

Sawing

Leitz Lexicon Edition 7



Explanation of abbreviations








A	= dimension A	LL	= left hand rotation
a_e	= cutting thickness (radial)	M	= metric thread
a_p	= cutting depth (axial)	MBM	= minimum order quantity
ABM	= dimension	MC	= multi-purpose steel, coated
APL	= panel raising length	MD	= thickness of knife
APT	= panel raising depth	min^{-1}	= revolutions per minute (RPM)
AL	= working length	MK	= morse taper
AM	= number of knives	m min^{-1}	= metres per minute
AS	= anti sound (low noise design)	m s^{-1}	= metres per second
b	= overhang	n	= RPM
B	= width	n_{max}	= maximum permissible RPM
BDD	= thickness of shoulder	NAL	= position of hub
BEM	= note	ND	= thickness of hub
BEZ	= description	NH	= zero height
BH	= tipping height	NL	= cutting length
BO	= bore diameter	NLA	= pinhole dimensions
CNC	= Computerized Numerical Control	NT	= grooving depth
d	= diameter	P	= profile
D	= cutting circle diameter	POS	= cutter position
D0	= zero diameter	PT	= profile depth
DA	= outside Diameter	PG	= profile group
DB	= diameter of shoulder	QAL	= cutting material quality
DFC	= Dust Flow Control (optimised chip clearance)	R	= radius
DGL	= number of links	RD	= right hand twist
DIK	= thickness	RL	= right hand rotation
DKN	= double keyway	RP	= radius of cutter
DP	= polycrystalline diamond	S	= shank dimension
DRI	= rotation	SB	= cutting width
FAB	= width of rebate	SET	= set
FAT	= depth of rebate	SLB	= slotting width
FAW	= bevel angle	SLL	= slotting length
FLD	= flange diameter	SLT	= slotting depth
f_z	= tooth feed	SP	= tool steel
$f_{z \text{ eff}}$	= effective tooth feed	ST	= Cobalt-basis cast alloys, e.g. Stellite®
GEW	= thread	STO	= shank tolerance
GL	= total length	SW	= cutting angle
GS	= Plunging edge	TD	= diameter of tool body
H	= height	TDI	= thickness of tool
HC	= tungsten carbide, coated	TG	= pitch
HD	= wood thickness (thickness of workpiece)	TK	= reference diameter
HL	= high-alloyed tool steel	UT	= cutting edges with irregular pitch
HS	= high-speed steel (HSS)	V	= number of spurs
HW	= tungsten carbide (TCT)	v_c	= cutting speed
ID	= ident number	v_f	= feed speed
IV	= insulation glazing	VE	= packing unit
KBZ	= abbreviation	VSB	= adjustment range
KLH	= clamping height	WSS	= workpiece material
KM	= edge breaker	Z	= number of teeth
KN	= single keyway	ZA	= number of fingers
KNL	= combination pinhole consists of 2/7/42 2/9/46,35 2/10/60	ZF	= tooth shape (cutting edge shape)
L	= length	ZL	= finger length
l	= clamping length		
LD	= left hand twist		
LEN	= Leitz standard profiles		

Notes to the Lexicon concerning the diagrams and tables

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

1. Sawing



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1. Sawing

1.1 Solid wood cutting along grain

1.1.1 Circular sawblades thin kerf



Lamellae cuts *Premium* - middle cut

Application:

For cutting strips and slats along grain on horizontal and vertical spindles.

Machine:

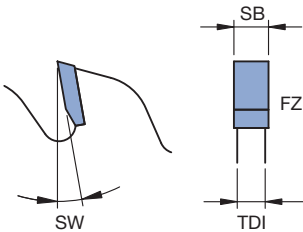
Moulders with/without forced guidance of workpieces. Application on single, double, horizontal or vertical spindles.

Workpiece material:

Softwood and hardwood, dry up to 10% wood moisture content, quality category 0 to 1.

Technical information:

Noise reducing design by irregular tooth pitch. Tool body without recess. Increased cutting performance and less resin build up by special coated tool body.



Middle cuts

WK 100 2 21

D	SB	TDI	BO	BO _{max}	NLA	FLD	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm			Deg.		
180	1.5	1.0	60	70	3/10/75	100	32	FZ	20	■	057443 ●
180	1.8	1.2	60	70	3/10/75	100	21	FZ	20	■	057444 ●
180	1.8	1.3	60	70	3/10/75	100	32	FZ	20	■	057412 ●
200	1.5	1.0	60	80	3/10/75	120	21	FZ	20	■	057445 ●
200	1.5	1.0	60	80	3/10/75	120	36	FZ	20	■	057421 ●
220	1.2	0.9	60	80	3/10/75	120	27	FZ	20	■	057475 ●
220	1.2	0.9	65	80	3/11/80	120	24	FZ	20	■	057474 ●
220	1.3	0.9	60	80	3/10/75	120	24	FZ	20	■	057476 ●
220	1.3	0.9	60	80	3/10/75	120	32	FZ	20	■	057478 ●
220	1.3	0.9	65	80	3/11/80	120	24	FZ	20	■	057477 ●
220	1.3	0.9	65	80	3/11/80	120	32	FZ	20	■	057479 ●
220	1.4	1.0	60	80	3/10/75	120	24	FZ	20	■	057480 ●
220	1.4	1.0	60	80	3/10/75	120	32	FZ	20	■	057464 ●
220	1.4	1.0	65	80	3/11/80	120	24	FZ	20	■	057481 ●
220	1.4	1.0	65	80	3/11/80	120	32	FZ	20	■	057465 ●
225	1.5	1.0	60	110	3/10/75	120	25	FZ	20	■	057447 ●
225	1.6	1.2	60	110	3/10/75	130	32	FZ	20	■	057482 ●
225	1.8	1.2	60	110	3/10/75	120	25	FZ	20	■	057448 ●
225	2.0	1.4	40	110	3/10/75	120	40	FZ	20	■	163600 ●
225	2.0	1.4	60	110	3/10/75	120	25	FZ	20	■	057449 ●
250	1.7	1.2	60	120	3/10/75	140	25	FZ	20	■	057450 ●
250	1.7	1.2	60	120	3/10/75	140	36	FZ	20	■	057433 ●
250	2.0	1.4	60	120	3/10/75	140	25	FZ	20	■	057451 ●
250	2.0	1.4	60	120	3/10/75	140	36	FZ	20	■	057434 ●



Lamellae cuts - shoulder cut

Application:

For cutting along grain - shoulder cuts in combination with middle cut sawblades.

Machine:

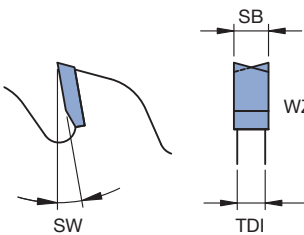
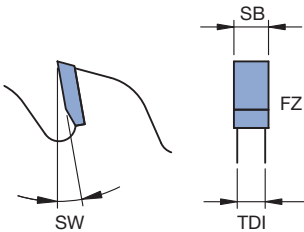
Moulders with/without forced guidance of workpieces. Application on single, double, horizontal or vertical spindles.

Workpiece material:

Softwood and hardwood, dry up to 10% wood moisture content, quality category 0 to 1.

Technical information:

Suitable for utilisation as a set in combination with thin kerf sawblades for middle cuts. Higher cutting performance and less resin build up by special coated tool body.



Shoulder cuts

WK 100 2 21

D	SB	TDI	BO	NLA	DKN	FLD	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm			Deg.		
200	5.0	4.0	30	3/10/75		120	24	FZ	20	■	165250 ●
220	5.0	4.0	30	3/10/75		120	24	FZ	20	■	165251 ●
225	5.0	4.0	30	3/10/75		120	24	FZ	20	■	165252 ●
225	5.0	4.0	60	3/10/75		120	40	FZ	20	■	165256 ●
250	5.0	4.0	30	3/10/75		140	24	FZ	20	■	165253 ●
250	5.0	4.0	30	3/10/75		140	36	FZ	20	■	165254 ●
250	8.0	6.0	80	4/7/95	13/89	100	24	FZ	15	■	165257 ●
				2/13/100							
300	8.0	6.0	80	4/7/95	13/89	100	24	FZ	15	■	165258 ●
				2/13/100							

Technical information:

Suitable for utilisation as a set in combination with thin kerf sawblades for middle cuts. Special tooth geometry for low cutting forces at low feed rates. Higher cutting performance and less resin build up by special coated tool body.

Shoulder cuts - reduced number of teeth

WK 150 2, WK 150 2 21

D	SB	TDI	BO	NLA	FLD	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm			Deg.		
180	3.8	3.0	60	3/10/75	100	12+12	WZ	20	■	165255 ●
				3/11/80						
200	3.8	3.0	60	3/10/75	100	12+12	WZ	20	■	165259 ●
				3/11/80						
220	3.8	3.0	60	3/10/75	120	6+6+6+6	WZ	20	■	165260 ●
				3/11/80						
220	3.8	3.0	65	3/10/75	120	6+6+6+6	WZ	20	■	165261 ●
				3/11/80						
220	3.8	3.0	60	3/10/75	120	12+12	WZ	20	■	165262 ●
				3/11/80						
225	3.8	3.0	60	3/10/75	120	12+12	WZ	20	■	165263 ●
				3/11/80						
250	3.8	3.0	60	3/10/75	120	12+12	WZ	20	■	165264 ●
				3/11/80						

1. Sawing

1.1 Solid wood cutting along grain 1.1.2 Circular sawblades with wiper teeth



Circular sawblades with internal and external wiper teeth

Application:

For cutting along grain - shoulder and trimming cuts.

Machine:

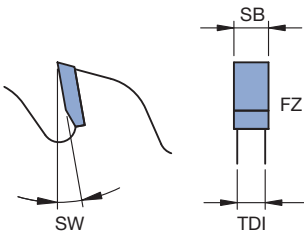
Edging, single blade, multi blade saws as well as saws with one or two spindles.

Workpiece material:

Softwood and hardwood wet, frozen, dry. Long fibre materials (poplar, balsa etc.)

Technical information:

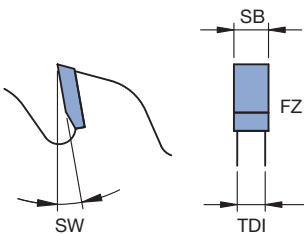
With two internal and external (over D>280 mm) wiper teeth. Large lateral tooth clearance for cuts in wet and frozen wood.



Square and shoulder cuts

WK 150 2

D	SB	TDI	BO	BO _{max}	NLA	DKN	FLD _{max}	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm	mm		Deg.			
250	4.4	2.8	30	80			130	18	FZ	25	■	165000 ●
250	4.4	2.8	80		19/89	6/5.5/91	130	18	FZ	25	■	165001 ●
					13/89	4/6.6/95						
						2/13/100						
300	5.0	3.2	30	80			130	20	FZ	25	■	165002 ●
350	5.0	3.2	30	100			130	24	FZ	25	■	165003 ●
350	5.0	3.2	80	100	19/89	6/5.5/91	130	24	FZ	25	■	165004 ●
					13/89	4/6.6/95						
						2/13/100						
400	5.0	3.2	30	120			150	28	FZ	25	■	165005 ●
400	5.0	3.2	80	120	19/89	6/5.5/91	150	28	FZ	25	■	165006 ●
					13/89	4/6.6/95						
						2/13/100						
450	5.0	3.2	30	120			160	28	FZ	25	■	165007 ●



Application:

For cutting along grain - middle cuts.

Middle cuts

WK 100 2 43

D	SB	TDI	BO	BO _{max}	NLA	DKN	FLD _{max}	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm	mm		Deg.			
250	3.5	2.2	30	80			130	18	FZ	25	■	165008 ●
250	3.5	2.2	80		19/89	6/5.5/91	130	18	FZ	25	■	165009 ●
					13/89	4/6.6/95						
						2/13/100						
300	3.5	2.2	30	80			110	20	FZ	25	■	165010 ●
300	3.5	2.2	70			21x83	110	20	FZ	25	■	165011 ●
300	3.5	2.2	80			23x90	110	20	FZ	25	■	165012 ●
						13x89						
350	4.0	2.8	30	100			130	24	FZ	25	■	165013 ●
350	4.0	2.8	80	100	19/89	6/5.5/91	130	24	FZ	25	■	165014 ●
					13/89	4/6.6/95						
						2/13/100						
400	4.0	2.8	30	120			150	28	FZ	25	■	165015 ●
400	4.0	2.8	80	120	19/89	6/5.5/91	150	28	FZ	25	■	165016 ●
					13/89	4/6.6/95						
						2/13/100						
450	4.4	3.0	30	120			160	28	FZ	25	■	165017 ●

1. Sawing

1.1 Solid wood cutting along grain 1.1.2 Circular sawblades with wiper teeth



Circular sawblades with internal and external wiper teeth

Application:

For cutting along grain - middle cuts.

Machine:

Edging, single blade, multi blade saws as well as saws with one or two spindles.

Workpiece material:

Softwood and hardwood, dry up to 15% wood moisture content. Long fibre materials (poplar, balsa etc.).

Technical information:

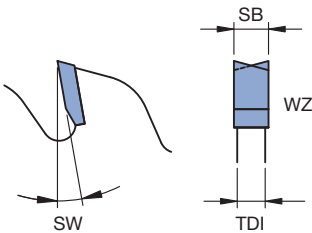
With two external and two or four (over D-320 mm) internal wiper teeth.



Middle cuts - dry

WK 150 2

D	SB	TDI	BO	BO _{max}	NLA	DKN	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm			Deg.		
250	3.2	2.2	70			20.6/83	20	WZ	20	■	165200 ●
300	3.2	2.2	70	80		20.6/83	24	WZ	20	■	165201 ●
320	3.2	2.2	70	80		20.6/83	28	WZ	20	■	165202 ●
350	3.5	2.5	70	100		20.6/83	28	WZ	20	■	165203 ●
400	4.0	2.8	70	100		20.6/83	24	WZ	20	■	165204 ●
500	5.0	3.5	30	100	KNL		28	WZ	20	■	165205 ●



1. Sawing

1.1 Solid wood cutting along grain 1.1.2 Circular sawblades with wiper teeth



Lamellae cuts - horizontal spindle - external wiper teeth

Application:

For cutting of thin slats on horizontal spindles.

Machine:

Edging, single blade, multi blade saws as well as saws or moulders with one or two spindles.

Workpiece material:

Softwood, dry up to 10% wood moisture content.

Technical information:

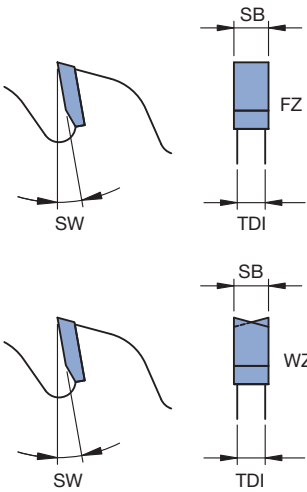
With two external wiper teeth. Higher cutting performance and less resin build up by special coated tool body.



Lamellae cuts on horizontal spindles

WK 100 2, WK 150 2

D	SB	TDI	BO	DKN	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			Deg.		
200	2.0	1.4	40		24	FZ	20	■	163575 ●
250	2.0	1.4	80	19/89	36	WZ	15	■	163576 ●
250	2.4	1.6	80	19/89	32	WZ	15	■	163577 ●
300	2.8	1.8	80	19/89	28	WZ	15	■	163578 ●



1. Sawing

1.1 Solid wood cutting along grain 1.1.2 Circular sawblades with wiper teeth



Lamellae cuts - horizontal spindle - external wiper teeth

Application:

For cutting of thin slats on horizontal spindles.

Machine:

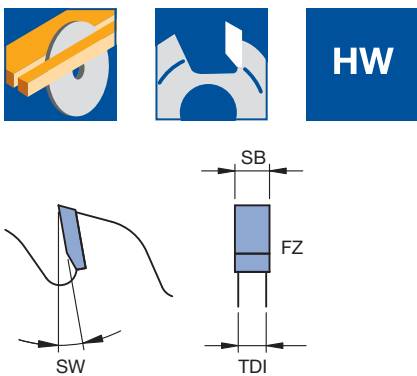
Edging, single blade, multi blade saws as well as saws or moulders with one or two spindles.

Workpiece material:

Softwood and hardwood, dry up to 10% wood moisture content.

Technical information:

With internal wiper teeth. Efficient energy and wood use by reduced cutting widths.



Lamellae cuts on horizontal spindles

WK 100 2

D	SB	TDI	BO	BO _{max}	DKN	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm			Deg.		
200	2.4	1.6	40	60		24	FZ	20	■	163550 ●
220	2.4	1.6	40	80		24	FZ	20	■	163551 ●
250	2.4	1.6	40	90		24	FZ	20	■	163552 ●
250	2.4	1.6	70		21/83	24	FZ	20	■	163553 ●
250	2.4	1.6	80		19x89	24	FZ	20	■	163554 ●
					13x89					
300	2.8	1.8	30	100		28	FZ	25	■	163555 ●
300	2.8	1.8	80		19x89	28	FZ	25	■	163556 ●
					13x89					
350	2.8	1.8	30	110		32	FZ	25	■	163557 ●

Lamellae cuts - vertical spindle

Application:

For cutting of thin slats on vertical spindles.

Machine:

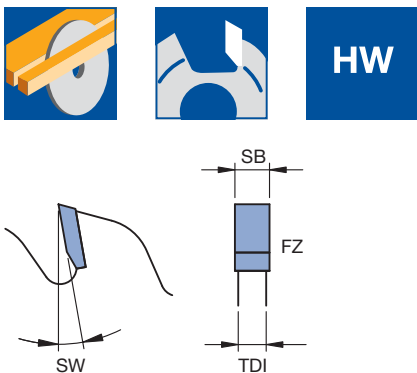
Edging, single blade, multi blade saws as well as saws or moulders with one or two spindles.

Workpiece material:

Softwood and hardwood, dry up to 10% wood moisture content.

Technical information:

With two external and two internal wiper teeth. Higher cutting performance and less resin build up by special coated tool body.



Lamellae cuts on vertical spindles

WK 100 2

D	SB	TDI	BO	BO _{max}	NLA	FLD _{max}	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm			Deg.		
250	2.4	1.6	60	80	3/10/75	120	24	FZ	20	■	163700 ●
250	2.4	1.6	60	80	3/10/75	120	40	FZ	20	■	163701 ●
270	2.4	1.6	60	80	3/10/75	120	28	FZ	20	■	163702 ●

1. Sawing

1.1 Solid wood cutting along grain 1.1.3 Circular sawblades without wiper teeth



Lamellae cuts - horizontal spindle

Application:

For cutting along grain - glueable middle and lamellae cuts on horizontal spindles.

Machine:

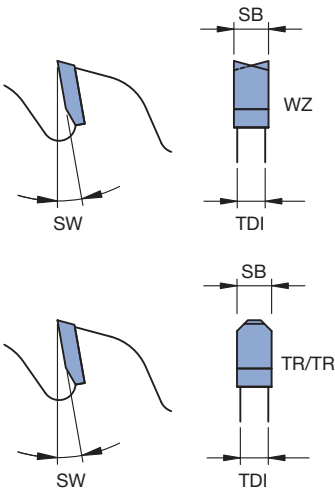
Single blade, multi blade saws as well as saws and moulders with one or two spindles.

Workpiece material:

Softwood and hardwood, dry up to 10% wood moisture content.

Technical information:

Special tooth geometry for glueable cutting surface. Noise reducing design by irregular tooth pitch. Tool body without recess. Higher cutting performance and less resin build up by special coated tool body.



Lamellae cuts on horizontal spindles

WK 100 2, WK 150 2, WK 152 2, WK 158 2

Machine	D	SB	TDI	BO	BO _{max}	NLA	DKN	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm	mm	mm			Deg.		
	180	2.2	1.4	30	60	3/10/75		18	FZ	15	■	165300 ●
	180	2.4	1.6	30	60	3/10/75		24	FZ	15	■	165301 ●
	200	2.4	1.6	30	60	3/10/75		18	FZ	15	■	165302 ●
	200	2.4	1.6	30	60	3/10/75		24	FZ	15	■	165303 ●
	225	2.4	1.6	30	60	3/10/75		24	FZ	15	■	165304 ●
	225	2.8	2.0	30	60	3/10/75		24	FZ	15	■	165305 ●
	240	2.8	2.0	40	60	3/10/75		24	FZ	15	■	165306 ●
Raimann	250	2.4	1.6	80		6/5.5/91	19/89	40	WZ	15	■	165309 ●
						4/6.6/95	13/89					
						2/13/100						
	250	2.8	2.0	30	100	3/10/75		24	FZ	15	■	165307 ●
	250	2.8	2.0	70	100		21/80	24	FZ	15	■	165308 ●
Raimann	300	2.8	1.8	80		6/5.5/91	19/89	28	WZFA	15	■	165310 ●
						4/6.6/95	13/89					
						2/13/100						
Raimann	300	2.8	1.8	80		6/5.5/91	19/89	48	TR/TR	15	■	165311 ●
						4/6.6/95	13/89					
						2/13/100						
Raimann	300	3.4	2.2	80		6/5.5/91	19/89	28	FZ	15	■	165312 ●
						4/6.6/95	13/89					
						2/13/100						
Raimann	300	4.0	2.8	80		6/5.5/91	19/89	28	TR/TR	15	■	165313 ●
						4/6.6/95	13/89					
						2/13/100						
Raimann	300	4.0	2.8	80		6/5.5/91	19/89	48	TR/TR	15	■	165314 ●
						4/6.6/95	13/89					
						2/13/100						

1. Sawing

1.1 Solid wood cutting along grain 1.1.3 Circular sawblades without wiper teeth



Shoulder and square cuts - middle cut

Application:

For cutting along grain - shoulder and trimming cuts.

Machine:

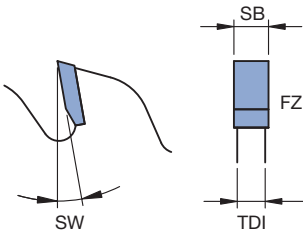
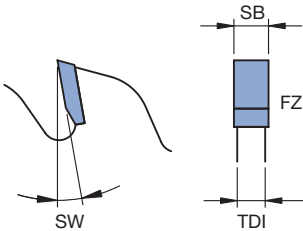
Edging, single blade, multi blade saws as well as saws with one or two spindles.

Workpiece material:

Softwood and hardwood wet and dry.

Technical information:

Large chip gullet and big lateral tooth clearance for cuts in wet wood.



Shoulder and square cuts

WK 100 2

D	SB	TDI	BO	NLA	DKN	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm			Deg.		
200	4.0	2.6	30			18	FZ	25	■	165100 ●
250	4.0	2.6	30	KNL		18	FZ	20	■	165101 ●
300	4.0	2.6	30	KNL		24	FZ	20	■	165102 ●
300	4.0	2.6	70		21x83	24	FZ	20	■	165103 ●
350	4.4	3.0	30	KNL		24	FZ	20	■	165104 ●
400	5.0	3.2	30	KNL		28	FZ	20	■	165105 ●
450	5.0	3.2	30	KNL		28	FZ	20	■	165106 ●
500	5.0	3.2	30	KNL		32	FZ	20	■	165107 ●

Middle cuts

WK 100 2

D	SB	TDI	BO	NLA	DKN	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm			Deg.		
200	3.2	2.2	30			18	FZ	25	■	165108 ●
210	3.2	2.2	30			18	FZ	20	■	165109 ●
250	3.2	2.2	30	KNL		18	FZ	20	■	165110 ●
300	3.2	2.2	30	KNL		24	FZ	20	■	165111 ●
300	3.2	2.2	70		21x83	24	FZ	20	■	165112 ●
350	3.2	2.2	30	KNL		24	FZ	20	■	165113 ●
400	4.0	2.8	30	KNL		28	FZ	20	■	165114 ●
450	4.0	2.8	30	KNL		28	FZ	20	■	165115 ●
500	4.0	2.8	30	KNL		32	FZ	20	■	165116 ●

1. Sawing

1.1 Solid wood cutting along grain 1.1.3 Circular sawblades without wiper teeth



Sizing solid wood along grain

Application:

For cutting along grain - sizing wood and wood derived materials.

Machine:

Edging, single blade, multi blade saws as well as saws with one or two spindles.

Workpiece material:

Softwood and hardwood, dry up to 15% wood moisture content.

Technical information:

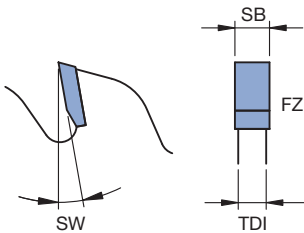
Design with chip thickness limitation.

Circular sawblade FZ with thickness limitation

WK 100 2



D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			Deg.		
250	3.2	2.2	30	KNL	18	FZ	20	■	166050 ●
300	3.5	2.4	30	KNL	14	FZ	20	■	166051 ●
350	3.5	2.4	30	KNL	16	FZ	20	■	166052 ●
400	4.0	2.8	30	KNL	18	FZ	20	■	166053 ●
450	4.0	2.8	30	KNL	20	FZ	20	■	166054 ●
500	4.0	2.8	30	KNL	24	FZ	20	■	166055 ●



Circular sawblades with chip thickness limitation and tooth shape WZ - see section Portable Saws and Table-Top Machines.



Trimming at high feed rates

Application:

For trimming and cross cutting with cycle times of 0.3 - 1.0 sec.

Machine:

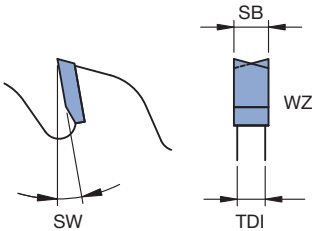
Cross, trimming and optimising saws.

Workpiece material:

Solid wood wet and dry across grain, solid wood profiles across grain.

Technical information:

Large lateral tooth clearance and a high number of teeth. Stable corner angle of 20° for tear-free cutting results and long tool life.



Trimming at high feed rates

WK 150 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			Deg.		
400	3.5	2.8	30	2/10/60 2/15/63	120	WZ	10	■	165450 ●
450	4.8	3.5	30	2/10/60 2/15/63	138	WZ	10	■	165451 ●
450	5.0	3.2	30	2/10/60 2/15/63	108	WZ	10	■	165452 ●
500	4.8	3.5	30	2/10/60 2/15/63	144	WZ	10	■	165454 ●
500	4.8	3.5	35	2/10/60 2/15/63	144	WZ	10	■	165455 □
500	5.2	3.2	30	2/10/60 2/15/63	120	WZ	10	■	165453 ●
520	4.6	3.4	30	2/10/60 2/15/63	144	WZ	10	■	165456 ●
550	5.0	3.2	30	2/10/60 2/15/63	96	WZ	10	■	165457 ●
550	5.2	3.2	30	2/10/60 2/15/63	120	WZ	10	■	165459 ●
550	5.2	3.2	30	2/10/60 2/15/63	160	WZ	10	■	165458 ●
600	5.4	4.0	30	2/10/60 2/15/63	172	WZ	10	■	165461 ●
600	5.8	4.0	30	2/10/60 2/15/63	108	WZ	10	■	165460 ●
630	5.4	4.4	30	2/10/60 2/15/63	180	WZ	10	■	165462 ●



Trimming with negative cutting angle

Application:

For trimming and cross cutting - positioning of workpiece under the sawblade.

Machine:

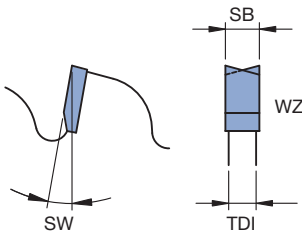
Cross, trimming, mitre and radial saws as well as double mitre cutting saws.

Workpiece material:

Softwood and hardwood wet and dry, laminated veneer lumber (e.g. plywood, multiplex plywood).

Technical information:

Specially for manually operated machines. Position of spindle above the workpiece.



Circular sawblade WZ with neg. cutting angle

WK 160 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			Deg.		
300	3.2	2.4	30	KNL	36	WZ	-5	■ ■	165500 ●
300	3.2	2.4	30	KNL	60	WZ	-5	■ ■	165501 ●
300	3.2	2.4	30	KNL	96	WZ	-5	■ ■	165502 ●
305	3.2	2.4	30	KNL	60	WZ	-5	■ ■	165503 ●
350	3.2	2.4	30	KNL	36	WZ	-5	■ ■	165504 ●
350	3.2	2.4	30	KNL	60	WZ	-5	■ ■	165505 ●
350	3.5	2.8	30	KNL	108	WZ	-5	■ ■	165506 ●
355	3.2	2.4	30	KNL	72	WZ	-5	■ ■	165507 ●
400	3.8	2.8	30	KNL	42	WZ	-5	■ ■	165508 ●
400	3.8	2.8	30	KNL	60	WZ	-5	■ ■	165509 ●
400	3.8	2.8	30	KNL	120	WZ	-5	■ ■	165510 ●
450	3.8	2.8	30	KNL	48	WZ	-5	■ ■	165511 ●
500	4.4	3.2	30	KNL	54	WZ	-5	■ ■	165512 ●

1. Sawing

1.2 Solid wood cutting across grain

1.2.2 Circular sawblades WZ with neg. cutting angle



Trimming with negative cutting angle *Excellent*

Application:

For trimming and cross cutting - positioning of workpiece under the sawblade.

Machine:

Cross, trimming, mitre and radial saws as well as double mitre cutting saws.

Workpiece material:

Softwood and hardwood wet and dry, laminated veneer lumber (e.g. plywood, multiplex plywood).

Technical information:

Specially for manually operated machines. Position of spindle above the workpiece.

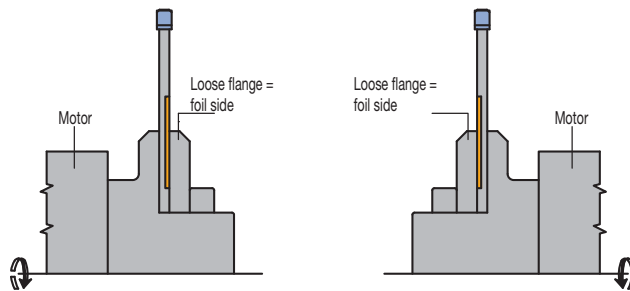
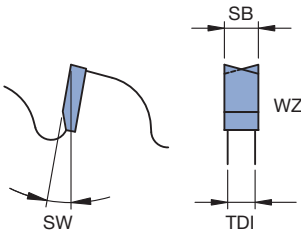
Excellent design. Tool body with vibration damping steel foil.



Circular sawblade WZ with neg. cutting angle

WK 180 2

D	SB	TDI	BO	NLA	Z	ZF	SW	Foil	WSS	ID
mm	mm	mm	mm	mm			Deg.			
300	3.2	2.4	30	KNL	96	WZ	-5	left		161330 ●
300	3.2	2.4	30	KNL	96	WZ	-5	right		161331 ●
350	3.2	2.4	30	KNL	108	WZ	-5	left		161332 ●
350	3.2	2.4	30	KNL	108	WZ	-5	right		161333 ●
400	3.2	2.4	30	KNL	120	WZ	-5	left		161334 ●
400	3.2	2.4	30	KNL	120	WZ	-5	right		161335 ●





Trimming, crossing and mitre cuts

Application:

For cross cutting, trimming and angled cuts.

Machine:

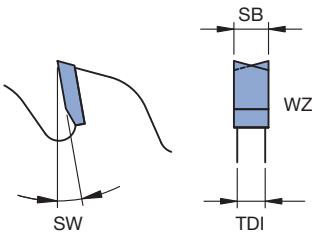
Cross and trimming saws and CNC controlled joinery machines, cross cutting twin saws.

Workpiece material:

Solid wood beams wet and dry, cross-glued beams.

Technical information:

Large lateral tooth clearance.



Circular sawblade WZ

WK 150 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW Deg.	WSS	ID
Routech	440	7.0	4.0	75	6/9/100	12+2+2	WZ	20	■ ■	165326 ●
					2/8.5/100					
Routech	500	4.4	3.2	75	2/8.5/100	28+2+2+2	WZ	20	■ ■	165328 ●
					6/10.6/100					
Routech	500	7.0	4.0	75	6/9/100	14+2+2+2	WZ	20	■ ■	165327 ●
					2/8.5/100					
Essetre	520	5.4	3.5	60	8/6.5/100	72	WZ	20	■ ■	165332 ●
Weinmann	555	5.2	3.6/6	55	6/7/75	54+2+2	WZ	20	■ ■	165325 ●
Essetre	600	5.4	3.5	80	8/9.5/120	72	WZ	20	■ ■	165333 ●
Routech	600	7.0	4.0	75	6/9/125	16+2+2+2	WZ	20	■ ■	165329 ●
					2/8.5/125					
Uniteam	640	5.4	3.6	30	8/6.5/160	36+2+2	WZ	20	■ ■	165330 ●
					8/6.5/130					
					4/10.5/90					
	700	6.0	4.4	30		72	WZ	15	■ ■	165334 ●
	750	6.0	4.4	30		72	WZ	15	■ ■	165335 ●
	800	6.0	4.4	30		72	WZ	15	■ ■	165336 ●
Uniteam	850	8.0	6.0	30	8/6.5/160	60+2+2+2	WZ	20	■ ■	165331 ●
					8/6.5/130					
					4/10.5/90					

1. Sawing

1.3 Sizing

1.3.1 Sizing sawblades WZ



Sizing *Premium*

Application:

For sizing and cross cutting with/without scoring.

Machine:

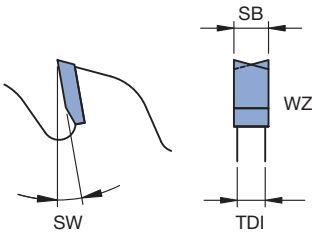
Table and sizing saws.

Workpiece material:

Solid wood across grain, chipboard and fibre materials, laminated veneer lumber (e.g. plywood, multiplex plywood).

Technical information:

Premium design with vibration damping ornaments (over D-200). Marked dimensions with irregular tooth pitch (UT).



Sizing sawblade WZ

WK 170 2

D	SB	TDI	BO	NLA	Z	ZF	Type	SW	WSS	ID
mm	mm	mm	mm	mm				Deg.		
150	3.2	2.2	30		48	WZ		10	■ ■	163100 ●
180	2.4	1.6	30		30	WZ	UT	10	■ ■	163101 ●
180	3.0	2.0	30		24	WZ	UT	10	■ ■	163102 ●
180	3.2	2.2	30		58	WZ		10	■ ■	163103 ●
180	3.5	2.5	30		30	WZ	UT	10	■ ■	163104 ●
200	2.4	1.6	30	KNL	36	WZ	UT	10	■ ■	163105 ●
200	2.4	1.6	30	KNL	60	WZ		10	■ ■	163106 ●
200	3.0	2.0	30	KNL	24	WZ	UT	10	■ ■	163107 ●
200	3.0	2.0	30	KNL	48	WZ	UT	10	■ ■	163108 ●
200	3.0	2.0	30	KNL	60	WZ		10	■ ■	163109 ●
220	3.2	2.2	30	KNL	36	WZ	UT	10	■ ■	163110 ●
220	3.2	2.2	30	KNL	60	WZ		10	■ ■	163111 ●
250	2.4	1.6	30	KNL	40	WZ	UT	10	■ ■	163112 ●
250	2.4	1.6	30	KNL	80	WZ		10	■ ■	163113 ●
250	3.2	2.2	30	KNL	40	WZ	UT	10	■ ■	163114 ●
250	3.2	2.2	30	KNL	60	WZ	UT	10	■ ■	163115 ●
250	3.2	2.2	30	KNL	80	WZ		10	■ ■	163116 ●
300	2.4	1.6	30	KNL	48	WZ	UT	10	■ ■	163117 ●
300	2.4	1.6	30	KNL	96	WZ		10	■ ■	163118 ●
300	3.2	2.2	30	KNL	36	WZ	UT	10	■ ■	163119 ●
300	3.2	2.2	30	KNL	48	WZ	UT	10	■ ■	163120 ●
300	3.2	2.2	30	KNL	72	WZ	UT	10	■ ■	163121 ●
300	3.2	2.2	30	KNL	96	WZ		10	■ ■	163122 ●
350	3.5	2.5	30	KNL	54	WZ	UT	10	■ ■	163123 ●
350	3.5	2.5	30	KNL	72	WZ	UT	10	■ ■	163124 ●
350	3.5	2.5	30	KNL	84	WZ	UT	10	■ ■	163125 ●
350	3.5	2.5	30	KNL	108	WZ		10	■ ■	163126 ●
400	3.5	2.5	30	KNL	48	WZ	UT	10	■ ■	163127 ●
400	3.5	2.5	30	KNL	60	WZ	UT	10	■ ■	163128 ●
400	3.5	2.5	30	KNL	84	WZ	UT	10	■ ■	163129 ●
400	3.5	2.5	30	KNL	96	WZ	UT	10	■ ■	163130 ●
400	3.5	2.5	30	KNL	120	WZ		10	■ ■	163131 ●
450	3.8	2.8	30	KNL	66	WZ	UT	10	■ ■	163132 ●
500	3.8	2.8	30	KNL	72	WZ	UT	10	■ ■	163133 ●

1. Sawing

1.3 Sizing

1.3.1 Sizing sawblades WZ



Sizing without scoring *Premium* - Mamba

Application:

For sizing and cross cutting without scoring.

Machine:

Table and sizing saws. Vertical panel sizing saws without scoring unit.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), thin walled plastic profiles (thickness < 2 mm), thin walled plastic honeycomb boards.

Technical information:

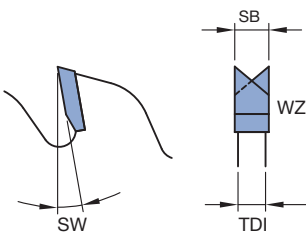
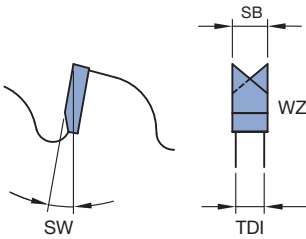
Special WZ with 40° corner angle for tear-free cuts on both sides. **Premium** design with vibration damping laser ornaments.



Circular sawblade Mamba, negative cutting angle

WK 880 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			Deg.		
250	3.2	2.2	30	KNL	80	WZ	-5		163225 ●
303	3.5	2.5	30	KNL	96	WZ	-5		163226 ●



Technical information:

Special WZ with 40° corner angle for tear-free cuts on both sides.

Premium design with vibration damping laser ornaments.

Circular sawblade Mamba, positive cutting angle

WK 870 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			Deg.		
300	3.5	2.5	30	KNL	96	WZ	5		163200 ●
350	3.5	2.5	30	KNL	108	WZ	5		163201 ●



Sizing and cutting veneer stacks - reduced cutting width

Application:

For sizing and cross cutting with and without scoring.

Machine:

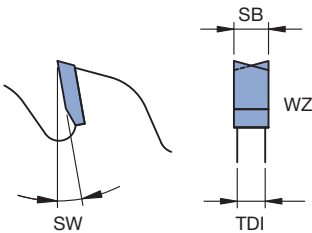
Table, sizing and veneer cutting saws.

Workpiece material:

Solid wood across grain, chipboard and fibre materials, laminated veneer lumber (e.g. plywood, multiplex plywood), veneered board stacks, plastic or derived material honeycomb boards.

Technical information:

Reduced cutting width and special designed tool body. Less cutting and feed forces are necessary.



Circular sawblade WZ

WK 250 2, WK 850 2, WK 850 2 10, WK 850 2 22

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			Deg.		
160	1.8	1.0/2.5	16	1/6/33	48	WZ	10		060574 ●
180	1.6	1.0/2.5	16	1/6/33	56	WZ	10		060591 ●
180	2.4	1.6	16	KNL	58	WZ	10		059665 ●
200	2.0	1.4	16	KNL	64	WZ	10		059666 ●
250	1.7	1.0/2.4	30	KNL	80	WZ	10		058520 ●
300	1.7	1.0/2.4	30	KNL	96	WZ	10		058521 ●
450	3.0	2.2	30	2/14/125 KNL	120	WZ	20		058461 ●



Sizing without scoring *Excellent* - Katana

Application:

For sizing and cross cutting without scoring.

Machine:

Table and sizing saws, vertical panel sizing machines without scoring unit, cross, trimming and mitre cutting saws.

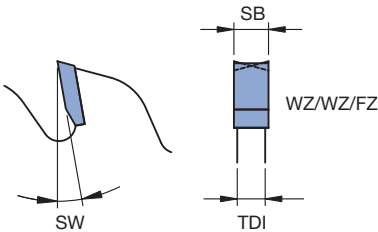
Workpiece material:

Solid wood across grain, laminated veneer lumber (e.g. plywood, multiplex plywood), honeycomb boards, thin walled plastic and non-ferrous metal profiles.

Technical information:

Katana tooth combination with alternate angle of cutting face for best cutting results.

Excellent design with plastic filled laser ornaments for vibration damping and reduction of noise level.



Circular sawblade Katana

WK 879 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			Deg.		
255	2.8	2.0	30	KNL	80	WZ/WZ/FZ	10		161200 ●
303	3.0	2.2	30	KNL	100	WZ/WZ/FZ	10		161201 ●
355	3.0	2.2	30	KNL	120	WZ/WZ/FZ	10		161202 ●
400	3.2	2.5	30	KNL	130	WZ/WZ/FZ	20		161203 ●
450	3.6	2.8	30	KNL	140	WZ/WZ/FZ	20		161204 ●
500	4.0	3.5	30	KNL	150	WZ/WZ/FZ	20		161205 ●
550	4.0	3.5	30	KNL	160	WZ/WZ/FZ	20		161206 ●



Sizing *Excellent* - WhisperCut

Application:

For sizing and trimming with/without scoring.

Machine:

Table and sizing saws, vertical panel sizing saws with/without scoring unit. Cross, trimming and mitre saws.

Workpiece material:

Solid wood across grain, laminated veneer lumber (e.g. plywood, multiplex plywood), chipboard and fibre materials plastic and paper coated, veneered, honeycomb boards, thin walled plastic and non-ferrous metal profiles.

Technical information:

Extreme noise reduction. Special design and grouping of teeth for perfect cuts and reduced cutting forces. **Excellent** design with plastic filled laser ornaments for vibration damping and reduction of noise level. Stable tooth geometry for a long tool life. Universal use for various materials. Resharpenable two times.

Circular sawblade WhisperCut

WK 879 2 DP

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			Deg.		
250	3.2	2.4	30	KNL	50	HZFA/WZFA	10		190697 ●
303	3.2	2.4	30	KNL	60	HZFA/WZFA	10		190698 ●
350	3.2	2.4	30	KNL	70	HZFA/WZFA	10		190699 ●

Application:

For scoring with feed.

Machine:

Table and sizing saws, vertical panel sizing saws with scoring unit.

Workpiece material:

Solid wood across grain, laminated veneer lumber (e.g. plywood, multiplex plywood), chipboard and fibre materials plastic and paper coated, veneered, honeycomb boards.

Scoring sawblade

WK 272 2

D	SB	BO	Z	ZF	SW	WSS	ID
mm	mm	mm			Deg.		
80	3.3	20	18	HZ/WZ	10		190700 ●
120	3.3	20	18	HZ/WZ	10		190701 ●
120	3.3	22	18	HZ/WZ	10		190702 ●
125	3.3	20	18	HZ/WZ	10		190703 ●

1. Sawing

1.3 Sizing

1.3.4 Sizing sawblades HZ/DZ



Sizing without scoring *Excellent*

Application:

For sizing and cross cutting without scoring.

Machine:

Table and sizing saws, vertical panel sizing saws without scoring unit.

Workpiece material:

Chipboard and fibre materials plastic and paper coated, veneered.

Technical information:

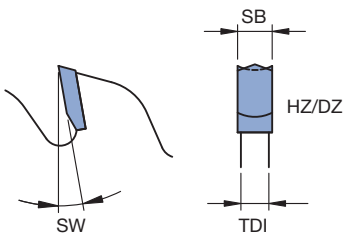
Excellent design with plastic filled laser ornaments for vibration damping and reduction of noise level.



Circular sawblade

WK 874 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			Deg.		
250	3.2	2.2	30	KNL	54	HZ/DZ	10	■ ■	161300 ●
303	3.2	2.2	30	KNL	68	HZ/DZ	10	■ ■	161301 ●
350	3.5	2.5	30	KNL	80	HZ/DZ	10	■ ■	161302 ●





Sizing without scoring *Premium*

Application:

For sizing and cross cutting without scoring.

Machine:

Table and sizing saws, vertical panel sizing saws without scoring unit.

Workpiece material:

Chipboard and fibre materials plastic and paper coated, veneered.

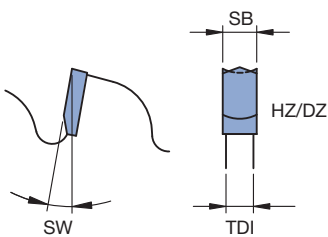
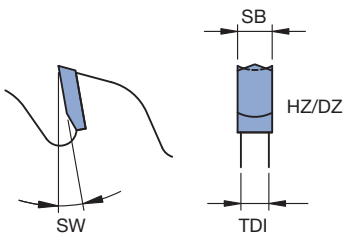
Technical information:

Premium design with vibration damping laser ornaments.

Circular sawblade, positive cutting angle

WK 274 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			Deg.		
220	3.2	2.2	30	KNL	42	HZ/DZ	10	■ ■	163050 ●
250	3.2	2.2	30	KNL	48	HZ/DZ	10	■ ■	163051 ●
303	3.5	2.5	30	KNL	60	HZ/DZ	10	■ ■	163052 ●
350	3.5	2.5	30	KNL	72	HZ/DZ	10	■ ■	163053 ●



Machine:

Vertical panel sizing saws without scoring unit.

Technical information:

Premium design with vibration damping laser ornaments. Better cutting edge at the exit side of the sawblade by negative cutting angle.

Circular sawblade, negative cutting angle

WK 864 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			Deg.		
220	3.2	2.2	30	KNL	42	HZ/DZ	-5	■ ■	163075 ●
250	3.2	2.2	30	KNL	48	HZ/DZ	-5	■ ■	163076 ●
303	3.2	2.2	30	KNL	60	HZ/DZ	-5	■ ■	163077 ●

1. Sawing

1.3 Sizing

1.3.5 Sizing sawblades FZ/TR



Sizing with scoring *Premium*

Application:

For sizing and trimming with scoring.

Machine:

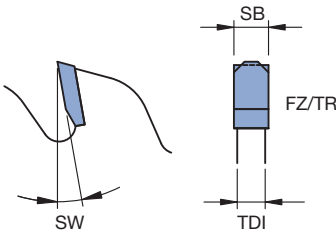
Table and sizing saws, vertical panel sizing saws with scoring unit.

Workpiece material:

Chipboard and fibre materials, paper and plastic coated, duroplastics (compact laminate panels, e.g. HPL), solid surface materials (e.g. Corian).

Technical information:

Premium design with vibration damping laser ornaments. Marked dimensions with irregular tooth pitch (UT).



Circular sawblade

WK 852 2

D	SB	TDI	BO	NLA	Z	ZF	Type	SW	WSS	ID
mm	mm	mm	mm	mm				Deg.		
220	3.2	2.2	30	KNL	64	FZ/TR		10		163000 ●
240	3.2	2.2	30	KNL	54	FZ/TR	UT	10		163001 ●
250	3.2	2.2	30	KNL	60	FZ/TR	UT	10		163002 ●
250	3.2	2.2	30	KNL	80	FZ/TR		10		163003 ●
280	3.2	2.2	30	KNL	60	FZ/TR	UT	10		163004 ●
300	3.2	2.2	30	KNL	72	FZ/TR	UT	10		163005 ●
300	3.2	2.2	30	KNL	96	FZ/TR		10		163006 ●
350	3.5	2.5	30	KNL	84	FZ/TR	UT	10		163007 ●
350	3.5	2.5	30	KNL	108	FZ/TR		10		163008 ●

1. Sawing

1.3 Sizing 1.3.6 Sizing sawblades FZ



Sizing *Premium*

Application:

For sizing and cross cutting with and without scoring.

Machine:

Table and sizing saws.

Workpiece material:

Solid wood along grain.

Technical information:

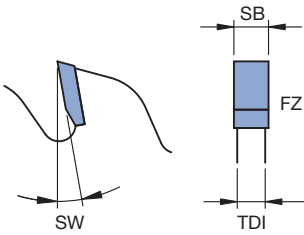
Reduced number of teeth and large gullet for deep cutting depths. **Premium** design with vibration damping laser ornaments.



Circular sawblade FZ

WK 120 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			Deg.		
350	3.5	2.5	30	KNL	12	FZ	10	■	163025 ●
400	3.5	2.5	30	KNL	14	FZ	10	■	163026 ●
450	3.8	2.8	30	KNL	16	FZ	10	■	163027 ●



1. Sawing

1.3 Sizing 1.3.6 Sizing sawblades FZ



Sizing, scoring, hogging

Application:

For sizing, cross cutting and scoring with feed, for mounting on hogsers or segment hogsers.

Machine:

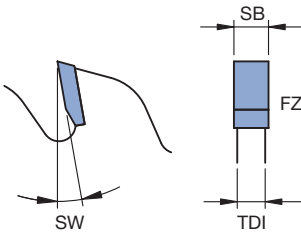
Table, sizing and vertical panel sizing saws.

Workpiece material:

Solid wood along grain, chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood).

Technical information:

Also suitable for assembly on hogsers and segment hogsers.

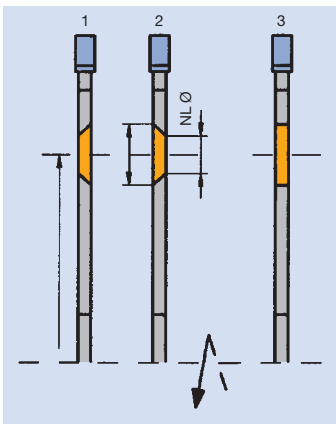


Scoring sawblade - Circular sawblade for mounting on hogger.

HW design.

WK 100 2

D	SB	TDI	BO	NLA	Type	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm				Deg.		
150	3.2	2.2	30			42	FZ	10		165375 ●
180	3.2	2.2	30			48	FZ	10		165378 ●
180	3.2	2.2	65	6/6/90	2	36	FZ	10		165376 ●
180	3.2	2.2	65	6/6/90	1	36	FZ	10		165377 ●
180	3.2	2.2	65	6/6/90	2	48	FZ	10		165379 ●
180	3.2	2.2	65	6/6/90	1	48	FZ	10		165380 ●
180	3.2	2.2	65	6/6/90	2	58	FZ	10		165381 ●
180	3.2	2.2	65	6/6/90	1	58	FZ	10		165382 ●
200	3.2	2.2	30			54	FZ	10		165383 ●



Type 1:

Countersink right

Type 2:

Countersink left

Type 3:

Pinhole without countersink

1. Sawing

1.3 Sizing 1.3.6 Sizing sawblades FZ



Sizing, scoring, hogging *Excellent*

Application:

For sizing, cross cutting and scoring with feed, for mounting on hogsers or segment hogsers.

Machine:

Table, sizing and vertical panel sizing saws.

Workpiece material:

Solid wood along grain, chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood).

Technical information:

Also suitable for assembly on hogsers and segment hogsers.

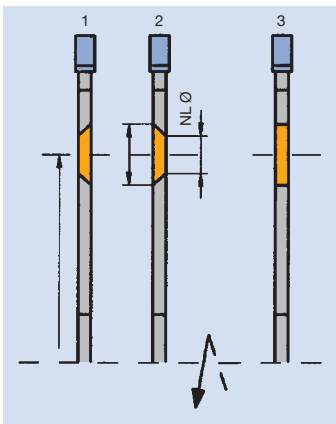
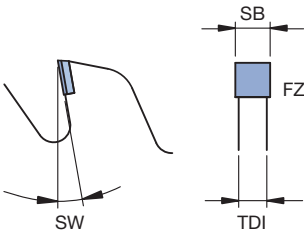


Scoring sawblade - circular sawblade for mounting on hogger.

DP design.

WK 800 2

D	SB	TDI	BO	NLA	Type	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm				Deg.		
180	3.2	2.2	65	6/6/90	2	24	FZ	10		190660 <input type="checkbox"/>
180	3.2	2.2	65	6/6/90	1	24	FZ	10		190661 <input type="checkbox"/>
180	3.2	2.2	65	6/6/90	2	36	FZ	10		190662 <input type="checkbox"/>
180	3.2	2.2	65	6/6/90	1	36	FZ	10		190663 <input type="checkbox"/>
180	3.2	2.2	65	6/6/90	2	48	FZ	10		190664 <input type="checkbox"/>
180	3.2	2.2	65	6/6/90	1	48	FZ	10		190665 <input type="checkbox"/>



Type 1:

Countersink right

Type 2:

Countersink left

Type 3:

Pinhole without countersink



Scoring sawblades with adjustable cutting width

Application:

For scoring with feed.

Machine:

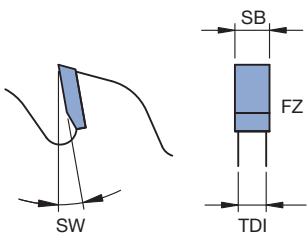
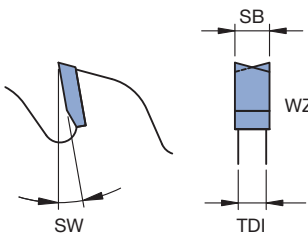
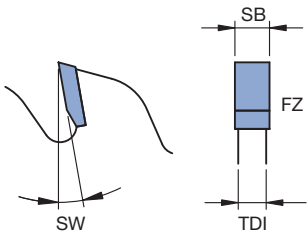
Table and sizing saws, vertical panel sizing saws with scoring unit.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood).

Technical information:

2 part design, adjustable with spacers. Scoring depth 1.50 - 2.00 mm.



Scoring sawblades adjustable, HW design

WK 200 2, WK 250 2

Machine	D mm	SB mm	BO mm	Z	ZF	SW Deg.	WSS	ID
Robland, Striebig	70	2.8 - 3.8	20	8+8	WZ	10	■	165400 ●
Schelling	80	2.8 - 3.8	20	10+10	FZ	10	■	165401 ●
Schelling	100	2.8 - 3.8	20	10+10	FZ	10	■	165402 ●
Altendorf	100	2.8 - 3.8	22	10+10	FZ	10	■	165403 ●
SCM	120	2.8 - 3.8	20	12+12	FZ	10	■	165404 ●
Martin	120	2.8 - 3.6	22	12+12	FZ	10	■	165405 ●
T74 Automatic								
Altendorf	120	2.8 - 3.8	22	12+12	FZ	10	■	165406 ●
Altendorf	125	2.8 - 3.8	20	12+12	FZ	10	■	165407 ●
Martin	140	2.8 - 3.8	36	12+12	WZ	10	■	165408 ●
SCM	160	2.8 - 3.8	20	16+16	FZ	10	■	165409 ●
Altendorf	180	3.0 - 3.8	22	18+18	WZ	10	■	165410 ●
SCM	200	4.3 - 5.2	20	30+30	FZ	10	■	165411 ●

Scoring sawblades for Altendorf Rapido-System, HW design

WK 200 2

Machine	D mm	SB mm	BO mm	Z	ZF	SW Deg.	WSS	ID
Altendorf	120	2.8 - 3.8	50	12+12	FZ	10	■	165412 ●
Altendorf	180	3.0 - 3.8	50	18+18	FZ	10	■	165413 ●



Scoring sawblades with adjustable cutting width *Excellent*

Application:

For scoring with feed.

Machine:

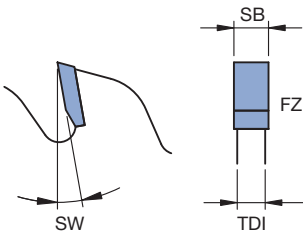
Table and sizing saws, vertical panel sizing saws with scoring unit.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood).

Technical information:

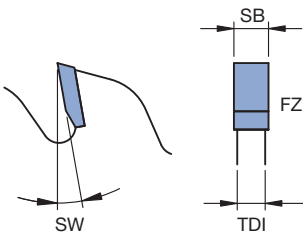
2 part design, adjustable with spacers. Scoring depth 1.50 - 2.00 mm.



Scoring sawblades adjustable, Diamaster PRO

WK 200 2

D	SB	BO	Z	ZF	SW	WSS	ID
mm	mm	mm			Deg.		
120	2.8 - 3.8	22	12+12	FZ	10	■	190694 ●
125	2.8 - 3.8	20	12+12	FZ	10	■	190695 ●



Scoring sawblades for Altendorf Rapido-System, Diamaster PRO

WK 200 2

D	SB	BO	Z	ZF	SW	WSS	ID
mm	mm	mm			Deg.		
120	2.8 - 3.8	50	12+12	FZ	10	■	190704 ●



Sizing of single boards and stacks of boards *Premium*

Application:

For panel sizing of single boards and stacks of boards with and without scoring.

Machine:

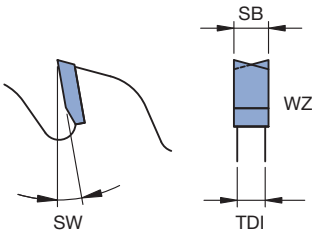
Panel sizing saws with pressure beam.

Workpiece material:

Chipboard and fibre materials, laminated veneer lumber (e.g. plywood, multiplex plywood).

Technical information:

For feed rates $v_f > 40 \text{ m min}^{-1}$ WZ can be reground to WZFA. **Premium** design with vibration damping laser ornaments.



Circular sawblade

WK 250 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			Deg.		
Höfer, Langzauner, Panhans	300	4.4	3.2	30	KNL	48	WZ	15	■	163300 ●
Holz-Her, Höfer, Langzauner, Panhans, Schelling	350	4.4	3.2	30	KNL	54	WZ	15	■	163301 ●
Holz-Her, Höfer, Langzauner, Panhans, Schelling	350	4.4	3.2	30	KNL	72	WZ	15	■	163302 ●
Homag	350	4.4	3.2	60	2/14/100	72	WZ	15	■	163304 ●
Gabbiani, SCM	350	4.4	3.2	80	4/9/100	54	WZ	15	■	163305 ●
					2/14/110					
					2/7/110					
Homag	355	4.4	3.2	30	KNL	72	WZ	15	■	163306 ●
	380	4.8	3.5	60	2/14/100	54	WZ	15	■	163307 ●
					2/14/125					
Höfer, Panhans, Scheer, Schelling	400	4.4	3.2	30	KNL	60	WZ	15	■	163308 ●
Höfer, Panhans, Scheer, Schelling	400	4.4	3.2	30	KNL	72	WZ	15	■	163309 ●
Schelling	430	4.4	3.2	30	KNL	72	WZ	15	■	163310 ●
Scheer, Schelling	450	4.4	3.2	30	KNL	54	WZ	15	■	163311 ●
					2/13/94					
Scheer, Schelling	450	4.4	3.2	30	KNL	72	WZ	15	■	163312 ●
					2/13/94					
Schelling	480	4.4	3.2	30	KNL	72	WZ	15	■	163313 ●
					2/13/94					
Schelling	500	5.2	3.5	30	KNL	60	WZ	15	■	163314 ●
	500	5.2	3.5	80		60	WZ	15	■	163315 ●
Schelling	520	4.4	3.2	30	2/13/94	72	WZ	15	■	163316 ●
	550	5.2	3.5	30	KNL	60	WZ	15	■	163317 ●
	550	5.2	3.5	80		60	WZ	15	■	163318 ●



Sizing of single boards and stacks of boards *Premium*

Application:

For panel sizing of single boards and stacks of boards with scoring.

Machine:

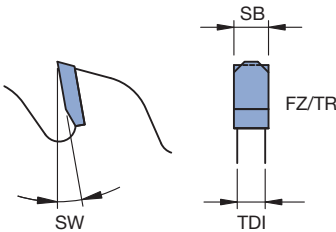
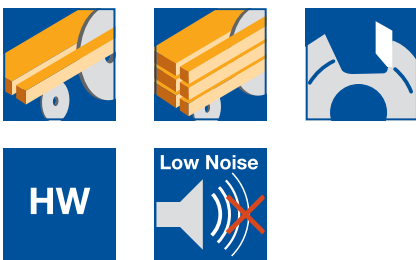
Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered.

Technical information:

Premium design with vibration damping laser ornaments.



Circular sawblade

WK 852 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW Deg.	WSS ID
Höfer, Langzauner, Panhans	300	4.4	3.2	30	KNL	60	FZ/TR	15	163400 ●
Homag	300	4.4	3.2	60	2/14/100	72	FZ/TR	15	163401 ●
Selco	300	4.4	3.2	65	2/9/110	60	FZ/TR	15	163402 ●
Homag	300	4.4	3.2	75		60	FZ/TR	15	163403 ●
Homag	308	3.2	2.4	60	2/14/100	96	FZ/TR	15	163404 ●
Homag	310	4.4	3.2	60	2/14/100	72	FZ/TR	15	163405 ●
Felder, Mayer	320	4.4	3.2	30	KNL	60	FZ/TR	15	163406 ●
Selco	320	4.4	3.2	65	2/9/110	60	FZ/TR	15	163407 ●
Höfer, Langzauner, Mayer, Panhans, Schelling	350	4.4	3.2	30	KNL	72	FZ/TR	15	163408 ●
Homag	350	4.4	3.2	60	2/14/100	72	FZ/TR	15	163409 ●
Homag	350	4.4	3.2	75		72	FZ/TR	15	163410 ●
Gabbiani, SCM	350	4.4	3.2	80	4/9/100	60	FZ/TR	15	163411 ●
					2/7/110				
					2/14/110				
Selco	355	4.4	3.2	65	2/9/110	72	FZ/TR	15	163412 ●
					2/9/100				
Giben, Homag	355	4.4	3.2	75		72	FZ/TR	15	163413 ●
Schelling	360	4.4	3.2	30	2/13/94	72	FZ/TR	15	163414 ●
Selco	360	4.4	3.2	65	2/9/100	72	FZ/TR	15	163415 ●
					2/9/110				
Panhans	370	4.4	3.2	30	2/13/94	72	FZ/TR	15	163416 ●
					KNL				
Giben	380	4.4	3.2	50	2/13/80	72	FZ/TR	15	163417 ●
					6/13/80				
Homag	380	4.4	3.2	60	2/14/100	72	FZ/TR	15	163418 ●
					2/14/125				
Homag	380	4.8	3.5	60	2/14/100	72	FZ/TR	15	163419 ●
					2/14/125				
Giben	380	4.4	3.2	75	3/15/75	72	FZ/TR	15	163420 ●
					2/7/110				
Höfer, Panhans, Scheer, Schelling	400	4.4	3.2	30	KNL	72	FZ/TR	15	163421 ●
Anthon	400	4.4	3.2	60	2/11/85	72	FZ/TR	15	163422 ●
Giben, Homag	400	4.4	3.2	75	4/15/105	72	FZ/TR	15	163423 ●
					2/7/110				
Selco	400	4.4	3.2	80	2/9/130	72	FZ/TR	15	163424 ●
					4/19/120				
Gabbiani	400	4.4	3.2	80	4/9/100	72	FZ/TR	15	163425 ●
					2/14/110				
					2/7/110				
Homag	420	4.8	3.5	60	2/14/125	72	FZ/TR	15	163426 ●
					2/19/120				
Schelling	430	4.4	3.2	30	KNL	72	FZ/TR	15	163427 ●
Giben	430	4.4	3.2	75	4/15/105	72	FZ/TR	15	163428 ●
Selco	430	4.4	3.2	80	2/9/130	72	FZ/TR	15	163429 ●
					4/19/120				



- Solid wood
- Board, coated
- Board, uncoated
- Non-ferrous metals
- Plastics
- Mineral materials
- Composites
- Steel, thin-walled

1. Sawing

1.4 Panel sizing

1.4.2 Panel sizing sawblades FZ/TR

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS ID
	mm	mm	mm	mm	mm			Deg.	
Scheer, Schelling	450	4.4	3.2	30	KNL	72	FZ/TR	15	163430 ●
									2/13/94
Homag	450	4.8	3.5	60	2/14/125	72	FZ/TR	15	163431 ●
									2/19/120
Gabbiani, SCM	450	4.4	3.2	80	2/9/100	72	FZ/TR	15	163432 ●
									2/14/110
									2/7/110
Selco	450	4.8	3.6	80	2/9/130	72	FZ/TR	15	163433 ●
									4/19/120
Schelling	460	4.4	3.2	30	2/13/94	72	FZ/TR	15	163434 ●
Giben	470	4.4	3.2	75	4/15/105	96	FZ/TR	15	163435 ●
Schelling	480	4.4	3.2	30	KNL	72	FZ/TR	15	163436 ●
Homag	480	4.8	3.5	60	2/19/120	72	FZ/TR	15	163437 ●
Selco	480	4.8	3.5	80	2/9/130	72	FZ/TR	15	163438 ●
									4/19/120
Schelling	500	5.2	3.5	30	KNL	60	FZ/TR	15	163439 ●
Anthon, Homag	500	5.2	3.5	60	2/11/115	60	FZ/TR	15	163440 □
									2/19/120
Selco	510	4.8	3.5	80	2/9/130	72	FZ/TR	15	163441 ●
									4/19/120
Schelling	520	4.4	3.2	30	2/13/94	72	FZ/TR	15	163442 ●
Homag	520	4.8	3.5	60	2/11/115	72	FZ/TR	15	163443 ●
									2/19/120
Selco	520	4.8	3.5	70	4/11/130	72	FZ/TR	15	163444 ●
Homag	570	4.8	3.5	60	2/11/115	60	FZ/TR	22	163445 ●
									2/19/120
Homag, Anthon	600	5.8	4.0	60	2/19/120	60	FZ/TR	22	163446 ●
									2/11/115
									2/11/85
Homag, Anthon	600	5.8	4.0	60	2/19/120	72	FZ/TR	22	163447 ●
									2/11/115
									2/11/85
Homag	670	5.8	4.2	60	2/11/148	42	FZ/TR	22	163448 ●
									2/19/120
Schelling	680	6.2	4.2	40	2/13/114	60	FZ/TR	22	163449 ●
									2/13/140
Anthon	700	6.2	4.4	80	1/17/110	60	FZ/TR	22	163450 ●
Schelling	720	6.5	4.5	40	2/13/140	60	FZ/TR	22	163451 ●
									2/13/114
Homag	730	6.2	4.2	60	2/11/148	60	FZ/TR	22	163452 ●
									2/19/120
Anthon	750	7.0	5.0	80	1/17/110	70	FZ/TR	22	163453 ●



Sizing of single boards in finish cut *Quality Excellent - RazorCut*

Application:

For panel sizing of single boards and stacks of boards with low cutting heights (up to 60 mm) without scoring.

Machine:

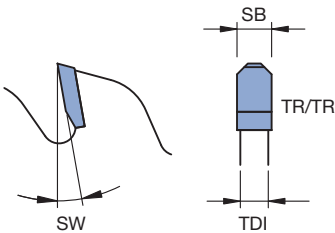
Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

Chipboard and fibre materials plastic coated, duroplastics (compact laminate panels, e.g. HPL), solid surface materials (e.g. Corian).

Technical information:

Special cutting geometry for excellent cutting results in finish cut quality. **Excellent** design with plastic filled laser ornaments for vibration damping and reduction of noise level. Irregular tooth pitch.



Circular sawblade RazorCut

WK 878 2 87

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			Deg.		
Striebig	250	3.2	2.2	30	KNL	60	TR/TR	15	■ ■ ■ ■ ■	161100 ●
Panhans	280	3.2	2.2	30	KNL	60	TR/TR	15	■ ■ ■ ■ ■	161101 ●
Höfer, Langzauner, Panhans	300	4.4	3.2	30	KNL	60	TR/TR	15	■ ■ ■ ■ ■	161102 ●
Striebig	300	3.2	2.2	30	KNL	72	TR/TR	15	■ ■ ■ ■ ■	161103 ●
Homag	300	4.4	3.2	60	2/14/100	72	TR/TR	15	■ ■ ■ ■ ■	161104 ●
Homag	308	3.2	2.4	60	2/14/100	96	TR/TR	15	■ ■ ■ ■ ■	161105 ●
Homag	310	4.4	3.2	60		72	TR/TR	15	■ ■ ■ ■ ■	161106 ●
Giben	320	4.4	3.2	50	3/15/80	60	TR/TR	15	■ ■ ■ ■ ■	161107 ●
Höfer, Langzauner, Panhans, Schelling	350	4.4	3.2	30	KNL	72	TR/TR	15	■ ■ ■ ■ ■	161108 ●
Homag	350	4.4	3.2	60	2/14/100	72	TR/TR	15	■ ■ ■ ■ ■	161109 ●
Homag	350	4.4	3.2	75		72	TR/TR	15	■ ■ ■ ■ ■	161110 ●
Giben, Homag	355	4.4	3.2	75		72	TR/TR	15	■ ■ ■ ■ ■	161111 ●
Selco	355	4.4	3.2	80	2/9/130	72	TR/TR	15	■ ■ ■ ■ ■	161112 ●
Schelling	360	4.4	3.2	30	2/13/94	72	TR/TR	15	■ ■ ■ ■ ■	161113 ●
Panhans	370	4.4	3.2	30	KNL	72	TR/TR	15	■ ■ ■ ■ ■	161114 ●
Holz-Her	380	4.4	3.2	30	KNL	72	TR/TR	15	■ ■ ■ ■ ■	161132 ●
Giben	380	4.4	3.2	50	4/13/80	72	TR/TR	15	■ ■ ■ ■ ■	161115 ●
Homag	380	4.4	3.2	60	2/14/100	72	TR/TR	15	■ ■ ■ ■ ■	161116 ●
Homag	380	4.8	3.5	60	2/14/100	72	TR/TR	15	■ ■ ■ ■ ■	161117 ●
Höfer, Panhans, Scheer, Schelling	400	4.4	3.2	30	KNL	72	TR/TR	15	■ ■ ■ ■ ■	161118 ●
Giben, Homag	400	4.4	3.2	75	4/15/105	72	TR/TR	15	■ ■ ■ ■ ■	161119 ●
Selco	400	4.4	3.2	80	2/9/130	72	TR/TR	15	■ ■ ■ ■ ■	161120 ●
Gabbiani, SCM	400	4.4	3.2	80	4/9/100	72	TR/TR	15	■ ■ ■ ■ ■	161121 ●
Homag	420	4.8	3.5	60	2/14/125	72	TR/TR	15	■ ■ ■ ■ ■	161122 ●
Schelling	430	4.4	3.2	30	KNL	72	TR/TR	15	■ ■ ■ ■ ■	161123 ●
Giben	430	4.4	3.2	75	4/15/105	72	TR/TR	15	■ ■ ■ ■ ■	161124 ●
Selco	430	4.4	3.2	80	2/9/130	72	TR/TR	15	■ ■ ■ ■ ■	161125 ●
Scheer, Schelling	450	4.4	3.2	30	2/13/94	72	TR/TR	15	■ ■ ■ ■ ■	161126 ●



- Solid wood
- Board, coated
- Board, uncoated
- Non-ferrous metals
- Plastics
- Mineral materials
- Composites
- Steel, thin-walled

1. Sawing

1.4 Panel sizing

1.4.3 Panel sizing sawblades TR/TR

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW Deg.	WSS	ID
Homag	450	4.8	3.5	60	2/14/125	72	TR/TR	15	●●●	161127 ●
Selco	450	4.8	3.5	80	2/9/130	72	TR/TR	15	●●●	161128 ●
Schelling	460	4.4	3.2	30	2/13/94	72	TR/TR	15	●●●	161129 ●
Homag	480	4.8	3.5	60	2/19/120	72	TR/TR	15	●●●	161130 ●
Selco	480	4.8	3.5	80	2/9/130	72	TR/TR	15	●●●	161133 □
Schelling	520	4.8	3.5	30	2/13/94	72	TR/TR	15	●●●	161131 ●



Sizing of single boards and stacks of boards *Premium*

Application:

For panel sizing of single boards and stacks of boards with scoring.

Machine:

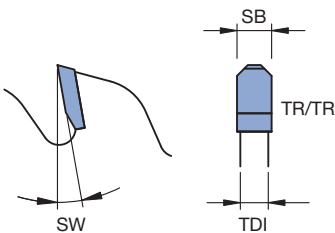
Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

Chipboard and fibre materials plastic coated, duroplastics (compact laminate panels, e.g. HPL).

Technical information:

Premium design with vibration damping laser ornaments.



Circular sawblade

WK 858 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW Deg.	WSS	ID
Höfer, Langzauner, Panhans	300	4.4	3.2	30	KNL	60	TR/TR	15	●●●	163350 ●
Selco	300	4.4	3.2	65	2/9/110	60	TR/TR	15	●●●	163351 ●
Selco	320	4.4	3.2	65	2/9/110	60	TR/TR	15	●●●	163352 ●
Holz-Her, Höfer, Langzauner, Panhans, Schelling	350	4.4	3.2	30	KNL	72	TR/TR	15	●●●	163353 ●
Homag	350	4.4	3.2	60	2/14/100	72	TR/TR	15	●●●	163354 ●
Selco	355	4.4	3.2	65	2/9/110	72	TR/TR	15	●●●	163355 ●
Schelling	360	4.4	3.2	30	KNL	72	TR/TR	15	●●●	163356 ●
Holz-Her	380	4.4	3.2	30	KNL	72	TR/TR	15	●●●	163357 ●
Homag	380	4.8	3.5	60	2/14/100	84	TR/TR	15	●●●	163358 ●
Selco	380	4.4	3.2	65	2/9/110	72	TR/TR	15	●●●	163359 ●
Höfer, Panhans, Scheer, Schelling	400	4.4	3.2	30	KNL	72	TR/TR	15	●●●	163360 ●
Selco	400	4.4	3.2	65	2/9/110	72	TR/TR	15	●●●	163361 ●
Selco	430	4.4	3.2	65	2/9/110	72	TR/TR	15	●●●	163362 ●
Scheer, Schelling	450	4.4	3.2	30	KNL	72	TR/TR	15	●●●	163363 ●
Homag	450	4.8	3.5	60	2/14/125	72	TR/TR	15	●●●	163364 ●
Schelling	460	4.4	3.2	30	2/13/94	72	TR/TR	15	●●●	163365 ●
Selco	470	4.8	3.5	70	4/11/130	72	TR/TR	15	●●●	163366 ●
Anthon, Homag	500	4.8	3.5	60	2/11/115	72	TR/TR	15	●●●	163367 ●
Homag	520	4.8	3.5	60	2/19/120	84	TR/TR	15	●●●	163368 ●

1. Sawing

1.4 Panel sizing

1.4.3 Panel sizing sawblades TR/TR



Sizing of single boards and stacks of boards *Excellent*

Application:

For panel sizing of single boards and stacks of boards with scoring.

Machine:

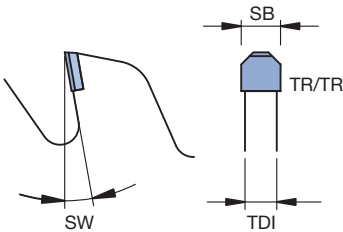
Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

Chipboard and fibre materials plastic coated, gypsum plaster and cement boards, duroplastics (compact laminate panels, e.g. HPL), fibre reinforced materials (e.g. GFRP, CFRP).

Technical information:

DP tipped for long tool life. Irregular tooth pitch for better running. **Excellent** design with plastic filled laser ornaments for damping vibration and noise reduction.



Panel sizing sawblade TR/TR, Diamaster PLUS

WK 278 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			Deg.		
Höfer, Langzauner, Panhans	300	4.4	3.2	30	KNL	60	TR/TR	10	■ ■ ■	190706 ●
Holz-Her, Höfer, Langzauner, Panhans, Schelling	350	4.4	3.2	30	KNL	72	TR/TR	10	■ ■ ■	190707 ●
Homag	350	4.4	3.2	60	2/14/100	72	TR/TR	10	■ ■ ■	190708 ●
Homag	380	4.4	3.2	60	2/14/100	72	TR/TR	10	■ ■ ■	190709 ●
Homag	380	4.8	3.5	60	2/14/125	72	TR/TR	10	■ ■ ■	190710 ●
Höfer, Panhans, Scheer, Schelling	400	4.4	3.2	30	KNL	72	TR/TR	10	■ ■ ■	190711 ●
Homag	450	4.8	3.5	60	2/14/125	72	TR/TR	10	■ ■ ■	190712 ●



Scoring sawblade KON/WZ

Application:

For scoring with feed.

Machine:

Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), alu composite panels (z.B. Alucobond®).

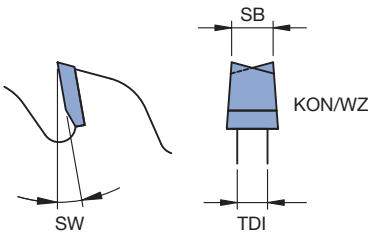
Technical information:

Scoring depth 1.50 - 2.00 mm. Scoring sawblade has to be selected according to the cutting width of the main sawblade.



Scoring sawblade KON/WZ, HW design

WK 856 2 01, WK 856 2 05



Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	n _{max}	WSS ID
	mm	mm	mm	mm	mm				Deg. min ⁻¹	
Panhans	125	3.2	2.5	20		24	KON/WZ	5	18300	165550 ●
	125	3.2	2.5	22		24	KON/WZ	5	18300	165551 ●
Giben, Homag, Mayer	125	4.4	3.5	45		24	KON/WZ	5	15200	165553 ●
Schelling	150	4.4	3.5	20		24	KON/WZ	5	15200	165554 ●
Felder, Mayer	150	4.4	3.5	30		36	KON/WZ	5	15200	165555 ●
Felder, Mayer	150	4.4	3.5	30		24	KON/WZ	5	15200	165556 ●
Homag	150	4.4	3.5	45		24	KON/WZ	5	15200	165557 ●
Homag	150	4.4	3.5	45		28	KON/WZ	5	14300	165558 ●
	160	3.2	2.5	20		32	KON/WZ	5	14300	165559 ●
Steton	160	4.4	3.5	30		36	KON/WZ	5	14300	165560 ●
Giben	160	4.4	3.5	45	3/11/70	36	KON/WZ	5	14300	165561 ●
Gabbiani	160	4.4	3.5	55	3/7/66	36	KON/WZ	5	12700	165562 ●
					3/6/84					
Höfer	180	3.2	2.5	20		36	KON/WZ	5	12700	165563 ●
	180	4.4	3.5	20		36	KON/WZ	5	12700	165564 ●
Homag	180	4.4	3.5	45		30	KON/WZ	5	12700	165565 ●
Anthon	180	4.4	3.5	45		36	KON/WZ	5	12700	165566 ●
Giben	180	4.5	3.2	50	3/13/80	36	KON/WZ	5	11400	165567 ●
Höfer,	200	4.4	3.5	20	2/11/66	24	KON/WZ	5	11400	165568 ●
Langzauner,										
Schelling										
Höfer,	200	4.4	3.5	20	2/11/66	36	KON/WZ	5	11400	165569 ●
Langzauner,										
Schelling										
	200	6.2	4.5	20	2/11/66	36	KON/WZ	5	11400	165570 ●
Scheer	200	3.2	2.5	30	2/10/60	60	KON/WZ	5	11400	165571 ●
Scheer	200	4.4	3.5	30	2/10/60	36	KON/WZ	5	11400	165572 ●
Schelling	200	4.8	3.5	20		36	KON/WZ	5	11400	165573 ●
Homag	200	4.4	3.5	45		36	KON/WZ	5	11400	165574 ●
Homag	200	5.8	4.6	45		36	KON/WZ	5	11400	165575 ●
Selco	200	4.4	3.5	65	2/9/100	36	KON/WZ	5	11400	165576 ●
					2/9/110					
Selco	200	4.8	3.5	65	2/9/100	36	KON/WZ	5	11400	165577 ●
					2/9/110					
Giben	215	4.4	3.5	50	3/15/80	42	KON/WZ	5	10600	165578 ●
					2/7/80					
Schelling	220	6.5	4.5	20	2/11/66	36	KON/WZ	5	10400	165579 ●
Homag	280	4.8	3.5	45		48	KON/WZ	5	8100	165580 ●
Homag	280	4.8	3.5	45		72	KON/WZ	5	8100	165581 ●
Schelling	300	4.4	3.5	30	2/11/73	48	KON/WZ	5	7600	165582 ●
Giben	300	4.4	3.5	50	3/15/80	48	KON/WZ	5	7600	165583 ●
Selco	300	4.4	3.5	65	2/9/100	72	KON/WZ	5	7600	165584 ●
					2/9/110					
Selco	300	4.4	3.5	65	3/15/80	48	KON/WZ	5	7600	165585 □
					2/9/110					



Scoring sawblades KON/FZ

Application:

For scoring with feed.

Machine:

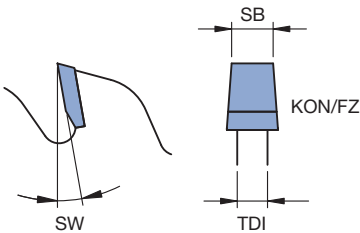
Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), alu composite panels (z.B. Alucobond®).

Technical information:

Scoring depth 1.50 - 2.00 mm. Scoring sawblade has to be selected according to the cutting width of the main sawblade.



Scoring sawblades KON/FZ, HW design

WK 804 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	n _{max}	WSS	ID
	mm	mm	mm	mm	mm			Deg.	min ⁻¹		
SCM	100	3.2	2.5	20		20	KON/FZ	5	22900		165625 ●
	100	3.2	2.5	22		20	KON/FZ	5	22900		165626 ●
	120	3.2	2.5	20		24	KON/FZ	5	19000		165627 ●
Panhans	125	4.4	3.5	20		24	KON/FZ	5	18300		165628 ●
Holz-Her	125	4.4	3.5	45		24	KON/FZ	5	18300		165629 ●
Anthon	180	4.4	3.5	20		28	KON/FZ	5	12700		165630 ●
Anthon	180	5.8	4.0	20		36	KON/FZ	5	12700		165631 ●
Holz-Her	180	4.4	3.5	30	2/10/60	30	KON/FZ	5	12700		165632 ●
Homag	180	4.4	3.5	45		36	KON/FZ	5	12700		165633 ●
Homag	180	4.8	3.5	45		36	KON/FZ	5	12700		165634 ●
Anthon	200	6.8	4.2	20		36	KON/FZ	5	11400		165635 ●
Homag	200	4.8	3.5	45		36	KON/FZ	5	11400		165636 ●
SCM	200	4.4	3.5	80	2/14/110	36	KON/FZ	5	11400		165637 ●
Homag	220	3.2	2.4	45		60	KON/FZ	5	10400		165638 ●
Panhans	250	4.4	3.5	30	2/10/60	42	KON/FZ	5	9100		165639 ●
Holz-Her	280	4.4	3.5	30	2/10/60	48	KON/FZ	5	9100		165640 ●



Scoring sawblades KON/FZ *Excellent*

Application:

For scoring with feed.

Machine:

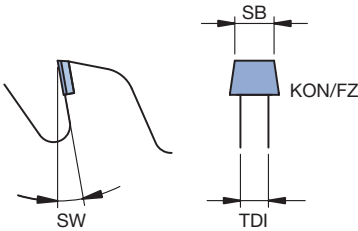
Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), alu composite panels (z.B. Alucobond®).

Technical information:

Scoring depth 2.00 - 2.50 mm. DP tipped for long tool life. Scoring sawblade has to be selected according to the cutting width of the main sawblade. Usable in combination with HW and DP tipped main sawblade. For use in combination with resharpened HW tipped main sawblades the cutting width (SB) of scoring sawblade is 0.1 mm less.



Scoring sawblades KON/FZ, Diamaster PLUS

WK 804 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	n _{max}	WSS	ID
	mm	mm	mm	mm	mm			Deg.	min ⁻¹		
Panhans	125	3.1	2.5	20		20	KON/FZ	10	18300		190564 ●
Felder, Mayer	150	4.3	3.2	30		24	KON/FZ	10	15200		190565 ●
Gabbiani	160	4.3	3.5	55	3/ 7/ 66	30	KON/FZ	10	14300		190566 ●
Holz-Her	180	4.3	3.5	30	2/10/ 60	30	KON/FZ	10	12700		190567 ●
Homag	180	4.3	3.5	45		30	KON/FZ	10	12700		190568 ●
Homag	180	4.7	3.5	45		30	KON/FZ	10	12700		190569 ●
Höfer,	200	4.3	3.5	20	2/11/66	30	KON/FZ	10	11400		190570 ●
Langzauner,											
Schelling											
Scheer	200	4.3	3.5	30	2/10/ 60	30	KON/FZ	10	11400		190571 ●
Homag	200	4.3	3.5	45		30	KON/FZ	10	11400		190572 ●
Selco	200	4.3	3.5	65	2/ 9/100	30	KON/FZ	10	11400		190615 ●
					2/ 9/110						

1. Sawing

1.4 Panel sizing

1.4.5 Scoring sawblades - softforming / postforming



Scoring sawblade - softforming / postforming

Application:

For scoring with feed at high feed rates and deep cutting depths.

Machine:

Panel sizing saws with adjustable soft and postforming units and pressure beam.

Workpiece material:

Chipboard and fibre materials paper and plastic coated.

Technical information:

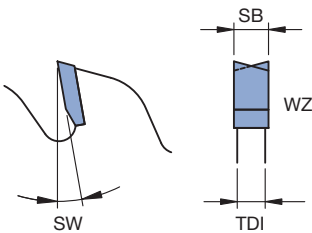
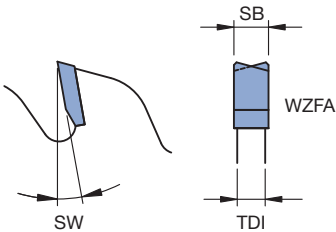
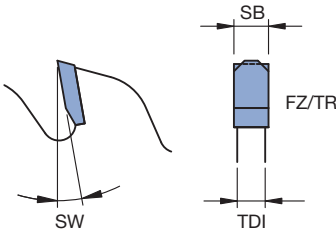
Tooth shape according to machine manufacturers' specification.



Circular sawblade FZ/TR

WK 852 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	n_{max}	WSS	ID
	mm	mm	mm	mm	mm			Deg.	min^{-1}		
Panhans	220	3.35	2.5	30		30	FZ/TR	10	10400	■	165676 ●
Panhans	250	4.55	3.2	30	2/10/60	48	FZ/TR	10	9100	■	165677 ●
Holz-Her	280	4.55	3.2	30	2/10/60	60	FZ/TR	10	8100	■	165678 ●
Homag	280	3.45	2.4	45		60	FZ/TR	10	8100	■	165675 ●
Homag	350	4.55	3.2	75		72	FZ/TR	10	6500	■	165679 ●
Scheer	450	4.8	3.5	30	2/10/60	72	FZ/TR	10	4200	■	165680 ●



Circular sawblade WZFA

WK 251 2, WK 851 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	n_{max}	WSS	ID
	mm	mm	mm	mm	mm			Deg.	min^{-1}		
Panhans	180	4.55	3.2	30		36	WZFA	10	12700	■	165681 ●
Schelling	300	4.55	3.2	30		72	WZFA	10	7600	■	165682 ●
Selco	300	4.55	3.2	65	2/9/110	72	WZFA	10	7600	■	165683 ●

Circular sawblade WZ

WK 850 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	n_{max}	WSS	ID
	mm	mm	mm	mm	mm			Deg.	min^{-1}		
Homag	280	4.55	3.2	45		84	WZ	10	8100	■	165684 ●
Homag	280	4.95	3.5	45		84	WZ	10	8100	■	165685 ●

1. Sawing

1.4 Panel sizing

1.4.6 Overview scoring and main sawblades

Machine – Type	Tool Type	ABM mm	Z	QAL	ZF	System	ID
Holz-Her- Tectra 6120 Classic	Main sawblade	350x4.4x30	54	HW	WZ		163301 ●
	Main sawblade	350x4.4x30	72	HW	WZ		163302 ●
	Main sawblade	350x4.4x30	72	HW	FZ/TR		163408 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut	161108 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR		163353 ●
	Main sawblade	350x4.4x30	72	DP	TR/TR		190707 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ	AS LowNoise UT	190567 ●
Holz-Her- Tectra 6120 Dynamic, Lift, Power	Main sawblade	380x4.4x30	72	HW	TR/TR	RazorCut	161132 ●
	Main sawblade	380x4.4x30	72	HW	TR/TR		163357 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ	AS LowNoise UT	190567 ●
Holz-Her- Zentrex 6220 Classic	Main sawblade	380x4.4x30	72	HW	TR/TR	RazorCut	161132 ●
	Main sawblade	380x4.4x30	72	HW	TR/TR		163357 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ	AS LowNoise UT	190567 ●
Holz-Her- Zentrex 6220 Dynamic, Lift, Power	Main sawblade	430x4.4x30	72	HW	WZ		163310 ●
	Main sawblade	430x4.4x30	72	HW	FZ/TR		163427 ●
	Main sawblade	430x4.4x30	72	HW	TR/TR	RazorCut	161123 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ	AS LowNoise UT	190567 ●
Homag- HKL300	Main sawblade	350x4.4x60	72	HW	WZ		163304 ●
	Main sawblade	350x4.4x60	72	HW	FZ/TR		163409 ●
	Main sawblade	350x4.4x60	72	HW	TR/TR	RazorCut	161109 ●
	Main sawblade	350x4.4x60	72	HW	TR/TR		163354 ●
	Main sawblade	350x4.4x60	72	DP	TR/TR		190708 ●
	Scoring sawblade	180x4.4x45	30	HW	KON/WZ		165565 ●
	Scoring sawblade	180x4.4x45	36	HW	KON/WZ		165566 ●
	Scoring sawblade	180x4.4x45	36	HW	KON/FZ		165633 ●
	Scoring sawblade	180x4.3/5.1x45	30	DP	KON/FZ	AS LowNoise UT	190568 ●
Homag- HKL600	Main sawblade	600x5.8x60	60	HW	FZ/TR		163446 ●
	Main sawblade	600x5.8x60	72	HW	FZ/TR		163447 ●
	Scoring sawblade	200x5.8x45	36	HW	KON/WZ		165575 ●
Homag- HPP130	Main sawblade	300x4.4x60	72	HW	FZ/TR		163401 ●
	Main sawblade	300x4.4x60	72	HW	TR/TR	RazorCut	161104 ●
	Scoring sawblade	150x4.4x45	24	HW	KON/WZ		165557 ●
	Scoring sawblade	150x4.4x45	28	HW	KON/WZ		165558 ●
Homag- HPP200	Main sawblade	350x4.4x60	72	HW	WZ		163304 ●
	Main sawblade	350x4.4x60	72	HW	FZ/TR		163409 ●
	Main sawblade	350x4.4x60	72	HW	TR/TR	RazorCut	161109 ●
	Main sawblade	350x4.4x60	72	HW	TR/TR		163354 ●
	Main sawblade	350x4.4x60	72	DP	TR/TR		190708 ●
	Scoring sawblade	200x4.4x45	36	HW	KON/WZ		165574 ●
	Scoring sawblade	200x4.3/5.1x45	30	DP	KON/FZ	AS LowNoise UT	190572 ●
Homag- HPP300, HPL300, HKL300	Main sawblade	380x4.8x60	54	HW	WZ		163307 ●
	Main sawblade	380x4.4x60	72	HW	FZ/TR		163418 ●
	Main sawblade	380x4.8x60	72	HW	FZ/TR		163419 ●
	Main sawblade	380x4.4x60	72	HW	TR/TR	RazorCut	161116 ●
	Main sawblade	380x4.8x60	72	HW	TR/TR	RazorCut	161117 ●
	Main sawblade	380x4.8x60	84	HW	TR/TR		163358 ●
	Scoring sawblade	180x4.4x45	30	HW	KON/WZ		165565 ●
	Scoring sawblade	180x4.4x45	36	HW	KON/WZ		165566 ●
	Scoring sawblade	180x4.4x45	36	HW	KON/FZ		165633 ●
	Scoring sawblade	180x4.8x45	36	HW	KON/FZ		165634 ●
	Scoring sawblade	180x4.3/5.1x45	30	DP	KON/FZ	AS LowNoise UT	190568 ●
	Scoring sawblade	180x4.7/5.5x45	30	DP	KON/FZ	AS LowNoise UT	190569 ●

1. Sawing

1.4 Panel sizing

1.4.6 Overview scoring and main sawblades

Machine – Type	Tool Type	ABM mm	Z	QAL	ZF	System	ID
Homag-HPP400	Main sawblade	450x4.8x60	72	HW	FZ/TR		163431 ●
	Main sawblade	450x4.8x60	72	HW	TR/TR	RazorCut	161127 ●
	Main sawblade	450x4.8x60	72	HW	TR/TR		163364 ●
	Main sawblade	450x4.8x60	72	DP	TR/TR		190712 ●
	Scoring sawblade	180x4.8x45	36	HW	KON/FZ		165634 ●
	Scoring sawblade	180x4.7/5.5x45	30	DP	KON/FZ	AS LowNoise UT	190569 ●
Schelling-ASH	Main sawblade	720x6.5x40	60	HW	FZ/TR		163451 ●
	Scoring sawblade	220x6.5x20	36	HW	KON/WZ		165579 ●
Schelling-fh3	Main sawblade	300x4.4x30	48	HW	WZ		163300 ●
	Main sawblade	300x4.4x30	60	HW	FZ/TR		163400 ●
	Main sawblade	300x4.4x30	60	HW	TR/TR	RazorCut	161102 ●
	Main sawblade	300x4.4x30	60	HW	TR/TR		163350 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ	AS LowNoise UT	190567 ●
Schelling-fh3 Plus package	Main sawblade	350x4.4x30	54	HW	WZ		163301 ●
	Main sawblade	350x4.4x30	72	HW	WZ		163302 ●
	Main sawblade	350x4.4x30	72	HW	FZ/TR		163408 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut	161108 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR		163353 ●
	Main sawblade	350x4.4x30	72	DP	TR/TR		190707 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ	AS LowNoise UT	190567 ●
Schelling-fh4 (former version)	Main sawblade	350x4.4x30	54	HW	WZ		163301 ●
	Main sawblade	350x4.4x30	72	HW	WZ		163302 ●
	Main sawblade	350x4.4x30	72	HW	FZ/TR		163408 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut	161108 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR		163353 ●
	Main sawblade	350x4.4x30	72	DP	TR/TR		190707 ●
	Scoring sawblade	300x4.4x30	48	HW	KON/WZ		165582 ●
Schelling-fh4 (new version)	Main sawblade	360x4.4x30	72	HW	FZ/TR		163414 ●
	Main sawblade	360x4.4x30	72	HW	TR/TR	RazorCut	161113 ●
	Main sawblade	360x4.4x30	72	HW	TR/TR		163356 ●
	Scoring sawblade	200x4.4x20	24	HW	KON/WZ		165568 ●
	Scoring sawblade	200x4.4x20	36	HW	KON/WZ		165569 ●
	Scoring sawblade	200x4.3/5.1x20	30	DP	KON/FZ	AS LowNoise UT	190570 ●
Schelling-fh5	Main sawblade	400x4.4x30	60	HW	WZ		163308 ●
	Main sawblade	400x4.4x30	72	HW	WZ		163309 ●
	Main sawblade	400x4.4x30	72	HW	FZ/TR		163421 ●
	Main sawblade	400x4.4x30	72	HW	TR/TR	RazorCut	161118 ●
	Main sawblade	400x4.4x30	72	HW	TR/TR		163360 ●
	Main sawblade	400x4.4x30	72	DP	TR/TR		190711 ●
	Scoring sawblade	200x4.4x20	24	HW	KON/WZ		165568 ●
	Scoring sawblade	200x4.4x20	36	HW	KON/WZ		165569 ●
	Scoring sawblade	200x4.3/5.1x20	30	DP	KON/FZ	AS LowNoise UT	190570 ●
Schelling-fh6	Main sawblade	460x4.4x30	72	HW	FZ/TR		163434 ●
	Main sawblade	460x4.4x30	72	HW	TR/TR	RazorCut	161129 ●
	Main sawblade	460x4.4x30	72	HW	TR/TR		163365 ●
	Scoring sawblade	200x4.4x20	24	HW	KON/WZ		165568 ●
	Scoring sawblade	200x4.4x20	36	HW	KON/WZ		165569 ●
	Scoring sawblade	200x4.3/5.1x20	30	DP	KON/FZ	AS LowNoise UT	190570 ●
Schelling-fh8, fm8	Main sawblade	520x4.4x30	72	HW	WZ		163316 ●
	Main sawblade	520x4.4x30	72	HW	FZ/TR		163442 ●
	Main sawblade	520x4.8x30	72	HW	TR/TR	RazorCut	161131 ●
	Scoring sawblade	200x4.4x20	24	HW	KON/WZ		165568 ●
	Scoring sawblade	200x4.4x20	36	HW	KON/WZ		165569 ●
	Scoring sawblade	200x4.8x20	36	HW	KON/WZ		165573 ●
	Scoring sawblade	200x4.3/5.1x20	30	DP	KON/FZ	AS LowNoise UT	190570 ●
Schelling-fm10	Main sawblade	680x6.2x40	60	HW	FZ/TR		163449 ●
	Scoring sawblade	200x6.2x20	36	HW	KON/WZ		165570 ●

- Solid wood
- Board, coated
- Board, uncoated
- Non-ferrous metals
- Plastics
- Mineral materials
- Composites
- Steel, thin-walled

1. Sawing

1.4 Panel sizing

1.4.6 Overview scoring and main sawblades

Machine – Type	Tool Type	ABM mm	Z	QAL	ZF	System	ID
Schelling- fm6	Main sawblade	460x4.4x30	72	HW	FZ/TR		163434 ●
	Main sawblade	460x4.4x30	72	HW	TR/TR	RazorCut	161129 ●
	Main sawblade	460x4.4x30	72	HW	TR/TR		163365 ●
	Scoring sawblade	200x4.4x20	24	HW	KON/WZ		165568 ●
	Scoring sawblade	200x4.4x20	36	HW	KON/WZ		165569 ●
	Scoring sawblade	200x4.3/5.1x20	30	DP	KON/FZ	AS LowNoise UT	190570 ●
Schelling- FSM	Main sawblade	720x6.5x40	60	HW	FZ/TR		163451 ●
Schelling- FTM Option	Main sawblade	680x6.2x40	60	HW	FZ/TR		163449 ●
	Scoring sawblade	220x6.5x20	36	HW	KON/WZ		165579 ●
Schelling- s45	Main sawblade	350x4.4x30	54	HW	WZ		163301 ●
	Main sawblade	350x4.4x30	72	HW	WZ		163302 ●
	Main sawblade	350x4.4x30	72	HW	FZ/TR		163408 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut	161108 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR		163353 ●
	Main sawblade	350x4.4x30	72	DP	TR/TR		190707 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ	AS LowNoise UT	190567 ●
Schelling- s45 Plus package	Main sawblade	400x4.4x30	60	HW	WZ		163308 ●
	Main sawblade	400x4.4x30	72	HW	WZ		163309 ●
	Main sawblade	400x4.4x30	72	HW	FZ/TR		163421 ●
	Main sawblade	400x4.4x30	72	HW	TR/TR	RazorCut	161118 ●
	Main sawblade	400x4.4x30	72	HW	TR/TR		163360 ●
	Main sawblade	400x4.4x30	72	DP	TR/TR		190711 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ	AS LowNoise UT	190567 ●
Selco- EB 100	Main sawblade	360x4.4x65	72	HW	FZ/TR		163415 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ	AS LowNoise UT	190615 ●
Selco- EB 70 (kit 80), EB 75, EB 80	Main sawblade	320x4.4x65	60	HW	TR/TR		163352 ●
	Main sawblade	320x4.4x65	60	HW	FZ/TR		163407 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ	AS LowNoise UT	190615 ●
Selco- EB 70 (L)	Main sawblade	300x4.4x65	60	HW	FZ/TR		163402 ●
	Main sawblade	300x4.4x65	60	HW	TR/TR		163351 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ	AS LowNoise UT	190615 ●
Selco- EB 90	Main sawblade	355x4.4x80	72	HW	TR/TR	RazorCut	161112 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ	AS LowNoise UT	190615 ●
Selco- EB 95	Main sawblade	355x4.4x65	72	HW	FZ/TR		163412 ●
	Main sawblade	355x4.4x65	72	HW	TR/TR		163355 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ	AS LowNoise UT	190615 ●
Selco- EB 110, EB 108, EB 120, WN 125, WN 200, WN 600/132, WN 512, WN 600/145, WN 600/162	Main sawblade	400x4.4x80	72	HW	FZ/TR		163424 ●
	Main sawblade	400x4.4x80	72	HW	TR/TR	RazorCut	161120 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ	AS LowNoise UT	190615 ●
Selco- EB 120, WN 125	Main sawblade	430x4.4x80	72	HW	TR/TR	RazorCut	161125 ●
	Main sawblade	430x4.4x80	72	HW	FZ/TR		163429 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ	AS LowNoise UT	190615 ●

1. Sawing

1.4 Panel sizing

1.4.6 Overview scoring and main sawblades

Machine – Type	Tool Type	ABM mm	Z	QAL	ZF	System	ID
Selco- WN 600/132, WN 200	Main sawblade	450x4.8x80	72	HW	FZ/TR	RazorCut	163433 ●
	Main sawblade	450x4.8x80	72	HW	TR/TR		161128 ●
	Scoring sawblade	200x4.8x65	36	HW	KON/WZ		165577 ●
Selco- WN 600/145, WN 512	Main sawblade	480x4.8x80	72	HW	FZ/TR	RazorCut	163438 ●
	Main sawblade	480x4.8x80	72	HW	TR/TR		161133 □
	Scoring sawblade	200x4.8x65	36	HW	KON/WZ		165577 ●

1. Sawing

1.4 Panel sizing

1.4.7 Circular sawblades for floor production



Middle cuts

Application:

For cutting of panels along grain for floor production.

Machine:

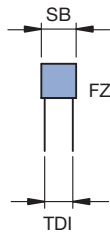
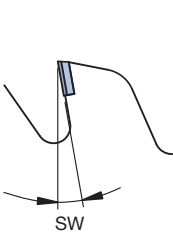
Multi blade saws.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered.

Technical information:

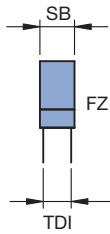
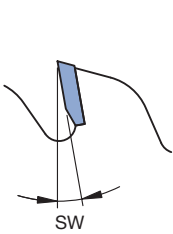
Circular sawblades BO = 115 mm for Hydro-Duo sleeve ID **030555** or BO = 110 mm for clamping flange TR 810 0. Tip height 5.5 mm.



Circular sawblade DP tipped

WK 800 2

Machine	D	SB	TDI	BO	NLA	DKN	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm	mm			Deg.		
Paul	210	2.2	1.6	100	4/7/120	13/109	36	FZ	3	■ ■	190676 □
Paul	210	2.2	1.6	115	8/7/131		36	FZ	3	■ ■	190677 □
Homag	250	2.0	1.6	100	3/18/150		48	FZ	3	■ ■	190678 □
Paul	250	2.0	1.6	100	4/7/140	13/109	48	FZ	3	■ ■	190679 □
Paul	250	2.0	1.6	115	8/7/131		48	FZ	3	■ ■	190680 □
Homag	250	2.2	1.6	100	3/18/150		36	FZ	3	■ ■	190681 □
Paul	250	2.2	1.6	100	4/7/140	13/109	36	FZ	3	■ ■	190682 □
Homag	250	2.2	1.6	100	3/18/150		48	FZ	3	■ ■	190684 □
Paul	250	2.2	1.6	100	4/7/140	13/109	48	FZ	3	■ ■	190685 □
Paul	250	2.2	1.6	115	8/7/131		36	FZ	3	■ ■	190683 □
Paul	250	2.2	1.6	115	8/7/131		48	FZ	3	■ ■	190686 □



Circular sawblade HW tipped

WK 800 2

D	SB	TDI	BO	NLA	DKN	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm			Deg.		
250	3.2	2.2	100	4/7/140	13/109	48	FZ	10	■ ■	061434 ●



Cross and mitre cuts

Application:

For trimming and mitre cuts - positioning of sawblade under the workpiece.

Machine:

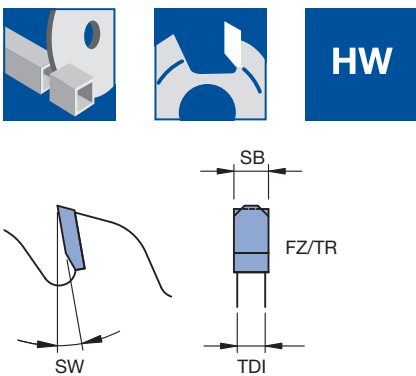
Cross, trimming, mitre and radial saws as well as double mitre cutting saws and CNC machining centres.

Workpiece material:

Non-ferrous metal or plastic profiles.

Technical information:

Spray lubrication recommended when processing non-ferrous metal profiles.



Circular sawblade FZ/TR cutting angle 5°

WK 452 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			Deg.		
Elumatec	280	3.2	2.6	32		96	FZ/TR	5	●	165725 ●
	300	3.2	2.6	30	KNL	72	FZ/TR	5	●	165726 ●
	300	3.2	2.6	30	KNL	96	FZ/TR	5	●	165727 ●
Rapid	320	3.2	2.6	30	KNL	84	FZ/TR	5	●	165728 ●
	350	3.4	2.8	30	KNL	84	FZ/TR	5	●	165729 ●
Rapid	350	3.2	2.6	30	KNL	108	FZ/TR	5	●	165730 ●
Emmegi	350	3.2	2.6	32	2/11/63	84	FZ/TR	5	●	165731 ●
					KNL					
Rapid	370	3.8	3.2	30	KNL	96	FZ/TR	5	●	165732 ●
Rapid	400	3.8	3.2	30	KNL	96	FZ/TR	5	●	165733 ●
Emmegi	400	3.8	3.2	32	2/11/63	96	FZ/TR	5	●	165734 □
Kaltenbach	400	3.8	3.2	50	4/15/80	96	FZ/TR	5	●	165735 □
Rapid, Elumatec	420	3.8	3.2	30	KNL	96	FZ/TR	5	●	165736 ●
	430	3.5	2.8	30	KNL	96	FZ/TR	5	●	165737 ●
	450	3.8	3.2	30	2/11/63	110	FZ/TR	5	●	165738 ●
					KNL					
Emmegi	450	3.8	3.2	32	2/11/63	96	FZ/TR	5	●	165739 ●
					KNL					
Rapid, Elumatec	500	4.4	3.8	30	KNL	120	FZ/TR	5	●	165740 ●
Emmegi	500	4.0	3.4	32	2/11/63	96	FZ/TR	5	●	165741 ●
Emmegi	500	4.0	3.4	32	2/11/63	120	FZ/TR	5	●	165742 ●
Elumatec	500	4.4	3.8	32	2/6/75	120	FZ/TR	5	●	165743 ●
					6/9.2-17.2/75					
Emmegi	550	4.0	3.4	32	2/11/63	96	FZ/TR	5	●	165744 ●
Emmegi	550	4.0	3.4	32	2/11/63	126	FZ/TR	5	●	165745 ●
Elumatec	550	4.4	3.8	30	KNL	120	FZ/TR	5	●	165746 ●
Stegmaier	600	4.6	4.0	30	2/11/63	140	FZ/TR	5	●	165747 ●
	600	5.0	4.4	32	2/11/63	132	FZ/TR	5	●	165748 ●
	650	5.0	4.4	30	2/11/63	144	FZ/TR	5	●	165749 ●

1. Sawing

1.5 Cutting non-ferrous metals and plastics

1.5.1 Cross and mitre cut sawblades for profiles



Cross and mitre cuts *Excellent*

Application:

For trimming and mitre cuts - positioning of sawblade under the workpiece.

Machine:

Cross, trimming, mitre and radial saws as well as double mitre cutting saws and CNC machining centres.

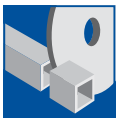
Workpiece material:

Non-ferrous metal or plastic profiles.

Technical information:

Spray lubrication recommended when processing non-ferrous metal profiles.

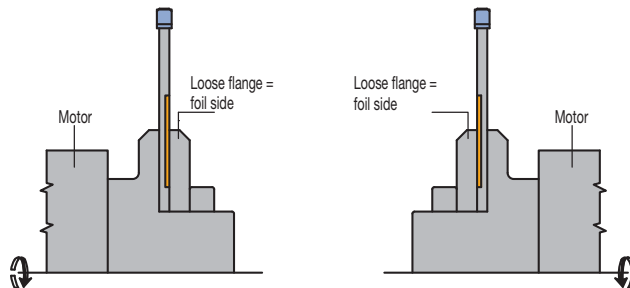
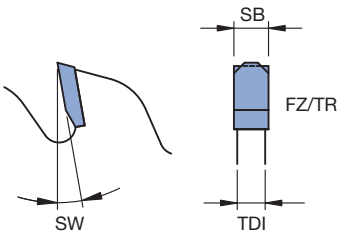
Excellent design. Tool body with vibration damping steel foil.



Circular sawblade FZ/TR cutting angle 5°

WK 472 2

D	SB	TDI	BO	NLA	Z	ZF	SW	Foil	WSS	ID
mm	mm	mm	mm	mm			Deg.			
300	3.2	2.6	30	KNL	96	FZ/TR	5	left		161360 ●
300	3.2	2.6	30	KNL	96	FZ/TR	5	right		161361 ●
350	3.2	2.6	30	KNL	108	FZ/TR	5	left		161362 ●
350	3.2	2.6	30	KNL	108	FZ/TR	5	right		161363 ●





Crossing and mitre cuts with negative cutting angle

Application:

For trimming and mitre cuts - positioning of workpiece under the sawblade.

Machine:

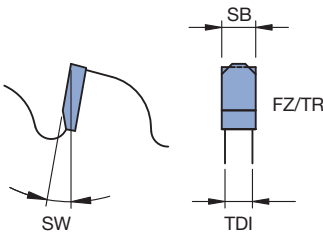
Cross, trimming, mitre and radial saws as well as double mitre cutting saws and CNC machining centres.

Workpiece material:

Non-ferrous metal or plastic profiles.

Technical information:

Spray lubrication recommended when processing non-ferrous metal profiles. Negative cutting angle for cuts from above.



Circular sawblade FZ/TR cutting angle -5°

WK 462 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			Deg.		
	300	3.2	2.6	30	KNL	72	FZ/TR	-5	■	165825 ●
	300	3.2	2.6	30	KNL	96	FZ/TR	-5	■	165826 ●
Elektra Beckum, Elu, DeWalt, Fezer, Lurem, Rapid, Ulmia, Scheppach										
Fezer, Rapid, Ulmia	300	3.2	2.6	30	KNL	120	FZ/TR	-5	■	165827 ●
	300	3.2	2.6	32	KNL	72	FZ/TR	-5	■	165828 □
	300	3.2	2.6	32	KNL	96	FZ/TR	-5	■	165829 □
	300	3.2	2.6	32	KNL	120	FZ/TR	-5	■	165830 □
Haffner	330	3.2	2.6	30	KNL	96	FZ/TR	-5	■	165831 ●
	330	3.2	2.6	32	KNL	96	FZ/TR	-5	■	165832 □
Haffner	350	3.4	2.8	30	KNL	84	FZ/TR	-5	■	165833 ●
	350	3.8	3.2	30	KNL	84	FZ/TR	-5	■	165834 ●
	350	3.8	3.2	32	KNL	84	FZ/TR	-5	■	165835 □
	350	3.8	3.2	40	2/10/55	84	FZ/TR	-5	■	165836 □
					2/11/63					
					KNL					
Haffner, Ulmia	350	3.2	2.6	30	KNL	108	FZ/TR	-5	■	165837 ●
Eisele, Graule	350	3.6	3.0	40	2/9/55	108	FZ/TR	-5	■	165838 ●
					4/12/64					
Elumatec	380	3.8	3.2	32		108	FZ/TR	-5	■	165839 ●
	400	3.8	3.2	30	KNL	96	FZ/TR	-5	■	165840 ●
	400	3.8	3.2	32	2/11/63	96	FZ/TR	-5	■	165841 ●
Eisele	400	3.8	3.2	40	2/12/80	96	FZ/TR	-5	■	165842 □
					4/12/64					
Kaltenbach	400	3.8	3.2	50	4/15/80	96	FZ/TR	-5	■	165843 □
Elumatec, Rapid, Haffner, Wegoma, Ulmia	420	3.8	3.2	30	KNL	108	FZ/TR	-5	■	165844 ●
Graule	420	3.8	3.2	40		108	FZ/TR	-5	■	165845 □
Rapid	450	3.8	3.2	30	KNL	108	FZ/TR	-5	■	165846 ●
Pressta Eisele	450	3.8	3.2	32	2/11/63	108	FZ/TR	-5	■	165847 □
					KNL					
Elu, Wegoma, Rapid	500	4.4	3.8	30	2/11/63	120	FZ/TR	-5	■	165848 ●
					6/9/100					
Graule	520	4.4	3.8	50		120	FZ/TR	-5	■	165849 ●
Rapid	550	4.0	3.4	30	KNL	132	FZ/TR	-5	■	165850 ●
	550	4.0	3.4	32	2/11/63	132	FZ/TR	-5	■	165851 □
Stürtz	600	5.2	4.6	30	KNL	138	FZ/TR	-5	■	165852 ●

1. Sawing

1.5 Cutting non-ferrous metals and plastics

1.5.1 Cross and mitre cut sawblades for profiles



Crossing and mitre cuts with negative cutting angle *Excellent*

Application:

For trimming and mitre cuts - positioning of workpiece under the sawblade.

Machine:

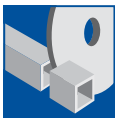
Cross, trimming, mitre and radial saws as well as double mitre cutting saws and CNC machining centres.

Workpiece material:

Non-ferrous metal or plastic profiles.

Technical information:

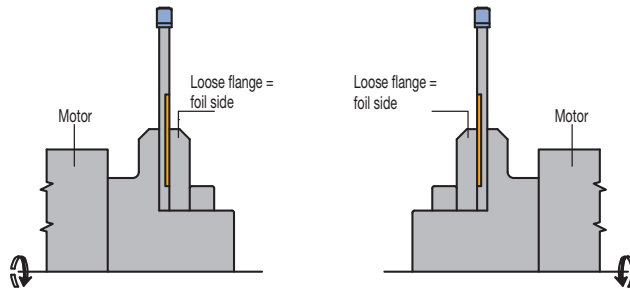
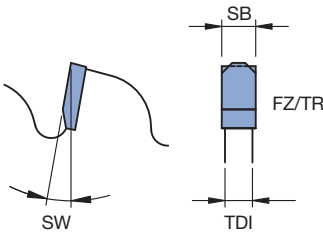
Spray lubrication recommended when processing non-ferrous metal profiles. Negative cutting angle for cuts from above. **Excellent** design. Tool body with vibration damping steel foil.



Circular sawblade FZ/TR cutting angle -5°

WK 482 2

D	SB	TDI	BO	NLA	Z	ZF	SW	Foil	WSS	ID
mm	mm	mm	mm	mm			Deg.			
300	3.2	2.6	30	KNL	96	FZ/TR	-5	left		161380 ●
300	3.2	2.6	30	KNL	96	FZ/TR	-5	right		161381 ●
350	3.2	2.6	30	KNL	108	FZ/TR	-5	left		161382 ●
350	3.2	2.6	30	KNL	108	FZ/TR	-5	right		161383 ●





Cross and mitre cuts with reduced cutting width *Premium*

Application:
For trimming and sizing.

Machine:
Cross, trimming, mitre and portable saws.

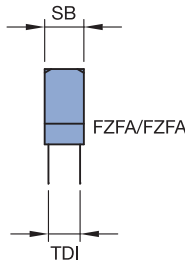
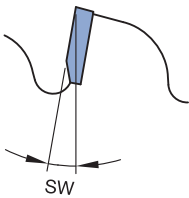
Workpiece material:
Thin walled, non-ferrous metal or plastic profiles, plastic honeycomb boards, fibre reinforced plastics (e.g. GFRP, CFRP), plastic wave boards (e.g. PVC).

Technical information:
Reduced cutting width for thin walled profiles and thin panels. Less resin build up by special coated tool body.



**Circular sawblade FZFA cutting angle -5°, thin kerf
WK 467 2**

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			Deg.		
160	1.6	1.2	20		60	FZFA/FZFA	-5		060277 ●
190	1.8	1.4	20		72	FZFA/FZFA	-5		060278 ●
200	1.8	1.4	30	KNL	80	FZFA/FZFA	-5		060274 ●
250	2.0	1.6	30	KNL	100	FZFA/FZFA	-5		060275 ●
300	2.2	1.8	30	KNL	120	FZFA/FZFA	-5		060276 ●
350	2.4	2.0	30	KNL	140	FZFA/FZFA	-5		060279 ●



1. Sawing

1.5 Cutting non-ferrous metals and plastics 1.5.1 Cross and mitre cut sawblades for profiles



Cross and mitre cuts in finish cut quality *Excellent* - GlossCut

Application:
For trimming and mitre cutting.

Machine:
Cross, trimming, mitre and cross cutting twin saws.

Workpiece material:
Non-ferrous metal or plastic profiles, coated and lacquered.

Technical information:
Cutting face with two different cutting angles for smooth surfaces and tear-free cutting edges. **Excellent** design with plastic filled laser ornaments for vibration damping and reduction of noise level.



Circular sawblade GlossCut WK 377 2

D	SB	TDI	BO	NLA	Z	ZF	WSS	ID
mm	mm	mm	mm	mm				
300	3.0	2.4	30	KNL	72	FZFA/FZFA		161005 ●
300	3.0	2.4	30	KNL	96	FZFA/FZFA		161006 ●
350	3.5	2.8	30	KNL	96	FZFA/FZFA		161007 ●

Further GlossCut dimensions suitable for portable and semi-stationary machines - see section Portable Saws and Table-Top Machines.



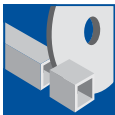
Cross and mitre cuts in finish cut quality *Excellent*

Application:
For trimming and mitre cutting.

Machine:
Cross, trimming, mitre and cross cutting twin saws.

Workpiece material:
Plastic profiles of windows with seals, plastic hollow wall profiles, fibre reinforced plastics, non-ferrous metal profiles.

Technical information:
Special tooth geometry for tear-free cutting edges on top and bottom side. DP tipped for long tool life.



Circular sawblade HRFA cutting angle 5°, Diamaster PRO WK 808 2 DP

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			Deg.		
300	4.4	3.6	30	KNL	60	HRFA	5		190666 □
350	4.4	3.6	30	KNL	70	HRFA	5		190667 □
400	4.4	3.6	30	KNL	80	HRFA	5		762339 □
450	4.4	3.6	30	KNL	90	HRFA	5		190668 □
500	4.4	3.6	30	KNL	100	HRFA	5		762341 □
550	4.4	3.6	30	KNL	110	HRFA	5		762342 □
600	4.8	4.0	30	KNL	120	HRFA	5		762343 □



Sizing in finish cut quality *Excellent* - BrillianceCut

Application:

For panel sizing of single boards and stacks of boards without scoring.

Machine:

Table and sizing saws, vertical panel sizing saws, panel sizing saws with pressure beam.

Workpiece material:

Transparent thermoplastics (e.g. PMMA, PC).

Technical information:

Special tooth geometry for very smooth surfaces and tear-free cutting edges. Recommended sawblade projection 5 - 10 mm. **Excellent** design with plastic filled laser ornaments for vibration damping and reduction of noise level. Design with positive cutting angle.

Circular sawblade BrillianceCut

WK 371 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	WSS	ID
	mm	mm	mm	mm	mm				
Altendorf, Martin, Striebig	303	3.5	2.5	30	KNL	60	TR/TR	■	161028 ●
Holz-Her, Höfer, Langzauner, Panhans, Schelling	350	4.4	3.2	30	KNL	72	WZ/FA	■	161029 ●
Homag	350	4.4	3.2	60	2/14/100	72	WZ/FA	■	161030 ●
Homag	380	4.8	3.5	60	2/14/100	84	WZ/FA	■	161031 ●
					2/14/125				
					2/19/120				
Höfer, Panhans, Scheer, Schelling	400	4.4	3.2	30	KNL	72	WZ/FA	■	161032 ●
Scheer, Schelling	450	4.4	3.2	30	KNL	72	WZ/FA	■	161033 ●
Homag	450	4.8	3.5	60	2/14/125	72	WZ/FA	■	161034 ●
					2/19/120				



Sizing in easy melting plastics *Premium*

Application:

For sizing and cross cutting without scoring.

Machine:

Table and sizing saws, vertical panel sizing saws, panel sizing saws with pressure beam.

Workpiece material:

Easy melting plastics (e.g. PP, PA).

Technical information:

Reduced number of teeth for reduced heating. Large gullets for optimum chip flow.

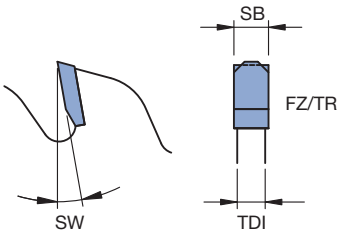
Premium design with vibration damping laser ornaments.



Circular sawblade FZ/TR, cutting angle 10°

WK 372 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			Deg.		
	300	3.6	2.2	30	KNL	20	FZ/TR	10	■	163500 ●
	300	3.6	2.2	30	KNL	42	FZ/TR	10	■	163501 ●
	350	3.8	2.5	30	KNL	24	FZ/TR	10	■	163502 ●
	350	3.8	2.5	30	KNL	48	FZ/TR	10	■	163503 ●
Höfer, Panhans, Scheer, Schelling	400	3.8	2.5	30	KNL	28	FZ/TR	10	■	163504 ●
Höfer, Panhans, Scheer, Schelling	400	3.8	2.5	30	KNL	54	FZ/TR	10	■	163505 ●
Scheer, Schelling	450	4.0	2.8	30	KNL	34	FZ/TR	10	■	163506 ●
Schelling	500	4.4	3.0	30	KNL	36	FZ/TR	10	■	163507 ●





Sizing non-ferrous solid material

Application:

For panel sizing of single boards and stacks of boards without scoring.

Machine:

Panel sizing saws with pressure beam.

Workpiece material:

Solid non-ferrous metals (e.g. aluminium or brass panels).

Technical information:

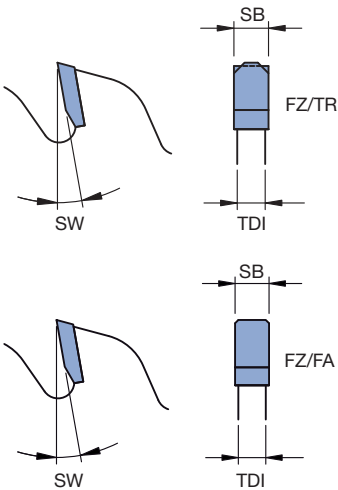
Special tungsten carbide grade for processing non-ferrous metals. Spray lubrication recommended.



Circular sawblade FZ/TR and FZFA, cutting angle 10°

WK 452 2, WK 457 2, WK 472 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			Deg.		
	350	3.8	3.0	30	KNL	48	FZFA/FZFA	10	■	165925 ●
	400	4.4	3.5	30	KNL	60	FZFA/FZFA	10	■	165926 ●
Schelling	450	4.4	3.5	30	KNL	60	FZ/TR	10	■	165927 ●
					2/13/94					
					2/13/107					
Schelling	460	4.4	3.5	30	2/13/94	48	FZFA/FZFA	10	■	165928 ●
					2/13/107					
Schelling	520	4.4	3.5	30	2/13/94	44	FZFA/FZFA	10	■	165929 ●
					2/13/107					
Schelling	530	4.4	3.5	30	2/13/94	44	FZFA/FZFA	10	■	165930 ●
					2/13/107					
Mayer	570	5.0	4.0	40	2/16/80	48	FZFA/FZFA	10	■	165931 ●
Schelling	620	5.5	4.5	40	2/13/140	36	FZFA/FZFA	10	■	165932 ●
					2/13/114					
Schelling	620	5.5	4.5	40	2/13/140	60	FZ/TR	10	■	165933 ●
					2/13/114					
Schelling	680	5.5	4.5	40	2/13/140	42	FZFA/FZFA	10	■	165934 ●
					2/13/114					



1. Sawing

1.5 Cutting non-ferrous metals and plastics 1.5.2 Circular sawblades für solid panels and blocks



Sizing *Excellent*

Application:

For sizing of single boards and stacks of boards.

Machine:

Table, sizing and vertical panel sizing saws.

Workpiece material:

Gypsum and cement fibre panels, duroplastics (compact laminated boards, e.g. HPL), fibre reinforced plastics (e.g. GFRP, CFRP), alu composite panels (e.g. Alucobond®).

Technical information:

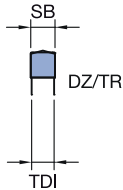
DP tipped for long tool life. **Excellent** design with plastic filled laser ornaments for damping vibrations and reduction of noise level.



Circular sawblade DZ/TR, Diamaster PRO

WK 872 2

D	SB	BO	NLA	Z	ZF	WSS	ID
mm	mm	mm	mm				
303	3.2	30	KNL	60	DZ/TR		190673 ●
303	3.2	30	KNL	96	DZ/TR		190674 ●





Trimming and sizing on CNC machining centres

Excellent - Katana

Application:

For sizing of panels on CNC machining centres.

Machine:

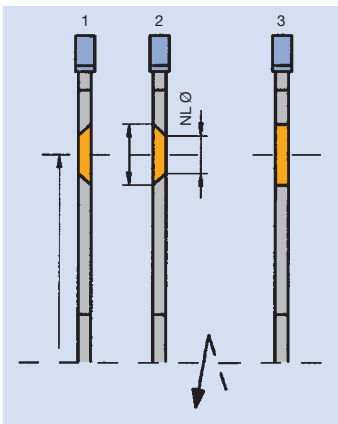
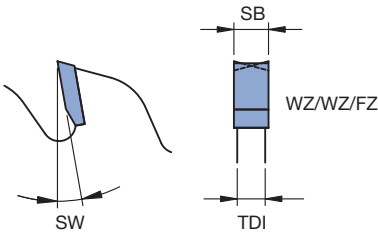
Processing units on CNC machining centres.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), solid wood panels across grain and for mitre joints.

Technical information:

Katana-tooth combination with alternate angle of cutting face for best cutting results. **Excellent** design with plastic filled laser ornaments for vibration damping and reduction of noise level. Mounting on flanges of processing units. When sizing wood derived materials first score with feed (1 - 2 mm) and then cut against feed.



- Type 1:** Countersink right
- Type 2:** Countersink left
- Type 3:** Pinhole without countersink

Circular sawblade Katana for CNC

WK 879 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Type	Z	ZF	SW Deg.	WSS	ID
Homag, Weeke	180	3.0	2.2	30	8/6.6/52	2	60	WZ/WZ/FZ	10	■ ■ ■	161250 ●
Flex 5, Flex 5+	180	3.0	2.2	40	8/6.6/52	2	60	WZ/WZ/FZ	10	■ ■ ■	161251 □
Homag, IMA	200	3.0	2.2	30	2/6.2/42	2	65	WZ/WZ/FZ	10	■ ■ ■	161253 ●
IMA	200	3.0	2.2	30	2/6.2/42	2	65	WZ/WZ/FZ	10	■ ■ ■	161254 ●
					4/6.6/60						
	220	3.0	2.2	30			70	WZ/WZ/FZ	10	■ ■ ■	161255 ●
Flex 5, Flex 5+, Homag, Weeke	220	3.0	2.2	40	8/6.6/52	2	70	WZ/WZ/FZ	10	■ ■ ■	161256 ●
	240	3.0	2.2	30	4/6.6/52	1.2	75	WZ/WZ/FZ	10	■ ■ ■	161257 ●
					4/6.6/52						
Flex 5, Flex 5+, Weeke, Homag	240	3.0	2.2	40	8/6.6/52	2	75	WZ/WZ/FZ	10	■ ■ ■	161258 ●
Biesse, Holz-Her	250	3.0	2.2	30	2/6/42	3	80	WZ/WZ/FZ	10	■ ■ ■	161259 ●
Homag, Felder Format-4	280	3.0	2.2	30	2/6/50	3	85	WZ/WZ/FZ	10	■ ■ ■	161260 ●

Technical information:

Reduced number of teeth for better cutting along grain and cuts with deep cutting depth when processing solid wood and solid wood panels.

Circular sawblade Katana, reduced number of teeth

WK 879 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Type	Z	ZF	SW Deg.	WSS	ID
Flex 5, Flex 5+, Homag, Weeke	220	3.0	2.2	30			55	WZ/WZ/ FZ	10	■ ■ ■	161261 ●
Flex 5, Flex 5+, Homag, Weeke	240	3.0	2.2	40	8/6.6/52	2	60	WZ/WZ/ FZ	10	■ ■ ■	161262 ●

- Solid wood
- Board, coated
- Board, uncoated
- Non-ferrous metals
- Plastics
- Mineral materials
- Composites
- Steel, thin-walled



Grooving on CNC machining centres

Application:

For grooving.

Machine:

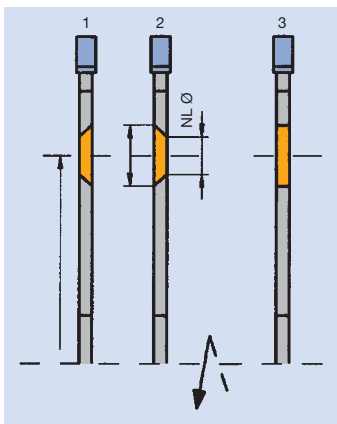
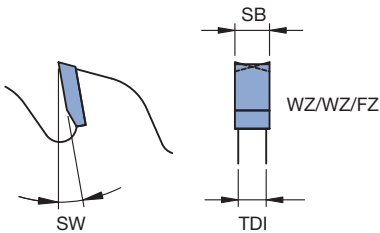
Processing units on CNC machining centres.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), duroplastics (compact laminate panels, e.g. HPL).

Technical information:

Tooth combination WZ/WZ/FR for tear-free grooves. Mounting on flanges of processing units.



Type 1:

Countersink right

Type 2:

Countersink left

Type 3:

Pinhole without countersink

Grooving circular sawblade WZ/WZ/FZ for CNC

WK 859 2

Machine	D	SB	TDI	BO	NLA	Type Z	ZF	SW	WSS ID	
	mm	mm	mm	mm	mm			Deg.		
Weeke	100	3.5	2.5	30		35	WZ/WZ/FZ	15	166000 ●	
Weeke	100	4.0	2.8	30		35	WZ/WZ/FZ	15	166008 ●	
Weeke	100	5.0	3.5	30		35	WZ/WZ/FZ	15	166001 ●	
SCM, Morbidelli	120	3.5	2.5	20	3/4.5/35	3	35	WZ/WZ/FZ	15	166002 ●
Biesse	120	3.5	2.5	35	4/6.3/50	2	35	WZ/WZ/FZ	15	166004 ●
SCM, Morbidelli	120	4.0	2.8	20	3/4.5/35	3	35	WZ/WZ/FZ	15	166009 ●
Biesse	120	4.0	2.8	35	4/6.3/50	2	35	WZ/WZ/FZ	15	166010 ●
SCM, Morbidelli	120	5.0	3.5	20	3/4.5/35	3	35	WZ/WZ/FZ	15	166003 ●
Biesse	120	5.0	3.5	35	4/6.3/50	2	35	WZ/WZ/FZ	15	166005 ●
Homag, Weeke	125	3.5	2.5	30	2x4/5.5/48	1.2	35	WZ/WZ/FZ	15	166006 ●
Homag, Weeke	125	4.0	2.8	30	2x4/5.5/48	1.2	35	WZ/WZ/FZ	15	166011 ●
Homag, Weeke	125	5.0	3.5	30	2x4/5.5/48	1.2	35	WZ/WZ/FZ	15	166007 ●



Universal sizing

Application:

For cutting along and across grain and sizing.

Machine:

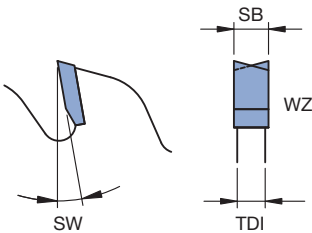
Portable and table saws.

Workpiece material:

Solid wood along and across grain, glued. Chipboard and fibre materials, plastic and paper coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), duroplastics (compact laminated boards e.g. HPL).

Technical information:

Tooth shape for universal use.



Circular sawblade WZ pos. cutting angle

WK 100 2, WK 150 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			Deg.		
Elu, DeWalt, Peugeot	100	2.4	1.6	12		30	WZ	10		166109 ●
Elu, DeWalt	100	2.4	1.6	22		30	WZ	10		166110 ●
Haffner, Mafell	120	2.4	1.6	20		24	WZ	15		166111 ●
Haffner, Mafell	125	2.4	1.6	20		24	WZ	15		166112 ●
Haffner, Mafell	125	2.4	1.6	20		36	WZ	10		166113 ●
AEG, Bosch, Holz-Her, Metabo	140	2.4	1.6	20		24	WZ	15		166114 ●
AEG, Atlas Copco, Elu, DeWalt, Metabo, Scheer, Skil	150	2.8	1.8	20		48	WZ	10		166115 ●
Metabo	160	1.6	1.1	20		24	WZ	25		166100 ●
AEG, Atlas Copco, Festool, Haffner, Hilti, Holz-Her, Mafell, Narex, Protool, Scheer	160	1.8	1.2	20		18	WZ	25		166101 ●
AEG, Atlas Copco, Festool, Haffner, Hilti, Holz-Her, Mafell, Narex, Protool, Scheer	160	1.8	1.2	20		32	WZ	5		166102 ●
AEG, Atlas Copco, Festool, Haffner, Hilti, Holz-Her, Mafell, Narex, Protool, Scheer	160	2.5	1.6	20		12	WZ	20		166116 ●
AEG, Atlas Copco, Festool, Haffner, Hilti, Holz-Her, Mafell, Narex, Protool, Scheer	160	2.5	1.6	20		24	WZ	15		166117 ●
AEG, Atlas Copco, Festool, Haffner, Hilti, Holz-Her, Mafell, Narex, Protool, Scheer	160	2.5	1.6	20		48	WZ	15		166118 ●
Bosch, DeWalt, Hilti, Makita	165	2.2	1.6	20		24	WZ	15		166119 ●
Bosch, DeWalt, Hilti, Makita	165	2.2	1.6	20		48	WZ	10		166104 ●
Bosch, DeWalt, Hilti, Makita	165	2.4	1.6	20		12	WZ	15		166103 ●
Bosch, Elu, DeWalt, Festool, Haffner	170	2.5	1.6	30		48	WZ	10		166120 ●
Haffner, Makita	180	2.5	1.6	20		24	WZ	15		166121 ●
Haffner, Makita	180	2.5	1.6	20		48	WZ	10		166122 ●
Bosch, Elu, DeWalt, Mafell	180	2.5	1.6	30		24	WZ	15		166123 ●
Bosch, Elu, DeWalt, Mafell	180	2.5	1.6	30		48	WZ	10		166105 ●
AEG, Bosch, DeWalt, Makita, Milwaukee, Skil, Black & Decker	184	2.5	1.6	20		24	WZ	15		166124 ●
AEG, Bosch, DeWalt, Makita, Milwaukee, Skil, Black & Decker	184	2.5	1.6	20		48	WZ	10		166106 ●
AEG, Atlas Copco, Bosch, Protool	190	2.5	1.8	30		24	WZ	20		166128 ●
Bosch, Skil	190	2.8	1.8	16		24	WZ	15		166125 ●
Bosch, Skil	190	2.8	1.8	16		48	WZ	10		166126 ●

1. Sawing

1.7 Portable saws and table-top machines

1.7.1 Circular sawblades WZ

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW Deg.	WSS	ID
AEG, Atlas Copco, Bosch, Elu, DeWalt, Festool, Mafell, Makita, Scheer, Skil	190	2.8	1.8	20			16 WZ	20		166127 ●
AEG, Atlas Copco, Bosch, Elu, DeWalt, Festool, Mafell, Makita, Protool, Scheer, Skil	190	2.8	1.8	30			48 WZ	10		166129 ●
AEG, Bosch, Elektra Beckum, Festool, Haffner, Holz-Her, Mafell, Scheer	200	3.0	2.0	30			34 WZ	10		166130 ●
AEG, Bosch, Elektra Beckum, Festool, Haffner, Holz-Her, Mafell, Scheer	200	3.0	2.0	30			48 WZ	10		166131 ●
AEG, Bosch, Elektra Beckum, Festool, Haffner, Holz-Her, Mafell, Scheer	200	3.0	1.6	30			64 WZ	10		166132 ●
AEG, Atlas Copco, Elektra Beckum, Fein, Festool, Haffner, Holz-Her, Mafell, Makita, Metabo, Skil	210	2.4	1.6	30			24 WZ	15		166133 ●
AEG, Atlas Copco, Elektra Beckum, Fein, Festool, Haffner, Holz-Her, Mafell, Makita, Metabo, Skil	210	2.4	1.6	30			42 WZ	20		166134 ●
AEG, Atlas Copco, Elektra Beckum, Fein, Festool, Haffner, Holz-Her, Mafell, Makita, Metabo, Skil	210	2.4	1.6	30			60 WZ	10		166135 ●
Haffner, Holz-Her, Metabo, Scheer	220	3.2	2.2	30			34 WZ	15		166136 ●
Haffner, Holz-Her, Metabo, Scheer	220	3.2	2.2	30			60 WZ	10		166107 ●
Festool, Mafell	225	2.6	1.8	30			32 WZ	20		166137 ●
Festool, Mafell	225	2.6	1.8	30			48 WZ	10		166138 ●
Hilti, Mafell	230	2.5	1.8	30			24 WZ	20		166140 ●
Hilti, Mafell	230	2.5	1.8	30			48 WZ	15		166108 ●
AEG, Atlas Copco, Bosch, Holz-Her	230	3.2	2.2	30			12 FZ	15		166139 ●
AEG, Atlas Copco, Bosch, Holz-Her, Metabo	230	3.2	2.2	30			34 WZ	15		166141 ●
	235	2.5	1.8	30			24 WZ	15		166156 ●
	235	2.5	1.8	30			56 WZ	15		166157 ●
Haffner, Makita, Skil	235	3.2	2.2	30			24 WZ	15		166142 ●
Haffner, Makita, Skil	235	3.2	2.2	30			34 WZ	15		166143 ●
Elu, DeWalt, Festool, Haffner, Holz-Her, Metabo, Protool	240	3.0	2.0	30			34 WZ	15		166144 ●
Elu, DeWalt, Festool, Haffner, Holz-Her, Metabo, Protool	240	3.0	1.8	30			48 WZ	10		166145 ●
Elektra Beckum, Elu, DeWalt, Lurem, Mafell, Metabo, PHM, Scheppach	250	2.8	2.0	30	KNL	24	WZ	25		166146 ●
Elektra Beckum, Elu, DeWalt, Lurem, Mafell, Metabo, PHM, Scheppach	250	2.8	2.0	30	KNL	60	WZ	20		166147 ●
Makita	260	3.2	2.2	30	KNL	60	WZ	10		166148 ●
Lurem, Mafell	280	3.2	2.2	30	KNL	48	WZ	10		166149 ●
Lurem, Mafell	280	3.2	2.2	30	KNL	60	WZ	10		166150 ●
Elektra Beckum, Lurem, Scheppach	315	3.0	2.0	30	KNL	48	WZ	15		166152 ●
Elektra Beckum, Lurem, Scheppach	315	3.2	2.2	30	KNL	28	WZ	20		166151 ●
Elektra Beckum, Lurem, Scheppach	315	3.2	2.2	30	KNL	72	WZ	10		166153 ●
Mafell	355	3.2	2.2	30	KNL	16	WZ	20		166154 ●
Mafell	355	3.2	2.2	30	KNL	32	WZ	20		166155 ●



Trimming from the top

Application:

For sizing across grain, trimming and cross cutting.

Machine:

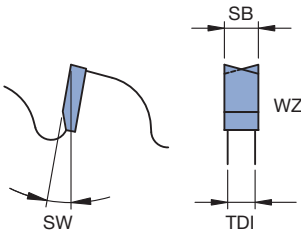
Trimming and mitre saws.

Workpiece material:

Softwood and hardwood wet and dry, laminated veneer lumber (e.g. plywood, multiplex plywood), thin walled plastic profiles (thickness < 2 mm).

Technical information:

Negative cutting angle especially for manually operated machines. Position of spindle above the workpiece.



Circular sawblade WZ cutting angle -5°

WK 160 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			Deg.		
AEG, Atlas Copco, Elektra Beckum, Fein, Haffner, Holz-Her, Mafell, Makita, Metabo, Skil	210	2.8	2.0	30		60	WZ	-5	■ ■	166252 ●
Elu, DeWalt, Makita, Metabo	216	3.0	2.0	30		24	WZ	-5	■ ■	166253 ●
Elu, DeWalt, Makita, Metabo	216	3.0	2.0	30		48	WZ	-5	■ ■	166254 ●
Elu, DeWalt, Makita, Metabo	216	3.0	2.0	30		64	WZ	-5	■ ■	166255 ●
Elektra Beckum, Elu, DeWalt, Lurem, Mafell, Metabo, PHM, Scheppach	250	2.4	1.8	30	KNL	48	WZ	-5	■ ■	166256 ●
Elektra Beckum, Elu, DeWalt, Lurem, Mafell, Metabo, PHM, Scheppach	250	2.4	1.8	30	KNL	60	WZ	-5	■ ■	166257 ●
Elektra Beckum, Elu, DeWalt, Lurem, Mafell, Metabo, PHM, Scheppach	250	3.2	2.6	30	KNL	80	WZ	-5	■ ■	166258 ●
Makita	255	2.8	2.0	30	KNL	60	WZ	-5	■ ■	166259 ●
Festool	260	2.5	1.8	30	KNL	60	WZ	-5	■ ■	166250 ●
Festool	260	2.5	1.8	30	KNL	80	WZ	-5	■ ■	166251 ●



Trimming cut

Application:

For sizing, trimming and cross cutting.

Machine:

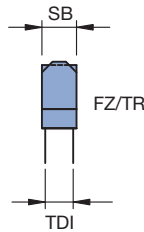
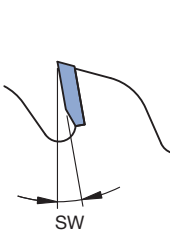
Portable and table saws.

Workpiece material:

Non-ferrous metal profiles, duroplastics (compact laminated boards e.g. HPL), solid surface materials (e.g. Corian).

Technical information:

Solid tooth shape for universal use.



Circular sawblade FZ/TR cutting angle 5°

WK 452 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW Deg.	WSS	ID
AEG, Atlas Copco, Festool, Haffner, Hilti, Holz-Her, Mafell, Narex, Protool, Scheer	160	2.6	1.8	20				48 FZ/TR 5	■ ■	166300 ●
	180	3.2	2.6	16				42 FZ/TR 5	■ ■	166301 ●
Bosch, Festool, Holz-Her, Mafell, Makita, Skil	190	2.8	1.8	30				54 FZ/TR 5	■ ■	166302 ●
Emmegi	200	2.8	2.2	20				84 FZ/TR 5	■ ■	166303 ●
Eisele, Elu, DeWalt, Haffner	200	3.2	2.6	30	KNL			48 FZ/TR 5	■ ■	166304 ●
Makita	250	3.2	2.6	30	KNL			60 FZ/TR 5	■ ■	166305 ●
Elektra Beckum, Elu, DeWalt, Haffner, Mafell, Makita, Metabo, PHM, Rapid, Scheppach	250	3.2	2.6	30	KNL			80 FZ/TR 5	■ ■	166306 ●
	250	3.2	2.6	32	2/11/63	60	FZ/TR 5		■ ■	166307 □
Elu, Pressta Eisele	250	3.2	2.6	32	2/11/63	80	FZ/TR 5		■ ■	166308 □
Eisele, Graule	250	3.2	2.6	40	2/8/55	80	FZ/TR 5		■ ■	166309 □
					4/12/64					
Eisele, Graule	275	3.4	2.8	40	2/9/55	72	FZ/TR 5		■ ■	166310 ●
					4/12/64					



Trimming from the top

Application:

For sizing across grain, trimming and cross cutting.

Machine:

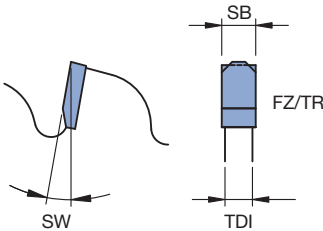
Trimming and mitre saws.

Workpiece material:

Non-ferrous metal or plastic profiles.

Technical information:

Negative cutting angle especially for manually operated machines. Position of spindle above the workpiece.



Circular sawblade FZ/TR cutting angle -5°

WK 462 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			Deg.		
	160	2.5	1.8	20		56	FZ/TR	-5	■ ■	166350 ●
Makita, Bosch, DeWalt	165	2.2	1.6	20		56	FZ/TR	-5	■ ■	166351 ●
Haffner, Makita	180	3.2	2.6	20		42	FZ/TR	-5	■ ■	166352 ●
	190	2.6	1.8	20		54	FZ/TR	-5	■ ■	166353 ●
	190	2.8	2.2	30		68	FZ/TR	-5	■ ■	166354 ●
Fezer	200	3.2	2.6	18		80	FZ/TR	-5	■ ■	166355 ●
Ulmia	200	3.2	2.6	30		60	FZ/TR	-5	■ ■	166356 ●
Festool	210	2.4	1.6	30		64	FZ/TR	-5	■ ■	166357 ●
Hitachi, Metabo, Makita	210	2.8	2.0	30		60	FZ/TR	-5	■ ■	166358 ●
Elu, DeWalt	216	3.0	2.4	30		64	FZ/TR	-5	■ ■	166359 ●
Haffner, Reich	220	3.2	2.6	30		72	FZ/TR	-5	■ ■	166360 ●
	225	2.6	1.8	30		68	FZ/TR	-5	■ ■	166361 ●
	250	3.2	2.6	30	KNL	60	FZ/TR	-5	■ ■	166362 ●
Elu, DeWalt, Fezer	250	3.2	2.6	30	KNL	80	FZ/TR	-5	■ ■	166363 ●
Festool	260	2.4	1.8	30	KNL	68	FZ/TR	-5	■ ■	166364 ●
	275	3.2	2.6	30	KNL	72	FZ/TR	-5	■ ■	166365 ●

1. Sawing

1.7 Portable saws and table-top machines

1.7.3 Circular sawblades with thickness limitation



Universal sizing

Application:

For multi-purpose application in solid wood and wood derived materials.

Machine:

Trimming and cross cutting saws.

Workpiece material:

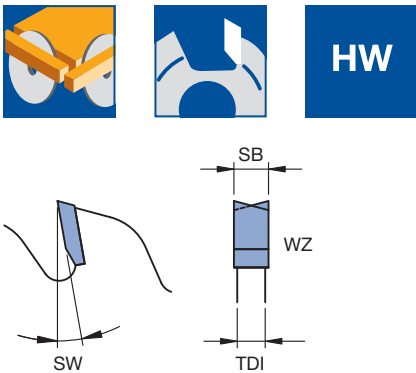
Softwood and hardwood wet and dry.

Technical information:

Design with chip thickness limitation.

Circular sawblade WZ with thickness limitation

WK 150 2



D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			Deg.		
210	3.2	2.2	30	KNL	24	WZ	20	■	166075 ●
250	3.2	2.2	30	KNL	24	WZ	20	■	166076 ●
300	3.2	2.2	30	KNL	28	WZ	20	■	166077 ●
350	3.2	2.2	30	KNL	32	WZ	20	■	166078 ●
400	4.0	2.8	30	KNL	36	WZ	20	■	166079 ●
450	4.0	2.8	30	KNL	42	WZ	20	■	166080 ●
500	4.0	2.8	30	KNL	48	WZ	20	■	166081 ●
550	4.8	3.5	30	KNL	54	WZ	20	■	166082 ●
600	4.8	3.5	30	KNL	60	WZ	20	■	166083 ●
700	4.8	3.5	30	KNL	60	WZ	20	■	166084 ●

Circular sawblades with chip thickness limitation and tooth shape FZ - see section Solid Wood Cutting Along Grain.



Circular sawblades for metals - DryCut

Application:

For splitting, trimming and sizing.

Machine:

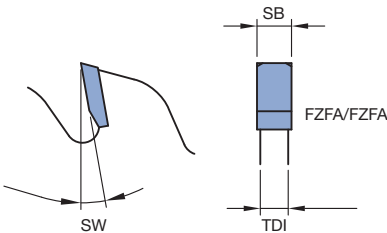
Trimming and mitre saws, portable machines and table saws.

Workpiece material:

Flat and angle steel, pipes, steel plates and profiles, sandwich panels.

Technical information:

Note: Slow feed! Reduce speed! There may be sparks in use. Pay attention to safety instructions of extraction.



Circular sawblade DryCut

WK 357 2, WK 457 2

Machine	D mm	SB mm	TDI mm	BO mm	Z	ZF	WSS	ID
AEG, Atlas Copco, Festool, Haffner, Hilti, Holz-Her, Mafell, Narex, Protool, Scheer	160	1.6	1.2	20	48	FZFA/FZFA	■	169000 ●
Bosch, DeWalt, Makita	165	1.6	1.2	20	48	FZFA/FZFA	■	169001 ●
AEG, Bosch, DeWalt, Makita, Skil, Black & Decker	184	1.8	1.4	20	48	FZFA/FZFA	■	163525 ●
	190	1.8	1.4	30	54	FZFA/FZFA	■	169002 ●
Festool	210	1.8	1.4	30	60	FZFA/FZFA	■	169003 ●
	225	2.2	1.8	30	64	FZFA/FZFA	■	169004 ●
	254	2.2	1.8	30	72	FZFA/FZFA	■	169005 ●
	300	2.2	1.8	30	80	FZFA/FZFA	■	163527 ●
	305	2.4	2.0	25.4	80	FZFA/FZFA	■	163526 ●
	355	2.4	2.0	25.4	80	FZFA/FZFA	■	169006 ●
	400	3.0	2.4	30	84	FZFA/FZFA	■	163528 ●



Sizing in finish cut quality *Excellent* - GlossCut

Application:
For trimming and sizing.

Machine:
Portable and table saws.

Workpiece material:
Transparent thermoplastics (e.g. PMMA, PC), plastic wave boards (e.g. PVC), solid surface materials (e.g. Corian), alu composite panels (e.g. Alucobond®). Non-ferrous metal or plastic profiles.

Technical information:
Cutting face with two different cutting angles for smooth surfaces and tear-free cutting edges. **Excellent** design with plastic filled laser ornaments for vibration damping and reduction of noise level (over D-210 mm).



Circular sawblade GlossCut
WK 357 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	WSS	ID
	mm	mm	mm	mm	mm				
AEG, Atlas Copco, Festool, Haffner, Hilti, Mafell, Narex, Protool, Scheer	160	2.2	1.6	20		48	FZFA/FZFA		161008 ●
Makita, Bosch, DeWalt	165	2.2	1.6	20		48	FZFA/FZFA		161009 ●
AEG, Atlas Copco, Bosch, Festool, Mafell, Makita, Metabo, Scheer, Skil	190	2.4	1.8	20		58	FZFA/FZFA		161010 ●
Festool	210	2.4	1.8	30		68	FZFA/FZFA		161011 ●
	250	2.8	2.0	30	KNL	72	FZFA/FZFA		161012 ●

Further GlossCut dimensions suitable for sizing, cross cut and mitre cut saws and twin sizing saws - see section Cutting Non-Ferrous Metals And Plastics.



Universal sizing

Application:

For universal use on building sites.

Machine:

Universal cutting saws.

Workpiece material:

Panels and timbers with small concrete and metal inclusions, wood wool (e.g. Heraklith), gypsum plasterboard and form work panel of veneer, gas aerated slabs, Styrodur slabs, roundwood and squared timbers.

Technical information:

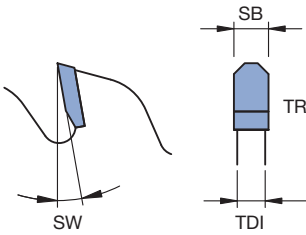
Tool body with round closed form and stable tooth shape. Special tungsten carbide grade for all requirements on construction sites. Noise reducing design.



Circular sawblade TR for saw benches

WK 123 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			Deg.		
350	3.5	2.5	30	KNL	24	TR	10		166025 ●
400	3.8	2.8	30	KNL	28	TR	10		166026 ●
450	4.0	3.0	30	KNL	32	TR	10		166027 ●
500	4.0	3.0	30	KNL	36	TR	10		166028 ●





Cutting facade panels *Excellent*

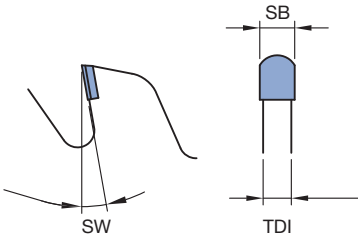
Application:
For trimming and sizing.

Machine:
Table and sizing saws, portable and radial cross saws.

Workpiece material:
Gypsum and cement based panels.

Technical information:
DP tipped for long tool life.

Circular sawblade DP design WK 808 2 DP



Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW Deg.	WSS	ID
AEG, Atlas Copco, Festool, Haffner, Hilti, Holz-Her, Mafell, Narex, Protool, Scheer	160	3.2	2.4	20		4	P	5	■	190302 ●
AEG, Bosch, DeWalt, Makita, Milwaukee, Skil, Black & Decker	184	3.2	2.4	20		4	P	5	■	190696 ●
AEG, Atlas Copco, Bosch, Elu, DeWalt, Festool, Holz-Her, Mafell, Makita, Metabo, Scheer, Skil	190	3.2	2.4	20		4	P	5	■	190303 ●
Festool, Mafell	225	3.2	2.4	30		6	P	5	■	190304 ●
Elektra Beckum, Elu, De- Walt, Lurem, Scheppach	300	3.2	2.4	30	KNL	8	P	5	■	190305 ●

Reducing rings

Technical information:

For reducing the bore of circular sawblades reducing rings can be used. Attention: When using reducing rings, pay attention to the distance to the flange. Reducing rings in riffle design.

Reducing ring riffled

TB 100 0 02

D	BO	DIK	ID
mm	mm	mm	
20	16	1.0	061148 ●
20	16	1.6	061104 ●
30	20	1.4	061149 ●
30	25.4	1.8	061150 ●
32	30	1.8	061151 ●

Key to pictograms



Sawing thin kerf



Sawing hollow metal



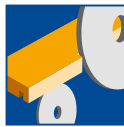
Sawing horizontal



Sawing crosscut metal



Sawing along grain



Scoring, hogging



Sawing across grain



Grooving, horizontal and vertical



Sawing universal



Tipped tool



Scoring, sawing



Low Noise Low noise



Scoring and sawing stacks



Tungsten carbide



Sawing hollow sections



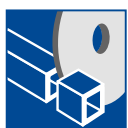
Polycrystalline diamond (PCD)



Sawing plastic single



Sawing plastic stacks



Sawing solid transparent plastic

