Planing and profiling

Leitz Lexicon Edition 7

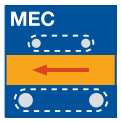
Explanation of abbreviations

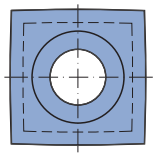
A	=	dimension A
a_e	=	cutting thickness (radial)
a_p	=	cutting depth (axial)
ABM	=	dimension
APL	=	panel raising length
APT	=	panel raising depth
AL	=	working length
AM	=	number of knives
AS	=	anti sound (low noise design)
b	=	overhang
B	=	width
BDD	=	thickness of shoulder
BEM	=	note
BEZ	=	description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

Notes to the Lexicon concerning the diagrams and tables

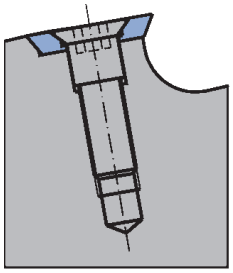
The statements made in the diagrams and tables relate to specific conditions and represent parameters from tests subjected to defined conditions. Variations when using tools in individual case due to special application conditions may be possible. Our support team will provide you with detailed information.

3. Planing and profiling





HW turnblade knife



Knives mounted on periphery

Planerhead HeliPlan with 4 edge HW turnblade knives

Application:
Pre-planing, surfacing and jointing all types of wood with large chip removal. Also suitable for finish planing if quality demands are less important or in combination with subsequent sanding.

Machine:
Four-sided moulders.

Workpiece material:
Softwood and hardwood.

Technical information:
Pre-planing cutterhead with 4 edge HW turnblade knives. Low noise and energy efficient due to spiral, segmented edge arrangement. Smooth finish by radiused cutting edges. Aluminium tool body. Optional with steel reference cutterhead for machines with fence.

Aluminium tool body, with bore
WW 220 2 01

D mm	SB mm	ND mm	BO mm	Z	AM PCS	n_{max} min^{-1}	ID
125	130	136	40	2/2	22	12000	**030423** ●
125	166	172	40	2/2	28	12000	**030467** ●
125	210	216	40	2/2	36	12000	**030452**
125	236	242	40	2/2	40	12000	**030466** ●
140	166	172	50	2/2	28	12000	**030468**
140	236	242	50	2/2	40	12000	**030469**

Design with HW cutting edges.
Further dimensions and inch dimensions available on request.
Suitable reference cutterheads on page 11.

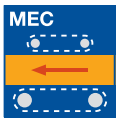
Spare knives:

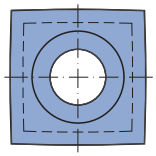
BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	15x15x2.5	HW	10	**009535** ●
Turnblade knife	15x15x2.5	TDC		**602901** ●

Spare parts:

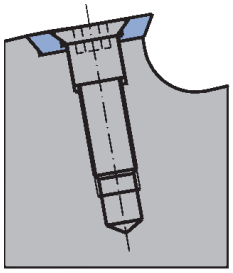
BEZ	ABM mm	ID
Countersink screw, Torx® 20	M5x14.2-8.8	**007394** ●
Torx® key	Torx® 20	**006091** ●

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

HW turnblade knife



Knives mounted on periphery

Planerhead HeliPlan with 4 edge HW turnblade knives

Application:
Pre-planing, surfacing and jointing all types of wood with large chip removal. Also suitable for finish planing if quality demands are less important or in combination with subsequent sanding.

Machine:
Four-sided moulders with HSK 85 WS interfaces.

Workpiece material:
Softwood and hardwood.

Technical information:
Pre-planing cutterhead with 4 edge HW turnblade knives. Low noise and energy efficient due to spiral, segmented edge arrangement. Smooth finish through radiused cutting edges. Aluminium tool body. Tool and HSK are shrink-fit together. Optional steel reference cutterhead for machines with fence.

Aluminium tool body, with HSK 85 WS
WL 210 2 02

D mm	SB mm	A mm	Z	AM PCS	n_{max} min^{-1}	ID bottom	ID top
125	130	26	2/2	22	12000	**132000** □	**132001** □
125	166	26	2/2	28	12000	**132022** □	**132023** □
125	210	26	2/2	36	12000	**132008**	**132009**
125	236	26	2/2	40	12000	**132024** □	**132025** □
125	270	26	2/2	46	8000	**132012**	**132013**
125	310	26	2/2	54	8000	**132014** ●	**132015** ●

Aluminium tool body, HSK 85 WS with reference cutterhead
WL 403 2 02

D mm	SB mm	A mm	Z	V	AM PCS	n_{max} min^{-1}	DRI	ID
125	236	26	2/2	2	40	12000	bottom	**132066** □
125	310	26	2/2	2	54	8000	bottom	**132065** □

Design with HW cutting edges.
Further dimensions and inch dimensions available on request.

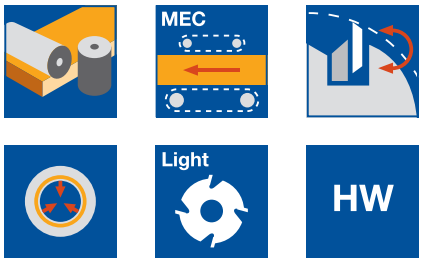
Spare knives:

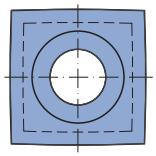
BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	15x15x2.5	HW	10	**009535** ●
Turnblade knife	15x15x2.5	TDC		**602901** ●

Spare parts:

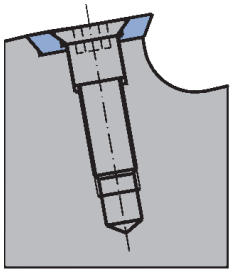
BEZ	ABM mm	ID
Countersink screw, Torx® 20	M5x14.2-8.8	**007394** ●
Torx® key	Torx® 20	**006091** ●

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

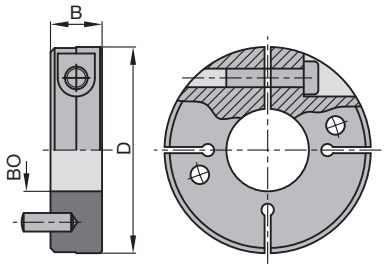




HW turnblade knife



Knives mounted on periphery



Clamping collar without thread

Hydro Planerhead HeliPlan

Application:
Pre-planing, surface cutting of all types of wood with large chip removal. Finish cutting of gluable surfaces and workpieces with secondary quality demands.

Machine:
Four-sided moulders and profiling machines.

Workpiece material:
Softwood and hardwood.

Technical information:
Pre-planing cutterhead with 4-time HW turnblades. Low noise and energy efficient through spiral, segmented edge arrangement. Plane surfaces through radiused cutting edges. Tool bodies of lightweight aluminium with integrated hydro clamping system. Activated by a grease gun.

Aluminium tool body
HW 230-2

D mm	SB mm	BO mm	Z	n_{max} min^{-1}	ID
160	150	50	4/4	11000	**132200**
160	180	50	4/4	11000	**132201**
160	200	50	4/4	11000	**132202**
160	230	50	4/4	11000	**132203**
160	310	50	4/4	11000	**132204**
200	150	50	6/6	8000	**132205**
200	180	50	6/6	8000	**132206**
200	200	50	6/6	8000	**132207**
200	230	50	6/6	8000	**132208**
200	310	50	6/6	8000	**132209**
250	150	50	8/8	6900	**132210**
250	180	50	8/8	6900	**132211**
250	200	50	8/8	6900	**132212**
250	230	50	8/8	6900	**132213**
250	310	50	8/8	6900	**132214**

Design in steel/lightweight aluminium on request. This version combines the advantages of a light weight tool and a wear resistant knife seating and gullet area.

Spare knives:

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

Spare parts:

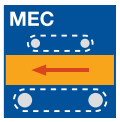
BEZ	ABM mm	ID
Countersink screw, Torx® 20	M5x14.2-8.8	**007394** ●
Torx® key	Torx® 20	**006091** ●

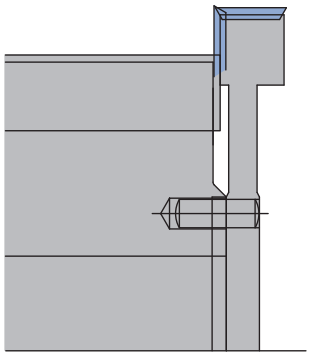
Clamping collars without thread
TD 870 0

D mm	B mm	BO mm	ID
100	25	40	**030700** ●
100	25	50	**030702** ●

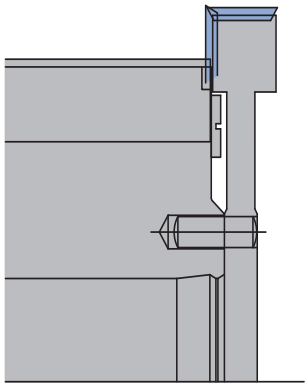
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





Combination with wedge-type system, build up system and CentroStar. For planerheads without boss, mounted with spacers.



Combination with HeliPlan and VariPlan Plus cutterhead. Mounting without spacer.

Reference cutterhead

Application:
For cutting a side reference rebate when surface planing on the first bottom spindle in combination with a planer cutterhead.

Machine:
Four-sided moulders with fence.

Workpiece material:
Softwood and hardwood.

Technical information:
Steel tool body with HW turnblade knives, can be combined with pre-planing and finish planing cutterheads on the first bottom spindle.
D 145 for planerheads D 125.
D 160 for planerheads D 140.

For wedge-type system, build-up system, CentroStar
WW 410 2

D mm	SB mm	BO mm	Z	V	QAL	n_{max} min^{-1}	ID
145	15	40	2	2	HW	12000	**132077** ●
160	15	40	2	2	HW	11000	**132078** ●

For HeliPlan, VariPlan Plus
WW 410 2

D mm	SB mm	BO mm	Z	V	QAL	n_{max} min^{-1}	ID
145	15	40	2	2	HW	12000	**132075** ●
160	15	40	2	2	HW	11000	**132076** ●

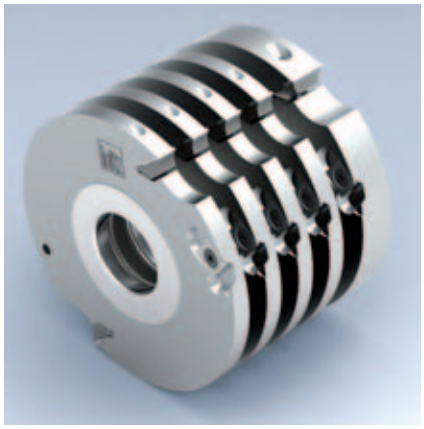
Spare knives:

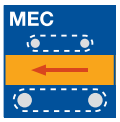
BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	15x15x2.5	HW	10	**009535** ●

Spare parts:

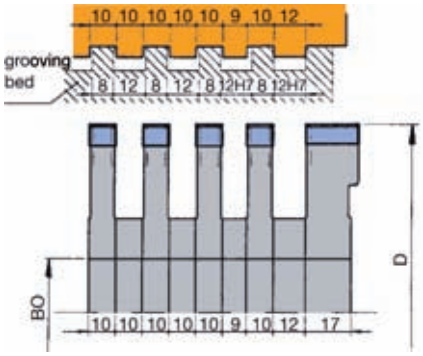
BEZ	ABM mm	ID
Spacer	70x3x40,DTK58	**028617** ●
Countersink screw, Torx® 20	M5x14.2-8.8	**007394** ●
Pin	6x20	**008617** ●

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





HW



Number of tools for different widths

SB mm	working width mm				
	80	100	120	140	170
SB 20	1	1	1	1	1
SB 10	3	4	5	6	8

Cutterhead for groove bed guide

Application:
For guide grooves on the first bottom spindle for precise feeding of short parts or curved workpieces.

Machine:
Four-sided moulders with groove beds.

Workpiece material:
Softwood and hardwood, along grain.

Technical information:
Build up turnblade knife tool system, diameter and cutting width constant. The closed, round design of the tool body reduces the noise level.

HW turnblade design
WW 101 2, WW 102 2

D mm	SB mm	BO mm	BO_{max} mm	Z	V	n_{max} min^{-1}	ID
125	20	40	50	2	2	12000	**020389** ●
125	10	40	50	2	2	12000	**020390** ●
140	20	40	50	2	2	10900	**020386** ●
140	10	40	50	2	2	10900	**020388** ●

Spare knives:

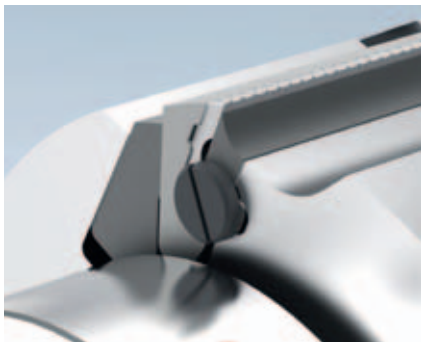
BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	19.7x8x1.5	HW-30F	10	**005071** ●
Turnblade knife	9.7x8x1.5	HW-30F	10	**005197** ●
Turnblade spur VS1	14x14x2	HW-F	10	**005099** ●

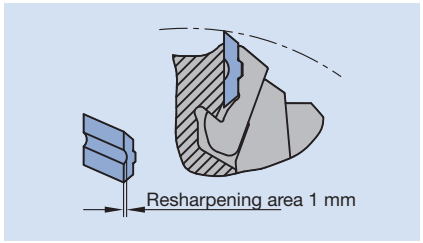
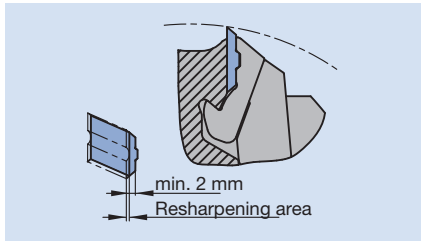
Spare parts:

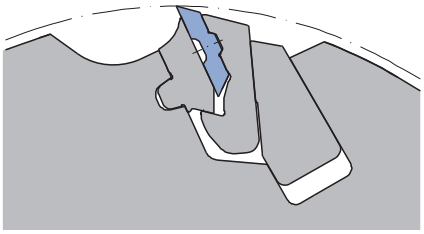
BEZ	ABM mm	ID
Spacer	60x0.1x40	**027941** ●
Spacer	60x0.3x40	**027942** ●
Spacer	60x9x40	**028449** ●
Spacer	60x10x40	**027951** ●
Clamping wedge	18x18.75x8.27	**009671** ●
Clamping wedge	9x18.75x8.27	**009764** ●
Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
Allen screw with shank, Torx® 15	M5x20	**007380** ●
Countersink screw, Torx® 20	M6x0.5x4.9	**006243** ●
Torx® key	Torx® 15	**117507** ●
Torx® key	Torx® 20	**117503** ●
Setting gauge for knives	0.3/0.8	**005374** ●

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

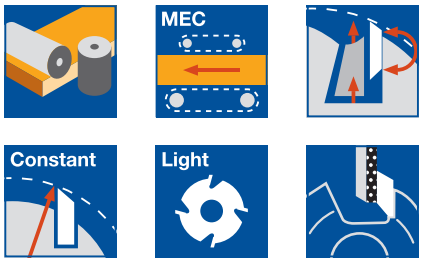
Planing cutterhead VariPlan Plus

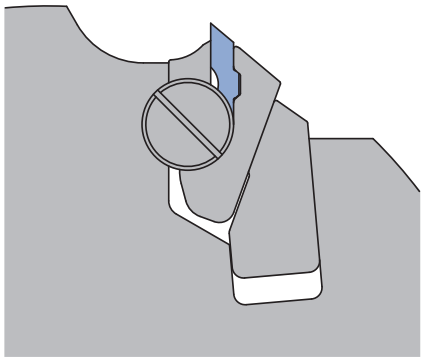


Application	Pre and finish planing of all types of wood.
Machines	Four-sided and multi spindle moulders, also with HSK 85 WS interface.
Workpiece material	Softwood and hardwood, plastics (limited suitable).
Number of knives	Z 2 to Z 12 depending on the feed speed and the tool diameter.
Resharpening area	 
Cutting material	HS for softwood. HW for hardwood, mixed use of softwood and hardwood or laminated wood with glued joint.
Chip removal	Pre-planing: Softwood up to 10 mm, hardwood up to 8 mm. Finish planing up to 1.0 mm.
Tool design	Resharpenable and constant diameter tool system with turnblade planer knives. Aluminium body, wear resistant steel chip breaker. Centrifugal force assisted, self-centering knife clamping system.
Technical characteristics	Operational safety through full form knife clamping. Fast knife change through self-positioning knife clamping. Knife clamping in the dust-protected area. One sharpening operation, therefore 2 extra tool lives by turnblade knife. VariPlan Plus basic body for 3 knife variants: Microfinish, RipTec and Integral turnblade knives. VariPlan Plus Planerheads for machines with HSK 85 WS interface are mounted on HSK 85 WS arbor. Combination with pre surfacing/rebating cutterhead possible.

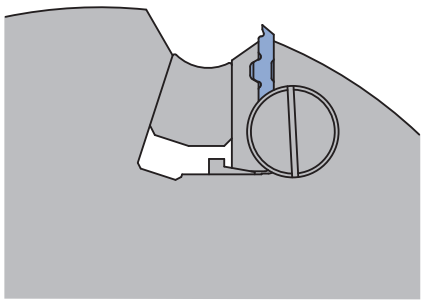


Aluminium tool body with steel chip breaker.





VariPlan knife clamping for planer knife - plane



CentroStrar knife clamping for planer knife - ripple

Planerhead VariPlan Plus Integral

Application:
Multi-purpose planing tool:
For pre-planing on machines with two spindles.
For roughing/finishing planing on a spindle.

Machine:
Four-sided moulders and multi spindle planing machines.

Workpiece material:
Softwood and hardwood with knots and/or a fibre structure difficult to machine.

Technical information:
Tool with two CentroStar ripple knives (constant diameter, turnblade) as well as two straight VariPlan planer knives (constant diameter and resharpenable). Irregular knife arrangement, divided to get optimal chips. Lightweight aluminium tool body.

Planerhead with bore
WW 240 2 09

D mm	SB mm	ND mm	BO mm	QAL	n_{max} min^{-1}	Z	ID
125	130	136	40	HW	12000	2+2	**131706** ●
125	166	172	40	HW	12000	2+2	**131707** ●
125	236	242	40	HW	12000	2+2	**131708** ●
140	130	136	50	HW	10500	2+2	**131709**
140	166	172	50	HW	10500	2+2	**131710**
140	236	242	50	HW	10500	2+2	**131711**

Planerhead with HSK 85 WS
WP 240 2 09

D mm	SB mm	QAL	n_{max} min^{-1}	Z	ID LH	ID RH
125	130	HW	12000	2+2	**131800** □	**131801** □
125	166	HW	12000	2+2	**131802** □	**131803** □
125	236	HW	12000	2+2	**131804** □	**131805** □

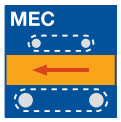
Planerhead with HSK 85 WS and reference cutterhead
WP 240 2 30

D mm	SB mm	QAL	n_{max} min^{-1}	Z	DRI	ID
125	236	HW	12000	2+2	LH / bottom	**131880** □

Spare knives:

BEZ	SB mm	H mm	DIK mm	SET PCS	QAL	ID
Turnblade knife set - CentroStar (ripple)	130	12	2.7	2	HW	**617312** ●
Turnblade knife set - CentroStar (ripple)	236	12	2.7	2	HW	**617379** ●
Turnblade knife set - CentroStar (ripple)	166	12	2.7	2	HW	**617380** ●
Turnblade knife set - VariPlan	130	16	3.7	2	HW-MF	**617106** ●
Turnblade knife set - VariPlan	166	16	3.7	2	HW-MF	**617171** ●
Turnblade knife set - VariPlan	236	16	3.7	2	HW-MF	**617169** ●

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Planerhead VariPlan Plus

Application:
Multi-purpose planing tool:
For pre-planing with RipTec turnblades.
For finish planing with microfinish turnblades.

Machine:
Four-sided moulders and multi spindle planing machines.

Workpiece material:
Softwood and hardwood, thermoplastics (partly suitable).

Technical information:
Resharpenable and constant diameter planerhead system.
Self-positioning and centrifugal force supported knife clamping. Lightweight aluminium tool body. Resharpening the knives on the cutting face means one sharpening operation gives two additional lives.

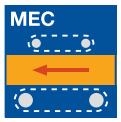
Lightweight aluminium tool body
WW 240 2 05

D mm	SB mm	ND mm	BO mm	n_{max} min^{-1}	Z	ID HS	ID HW-MF
125	130	136	40	12000	2	**134250** □	**134200** ●
125	150	156	40	12000	2	**134251**	**134201**
125	166	172	40	12000	2	**134252** □	**134202** ●
125	180	186	40	12000	2	**134253**	**134203**
125	210	216	40	12000	2	**134254**	**134204**
125	236	242	40	12000	2	**134255** □	**134205** ●
125	270	240	40	10500	2	**134256**	**134206**
125	130	136	40	12000	4	**134450** □	**134400** ●
125	150	156	40	12000	4	**134451**	**134401**
125	166	172	40	12000	4	**134452** □	**134402** ●
125	180	186	40	12000	4	**134453**	**134403**
125	210	216	40	12000	4	**134454**	**134404**
125	236	242	40	12000	4	**134455** □	**134405** ●
125	270	240	40	10500	4	**134456**	**134406**

Further dimensions and inch dimensions on request.
Spare knives (HS/HW-MF/HW-RipTec) see section Knives and Spare Parts.

Spare knives:

SB mm	H mm	DIK mm	SET PCS	ID HS	ID HW-MF
130	16	3.7	2	**610506** ●	**617106** ●
150	16	3.7	2	**610509** ●	**617109** ●
166	16	3.7	2	**610571** □	**617171** ●
180	16	3.7	2	**610512** ●	**617112** ●
210	16	3.7	2	**610515** ●	**617115** ●
236	16	3.7	2	**610569** □	**617169** ●
270	16	3.7	2		**617165** ●



Planerhead VariPlan Plus

Application:
Multi-purpose planing tool:
For pre-planing with RipTec turnblades.
For finish planing with microfinish turnblades.

Machine:
Four-sided moulders and multi spindle moulders with HSK 85 WS interfaces.

Workpiece material:
Softwood and hardwood, thermoplastics (partly suitable).

Technical information:
Resharpenable and constant diameter planerhead system. Self-positioning and centrifugal force supported knife clamping. Lightweight aluminium tool body. Resharpening the knives on the cutting face means one sharpening operation gives two additional lives. Tool body and HSK arbor are shrunk fit together.

Lightweight aluminium tool body on HSK 85 WS
WP 240 2 05

D mm	SB mm	A mm	n_{max} min^{-1}	Z	QAL	ID LH / bottom	ID RH / top
125	130	26	12000	2	HW-MF	**134500** □	**134501** □
125	150	26	12000	2	HW-MF	**134502**	**134503**
125	166	26	12000	2	HW-MF	**134504** □	**134505** □
125	180	26	12000	2	HW-MF	**134506**	**134507**
125	210	26	12000	2	HW-MF	**134508**	**134509**
125	236	26	12000	2	HW-MF	**134510** □	**134511** □
125	270	26	8000	2	HW-MF	**134512**	**134513**
125	310	26	8000	2	HW-MF	**134514**	**134515**
125	130	26	12000	4	HW-MF	**134600** □	**134601** □
125	150	26	12000	4	HW-MF	**134602**	**134603**
125	166	26	12000	4	HW-MF	**134604** □	**134605** □
125	180	26	12000	4	HW-MF	**134606**	**134607**
125	210	26	12000	4	HW-MF	**134608**	**134609**
125	236	26	12000	4	HW-MF	**134610** □	**134611** □
125	270	26	8000	4	HW-MF	**134612**	**134613**
125	310	26	8000	4	HW-MF	**134614**	**134615**

Lightweight aluminium tool body on HSK 85 WS with reference cutterhead Z2 / V2
WP 240 2 08

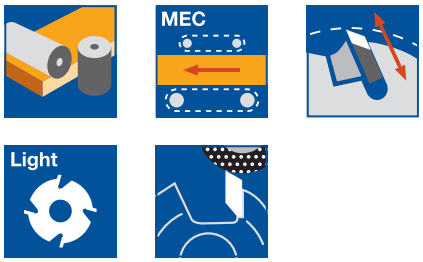
D mm	SB mm	A mm	n_{max} min^{-1}	Z	QAL	DRI	ID
125	236	26	12000	2	HW-MF	LH / bottom	**134581** □
125	236	26	12000	4	HW-MF	LH / bottom	**134681** □

Further dimensions and inch dimensions on request.
Spare knives (HS/HW-MF/HW-RipTec) see section Knives and Spare Parts.

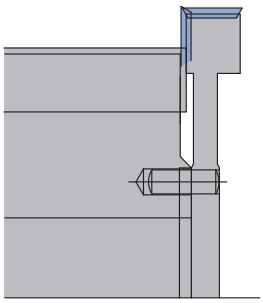
Spare knives:

SB mm	H mm	DIK mm	SET PCS	ID HS	ID HW-MF
130	16	3.7	2	**610506** ●	**617106** ●
150	16	3.7	2	**610509** ●	**617109** ●
166	16	3.7	2	**610571** □	**617171** ●
180	16	3.7	2	**610512** ●	**617112** ●
210	16	3.7	2	**610515** ●	**617115** ●
236	16	3.7	2	**610569** □	**617169** ●
270	16	3.7	2		**617165** ●
310	16	3.7	2	**610522** ●	**617122** ●

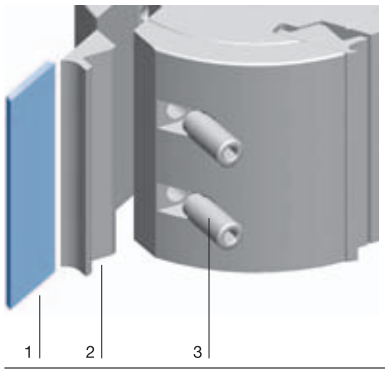
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Correct protrusion: max. 2 mm



Combined with reference cutterhead



Planerhead wedge-type system

Application:
Multi-purpose suitable for pre-planing with large chip removal and for finish planing.

Machine:
Four-sided moulders and profile machines.

Workpiece material:
Softwood and hardwood.

Technical information:
Cutterhead with resharpenable planer knives SB x 30 x 3.0 mm. Pressure springs position the knives by a setting gauge on the defined cutting edge circle. Cutting material quality HS, Marathon (MC33) and HW available.

Aluminium tool body, coated
WM 200 2 07

D mm	SB mm	BO mm	n_{max} min^{-1}	Z	ID HS	ID HW
125	100	40	10500	4	**140408** ●	**140458** □
125	130	40	10500	4	**140409** ●	**140459** □
125	150	40	10500	4	**140410**	**140460**
125	170	40	10500	4	**140411** ●	**140461** □
125	180	40	10500	4	**140412**	**140462**
125	210	40	10500	4	**140413**	**140463**
125	230	40	10500	4	**140414**	**140464**
125	240	40	10500	4	**140415** ●	**140465** □

Suitable reference cutterhead on page 11.

Spare knives:

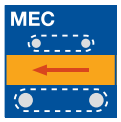
Part-no.	SB mm	H mm	DIK mm	ID HS Classic	ID HS Premium	ID HW	ID MC33
1	100	30	3	**605002** ●	**027103** ●	**027279** ●	**606702** ●
1	130	30	3	**605005** ●	**027106** ●	**027282** ●	**606705** ●
1	150	30	3	**605006** ●	**027107** ●	**027283** ●	**606706** ●
1	170	30	3	**605007** ●	**027108** ●	**027284** ●	**606707** ●
1	180	30	3	**605008** ●	**027109** ●	**027285** ●	**606708** ●
1	210	30	3	**605010**	**027110** ●	**027286** ●	**606710** ●
1	230	30	3	**605011** ●	**027111** ●	**027287** ●	**606711** ●
1	240	30	3	**605012** ●	**027134** ●	**027323** ●	**606712** ●

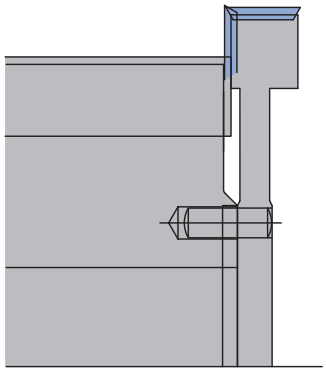
Spare knives in further dimensions and qualities see section Knives and Spare Parts.

Spare parts:

Part-no.	BEZ	ABM mm	for SB mm	ID
2	Clamping wedge		100	**620900** ●
2	Clamping wedge		130	**620901** ●
2	Clamping wedge		150	**620902** ●
2	Clamping wedge		170	**620903** ●
2	Clamping wedge		180	**620904** ●
2	Clamping wedge		210	**620905** ●
2	Clamping wedge		230	**620906** ●
2	Clamping wedge		240	**620907** ●
3	Allen screw	M10x1x25		**007395** ●
	Allen key	SW 5		**117509** ●
	Pressure spring	27x6x0.75		**008076** ●

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





Combined with reference cutterhead

Planerhead CentroStar

Application:
Especially suitable for finish planing. Can also be used for pre-planing with chip removal up to 6 mm.

Machine:
Four-sided moulders.

Workpiece material:
Softwood and hardwood.

Technical information:
Form fit knife clamping system supported by centrifugal force. Axial or radial knife removal. HS or HW turnblade planer knife SB x 12 x 2.7 mm. Integrated chip breaker to prevent pre-splitting. Aluminium tool body.

Aluminium tool body
WW 240 2 20

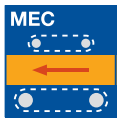
D mm	SB mm	ND mm	BO mm	BO_{max} mm	Z	n_{max} min^{-1}	ID HS	ID HW
125	100	106	40	50	4	12000	**130442** ●	**130443** □
125	130	136	40	50	4	12000	**130446** ●	**130447** □
125	166	172	40	50	4	12000	**130492** ●	**130493** □
125	180	186	40	50	4	12000	**130454**	**130455**
125	210	216	40	50	4	12000	**130458**	**130459**
125	236	242	40	50	4	12000	**130494** ●	**130495** □

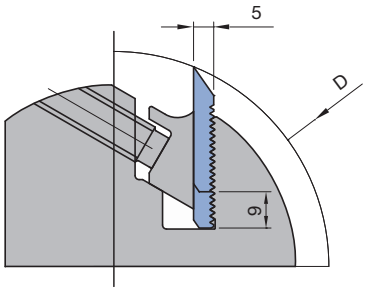
Further dimensions and inch dimensions available on request.
Suitable reference cutterheads on page 11.
Spare parts service only by the manufacturer.

Spare knives:

SB mm	H mm	DIK mm	QAL	SET PCS	ID
100	12	2.7	HS	4	**610203** ●
130	12	2.7	HS	4	**610205** ●
166	12	2.7	HS	4	**610286** ●
180	12	2.7	HS	4	**610211** ●
210	12	2.7	HS	4	**610213** ●
236	12	2.7	HS	4	**610287** ●
100	12	2.7	HW-F	2	**610606** ●
130	12	2.7	HW-F	2	**610612** ●
166	12	2.7	HW-F	2	**610680** ●
180	12	2.7	HW-F	2	**610621** ●
210	12	2.7	HW-F	2	**610627** ●
236	12	2.7	HW-F	2	**610679** ●

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





Planerhead with HSK 85 WS and serrated back HS Marathon planer knives

Application:
Finish planing.

Machine:
Four-sided moulders with HSK 85 WS interface.

Workpiece material:
Cutting angle 20° for softwood and hardwood in general.
Cutting angle 12° for materials likely to splinter such as oak, Douglas fir, merbau and wood fibre materials, e.g. MDF.

Technical information:
Finish planing cutterhead in mono block design DTK 90 mm with serrated back planer knives SB x 40 x 5 mm ground to cutting circle. Jointable by specific jointing stone. Steel tool body. High balance quality by assembly with parts of the same weight.

Cutting angle 20°
WP 210 2 01

D mm	SB mm	A mm	QAL	Z	n_{max} min^{-1}	ID LH / bottom	ID RH / top
106	130	26	MC33	2	12000	**140322** ●	**140323** ●
106	170	26	MC33	2	12000	**140324** ●	**140325** ●
106	240	26	MC33	2	12000	**140326** ●	**140327** ●
106	80	26	MC33	4	12000	**140330** ●	**140331** ●
106	130	26	MC33	4	12000	**140332** ●	**140333** ●
106	170	26	MC33	4	12000	**140334** ●	**140335** ●
106	240	26	MC33	4	12000	**140336** ●	**140337** ●
128	80	26	MC33	6	10000	**140346** ●	**140347** ●
128	130	26	MC33	6	10000	**140348** ●	**140349** ●
128	170	26	MC33	6	10000	**140350** ●	**140351** ●
128	240	26	MC33	6	8000	**140352** ●	**140353** ●

Cutting angle 12°
WP 210 2 01

D mm	SB mm	A mm	QAL	Z	n_{max} min^{-1}	ID LH / bottom	ID RH / top
106	130	26	MC33	2	12000	**140302** ●	**140303** ●
106	170	26	MC33	2	12000	**140304**	**140305**
106	240	26	MC33	2	12000	**140306**	**140307**
106	130	26	MC33	4	12000	**140312**	**140313**
106	170	26	MC33	4	12000	**140314**	**140315**
128	80	26	MC33	6	10000	**140340**	**140341**
128	130	26	MC33	6	10000	**140342**	**140343**
128	170	26	MC33	6	10000	**140344**	**140345**

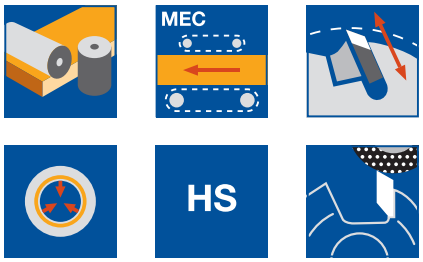
Spare knives:

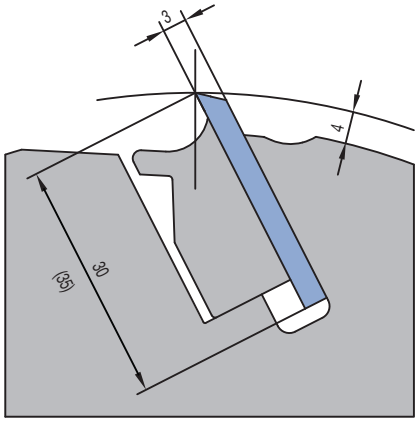
SB mm	H mm	DIK mm	QAL	VE PCS	ID
80	40	5	MC33	2	**697302** ●
130	40	5	MC33	2	**697304** ●
170	40	5	MC33	2	**697306** ●
240	40	5	MC33	2	**697311** ●

Spare parts:

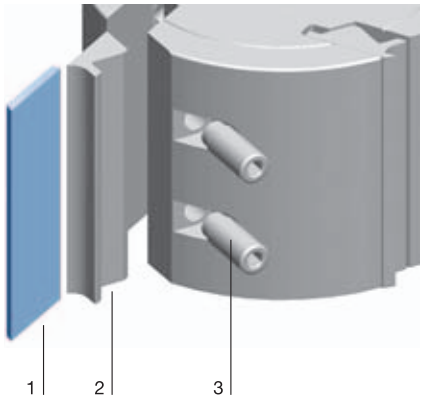
BEZ	ABM mm	for SB mm	ID
Clamping wedge	78x25.3x10.8	80	**620702** ●
Clamping wedge	128x25.3x10.8	130	**620705** ●
Clamping wedge	168x25.3x10.8	170	**620707** □
Clamping wedge	238x25.3x10.8	240	**620710** □
Allen screw	M10x1x20		**007396** ●
Allen key	SW 5		**117509** ●

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





Mounted knife



Hydro planerhead

Application:
Pre and finish planing with high feed speeds.

Machine:
Four-sided moulders and profile machines with jointing equipment.

Workpiece material:
Softwood and hardwood.

Technical information:
Steel tool body with corrosion resistant surface protection. Integrated hydro clamping system with exchangeable clamping sleeves. Activated by a grease gun. Inclusive resharpenable HS planer knives (SB x 30 x 3 mm). From diameter 203 mm, knives with 35 mm height also can be used. Hydro planerheads can only be used in combination with a clamping collar.

Steel tool body
HM 200 2 07

D mm	SB mm	BO mm	Z	QAL	n_{max} min^{-1}	ID
163	130	50	4	HS	8100	**142050**
163	160	50	4	HS	8100	**142051**
163	230	50	4	HS	8100	**142052**
163	60	50	6	HS	8100	**142053** ●
163	100	50	6	HS	8100	**142054** ●
163	130	50	6	HS	8100	**142055** ●
163	160	50	6	HS	8100	**142056** ●
163	230	50	6	HS	8100	**142057** ●
163	60	50	8	HS	8100	**142058**
163	100	50	8	HS	8100	**142059**
163	130	50	8	HS	8100	**142060**
163	160	50	8	HS	8100	**142061**
163	180	50	8	HS	8100	**142062**
163	230	50	8	HS	8100	**142063**
203	100	50	12	HS	6600	**142064**
203	130	50	12	HS	6600	**142065**
203	160	50	12	HS	6600	**142066**
203	180	50	12	HS	6600	**142067**
203	230	50	12	HS	6600	**142068**

Lightweight aluminium version on request.

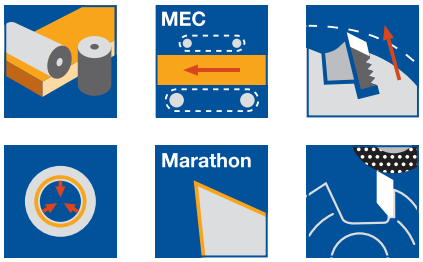
Spare knives:

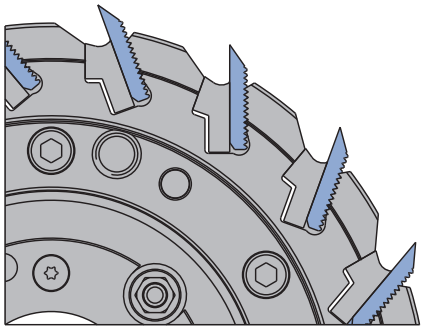
Part-no.	SB mm	H mm	DIK mm	ID HS Classic	ID HS Premium	ID HW	ID MC33
1	60	30	3	**605000**	**027101** ●	**027277** ●	**606700** ●
1	100	30	3	**605002** ●	**027103** ●	**027279** ●	**606702** ●
1	130	30	3	**605005** ●	**027106** ●	**027282** ●	**606705** ●
1	160	30	3	**605045** ●	**027163** ●		**606745** ●
1	180	30	3	**605008** ●	**027109** ●	**027285** ●	**606708** ●
1	230	30	3	**605011** ●	**027111** ●	**027287** ●	**606711** ●

Spare parts:

Part-no.	BEZ	ABM mm	for SB mm	ID
2	Clamping wedge		60	**620950** ●
2	Clamping wedge		100	**620951** ●
2	Clamping wedge		130	**620952** ●
2	Clamping wedge		160	**620953** ●
2	Clamping wedge		180	**620954** ●
2	Clamping wedge		230	**620955** ●
3	Allen screw	M10x1x25		**007395** ●
3	Allen screw	M10x1x20		**007396** ●
3	Allen screw	M10x1x16		**007397** ●
	Grease nipple	M10x1		**007935** ●
	Relief plug	M10x1		**007983** ●
	Allen key	SW 5		**117509** ●
	Grease gun			**008239** ●

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





TurboPlan PLUS knife clamping

Hydro planerhead TurboPlan PLUS

Application:
Pre and finish planing with high feed speeds.

Machine:
High performance planing machines with precision spindles and counter bearing as well as a jointing unit.

Workpiece material:
Softwood and hardwood.

Technical information:
Tool body in weight optimized design with two independent hydro systems for the tool and knife clamping. Activated by a grease gun. Marathon coated planer knives with back serration (SB x 30 x 5 mm). Hydro planerheads can only be used in combination with a clamping collar.

Weight optimised design
HM 200 2 08

D mm	SB mm	BO mm	Z	n_{max} min^{-1}	ID
200	150	50	14	8000	**142230**
200	230	50	14	8000	**142231**
200	330	50	14	8000	**142232**
225	150	50	18	7200	**142233**
225	230	50	18	7200	**142234**
225	330	50	18	7200	**142235**
260	150	50	22	6200	**142236**
260	230	50	22	6200	**142237**
260	330	50	22	6200	**142238**

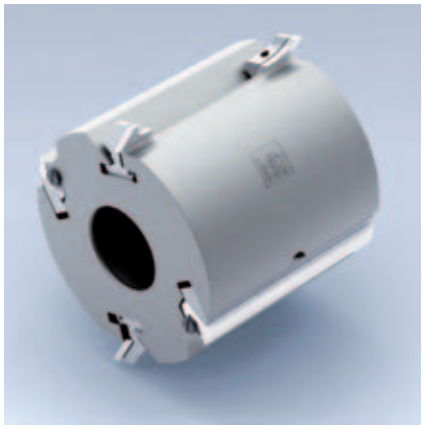
Spare knives:

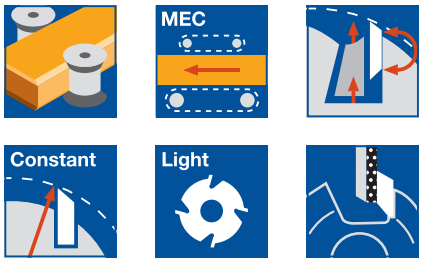
SB mm	H mm	DIK mm	QAL	ID
150	30	5	MC33	**697359** □
230	30	5	MC33	**697360** □
330	30	5	MC33	**697363** □

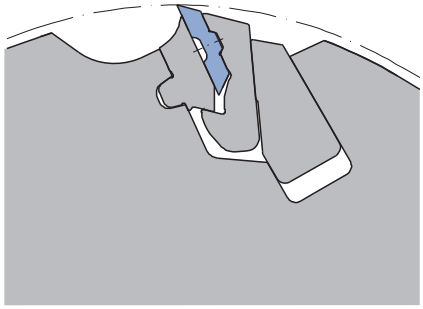
Spare parts:

BEZ	ABM mm	BEM	ID
Knife setting device	for TurboPlan		**142290**
Setting gauge for Hydro planerhead	Knife protrusion 3.8 mm		**142291**
Grease gun			**008239** ●
Grease cartridge	for Hydro sleeve		**007934** ●
Jointing stone (round)	12x32	Colour: grey	**008237** ●
Jointing stone (angular)	20x15x60	Colour: brown	**008238** ●

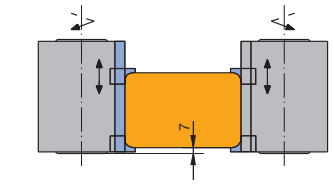
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

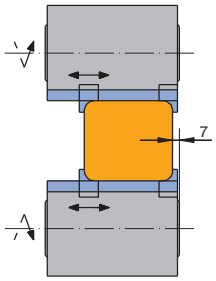






Lightweight aluminium tool body with steel chip breaker





Use on vertical or horizontal spindles
HD = SB - 40 mm

Planerhead VariPlan Plus/ProFix F system PF 25

Application:
For planing and profiling (chamfering) e.g. grooving, bevelling, rounding or profiling in common.

Machine:
Four-sided moulders.

Workpiece material:
Softwood and hardwood.

Technical information:
Resharpenable cutterhead system with constant diameter and constant profile. VariPlan Plus planerhead with knife seatings for ProFix F profile knives (PF 25) and HW microfinish turnblade knives. Profile knives: PT_{max} 25 mm, SB_{max} 100 mm. Lightweight aluminium tool body.

Bore 40 mm
WW 240 2 07

D mm	SB mm	ND mm	BO mm	QAL	n_{max} min^{-1}	Z	ID
125	130	136	40	HW	10200	2+2	**131060** ●
125	166	172	40	HW	10200	2+2	**131058** ●
125	236	242	40	HW	10200	2+2	**131059** ●

Further knife types, dimensions and inch dimensions on request. Servicing with spare parts only by the manufacturer. VariPlan Plus spare knives in section Knives and Spare Parts.

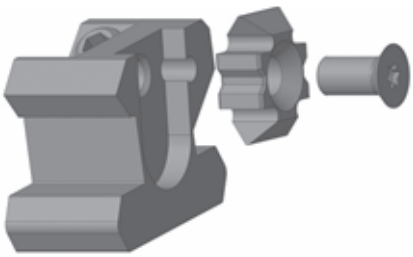
Spare knives:

BEZ	SB mm	ABM mm	QAL	ID LH	ID RH
ProFix F knife PF 25 R=3	25	R=3	HW	**011041** ●	**011042** ●
ProFix F knife PF 25 R=5	25	R=5	HW	**011043** ●	**011044** ●
ProFix F knife PF 25 R=10	25	R=10	HW	**011047** ●	**011048** ●
ProFix F knife PF 25 Bevel 45°	25	Bevel 45°	HW	**011051** ●	**011052** ●

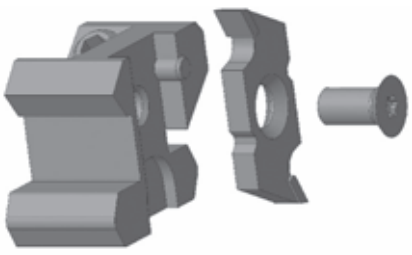
Further profile knives on request.

Spare parts:

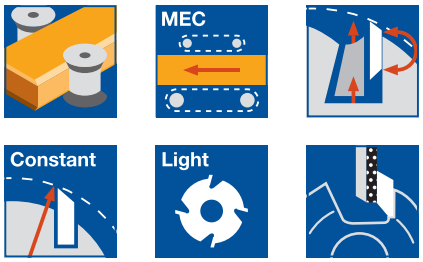
BEZ	ABM mm	ID LH	ID RH
Knife holder for edge knives	D=125, SW=20°	**011301** ●	**011300** ●
Knife holder for grooving knives	D=125, SW=20°, NT=6	**011303** ●	**011302** ●
Allen key	SW 4		**005445** ●
Allen key	SW 5		**005452** ●

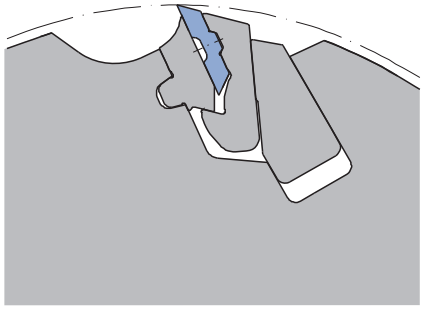


Knife holder to adapt edge knives.

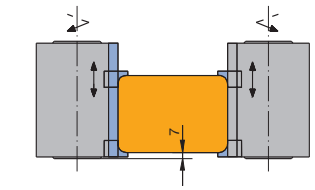


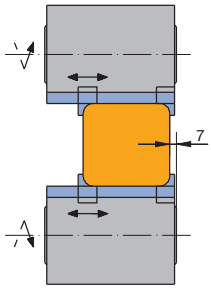
Knife holder to adapt grooving knives.





Lightweight aluminium tool body with steel chip breaker





Use on vertical or horizontal spindles
HD = SB - 40 mm

Planerhead VariPlan Plus/ProFix F system PF 25

Application:
For planing and profiling (chamfering) e.g. grooving, bevelling, rounding or profiling in common.

Machine:
Four-sided moulders with HSK 85 WS interface.

Workpiece material:
Softwood and hardwood.

Technical information:
Resharpenable cutterhead system with constant diameter and constant profile. VariPlan Plus planerhead with knife seatings for ProFix F profile knives (PF 25) and HW microfinish turnblade knives. Profile knives: PT_{max} 25 mm, SB_{max} 100 mm. Lightweight aluminium tool body.

HSK 85 WS
WP 240 2 01

D mm	SB mm	A mm	Z	n_{max} min^{-1}	DRI	BEM	ID
125	130	26	2+2	10200	LH	left/on bottom	**131120** □
125	130	26	2+2	10200	RH	right/on top	**131121** □
125	166	26	2+2	10200	LH	left/on bottom	**131116** □
125	166	26	2+2	10200	RH	right/on top	**131117** □
125	236	26	2+2	10200	LH	on bottom	**131118** □
125	236	26	2+2	10200	RH	on top	**131119** □

Further knife types, dimensions and inch dimensions on request. Servicing with spare parts only by the manufacturer. VariPlan Plus spare knives in section Knives and Spare Parts.

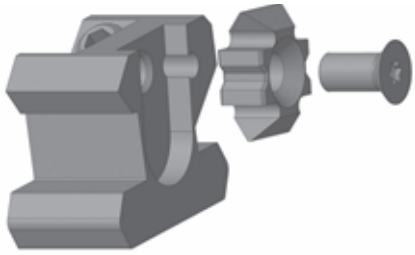
Spare knives:

BEZ	SB mm	ABM mm	QAL	ID LH	ID RH
ProFix F knife PF 25 R=3	25	R=3	HW	**011041** ●	**011042** ●
ProFix F knife PF 25 R=5	25	R=5	HW	**011043** ●	**011044** ●
ProFix F knife PF 25 R=10	25	R=10	HW	**011047** ●	**011048** ●
ProFix F knife PF 25 Bevel 45°	25	Bevel 45°	HW	**011051** ●	**011052** ●

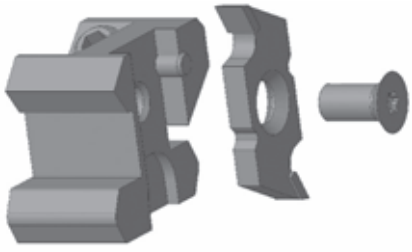
Further profile knives on request.

Spare parts:

BEZ	ABM mm	ID LH	ID RH
Knife holder for edge knives	D=125, SW=20°	**011301** ●	**011300** ●
Knife holder for grooving knives	D=125, SW=20°, NT=6	**011303** ●	**011302** ●
Allen key	SW 4		**005445** ●
Allen key	SW 5		**005452** ●

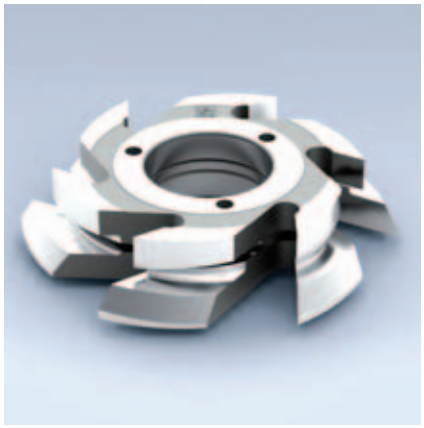


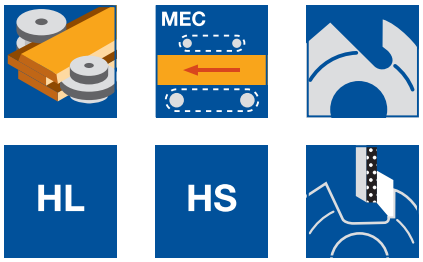
Knife holder to adapt edge knives.

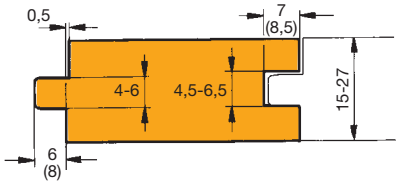


Knife holder to adapt grooving knives.

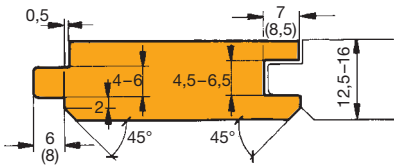
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



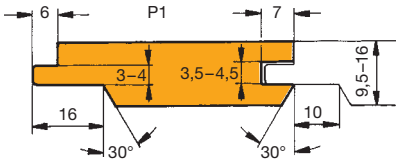




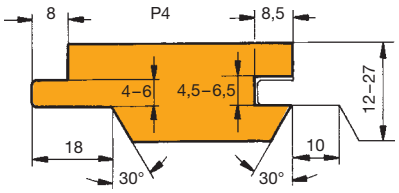
Profile 3: AF 200 2



Profile 5: AF 210 2



Profile 1: AF 240 2



Profile 4: AF 240 2

Tongue and groove cutter, HL solid / HS tipped

Application:
For tongue and groove profiles on wall and ceiling panels.

Machine:
Four-sided moulders.

Workpiece material:
Softwood, along grain.

Technical information:
Tongue and groove cutterset with spacers for adjustment to different wood thicknesses and tongue and groove widths. BO 60 for use on hydro sleeve for high feed speeds and machining qualities. HL profile cutter with form ground clearance and large resharpening area; HS tipped design with straight clearance.

Straight with closed joint (P3), as viewed from finished face
AF 200 2

P	D mm	BO mm	HD mm	Z	NT mm	FL mm	n_{max} min^{-1}	QAL	ID
3	180	60	15 - 27	6	8.5	8	9000	HL	**021876**
3	160	40	15 - 27	6	8.5	8	9000	HS	**022016**

Bevel profile with closed joint (P5), as viewed from finished face
AF 210 2

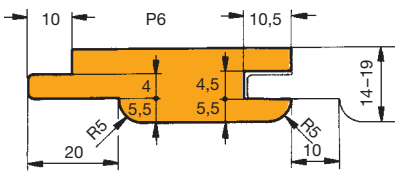
P	D mm	BO mm	HD mm	Z	NT mm	FL mm	n_{max} min^{-1}	QAL	ID
5	160	40	12.5 - 16	6	7	6	9000	HS	**021913**

Bevel profile (P1, P4)
AF 240 2

P	D mm	BO mm	HD mm	NT mm	FL mm	Z	n_{max} min^{-1}	QAL	ID
1	180	60	12 - 27	7	6	6	9000	HL	**021964** ●
4	180	60	12 - 27	8	8.5	6	9000	HL	**021969** ●

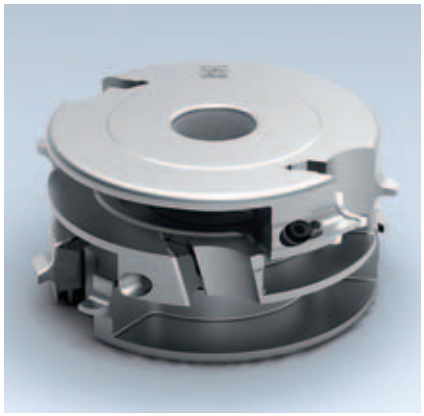
Radius profile R5 (P6)
AF 221 2

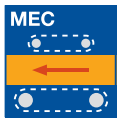
P	D mm	BO mm	HD mm	NT mm	FL mm	Z	n_{max} min^{-1}	QAL	ID
6	180	60	14 - 19	10	10.5	6	9000	HL	**021883**

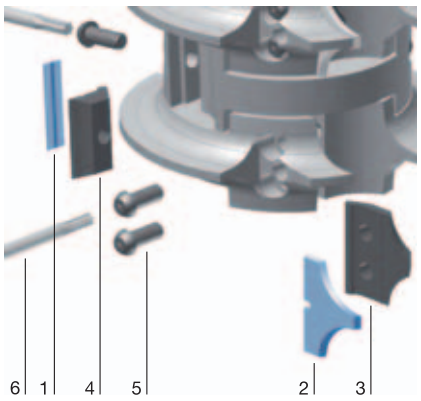


Profile 6: AF 221 2

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org







Profile cutterhead set ProfilCut Q - bevelling / rounding

Application:
Multi-purpose tool set for bevelling, rounding and jointing the workpiece edges at the same time.

Machine:
Spindle moulders, copy shaping and moulders, double-end tenoner.

Workpiece material:
Softwood and hardwood.

Technical information:
With a combination of jointing and bevelling/rounding cutterheads, different profiles and wood thicknesses can be machined. Profile knives with different radii/bevels can be mounted in one cutterhead.

Mechanical feed
SE 541 2 53

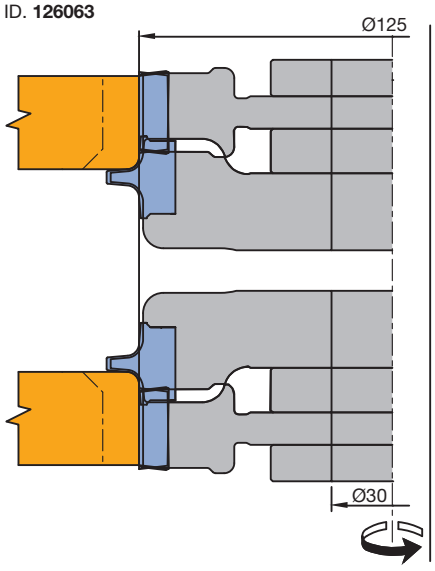
Tool Type	D_0 mm	AW PCS	n_{max} min^{-1}	Z	ID
Jointing-rounding	125	2	8000	2	**126063** □
Rounding-jointing-rounding	125	3	8000	2	**126064** □
Rounding-rounding	125	2	8000	2	**126065** □

Further radii are available at short notice.

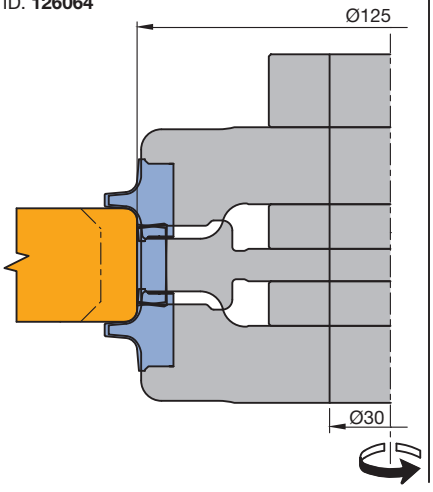
Spare parts:

Part-no.	BEZ	ABM mm	Tool no.	ID
3	Clamping wedge	18x22x8.27	1/2	**629231**
3	Clamping wedge	33x28x8.27	3/4	**629232**
3	Clamping wedge	38x29.71x8.27	5	**629233**
3	Clamping wedge	38x29.71x8.27	6	**629234**
3	Clamping wedge	48x31.73x8.27	7	**629235**
3	Clamping wedge	48x31.73x8.27	8	**629236**
4	Clamping wedge	18x18.75x8.27	20	**009671** ●
4	Clamping wedge	33x18.75x8.27	35	**009674** ●
4	Clamping wedge	48x18.75x8.27	50	**009677** ●
5	Clamping screw w. disc, Torx® 25	M6x18.5		**007442** ●
6	Torx® key	Torx® 25		**117504** ●

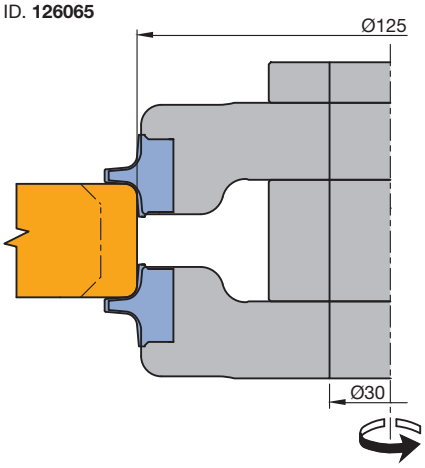
ID. **126063**



ID. **126064**

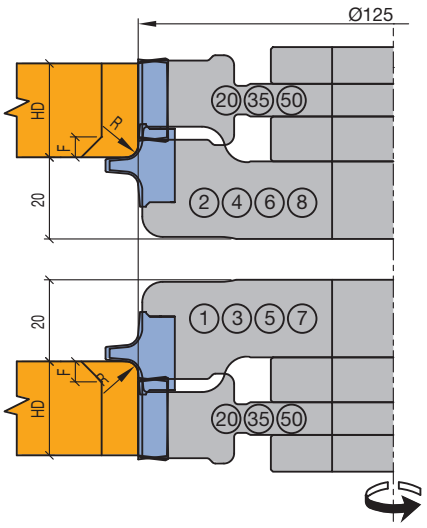


ID. **126065**



● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

ID. 126063



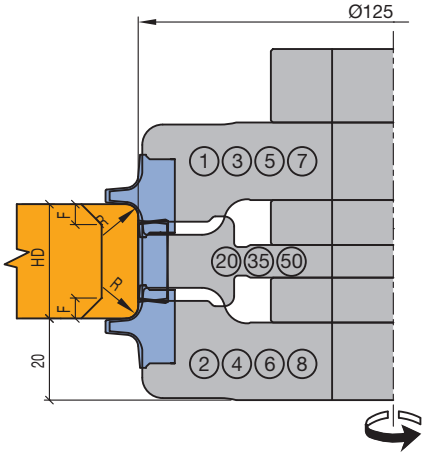
Order example:
-Combination ID 126063
-Profile description top down RL
jointingSB35/R5 or R5/jointingSB35
-Bore diameter 30

Wood thickness (HD):

Jointing tool	20	35	50
max. HD	18+R (F)	33+R (F)	48+R (F)

F (bevel) max. = 5 or 9x45°

ID. 126064



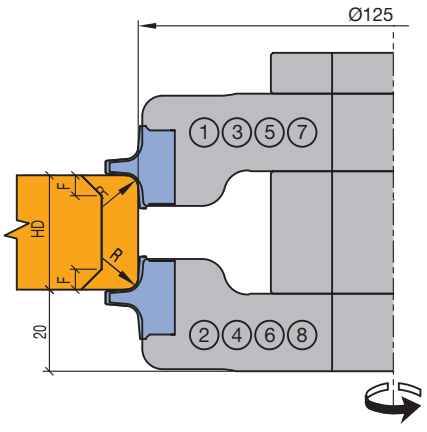
Order example:
-Combination ID 126064
-Profile description top down RL
R5/jointingSB35/R5
-Bore diameter 30

Radii tools	Jointing tool 20	35	50
No.1+2	6	12	24
No.1+4	13	19	31
No.1+6	18	24	36
No.1+8	28	34	46
No.3+2	13	19	31
No.3+4	20	26	38
No.3+6	25	31	43
No.3+8	35	41	53
No.5+2	18	24	36
No.5+4	25	31	43
No.5+6	30	36	48
No.5+8	40	46	58
No.7+2	28	34	46
No.7+4	35	41	53
No.7+6	40	46	58
No.7+8	50	56	68
max. HD	18+R+R (F+F)	33+R+R (F+F)	48+R+R (F+F)

Minimum wood thickness

F (bevel) max. = 3, 5, 7x45° or 8x40°
Wood thicknesses are calculated with max. bevel

ID. 126065



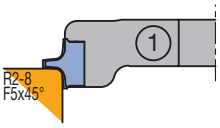
Order example:
-Combination ID 126065
-Profile description top down RL
R5/R5
-Bore diameter 30

Radii tools	
No.1+2	-2
No.1+4	5
No.1+6	10
No.1+8	20
No.3+2	5
No.3+4	12
No.3+6	17
No.3+8	27
No.5+2	10
No.5+4	17
No.5+6	22
No.5+8	32
No.7+2	20
No.7+4	27
No.7+6	32
No.7+8	42

Minimum wood thickness

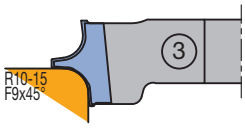
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

Spare part:
clamping wedge 629231



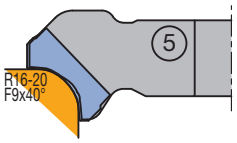
WZ 125306 / ME 619247	R4	
WZ 125307 / ME 619248	R5	
WZ 125308 / ME 619249	R6	
WZ 125309 / ME 619250	R7	
WZ 125304 / ME 619245	R2	
WZ 125310 / ME 619251	R8	
WZ 125305 / ME 619246	R3	
WZ 125311 / ME 619253	F5x45°	

Spare part:
clamping wedge 629232



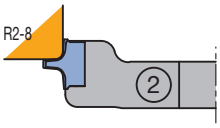
WZ 125321 / ME 619255	R11	
WZ 125322 / ME 619256	R12	
WZ 125323 / ME 619257	R13	
WZ 125324 / ME 619258	R14	
WZ 125325 / ME 619259	R15	
WZ 125320 / ME 619254	R10	
WZ 125326 / ME 619260	F9x45°	

Spare part:
clamping wedge 629233



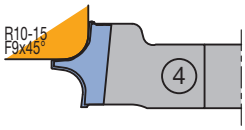
WZ 125334 / ME 619263	R16	
WZ 125335 / ME 619264	R17	
WZ 125336 / ME 619265	R18	
WZ 125337 / ME 619266	R19	
WZ 125338 / ME 619267	R20	
WZ 125339 / ME 619269	F9x40°	

Spare part:
clamping wedge 629231



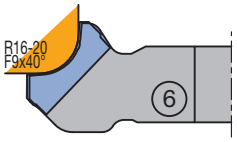
WZ 125314 / ME 619247	R4	
WZ 125315 / ME 619248	R5	
WZ 125316 / ME 619249	R6	
WZ 125317 / ME 619250	R7	
WZ 125312 / ME 619245	R2	
WZ 125318 / ME 619251	R8	
WZ 125313 / ME 619246	R3	
WZ 125319 / ME 619253	F5x45°	

Spare part:
clamping wedge 629232



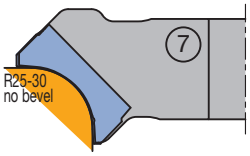
WZ 125328 / ME 619255	R11	
WZ 125329 / ME 619256	R12	
WZ 125330 / ME 619257	R13	
WZ 125331 / ME 619258	R14	
WZ 125332 / ME 619259	R15	
WZ 125327 / ME 619254	R10	
WZ 125333 / ME 619260	F9x45°	

Spare part:
clamping wedge 629234



WZ 125340 / ME 619271	R16	
WZ 125341 / ME 619272	R17	
WZ 125342 / ME 619273	R18	
WZ 125343 / ME 619274	R19	
WZ 125344 / ME 619275	R20	
WZ 125345 / ME 619277	F9x40°	

Spare part:
clamping wedge 629235

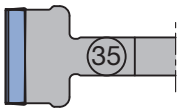


WZ 125346 / ME 619279	R25	
WZ 125347 / ME 619280	R26	
WZ 125348 / ME 619281	R27	
WZ 125349 / ME 619282	R28	
WZ 125350 / ME 619283	R29	
WZ 125351 / ME 619284	R30	

SB 20

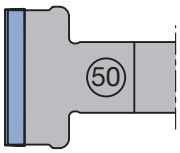
WZ 23015
ME 5071
VE 10 pcs.)
Wedge 9671

SB 35



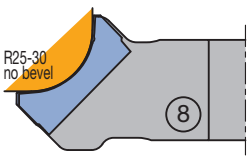
WZ 23016
ME 5073
VE 10 pcs.)
Wedge 9674

SB 50



WZ 23017
ME 5075
VE 10 pcs.)
Wedge 9677

Spare part:
clamping wedge 629236

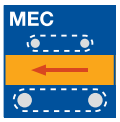


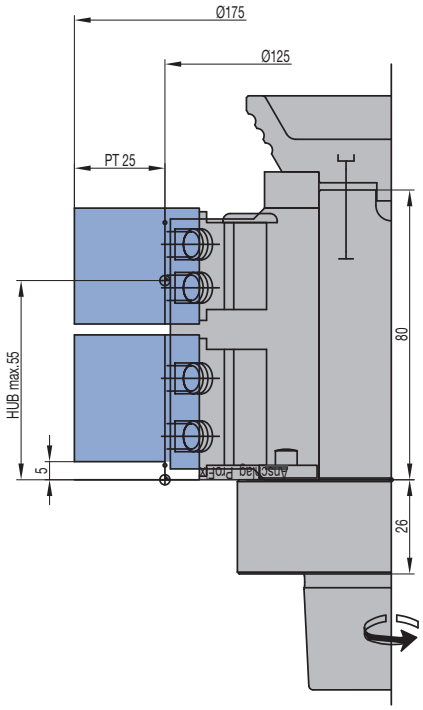
WZ 125352 / ME 619285	R25	
WZ 125353 / ME 619286	R26	
WZ 125354 / ME 619287	R27	
WZ 125355 / ME 619288	R28	
WZ 125356 / ME 619289	R29	
WZ 125357 / ME 619290	R30	

Spacer set
(one set per cutterhead necessary)

60x20x30

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





Profile cutterhead ProFix F

Application:
Flexible profiling of different profiles, suitable for panel production.

Machine:
Four-sided moulder and profiling machine.

Workpiece material:
Softwood and hardwood, with grain.

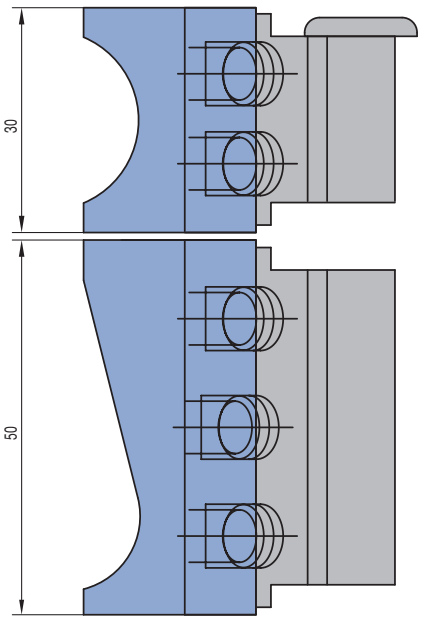
Technical information:
Resharpenable, diameter and profile constant tooling system. Easy profile adjustment through knife change. No tool measurement required. To adapt ProFix F knives with 4.5 mm resharpening area and a profile depth of 25 mm max. Lightweight aluminium tool body. Division of maximum cutting width to several knives possible.

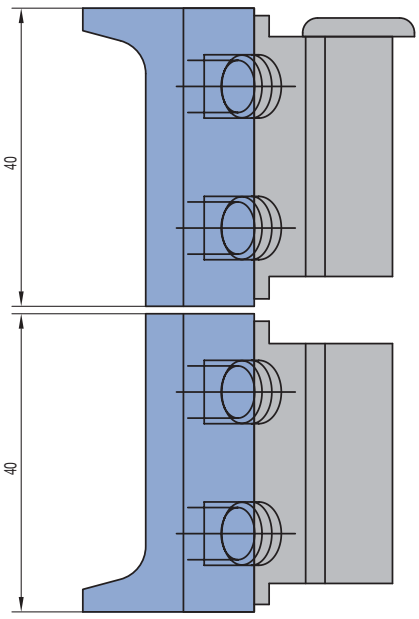
Bore 40 mm
HY 500 2 25

D_0 mm	PT mm	SB mm	n_{max} min^{-1}	Z	ID
125	25	20 - 70	10000	2	**014044** ●
125	25	20 - 90	10000	2	**014043** ●

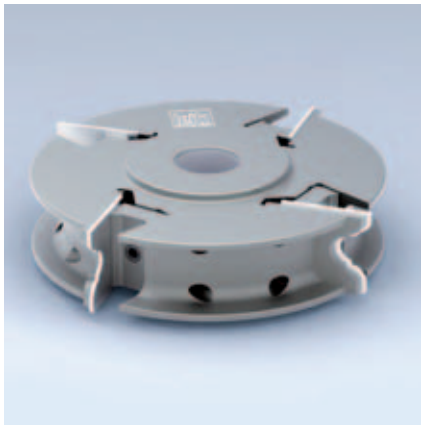
HSK 85 WS
HY 500 2 25

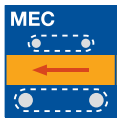
D_0 mm	PT mm	SB mm	n_{max} min^{-1}	BEM	Z	ID
125	25	20 - 70	10000	right/top	2	**014046** □
125	25	20 - 70	10000	left/bottom	2	**014048** □
125	25	20 - 90	10000	right/top	2	**014045** □
125	25	20 - 90	10000	left/bottom	2	**014047** □

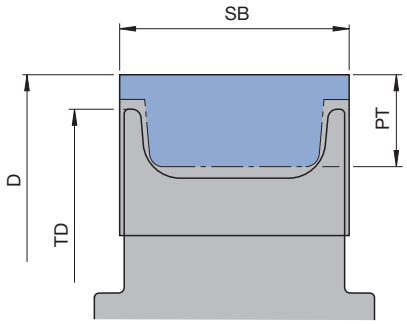




● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Tool body, U profile

Table of the 0-diameter (D_0)
for adjusting the machine spindles

D mm	TD mm	D_0 mm
150	135	110
165	140	125
180	165	140

Profile cutterhead VariForm

Application:
For cutting profiles. Different profiles with maximum 20 mm profile depth can be mounted.

Machine:
Moulders, double-end tenoners, edgebanding machines etc.

Workpiece material:
Softwood and hardwood (HW-30F), panel materials or glued wood (HW-10F).

Technical information:
Multi-purpose cutterhead for MEC feed with tungsten carbide special profile knives and backing plates.
Resharpenable 3 to 4 times.

Partly profiled tool body, MEC feed, Z 2 - Z 4 U profile
TT 531 2

D mm	TD mm	SB mm	BO mm	BO_{max} mm	PT_{max} mm	Z	n_{max} min^{-1}	ID
165	140	40	30	40	20	2	10000	**135212** ●
165	140	60	30	40	20	2	10000	**135214** ●
180	165	40	30	50	20	4	9000	**135206** ●
180	165	60	30	50	20	4	9000	**135208** ●

Supplied with clamping wedges, but without backing plates and knives.

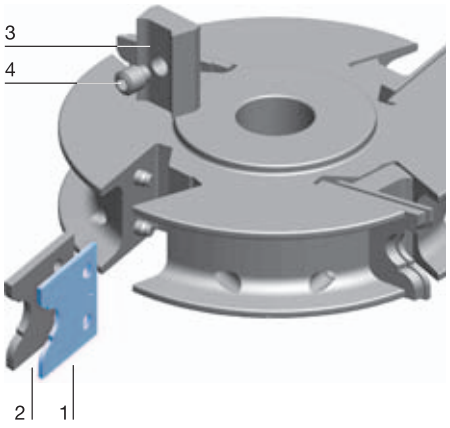
Spare knives:

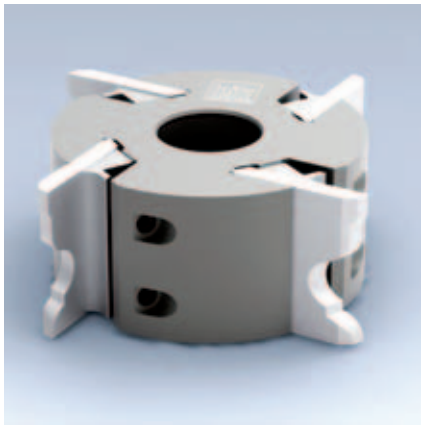
Part-no.	H mm	SB mm	ID HW-10F	ID HW-30F
1	45	40	**636226** ●	**636239** ●
1	45	60	**636287** ●	**636275** ●

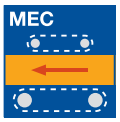
Spare parts:

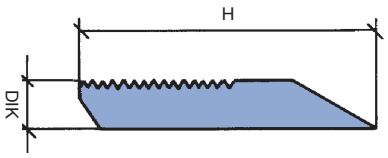
Part-no.	BEZ	ABM mm	for SB mm	ID
2	Backing plate VariForm	for knives 40x45x2.1		**645004** ●
2	Backing plate VariForm	for knives 60x45x2.1		**645006** ●
3	Clamping wedge	36x13.21x26	40/45	**009756** ●
3	Clamping wedge	56x13.21x26	60	**009757** ●
4	Allen screw with ISK 5	M10x12		**006044** ●
	Allen key	SW 5, L100		**117506** ●

Tool system description VariForm see section Profile Tool Systems.

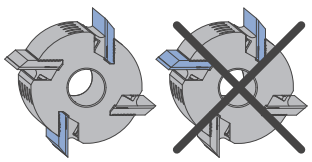








Serrated back blank knives with high precision serration, serration angle 60°, pitch 1.6 mm.



Attention:
For safety reasons, always mount knives + backing plates (VE) of the same weight opposite to each other.

H	QAL	PT
mm		mm
50	MC	15
60	MC	20
70	MC	30
50	HW	10
60	HW	18
55		15
70		27

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

Profile cutterheads for serrated back blank knives

Application:
For multi-purpose profiles in hard and/or materials likely to splinter.

Machine:
Four-sided moulders.

Workpiece material:
Cutting angle 20° for softwood and hardwood in general.

Technical information:
Profile cutterhead with 60° serration, 1.6 mm pitch. Steel tool body. Blank knives with knife thickness 8 - 10 mm and knife heights of 40 - 70 mm can be used depending on required profile depth. Cutting materials: Marathon (MC) and HW.

Cutting angle 20°
WM 501 2 05

TD mm	SB mm	BO mm	BO_{max} mm	n_{max} min^{-1}	Z	ID
122	80	40	40	10300	2	**135805** ●
122	40	40	40	10300	4	**135802** ●
122	60	35	40	10300	4	**135806** ●
122	60	40	40	10300	4	**135808** ●
122	80	40	40	10300	4	**135809** ●
122	100	35	40	10300	4	**135810**
122	100	40	40	10300	4	**135812** ●
122	130	40	40	10300	4	**135814** ●
122	150	40	40	10300	4	**135817** ●
122	170	40	40	10300	4	**135816** ●
122	180	40	40	10300	4	**135819** ●
122	230	40	40	10300	4	**135821** ●
122	240	40	40	10300	4	**135822**
137	60	40	50	9400	4	**135823**
137	60	50	50	9400	4	**135825** ●
137	80	50	50	9400	4	**135826** ●
137	100	40	50	9400	4	**135827**
137	100	50	50	9400	4	**135829** ●
137	130	40	50	9400	4	**135830**
137	130	50	50	9400	4	**135831** ●
137	150	50	50	9400	4	**135833** ●
137	180	50	50	9400	4	**135836**
137	230	50	50	9400	4	**135838** ●

Workpiece material:
Cutting angle 12° for materials likely to splinter such as oak, Douglas fir, merbau and wood fibre materials, e.g. MDF.

Cutting angle 12°
WM 501 2 05

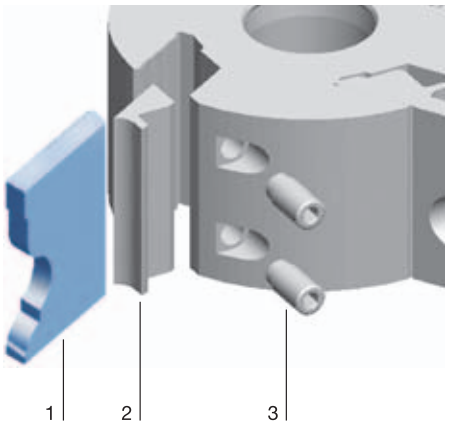
TD mm	SB mm	ND mm	BO mm	Z	ID
122	40	40	40	4	**135840**
122	60	60	40	4	**135841**
122	80	80	40	4	**135842**
122	130	130	40	4	**135843**

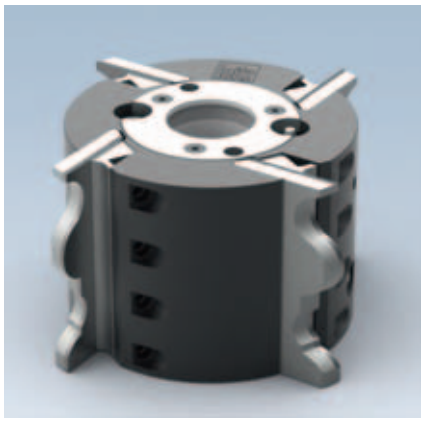
Cutterhead without knives. For blank knives in different dimensions and qualities, see section Knives and Spare Parts.
Lightweight aluminium design on request.

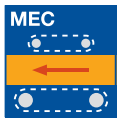
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

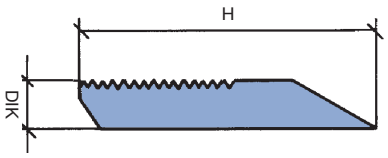
Spare parts:

Part-no.	BEZ	ABM mm	for SB mm	ID
2	Clamping wedge	38x25.3x10.8	40	**620700** ●
2	Clamping wedge	58x25.3x10.8	60	**620701** ●
2	Clamping wedge	78x25.3x10.8	80	**620702** ●
2	Clamping wedge	98x25.3x10.8	100	**620703** ●
2	Clamping wedge	128x25.3x10.8	130	**620705** ●
2	Clamping wedge	148x25.3x10.8	150	**620706** ●
2	Clamping wedge	168x25.3x10.8	170	**620707** □
2	Clamping wedge	178x25.3x10.8	180	**620708** □
2	Clamping wedge	228x25.43x11	230	**620709** □
2	Clamping wedge	238x25.3x10.8	240	**620710** □
3	Allen screw	M10x1x20		**007396** ●
	Filler piece	40x30x8	40	**005305** ●
	Filler piece	60x30x8	60	**005306** ●
	Filler piece	80x30x8	80	**005307** ●
	Filler piece	100x30x8	100	**005308** ●
	Filler piece	130x30x8	130	**005310** ●
	Filler piece	150x30x8	150	**005311** ●
	Filler piece	170x30x8	170	**620770** ●
	Filler piece	180x30x8	180	**005312** ●
	Filler piece	230x30x8	230	**005313** ●
	Filler piece	240x30x8	240	**620771** ●
	Allen key	SW 5		**117509** ●

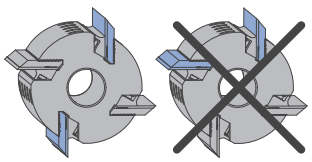








Serrated back blank knives with high precision serration, serration angle 60°, pitch 1.6 mm.



Attention:
For safety reasons, always mount knives + backing plates (VE) of the same weight opposite to each other.

H mm	QAL	PT mm
50	MC	15
60	MC	20
70	MC	30
50	HW	10
60	HW	18
55		15
70		27

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

Hydro profile cutterhead for serrated back blank knives

Application:
Cutting of multi-purpose profiles with high feed speeds.

Machine:
Four-sided moulders and profile machines.

Workpiece material:
Softwood and hardwood.

Technical information:
Profile cutterhead with 60°-serration, 1.6 mm pitch. Steel tool body with corrosion resistant surface protection. For blank knives with 8 - 10 mm knife thickness and 5 mm (see table) and 40 - 70 mm knife height, depending on the required profile depth. Integrated hydro clamping system with exchangeable clamping sleeves. Activated by a grease gun. Hydro profile cutterheads can only be used in combination with a clamping collar.

Steel tool body
HM 501 2 05

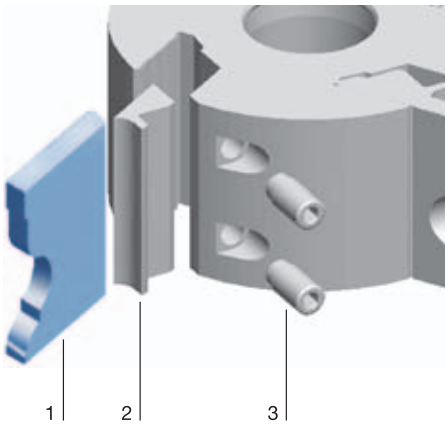
TD mm	SB mm	BO mm	for knife thickness mm	Z	n_{max} min^{-1}	ID
135	100	40	8 - 10	4	9400	**137035**
135	150	40	8 - 10	4	9400	**137036**
145	60	50	8 - 10	6	9100	**137037** ●
145	100	50	8 - 10	6	9100	**137038**
150	60	50	8 - 10	4	8800	**137039** ●
150	100	50	8 - 10	4	8800	**137040** ●
150	150	50	8 - 10	4	8800	**137041** ●
150	230	50	8 - 10	4	8800	**137042** ●
150	60	50	8 - 10	6	8800	**137043** ●
150	100	50	8 - 10	6	8800	**137044** ●
150	150	50	8 - 10	6	8800	**137045** ●
150	230	50	8 - 10	6	8800	**137046**
165	60	50	8 - 10	8	8200	**137047** ●
165	100	50	8 - 10	8	8200	**137048** ●
170	60	50	8 - 10	8	8100	**137049** ●
170	100	50	8 - 10	8	8100	**137050**
170	150	50	8 - 10	8	8100	**137051** ●
190	60	50	5	12	7400	**137052**
190	60	50	5	14	7400	**137053**

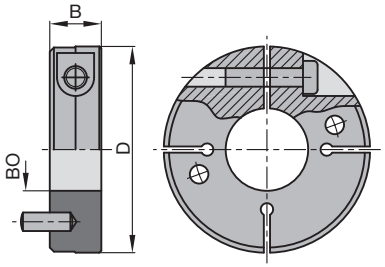
Cutterhead without knives. Blanks in various dimensions and qualities see section Knives and Spare Parts.

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

Spare parts:

Part-no.	BEZ	ABM	for SB	ID
		mm	mm	
2	Clamping wedge	38x25.3x10.8	40	**620700** ●
2	Clamping wedge	58x25.3x10.8	60	**620701** ●
2	Clamping wedge	78x25.3x10.8	80	**620702** ●
2	Clamping wedge	98x25.3x10.8	100	**620703** ●
2	Clamping wedge	128x25.3x10.8	130	**620705** ●
2	Clamping wedge	148x25.3x10.8	150	**620706** ●
2	Clamping wedge	168x25.3x10.8	170	**620707** □
2	Clamping wedge	178x25.3x10.8	180	**620708** □
2	Clamping wedge	228x25.43x11	230	**620709** □
2	Clamping wedge	238x25.3x10.8	240	**620710** □
3	Allen screw	M10x1x20		**007396** ●
	Filler piece	40x30x8	40	**005305** ●
	Filler piece	60x30x8	60	**005306** ●
	Filler piece	80x30x8	80	**005307** ●
	Filler piece	100x30x8	100	**005308** ●
	Filler piece	130x30x8	130	**005310** ●
	Filler piece	150x30x8	150	**005311** ●
	Filler piece	170x30x8	170	**620770** ●
	Filler piece	180x30x8	180	**005312** ●
	Filler piece	230x30x8	230	**005313** ●
	Filler piece	240x30x8	240	**620771** ●
	Allen key	SW 5		**117509** ●



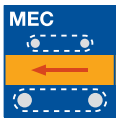


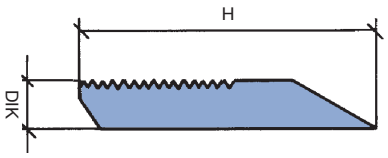
Clamping collar without thread

Clamping collars without thread

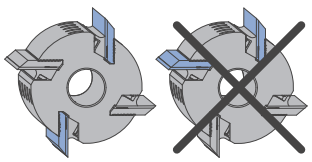
TD 870 0

D	B	BO	ID
mm	mm	mm	
100	25	40	**030700** ●
100	25	50	**030702** ●





Serrated back blank knives with high precision serration, serration angle 60°, pitch 1.6 mm.



Attention:
For safety reasons, always mount knives + backing plates (VE) of the same weight opposite to each other.

H mm	QAL	PT mm
50	MC	15
60	MC	20
70	MC	30
50	HW	10
60	HW	18
55		15
70		27

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

Profile cutterhead with HSK 85 WS for serrated back blank knives

Application:
For multi-purpose profiles in hard and/or materials likely to splinter.

Machine:
Four-sided moulders with HSK 85 WS interface.

Workpiece material:
Cutting angle 20° for softwood and hardwood in general.
Cutting angle 12° for materials likely to splinter e.g. oak, Douglas fir, merbau and wood fibre materials, e.g. MDF.

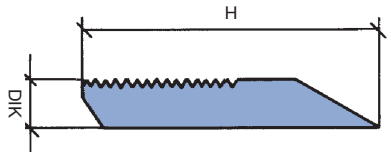
Technical information:
Profile cutterhead with back serration, 1.6 mm pitch, with integrated HSK.
Blanks with knife thickness 8 - 10 mm and knife heights of 40 - 70 mm can be used depending on the required profile depth. Cutting materials: Marathon (MC) and HW.
Steel tool body. High balance quality by assembly with parts of the same weight.

Cutting angle 20°
WP 510 2 02

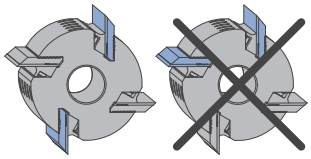
	TD mm	SB mm	A mm	Z	n_{max} min^{-1}	ID LH / bottom	ID RH / top
	90	40	26	2	12000	**136200**	**136201**
	90	60	26	2	12000	**136202** ●	**136203** ●
	90	80	26	2	12000	**136204** ●	**136205** ●
	90	100	26	2	12000	**136206** ●	**136207** ●
	90	130	26	2	12000	**136208** ●	**136209** ●
	90	150	26	2	12000	**136210**	**136211**
*	90	170	26	2	12000	**136212** ●	**136213** ●
*	90	210	26	2	12000	**136216**	**136217**
*	90	240	26	2	12000	**136218** ●	**136219** ●
	90	270	26	2	8000	**136220**	**136221**
	90	40	26	4	12000	**136224** ●	**136225** ●
	90	60	26	4	12000	**136226** ●	**136227** ●
	90	80	26	4	12000	**136228** ●	**136229** ●
	90	100	26	4	12000	**136230** ●	**136231** ●
	90	130	26	4	12000	**136232** ●	**136233** ●
	90	150	26	4	12000	**136234**	**136235**
*	90	170	26	4	12000	**136236** ●	**136237** ●
*	90	210	26	4	12000	**136240**	**136241**
*	90	240	26	4	12000	**136242** ●	**136243** ●
*	90	270	26	4	8000	**136244**	**136245**
	115	80	26	6	10000	**136198** ●	**136199** ●
	115	130	26	6	10000	**136400** ●	**136401** ●
	115	170	26	6	10000	**136402** ●	**136403** ●
	115	240	26	6	8000	**136404** ●	**136405** ●

* = Not for PKS blank knives H = 70 mm with n = 12,000 min^{-1}
Cutterhead without knives. For blank knives in different dimensions and qualities, see section Knives and Spare Parts.

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Serrated back blank knives with high precision serration, serration angle 60°, pitch 1.6 mm.



Attention:
For safety reasons, always mount knives + backing plates (VE) of the same weight opposite to each other.

H mm	QAL	PT mm
50	MC	15
60	MC	20
70	MC	30
50	HW	10
60	HW	18
55		15
70		27

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

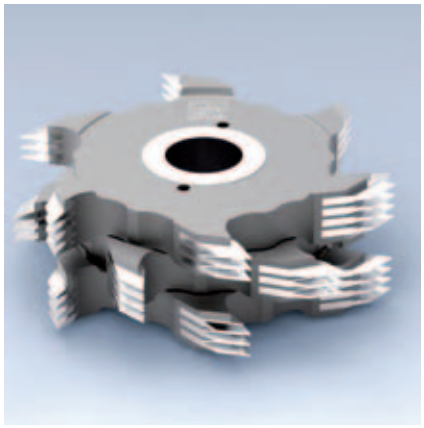
Cutting angle 12°
WP 510 2 02

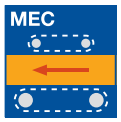
	TD mm	SB mm	A mm	Z	n_{max} min^{-1}	ID LH / bottom	ID RH / top
	90	40	26	2	12000	**136248** ●	**136249** ●
	90	60	26	2	12000	**136250** ●	**136251** ●
	90	80	26	2	12000	**136252**	**136253**
	90	100	26	2	12000	**136254** ●	**136255** ●
	90	130	26	2	12000	**136256** ●	**136257** ●
	90	150	26	2	12000	**136258**	**136259**
*	90	170	26	2	12000	**136260**	**136261**
*	90	210	26	2	12000	**136264**	**136265**
*	90	240	26	2	12000	**136266**	**136267**
	90	40	26	4	12000	**136270** ●	**136271** ●
	90	60	26	4	12000	**136272** ●	**136273** ●
	90	80	26	4	12000	**136274** ●	**136275** ●
	90	100	26	4	12000	**136276** ●	**136277** ●
	90	130	26	4	12000	**136278**	**136279**
	90	150	26	4	12000	**136280**	**136281**
*	90	170	26	4	12000	**136282**	**136283**
	115	80	26	6	10000	**136192**	**136193**
	115	130	26	6	10000	**136194**	**136195**
	115	170	26	6	10000	**136196**	**136197**

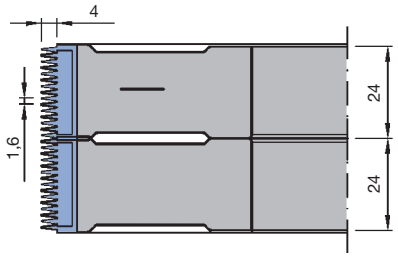
* = Not for PKS blank knives H = 70 mm with n = 12,000 min^{-1}
Cutterhead without knives. For blank knives in different dimensions and qualities, see section Knives and Spare Parts.

Spare parts:

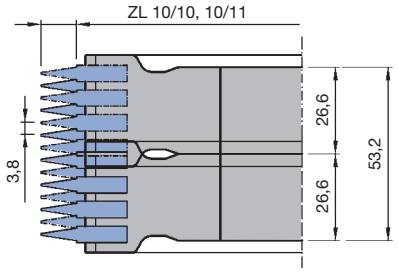
BEZ	for knife thickness mm	for SB mm	ID
Clamping wedge	8/10	40	**620816** ●
Clamping wedge	8/10	60	**620817** ●
Clamping wedge	8/10	80	**620818** ●
Clamping wedge	8/10	100	**620819** ●
Clamping wedge	8/10	130	**620820** ●
Clamping wedge	8/10	150	**620821** ●
Clamping wedge	8/10	170	**620822** ●
Clamping wedge	8/10	190	**620823** ●
Clamping wedge	8/10	210	**620824** ●
Clamping wedge	8/10	240	**620825** ●
Clamping wedge	8/10	270	**620826** ●
Clamping wedge	8/10	310	**620827** ●
Allen screw			**007396** ●
Filler piece		40	**005305** ●
Filler piece		60	**005306** ●
Filler piece		80	**005307** ●
Filler piece		100	**005308** ●
Filler piece		130	**005310** ●
Filler piece		150	**005311** ●
Filler piece		170	**620770** ●
Filler piece		190	**620772** ●
Filler piece		210	**620773** ●
Filler piece		240	**620771** ●
Filler piece		270	**620774** ●
Filler piece		310	**620775** ●
Dust protection cover			**008244** ●
Allen key			**117509** ●



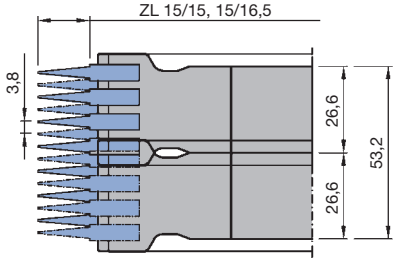




Minifinger joint cutter ZL 4 mm, TG 1.6 mm



Minifinger joint cutter ZL 10 mm, TG 3.8 mm



Minifinger joint cutter ZL 15 mm, TG 3.8 mm

Minifinger joint cutter, HS

Application:
For self-locking longitudinal joints. See section introduction for additional information.

Machine:
Finger joint machines with/without cut-off saw, continuous machines.

Workpiece material:
Softwood, across grain; limited suitability for hardwood.

Technical information:
Reduced risk of breakage from individually brazed finger cutting edges. Design with enlarged tip gap suitable for PU adhesives and for finger joint machines without cut-off saw and horizontal working spindle. Cutting material HS. Resharpening area 12 mm.

ZL 4 mm, TG 1.6 mm
WF 620 2

D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ZL mm	ID
160	25	22.4	50	2/2	15	HS	4	**021543** ●

ZL 10 mm, TG 3.8 mm
WF 620 2

D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 10/10	ID ZL 10/11
160	28.6	26.6	50	2/2	7	HS	**021685** ●	**021689** ●
160	28.6	26.6	50	3/3	7	HS	**120313** □	**021692** ●
250	28.6	26.6	50	3/3	7	HS	**021688** □	**021693** ●
250	28.6	26.6	50	4/4	7	HS	**120316** □	**120318** □

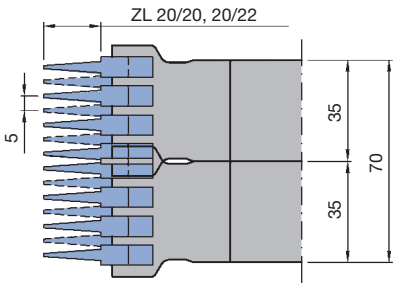
ZL 15 mm, TG 3.8 mm
WF 620 2

D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 15/15	ID ZL 15/16.5
170	28.6	26.6	50	2/2	7	HS	**021694** ●	**021696** ●
260	28.6	26.6	50	3/3	7	HS	**021695** □	**021697** ●
260	28.6	26.6	80	4/4	7	HS	**120420**	**120422**

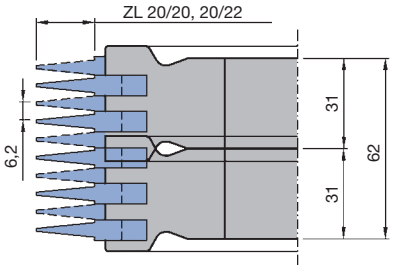
ZL 15 mm, TG 3.8 mm, for application with PU glue
WF 620 2

D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 15/15	ID ZL 15/16.5
170	28.6	26.6	50	2/2	7	HS	**120412** ●	**120414** □
260	28.6	26.6	50	3/3	7	HS	**120413** □	**120415** □
260	28.6	26.6	80	4/4	7	HS	**120421**	**120423**

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Minifinger joint cutter ZL 20 mm, TG 5.0 mm



Minifinger joint cutter ZL 20 mm, TG 6.2 mm

ZL 20 mm, TG 5.0 mm
WF 620 2

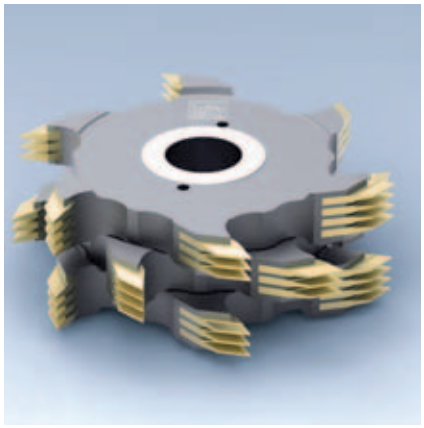
D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 20/20	ID ZL 20/22
180	37	35	50	2/2	7	HS	**021729** ●	**021730** □

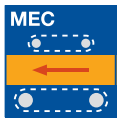
ZL 20 mm, TG 6.2 mm
WF 620 2

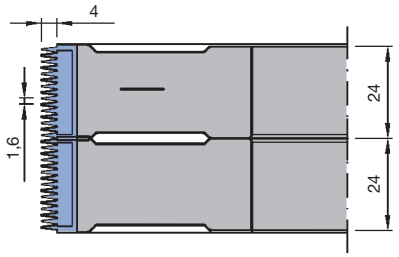
D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 20/20	ID ZL 20/22
180	33	31	50	2/2	5	HS	**021668** ●	**021669** ●
260	33	31	50	3/3	5	HS	**021674** □	**021670** □
260	33	31	80	4/4	5	HS	**120525**	**120527**

ZL 20 mm, TG 6.2 mm, for application with PU glue
WF 620 2

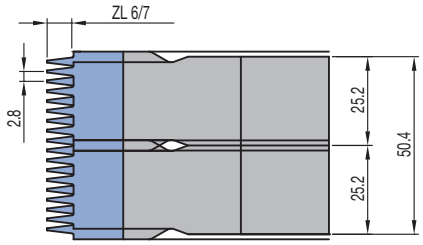
D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 20/20	ID ZL 20/22
180	33	31	50	2/2	5	HS	**120515** ●	**120516** ●
260	33	31	50	3/3	5	HS	**120510** □	**120511** □
260	33	31	80	4/4	5	HS	**120524**	**120526**



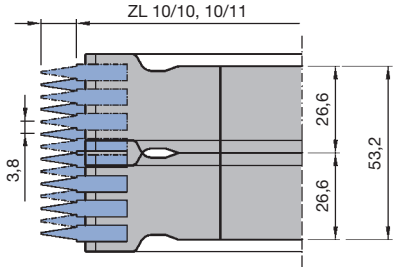




Minifinger joint cutter ZL 4 mm, TG 1.6 mm



Minifinger joint cutter ZL 6/7 mm, TG 2.8 mm



Minifinger joint cutter ZL 10 mm, TG 3.8 mm

Minifinger joint cutter, Marathon

Application:
For self-locking longitudinal joints. See section introduction for additional information.

Machine:
Finger joint machines with/without cut-off saw, continuous machines.

Workpiece material:
Softwood, across grain; also suitable for hardwood.

Technical information:
Reduced risk of breakage from individually brazed finger cutting edges. Design with enlarged tip gap suitable for PU adhesives and for finger joint machines without cut-off saws and horizontal working spindle. Marathon coating allows up to 4 times longer tool life compared to HS version. Resharpening area 12 mm (or 8 mm for ID **123005** and ID **123102**).

ZL 4/5 mm, TG 1.6 mm
WF 620 2 06

D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ZL mm	ID
160	25	22.4	50	2/2	15	MC	4/5	**123003**
250	25	22.4	50	4/4	15	MC	4/5	**123004**
250	25	22.4	50	6/6	15	MC	4/5	**123005** ●

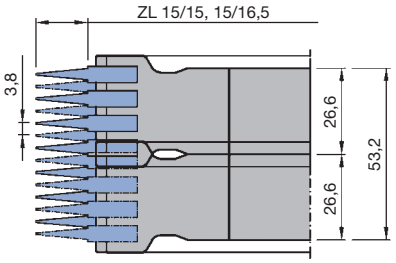
ZL 6/7 mm, TG 2.8 mm
WF 620 2 06

D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ZL mm	ID
160	34	33.6	50	3/3	12	MC	6/7	**123100** ●
250	34	33.6	50	4/4	12	MC	6/7	**123101** ●
250	34	33.6	50	6/6	12	MC	6/7	**123102** ●

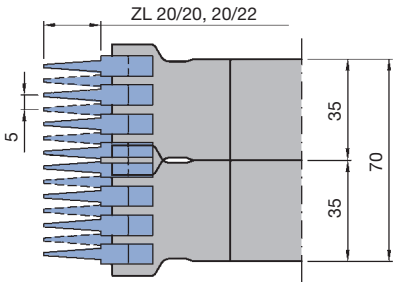
ZL 10 mm, TG 3.8 mm
WF 620 2 06

D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 10/10	ID ZL 10/11
160	28.6	26.6	50	2/2	7	MC	**120608** ●	**120612** ●
160	28.6	26.6	50	3/3	7	MC	**120616** □	**120617** □
250	28.6	26.6	50	3/3	7	MC	**120609** □	**120613** ●
250	28.6	26.6	50	4/4	7	MC	**120620** □	**120622** □

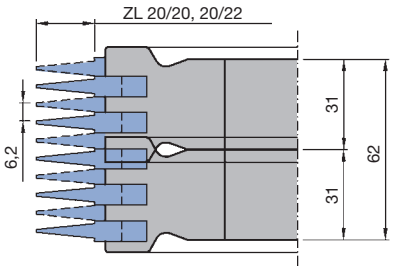
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Minifinger joint cutter ZL 15 mm, TG 3.8 mm



Minifinger joint cutter ZL 20 mm, TG 5.0 mm



Minifinger joint cutter ZL 20 mm, TG 6.2 mm

ZL 15 mm, TG 3.8 mm
WF 620 2 06

D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 15/15	ID ZL 15/16.5
170	28.6	26.6	50	2/2	7	MC	**120709** ●	**120713** ●
260	28.6	26.6	50	3/3	7	MC	**120710** □	**120714** ●
260	28.6	26.6	80	4/4	7	MC	**120721**	**120723**

ZL 15 mm, TG 3.8 mm, for application with PU glue
WF 620 2 06

D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 15/15	ID ZL 15/16.5
170	28.6	26.6	50	2/2	7	MC	**120711** ●	**120715** □
260	28.6	26.6	50	3/3	7	MC	**120712** □	**120716** □
260	28.6	26.6	80	4/4	7	MC	**120722**	**120724**

ZL 20 mm, TG 5.0 mm
WF 620 2 06

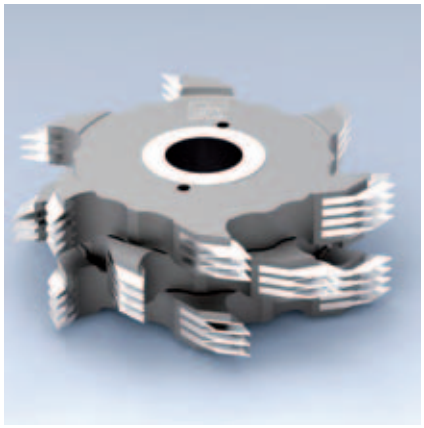
D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 20/20	ID ZL 20/22
180	37	35	50	2/2	7	MC	**120818** □	**120820** □
260	37	35	50	3/3	7	MC	**120819** □	**120821** □

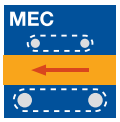
ZL 20 mm, TG 6.2 mm
WF 620 2 06

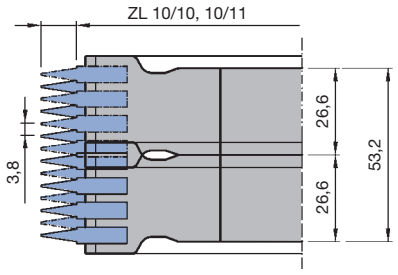
D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 20/20	ID ZL 20/22
180	33	31	50	2/2	5	MC	**120810** ●	**120814** □
260	33	31	50	3/3	5	MC	**120811** □	**120815** □
260	33	31	80	4/4	5	MC	**120834**	**120836**

ZL 20 mm, TG 6.2 mm, for application with PU glue
WF 620 2 06

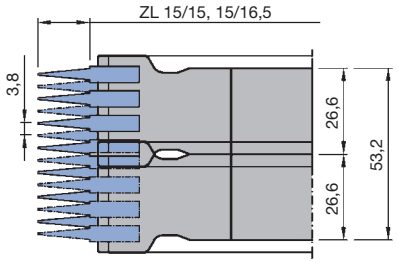
D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 20/20	ID ZL 20/22
180	33	31	50	2/2	5	MC	**120812** ●	**120816** □
260	33	31	50	3/3	5	MC	**120813** □	**120817** □
260	33	31	80	4/4	5	MC	**120835**	**120837**







Minifinger joint cutter ZL 10 mm, TG 3.8 mm



Minifinger joint cutter ZL 15 mm, TG 3.8 mm

Minifinger joint cutter, HW

Application:
For self-locking longitudinal joints. See section introduction for additional information.

Machine:
Finger joint machines with/without cut-off saws, continuous machines.

Workpiece material:
Hardwood, across grain.

Technical information:
Reduced risk of breakage from individually brazed finger cutting edges. Cutting material HW. Resharpening area 12 mm.

ZL 10 mm, TG 3.8 mm
WF 620 2

D mm	SB mm	BO mm	Z	ZA PCS	QAL	n_{max} min^{-1}	ID ZL 10/10	ID ZL 10/11
160	28.6	50	2/2	7	HW	8000	**021600** ●	**021601** ●
160	28.6	50	3/3	7	HW	8000	**021604** □	**021603** ●
250	28.6	50	3/3	7	HW	6000	**021605** □	**021602** ●

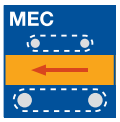
ZL 15 mm, TG 3.8 mm
WF 620 2

D mm	SB mm	BO mm	Z	ZA PCS	QAL	n_{max} min^{-1}	ID ZL 15/15	ID ZL 15/16.5
170	28.6	50	2/2	7	HW	8000	**021644** ●	**021645** ●
260	28.6	50	3/3	7	HW	6000	**021652**	**021648**

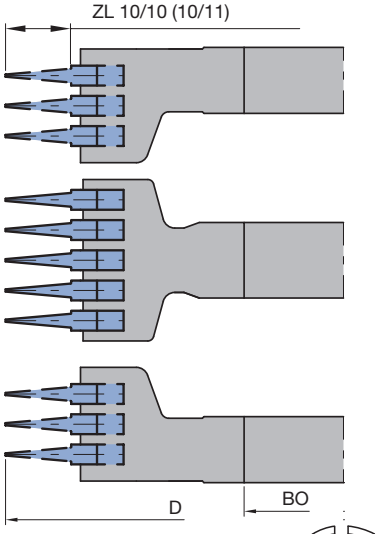
Table to determine the number of cutters for a given wood thickness.
Finger length 10 and 15 mm;
D = 160/250 mm and 170/260 mm
Finger pitch = 3.8 mm

SB	28.6 mm
Hub	26.6 mm
ZA	Tooth row ZA 7
Wood thickness	Quantity cutter
24	1
51	2
77	3
104	4
131	5
157	6
184	7
210	8
237	9
264	10
290	11
317	12

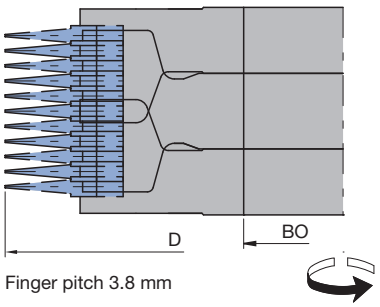
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



ZL 15/15 (15/16,5)
ZL 10/10 (10/11)



Finger pitch 3.8 mm



Finger pitch 3.8 mm

Minifinger joint cutter, Marathon, real Z 4

Application:
For self-locking longitudinal joints. See section introduction for additional information.

Machine:
High performance finger joint machines with/without cut-off saws.

Workpiece material:
Softwood, across grain; also suitable for hardwood.

Technical information:
High number of teeth tool design, top and bottom final cutters required. Assembly of tool set: see section introduction. Version with enlarged tip gap suitable for PU adhesives and for finger joint machines without cut-off saws for horizontal spindle. Marathon coating allows up to 4 times longer tool life compared to HS version. Resharpening area 12 mm.

ZL 15 mm, TG 3.8 mm
WF 620 2 06, WF 623 2 06

Tool Type	D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 15/15	ID ZL 15/16.5
Top final cutter	170	20.2	16.6	50	4	3	MC	**121700** □	**121704** □
Basic cutter	170	35.4	19.0	50	4	5	MC	**120705** □	**120707** □
Bottom final cutter	170	20.2	16.6	50	4	3	MC	**121701** □	**121705** □

ZL 15 mm, TG 3.8 mm, for application with PU glue
WF 620 2 06, WF 623 2 06

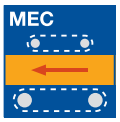
Tool Type	D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 15/15	ID ZL 15/16.5
Top final cutter	170	20.2	16.6	50	4	3	MC	**121702** ●	**121706** □
Basic cutter	170	35.4	19.0	50	4	5	MC	**120706** ●	**120708** □
Bottom final cutter	170	20.2	16.6	50	4	3	MC	**121703** ●	**121707** □
Top final cutter	200	20.2	16.6	60	4	3	MC	**121708**	**121710**
Basic cutter	200	35.4	19	60	4	5	MC	**120725**	**120726**
Bottom final cutter	200	20.2	16.6	60	4	3	MC	**121709**	**121711**

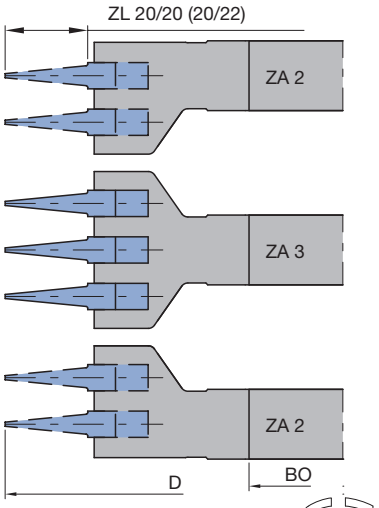
Finger length 10 and 15 mm
TG: 3,8 mm
Real Z4

		Basic cutter	Final cutter top	Final cutter bottom
ZA		5	3	3
ND		19	16,6	16,6
HD	KLH	Cutter quantity	Cutter quantity	Cutter quantity
19	33,2	0	1	1
38	52,2	1	1	1
57	71,2	2	1	1
76	90,2	3	1	1
95	109,2	4	1	1
114	128,2	5	1	1
133	147,2	6	1	1
152	166,2	7	1	1
171	185,2	8	1	1
190	204,2	9	1	1
209	223,2	10	1	1
228	242,2	11	1	1
247	261,2	12	1	1
266	280,2	13	1	1
285	299,2	14	1	1
304	318,2	15	1	1
323	337,2	16	1	1

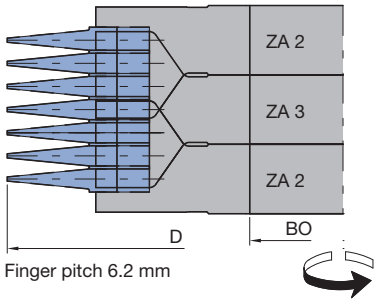
HD = wood thickness
KLH = clamping height

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





Finger pitch 6.2 mm



Finger pitch 6.2 mm

Minifinger joint cutter, Marathon, real Z 4

Application:
For self-locking longitudinal joints. See section introduction for additional information.

Machine:
High performance finger joint machines with/without cut-off saws.

Workpiece material:
Softwood, across grain; also suitable for hardwood.

Technical information:
High number of teeth tool design, top and bottom final cutters required. Assembly of tool set: see section introduction. Version with enlarged tip gap suitable for PU adhesives and for finger joint machines without cut-off saws for horizontal spindle. Marathon coating allows up to 4 times longer tool life compared to HS version. Resharpening area 12 mm.

ZL 20 mm, TG 6.2 mm
WF 623 2 06

Tool Type	D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 20/20	ID ZL 20/22
Top final cutter	180	18.6	18.6	50	4	2	MC	**121808**	**121810**
Basic cutter	180	31	18.6	50	4	3	MC	**120838**	**120840**
Bottom final cutter	180	18.6	18.6	50	4	2	MC	**121812**	**121814**

ZL 20 mm, TG 6.2 mm, for application with PU glue
WF 623 2 06

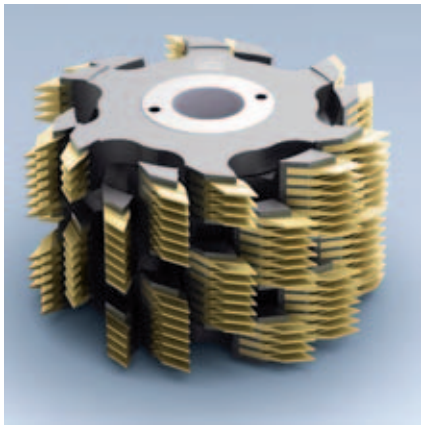
Tool Type	D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 20/20	ID ZL 20/22
Top final cutter	180	18.6	18.6	50	4	2	MC	**121809**	**121811**
Basic cutter	180	31	18.6	50	4	3	MC	**120839**	**120841**
Bottom final cutter	180	18.6	18.6	50	4	2	MC	**121813**	**121815**

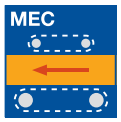
Finger length 20 mm
TG: 6,2 mm
Real Z3

		Basic cutter	Final cutter top	Final cutter bottom
ZA		3	2	2
ND		18,6	18,6	18,6
HD	KLH	Cutter quantity	Cutter quantity	Cutter quantity
19	37,2	0	1	1
37	55,8	1	1	1
56	74,4	2	1	1
74	93	3	1	1
93	111,6	4	1	1
112	130,2	5	1	1
130	148,8	6	1	1
149	167,4	7	1	1
167	186	8	1	1
186	204,6	9	1	1
205	223,2	10	1	1
223	241,8	11	1	1
242	260,4	12	1	1
260	279	13	1	1
279	297,6	14	1	1
298	316,2	15	1	1
316	334,8	16	1	1

HD = wood thickness
KLH = clamping height

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





Minifinger joint cutter, Marathon, real Z 6

Application:
For self-locking longitudinal joints. See section introduction for additional information.

Machine:
High performance finger joint machines with/without cut-off saws.

Workpiece material:
Softwood, across grain; also suitable for hardwood.

Technical information:
High number of teeth tool design, top and bottom final cutters required. Assembly of tool set: see section introduction. Version with enlarged tip gap suitable for PU adhesives and for finger joint machines without cut-off saws for horizontal spindle. Marathon coating allows up to 4 times longer tool life compared to HS version. Resharpening area 12 mm.

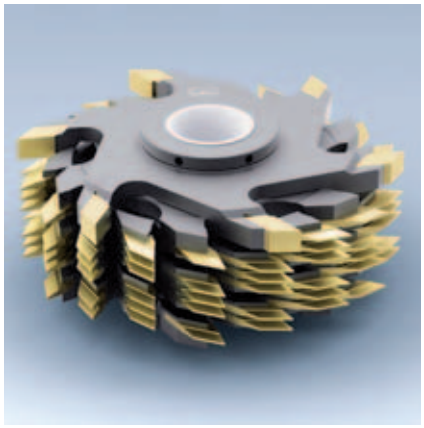
ZL 10 mm, TG 3.8 mm
WF 620 2 06, WF 623 2 06

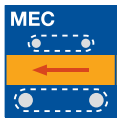
Tool Type	D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ZL mm	ID
Top final cutter	250	26.6	19	50	6	4	MC	10/11	**121012** ●
Basic cutter	250	49.4	26.6	50	6	7	MC	10/11	**120601** ●
Bottom final cutter	250	26.6	19	50	6	4	MC	10/11	**121013** ●

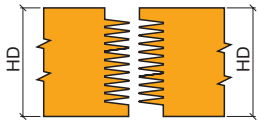
Finger length 10 mm and 15 mm
TG: 3,8 mm
Real Z6

		Basic cutter	Final cutter top	Final cutter bottom
ZA		7	4	4
ND		26,6	19	19
HD	KLH	Cutter quantity	Cutter quantity	Cutter quantity
27	38	0	1	1
53	64,6	1	1	1
80	91,2	2	1	1
106	117,8	3	1	1
133	144,4	4	1	1
160	171	5	1	1
186	197,6	6	1	1
213	224,2	7	1	1
239	250,8	8	1	1
266	277,4	9	1	1
293	304	10	1	1

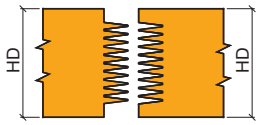
HD = wood thickness
KLH = clamping height







Profile 2



Profile 3

Minifinger joint cutter and shoulder cutter, Marathon, real Z 6

Application:
For self-locking longitudinal joints with straight visible joint for horizontal joints, e.g. solid wood panels or finger jointed profile strips. See section introduction for additional information.

Machine:
High performance finger joint machines with cut-off saw.

Workpiece material:
Softwood, across grain; also suitable for hardwood.

Technical information:
High number of teeth tool design. Tool set consists of basic cutter, extension cutter and shoulder cutters for different positions of the visible joint. Cutting width adjusted to wood thickness. Mounted on clamping sleeve. Marathon coating allows up to 4 times longer tool life compared to HS version. Resharpening area 12 mm.

Basic- / extension cutter ZL 10/11 mm, TG 3.8 mm
WF 620 2 06, WF 623 2 06

Tool Type	D	SB	ND	BO	Z	ZA	QAL	DRI	ID
	mm	mm	mm	mm		PCS			
Basic cutter	250	20.2	11.2	60	6	3	MC	RH	**120624** □
Extension cutter	250	5.0	11.2	60	6	1	MC	LH	**121608** □
Extension cutter	250	5.0	11.2	60	6	1	MC	RH	**121609** □
Extension cutter	250	12.6	11.2	60	6	2	MC	LH	**121610** □
Extension cutter	250	12.6	11.2	60	6	2	MC	RH	**121611** □

Shoulder cutter profile 2 and 3 for ZL 10/11 mm, TG 3.8 mm
WF 621 2 06

D	SB	BO	Z	QAL	ID	ID
mm	mm	mm			LH	RH
249.7	12	60	6	MC	**122400** □	**122401** □

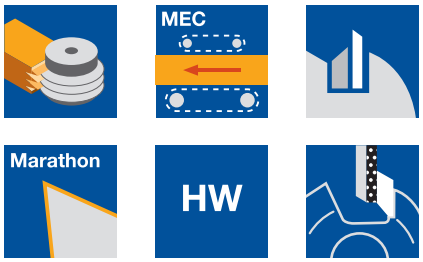
Clamping sleeve with threaded nut for LH/RH rotation
TB 270 0

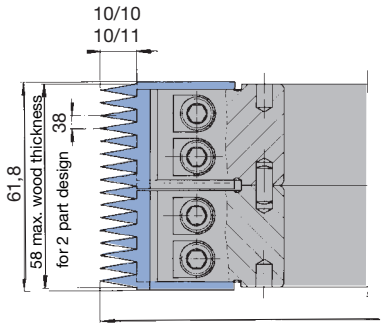
D	BO	NL	GL	ID
mm	mm	mm	mm	
60	50	85	105	**029474** ●
60	50	120	140	**029475** ●
60	50	150	170	**029476** ●
60	50	180	200	**029477** ●
60	50	210	230	**029478** ●
60	50	240	260	**029479** ●

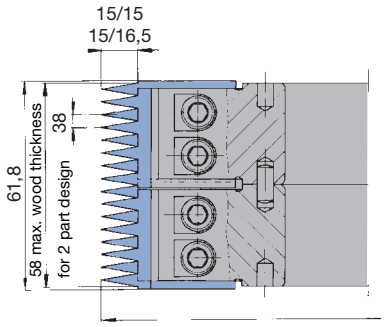
Spacer
TR 100 0

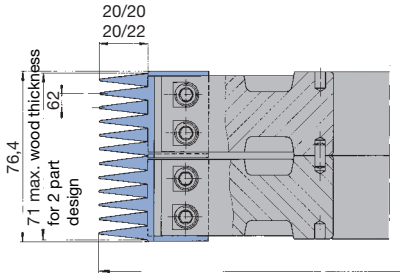
D	B	BO	ID
mm	mm	mm	
90	3.8	60	**028447** ●
90	11.4	60	**028448** ●

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org









Minifinger joint cutterhead with replaceable knives

Application:
For self-locking longitudinal joints. See section introduction for additional information.

Machine:
Finger joint machines with and without cut-off saw, continuous machines.

Workpiece material:
Softwood and hardwood.

Technical information:
Steel tool body with block knives. Individually replaceable knives if damaged. Always resharpen sets of tools to the same diameter. Marathon coating allows up to 4 times longer tool life compared to HS version. Resharpening area 10 mm for MC or 6 mm for HW.

ZL 10/10 and 10/11 mm, MC
WM 620 2 06

D mm	SB mm	BO mm	ND mm	Z	TG	ZA PCS	n_{max} min^{-1}	ID ZL 10/10	ID ZL 10/11
160	31.4	50	30.4	2/2	3.8	8	8000	**135900**	**135902**
250	31.4	50	30.4	3/3	3.8	8	4500	**135901**	**135903**

ZL 10/10 and 10/11 mm, HW
WM 620 2

D mm	SB mm	BO mm	ND mm	Z	TG	ZA PCS	n_{max} min^{-1}	ID ZL 10/10	ID ZL 10/11
160	31.4	50	30.4	2/2	3.8	8	8000	**022730**	**022731**
250	31.4	50	30.4	3/3	3.8	8	4500	**022732**	**022733**

ZL 15/15 and 15/16.5 mm, MC
WM 620 2 06

D mm	SB mm	BO mm	ND mm	Z	TG	ZA PCS	n_{max} min^{-1}	ID ZL 15/15	ID ZL 15/16.5
170	31.4	50	30.4	2/2	3.8	8	8000	**135904**	**135906**
260	31.4	50	30.4	3/3	3.8	8	4500	**135905**	**135907**

ZL 20/20 and 20/22 mm, MC
WM 620 2 06

D mm	SB mm	BO mm	ND mm	Z	TG	ZA PCS	n_{max} min^{-1}	ID ZL 20/20	ID ZL 20/22
180	39.2	50	37.2	2/2	6.2	6	8000	**135908**	**135910**
260	39.2	50	37.2	3/3	6.2	6	4500	**135909**	**135911**

Spare knives:

QAL	Cut-off saws	Tip gap	Profile knife	ZL mm	TG	ZA PCS	ID SET 2	ID SET 3
MC	without	standard	right	10/10	3.8	4	**611452** □	**611552** □
MC	without	standard	left	10/10	3.8	4	**611453** □	**611553** □
MC	without	standard	right	15/15	3.8	4	**611454** □	**611554** □
MC	without	standard	left	15/15	3.8	4	**611455** □	**611555** □
MC	without	standard	right	20/20	6.2	3	**611456** □	**611556** □
MC	without	standard	left	20/20	6.2	3	**611457** □	**611557** □
MC	with	standard	right	10/11	3.8	4	**611450** □	**611550** □
MC	with	standard	left	10/11	3.8	4	**611458** □	**611558** □
MC	with	standard	right	15/16.5	3.8	4	**611459** □	**611559** □
MC	with	standard	left	15/16.5	3.8	4	**611460** □	**611560** □
MC	with	standard	right	20/22	6.2	3	**611461** □	**611561** □
MC	with	standard	left	20/22	6.2	3	**611451** □	**611551** □
MC	without	large	right	10/10	3.8	4	**611474** □	**611574** □
MC	without	large	left	10/10	3.8	4	**611475** □	**611575** □
MC	without	large	right	15/15	3.8	4	**611476** □	**611576** □
MC	without	large	left	15/15	3.8	4	**611477** □	**611577** □
MC	without	large	right	20/20	6.2	3	**611478** □	**611578** □
MC	without	large	left	20/20	6.2	3	**611479** □	**611579** □
HW	without	standard	right	10/10	3.8	4	**611300** □	**611350** □
HW	without	standard	left	10/10	3.8	4	**611302** □	**611352** □
HW	with	standard	right	10/11	3.8	4	**611304** □	**611354** □
HW	with	standard	left	10/11	3.8	4	**611306** □	**611356** □

Table to determine the quantity of cutterheads for given wood thickness.

Cutterhead - block knife with pitch 3.8 mm

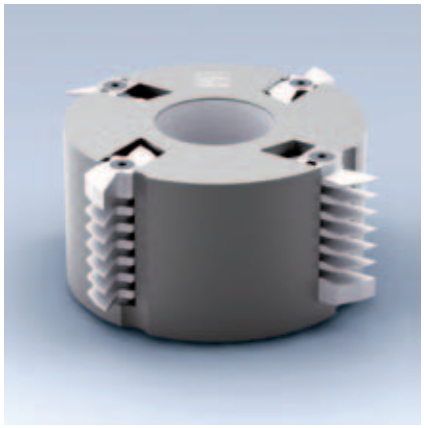
Finger length 10 and 10/11 mm 15 and 15/16.5 mm	
SB	31.4 mm
Hub	30.4 mm
ZA	Tooth row 8
Wood thickness	Quantity of cutterheads
28	1
58	2
89	3
119	4
150	5
180	6
210	7
241	8
271	9
302	10
332	11
362	12

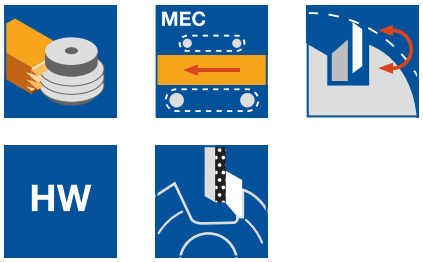
Table to determine the quantity of cutterheads for given wood thickness.

Cutterhead - block knife with pitch 6.2 m

Finger length 20/20 mm 22/22 mm	
SB	39.2 mm
Hub	37.2 mm
ZA	Tooth row 6
Wood thickness	Quantity of cutterheads
34	1
71	2
108	3
145	4
183	5
220	6
257	7
294	8
331	9
368	10

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

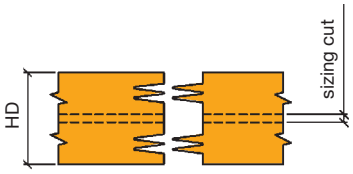




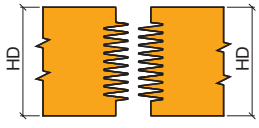
Profile 1 with continuous finger jointing

Profile 2 with staggered shoulder cutters

Profile 3 with shoulder cutters on the same level



Profile 4 with shoulder cutters for splitting



Profile 5 with half shoulder

Minifinger cutterhead with HW turnblade knives

Application:
For self-locking longitudinal joints for non-supporting components, e.g. panels and strips.

Machine:
Finger joint machines and continuous machines with cut-off saw.

Workpiece material:
Softwood and hardwood, across grain.

Technical information:
Steel tool body with HW turnblade knives. Particularly suitable for hardwood, e.g. for horizontal joints with and without shoulders. Variable design for defined wood thicknesses from 15 to 60 mm. The rest of the knife seating must be filled with spacers and a safety washer (spare part no. 4). Individual cutting edges can be replaced if a cutting edge breaks. Resharpening area 2 x 6 mm.

Profile 1, ZL 10/11 mm, TG 3.8 mm
WM 620 2 01

D mm	SB mm	BO mm	Z	HD mm	n_{max} min^{-1}	ID LH	ID RH
160	60	50	2/2	60	8000	**135001** □	**135000** □
250	60	50	3/3	60	5000	**135005** □	**135004** □

Attention: When assembling, always finish by fitting spacers with the securing device (spare part no. 4).

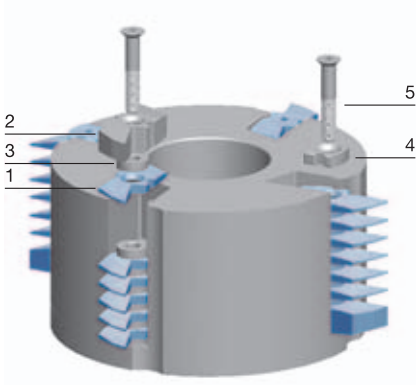
Tools for profile 2 - 5 on request.

Spare knives:

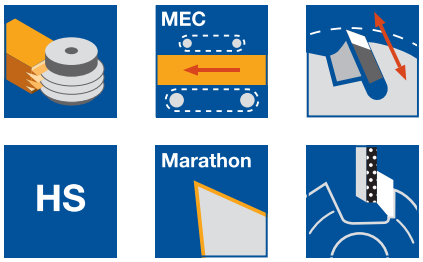
Part-no.	BEZ	P	ZL mm	SB mm	TG	QAL	ID
1	Minifinger knife		10/11	3.8	3.8	HW	**618002** ●
2	Shoulder knife	2. 3. 4	10/11	11.4	3.8	HW	**618005** ●
2	Shoulder knife	5	10/11	11.4	3.8	HW	**618006** ●

Spare parts:

Part-no.	BEZ	ABM mm	ID
3	Spacer for ZL 10/11	13x3.8x6.1	**008199** ●
3	Spacer	15x17x5	**008230** ●
4	Spacer with safety device	24.9x21x3.8	**008200** ●
4	Spacer with safety device	24.9x20x6.2	**008201** ●
5	Countersink screw, Torx® 20	M6x40	**006090** ●
5	Countersink screw, Torx® 20	M6x50	**007856** ●
5	Countersink screw, Torx® 20	M6x65	**007882** ●
5	Countersink screw, Torx® 20	M6x70	**007880** ●
	Torx® key	Torx® 20	**006091** ●



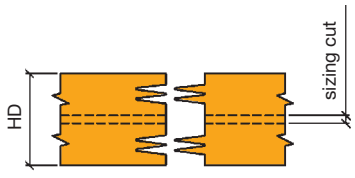
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Profile 1 with continuous finger jointing

Profile 2 with staggered shoulder cutters

Profile 3 with shoulder cutters on the same level



Profile 4 with shoulder cutters for splitting

Hydro minifinger cutterhead TurboHawk with curved knives

Application:
For self-locking longitudinal joints for non supporting components, e.g. panels and strips.

Machine:
High performance finger joint machines and continuous machines with cut-off saw.

Workpiece material:
Softwood; limited suitability for hardwood.

Technical information:
Resharpenable, constant diameter and constant profile tool system with hydro clamping. No machine adjustment required. Particularly suitable for horizontal joints with and without shoulders. Variable for defined wood thicknesses from 15 to 50 mm. The remaining knife seatings must be filled with spacers and a locking nut. Minifinger curved knives with extremely large resharpening area.

With curved knives ZL 6.35 mm (1/4"), TG 3.53 mm
HM 620 2 05

P	D mm	BO mm	HD_{max} mm	Z	QAL	n_{max} min^{-1}	ID LH	ID RH
1	266.67	50	50	5/5	HS	4000	**135524**	**135525**
2	266.67	50	50	5/5	HS	4000	**135532**	**135533**
3	266.67	50	50	5/5	HS	4000	**135540**	**135541**

With curved knives ZL 9.52 mm (3/8"), TG 4.3 mm
HM 620 2 05

P	D mm	BO mm	HD_{max} mm	Z	QAL	n_{max} min^{-1}	ID LH	ID RH
1	266.67	50	50	5/5	HS	4000	**135548**	**135549**
2	266.67	50	50	5/5	HS	4000	**135556**	**135557**
3	266.67	50	50	5/5	HS	4000	**135564**	**135565**

With curved knives ZL 10/11 mm, TG 3.8 mm
HM 620 2 05

P	D mm	BO mm	HD_{max} mm	Z	QAL	n_{max} min^{-1}	ID LH	ID RH
1	266.67	50	50	5/5	HS	4000	**135500**	**135501**
2	266.67	50	50	5/5	HS	4000	**135508**	**135509**
3	266.67	50	50	5/5	HS	4000	**135516**	**135517**

Please note the spindle arrangement. Arrangement for other wood thicknesses on request.

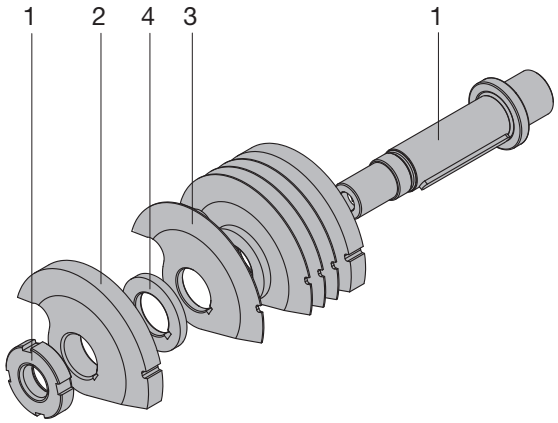
Spare knives:

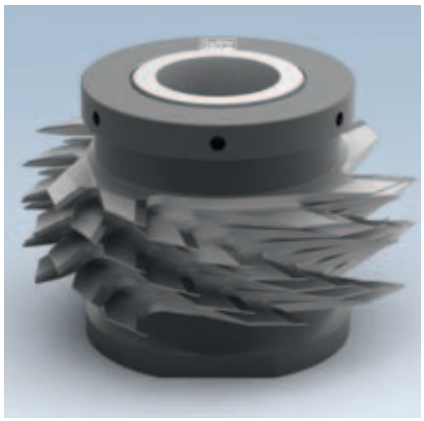
Part-no.	BEZ	ABM mm	ZL mm	ID HS	ID MC
3	Minifinger knife	38.1x3.53x19.05	6.35	**618202** ●	**618221** ●
2	Shoulder knife	38.1x8.74x19.05	6.35	**618252** ●	**618270** ●
3	Minifinger knife	38.1x4.3x19.05	9.52	**618208** ●	**618222** ●
2	Shoulder knife	38.1x9.51x19.05	9.52	**618258** ●	**618271** ●
3	Minifinger knife	38.1x3.8x19.05	10/11	**618200** ●	**618220** ●
2	Shoulder knife	38.1x11.4x19.05	10/11	**618250** ●	**618269** ●

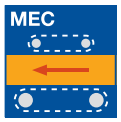
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

Spare parts:

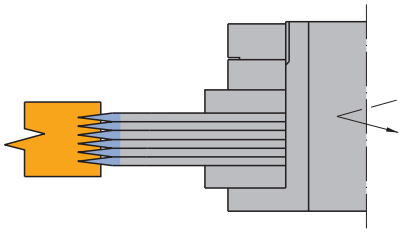
Part-no.	BEZ	ABM mm	TG	ID
	Setting gauge	D266.67x80		**005377** ●
1	Clamping arbor	HD 50 mm KL 55 mm		**008226** ●
1	Clamping arbor	HD 38 mm KL 43 mm		**008227** ●
1	Clamping arbor	HD 32 mm KL 34.5 mm		**008228** ●
1	Clamping arbor	HD 25 mm KL 29 mm		**008229** ●
	Sickle spanner	34/36 DIN 1810 A		**117510** ●
	Screw driver	SW 6, L50		**117508** ●
4	Filler piece for rounding knives	33x3.53x19.05,KN1.8x4.2	3.53	**008224** ●
4	Filler piece for rounding knives	33x4.3x19.05,KN1.8x4.2	4.3	**008225** ●
4	Filler piece for rounding knives	33x3.8x19.05,KN1.8x4.2	3.8	**008223** ●



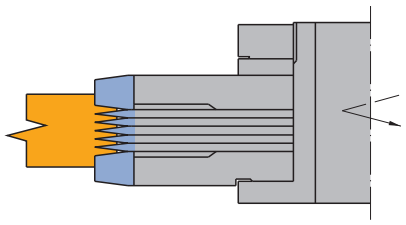




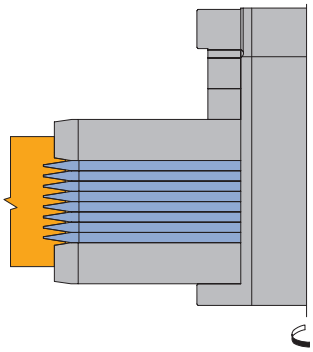
HW



Minifinger joint cutterset without shoulder cutters



Minifinger joint cutterset with shoulder cutters P3



Minifinger joint cutterset with shoulder cutters P5

Minifinger disc cutter, HW, with and without shoulder cutter

Application:
For self-locking longitudinal joints for non-supporting components, e.g. panels and strips.

Machine:
Finger joint machines with cut-off saws.

Workpiece material:
Hardwood and abrasive tropical wood.

Technical information:
HW tipped cutters. Tool body thickness corresponds to finger pitch. Particularly suitable for horizontal joints with and without shoulders. Variable design for defined wood thicknesses from 15 to 80 mm. Suitable for small wood thicknesses. Resharpening area 3.5 mm. Design in DP on request.

HW, ZL 10/11 mm, TG 3.8 mm
WF 620 2, WF 621 2

Tool Type	D mm	SB mm	BO mm	Z	n_{max} min^{-1}	ID
Minifinger joint cutter	160	3.8	70	2	9000	**022200** ●
Minifinger joint cutter	160	3.8	70	4	9000	**021511** ●
Minifinger joint cutter	250	3.8	70	6	6000	**021513** ●
Shoulder cutter	159.8	15.2	70	4	9000	**021762** ●
Shoulder cutter P3	249.7	15.2	70	6	6000	**021764** ●
Shoulder cutter P5	239.7	15.2	70	6	6000	**022153** ●

HW, ZL 10/11.5 mm, TG 4.0 mm
WF 620 2, WF 621 2

Tool Type	D mm	SB mm	BO mm	Z	n_{max} min^{-1}	ID
Minifinger joint cutter	160	4	70	2	9000	**021509** ●
Shoulder cutter	159.9	16	70	2	9000	**022204** ●

Clamping element with threaded nut
TB 270 0

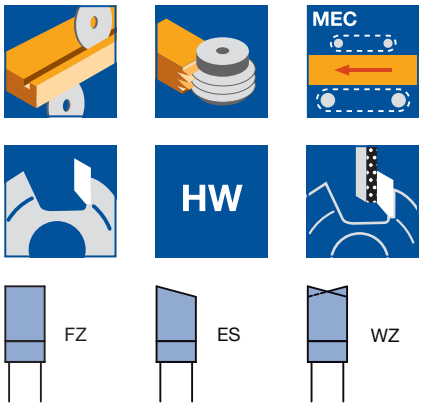
D mm	BO mm	NL mm	GL mm	DRI	ID
70	50	120	146	LH, RH	**029695** ●
70	50	80	110	LH, RH	**029473** ●

Spare parts:

BEZ	ABM mm	ID
Sickle spanner adjustable	D90/155; L290; DIN1816; tenon 6	**005462** ●

Spacers
TR 100 0

D mm	B mm	BO mm	TG	ID
100	3.8	70	3.8	**028437** ●
100	11.4	70	3.8	**028450** ●
100	15.2	70	3.8	**028439** ●
175	11.4	70	3.8	**028678** ●



Scorer for shoulder minifinger joints

Application:
For scoring in front of the trimming hogger or for machining the face edge of shoulder joints.

Machine:
Finger joint machines with trimming and scoring aggregates.

Workpiece material:
Softwood, hardwood and wood derived materials.

Technical information:
Particularly suitable for scoring the shoulders on finger joint machines. Tear-free shoulders guaranteed.

Scoring sawblade for Grecon PowerJoint
WK 100 2

D mm	SB mm	BO mm	Z	ZF	QAL	n_{max} min^{-1}	ID LH	ID RH
100	4.4	20	18	FZ	HW	8000	**061995** ●	**061995** ●

Single scoring saw mounted on flanged sleeve
SK 999 2

D mm	SB mm	BO mm	Z	ZF	QAL	n_{max} min^{-1}	ID LH	ID RH
200	6.5	40 DKN	48	WZ	HW	7200	**061986** □	**061987** □

Double scoring saw mounted on flanged sleeve
SK 999 2

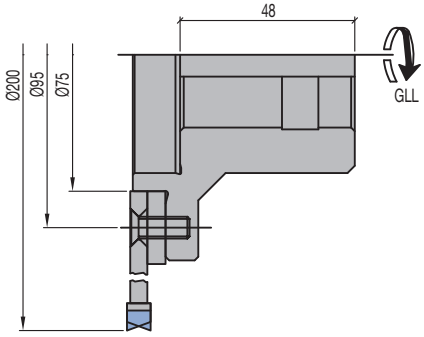
D mm	SB mm	BO mm	Z	ZF	QAL	n_{max} min^{-1}	ID LH	ID RH
200	12.2	40 DKN	48	WZ/WZ	HW	7200	**061988** □	**061989** □
200	12.3	40 DKN	48	ES/WZ	HW	7200	**061990** □	**061991** □
190								

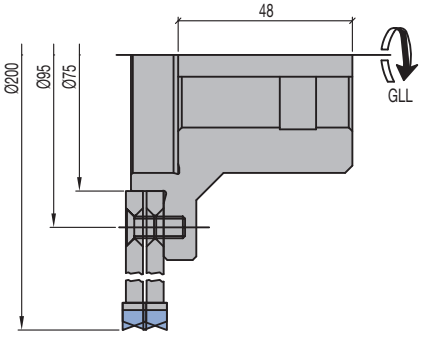
Spare sawblades:

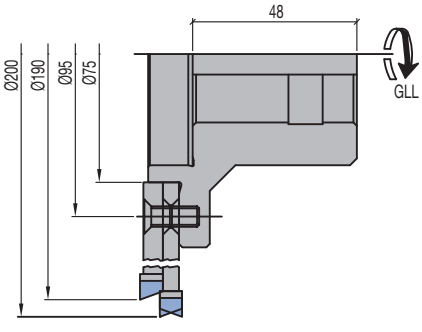
D mm	SB mm	BO mm	Z	ZF	NLA mm	QAL	n_{max} min^{-1}	ID LH	ID RH
200	6.5	75	48	WZ	6NL TK95	HW	7200	**061992** ●	**061992** ●
190	6.7	75	48	ES	6NL TK95	HW	7200	**061993** ●	**061994** ●

Spare parts:

BEZ	ABM mm	L mm	BO mm	ID
Flanged sleeve	113/75x61x40 DKN	61	40 DKN	**061680** ●
Flanged disc	D115/BO75/TK95		75	**028676** ●
Spacer	180x1x75		75	**028677** ●
Countersink screw, Torx® 20	M6x16			**006086** ●



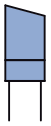




● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



HW


ES

Sawblade hogger for trimming minifingers

Application:
Defined trimming of the workpiece before cutting the fingers for adjusting the finger fitting.

Machine:
Finger joint machine with trimming aggregate, double-end profiler, tenoner.

Workpiece material:
Softwood, hardwood and wood derived materials.

Technical information:
HW circular saw blade with high number of teeth. Bevelled on one side for perfect cutting quality and reduced tear-outs.

Sawblade hogger mounted on flanged sleeve
SK 999 2

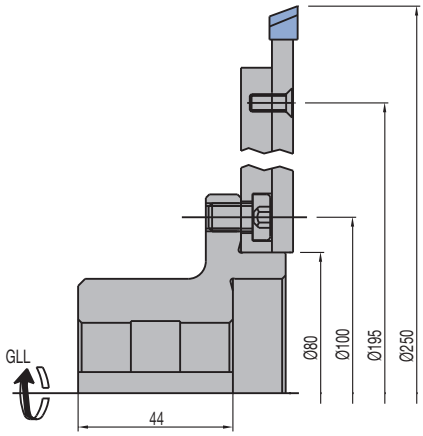
D mm	SB mm	BO mm	Z	ZF	QAL	ID LH	ID RH
250	6.35	40 DKN	80	ES	HW	**062618** □	**062619** □
250	8	40 DKN	60	ES	HW	**062620** □	**062621** □
350	8	40 DKN	72	ES	HW	**062622** □	**062623** □

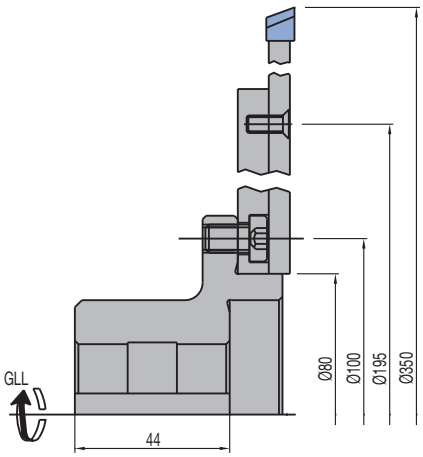
Spare sawblades:

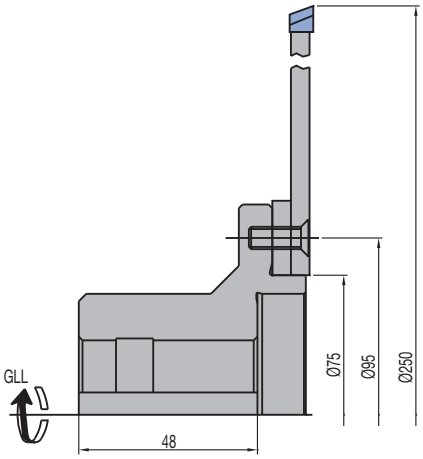
D mm	SB mm	BO mm	Z	ZF	QAL	ID LH	ID RH
250	6.35	75	80	ES	HW	**062624** ●	**062625** ●
250	8	80	60	ES	HW	**062626** ●	**062627** ●
350	8	80	72	ES	HW	**062628** ●	**062629** ●

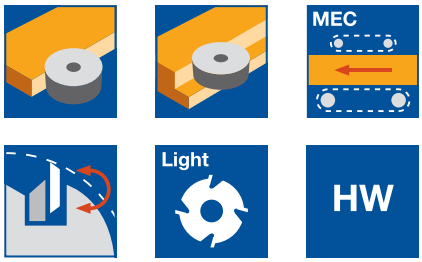
Spare parts:

BEZ	ABM mm	L mm	BO mm	ID
Flanged sleeve	113/80x59x40 DKN	59	40 DKN	**061679** ●
Flanged sleeve	113/75x61x40 DKN	61	40 DKN	**061680** ●
Flanged disc	D215/BO80/TK195		80	**028675** ●
Flanged disc	D115/BO75/TK95		75	**028676** ●
Countersink screw, Torx® 20	M6x16			**006086** ●
Countersink screw, Torx® 20	M5x12			**006247** ●
Cylindrical screw with ISK	M8x12			**005943** ●









Rebating cutterhead for joinery machines - HeliCut 15

Application:
For cutting grooves, rebate grooves, V-grooves as well as for jointing longitudinal and crosscut wood with large hogging depths in the wood construction.

Machine:
CNC-controlled joinery machines, as well as special machines for general wood construction with machine-specific adaptors.

Workpiece material:
Solid wood, preferably softwood for wood construction, hardwood (oak, ash etc.).

Technical information:
Carrier body constructed from high strength lightweight aluminium alloy. With 4-times turnable, spiral-shaped assembled HW turnblades. Application of the same knives as peripheral knives and spurs. The cutting bevels of the HW knives are numbered. No clamping wedges, direct tangential knife clamping. Easy handling of knife change without further mounting aid.

Aluminium tool body
WW 430 2 05

D mm	SB mm	BO mm	Z	V	ID
250	60	30	4x6	2 x 4+4	**132538**
250	80	30	4x8	2 x 4+4	**132539**
250	100	30	4x10	2 x 4+4	**132540**
300	20	30	4x2	2 x 4+4	**132541**
300	40	30	4x4	2 x 4+4	**132542**
300	60	30	4x6	2 x 4+4	**132543**
300	80	30	4x8	2 x 4+4	**132544**
300	100	30	4x10	2 x 4+4	**132545**
350	20	30	4x2	2 x 4+4	**132546**
350	40	30	4x4	2 x 4+4	**132547**
350	60	30	4x6	2 x 4+4	**132548**
350	80	30	4x8	2 x 4+4	**132549**
350	100	30	4x10	2 x 4+4	**132550**
400	20	30	4x2	2 x 4+4	**132551**
400	40	30	4x4	2 x 4+4	**132552**
400	60	30	4x6	2 x 4+4	**132553**
400	80	30	4x8	2 x 4+4	**132554**
400	100	30	4x10	2 x 4+4	**132555**

More dimensions on request.

Spare knives:

BEZ	ABM mm	QAL	BEM	VE PCS	ID
Turnblade knife	15x15x2.5	HW	HeliCut 15	10	**009549** ●
Turnblade knife	15x15x2.5	HW-MF	HeliCut 15	10	**009543** ●
Turnblade knife	15x15x2.5	TDC	HeliCut 15		**602900** ●

Spare parts:

BEZ	ABM mm	ID
Countersink screw, Torx® 20	M5x18	**114030** ●
Torx® key	Torx® 20	**006091** ●

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

Key to pictograms


Scoring, top and bottom


Hogging


Grooving, horizontal and vertical


Jointing


Rebating

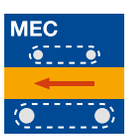

Profiling


Profiling joints


Profiling tongue and groove


Planing


Planing, profiling



Mechanical feed

Manual feed


Solid metal tool


Tipped tool

Light alloy body


Interchangeable knives


Mechanical knife clamping, reversible


Centrifugal knife clamping, reversible


Mechanical knife clamping, adjustable - serrated


Mechanical knife clamping adjustable - plane echan.

Mechanical knife clamping, re-sharpenable and constant diameter


Hydro clamping


Resharpenable cutting face


Resharpenable clearance face

Low noise

High-alloyed tool steel

High-speed steel

Tungsten carbide

Carbide metal coating

www.leitz.org