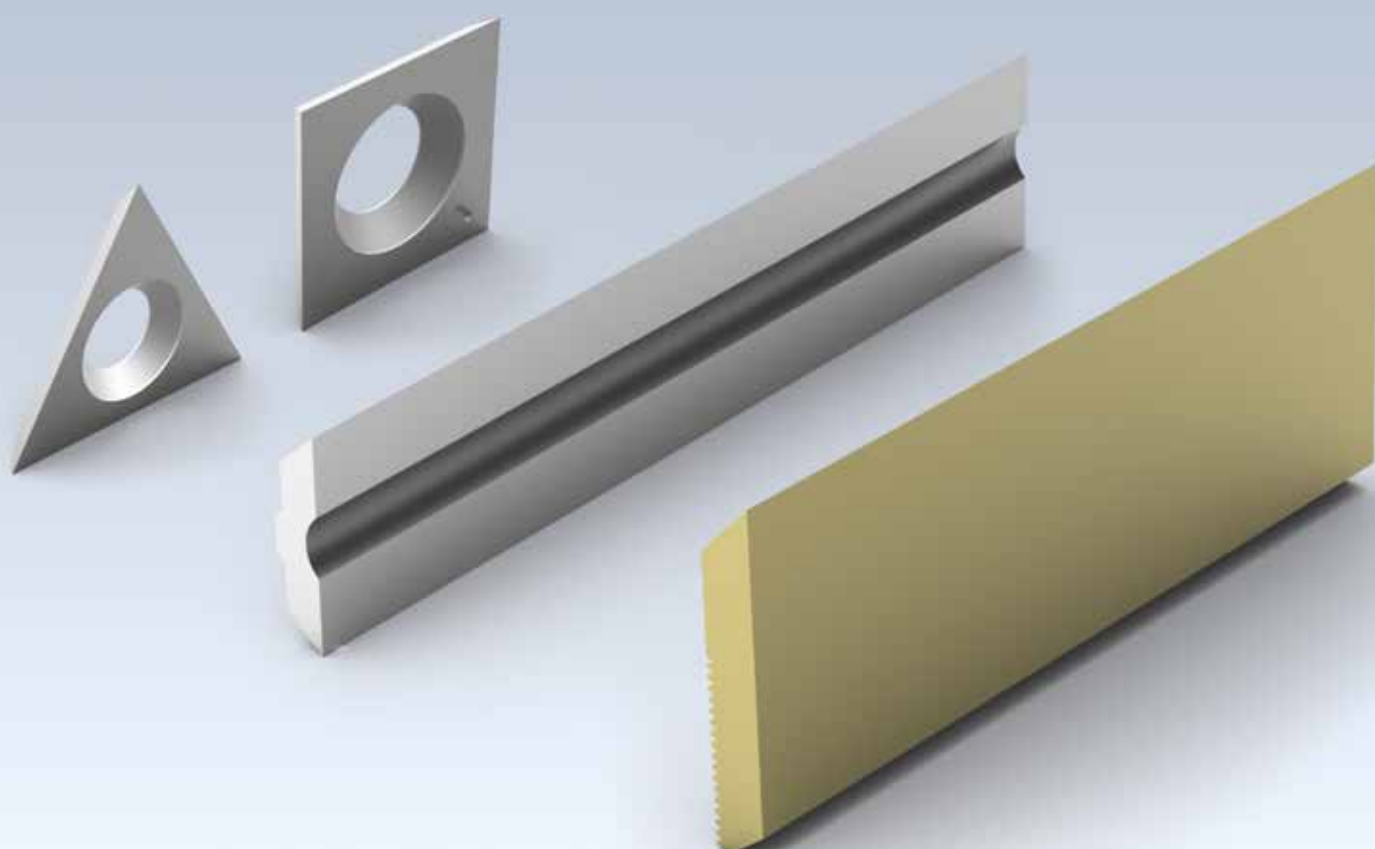


Knives and spare parts

Leitz Lexicon Edition 7



Explanation of abbreviations

A	= dimension A
a_e	= cutting thickness (radial)
a_p	= cutting depth (axial)
ABM	= dimension
APL	= panel raising length
APT	= panel raising depth
AL	= working length
AM	= number of knives
AS	= anti sound (low noise design)

b	= overhang
B	= width
BDD	= thickness of shoulder
BEM	= note
BEZ	= description
BH	= tipping height
BO	= bore diameter

CNC	= Computerized Numerical Control
-----	----------------------------------

d	= diameter
D	= cutting circle diameter
D0	= zero diameter
DA	= outside Diameter
DB	= diameter of shoulder
DFC	= Dust Flow Control (optimised chip clearance)
DGL	= number of links
DIK	= thickness
DKN	= double keyway
DP	= polycrystalline diamond
DRI	= rotation

FAB	= width of rebate
FAT	= depth of rebate
FAW	= bevel angle
FLD	= flange diameter
f_z	= tooth feed
$f_{z\text{ eff}}$	= effective tooth feed

GEW	= thread
GL	= total length
GS	= Plunging edge

H	= height
HC	= tungsten carbide, coated
HD	= wood thickness (thickness of workpiece)
HL	= high-alloyed tool steel
HS	= high-speed steel (HSS)
HW	= tungsten carbide (TCT)

ID	= ident number
IV	= insulation glazing

KBZ	= abbreviation
KLH	= clamping height
KM	= edge breaker
KN	= single keyway
KNL	= combination pinhole consists of 2/7/42 2/9/46,35 2/10/60

L	= length
I	= clamping length
LD	= left hand twist
LEN	= Leitz standard profiles

LL	= left hand rotation
----	----------------------

M	= metric thread
MBM	= minimum order quantity
MC	= multi-purpose steel, coated
MD	= thickness of knife
min^{-1}	= revolutions per minute (RPM)
MK	= morse taper
m min^{-1}	= metres per minute
m s^{-1}	= metres per second

n	= RPM
n_{max}	= maximum permissible RPM
NAL	= position of hub
ND	= thickness of hub
NH	= zero height
NL	= cutting length
NLA	= pinhole dimensions
NT	= grooving depth

P	= profile
POS	= cutter position
PT	= profile depth
PG	= profile group

QAL	= cutting material quality
-----	----------------------------

R	= radius
RD	= right hand twist
RL	= right hand rotation
RP	= radius of cutter

S	= shank dimension
SB	= cutting width
SET	= set
SLB	= slotting width
SLL	= slotting length
SLT	= slotting depth
SP	= tool steel
ST	= Cobalt-basis cast alloys, e.g. Stellite®
STO	= shank tolerance
SW	= cutting angle

TD	= diameter of tool body
TDI	= thickness of tool
TG	= pitch
TK	= reference diameter

UT	= cutting edges with irregular pitch
----	--------------------------------------

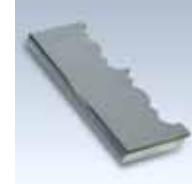
V	= number of spurs
v_c	= cutting speed
v_f	= feed speed
VE	= packing unit
VSB	= adjustment range

WSS	= workpiece material
-----	----------------------

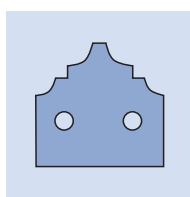
Z	= number of teeth
ZA	= number of fingers
ZF	= tooth shape (cutting edge shape)
ZL	= finger length

Notes to the Lexicon concerning the diagrams and tables

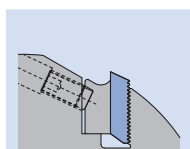
The statements made in the diagrams and tables relate to specific conditions and represent parameters from tests subjected to defined conditions. Variations when using tools in individual case due to special application conditions may be possible. Our support team will provide you with detailed information.



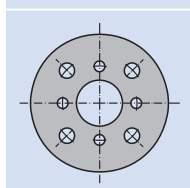
8. Knives and spare parts



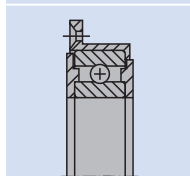
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8.1.2 Spurs	9
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8.1.5 Planer knives	14
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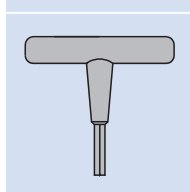
8.2. Spare parts and clamping parts	34
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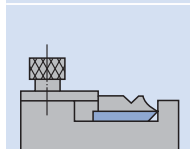
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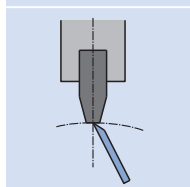
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8.6. Setting gauges / mounting devices	43
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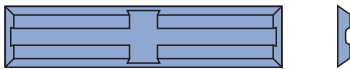
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8. Knives and spare parts

8.1 Knives and blank knives

8.1.1 Turnblade knives



Turnblade knife for router cutter
WL 100 1

Workpiece material:

Softwood and hardwood

Cutting material:

HW

Knife height up to 5.5 mm

HW-05

TM 410 0

SB mm	H mm	DIK mm	KBZ	QAL	VE PCS	ID
20	4.1	1.1	WL 100-1	HW-05	10	005186 ●
20	5.5	1.1	WL 100-1	HW-05	10	005187 ●
25	5.5	1.1	WL 100-1	HW-05	10	005188 ●
30	5.5	1.1	WL 100-1	HW-05	10	005189 ●
40	5.5	1.1	WL 100-1	HW-05	10	005190 ●
50	5.5	1.1	WL 100-1	HW-05	10	005191 ●

ID = 1 piece.



Turnblade knife HW

Knife height 8 mm

HW-30F / HW-05

TM 410 0

SB mm	H mm	DIK mm	VE PCS	ID HW-05	ID HW-30F
7.7	8	1.5	10	005053 ●	005068 ●
9.7	8	1.5	10	005054 ●	005197 ●
11.7	8	1.5	10	005055 ●	005069 ●
14.7	8	1.5	10	005056 ●	005070 ●
19.7	8	1.5	10	005057 ●	005071 ●
25	8	1.5	10	005058 ●	005198 ●
30	8	1.5	10	005059 ●	005072 ●
35	8	1.5	10	005400 ●	005073 ●
40	8	1.5	10	005401 ●	005074 ●
45	8	1.5		007681 ●	007679 □
50	8	1.5	10	005402 ●	005075 ●
60	8	1.5	10	005403 ●	005076 ●
70	8	1.5		007682 ●	007680 □
80	8	1.5	10		005077 ●
80	8	1.5		005404 ●	
100	8	1.5		005405 ●	005184 ●
120	8	1.5		005406 ●	005185 ●

ID = 1 piece.

Cutting material recommendation	HW-30F	HW-05
Softwood	◆	◇
Hardwood	◇	◆
Glulam	◇	◆
Chipboard	◇	◆
MDF	◇	◆
Thermoplastics (PE, PP, PVC, etc.)	◇	◆

◆ suitable ◇ partly suitable

Cutting material:

HW fine grain quality/ HW



Turnblade knife HW

Cutting material recommendation	HW-30F MC	HW-30F MC Micro
Softwood	◆	◆
Hardwood	◇	◆
Glulam	◇	◇
Chipboard		
MDF		
Thermoplastics (PE, PP, PVC, etc.)	◇	◇
	HW-05 MC	TDC
Softwood	◇	◇
Hardwood	◆	◇
Glulam	◆	◆
Chipboard	◆	◆
MDF	◆	◆
Thermoplastics (PE, PP, PVC, etc.)	◆	◆

◆ suitable ◇ partly suitable

Coating:

Marathon MC (Multi Coating) / Marathon TDC (Tungsten Diamond Coating)

Attention:

HW-30F MC cutting edges with microfinish for high demands on finish quality and cutting performance

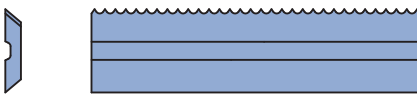
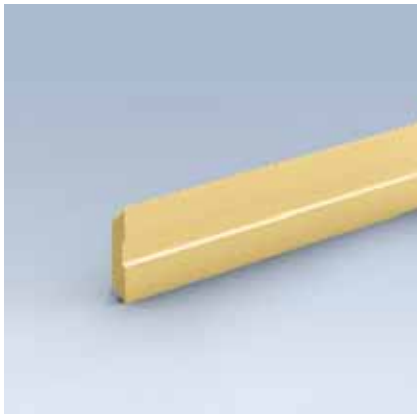
Knife height 8 mm Marathon

HW-30F MC / HW-30F MC Micro / HW-05 MC / HW TDC

TM 410 0 50, TM 410 0 70

SB mm	H mm	DIK mm	VE PCS	ID HW-30F MC	ID HW-30F MC Micro	ID HW-05 MC	ID HW TDC
7.7	8	1.5	10	601600 ●	601704 ●	601628 ●	601416
9.7	8	1.5	10	601601 ●	601705 ●	601629 ●	601417
11.7	8	1.5	10	601602 ●	601706 ●	601630 ●	601418
14.7	8	1.5	10	601603 ●	601707 ●	601631 ●	601419
19.7	8	1.5	10	601604 ●	601708 ●	601632 ●	601420
25	8	1.5	10	601605 ●	601709 ●	601633 ●	601421
30	8	1.5	10	601606 ●	601710 ●	601634 ●	601422
35	8	1.5	10	601607 ●	601711 ●	601635 ●	601423
40	8	1.5	10	601608 ●	601712 ●	601636 ●	601424
45	8	1.5		601609 □	601713 □	601637 ●	601425
50	8	1.5	10	601610 ●		601638 ●	601426
50	8	1.5			601714 ●		
60	8	1.5	10	601611 ●		601639 ●	601427
60	8	1.5			601715 ●		
70	8	1.5		601612 □	601716 □	601640 ●	601428
80	8	1.5	10	601613 ●			601429
80	8	1.5			601717 ●	601641 ●	
100	8	1.5		601614 ●	601718 ●	601642 ●	601430
120	8	1.5		601615 ●	601719 ●	601643 ●	601431

ID = 1 piece.



One-way knife HW



Workpiece material:

Softwood and hardwood

Cutting material:

HW fine grain quality (HW 30F)
HW (HW-05)

Coating:

Marathon MC (Multi Coating)

RipTec:

Cutting edges with RipTec profile for high surface quality and cutting performance

Changeable knife 8 mm Marathon RipTec for turnblade knife tools Integral

HW-30F MC RipTec

TM 140 0 08

SB	H	DIK	KBZ	QAL	VE	ID
mm	mm	mm			PCS	
8	8	1.5	EPR 8/8-MC	HW-30F MC	10	601744
10	8	1.5	EPR 8/10-MC	HW-30F MC	10	601745
12	8	1.5	EPR 8/12-MC	HW-30F MC	10	601746
14	8	1.5	EPR 8/15-MC	HW-30F MC	10	601747
20	8	1.5	EPR 8/20-MC	HW-30F MC	10	601748
24	8	1.5	EPR 8/25-MC	HW-30F MC	10	601749
29	8	1.5	EPR 8/30-MC	HW-30F MC	10	601750
34	8	1.5	EPR 8/35-MC	HW-30F MC	10	601751
39	8	1.5	EPR 8/40-MC	HW-30F MC	10	601752
44	8	1.5	EPR 8/45-MC	HW-30F MC		601753
49	8	1.5	EPR 8/50-MC	HW-30F MC	10	601754
59	8	1.5	EPR 8/60-MC	HW-30F MC	10	601755
69	8	1.5	EPR 8/70-MC	HW-30F MC		601756
78	8	1.5	EPR 8/80-MC	HW-30F MC	10	601757
98	8	1.5	EPR 8/100-MC	HW-30F MC		601758
118	8	1.5	EPR 8/120-MC	HW-30F MC		601759

ID = 1 piece.

HW-05 MC RipTec

TM 140 0 08

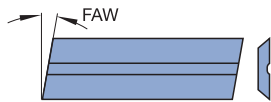
SB	H	DIK	KBZ	QAL	VE	ID
mm	mm	mm			PCS	
8	8	1.5	EPR 8/8B-MC	HW-05 MC	10	601760
10	8	1.5	EPR 8/10B-MC	HW-05 MC	10	601761
12	8	1.5	EPR 8/12B-MC	HW-05 MC	10	601762
14	8	1.5	EPR 8/15B-MC	HW-05 MC	10	601763
20	8	1.5	EPR 8/20B-MC	HW-05 MC	10	601764
24	8	1.5	EPR 8/25B-MC	HW-05 MC	10	601765
29	8	1.5	EPR 8/30B-MC	HW-05 MC	10	601766
34	8	1.5	EPR 8/35B-MC	HW-05 MC	10	601767
39	8	1.5	EPR 8/40B-MC	HW-05 MC	10	601768
44	8	1.5	EPR 8/45B-MC	HW-05 MC		601769
49	8	1.5	EPR 8/50B-MC	HW-05 MC		601770
59	8	1.5	EPR 8/60B-MC	HW-05 MC		601771
69	8	1.5	EPR 8/70B-MC	HW-05 MC		601772
78	8	1.5	EPR 8/80B-MC	HW-05 MC		601773
98	8	1.5	EPR 8/100B-MC	HW-05 MC		601774
118	8	1.5	EPR 8/120B-MC	HW-05 MC		601775

ID = 1 piece.

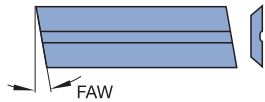
8. Knives and spare parts

8.1 Knives and blank knives

8.1.1 Turnblade knives



Turnblade knife ZM 10/x



Turnblade knife ZM 11/x

Workpiece material:

Softwood and hardwood

Cutting material:

HW fine grain quality

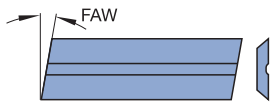
Knife height 8 mm (bevel/tenoning tools)

HW-F

TM 410 0

SB mm	H mm	DIK mm	FAW °	KBZ	QAL	ID
21	8	1.5	10°	ZM 10/1	HW-F	005004 ●
15	8	1.5	14°	ZM 10/4	HW-F	005050 ●
21	8	1.5	10°	ZM 11/1	HW-F	005006 ●
15	8	1.5	14°	ZM 11/4	HW-F	005051 ●

ID = 1 piece.



Turnblade knife ZM 10/x



Turnblade knife ZM 11/x

Knife height 8 mm Marathon (bevel/tenoning tools)

HW-30F MC / HW-05 MC

TM 410 0 50

SB mm	H mm	DIK mm	FAW °	ID HW-05 MC	ID HW-30F MC
15	8	1.5	8°	601645 ●	601616 ●
15	8	1.5	8°	601644 ●	601617 ●
15	8	1.5	14°	601647 ●	601618 ●
15	8	1.5	14°	601646 ●	601619 ●
21	8	1.5	10°	601649 ●	601620 ●
21	8	1.5	10°	601648 ●	601621 ●

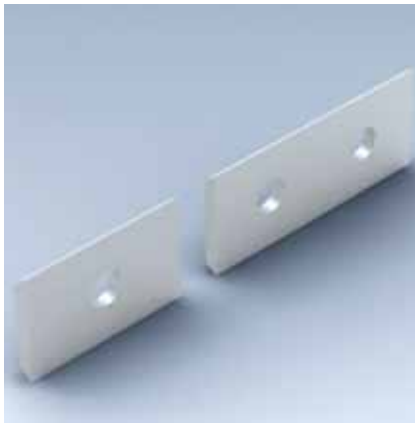
ID = 1 piece.

Cutting material recommendation	HW-30F MC	HW-05 MC
Softwood	◆	◇
Hardwood	◇	◆
Glulam	◇	◆
Chipboard		◆
MDF		◆
Thermoplastics (PE, PP, PVC, etc.)	◇	◆

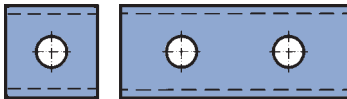
◆ suitable ◇ partly suitable

Coating:

Marathon MC (Multi Coating)



Knife type:
Type 1 Type 2



Turnblade knife

Cutting material recommendation	HW-05F	HW-02 UF
Softwood	◆	◇
Hardwood	◇	◆
Glulam	◇	◆
Chipboard	◇	◆
MDF	◇	◆
Thermoplastics (PE, PP, PVC, etc.)	◇	◆

◆ suitable ◇ partly suitable

Knife height 12 mm

HW-05F / HW-02UF

TM 405 0

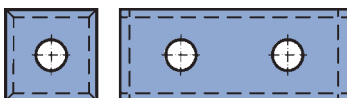
Knife	SB mm	H mm	DIK mm	VE PCS	ID HW-05F	ID HW-02UF
1	7.6	12	1.5	10	005080 ●	
1	9	12	1.5	10	005158 ●	
1 *	12	12	1.5	10	005081 ●	
1	15	12	1.5	10	005082 ●	
1	20	12	1.5	10	005083 ●	602001 ●
2	30	12	1.5	10	005084 ●	602002 ●
2	40	12	1.5	10	005085 ●	602003 ●
2	50	12	1.5	10	005086 ●	602004 ●
2	60	12	1.5	10	005087 ●	

ID = 1 piece.

* = with 4 cutting edges.

Cutting material:

HW / HW ultra fine grain quality



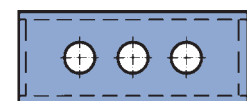
Turnblade knife with 4 cutting edges

Cutting material recommendation	HW-05F	HW-02 UF
Softwood	◆	◇
Hardwood	◇	◆
Glulam	◇	◆
Chipboard	◇	◆
MDF	◇	◆
Thermoplastics (PE, PP, PVC, etc.)	◇	◆

◆ suitable ◇ partly suitable

Cutting material:

HW / HW ultra fine grain quality



Turnblade knife with 4 cutting edges
and 3 holes

Knife height 12 mm with 4 cutting edges

HW-05F / HW-02UF

TM 405 0

SB mm	H mm	DIK mm	VE PCS	ID HW-02UF	ID HW-05F
30	12	1.5	10	602005 ●	005161 ●
50	12	1.5	10	602006 ●	006506 ●

ID = 1 piece.

HW-05F with 3 holes

TM 405 0

SB mm	H mm	DIK mm	QAL	VE PCS	ID
50	12	1.7	HW-05F	10	007668 ●

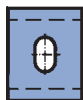
ID = 1 piece.

Workpiece material:

Solid wood, wood derived materials

Cutting material:

HW



Turnblade knife

Workpiece material:

Softwood and hardwood

Cutting material:

HW

Knife height 12 mm (slotting tools)

HW

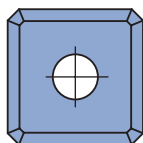
TM 405 0

SB	H	DIK	KBZ	QAL	ID
mm	mm	mm			
7.6	12	1.5	SM 1/1	HW	005120 ●
9.6	12	1.5	SM 1/2	HW	005121 ●
11.6	12	1.5	SM 1/3	HW	005122 ●

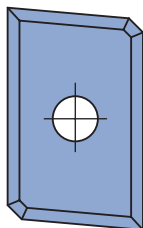
Knife type:

Type 1

Type 2



Turnblade knife



Workpiece material:

Softwood and hardwood

Cutting material:

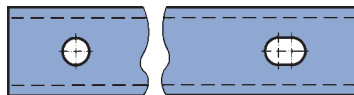
HW

Knife height 12 mm with bevel

HW

TM 405 0

Knife	SB	H	DIK	FAW	QAL	ID
	mm	mm	mm	°		
1	12	12	1.5	1x45°	HW	602009 ●
2	19.7	12	1.5	5°	HW	602010 ●



Turnblade knife

Workpiece material:

Softwood and hardwood

Cutting material:

HW

Knife height 13 mm

HW

TM 405 0

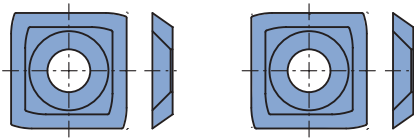
SB	H	DIK	QAL	VE	ID
mm	mm	mm		PCS	
80	13	2.2	HW	10	005096 ●
100	13	2.2	HW	10	005097 ●
120	13	2.2	HW	10	005098 ●

ID = 1 piece.

8. Knives and spare parts

8.1 Knives and blank knives

8.1.1 Turnblade knives



Turnblade knife with radius for calibration moulder System Rotoles

HW

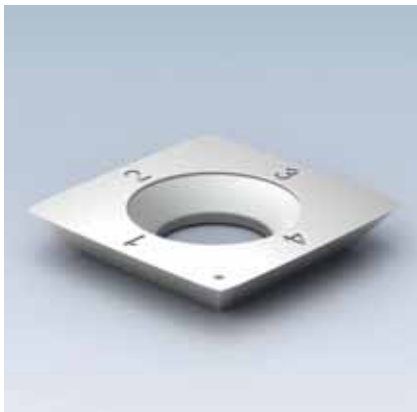
TM 435 0

SB	H	DIK	QAL	VE	ID	ID
mm	mm	mm		PCS	left	right
14.3	14.3	2.5	HW	10	602525 ●	602526 ●
14	14	2	HW-10F	10	602527 ●	602528 ●

ID = 1 piece.

Workpiece material:
Softwood and hardwood

Cutting material:
HW / HW fine grain quality



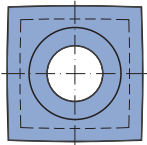
Turnblade knives for cutterhead system HeliCut

HW / TDC

TM 135 0, TM 405 0, TM 435 0

BEM	SB	H	DIK	QAL	VE	ID
	mm	mm	mm		PCS	
HeliCut 15	15	15	2.5	HW	10	009549 ●
HeliCut 15	15	15	2.5	HW-MF	10	009543 ●
HeliCut 15	15	15	2.5	TDC		602900 ●
HeliCut 11 (peripheral tip)	11	11	1.5	HW	10	602515 ●
HeliCut 11 (peripheral tip)	11	11	1.5	TDC		602904 ●
HeliCut 11 (plunging tip D30)	20.6	12.7	2	HW	10	602531 ●
HeliCut 11 (plunging tip D40)	22	12.7	2	HW	10	602516 ●

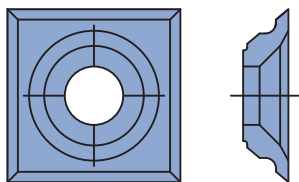
ID = 1 piece.



HW turnblade knife

Workpiece material:
Softwood and hardwood

Cutting material:
HW / TDC



Turnblade knife with 4 cutting edges

Knife height 21 mm with 4 cutting edges

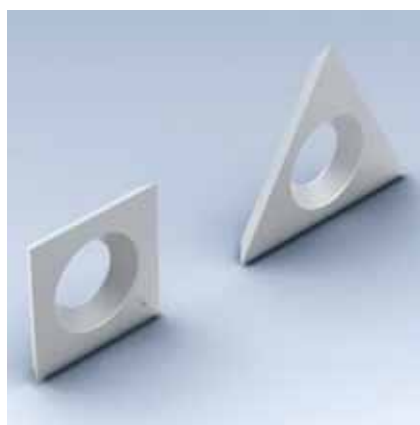
HW

TM 410 0

SB	H	DIK	QAL	ID
mm	mm	mm		
21	21	5.5	HW	009527 ●

Workpiece material:
Softwood and hardwood

Cutting material:
HW



Spurs

HW / DP

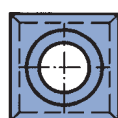
TM 405 0, TM 480 0

SB mm	H mm	DIK mm	KBZ	QAL	VE PCS	ID
14	14	2	VS 1	HW-F	10	005099 ●
14	14	1.2	VS 4	HW	10	005130 ●
14	14	1.2	Holz-Her	HW	10	602500 ●
15	15	2		HW		005100 ●
19		2	VS 2	HW-F	10	005115 ●
19		2	VS 2R*	HW-F	10	006615 ●
19		2	VS 2L*	HW-F	10	006616 ●
19		2	VS 2	DP*	2	006607 ●
19		2	VS 3R	HW-F		005116 ●
19		2	VS 3L	HW-F		005159 ●

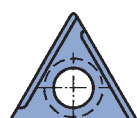
* = Spurs with reduced slotting depth. Knives can be used alternatively in VS2 knife seating.

DP* = diamond coated.

ID = 1 piece.



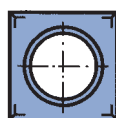
VS 1



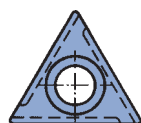
VS 3L



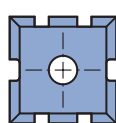
VS 2



VS 4



VS 3R



ID 005100

Workpiece material:

Solid wood, wood derived materials

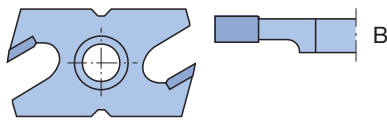
Cutting material:

HW fine grain quality / DP*

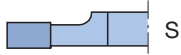
8. Knives and spare parts

8.1 Knives and blank knives

8.1.3 Grooving knives / profile grooving knives



Grooving knife Grooving knife image



Grooving knife mirror image

Workpiece material:
Softwood and hardwood

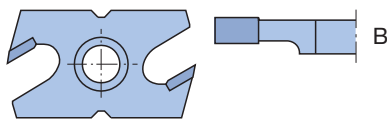
Cutting material:
HW fine grain quality

Grooving knives

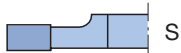
Mechanical feed

TM 460 0

SB mm	KBZ	QAL	ID
3	NA 3B	HW-F	008315 ●
3	NA 3S	HW-F	008316 ●
3	NAK 3B*	HW-F	616002 ●
3	NAK 3S*	HW-F	616003 ●
4,5	NA 4,5	HW-F	008333 ●
4	NA 4	HW-F	008317 ●
5	NA 5	HW-F	008318 ●
7	NA 7	HW-F	008319 ●
8	NAN 8	HW-F	008349 ●
9	NA 9	HW-F	008320 ●



Grooving knife Grooving knife image



Grooving knife mirror image

Workpiece material:
Softwood and hardwood

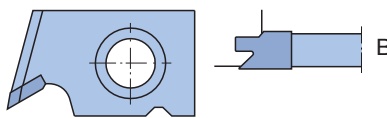
Cutting material:
HW fine grain quality

Manual feed

TM 460 1

SB mm	KBZ	QAL	ID
3	NB 3B	HW-F	008321 ●
3	NB 3S	HW-F	008322 ●
3	NBK 3B*	HW-F	616000 ●
3	NBK 3S*	HW-F	616001 ●
4	NB 4	HW-F	008323 ●
5	NB 5	HW-F	008324 ●
7	NB 7	HW-F	008325 ●
8	NBN 8	HW-F	008348 ●
9	NB 9	HW-F	008326 ●

* Grooving knife with reduced grooving depth.



Profile grooving knife Profile grooving knife image



Profile grooving knife mirror image

Workpiece material:
Softwood and hardwood

Cutting material:
HW fine grain quality

Profile grooving knives

For sealing strip

TM 160 0

SB mm	KBZ	QAL	ID
8	NC 1B	HW-F	008327 ●
8	NC 1S	HW-F	008328 ●



Lamello turnblade knives

Cutting material:

HW

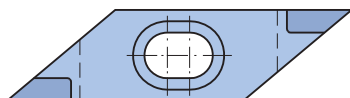
Lamello turnblade knives

HW

TM 463 0

SB mm	H mm	DIK mm	KBZ	QAL	VE PCS	ID
18	18	1.95	WP 18/1,95	HW	10	005114 ●
18	18	2.5	WP 18/2,5	HW	10	005195 ●

ID = 1 piece



Rhomboid turnblade knives

Cutting material:

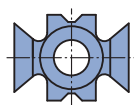
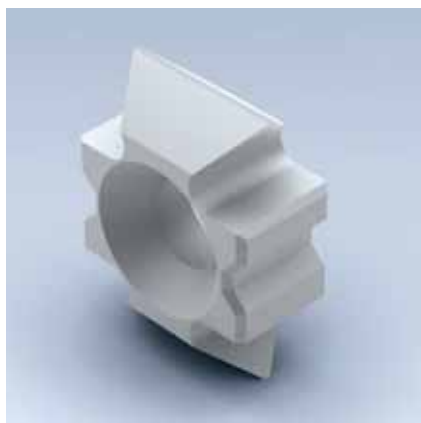
HW fine grain quality

Rhomboid turnblade knives

HW-F

TM 461 0

L mm	H mm	SB mm	KBZ	QAL	ID
45.416	12	5.6	RMA 5,6	HW-F	008329 ●
45.416	12	6.6	RMA 6,6	HW-F	008330 ●



Workpiece material:
Softwood and hardwood

Cutting material:
HW fine grain quality

Mechanical feed

HW-F

TM 462 0

SB mm	H mm	DIK mm	KBZ	QAL	ID
20	15	8	KM 11/0 45°	HW-F	008268 ●
20	15	7	KM 12/4 R1,5	HW-F	008272 ●
20	15	7.3	KM 12/3 R2	HW-F	008307 ●
22.3	15	9	KM 12/0 R3	HW-F	008270 ●
22	15	9	KM 15/0 R3	HW-F	008275 ●
20	15	9	KM 12/1 R3	HW-F	008271 ●
17.5	15	8	KM 11/1 60°	HW-F	008269 ●
18.3	15	7.3	KM 12/3F R2F	HW-F	008308 ●
22.3	15	10	KM 12/5 R3F	HW-F	008273 ●
22.3	15	7.3	KM 13/0 N5	HW-F	008274 ●
22.3	15	9	KM 13/1 N7	HW-F	008287 ●
22.3	15	7.3	KM 16/0	HW-F	008286 ●
22.3	15	7.3	KM 14/0 R5	HW-F	008347 ●

KM 11/0



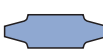
KM 12/5



KM 11/1



KM 13/0



KM 12/0



KM 13/1



KM 12/1



KM 14/0



KM 12/3



KM 15/0



KM 12/3F

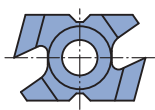
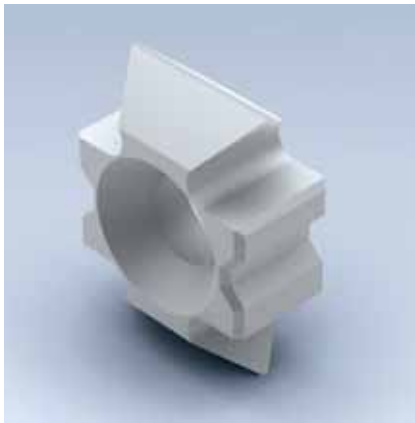


KM 16/0



KM 12/4





Workpiece material:
Softwood and hardwood

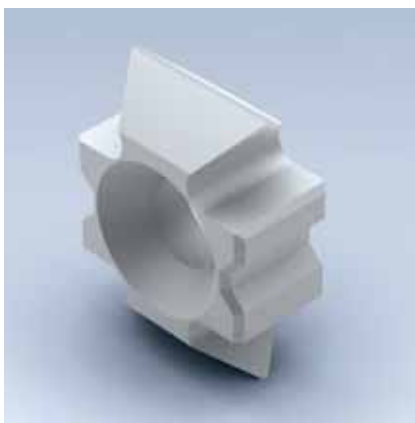
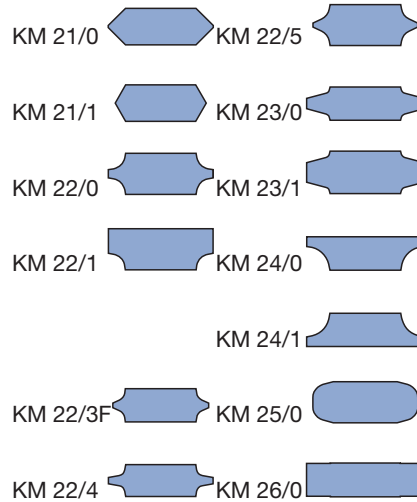
Cutting material:
HW fine grain quality

Manual feed

HW-F

TM 462 1

SB mm	H mm	DIK mm	KBZ	QAL	ID
23	15	7.3	KM 22/3 R2	HW-F	008309 ●
23	15	8	KM 21/0 45°	HW-F	008292 ●
23	15	9	KM 22/1 R3	HW-F	008290 ●
25.7	15	7.3	KM 24/0 R5	HW-F	008305 ●
23	15	7	KM 22/4 R1,5	HW-F	008295 ●
23	15	9	KM 25/0 R3	HW-F	008291 ●
25.7	15	9.3	KM 23/1 N7	HW-F	008298 ●
25.7	15	7.3	KM 24/1 R5	HW-F	008306 ●
23	15	9	KM 22/0 R3	HW-F	008293 ●
20.5	15	8	KM 21/1 60°	HW-F	008294 ●
21	15	7.3	KM 22/3F R2F	HW-F	008310 ●
23	15	9	KM 22/5 R3F	HW-F	008296 ●
25.7	15	7.3	KM 23/0 N5	HW-F	008297 ●
25.7	15	7.3	KM 26/0	HW-F	008299 ●



Workpiece material:
Softwood and hardwood

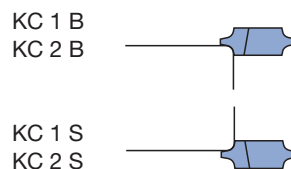
Cutting material:
HW fine grain quality

With shear angle

HW-F

TM 462 0

SB mm	H mm	DIK mm	KBZ	QAL	ID
20	15	8.3	KC 1B (R2)	HW-F	008334 ●
20	15	10	KC 2B (R3)	HW-F	008335 ●
20	15	8.3	KC 1S (R2)	HW-F	008336 ●
20	15	10	KC 2S (R3)	HW-F	008337 ●





Cutting material recommendation	HS Classic / Premium	MC33	HW
Solid wood dry	◆	◆	◇
Solid wood wet	◇	◆	
Hardwood dry	◇		◆
Hardwood wet	◇	◆	
Glulam		◇	◇
Thermoplastics (PE, PP, PVC, etc.)	◆	◆	◇
WPC			
(Wood-Plastic-Composite)	◇	◆	◇

◆ suitable ◇ partly suitable



Cross section of planer knife (HS Classic / HS Premium / MC33)



Cross section of planer knife (HW)

Cutting material:

HS Classic / HS Premium / MC33 / HW

Wedge angle:

40° (HS Classic / HS Premium / MC33)

45° (HW)

Knife height 30 mm

For planerhead wedge-type system WM 200 2 05

TM 100 0, TM 100 0 03, TM 100 0 05

SB	H	DIK	VE	ID	ID	ID	ID
mm	mm	mm	PCS	HS Classic	HS Premium	MC33	HW
60	30	3	2	605000	027101 ●	606700 ●	027277 ●
80	30	3	2	605001	027102 ●	606701 ●	027278 ●
100	30	3	2	605002 ●	027103 ●	606702 ●	027279 ●
110	30	3	2	605003	027104 ●	606703 ●	027280 ●
120	30	3	2	605004	027105 ●	606704 ●	027281 ●
130	30	3	2	605005 ●	027106 ●	606705 ●	027282 ●
150	30	3	2	605006 ●	027107 ●	606706 ●	027283 ●
160	30	3	2	605045 ●	027163 ●	606745 ●	
170	30	3	2	605007 ●	027108 ●	606707 ●	027284 ●
180	30	3	2	605008 ●	027109 ●	606708 ●	027285 ●
190	30	3	2	605009	027144 ●	606709 ●	027322 ●
210	30	3	2	605010	027110 ●	606710 ●	027286 ●
230	30	3	2	605011 ●	027111 ●	606711 ●	027287 ●
240	30	3	2	605012 ●	027134 ●	606712 ●	027323 ●
250	30	3	2	605013	027161 ●	606713 ●	
260	30	3	2	605014 ●	027112 ●	606714 ●	027288 ●
270	30	3	2	605015	027162 ●	606715 ●	
310	30	3	2	605016 ●	027113 ●	606716 ●	027289 ●
320	30	3	2	605046	027164 ●	606746 ●	
360	30	3	2	605029	027114 ●	606729 ●	027292 ●
400	30	3	2	605030	027115 ●	606730 ●	
410	30	3	2	605031 ●	027116 ●	606731 ●	027293 ●
460	30	3	2	605032	027130 ●	606732 □	027295 ●
500	30	3	2	605033	027117 ●	606733 □	
510	30	3	2	605034 ●	027118 ●	606734 □	027296 ●
600	30	3	2	605035	027119 ●	606735 □	
610	30	3	2	605036 ●	027120 ●	606736 □	027297 ●
630	30	3	2	605037	027125 ●	606737 □	027298 ●
640	30	3	2	605038 ●	027121 ●	606738 □	027299 ●
710	30	3	2	605039	027122 ●	606739 □	027300 ●
810	30	3	2	605040 ●	027123 ●	606740 □	027302 ●

ID = 1 piece.

Knife height 35 mm

For long planerheads wedge-type system

TM 100 0, TM 100 0 03, TM 100 0 05

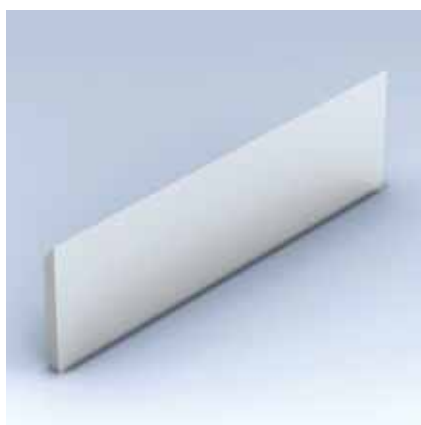
SB	H	DIK	VE	ID	ID	ID	ID
mm	mm	mm	PCS	HS Classic	HS Premium	MC33	HW
60	35	3	2	605119	027387 ●	606819 ●	
100	35	3	2	605120	027388 ●	606820 ●	
160	35	3	2	605121	027389 ●	606821 ●	
230	35	3	2	605122	027390 ●	606822 ●	
310	35	3	2	605100	027351 ●	606800 ●	027303 ●
320	35	3	2	605101	027352 ●	606801 ●	027304 □
330	35	3	2	605102	027353 ●	606802 ●	027305 □
360	35	3	2	605103	027354 ●	606803 ●	027306 □
400	35	3	2	605104	027355 ●	606804 ●	027307 □
410	35	3	2	605105 ●	027356 ●	606805 ●	027308 ●
450	35	3	2	605106	027357 ●	606806 □	027309 □
460	35	3	2	605107	027358 ●	606807 □	027310 □
500	35	3	2	605108 ●	027359 ●	606808 □	027311 □
510	35	3	2	605109 ●	027360 ●	606809 □	027312 ●
600	35	3	2	605110	027361 ●	606810 □	027313 □
610	35	3	2	605111 ●	027362 ●	606811 □	027314 □
630	35	3	2	605112	027363 ●	606812 □	027315 ●
635	35	3	2	605113	027364 ●	606813 □	027316 ●
640	35	3	2	605114 ●	027365 ●	606814 □	027317 ●
660	35	3	2		027371 ●		
700	35	3	2	605115	027366 ●	606815 □	027318 □
710	35	3	2	605116	027367 ●	606816 □	027319 □
740	35	3	2	605117	027368 ●	606817 □	027320 □
810	35	3	2	605118 ●	027369 ●	606818 □	027321 ●

ID = 1 piece.

● available ex stock

□ available at short notice

Instruction manual visit www.leitz.org



Knives for cassette system

Planer knives 30 mm with threaded bore

TM 105 0

SB mm	H mm	DIK mm	VE PCS	ID HS	ID HW
130	30	3	2	006825 ●	006915 ●
150	30	3	2	006928 ●	006931 ●
180	30	3	2	006826 ●	006916 ●
190	30	3	2	006929 ●	
230	30	3	2	006827 ●	006917 ●
240	30	3	2	006926 ●	

ID = 1 piece.

Cutting material recommendation	HS	HW
Solid wood dry	◆	
Solid wood wet	◇	
Hardwood dry		◆
Hardwood wet		◆
Glulam		◆
Chipboard		◇
MDF		◇
Thermoplastics (PE, PP, PVC, etc.)		◇
WPC		
(Wood-Plastic-Composite)		◇

◆ suitable ◇ partly suitable



Cross section of planer knife
(HS Classic / HS Premium / MC33)



Cross section of planer knife (HW)

Cutting material:

HS / HW



Planer knives with 60° back serration

For planerhead with 60° back serrated knife fixture

AT 103 0 29

SB mm	H mm	DIK mm	SET PCS	QAL	ID
150	30	5	2	MC33	697359 □
230	30	5	2	MC33	697360 □
310	30	5	2	MC33	697361 □
320	30	5	2	MC33	697362 □
330	30	5	2	MC33	697363 □
40	40	5	2	MC33	697300 ●
60	40	5	2	MC33	697301 ●
80	40	5	2	MC33	697302 ●
100	40	5	2	MC33	697303 ●
130	40	5	2	MC33	697304 ●
150	40	5	2	MC33	697305 ●
170	40	5	2	MC33	697306 ●
180	40	5	2	MC33	697307 ●
190	40	5	2	MC33	697308 ●
210	40	5	2	MC33	697309 ●
230	40	5	2	MC33	697310 ●
240	40	5	2	MC33	697311 ●
270	40	5	2	MC33	697312 ●
310	40	5	2	MC33	697313 ●

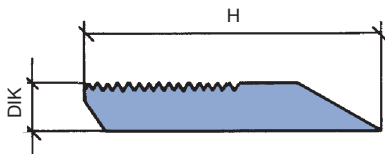
Set of the same weight.

Attention:

Please do not mix new MC33 blank knives with previous MC blank knives in one cutterhead due to weight difference.

Cutting material recommendation	MC 33
Solid wood dry	◆
Solid wood wet	◆
Hardwood dry	◆
Hardwood wet	◆
Glulam	◇
Chipboard	
MDF	
Thermoplastics (PE, PP, PVC, etc.)	◆
WPC (Wood-Plastic-Composite)	◆

◆ suitable ◇ partly suitable

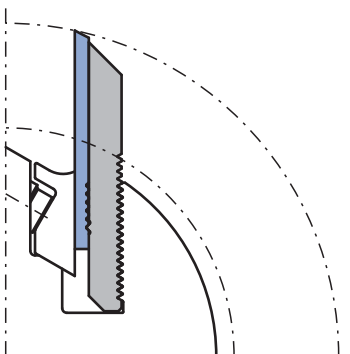
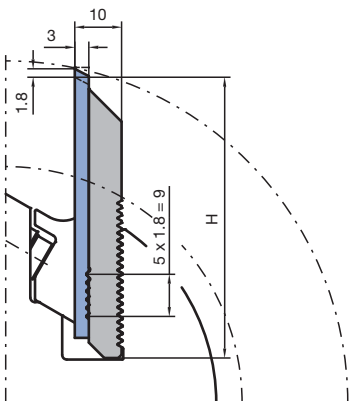


Cutting material:
MC33



Cutting material recommendation	HW-30F jointable	HW-10F not jointable
Solid wood dry	◆	
Solid wood wet		
Hardwood dry	◆	◆
Hardwood wet		◇
Glulam	◇	◆
Chipboard		◆
MDF	◆	◆
Thermoplastics (PE, PP, PVC, etc.)	◆	◆
WPC (Wood-Plastic-Composite)	◆	◆

◆ suitable ◇ partly suitable



Planer knives Powerknife System PKS®

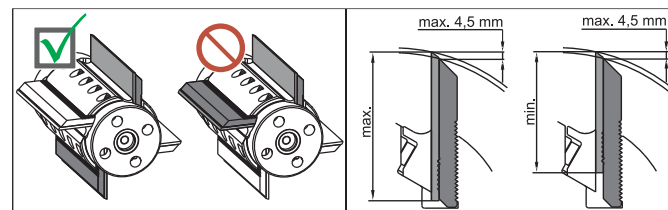
For planerhead with 60° back serrated knife fixture

AT 103 0 26, AT 107 0 26

SB mm	H mm	DIK mm	SET PCS	QAL	ID Blank knife set	ID Blank knife set with backing plate
40	40	10	2	HW-30F	696614 □	697814 □
60	40	10	2	HW-30F	696615 □	697815 □
80	40	10	2	HW-30F	696616 □	697816 □
100	40	10	2	HW-30F	696617 □	697817 □
130	40	10	2	HW-30F	696618 □	697818 □
150	40	10	2	HW-30F	696619 ●	697819 ●
170	40	10	2	HW-30F	696620 ●	697820 ●
180	40	10	2	HW-30F	696621 □	697821 □
190	40	10	2	HW-30F	696622 □	697822 □
210	40	10	2	HW-30F	696623 ●	697823 ●
230	40	10	2	HW-30F	696624 □	697824 □
240	40	10	2	HW-30F	696625 ●	697825 ●
270	40	10	2	HW-30F	696626 □	697826 □
310	40	10	2	HW-30F	696627 ●	697827 ●
40	40	10	2	HW-10F	696600 □	697800 □
60	40	10	2	HW-10F	696601 □	697801 □
80	40	10	2	HW-10F	696602 □	697802 □
100	40	10	2	HW-10F	696603 □	697803 □
130	40	10	2	HW-10F	696604 □	697804 □
150	40	10	2	HW-10F	696605 ●	697805 ●
170	40	10	2	HW-10F	696606 ●	697806 ●
180	40	10	2	HW-10F	696607 □	697807 □
190	40	10	2	HW-10F	696608 □	697808 □
210	40	10	2	HW-10F	696609 ●	697809 ●
230	40	10	2	HW-10F	696610 □	697810 □
240	40	10	2	HW-10F	696611 ●	697811 ●
270	40	10	2	HW-10F	696612 □	697812 □
310	40	10	2	HW-10F	696613 ●	697813 ●

- Blank knives with polished cutting face for high cutting edge quality.
- Solid tungsten carbide - profile knives, adjustable (1.80 mm steps).
- Knives supported by profiled backing plates.
- Resharpener area 10.8 mm at maximum profile depth.

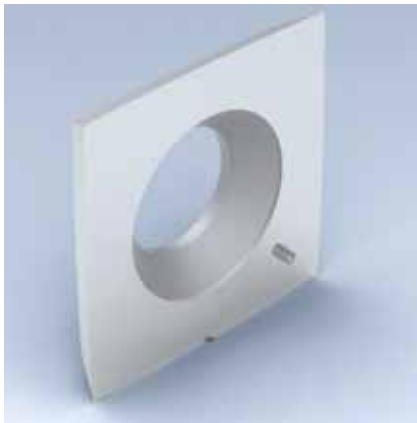
Set of the same weight.



Cutting material:
HW-30F / HW-10F

Attention:

Maximum knife protrusion above the backing plate 4.5 mm. For safety reasons, only mount knives and backing plates of same weight in opposite seatings.



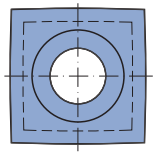
Turnblade planing knives HeliPlan

For cutterhead system HeliPlan

TM 405 0

BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	15x15x2.5	HW	10	009535 •
Turnblade knife	15x15x2.5	TDC		602901 •

ID = 1 piece.



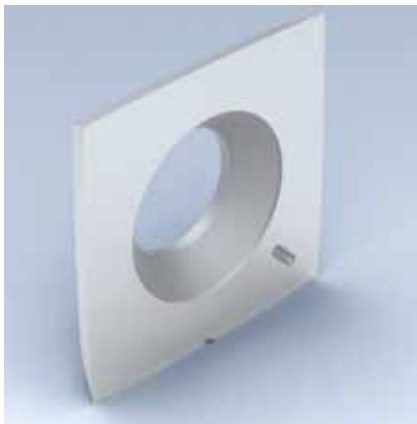
HW turnblade knife

Workpiece material:

Softwood and hardwood

Cutting material:

HW / TDC



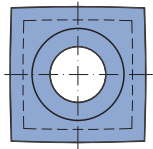
Turnblade planing knives CASTOR

For cutterhead system CASTOR-Finish

TM 405 0

BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	15x15x2.5	HW	10	009540 •

ID = 1 piece.



HW turnblade knife

Workpiece material:

Softwood and hardwood

Cutting material:

HW



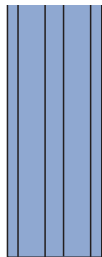
Turnblade planing knives CentroStar, CentroFix, QuickFix

For cutterhead system CentroStar, CentroFix, QuickFix - HS

AT 103 0 02, AT 103 0 20

Cutting material recommendation	HS	MC	HW
Solid wood dry	◆	◆	
Solid wood wet	◇	◆	
Hardwood dry		◇	◆
Hardwood wet		◆	◆
Glulam		◆	◆
Clipboard			◇
MDF			◇

◆ suitable ◇ partly suitable



Turnblade knife CentroFix

Cutting material:

HS

SB	H	DIK	SET	QAL	ID
mm	mm	mm	PCS		
100	12	2.7	4	HS	610203 ●
120	12	2.7	4	HS	610204 ●
124.6	12	2.7	4	HS	610244 ●
130	12	2.7	4	HS	610205 ●
136	12	2.7	4	HS	610206 ●
150	12	2.7	4	HS	610208 ●
166	12	2.7	4	HS	610286 ●
170	12	2.7	4	HS	610210 ●
180	12	2.7	4	HS	610211 ●
186	12	2.7	3	HS	610247 ●
190	12	2.7	4	HS	610212 ●
210	12	2.7	4	HS	610213 ●
230	12	2.7	4	HS	610214 ●
236	12	2.7	4	HS	610287 ●
240	12	2.7	4	HS	610215 ●
260	12	2.7	4	HS	610017 ●
310	12	2.7	4	HS	610018 ●
400	12	2.7	4	HS	610022 ●
410	12	2.7	4	HS	610023 ●
410	12	2.7	3	HS	610043 ●
420	12	2.7	4	HS	610024 ●
430	12	2.7	4	HS	610025 ●
500	12	2.7	4	HS	610028 ●
510	12	2.7	4	HS	610029 ●
520	12	2.7	4	HS	610030 ●
530	12	2.7	4	HS	610031 ●
540	12	2.7	4	HS	610032 ●
610	12	2.7	4	HS	610034 ●
630	12	2.7	4	HS	610036 ●
640	12	2.7	4	HS	610038 ●
710	12	2.7	4	HS	610040 ●
810	12	2.7	4	HS	610042 ●

8. Knives and spare parts

8.1 Knives and blank knives

8.1.5 Planer knives



For cutterhead system CentroStar, CentroFix, QuickFix - MC
AT 103 0 20

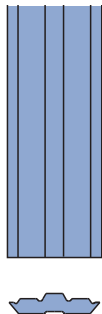
SB mm	H mm	DIK mm	SET PCS	QAL	ID
100	12	2.7	4	MC	610278 ●
120	12	2.7	4	MC	610279
130	12	2.7	4	MC	610280 ●
150	12	2.7	4	MC	610281
180	12	2.7	4	MC	610282 ●
230	12	2.7	4	MC	610283 ●
240	12	2.7	4	MC	610284 ●
310	12	2.7	4	MC	610285

Cutting material recommendation	HS	MC	HW
Solid wood dry	◆	◆	
Solid wood wet	◇	◆	
Hardwood dry		◇	◆
Hardwood wet		◆	◆
Glulam		◆	◆
Clipboard			◇
MDF			◇

◆ suitable ◇ partly suitable

Cutting material:

MC



Turnblade knife CentroFix

Cutting material:

HW-F

For cutterhead system CentroStar, CentroFix, QuickFix - HW-F

AT 103 0 20, TM 410 0 02

SB mm	H mm	DIK mm	SET PCS	QAL	ID
100	12	2.7	2	HW-F	610606 ●
120	12	2.7	2	HW-F	610610 ●
130	12	2.7	2	HW-F	610612 ●
136	12	2.7	2	HW-F	610614 ●
150	12	2.7	2	HW-F	610616 ●
166	12	2.7	2	HW-F	610680 ●
170	12	2.7	2	HW-F	610620 ●
180	12	2.7	2	HW-F	610621 ●
190	12	2.7	2	HW-F	610625 ●
210	12	2.7	2	HW-F	610627 ●
230	12	2.7	2	HW-F	610629 ●
236	12	2.7	2	HW-F	610679 ●
240	12	2.7	2	HW-F	610631 ●
400	12	2.7	1	HW-F	612016 ●
410	12	2.7	1	HW-F	612017 ●
420	12	2.7	1	HW-F	612018 ●
430	12	2.7	1	HW-F	612019 ●
500	12	2.7	1	HW-F	612022 ●
510	12	2.7	1	HW-F	612023 ●
520	12	2.7	1	HW-F	612024 ●
530	12	2.7	1	HW-F	612025 ●
540	12	2.7	1	HW-F	612026 ●

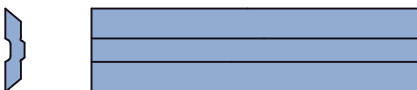


Cutting material recommendation	HS	HW
Solid wood dry	◆	
Solid wood wet	◇	
Hardwood dry		◆
Hardwood wet		◆
Glulam		◆
Clipboard		◇
MDF		◇

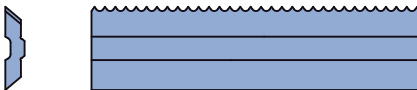
◆ suitable ◇ partly suitable

Cutting material:
HS / HW

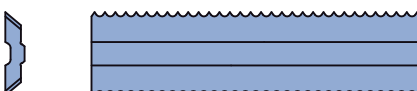
Cutting material:
HW



Turnblade knife VariPlan HS / HW
resharpenable, for finish cutting of
softwood and hardwood



Turnblade knife VariPlan HW Integral
resharpenable, for pre and finish cutting
softwood and hardwood



Turnblade knife VariPlan HW RipTec
resharpenable, for pre-cutting softwood
and hardwood

Turnblade planing knives VariPlan / VariPlan Plus

For cutterhead system VariPlan / VariPlan Plus

AT 103 0 03, AT 103 0 27

SB mm	H mm	DIK mm	SET PCS	ID Type HS	ID Type HW Microfinish
50	16	3.7	2	610500 □	617100 □
60	16	3.7	2	610501 □	617101 □
80	16	3.7	2	610502 □	617102 □
100	16	3.7	2	610504 ●	617104 □
120	16	3.7	2	610505 ●	617105 □
130	16	3.7	2	610506 ●	617106 ●
150	16	3.7	2	610509 ●	617109 ●
166	16	3.7	2	610571 □	617171 ●
170	16	3.7	2	610511 ●	617111 ●
180	16	3.7	2	610512 ●	617112 ●
190	16	3.7	2	610514 ●	617114 ●
210	16	3.7	2	610515 ●	617115 ●
230	16	3.7	2	610516 ●	617116 ●
236	16	3.7	2	610569 □	617169 ●
240	16	3.7	2	610518 ●	617118 ●
270	16	3.7	2		617165 ●
310	16	3.7	2	610522 ●	617122 ●
330	16	3.7	2		617124 □
360	16	3.7	2		617125 □
400	16	3.7	2	610526 □	617126 □
410	16	3.7	2	610527 ●	617127 □
410	16	3.7	3	610528 □	
420	16	3.7	2	610529 □	617129 □
430	16	3.7	2	610530 □	617130 □
500	16	3.7	2	610533 ●	617133 □
510	16	3.7	4	610562 □	617162 □
520	16	3.7	4	610563 □	617163 □
530	16	3.7	2	610536 □	617136 □
540	16	3.7	2	610537 □	617137 □
600	16	3.7	2	610538 ●	617138 □
610	16	3.7	2	610539 □	617139 □
630	16	3.7	2	610541 ●	617141 □
640	16	3.7	4	610564 □	617164 □

For cutterhead system VariPlan Plus

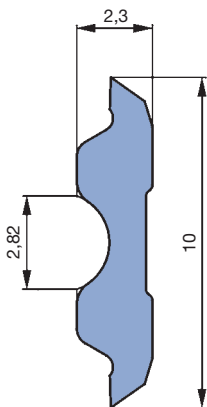
AT 103 0 23, AT 103 0 24

SB mm	H mm	DIK mm	SET PCS	ID Type HW Integral	ID Type HW RipTec
100	16	3.7	2	611904	611204 □
120	16	3.7	2	611905	611205 □
130	16	3.7	2	611906 ●	611206 ●
150	16	3.7	2	611909	611209 ●
170	16	3.7	2	611911 ●	611211 ●
180	16	3.7	2	611912 ●	611212 ●
190	16	3.7	2	611914	611214 ●
210	16	3.7	2	611915	611215 ●
230	16	3.7	2	611916	611216 ●
240	16	3.7	2	611918 ●	611218 ●
270	16	3.7	2	611965	611265 ●
310	16	3.7	2	611922	611222 ●



Cutting material recommendation	HS	HW
Solid wood dry	◆	
Solid wood wet	◇	
Hardwood dry		◆
Hardwood wet		◆
Glulam		◆
Clipboard		◇
MDF		◇

◆ suitable ◇ partly suitable



Turnblade knife MicroTec
Turnblade knife TriTec

Workpiece material:

Softwood and hardwood

Cutting material:

HS

Suitable for:

Long planerheads

on surface planers and thickness planing machines with centrifugal force clamping system (e.g. SCM, SAC, Panhans, Martin)

Cutterheads

with centrifugal force clamping system for 4-sided moulders (e.g. Weinig, SCM, Leadermac)

Turnblade planing knives TriTec

For cutterhead system Tersa, HS

AT 103 0 12

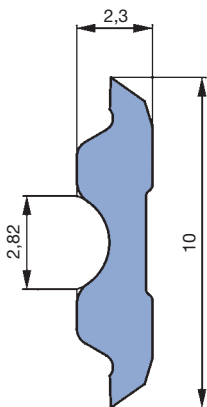
SB	H	DIK	QAL	SET	ID
mm	mm	mm		PCS	
60	10	2.3	HS	4	610900 □
80	10	2.3	HS	4	610901 □
100	10	2.3	HS	4	610902 ●
110	10	2.3	HS	4	610903 ●
120	10	2.3	HS	4	610904 ●
130	10	2.3	HS	4	610905 ●
140	10	2.3	HS	4	610906 ●
150	10	2.3	HS	4	610907 ●
170	10	2.3	HS	4	610908 ●
180	10	2.3	HS	4	610909 ●
190	10	2.3	HS	4	610910 ●
200	10	2.3	HS	4	610911 ●
210	10	2.3	HS	4	610912 ●
220	10	2.3	HS	4	610913 ●
230	10	2.3	HS	4	610914 ●
240	10	2.3	HS	4	610915 ●
250	10	2.3	HS	4	610916 ●
260	10	2.3	HS	4	610917 ●
265	10	2.3	HS	4	610918 ●
270	10	2.3	HS	4	610919 ●
300	10	2.3	HS	4	610920 ●
310	10	2.3	HS	4	610921 ●
350	10	2.3	HS	4	610922 ●
360	10	2.3	HS	4	610923 □
400	10	2.3	HS	4	610924 ●
410	10	2.3	HS	4	610925 ●
420	10	2.3	HS	4	610926 □
430	10	2.3	HS	4	610927 ●
450	10	2.3	HS	4	610928 □
460	10	2.3	HS	4	610929 □
500	10	2.3	HS	4	610930 ●
510	10	2.3	HS	4	610931 ●
520	10	2.3	HS	4	610932 ●
530	10	2.3	HS	4	610933 ●
600	10	2.3	HS	4	610934 □
610	10	2.3	HS	4	610935 ●
630	10	2.3	HS	4	610936 ●
640	10	2.3	HS	4	610937 ●
660	10	2.3	HS	4	610938 ●
710	10	2.3	HS	4	610939 ●
740	10	2.3	HS	4	610940 □
810	10	2.3	HS	4	610941 ●

Further dimensions on request.



Cutting material recommendation	HS	HW
Solid wood dry	◆	
Solid wood wet	◇	
Hardwood dry		◆
Hardwood wet		◆
Glulam		◆
Clipboard		◇
MDF		◇

◆ suitable ◇ partly suitable



Turnblade knife MicroTec
Turnblade knife TriTec

Cutting material:
HW

Note:
Knives longer than 540 mm are cut into pieces.

Suitable for:
Long planerheads
on surface planers and thickness planing machines with centrifugal force clamping system (e.g. SCM, SAC, Panhans, Martin)
Cutterheads
with centrifugal force clamping system for 4-sided moulders (e.g. Weinig, SCM, Leadermac)

Turnblade planing knives MicroTec

For cutterhead system Torsa, HW
AT 103 0 12

SB mm	H mm	DIK mm	QAL	SET PCS	ID
60	10	2.3	HW	2	610950 □
80	10	2.3	HW	2	610951 □
100	10	2.3	HW	2	610952 □
110	10	2.3	HW	2	610953 □
120	10	2.3	HW	2	610954 □
130	10	2.3	HW	2	610955 □
140	10	2.3	HW	2	610956 □
150	10	2.3	HW	2	610957 □
170	10	2.3	HW	2	610958 □
180	10	2.3	HW	2	610959 □
190	10	2.3	HW	2	610960 □
200	10	2.3	HW	2	610961 □
210	10	2.3	HW	2	610962 □
220	10	2.3	HW	2	610963 □
230	10	2.3	HW	2	610964 □
240	10	2.3	HW	2	610965 □
250	10	2.3	HW	2	610966 □
260	10	2.3	HW	2	610967 □
265	10	2.3	HW	2	610968 □
270	10	2.3	HW	2	610969 □
300	10	2.3	HW	2	610970 □
310	10	2.3	HW	2	610971 □
350	10	2.3	HW	2	610972 □
360	10	2.3	HW	2	610973 □
400	10	2.3	HW	2	610974 □
410	10	2.3	HW	2	610975 □
420	10	2.3	HW	2	610976 □
430	10	2.3	HW	2	610977 □
450	10	2.3	HW	2	610978 □
460	10	2.3	HW	2	610979 □
500	10	2.3	HW	2	610980 □
510	10	2.3	HW	2	610981 □
520	10	2.3	HW	2	610982 □
530	10	2.3	HW	2	610983 □

Further dimensions on request.



Turnblade planing knives Centrolock

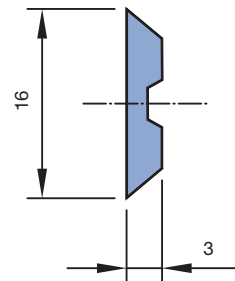
For cutterhead system Centrolock / Easylock

AT 103 0 13

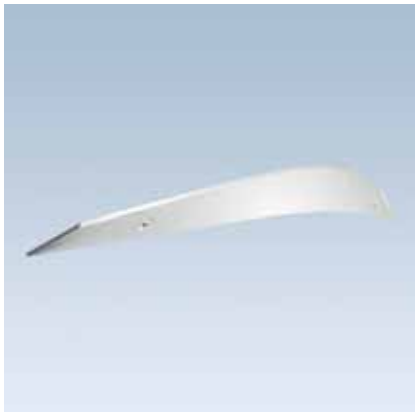
SB mm	H mm	DIK mm	SET PCS	ID HS	ID HW	ID MC
60	16	3	2	611801 ●	611861 ●	611831 ●
80	16	3	2	611802 ●	611862 ●	611832 ●
100	16	3	2	611803 ●	611863 ●	611833 ●
130	16	3	2	611804 ●	611864 ●	611834 ●
150	16	3	2	611805 ●	611865 ●	611835 ●
170	16	3	2	611806 ●	611866 ●	611836 ●
180	16	3	2	611807 ●	611867 ●	611837 ●
190	16	3	2	611808 ●	611868 ●	611838 ●
230	16	3	2	611809 ●	611869 ●	611839 ●
240	16	3	2	611810 ●	611870 ●	611840 ●
260	16	3	2	611811 ●	611871 ●	611841 ●
270	16	3	2	611812 ●	611872 ●	611842 ●
285	16	3	2	611817 ●	611877 ●	611847
310	16	3	2	611813 ●	611873 ●	611843 ●
460	16	3	2	611814 ●		

Cutting material recommendation	HS	MC	HW
Solid wood dry	◆	◆	
Solid wood wet	◇	◆	
Hardwood dry		◇	◆
Hardwood wet		◆	◆
Glulam		◆	◆
Clipboard			◇
MDF			◇

◆ suitable ◇ partly suitable



Cutting material:
HS / MC / HW



Spiral planer knife

Throwaway knife for spiral long planerhead

TM 101 0

BEZ	SB mm	QAL	ID
HS-Spiral knife, one-way	410	HS	006841 ●
HS-Spiral knife, one-way	420	HS	006910
HS-Spiral knife, one-way	510	HS	006842 ●
HS-Spiral knife, one-way	520	HS	006911 ●
HS-Spiral knife, one-way	610	HS	006843 ●
HS-Spiral knife, one-way	630	HS	006912 ●
HS-Spiral knife, one-way	640	HS	006844 ●

Resharpenable knife for spiral long planerhead

TM 106 0

BEZ	SB mm	QAL	ID
HS-Spiral knife, resharpenable	410	HS	006828 ●
HS-Spiral knife, resharpenable	420	HS	006907
HS-Spiral knife, resharpenable	510	HS	006829 ●
HS-Spiral knife, resharpenable	520	HS	006908
HS-Spiral knife, resharpenable	610	HS	006830 ●
HS-Spiral knife, resharpenable	630	HS	006909 ●
HS-Spiral knife, resharpenable	640	HS	006831 ●

Cutting material:
HS

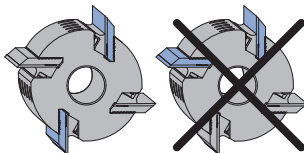
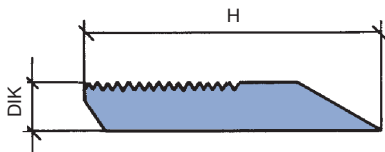


Cutting material recommendation	HS Classic / Premium	MC33	HW
Solid wood dry	◆	◆	◇
Solid wood wet	◇	◆	◆
Hardwood dry	◇	◆	◆
Hardwood wet	◇	◆	◆
Glulam		◇	◇
Thermoplastics (PE, PP, PVC, etc.)	◆	◆	◇
WPC (Wood-Plastic-Composite)	◇	◆	◇

◆ suitable ◇ partly suitable

H	PT
mm	mm
50	15
60	20
70	30

Table to determine maximum profile depth. The profile depth figures are to be regarded as standard values. The maximum profile depth depends on the tool diameter and cutting angle.



Attention:

For safety reasons, always mount knives of the same weight in opposite seatings

Cutting material:

HS / MC33

The Leitz MC33 cutting material replaces previous design in MC Marathon

Blank knives with 60° back serration

HS and MC33 blank knives, for profile and hydro profile cutterheads

AT 103 0 28, AT 103 0 29

SB	H	DIK	PT _{max}	SET	ID	ID
mm	mm	mm	mm	PCS	HS	MC33
40	50	8	15	2	697500 □	697314 ●
60	50	8	15	2	697501 □	697315 ●
80	50	8	15	2	697502 □	697316 ●
100	50	8	15	2	697503 □	697317 ●
130	50	8	15	2	697504 □	697318 ●
150	50	8	15	2	697505 □	697319 ●
170	50	8	15	2	697506 □	697320 ●
180	50	8	15	2	697507 □	697321 □
190	50	8	15	2	697508 □	697322 □
210	50	8	15	2	697509 □	697323 □
230	50	8	15	2	697510 □	697324 ●
240	50	8	15	2	697511 □	697325 ●
260	50	8	15	2	697512 □	697326 □
270	50	8	15	2	697513 □	697327 □
310	50	8	15	2	697514 □	697328 ●
40	60	8	20	2	697515 □	697329 ●
60	60	8	20	2	697516 □	697330 ●
80	60	8	20	2	697517 □	697331 ●
100	60	8	20	2	697518 □	697332 ●
130	60	8	20	2	697519 □	697333 ●
150	60	8	20	2	697520 □	697334 ●
170	60	8	20	2	697521 □	697335 ●
180	60	8	20	2	697522 □	697336 □
190	60	8	20	2	697523 □	697337 □
210	60	8	20	2	697524 □	697338 □
230	60	8	20	2	697525 □	697339 ●
240	60	8	20	2	697526 □	697340 ●
260	60	8	20	2	697527 □	697341 □
270	60	8	20	2	697528 □	697342 □
310	60	8	20	2	697529 □	697343 ●
40	70	8	30	2	697530 □	697344 ●
60	70	8	30	2	697531 □	697345 ●
80	70	8	30	2	697532 □	697346 ●
100	70	8	30	2	697533 □	697347 ●
130	70	8	30	2	697534 □	697348 ●
150	70	8	30	2	697535 □	697349 ●
170	70	8	30	2	697536 □	697350 ●
180	70	8	30	2	697537 □	697351 ●
190	70	8	30	2	697538 □	697352 □
210	70	8	30	2	697539 □	697353 □
230	70	8	30	2	697540 □	697354 □
240	70	8	30	2	697541 □	697355 ●
260	70	8	30	2	697542 □	697356 □
270	70	8	30	2	697543 □	697357 □
310	70	8	30	2	697544 □	697358 □

Set of the same weight.

Attention:

Please do not mix new MC33 blank knives with previous MC blank knives in one cutterhead due to weight difference.



Blank knives with 60° back serration

HS and MC33 blank knives for cutting to individual cutting width

TC 110 0, TC 110 0 03

SB	H	DIK	PT _{max}	ID	ID
mm	mm	mm	mm	HS	MC33
650	38.1	8	5	635003 □	635206 □
650	45	8	10	635004 □	635207 □
650	50	8	15	635000 ●	635203 □
650	60	8	20	635001 ●	635204 □
650	70	8	30	635002 ●	635205 □

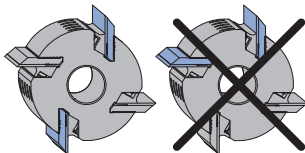
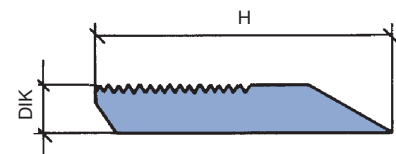
ID = 1 piece.

Attention:

Please do not mix new MC33 blank knives with previous MC blank knives in one cutterhead due to weight difference.

Cutting material recommendation	HS	MC 33
Solid wood dry	◆	◆
Solid wood wet	◇	◆
Hardwood dry	◇	◆
Hardwood wet	◇	◆
Glulam		◇
Thermoplastics (PE, PP, PVC, etc.)	◆	◆
WPC (Wood-Plastic-Composite)	◇	◆

◆ suitable ◇ partly suitable



Attention:

For safety reasons, always mount knives of the same weight in opposite seatings

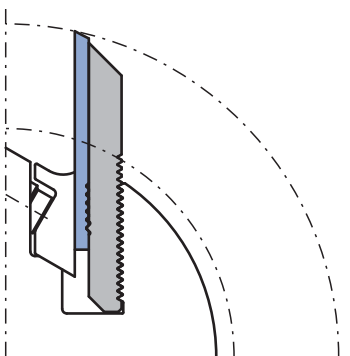
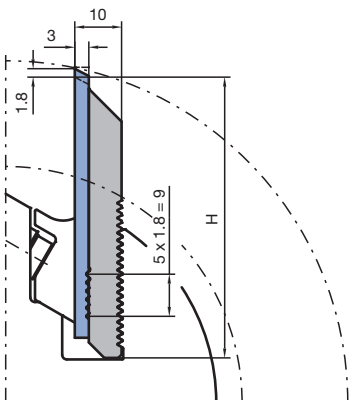
Cutting material:

HS / MC33



Cutting material recommendation	HW-30F jointable	HW-10F not jointable
Solid wood dry	◆	
Solid wood wet		
Hardwood dry	◆	◆
Hardwood wet		◇
Glulam	◇	◆
Chipboard		◆
MDF	◆	◆
Thermoplastics (PE, PP, PVC, etc.)	◆	◆
WPC (Wood-Plastic-Composite)	◆	◆

◆ suitable ◇ partly suitable



Blank knives / backing plates Powerknife System PKS®

For profile and hydro profile cutterheads, PT 15 mm

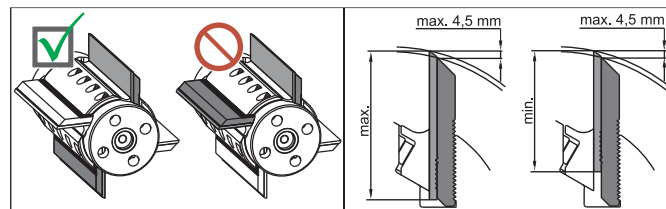
AT 103 0 26, AT 107 0 26

SB mm	H mm	DIK mm	PT _{max} mm	SET PCS	QAL	ID Blank knife set	ID Blank knife set with backing plate
40	50	10	15	2	HW-30F	696642 ●	697842 ●
60	50	10	15	2	HW-30F	696643 ●	697843 ●
80	50	10	15	2	HW-30F	696644 ●	697844 ●
100	50	10	15	2	HW-30F	696645 ●	697845 ●
130	50	10	15	2	HW-30F	696646 ●	697846 ●
150	50	10	15	2	HW-30F	696647 ●	697847 ●
170	50	10	15	2	HW-30F	696648 □	697848 □
180	50	10	15	2	HW-30F	696649 □	697849 □
190	50	10	15	2	HW-30F	696650 □	697850 □
210	50	10	15	2	HW-30F	696651 □	697851 □
230	50	10	15	2	HW-30F	696652 □	697852 □
240	50	10	15	2	HW-30F	696653 ●	697853 ●
270	50	10	15	2	HW-30F	696654 □	697854 □
310	50	10	15	2	HW-30F	696655 ●	697855 ●
40	50	10	15	2	HW-10F	696628 ●	697828 ●
60	50	10	15	2	HW-10F	696629 ●	697829 ●
80	50	10	15	2	HW-10F	696630 ●	697830 ●
100	50	10	15	2	HW-10F	696631 ●	697831 ●
130	50	10	15	2	HW-10F	696632 ●	697832 ●
150	50	10	15	2	HW-10F	696633 ●	697833 ●
170	50	10	15	2	HW-10F	696634 □	697834 □
180	50	10	15	2	HW-10F	696635 □	697835 □
190	50	10	15	2	HW-10F	696636 □	697836 □
210	50	10	15	2	HW-10F	696637 □	697837 □
230	50	10	15	2	HW-10F	696638 □	697838 □
240	50	10	15	2	HW-10F	696639 ●	697839 ●
270	50	10	15	2	HW-10F	696640 □	697840 □
310	50	10	15	2	HW-10F	696641 ●	697841 ●

The indicated profile depth values should be regarded as standard values for information. The maximum profile depth depends on the tool diameter and cutting angle.

Set of the same weight.

- Blank knives with polished cutting face for high cutting edge quality.
- Solid tungsten carbide - profile knives, adjustable (1.80 mm steps).
- Knives supported by profiled backing plates.
- Resharpener area 10.8 mm at maximum profile depth.



Cutting material:

HW-30F / HW-10F

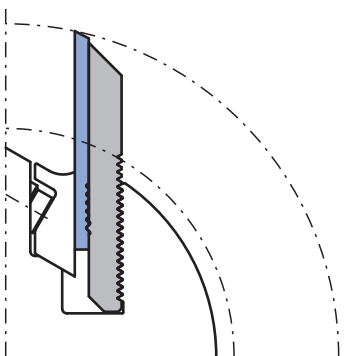
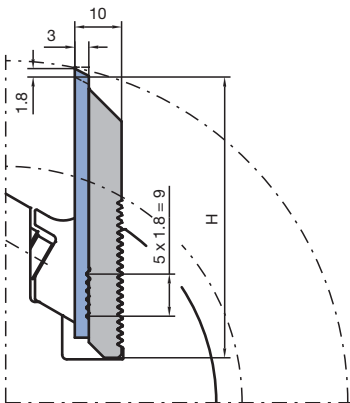
Attention:

Maximum knife protrusion above the backing plate 4.5 mm. For safety reasons, only mount knives and backing plates of same weight in opposite seatings.



Cutting material recommendation	HW-30F jointable	HW-10F not jointable
Solid wood dry	◆	
Solid wood wet		
Hardwood dry	◆	◆
Hardwood wet		◇
Glulam	◇	◆
Chipboard		◆
MDF	◆	◆
Thermoplastics (PE, PP, PVC, etc.)	◆	◆
WPC (Wood-Plastic-Composite)	◆	◆

◆ suitable ◇ partly suitable



Blank knives / backing plates Powerknife System PKS®

For profile and hydro profile cutterheads, PT 20 mm

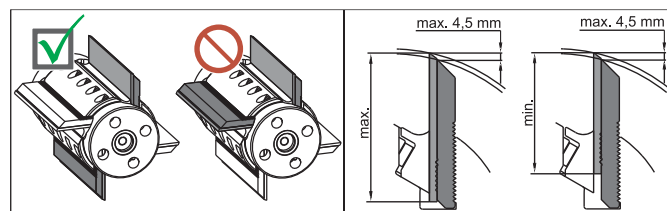
AT 103 0 26, AT 107 0 26

SB mm	H mm	DIK mm	PT _{max} mm	SET PCS	QAL	ID Blank knife set	ID Blank knife set with backing plate
40	60	10	20	2	HW-30F	696670 ●	697870 ●
60	60	10	20	2	HW-30F	696671 ●	697871 ●
80	60	10	20	2	HW-30F	696672 ●	697872 ●
100	60	10	20	2	HW-30F	696673 ●	697873 ●
130	60	10	20	2	HW-30F	696674 ●	697874 ●
150	60	10	20	2	HW-30F	696675 ●	697875 ●
170	60	10	20	2	HW-30F	696676 □	697876 □
180	60	10	20	2	HW-30F	696677 □	697877 □
190	60	10	20	2	HW-30F	696678 □	697878 □
210	60	10	20	2	HW-30F	696679 □	697879 □
230	60	10	20	2	HW-30F	696680 □	697880 □
240	60	10	20	2	HW-30F	696681 ●	697881 ●
40	60	10	20	2	HW-10F	696656 ●	697856 ●
60	60	10	20	2	HW-10F	696657 ●	697857 ●
80	60	10	20	2	HW-10F	696658 ●	697858 ●
100	60	10	20	2	HW-10F	696659 ●	697859 ●
130	60	10	20	2	HW-10F	696660 ●	697860 ●
150	60	10	20	2	HW-10F	696661 ●	697861 ●
170	60	10	20	2	HW-10F	696662 □	697862 □
180	60	10	20	2	HW-10F	696663 □	697863 □
190	60	10	20	2	HW-10F	696664 □	697864 □
210	60	10	20	2	HW-10F	696665 □	697865 □
230	60	10	20	2	HW-10F	696666 □	697866 □
240	60	10	20	2	HW-10F	696667 ●	697867 ●

The indicated profile depth values should be regarded as standard values for information. The maximum profile depth depends on the tool diameter and cutting angle.

Set of the same weight.

- Blank knives with polished cutting face for high cutting edge quality.
- Solid tungsten carbide - profile knives, adjustable (1.80 mm steps).
- Knives supported by profiled backing plates.
- Resharpener area 10.8 mm at maximum profile depth.



Cutting material:

HW-30F / HW-10F

Attention:

Maximum knife protrusion above the backing plate 4.5 mm. For safety reasons, only mount knives and backing plates of same weight in opposite seatings.

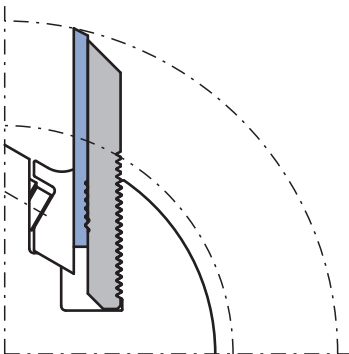
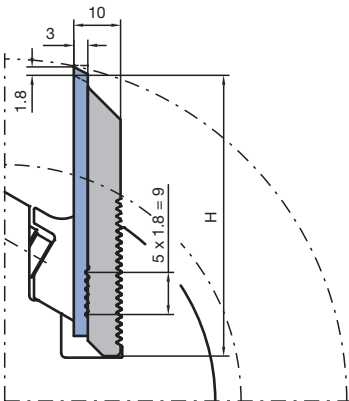
8. Knives and spare parts

8.1 Knives and blank knives

8.1.6 Blank knives

Cutting material recommendation	HW-30F jointable	HW-10F not jointable
Solid wood dry	◆	
Solid wood wet		
Hardwood dry	◆	◆
Hardwood wet		◇
Glulam	◇	◆
Chipboard		◆
MDF	◆	◆
Thermoplastics (PE, PP, PVC, etc.)	◆	◆
WPC (Wood-Plastic-Composite)	◆	◆

◆ suitable ◇ partly suitable



Cutting material:
HW-30F / HW-10F

Attention:

Maximum knife protrusion above the backing plate 4.5 mm. For safety reasons, only mount knives and backing plates of same weight in opposite seatings.

For profile and hydro profile cutterheads, PT 30 mm

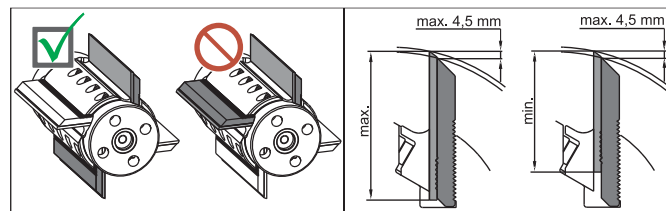
AT 103 0 26, AT 107 0 26

SB mm	H mm	DIK mm	PT _{max} mm	SET PCS	QAL	ID Blank knife set	ID Blank knife set with backing plate
40	70	10	30	2	HW-30F	696691 ●	697891 ●
60	70	10	30	2	HW-30F	696692 ●	697892 ●
80	70	10	30	2	HW-30F	696693 ●	697893 ●
100	70	10	30	2	HW-30F	696694 ●	697894 ●
130	70	10	30	2	HW-30F	696695 ●	697895 ●
150	70	10	30	2	HW-30F	696696 ●	697896 ●
40	70	10	30	2	HW-10F	696684 ●	697884 ●
60	70	10	30	2	HW-10F	696685 ●	697885 ●
80	70	10	30	2	HW-10F	696686 ●	697886 ●
100	70	10	30	2	HW-10F	696687 ●	697887 ●
130	70	10	30	2	HW-10F	696688 ●	697888 ●
150	70	10	30	2	HW-10F	696689 ●	697889 ●

The indicated profile depth values should be regarded as standard values for information. The maximum profile depth depends on the tool diameter and cutting angle.

Set of the same weight.

- Blank knives with polished cutting face for high cutting edge quality.
- Solid tungsten carbide - profile knives, adjustable (1.80 mm steps).
- Knives supported by profiled backing plates.
- Resharpener area 10.8 mm at maximum profile depth.



**Workpiece material:**

Softwood

Cutting material:

SP

For multi-purpose profile cutterheads:

WM 502 2

WM 510 1 01

WM 510 1 02

Profiles to scale 1:1 can be found on the
Leitz Homepage www.leitz.org**Profile knives for multi-purpose cutterheads****Knives**

TM 135 1

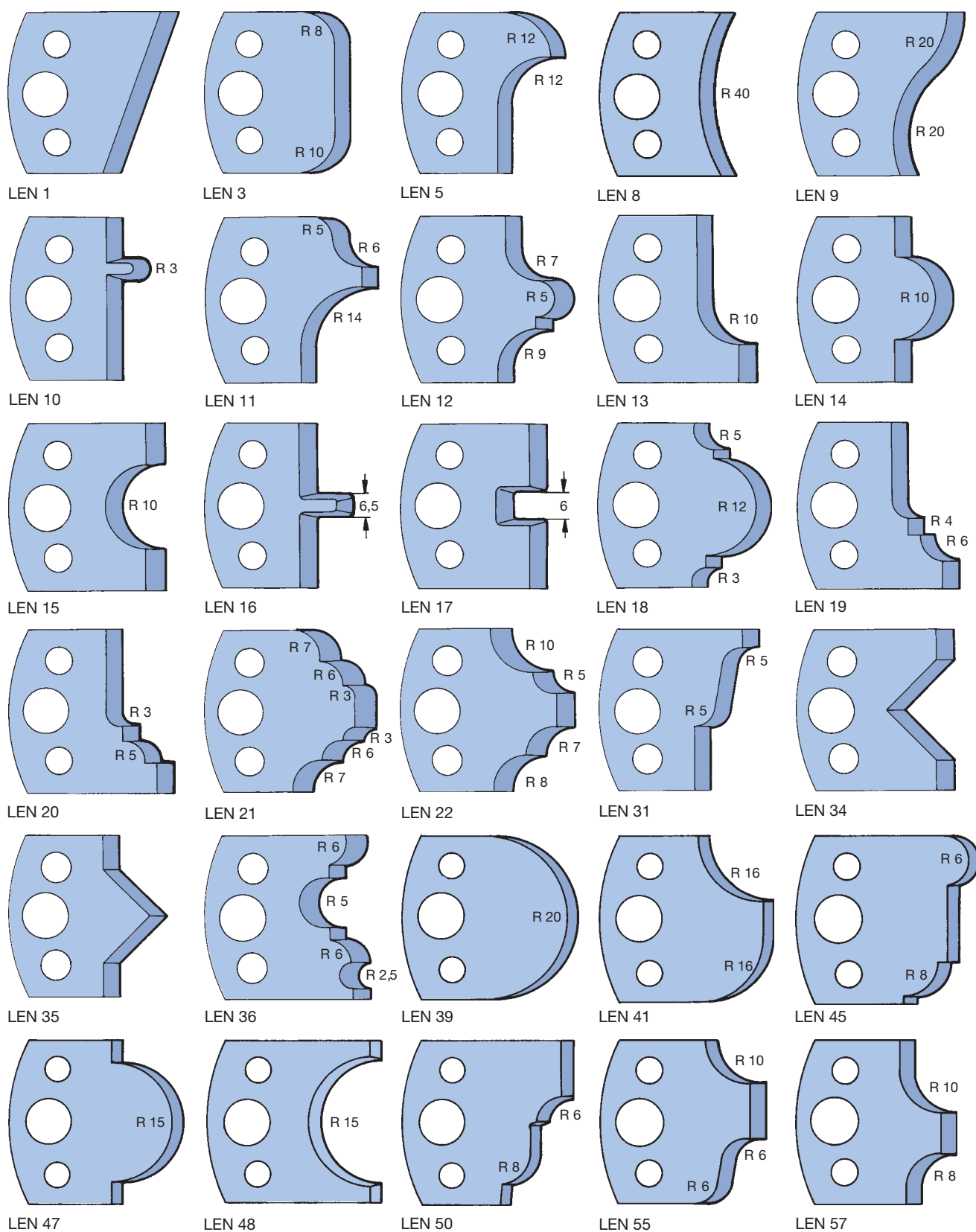
LEN-Profile	ID
1	026101 ●
3	026103 ●
5	026105 ●
8	026108 ●
9	026109 ●
10	026110 ●
11	026111 ●
12	026112 ●
13	026113 ●
14	026114 ●
15	026115 ●
16	026116 ●
17	026117 ●
18	026118 ●
19	026119 ●
20	026120 ●
21	026121 ●
22	026122 ●
31	026131 ●
34	026134 ●
35	026135 ●
36	026136 ●
39	026177 ●
41	026179 ●
45	026183 ●
47	026185 ●
48	026186 ●
50	026188 ●
55	026193 ●
57	026195 ●
58	026196 ●
66	026254 ●
68	026256 ●
75	026263 ●
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84	690001 ●
91	690003 ●
97	690005 ●
127	690007 ●

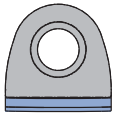
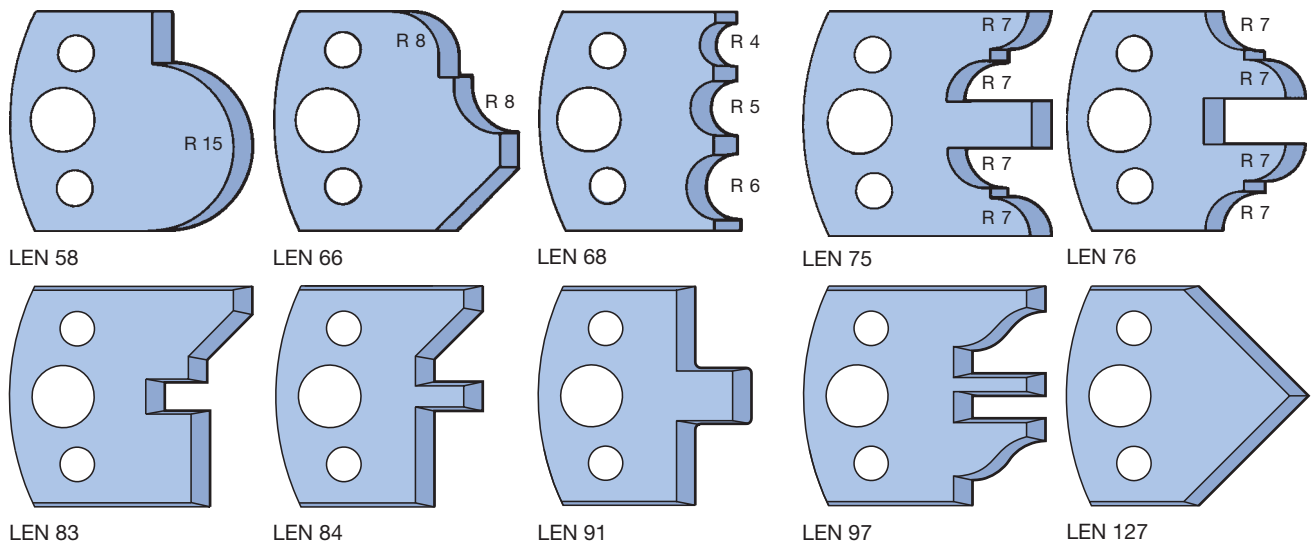
Limitors

TA 300 1

LEN-Profile	ID
1	026301 ●
3	026303 ●
5	026305 ●
8	026308 ●
9	026309 ●
10	026310 ●
11	026311 ●
12	026312 ●
13	026313 ●
14	026314 ●
15	026315 ●
16	026316 ●
17	026317 ●
18	026318 ●
19	026319 ●
20	026320 ●
21	026321 ●
22	026322 ●
31	026331 ●
34	026334 ●
35	026335 ●
36	026336 ●
39	026384 ●
41	026386 ●
45	026390 ●
47	026392 ●
48	026393 ●
50	026395 ●
55	026400 ●
57	026402 ●
58	026403 ●
66	026411 ●
68	026413 ●
75	026420 ●
76	026421 ●
83	695000 ●
84	695001 ●
91	695003 ●
97	695005 ●
127	695007 ●

Sold in pairs only.





WhisperCut DP-edges for hybrid tools

WhisperCut DP-edges; suitable for the combination with the tool systems
ProfilCut, ProFix, turnblade or HeliPlan

TM 160 0 02, TM 160 0 13

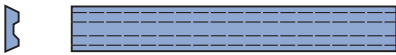
BEM	SB mm	R mm	FAW °	QAL	ID
Jointing	14			DP	091052 ●
Jointing of glued joint*	14			DP	091056 ●
Radius on bottom	14	1.0		DP	091057
Radius on top	14	1.0		DP	091058
Radius on bottom	14	1.5		DP	091059
Radius on top	14	1.5		DP	091060
Radius on bottom	14	2.0		DP	091061
Radius on top	14	2.0		DP	091062
Bevel on bottom	14		45	DP	091063
Bevel on top	14		45	DP	091064

* = If the knife mounted has a 0° cutting area bevel, it can be used **preferably for glued joints** due to the crown.

8. Knives and spare parts

8.1 Knives and blank knives

8.1.8 For portable planers and semi-stationary machines



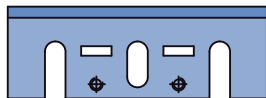
Turnblade knife

Workpiece material:

Softwood and hardwood, chipboard and fibre materials, glulam

Cutting material:

HW



Makita

Cutting material:

HS / HW

Planer knives for portable planers

Turnblade knives HW

TM 410 0

Machine	SB mm	H mm	DIK mm	QAL	ID
AEG, Bosch, Festool, Haffner, Holz-Her, Mafell, Metabo, Scheer	75.5	5.5	1.1	HW	005064 ●
Black & Decker	75.7	5.5	1.2	HW	005199 ●
Elu	80.5	5.9	1.2	HW	005131 ●
AEG, Black & Decker, DeWalt, Elu, Mafell, Makita, Metabo	82	5.5	1.1	HW	005066 ●

Planer knife HS / HW

TM 105 0

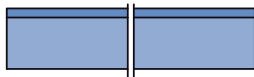
Machine	SB mm	H mm	DIK mm	ID HS	ID HW
Makita	82	29	3	027530 ●	027598 ●

Planer knives for semi-stationary machines

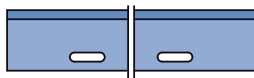
HS

TM 100 0, TM 105 0

Machine	SB mm	H mm	DIK mm	QAL	ID
Kity	260	20	2.5	HS	027154 ●
Metabo	263	20	3	HS	027157 ●
Scheppach	260	18	3	HS	027158 ●



Kity



Metabo



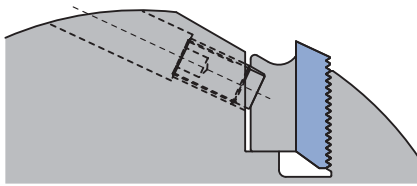
Scheppach

Workpiece material:

Softwood and hardwood, chipboard and fibre materials, glulam

Cutting material:

HS

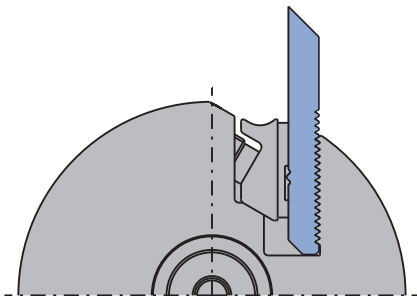


Back-serrated profile cutterheads

Filler pieces for knife thickness 8 - 10 mm

TD 510 0 05

BEZ	for SB mm	ID
Filler piece	40	005305 ●
Filler piece	60	005306 ●
Filler piece	80	005307 ●
Filler piece	100	005308 ●
Filler piece	120	005309 ●
Filler piece	130	005310 ●
Filler piece	150	005311 ●
Filler piece	170	620770 ●
Filler piece	180	005312 ●
Filler piece	190	620772 ●
Filler piece	210	620773 ●
Filler piece	230	005313 ●
Filler piece	240	620771 ●
Filler piece	270	620774 ●
Filler piece	310	620775 ●



Filler pieces for profiling of PKS-system backing plates

TF 200 0

BEZ	for SB mm	ID
Filler piece	40	008355 □
Filler piece	80	008356 □
Filler piece	130	008357 □
Filler piece	170	008358 □
Filler piece	210	008359 □
Filler piece	240	008221 ●

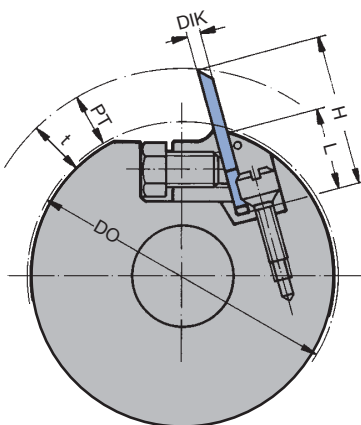
Profile cutterhead
PKS-system

Profile cutterhead WM 502 2

Profile cutterhead WM 502 2

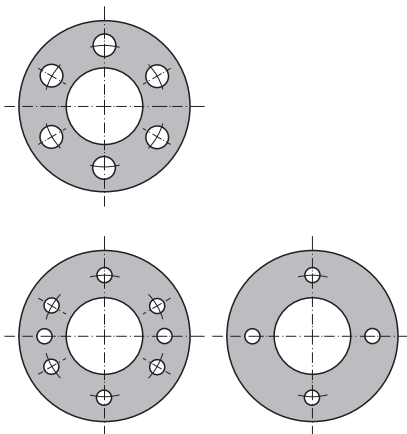
TC 105 0

BEZ	SB mm	QAL	ID
Profile blank knife	40	SP	007601 ●
Profile blank knife	50	SP	007602 ●
Profile blank knife	60	SP	007603 ●
Profile blank knife	40	HS	007284 ●
Profile blank knife	50	HS	007285 ●
Profile blank knife	60	HS	007286 ●



Workpiece material:
Softwood and hardwood

Cutting material:
SP / HS

Spacers with
6+4 pinholesSpacers with
4 pinholes**With pinholes****Spacers with 1 pitch**
TR 100 0

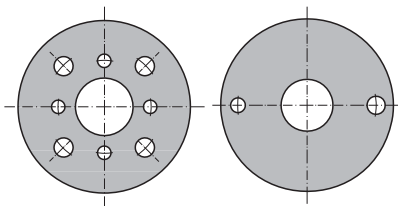
D mm	B mm	BO mm	NLA mm	ID
45	3	20	4/6/32	028088 ●
45	5	20	4/6/32	028089 ●
45	10	20	4/6/32	028090 ●
45	20	20	4/6/32	028639 ●
45	0.1	20	4/6/32	029208 ●
45	0.3	20	4/6/32	029209 ●
45	0.5	20	4/6/32	029210 ●
45	1	20	4/6/32	029211 ●
60	0.1	30	4/7/48	029237 ●
60	0.1	30	6/7/48	027914 ●
60	0.3	30	4/7/48	029238 ●
60	0.3	30	6/7/48	027915 ●
60	0.5	30	4/7/48	029239 ●
60	0.5	30	6/7/48	027916 ●
60	1	30	4/7/48	029240 ●
60	1	30	6/7/48	027917 ●
60	3	30	6/7/48	028580 ●
60	4	30	6/7/48	028581 ●
60	5	30	6/7/48	028582 ●
60	6	30	6/7/48	028583 ●
60	7	30	6/7/48	028584 ●
60	8	30	6/7/48	028585 ●
60	10	30	6/7/48	028586 ●
60	11	30	6/7/48	028587 ●
60	12	30	6/7/48	028588 ●
60	15	30	6/7/48	028589 ●
60	20	30	6/7/48	028591 ●
70	0.1	30	6/7/58	027952 ●
70	0.3	30	6/7/58	027953 ●
70	0.5	30	6/7/58	027954 ●
70	1	30	6/7/58	027955 ●
70	3	30	6/7/58	028599 ●
70	4	30	6/7/58	028600 ●
70	5	30	6/7/58	028601 ●
70	10	30	6/7/58	028605 ●
70	20	30	6/7/58	028608 ●
60	0.1	35	6/7/48	027930 ●
60	0.3	35	6/7/48	027931 ●
60	0.5	35	6/7/48	027932 ●
60	1	35	6/7/48	027933 ●
60	3	35	6/7/48	028592 ●
60	5	35	6/7/48	028594 ●
60	10	35	6/7/48	028598 ●
62	0.1	35	4/7/52	028667 ●
62	0.3	35	4/7/52	028668 ●
62	0.5	35	4/7/52	028669 ●
62	1	35	4/7/52	028670 ●
64	3	35	4/7/52	028671 ●
64	4	35	4/7/52	028672 ●
64	5	35	4/7/52	028673 ●
70	0.1	35	6/7/58	027966 ●
70	0.3	35	6/7/58	027967 ●
70	0.5	35	6/7/58	027968 ●
70	1	35	6/7/58	027969 ●
70	3	35	6/7/58	028609 ●
70	5	35	6/7/58	028611 ●
70	10	35	6/7/58	028615 ●
70	20	35	6/7/58	028616 ●
70	0.1	40	6/7/58	027978 ●
70	0.3	40	6/7/58	027979 ●
70	0.5	40	6/7/58	027980 ●
70	1	40	6/7/58	027981 ●

● available ex stock

□ available at short notice

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D mm	B mm	BO mm	NLA mm	ID
70	3	40	6/7/58	028617 ●
70	4	40	6/7/58	028618 ●
70	5	40	6/7/58	028619 ●
70	6	40	6/7/58	028620 ●
70	7	40	6/7/58	028621 ●
70	8	40	6/7/58	028622 ●
70	10	40	6/7/58	028623 ●
70	12	40	6/7/58	028624 ●
70	15	40	6/7/58	028625 ●
70	20	40	6/7/58	028626 ●
76.5	0.1	50	6/7/65	028005 ●
76.5	0.3	50	6/7/65	028006 ●
76.5	0.5	50	6/7/65	028007 ●
76.5	1	50	6/7/65	028008 ●
77	3	50	6/7/65	028627 ●
77	4	50	6/7/65	028628 ●
77	5	50	6/7/65	028629 ●
77	6	50	6/7/65	028630 ●
77	8	50	6/7/65	028631 ●
77	10	50	6/7/65	028632 ●
77	20	50	6/7/65	028633 ●
90	0.1	60	6/9/75	028020 ●
90	0.3	60	6/9/75	028021 ●
90	0.5	60	6/9/75	028022 ●
90	1	60	6/9/75	028023 ●
90	3	60	6/9/75	028634 ●
90	4	60	6/9/75	028635 ●
90	5	60	6/9/75	028636 ●
90	10	60	6/9/75	028637 ●
90	20	60	6/9/75	028638 ●

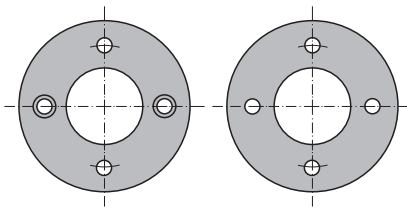
Spacers with
4+4 pinholesSpacers with
2 pinholes

With pinholes

Spacers with different pitches

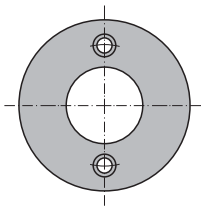
TR 100 0

D mm	B mm	BO mm	NLA mm	ID
90	0.1	30	4/7/48	028422 ●
			4/10/60	
90	0.3	30	4/7/48	028423 ●
			4/10/60	
90	0.5	30	4/7/48	028424 ●
			4/10/60	
90	1	30	4/7/48	028425 ●
			4/10/60	
90	3	30	4/7/48	028426 ●
			4/10/60	
90	5	30	4/7/48	028427 ●
			4/10/60	
90	10	30	4/7/48	028428 ●
			4/10/60	
90	20	30	4/7/48	028429 ●
			4/10/60	
100	0.1	30	1/8.5/80	028029 ●
			1/10.5/80	
100	0.3	30	1/8.5/80	028030 ●
			1/10.5/80	
100	0.5	30	1/8.5/80	028031 ●
			1/10.5/80	
100	1	30	1/8.5/80	028032 ●
			1/10.5/80	



Spacers with 4 pinholes (two of them with cylindrical countersink)

Spacers with 4 pinholes



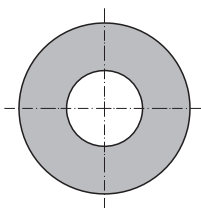
Spacers with 2 pinholes with cylindrical countersink

With pinholes, aluminium

Aluminium spacers

TR 100 0

D mm	B mm	BO mm	NLA mm	BEM	ID
60	10	30	2/7/48	2 pinholes with cylindrical countersink	029244 •
			2/7/48		
64	5	35	4/7/52	Cylindrical countersink pinholes	029246 •
64	10	35	4/7/52		029247 •
64	10	35	2/7/52		029248 •
64	20	35	4/7/52		029249 •



Without pinholes

Without pinholes

TR 100 0

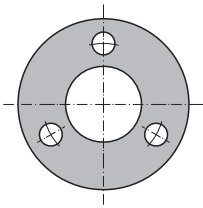
D mm	B mm	BO mm	ID
34	0.1	20	028400 •
34	0.3	20	028401 •
34	0.5	20	028402 •
34	1	20	028403 •
34	3	20	028404 •
34	4	20	028405 •
34	5	20	028406 •
50	0.1	30	027901 •
50	0.3	30	027902 •
50	0.5	30	027903 •
50	1	30	027904 •
50	3	30	027905 •
50	4	30	027906 •
50	5	30	027907 •
50	6	30	027908 •
50	7	30	027909 •
50	8	30	027910 •
50	10	30	027911 •
50	14	30	027912 •
50	20	30	027913 •
60	3	30	027918 •
60	4	30	027919 •
60	5	30	027920 •
60	6	30	027921 •
60	7	30	027922 •
60	8	30	027923 •
60	10	30	027924 •
60	11	30	027925 •
60	12	30	027926 •
60	15	30	027927 •
60	17.5	30	027928 •
60	20	30	027929 •
60	3	35	027934 •
60	5	35	027936 •
60	6	35	027937 •
60	7	35	027938 •

• available ex stock

□ available at short notice

Instruction manual visit www.leitz.org

D	B	BO	ID
mm	mm	mm	
60	8	35	027939 ●
60	10	35	027940 ●
60	0.1	40	027941 ●
60	0.3	40	027942 ●
60	0.5	40	027943 ●
60	1	40	027944 ●
60	3	40	027945 ●
60	4	40	027946 ●
60	5	40	027947 ●
60	6	40	027948 ●
60	7	40	027949 ●
60	8	40	027950 ●
60	9	40	028449 ●
60	10	40	027951 ●
70	3	30	027956 ●
70	4	30	027957 ●
70	5	30	027958 ●
70	6	30	027959 ●
70	7	30	027960 ●
70	8	30	027961 ●
70	10	30	027962 ●
70	12	30	027963 ●
70	15	30	027964 ●
70	20	30	027965 ●
70	3	35	027970 ●
70	4	35	027971 ●
70	5	35	027972 ●
70	6	35	027973 ●
70	7	35	027974 ●
70	8	35	027975 ●
70	10	35	027976 ●
70	20	35	027977 ●
70	3	40	027982 ●
70	4	40	027983 ●
70	5	40	027984 ●
70	6	40	027985 ●
70	7	40	027986 ●
70	8	40	027987 ●
70	10	40	027988 ●
70	12	40	027989 ●
70	15	40	027990 ●
70	20	40	027991 ●
70	0.1	50	027992 ●
70	0.3	50	027993 ●
70	0.5	50	027994 ●
70	1	50	027995 ●
70	3	50	027996 ●
70	4	50	027997 ●
70	5	50	027998 ●
70	6	50	027999 ●
70	7	50	028000 ●
70	8	50	028001 ●
70	10	50	028002 ●
70	15	50	028003 ●
70	20	50	028004 ●
77	3	50	028009 ●
77	4	50	028010 ●
77	5	50	028011 ●
77	6	50	028012 ●
77	8	50	028013 ●
77	10	50	028014 ●
77	20	50	028015 ●
90	3	60	028024 ●
90	4	60	028025 ●
90	5	60	028026 ●
90	10	60	028027 ●
90	20	60	028028 ●
100	4	30	028033 ●



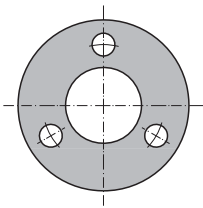
Spacers hardened and high precision for hydro and Hydro-Duo clamping sleeves to fill the clamping length.

Spacers, hardened and high precision for hydro and Hydro-Duo clamping sleeves

Spacers, hardened and high precision for hydro and Hydro-Duo clamping sleeves

TR 100 0

D	B	BO	NLA	ID
mm	mm	mm	mm	
90	10	60	3/9/75	030684 ●
90	15	60	3/9/75	030685 ●
90	20	60	3/9/75	030686 ●



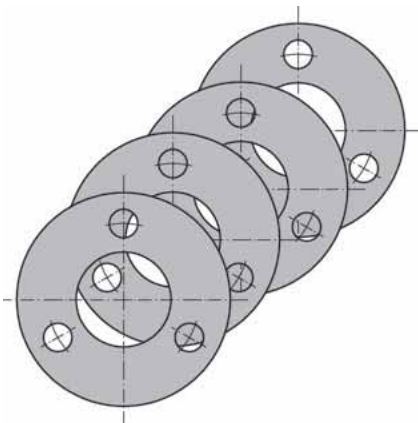
Spacers hardened and high precision for hydro and Hydro-Duo clamping sleeves to fill the clamping length.

High precision spacers for adjusting tongue and groove cuttersets

High precision spacers for adjusting tongue and groove cuttersets

TR 100 0

D	B	BO	NLA	ID
mm	mm	mm	mm	
90	3.1	60	3/9/75	030687 ●
90	3.3	60	3/9/75	030688 ●
90	3.5	60	3/9/75	030689 ●
90	3.7	60	3/9/75	030690 ●
90	3.9	60	3/9/75	030691 ●
90	4.1	60	3/9/75	030692 ●
90	4.3	60	3/9/75	030693 ●
90	4.5	60	3/9/75	030694 ●
90	4.7	60	3/9/75	030695 ●
90	4.9	60	3/9/75	030696 ●
90	5	60	3/9/75	030697 ●
90	5.1	60	3/9/75	030698 ●



Spacer sets

Set of standard cutter spindle spacers

AT 100 0 01

D	BO	ID
mm	mm	
50	30	028381 ●
60	40	028382 ●

AT 100 0 01

8 part spacer set with total clamping length 125 mm, surface ground face parallel, spacers black-finished, to DIN 8837

Set consisting of:

- 2 pieces: B 5.0 mm
- 2 pieces: B 16.0 mm
- 1 piece: B 8.0 mm
- 1 piece: B 10.0 mm
- 1 piece: B 25.0 mm
- 1 piece: B 40.0 mm

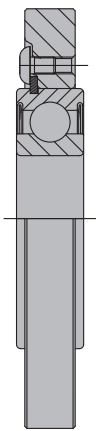


Ball bearings

Ball bearings

TL 510 0

BEZ	Type	D mm	D Ring mm	B mm	BO mm	ID
Ball bearing	A	62	min. 85	16	30	008114 ●
Ball bearing	A	62	min. 90	16	31.75	008142 □
Ball bearing	B	80	min. 102	18	40	008116 ●
Ball bearing	C	90	min. 112	20	50	008117 ●
Ball bearing	D	110	min. 132	22	60	008118

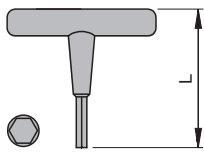


Guide rings

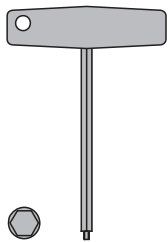
Guide rings

TR 500 0

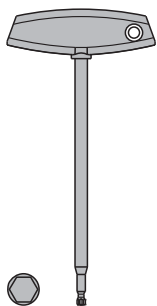
BEZ	Type	D mm	ID
Guide ring	A	85	027826 ●
Guide ring	A	90	027799 □
Guide ring	A	100	027800 ●
Guide ring	A	105	027801 □
Guide ring	A	110	027802 ●
Guide ring	A	120	027803
Guide ring	A	125	027804 ●
Guide ring	A	130	027805 ●
Guide ring	A	140	027806 ●
Guide ring	A	150	027807 ●
Guide ring	B	105	027808
Guide ring	B	110	027809
Guide ring	B	120	027810
Guide ring	B	125	027811
Guide ring	B	130	027812
Guide ring	B	140	027813
Guide ring	B	150	027814
Guide ring	C	112	027815
Guide ring	C	120	027816
Guide ring	C	125	027817
Guide ring	C	130	027818
Guide ring	C	140	027819
Guide ring	C	150	027820
Guide ring	C	160	027821
Guide ring	D	140	027822
Guide ring	D	150	027823
Guide ring	D	160	027824
Guide ring	D	170	027825



Hexagon key,
L 75 - 100 mm



Hexagon key, with
tenon



Hexagon key, for
quick-change
sleeve

Hexagon allen keys

T-handle without tenon

TH 500 0

ABM mm	L mm	ID
SW 2.5	100	005472 ●
SW 3	75	005444 ●
SW 4	75	005445 ●
SW 6	100	005447 ●

T-handle with tenon

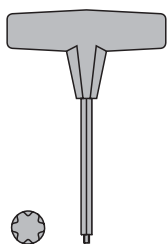
TH 500 0

ABM mm	ID
SW 5	005452 ●
SW 6	005494 ●

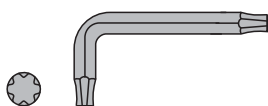
For quick-change chuck

TH 505 0

ABM mm	L mm	ID
SW 6	240	117516 ●



Torx® key with
T-handle



Torx® key, 90° angle

Torx® keys

T-handle

TH 500 0

ABM mm	L mm	ID
Torx® 8		006093 ●
Torx® 9		005463 ●
Torx® 15	100	005466 ●
Torx® 15	130	117507 ●
Torx® 20	100	006091 ●
Torx® 20	130	117503 ●
Torx® 25	100	005502 ●
Torx® 25	130	117504 ●

90° angle

TH 500 0

ABM mm	L mm	ID
Torx® 20	140	117511 ●



Torque tool set

TorqueVario®-STplus T-handle torque tool set, 11 parts

AT 199 0

BEZ	BEM	ID
TorqueVario-STplus 5-14 Nm	Bitholder 1/4 inch for bits with drive E 6.3 and C 6.3; Bits of series 7045 Torx and 7043 Hexagon in lengths 70 mm; Torx T 15 - T 20 - T 25; Hexagon SW 4 - SW 5 - SW 6 - SW 8	009103 •

Application:

Controlled tightening with predefined torque for changing knife tool systems

Design:

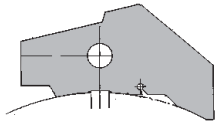
Model 5-14 Nm. Numeric torque indicator in the window scale. Steplessly controlled torque by control tool Torque Setter (included in delivery). Comfortable T-handle with soft zones for optimal torque transmission.

Precision:

±6%, based on national standards

Extra:

Delivery in stable metal box, incl. test protocol



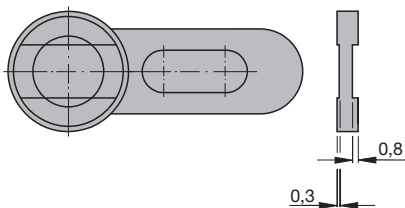
Setting gauge for hydro planerhead / planerhead wedge-type system

VN 265 0

ABM	ID
mm	
D143	007988 ●
D163	007989 ●
D203	008002 ●

Setting gauge
0.3/0.8 mm

Setting gauge 1 mm



Magnetic setting gauge 0.3/0.8 mm

Setting gauge for turnblade

VN 230 0

BEZ	ABM	ID
	mm	
Setting gauge for knives	0.3/0.8	005374 ●
Setting gauge for knives	1.0	005350 ●
Magnetic setting gauge	0.3/0.8	005376 ●

Mounting device

VN 799 0

BEZ	BEM	ID
Mounting device for SK 30/BT30 with grooves and notches	Not for Biesse	079000 ●
Mounting device for SK40		079001 ●
Mounting device for HSK-F50		079002 ●
Mounting device for HSK-E63 and HSK-F63		079003 ●
Mounting device for SCM/Morbidelli ISO30		079004 ●
Mounting device for CMS ISO30		079005 ●
Mounting device for Alberti HSK-E 40		079006 ●



Application:

For the assembly of shank tools in clamping chucks or tools with borehole on arbors with adaptors for automatic tool change

- Reduced risk of injury when mounting tools
- Quick clamping levers and fixing pins secure the clamped taper axially as well as against twisting



Mounting device

Mounting device for tools with HSK 85 / HSK-F 63 adaptor

VN 799 0

BEZ	Machine	l mm	d mm	ID
Mounting device EASY-Hold HSK 85 WS	Weinig	30 - 310	20 - 50	079010 •
Mounting device EASY-Hold HSK-F 63				079009 •

For quick and easy mounting of knives or tools on arbors.

Application:

For mounting saws, tools, tool sets and cutterheads



Mounting device

Clamping device for drills with 10 mm shank and clamping flat

VN 799 0

BEZ	ID
Clamping device for drill 10 mm shank	079020 •

Application:

For clamping drills (10 mm shank with clamping flat) when altering the length adjusting screw.

Advantages:

- reduced risk of injury when mounting the tools
- easy and stable tool clamping during mounting



Lifting device for large circular saw blades

MagneticGrip Lifting device

VZ 999 0

BEZ	BEM	ID
Lifting device	20 kg load capacity	119900 ●
Lifting device	45 kg load capacity	119901 ●

For optimal lifting, 2 pcs. are recommended.

Application:

For easy lifting of large circular saw blades by means of magnetic power

Jointing stones for Leitz Marathon planer knife

FS 100 0, FS 199 0

BEZ	Machine	BEM	ABM mm	ID
Jointing stone (angular)	WACO	Colour: brown	20x15x60	008238 ●
Jointing stone (round)	Weinig, Leadermac	Colour: grey	12x32	008237 ●

Grinding wheels suitable for sharpening Marathon planer knives available on request.

Key to pictograms



	Sawing, multiple cut		Sawing solid transparent plastic		Copy shaping		Slotting		Profiling		Mechanical knife clamping, adjustable - serrated		Resharpenable cutting face
	Sawing, thin kerf		Sawing hollow metal		Rebating		Spiral boring		Profiling joints		Mechanical knife clamping, adjustable - plane		Resharpenable clearance face
	Sawing, horizontal		Sawing crosscut metal		Bevelling		Non-axial boring		Mortising		Constant Mechanical knife clamping, re-sharpenable and constant diameter		Low noise
	Sawing along grain		Scoring, top and bottom		Panel raising		Plug cutting		MEC Mechanical feed		Spindle without twist protection		DFC Optimised chip flow
	Sawing across grain		Scoring, hogging		Profiling		Carving		MAN Manual feed		Spindle with anti-twist keyway		SP Alloyed tool steel
	Sawing, universal		Hogging		Profiling joints		Grooving, sizing		Solid metal tool		Spindle with anti-twist hexagon		HL High-alloyed tool steel
	Scoring, sawing		Double hogging		Profiling tongue and groove		Finish sizing		Tipped tool		Hydro clamping system - open		HS High-speed steel
	Scoring and sawing stacks		Hogging, folding		Planing		Grooving, horizontal and vertical		Heavy Special body alloy		Hydro clamping system - closed		ST Stellite
	Sawing hollow sections		End trimming		Planing, profiling		Joining		Light Light alloy body		Hydro-Duo (bi-directional) clamping		HW Tungsten carbide
	Sawing, honeycomb panels		Edge trimming		Drilling blind holes		Copy shaping		Inter-changeable knives		Hydro clamping arbors		DP Polycrystalline diamond (PCD)
	Sawing plastic single		Grooving, horizontal and vertical		Drilling, through holes		Rebating		Mechanical knife clamping, reversible		Hydro clamping		DM Monocrystalline diamond (MKD)
	Sawing plastic stacks		Grooving honeycomb panels		Step drilling		Bevelling		Centrifugal knife clamping, reversible		Shrink-fit clamping		Marathon Carbide metal coating
	Sawing hollow transparent plastic		Joining		Counter-sinking		Panel raising		Mechanical knife clamping, non-adjustable		Quick Quick clamping system		Diamond Diamond coating

