	20	40.4	2.0	HL Board 06	152516	10	183057
	25	40.4	2.0	HL Board 06	152516	10	183058
	32	40.4	2.0	HL Board 06	152516	10	182419
	40	40.4	2.0	HL Board 06	152516	10	182420
	50	40.4	2.0	HL Board 06	152516	10	182421
	60	40.4	2.0	HL Board 06	152516	10	182422
	[mm]	[mm]	[mm]			[pc.]	

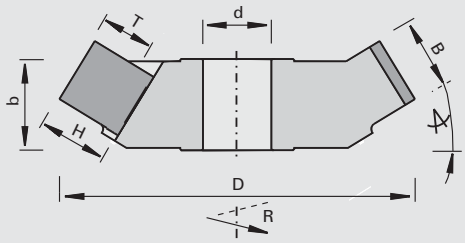
Blanks	B	H	S	LEUCODUR	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	15	30.4	2.0	HL Board 06 topline	152716	10	183680 o	183680 o
	20	40.4	2.0	HL Board 06 topline	152716	10	183681 o	183681 o
	25	40.4	2.0	HL Board 06 topline	152716	10	183682 o	183682 o
	32	40.4	2.0	HL Board 06 topline	152716	10	182563 o	182562 o
	40	40.4	2.0	HL Board 06 topline	152716	10	182565 o	182564 o
	50	40.4	2.0	HL Board 06 topline	152716	10	182567	182566
	60	40.4	2.0	HL Board 06 topline	152716	10	182569 o	182568 o
	[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 DIN-EN 50144

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
	20	40.4	2.0	HL Board 06	152516	10	183057
	25	40.4	2.0	HL Board 06	152516	10	183058
	32	40.4	2.0	HL Board 06	152516	10	182419
	40	40.4	2.0	HL Board 06	152516	10	182420
	50	40.4	2.0	HL Board 06	152516	10	182421
	60	40.4	2.0	HL Board 06	152516	10	182422
	[mm]	[mm]	[mm]			[pc.]	

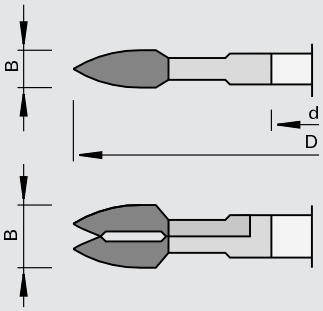
Blanks	B	H	S	LEUCODUR	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	15	30.4	2.0	HL Board 06 topline	152716	10	183680 o	183680 o
	20	40.4	2.0	HL Board 06 topline	152716	10	183681 o	183681 o
	25	40.4	2.0	HL Board 06 topline	152716	10	183682 o	183682 o
	32	40.4	2.0	HL Board 06 topline	152716	10	182563 o	182562 o
	40	40.4	2.0	HL Board 06 topline	152716	10	182565 o	182564 o
	50	40.4	2.0	HL Board 06 topline	152716	10	182567	182566
	60	40.4	2.0	HL Board 06 topline	152716	10	182569 o	182568 o
	[mm]	[mm]	[mm]			[pc.]		

122415

Cutters HW for removing resin pockets

Product

Drawing



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

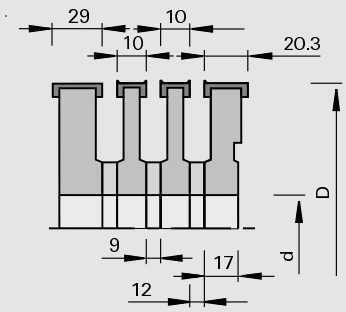
Ø D	B	Ø d	Z	NL	nmax	Ident-No.
100	8,0	22	4	4/4,3/36	12000	180469
100	15	22	4		12000	70176420 o
[mm]	[mm]	[mm]			[min-1]	

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
140	20,3	40	2+2	176067
140	29	40	2	180536 s
140	39,5	40	2	186498 s
140	10	50	2+2	176069
140	20,3	50	2+2	176070
[mm]	[mm]	[mm]		

Spare parts	Ø D	B	Ø d	Class-No.	PU	Ident-No.	
Spacers	70	9	40	955520	1	177308	
Spacers	70	12	40	955520	1	162706	
Spacers	70	9	50	955520	1	177309	s
Spacers	70	10	50	955520	1	163886	
Spacers	70	12	50	955520	1	163887	s
	[mm]	[mm]	[mm]				

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Spurs	14	14	2.0	150558	10	003079
Turnover Knives	9,6	12	1.5	150515	10	171163
Turnover Knives	20	12	1.5	150516	10	178287
Turnover Knives	29,5	12	1.5	150515	10	180825
Turnover Knives	39,5	12	1.5	150515	10	171149
	[mm]	[mm]	[mm]		[pc.]	

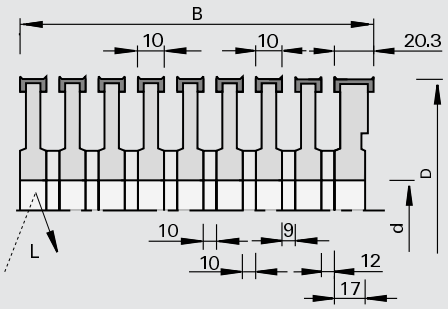
Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=7,2	176066, 176069	925300	2	168074
Set Screws	M5x12 DIN EN ISO 4028	176066, 176069	995161	10	050565
Countersunk Screws	M5x6 T20	176066, 176069	995125	10	176199
Adjusting Gauges	0,7	176066, 176069	985200	1	056096
Pressure Bars	B=17	176067, 176070	925300	2	167971
Set Screws	M8x16 DIN EN ISO 4028	176067, 176070, 180536	995161	10	164422
Countersunk Screws	M5x10,8 T15	176067, 176070	995125	10	180840
Adjusting Gauges	1,0	176067, 176070, 180536, 186498	985200	1	011103
Pressure Bars	B=30	180536	925300	2	164185
Pressure Bars	B=38	186498	925300	2	50775234
Set Screws	M6x12 T15	186498	995195	10	50930404
Screwdrivers	SW2,5x100	176066, 176069	985730	1	168010
Screwdrivers	SW4x100	176067, 176070, 180536	985730	1	166091
Screwdrivers	T15x100	176067, 176070	985730	1	180470
Screwdrivers	T15x140	186498	985730	1	179145
Screwdrivers	T20x100	176066, 176067, 176069, 176070, 180536	985730	1	166092
	[mm]			[pc.]	

121450

Groove Bed Cutterhead Sets HW

Product

Drawing



LEUCO DUR

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"

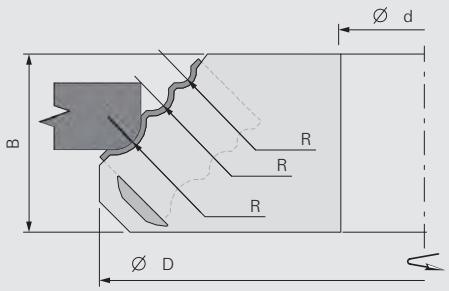
Ø D	B	Ø d	Z	Ident-No.
140	80	35	2+2	176071 &
140	100	35	2+2	176072 &
140	120	35	2+2	176073 &
140	140	35	2+2	176074 &
140	170	35	2+2	176075 &
140	80	40	2+2	176076 &
140	100	40	2+2	176077 &
140	120	40	2+2	176078 &
140	140	40	2+2	176079 &
140	170	40	2+2	176080 &
140	80	50	2+2	176081 &
140	100	50	2+2	176082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

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

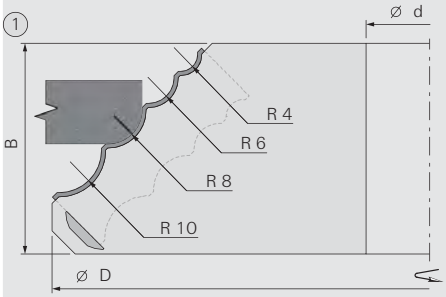
Notes

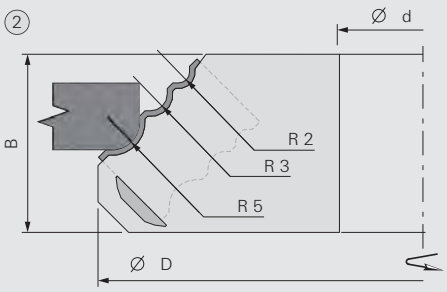
- application against feed

R	Ø D	B	Ø d	Z	Type	nmin-nmax	Ident-No.
2, 3, 5	140	32	30	2	2	5400-6400	50661673 s
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
Profile Knives KB20	1	4,6,8,10	50	16	2.0	151547	2	50820001
		[mm]	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	23x11x6	925300	2	50591382 s
Pressure Bars	48x11x6	925300	2	180346
Clamping Pieces	12x8,5/M8L	925100	2	180357
Clamping Set Screws	M8x26 SW4	995161	10	180340
Screwdrivers	SW4x100	985730	1	166091
	[mm]		[pc.]	

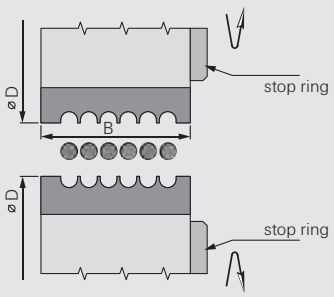




Multi Dowel Cutterheads HS

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

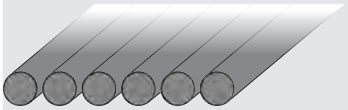
Ø D	B	Ø d	Ø dmax	Z	nmax	Ident-No.	
102	50	35	40	2	6000	50389261	s
102	75	35	40	2	6000	50389262	s
102	100	35	40	2	6000	50389263	s
102	50	40	40	2	6000	50389264	s
102	75	40	40	2	6000	50389265	s
102	100	40	40	2	6000	50389266	s
102	125	40	40	2	6000	50389267	s
102	150	40	40	2	6000	50389268	s
102	50	35	40	4	6000	50389269	s
102	75	35	40	4	6000	50389270	s
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	995111	10	180005	
Washers	B=8,4 DIN 125	995410	10	50945505	s
Cranked Wrench Keys	SW6x100	985730	1	180383	o
	[mm]		[pc.]		

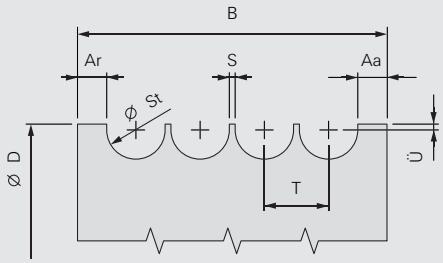
332990

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

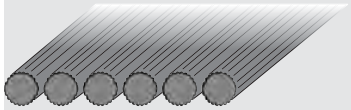
Knives

	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

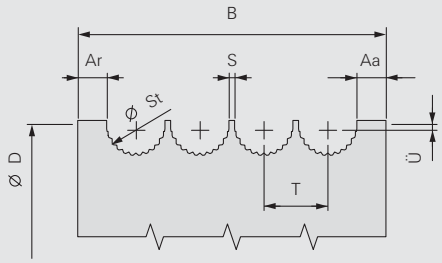
332990

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

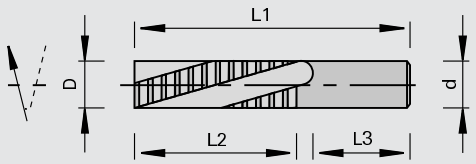
	St= bar Ø	6,1	7,1	8,1	10,1	11,1	12,1	13,1	14,1	15,1	16,1
	No. of serrations	16	16	20	22	22	22	22	22	22	22
	S = bridge	1	1	1	1	1,5	1,5	1,5	1,5	1,5	1,5
	T= pitch	7,1	8,1	9,1	11,1	12,6	13,6	14,6	15,6	16,6	17,6
	D= diameter	127	127	135	135	135	135	135	135	135	135
B=50	No. of bars	6	5	4	3	3	3	3	2	2	2
	Ident-No. 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

129460

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

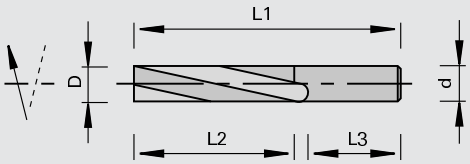
Ø D	L2	Ø d	L3	L1	Z	Helical direction	Ident-No.
8.0	32	8,0	35	75	3	positive	183950
10	32	10	30	75	3	positive	183951
12	42	12	40	90	3	positive	183952
16	35	16	38	90	3	positive	183953
16	55	16	36	110	3	positive	183954
[mm]	[mm]	[mm]	[mm]	[mm]			

129460

Finishing Cutters VHW - ecoline

Product

Drawing



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

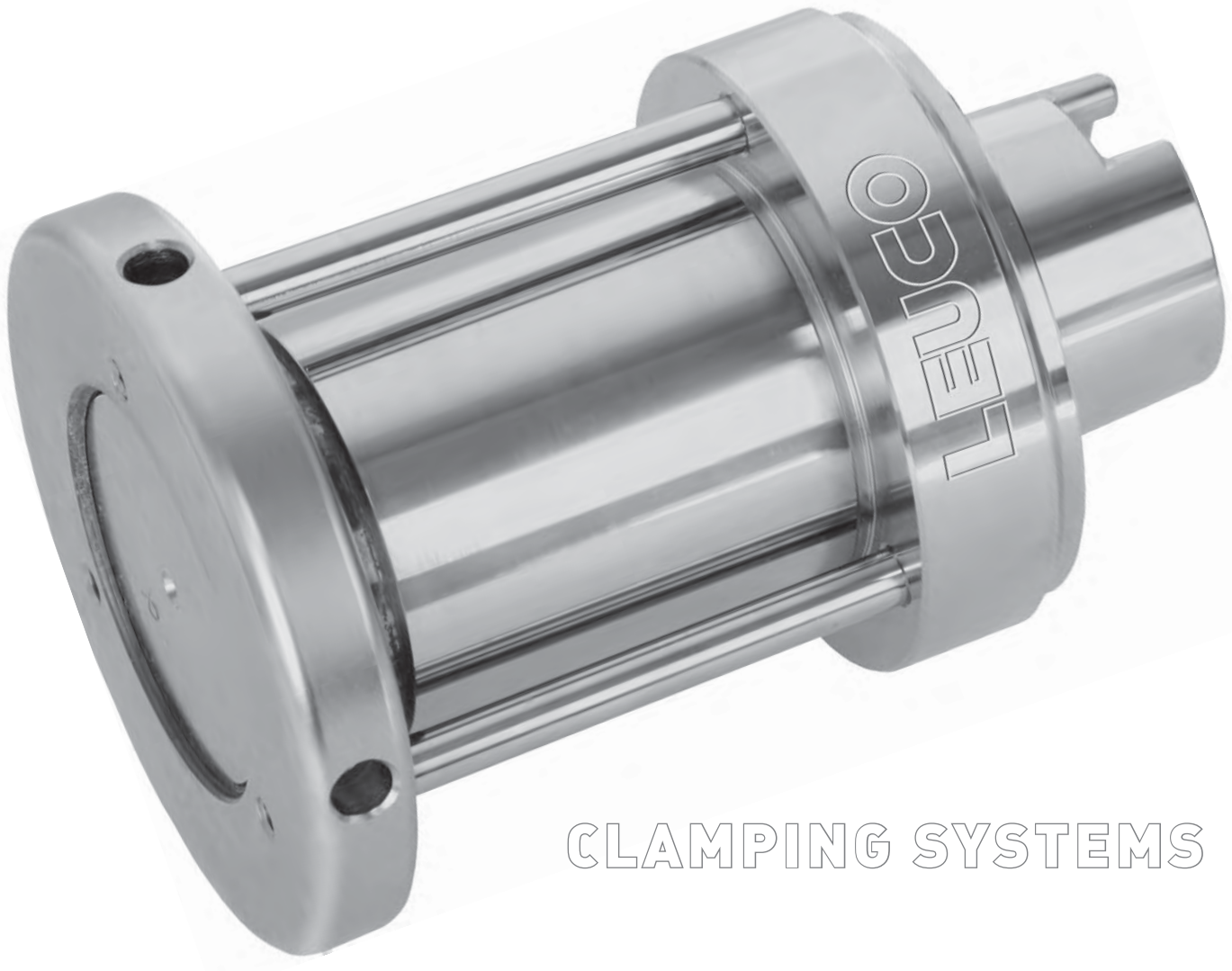
Advantages

- 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
3.0	15	6,0	36	60	2	positive	183938
4.0	15	4,0	36	60	2	positive	183939
4.0	15	4,0	28	60	2	negative	183940
4.0	15	6,0	36	60	2	positive	183941
5.0	15	6,0	36	60	2	positive	183942
6.0	22	6,0	30	60	2	positive	183943
6.0	22	6,0	30	60	2	negative	183944
8.0	30	8,0	36	75	2	positive	183945
8.0	30	8,0	36	75	2	negative	183946
10	30	10	35	75	2	positive	183947
10	30	10	36	75	2	negative	183948
12	42	12	40	90	3	positive	183949
[mm]	[mm]	[mm]	[mm]	[mm]			



CLAMPING SYSTEMS

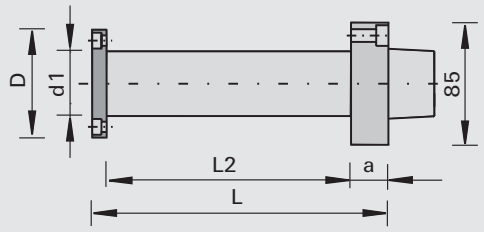
Clamping Systems

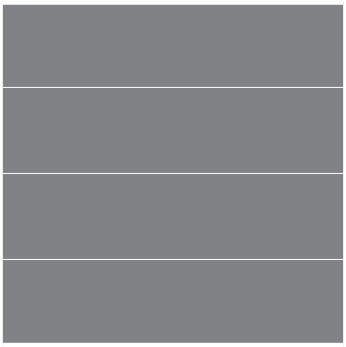
997300

Hydro Tensile Spindles Weinig HSK - clamping length 170-210 mm

Product

Drawing





Machine / Application
- planing machines Weinig Powermat
- for precise clamping of tools with bore

Design
- with hydro-tensile spindle

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

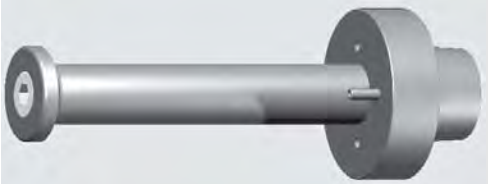
Ø D	Ø d	Ø d1	L2	a	Ident-No.	
85	Weinig HSK	40	170	26	181875	o
85	Weinig HSK	50	170	26	181877	o
85	Weinig HSK	50	210	26	181973	o
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Class-No.	PU	Ident-No.	
Dummy Pieces (cover)	997300	1	182286	o
		[pc.]		

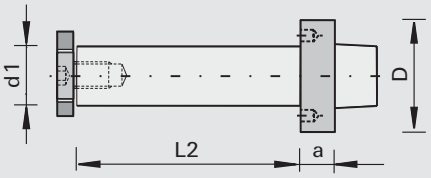
997300

Mounting Arbors Weinig HSK

Product



Drawing



Machine / Application

- profile machines Weinig Powermat
- for mounting of tools with bore

Design

Advantages

Notes

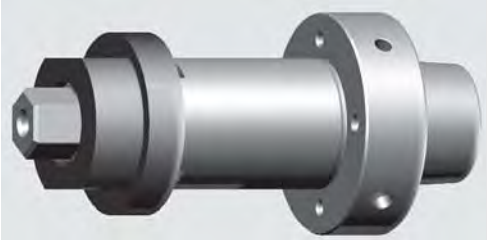
- for right- and lefthand rotation
- other dimensions on request
- for permissible RPM please refer to diagram
- attention: please observe the recommended tightening torque 80 Nm!

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	
85	Weinig HSK	30	60	26	2/6/48 + 2/M6/48	1.8	182057	
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	o
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	
85	Weinig HSK	40	60	26	2/6/54 + 2/M6/54	2.1	182063	
85	Weinig HSK	40	80	26	2/6/54 + 2/M6/54	2.3	182064	
85	Weinig HSK	40	130	26	2/6/54 + 2/M6/54	2.8	182065	
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]		

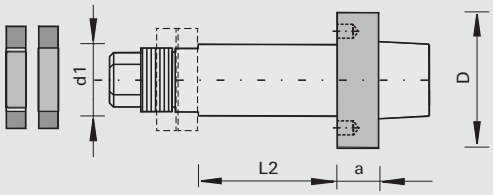
997300

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

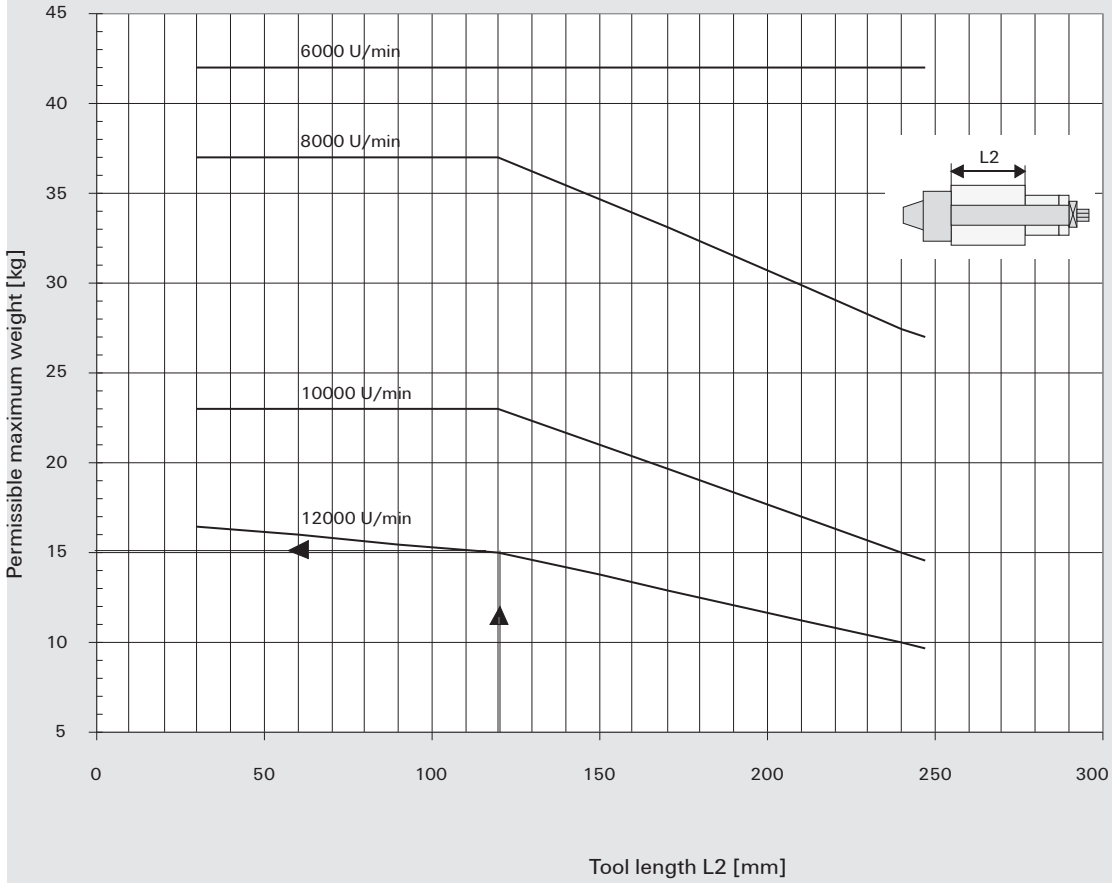
- for right- and lefthand rotation
- other dimensions on request
- for permissible RPM please refer to diagram
- attention: please observe the recommended tightening torque 80 Nm!
- included in delivery: mounting arbor incl. ring and spindle nut

Ø D	Ø d	Ø d1	L2	a	NL	Weight	Ident-No.
85	Weinig HSK	40	30	26	2/6/54 + 2/M6/54	1.9	183281 s
85	Weinig HSK	40	50	26	2/6/54 + 2/M6/54	2.1	183282 s
85	Weinig HSK	40	70	26	2/6/54 + 2/M6/54	2.3	183283 s
85	Weinig HSK	40	90	26	2/6/54 + 2/M6/54	2.5	183284 s
85	Weinig HSK	40	120	26	2/6/54 + 2/M6/54	2.8	183285 s
85	Weinig HSK	40	140	26	2/6/54 + 2/M6/54	2.95	183286 s
85	Weinig HSK	40	160	26	2/6/54 + 2/M6/54	3.2	183287 s
85	Weinig HSK	40	170	26	2/6/54 + 2/M6/54	3.3	183288 s
85	Weinig HSK	40	200	26	2/6/54 + 2/M6/54	3.6	183289 s
85	Weinig HSK	40	220	26	2/6/54 + 2/M6/54	3.8	183290 s
85	Weinig HSK	40	230	26	2/6/54 + 2/M6/54	3.9	183291 s
85	Weinig HSK	40	260	26	2/6/54 + 2/M6/54	4.2	183292 s
85	Weinig HSK	40	300	26	2/6/54 + 2/M6/54	4.6	183293 s
85	Weinig HSK	50	30	26	2/6/74 + 2/M6/64	2.1	183294 s
85	Weinig HSK	50	50	26	2/6/74 + 2/M6/64	2.4	183295 s
85	Weinig HSK	50	70	26	2/6/74 + 2/M6/64	2.7	183296 s
85	Weinig HSK	50	90	26	2/6/74 + 2/M6/64	3.0	183297 s
85	Weinig HSK	50	120	26	2/6/74 + 2/M6/64	3.5	183298 s
85	Weinig HSK	50	140	26	2/6/74 + 2/M6/64	3.75	183299 s
85	Weinig HSK	50	160	26	2/6/74 + 2/M6/64	4.1	183300 s
85	Weinig HSK	50	170	26	2/6/74 + 2/M6/64	4.3	183301 s
85	Weinig HSK	50	200	26	2/6/74 + 2/M6/64	4.7	183302 s
85	Weinig HSK	50	220	26	2/6/74 + 2/M6/64	5.0	183303 s
85	Weinig HSK	50	230	26	2/6/74 + 2/M6/64	5.13	183304 s
85	Weinig HSK	50	260	26	2/6/74 + 2/M6/64	5.6	183305 s
85	Weinig HSK	50	300	26	2/6/74 + 2/M6/64	6.3	183306 s
[mm]	[mm]	[mm]	[mm]	[mm]		[kg]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M6x16 SW3	995161	10	001617
rings	60x15x35	955520	1	183308 o
Spindle Nuts	M33x1,5	995210	1	183307 o
	[mm]		[pc.]	

Adapter Weinig HSK

Diagram for PowerLock-Adapter

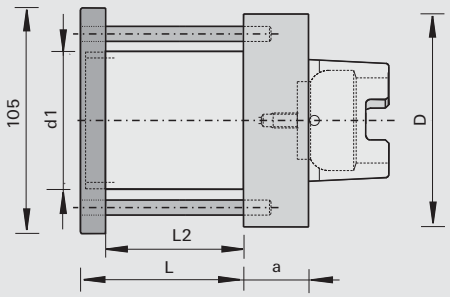


997300

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	Weinig HSK	60	68	26	3/8/74	182974 o
[mm]	[mm]	[mm]	[mm]	[mm]		

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

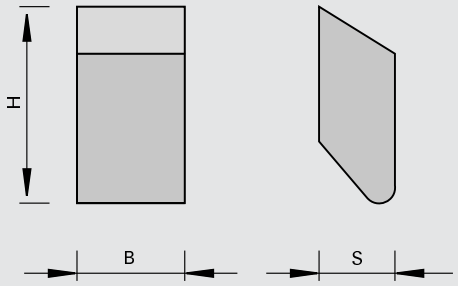
Spare Parts

153301

Saw Teeth HW for Circular Saw Blades - with solder coating

Product

Drawing



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

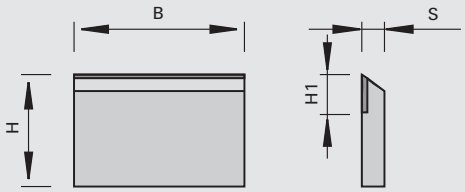
B	H	S	LEUCODUR	Ident-No.
2,7	7.1	2.0	HL Board 06	177493 s
2,8	8.0	2.3	HL Solid 15	177500 s
3,6	8.0	2.3	HL Board 06	177494
4,2	10.5	3.5	HL Solid 15	177501
4,3	10.5	3.0	HL Board 06	177496
4,5	8.0	2.3	HL Board 06	177495
5,0	10.5	3.0	HL Board 06	177497
5,0	10.5	3.5	HL Solid 15	80318077 s
5,4	10.5	3.0	HL Board 06	177498
5,6	10.5	4.0	HL Solid 20	80369454 s
5,8	10.5	3.5	HL Solid 25	80325122 s
6,0	10.5	3.5	HL Solid 15	80304506 s
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
6,0	12.5	4.0	HL Solid 25	80356362 s
6,0	13	4.0	HL Solid 15	80344985 s
6,5	10.5	3.5	HL Solid 15	80357275 s
6,5	12.5	3.0	HL Solid 15	80373746 s
6,5	13	4.0	HL Solid 15	80344986 s
6,8	12.5	4.0	HL Board 06	177499
7,5	10.5	3.5	HL Solid 25	80325124 s
7,5	12.5	3.0	HL Solid 15	80373745 s
7,5	12.5	4.0	HL Solid 15	80282311 s
7,5	13	4.0	HL Solid 15	80363992 s
[mm]	[mm]	[mm]		

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 and support plates with equal weight (packing unit VE) opposite each other

B	H	S	H1	PU	Ident-No.	
60	30	3.0	11	2	160586	
80	30	3.0	11	2	006204	
100	30	3.0	11	2	006205	
110	30	3.0	11	2	165329	o
120	30	3.0	11	2	006206	o
130	30	3.0	11	2	006207	
150	30	3.0	11	2	006208	
170	30	3.0	11	2	006209	
180	30	3.0	11	2	055649	
210	30	3.0	11	2	006210	o
230	30	3.0	11	2	160588	
240	30	3.0	11	2	182641	
260	30	3.0	11	2	160589	o
310	30	3.0	11	2	055648	
310	35	3.0	11	2	165338	o
320	30	3.0	11	2	165330	o
320	35	3.0	11	2	165339	o
330	30	3.0	11	2	165331	o
330	35	3.0	11	2	165340	o
360	30	3.0	11	2	165332	o
360	35	3.0	11	2	165341	o
400	35	3.0	11	2	165342	o
410	30	3.0	11	2	006211	
410	35	3.0	11	2	165343	o
450	30	3.0	11	2	165333	o
450	35	3.0	11	2	165344	o
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	
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	o
[mm]	[mm]	[mm]	[mm]	[pc.]		

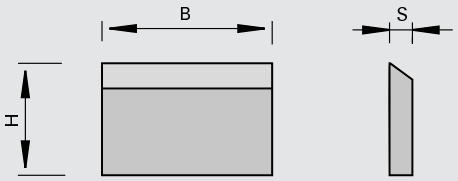
B	H	S	H1	PU	Ident-No.
740	30	3.0	11	2	165337 o
740	35	3.0	11	2	165355 o
810	30	3.0	11	2	160592
810	35	3.0	11	2	165356 o
[mm]	[mm]	[mm]	[mm]	[pc.]	

332121

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°

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.
60	30	3.0	2	160593
80	30	3.0	2	160594
100	30	3.0	2	055647
110	30	3.0	2	160595 s
120	30	3.0	2	160596
130	30	3.0	2	006139
150	30	3.0	2	160597
170	30	3.0	2	160598
180	30	3.0	2	160599
210	30	3.0	2	160600
230	30	3.0	2	160601
260	30	3.0	2	006485
310	30	3.0	2	160602
310	35	3.0	2	165310
320	30	3.0	2	160603
320	35	3.0	2	165311 s
330	30	3.0	2	160604 s
330	35	3.0	2	165312
360	30	3.0	2	160605 s
360	35	3.0	2	165313 s
400	30	3.0	2	165307
400	35	3.0	2	165314 s
410	30	3.0	2	006486
410	35	3.0	2	006487
450	30	3.0	2	160606 s
450	35	3.0	2	165315 s
460	30	3.0	2	160607 s
460	35	3.0	2	165316 s
500	30	3.0	2	165308
500	35	3.0	2	165317
510	30	3.0	2	006488
510	35	3.0	2	006489
600	30	3.0	2	165309 s
600	35	3.0	2	165318 s
[mm]	[mm]	[mm]	[pc.]	

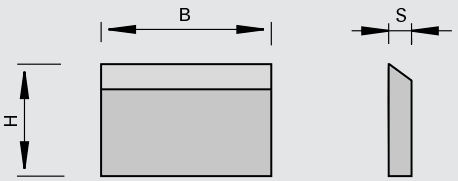
B	H	S		PU	Ident-No.
610	30	3.0		2	006490
610	35	3.0		2	006491
630	30	3.0		2	160608
630	35	3.0		2	165319
635	35	3.0		2	165320 s
640	30	3.0		2	160609
640	35	3.0		2	165321
700	35	3.0		2	165322 s
710	30	3.0		2	160610 s
710	35	3.0		2	165323 s
740	35	3.0		2	165324 s
810	30	3.0		2	160612
810	35	3.0		2	165325
840	30	3.0		2	160613 s
1050	25	3.0		2	185843 s
1050	30	3.0		2	176331
1050	35	3.0		2	176332
[mm]	[mm]	[mm]		[pc.]	

332121

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 and support plates with equal weight (packing unit VE) opposite each other

B	H	S		PU	Ident-No.
130	30	3.0		2	182759 o
150	30	3.0		2	182760 o
170	30	3.0		2	182761 o
180	30	3.0		2	182762 o
190	30	3.0		2	182763 o
210	30	3.0		2	182764 o
230	30	3.0		2	182765 o
240	30	3.0		2	182766 o
270	30	3.0		2	182767 o
310	30	3.0		2	182768 o
[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 s
[mm]	[mm]	[mm]		[pc.]	

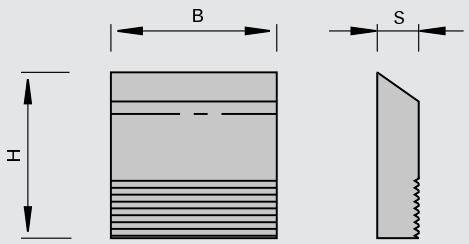
B	H	S		PU	Ident-No.
240	30	3.0	topcoat	10	186014 s
270	30	3.0	topcoat	10	186015 s
310	30	3.0	topcoat	10	186016 s
[mm]	[mm]	[mm]		[pc.]	

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

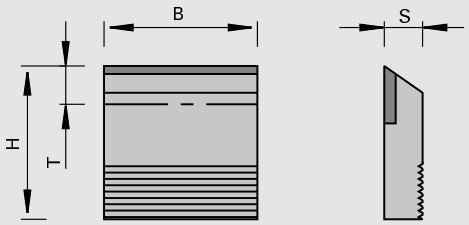
B	H	S	Tmax	PU	Ident-No.
40	50	8.0	12	2	163385
40	60	8.0	20	2	163386
40	70	8.0	30	2	163387
50	50	8.0	12	2	180533 s
50	60	8.0	20	2	180534
60	50	8.0	12	2	163388
60	60	8.0	20	2	163389
60	70	8.0	30	2	163390
80	50	8.0	12	2	163391
80	60	8.0	20	2	163392
80	70	8.0	30	2	163393
100	50	8.0	12	2	163394
100	60	8.0	20	2	163395
100	70	8.0	30	2	163396
130	50	8.0	12	2	163397
130	60	8.0	20	2	163398
130	70	8.0	30	2	163399 s
150	50	8.0	12	2	163400
150	60	8.0	20	2	163401
150	70	8.0	30	2	163402
180	50	8.0	12	2	163403 s
180	60	8.0	20	2	163404 s
180	70	8.0	30	2	163405 s
230	50	8.0	12	2	164495
230	60	8.0	20	2	164496 s
650	50	8.0	12	2	176318
650	60	8.0	20	2	176319
650	70	8.0	30	2	176320
[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

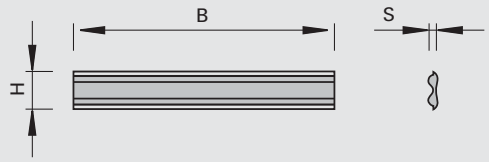
B	H	S	Tmax	PU	Ident-No.	
40	50	10	13	2	165357	
40	60	10	18	2	165365	
60	50	10	13	2	165358	
60	60	10	18	2	165366	
80	50	10	13	2	165359	o
80	60	10	18	2	165367	
100	50	10	13	2	165360	
100	60	10	18	2	165368	
130	50	10	13	2	165361	o
130	60	10	18	2	165369	o
150	50	10	13	2	165362	o
150	60	10	18	2	165370	o
180	50	10	13	2	165363	o
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.]		

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

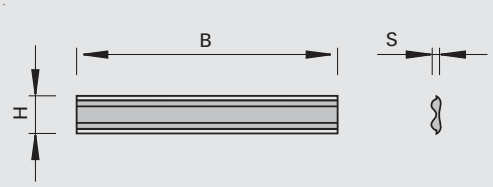
B	H	S	PU	Ident-No.	
60	10	2.3	2	175305	o
80	10	2.3	2	175307	o
90	10	2.3	2	175308	o
100	10	2.3	2	175309	o
110	10	2.3	2	175310	o
120	10	2.3	2	175311	o
130	10	2.3	2	175312	o
140	10	2.3	2	175313	o
150	10	2.3	2	175314	o
160	10	2.3	2	175315	o
170	10	2.3	2	175316	o
180	10	2.3	2	175317	o
185	10	2.3	2	175318	o
190	10	2.3	2	175319	o
200	10	2.3	2	175320	o
210	10	2.3	2	175321	o
220	10	2.3	2	175322	o
230	10	2.3	2	175323	o
240	10	2.3	2	175324	o
250	10	2.3	2	175325	o
260	10	2.3	2	175326	o
265	10	2.3	2	175327	o
270	10	2.3	2	175328	o
280	10	2.3	2	175329	o
300	10	2.3	2	175331	o
310	10	2.3	2	175332	
320	10	2.3	2	175334	o
330	10	2.3	2	175335	o
350	10	2.3	2	175337	o
360	10	2.3	2	175338	o
400	10	2.3	2	175342	o
410	10	2.3	2	175343	
420	10	2.3	2	175344	o
430	10	2.3	2	175345	o
450	10	2.3	2	175347	o
500	10	2.3	2	175352	o
510	10	2.3	2	175353	
520	10	2.3	2	175354	
530	10	2.3	2	175355	o
540	10	2.3	2	175356	o
610	10	2.3	2	175363	o
630	10	2.3	2	175365	
635	10	2.3	2	175366	o
640	10	2.3	2	175368	
650	10	2.3	2	175369	o
[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 o
70	10	2.3	2	175206 o
80	10	2.3	2	175207 o
90	10	2.3	2	175208 o
100	10	2.3	2	175209 o
110	10	2.3	2	175210 o
120	10	2.3	2	175211 o
130	10	2.3	2	175212 o
140	10	2.3	2	175213 o
150	10	2.3	2	175214 o
160	10	2.3	2	175215 o
170	10	2.3	2	175216 o
180	10	2.3	2	175217 o
185	10	2.3	2	175218 o
190	10	2.3	2	175219 o
200	10	2.3	2	175220 o
210	10	2.3	2	175221 o
220	10	2.3	2	175222 o
230	10	2.3	2	175223 o
240	10	2.3	2	175224 o
250	10	2.3	2	175225 o
260	10	2.3	2	175226 o
265	10	2.3	2	175227 o
270	10	2.3	2	175228 o
280	10	2.3	2	175229 o
290	10	2.3	2	175230 o
300	10	2.3	2	175231 o
310	10	2.3	2	175232 o
315	10	2.3	2	175233 o
320	10	2.3	2	175234 o
330	10	2.3	2	175235 o
340	10	2.3	2	175236 o
350	10	2.3	2	175237 o
360	10	2.3	2	175238 o
370	10	2.3	2	175239 o
380	10	2.3	2	175240 o
390	10	2.3	2	175241 o
400	10	2.3	2	175242 o
410	10	2.3	2	175243 o
420	10	2.3	2	175244 o
430	10	2.3	2	175245 o
440	10	2.3	2	175246 o
450	10	2.3	2	175247 o
460	10	2.3	2	175248 o
[mm]	[mm]	[mm]	[pc.]	

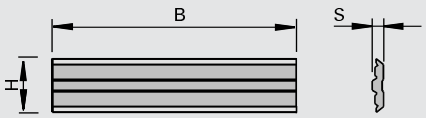
B	H	S	PU	Ident-No.
470	10	2.3	2	175249 o
480	10	2.3	2	175250 o
490	10	2.3	2	175251 o
500	10	2.3	2	175252 o
510	10	2.3	2	175253
520	10	2.3	2	175254 o
530	10	2.3	2	175255 o
540	10	2.3	2	175256 o
550	10	2.3	2	175257 o
560	10	2.3	2	175258 o
570	10	2.3	2	175259 o
580	10	2.3	2	175260 o
590	10	2.3	2	175261 o
600	10	2.3	2	175262 o
610	10	2.3	2	175263 o
620	10	2.3	2	175264 o
630	10	2.3	2	175265 o
635	10	2.3	2	175266 o
640	10	2.3	2	175268 o
650	10	2.3	2	175269 o
[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

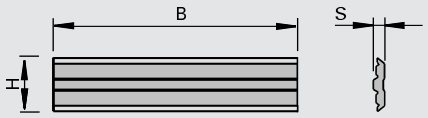
B	H	S	PU	Ident-No.
80	12	2.7	4	182769 o
100	12	2.7	4	182770 o
130	12	2.7	4	182771 o
150	12	2.7	4	182772 o
170	12	2.7	4	182773 o
180	12	2.7	4	182774 o
190	12	2.7	4	182775 o
210	12	2.7	4	182776 o
230	12	2.7	4	182777 o
240	12	2.7	4	182778 o
310	12	2.7	4	182779 o
410	12	2.7	4	182780 o
520	12	2.7	4	182781 o
510	12	2.7	4	182782 o
640	12	2.7	4	182783 o
[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

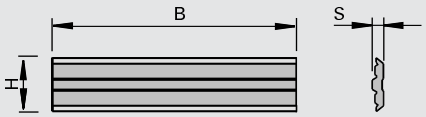
B	H	S	PU	Ident-No.	
100	12	2.7	2	182784	o
130	12	2.7	2	182785	o
150	12	2.7	2	182786	o
170	12	2.7	2	182787	o
180	12	2.7	2	182788	o
190	12	2.7	2	182789	o
210	12	2.7	2	182790	o
230	12	2.7	2	182791	o
240	12	2.7	2	182792	o
410	12	2.7	2	182793	o
510	12	2.7	2	182794	o
640	12	2.7	2	182795	o
[mm]	[mm]	[mm]	[pc.]		

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	2	186244 s
20	5.5	1.1	HL Solid 20	2	186245 s
20	10	1.5	HL Board 03	2	186246 s
20	10	1.5	HL Solid 20	2	186247 s
30	6.5	1.1	HL Board 03	2	186248 s
30	6.5	1.1	HL Solid 20	2	186249 s
30	10	1.5	HL Board 03	2	186250 s
30	10	1.5	HL Solid 20	2	186251 s
50	6.5	1.1	HL Board 03	2	186252 s
50	6.5	1.1	HL Solid 20	2	186253 s
50	10	1.5	HL Board 03	2	186254 s
50	10	1.5	HL Solid 20	2	186256 s
[mm]	[mm]	[mm]		[pc.]	

132891

Turnover Knive Holders - Ledinek Rotoles

Product

Drawing

Tungsten Carbide [HW]

Machine / Application
- planing machines Ledinek Rotoles
- for LEUCODUR turnover knives straight and with chamfer

Design
- for mounting of LEUCODUR turnover knives 14 x 14 mm and 14.3 x 14.3 mm

Advantages

Notes

	Ident-No.	
for thicknesser (TOK 14x14x2) top	182082	o
for service planing rotor (TOK 14x14x2) bottom	182083	o
for thicknesser segments (TOK 14,3x14,3x2,5) top	182084	o
for service planing rotor segments (TOK 14,3x14,3x2,5) bottom	182085	o

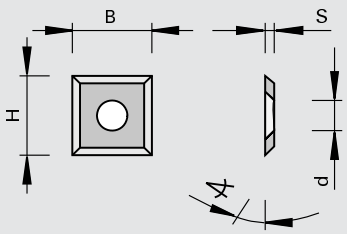
Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x9 T20 D=Ø9,3	995125	10	827277
	[mm]		[pc.]	

150517 / 150553 / 150555 / 150558

Profile Turnover Knives HW with 4 cutting edges - Ledinek Rotoles

Product

Drawing



Tungsten Carbide [HW]

Machine / Application
- planing machines Ledinek Rotoles
- for use in turnover knife holders for plain milling

Design
- cutting material: HW
- HL Board 03 for wood-based panels and plastics
- HL Board 05 for wood-based panels, plastics and hard woods
- HL Solid 20 for wood-based panels, hard and soft woods
- HL Solid 30 for hard and soft woods

Advantages

Notes
- packing unit: 10 pieces

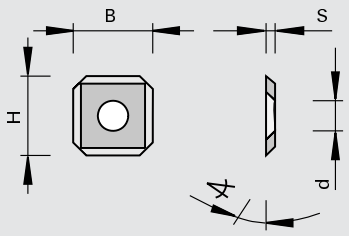
B	H	S	Ø d	Wedge◁	LEUCODUR	Ident-No.
14	14	2.0	6,3	60	HL Solid 30	003079
14	14	2.0	6,3	60	HL Board 05	180954
14	14	2.0	6,3	60	HL Board 03	180646
14,3	14.3	2.5	6,3	55	HL Solid 20	170248
[mm]	[mm]	[mm]	[mm]	[°]		

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

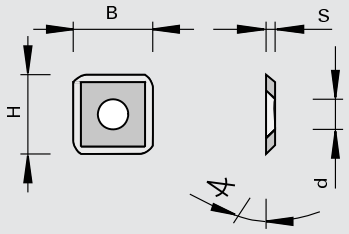
B	H	S	Ø d	Wedge◁	LEUCODUR	Ident-No. [L]	Ident-No. [R]
14	14	2.0	6,4	60	HL Solid 20	180933	180932
14,3	14.3	2.5	6,4	55	HL Solid 20	181144	181143
[mm]	[mm]	[mm]	[mm]	[°]			

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

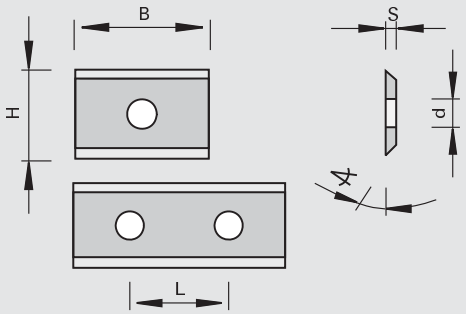
B	H	S	Ø d	Wedge◁	LEUCODUR	Ident-No. [L]	Ident-No. [R]
14	14	2.0	6,4	60	HL Solid 20	182442	182441
14,3	14.3	2.5	6,4	55	HL Solid 20	182444	182443
[mm]	[mm]	[mm]	[mm]	[°]			

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	
7,5	12	1.5	4,0		45	HL Solid 20	173473	o
9,6	12	1.5	4,0		55	HL Board 05	171163	
10,5	12	1.5	4,0		55	HL Board 05	162636	
11	12	1.5	4,0		55	HL Board 05	162637	
13	12	1.5	4,0		55	HL Board 05	162638	
15	12	1.5	4,0		55	HL Board 05	003081	
15	12	1.5	4,0		45	HL Solid 20	173467	o
15,7	12	1.5	4,0		55	HL Board 05	163846	
17	12	1.5	4,0		55	HL Board 05	162639	
18	12	1.5	4,0		55	HL Board 05	162520	
19	12	1.5	4,0		55	HL Board 05	164242	
20	12	1.5	4,0		55	HL Board 02	176469	
20	12	1.5	4,0		55	HL Board 06	178287	
20	12	1.5	4,0		55	HL Board 06 EcoKnife	183569	
20	12	1.5	4,0		55	HL Board 05	003082	
20	12	1.5	4,0		45	HL Solid 20	173468	o
20	12	1.5	4,0		45	HL Solid 20 topline	176265	
30	12	1.5	4,0	14	55	HL Board 01	180223	#
30	12	1.5	4,0	14	55	HL Board 02	176470	
30	12	1.5	4,0	14	55	HL Board 06	178288	
30	12	1.5	4,0	11-14	55	HL Board 06 EcoKnife	183570	
30	12	1.5	4,0	14	55	HL Board 05	003083	
30	12	1.5	4,0	14	45	HL Solid 20	173469	o
30	12	1.5	4,0	14	45	HL Solid 20 topline	176266	
40	12	1.5	4,0	26	55	HL Board 02	182191	o
40	12	1.5	4,0	26	55	HL Board 05	164078	
40	12	1.5	4,0	26	45	HL Solid 20	173470	o
40	12	1.5	4,0	26	45	HL Solid 20 topline	176267	
50	12	1.5	4,0	26	55	HL Board 01	180224	#
50	12	1.5	4,0	26	55	HL Board 02	176471	
[mm]	[mm]	[mm]	[mm]	[mm]	[°]			

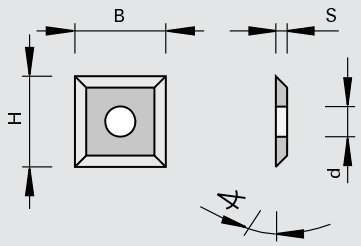
B	H	S	Ø d	L	Wedge◁	LEUCODUR	Ident-No.	
50	12	1.5	4,0	26	55	HL Board 06	178289	
50	12	1.5	4,0	20-26	55	HL Board 06 EcoKnife	183571	
50	12	1.5	4,0	26	55	HL Board 05	003085	
50	12	1.5	4,0	26	45	HL Solid 20 topline	176268	
60	12	1.5	4,0	26	55	HL Board 05	003086	
60	12	1.5	4,0	26	45	HL Solid 20	173472	o
60	12	1.5	4,0	26	45	HL Solid 20 topline	176269	
80	13	2.2	4,0	59-61	55	HL Board 06	003087	
80	13	2.2	4,0	59-61	45	HL Solid 20 topline	181677	
100	13	2.2	4,0	59-61	55	HL Board 06	003088	
120	13	2.2	4,0	59-61	55	HL Board 06	003089	
[mm]	[mm]	[mm]	[mm]	[mm]	[°]			

150513 / 150515 150518 / 150718

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 Solid 20 topline for hard and soft woods
- HL Solid 30 for hard and soft woods

Advantages

- long edge lives and optimum cutting quality in solid woods

Notes

- packing unit: 10 pieces

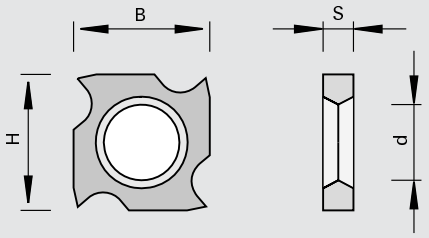
B	H	S	Ø d	Wedge◁	LEUCODUR			Ident-No.
10,5	10.5	1.5	4,0	55	HL Solid 30			162316
12	12	1.5	4,0	55	HL Board 03		*	180820
12	12	1.5	4,0	55	HL Board 05		*	003080
12	12	1.5	4,0	45	HL Solid 20 topline		*	176340
17	17	2.0	4,0	55	HL Board 05	Weinig		162581
19	19	2.0	4,0	55	HL Board 05			162582
[mm]	[mm]	[mm]	[mm]	[°]				

150508

Grooving Turnover Knives HW with 4 cutting edges - grooving cutterheads

Product

Drawing



LEUCODUR

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

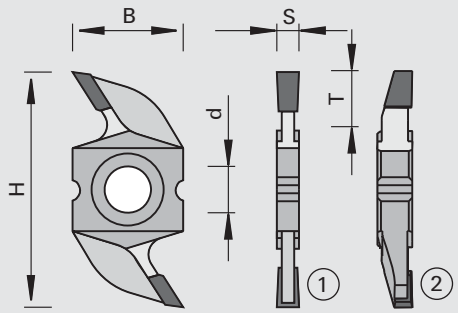
B	H	S	Ø d	Ident-No.
18	18	1.95	10	163699
18	18	2.5	10	165906
18	18	3.7	10	169250
[mm]	[mm]	[mm]	[mm]	

150508/150509

Grooving Turnover Knives HW with 2 cutting edges and positioning groove

Product

Drawing



LEUCODUR

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
- packing unit 10 pieces

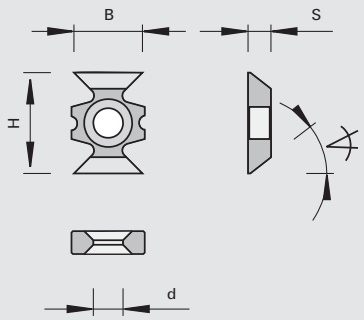
B	H	S	Ø d	Tmax	LEUCODUR		Ident-No.
13	36	3.5	7,4	10	HL Solid 30	no radial positioning	165968
16	34	3.2	6,7	8,0	HL Solid 30		183663
16	34	3.5	6,7	8,0	HL Solid 30		183664 s
16	34	4.0	6,7	8,0	HL Solid 30		183665
16	34	5.0	6,7	8,0	HL Solid 30		183666
[mm]	[mm]	[mm]	[mm]	[mm]			

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

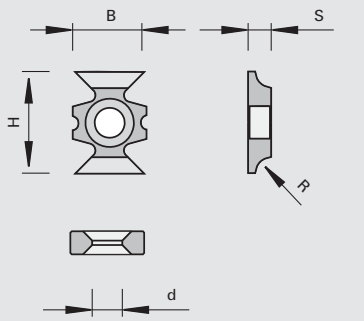
Chamfer∢	B	H	S	Ø d	Ident-No.
45 [°]	16 [mm]	22 [mm]	5.0 [mm]	6,5 [mm]	183668

150577

Rounding Turnover Knives HW with 4 cutting edges and positioning groove

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
- 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
2,0	16	22	5.0	6,5	183670 s
2,5	16	22	5.0	6,5	183671 s
3,0 [mm]	16 [mm]	22 [mm]	5.0 [mm]	6,5 [mm]	183672

985710

Ball hammers one sided

Product	Notes
	I Hand tools for straightening circular saw blades

Weight [kg]	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

985710

Ball hammers double sided

Product	Notes
	I Hand tools for straightening circular saw blades

Weight [kg]	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

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 o
200	186297 o
300	186298 o
400	186299 o
500	186300 o
600	186301 o
800	186302 o

[mm]

985300

Dial gauges

Product

Ident-No.
186304 o

985300

Saw setting dial gauges

Product

Ident-No.
186303 o

AS GOOD AS NEW: EXCELLENT RESHARPENING SERVICE

As a premium manufacturer we know cutting materials and cutting edge geometries very well and have access to the original data. Among others, LEUCO offers carbide-tipped tools with different carbide grades and thus meets the application like no other. As a manufacturer, LEUCO has the know-how for the best service.

In addition, LEUCO's excellent sharpening service is characterized by:

- sharpening know-how of well-trained LEUCO employees
- the most modern high-tech systems in the company service centers
- availability of your tools based on strict sharpening schedules

LEUCO diamond and carbide service: worldwide

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or just scan the QR code:

"GOOD SERVICE IS NOT ABOUT SMILING AT THE CUSTOMER, BUT ABOUT EARNING THE CUSTOMER'S SMILE. THAT IS WHAT WE STRIVE FOR! TO DESERVE YOUR SMILE!"

Short descriptions of the cutting materials

NEW– according to ISO	Meaning	Old designation
SP	Alloyed tool steel (minimum 0.6% C and no more than 5% alloy constituents	SP
HS	High-alloyed tool steel (more than 12% alloy elements Mo, V, Co in total)	HSS
ST	Casting alloy on cobalt basis e.g. Stellite	Stellite
HW	Uncoated tungsten carbide	HM
VHW	Solid tungsten carbide	VHM
DP	Polycrystalline diamond	DIA

02

Tool attributes

Short form	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	No. of teeth

03

Types of feed

Short form	Meaning
MEC	mechanical feed
MAN	manual feed

04

Delivery signs

Kurzform	Bedeutung
&	Modification and/or mounting of stock parts
o	Available from stock on short notice
s	Production per drawing
#	New type in process
$	Superstandard

All ID numbers are available from stock unless specifically indicated.

LEUCO Ledermann GmbH & Co. KG fulfills all demands of ISO 9001:2008.
The certificate-no. is 01 100 010679.

LEUCO

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SW 02

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