



Adresse / Address

Datum / Date

Kontakt / Contact

11/2016

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Betreff / Subject

LEUCO High-Performance Finger Joint Cutters - new generation

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Inhalt / Content

To meet the demands for quality laminated timber, gluelam construction timber as well as window scantlings, the manufacturers must increase productivity either by additional investments in new machine lines or by an increase of cycle rates. Under the assumption of constant quality, higher cycle rates can in principle only be realized by higher feed speeds and higher RPM. LEUCO meets these customer demands and developed a generation of finger joint cutters with a higher number of cutting edges. This allows feed speeds up to 52 m/min. RPM and finger joint quality remain equal to those of cutters with less cutting edges.

Application

I For the production of finger joints on finger joint machines with and without cross-cutting device

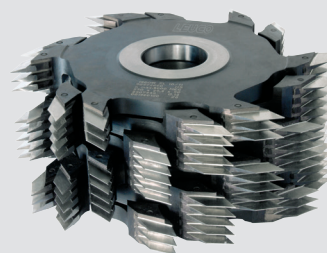
Design

- I Cutting material: high speed steel [HS]
- I Real Z6 version
- I Narrow spiral set design
- I Runout accuracy of 5µm thanks to highly precise manufacturing of the tool body

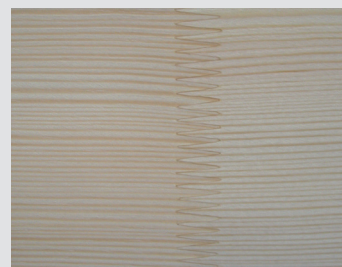
Advantages

- I Double feed speed possible with the same RPM and finger joint quality
- I Minimized risk of shrinking of short wood pieces
- I Minor chipping when exiting the wood even at edge life 's end

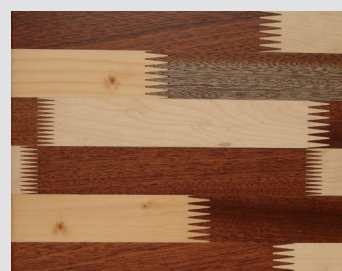
Bildmaterial / Imagery



LEUCO High-Performance Finger Joint Cutters for high feedrates



Sealed finger joints with 10 mm



Using the Z=6+6 tool different finger lengths with and without gap on finger tip can be cut

LEUCO

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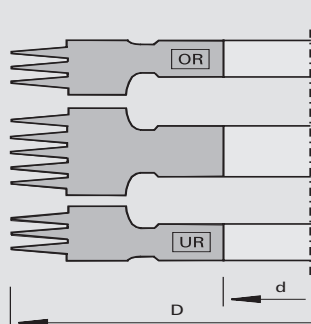
Bildmaterial / Imagery

Dimensions

Ø D [mm]	B [mm]	Ø d [mm]	Teeth	Division	Finger length	Number of tooth	nmax [min-1]	Remark	Ident-No.
170	25,8	50	4	3,8	15/15	3	8000	top cutter	182675
170	41,0	50	4	3,8	15/15	5	8000	base cutter	182676
170	25,8	50	4	3,8	15/15	3	8000	bottom cutter	182677
170	25,8	50	4	3,8	15/16,5	3	8000	top cutter	182678
170	41,0	50	4	3,8	15/16,5	5	8000	base cutter	182679
170	25,8	50	4	3,8	15/16,5	3	8000	bottom cutter	182680
250	26,4	50	6	3,8	10/11	3	6000	top cutter	182630
250	41,0	50	6	3,8	10/11	5	6000	base cutter	182682
250	26,4	50	6	3,8	10/11	3	6000	bottom cutter	182631

Dimensions for PUR-bonding

170	25,8	50	4	3,8	15/15	3	8000	top cutter for PUR-bonding	192264s
170	41,0	50	4	3,8	15/15	5	8000	base cutter for PUR-bonding	192265s
170	25,8	50	4	3,8	15/15	3	8000	bottom cutter for PUR-bonding	192266s
180	27,2	50	3	6,2	20/20	3	8000	top cutter for PUR-bonding	192267s
180	41,0	50	3	6,2	20/20	5	8000	base cutter for PUR-bonding	192268s
180	27,2	50	3	6,2	20/20	3	8000	bottom cutter for PUR-bonding	192269s



Holzbreite

15 mm
34 mm
53 mm
72 mm
91 mm
110 mm
129 mm
148 mm
167 mm
186 mm
208 mm
260 mm
310 mm

Anzahl Fräser

OR + UR
OR + 1 + UR
OR + 2 + UR
OR + 3 + UR
OR + 4 + UR
OR + 5 + UR
OR + 6 + UR
OR + 7 + UR
OR + 8 + UR
OR + 9 + UR
OR + 10 + UR
OR + 13 + UR
OR + 16 + UR

OR = top cutter

UR = bottom cutter