Wood construction

Tool programme for the
professional processing of solid wood

Content

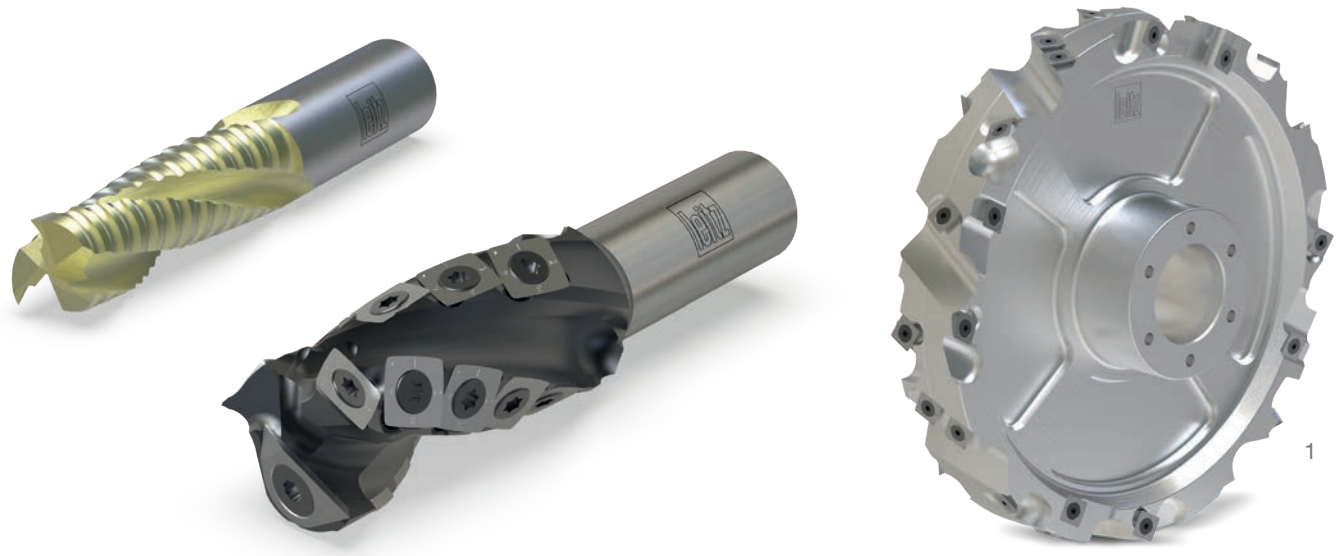
Introduction

New challenges & technologies for the oldest construction material in the world – future-oriented, design-led and high-quality

From today's point of view, wood as a renewable raw material, CO_2 storage and material with excellent insulating properties is probably the most sustainable raw material currently available worldwide. In modern architecture and craftsmanship, wood is experiencing a true renaissance from an aesthetic point of view, for environmental awareness, material properties and workability. The mechanical processing of wood is subject to a multitude of different demands, and this becomes particularly clear in the area of structural wood construction.
Leitz, with vast experience in solid wood applications and extensive knowledge of the challenges in manual and industrial production, make its innovative tool range the preferred solution for wood construction companies.

For Leitz, the success of its customers and a long-term partnership is the main focus. As a leading supplier of technically high-quality tool solutions, it is our goal to increase efficiency, productivity, quality and sustainability for our customers.

This is made possible by our more than 140 years of experience in tool manufacturing and our particularly deep knowledge of our customers needs and that of the market. All of this and a worldwide Leitz service network with more than 120 of our own service stations as well as our certified quality promise, make Leitz the partner for your success.



Glulam, CLT ...

Core products for wooden house construction

Meeting challenges with innovative solutions

The demand for wood-based construction elements in the building industry continues to grow unabated. Increasing demand and the resulting growth in consumption of materials such as glulam (BSH) or cross-laminated timber (BSP) are forcing the timber construction industry to optimize its manufacturing processes in terms of cost and time. In addition, quality-forming aspects such as appearance, surface finish and gluing ability are increasingly coming into focus.

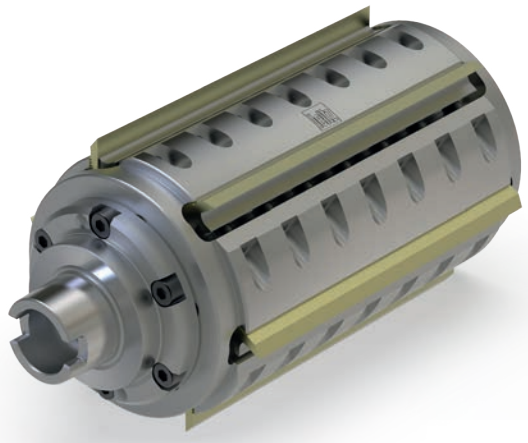
These goals can only be achieved with resilient and robust tool systems that allow high feed rates, are easy to handle, deliver perfect results and are convincing in terms of ease of maintenance.

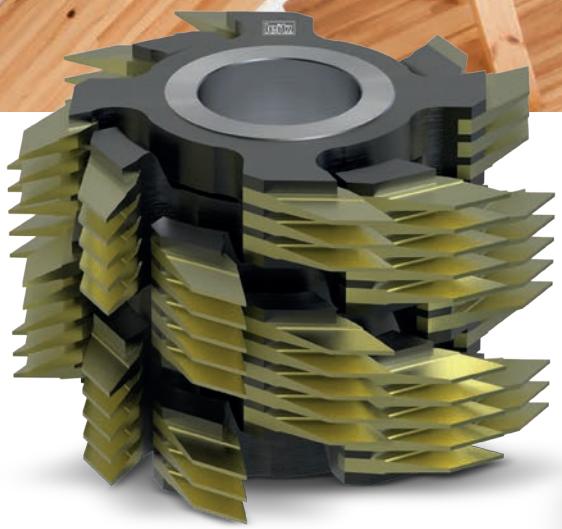
Planerheads

Dimensional accuracy, shape accuracy and surface quality

The first operation after cutting the raw wood is planing. It is primarily the most important step in woodworking. Here, the shape and material thickness are determined, and surfaces and reference surfaces are created. When planing, the selection of the right tool and the appropriate machining strategy are decisive for the results in all subsequent machining processes.

Further information can be found from page 28 ►





Minifinger jointing tools

High-strength joints with excellent appearance

The dimensionally stable jointing of several short wooden parts to form a large component creates wooden construction elements that would not occur in nature in the required shape, size or load-bearing capacity. Particularly important is the quality and stability of the corresponding type of joint. The production of high-quality flat or upright minifingers requires tools that are optimally matched to the material, adhesive and final use.

Further information can be found from page 45 ►

Optimization cross-cut sawblades

Excellent cross-cuts with short cycle times

Perfect fitting accuracy in the shortest possible time – with precisely placed saw cuts. The prerequisite for perfect results here is the performance and stability of the circular sawblades under high loads.

Further information can be found from page 18 ►

Joinery

Wood cutting on machine controlled equipment

Precise tool solutions for every requirement

The more precise the fit in the joinery, the more time can be saved during final assembly and the better the appearance of visible components. Nowadays, CNC-controlled production machines are mainly used for this work.

The precision and quality of the joinery must also be reflected in the tools used. Leitz offers tooling solutions, especially for joineries, that more than meet these requirements.

Circular sawblades

Leitz circular sawblades offer above all dimensional stability in machining as well as tear-free and absolutely precise results.

◄ **Further information can be found from page 14**

Boring bits

Boring tools from Leitz are convincing in terms of shape and position accuracy and allow maximum speeds during boring, without intermediate discharge.

Further information can be found from page 74 ►

Roughing-finishing routers

When it comes to large chip removal combined with low feed forces, Leitz routers with Marathon coating are the perfect choice for sizing, grooving or routing.

◄ **Further information can be found from page 64**

HeliCut 11 Roughing router

Perfect machining results, large cutting volumes and easy handling – these are the main features of the HeliCut 11 system from Leitz.

Further information can be found from page 61 ►

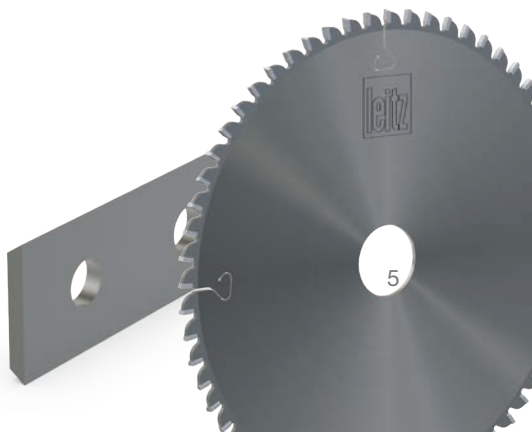
HeliCut 15 Cutterhead

Whether on CNC joinery systems or on other machines for solid wood processing – the HeliCut 15 rebate cutterhead from Leitz offers perfect results with maximum performance.

◄ Further information can be found from page 56

Tools for manual machines

Leitz offers a comprehensive range of turnblades, circular sawblades or boring bits for manual joineries or for finishing work on the construction site – for precision and perfection in manual operation.



Profiling

Shaping, appearance and surface

Rough sheet piling, tongue & groove, ceiling elements, profile strips, decking boards ...

Profiling is the final processing step that applies to solid wood processing – from raw wood to the final product. This is where the final shape is given to the workpiece. At the same time, this partial process also determines the quality of the final product and thus also the impression that the consumer perceives.

This and the requirements of modern production concepts need, above all, powerful and adaptable tooling systems that are reliable and flexible.

ProfilCut Q

The ProfilCut Q system stands for highest performance and cutting quality and is the customized solution for almost every requirement, every material and every machine.

VariPlan / ProFix

Continuity of diameter, high runout quality, no adjustment effort on the machine, as well as quick and easy knife change with absolutely flexible profile design convince users day after day.

Further information can be found from page 37 ►

HeliCut

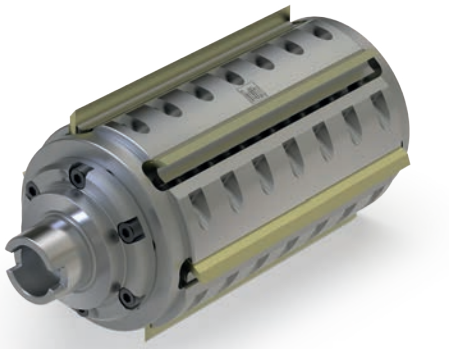
The absolute all-round specialist for tear-free machining results with simple and fast cutting edge change as well as long lifetime.

◄ Further information can be found from page 56

Profile cutter

The Leitz tipped profile cutters are particularly robust and stand for the highest machining quality, long lifetime, low-maintenance operation and significant reduction in set-up times.

Further information can be found from page 39 ►



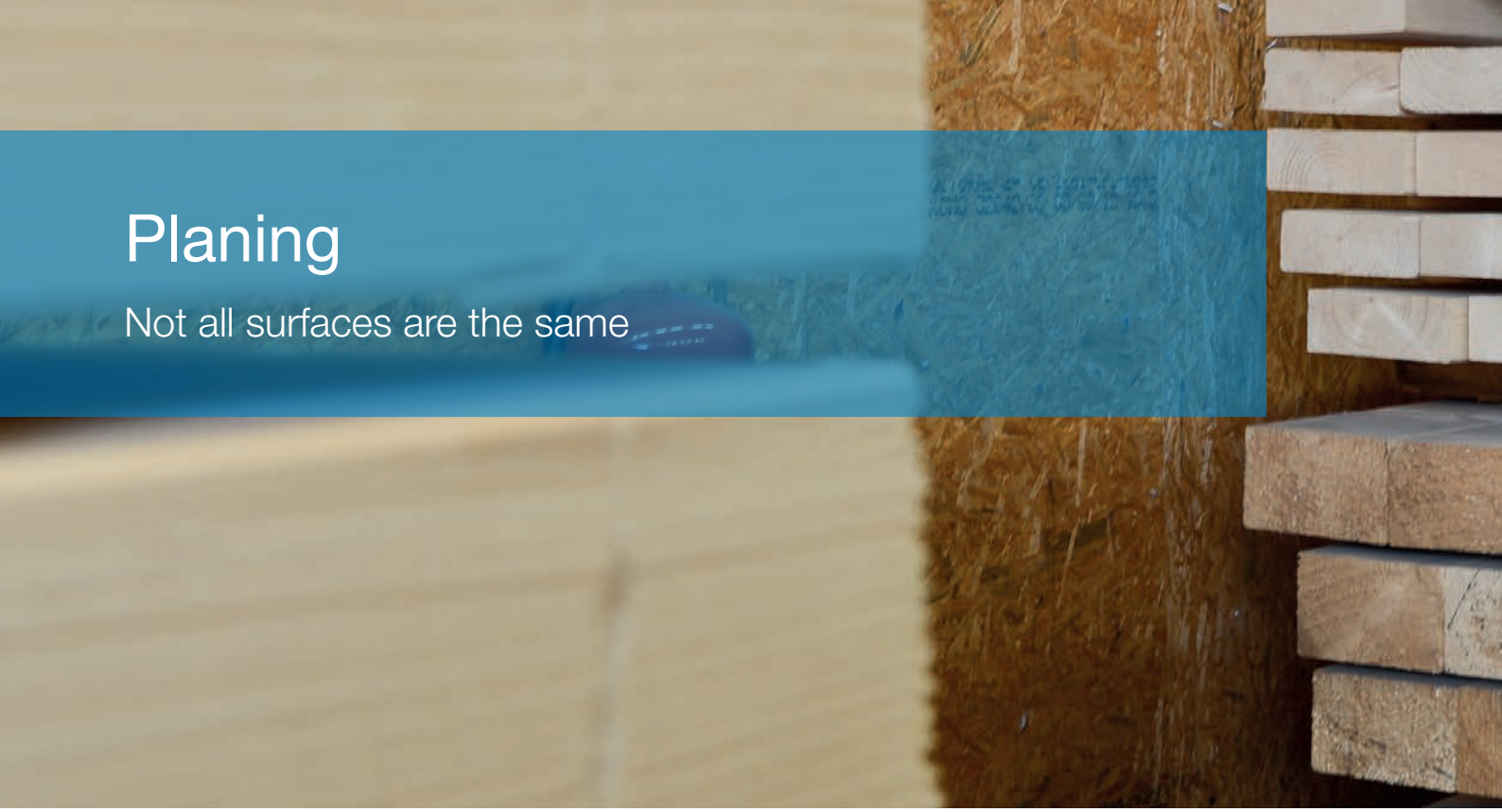
Profile cutterheads

Leitz offers a wide range of tools for processing any profile using standard support bodies and individually profiled blanks. By mounting straight knives, the tool can also be used for planing.

◄ Further information can be found from page 39

Turnblade tools

For more efficiency and flexibility in jointing, rebating, rounding and grooving, Leitz offers an extensive range of standardized turnblade tools for particularly easy on-site service.



Planing

Not all surfaces are the same

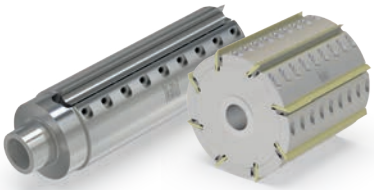
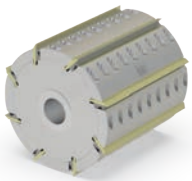
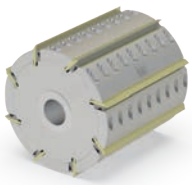
What matters!

Before choosing a specific tooling system, various parameters must be considered in advance of planning. Only by answering these seven key questions it will be possible to determine the appropriate tooling solution.

Together with application experts on site, Leitz defines the technically suitable solution for each application. We always aim to achieve the optimum added value for the overall process and thus for the customer's economic success.

What type of machine is used?	The machine type determines the dimensions of the tool and how it is mounted within the production unit.
What must be the quality of the surface?	The surface quality to be achieved determines the type of tool. Important: the best technical solution is not always the most economical.
Which application data are required?	Speed or feed rate decisively determine the technical design of the tool and the number of cutting edges.
Which workpiece material is being machined?	The material to be machined and its condition determine the cutting material and the appropriate application data.
What does capacity planning look like?	The throughput of material, whether series production or single application, the goal is an efficient and cost-oriented solution.
How much material is removed?	The difference in thickness between the raw material and the finished product determines the process and thus also the choice of the ideal tooling system.
Who will do the sharpening?	The choice of tool is also determined by whether reprocessing is to take place internally or externally. Always with a view to the production costs.

... Leitz planing systems at a glance.

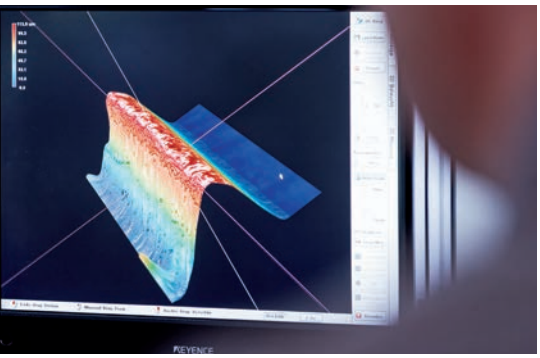
	Craft **Window construction** **Furniture construction** **Mould production**	**Furniture production** **Mould production** **Planing mills** **Floor production**	**Planing mills** **Production of construction components (BSH, BSP, N+F, KVH)** **Floor production**
Finish planing	 **VariPlan Plus** **CentroStar**	 **Planerhead with back-serrated knives**	 **TurboPlan**
Pre- / finish planing	 **Planerhead with clamping wedge system**	 **Hydro planerhead**	 **Hydro planerhead with back-serrated knives**
Pre-planing	 **HeliPlan**	 **HeliPlan-Hydro**	 **Hydro planerhead with back-serrated knives**
	v_f = 5-18 m/min	v_f = 18-80 m/min	v_f = 80-500 m/min

Special materials

... require special tool solutions

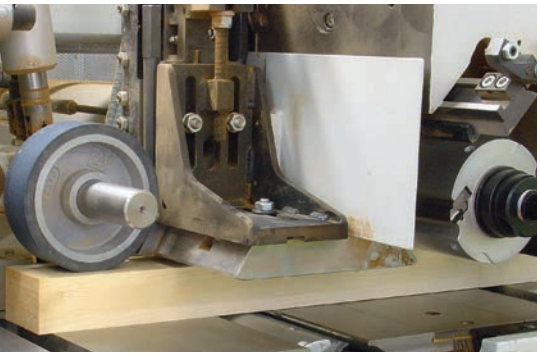
Consulting and process optimization for special requirements

Laminated veneer wood, fiber cement, Alucobond, compact laminates, gypsum fiberboard or wood fiberboard – the variety of new types of materials is great and so are the challenges that go hand in hand with them in machining.



Knowledge and experience around cutting materials or coatings

Every material has its own special features, which are reflected in the machining process. To ensure that this can also be designed optimally from an economic point of view, it is important to use the ideal cutting material for the respective application. Leitz has decades of knowledge in the development of cutting materials – whether in the form of various coatings or specially developed carbide mixtures.



Process analysis and process definition for the most economical solution

The basis for the development of feasible strategies and tool solutions is always a thorough examination of the conditions on site. Leitz engineers and technicians deal with the daily challenges that arise in ongoing production. The aim is always to find the most economical and reasonable solution in the interest of the customer and thus to support his business success.

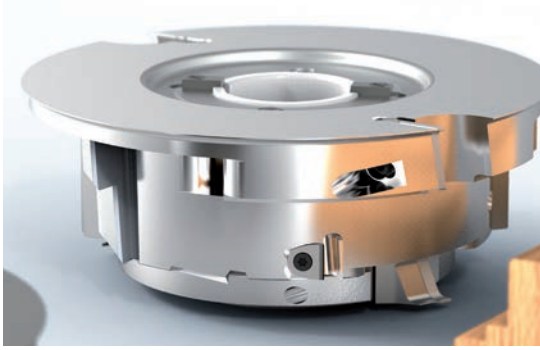
Leitz supports its customers from a wide range of sectors and industries with individual solutions when it comes to machining new materials, increasing tool life, reducing set-up times, minimizing cutting forces, conserving resources or simply making machining more efficient.

Machining strategies around the optimal process

Leitz offers an extensive programme of training courses for its customers. Practice-oriented training courses and workshops impart valuable user knowledge and are always oriented to the current state of the art. From tool optimization, process sequences, machining methods, milling strategies, and production optimization to the optimum use of extraction systems – the range of topics is optimally customized to individual needs.

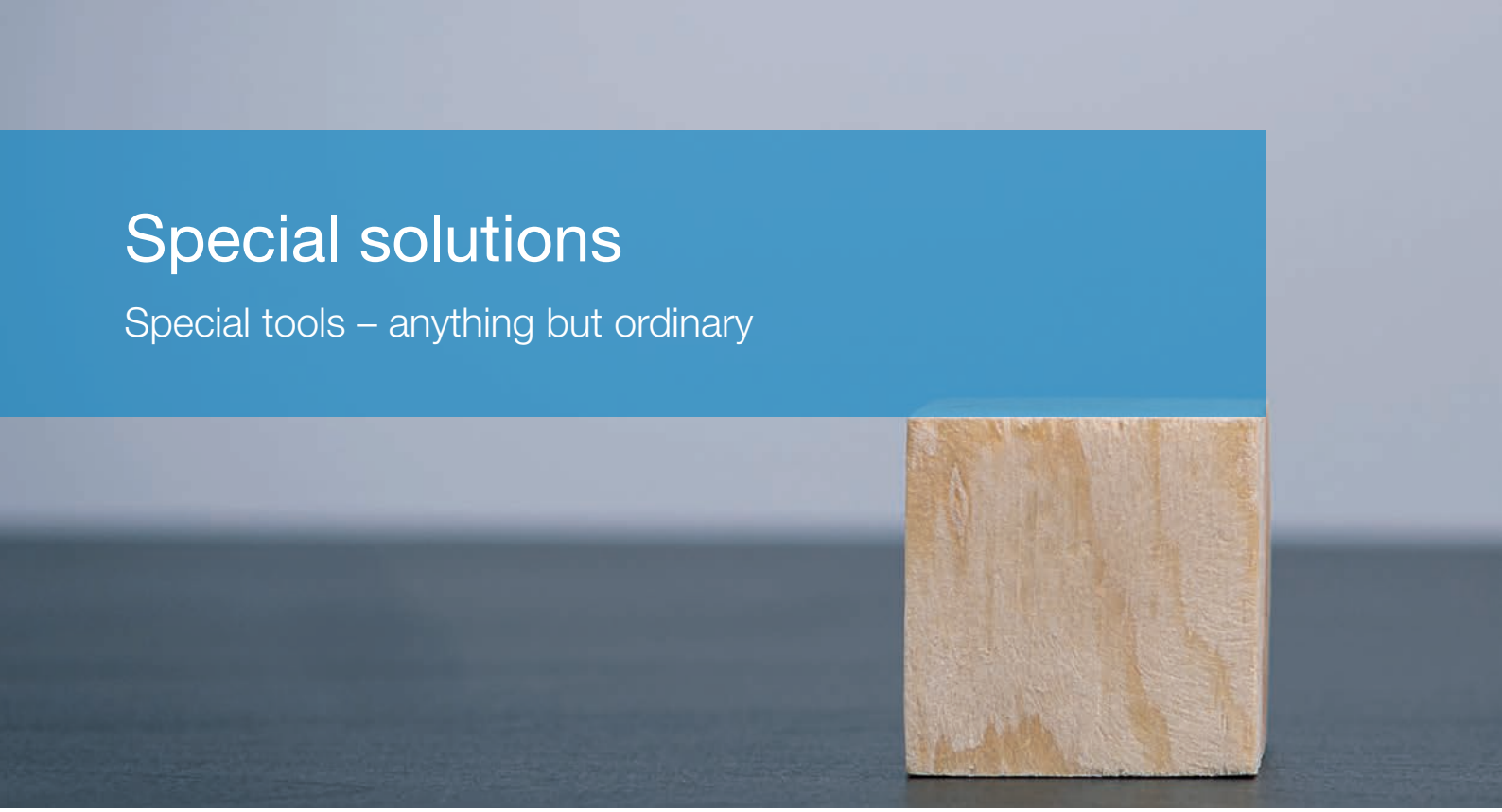
Tool combinations or hybrid solutions

Especially when machining combined materials, each tool used must be optimally adapted to the respective machining operation. Leitz offers tool combinations or hybrid solutions that are always aimed at achieving the optimum machining result – and always under the guideline of not losing sight of the efficiency and thus the cost-effectiveness of the overall process.



Special solutions

Special tools – anything but ordinary



Three steps for the optimal process ...

Special requirements for the end product always require special solutions within the manufacturing process. Here it is important to know the numerous influencing components within a production and to understand their interdependencies in order to achieve the optimum result in the end.

Leitz, with its extensive process knowledge and wide range of products, offers the possibility to fall back on universal tooling systems and to adapt them individually to the customer's requirements.

1

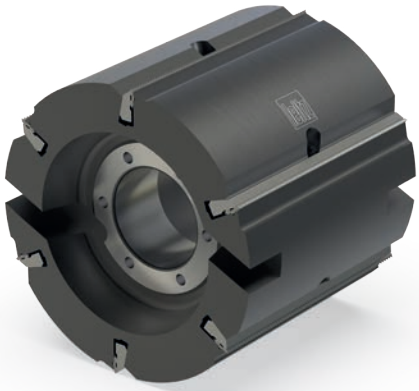
Workpiece

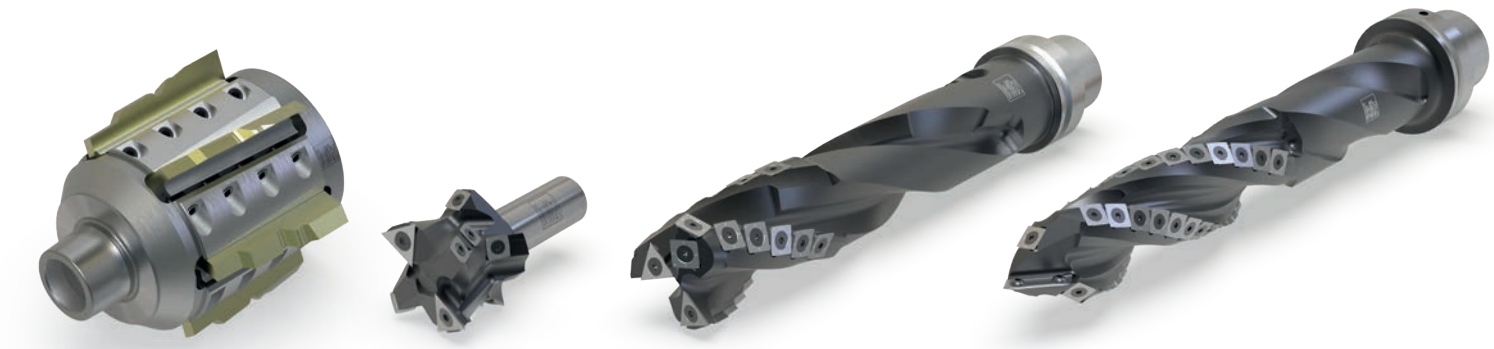
Relevant information:
Machining task, cutting direction, profile type, material type, material properties

2

Machine

Relevant information:
Machine type, application para
spindle sequence, engine power,





meter, manufacturer, type, year of construction,
direction of rotation

3

Tool system

Relevant information:
Dimensions, service options, cutting material,
type of adaptor

Sawing

Leitz tool programme for wood construction

Content chapter Sawing

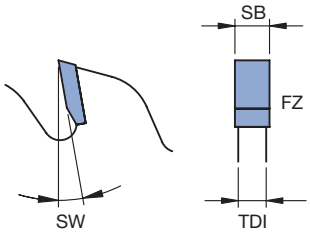
Lamella cut

Application:
For cutting along grain - shoulder and trimming cuts.

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

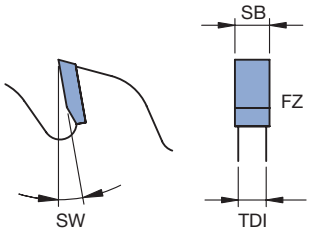
Workpiece material:
Softwood and hardwood wet and dry.

Technical information:
Large gullet area and large lateral tooth protrusion. Solid desing particularly for edge cuts. For universal use in dry and wet soft and hard woods. Design without raker blades. Partially suitable for larger cutting depths and the use in frozen woods.



Shoulder and square cut
WK 100 2

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
250	4,0	2.6	30	KNL	18	FZ	20	■	**165101** ●
300	4,0	2.6	30	KNL	24	FZ	20	■	**165102** ●
350	4.4	3,0	30	KNL	24	FZ	20	■	**165104** ●
400	5,0	3.2	30	KNL	28	FZ	20	■	**165105** ●
450	5,0	3.2	30	KNL	28	FZ	20	■	**165106** ●
500	5,0	3.2	30	KNL	32	FZ	20	■	**165107** ●



Middle cut
WK 100 2

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
200	3.2	2.2	30	KNL	18	FZ	25	■	**165108** ●
210	3.2	2.2	30	KNL	18	FZ	20	■	**165109** ●
250	3.2	2.2	30	KNL	18	FZ	20	■	**165110** ●
300	3.2	2.2	30	KNL	24	FZ	20	■	**165111** ●
350	3.2	2.2	30	KNL	24	FZ	20	■	**165113** ●
400	4,0	2.8	30	KNL	28	FZ	20	■	**165114** ●
450	4,0	2.8	30	KNL	28	FZ	20	■	**165115** ●
500	4,0	2.8	30	KNL	32	FZ	20	■	**165116** ●

● available ex stock
□ available at short notice
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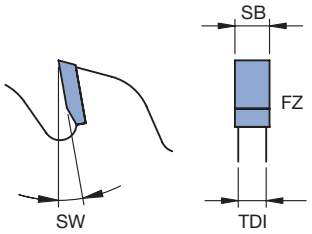


Sizing solid wood along grain

Application:
For cutting along grain - sizing wood.

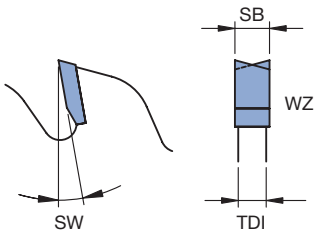
Machine:
Edging, single blade, multi blade saws as well as saws with one or two spindles.

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

Technical information:
Design with chip thickness limitation for limited chip removal per tooth and reduced feed speeds.

Circular sawblade FZ with thickness limitation
WK 100 2

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
250	3.2	2.2	30	KNL	18	FZ	20	■	**166050** ●
300	3.5	2.4	30	KNL	14	FZ	20	■	**166051** ●
350	3.5	2.4	30	KNL	16	FZ	20	■	**166052** ●
400	4,0	2.8	30	KNL	18	FZ	20	■	**166053** ●
450	4,0	2.8	30	KNL	20	FZ	20	■	**166054** ●
500	4,0	2.8	30	KNL	24	FZ	20	■	**166055** ●



Universal sizing

Application:
For multi-purpose application in solid wood.

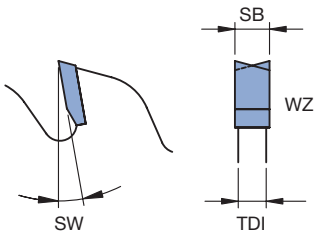
Machine:
Trimming and cross cutting saws.

Workpiece material:
Softwood and hardwood wet and dry.

Technical information:
Design with chip thickness limitation for limited chip removal per tooth and reduced feed speeds. Tooth shape WZ for cuts in long-fibred woods such as poplar and for cuts in wet woods. Lower power consumption due to tooth shape WZ. Also suitable for cuts across the grain.

Circular sawblade WZ with thickness limitation
WK 150 2

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
250	3.2	2.2	30	KNL	24	WZ	20	■	**166076** ●
300	3.2	2.2	30	KNL	28	WZ	20	■	**166077** ●
350	3.2	2.2	30	KNL	32	WZ	20	■	**166078** ●
400	4,0	2.8	30	KNL	36	WZ	20	■	**166079** ●
450	4,0	2.8	30	KNL	42	WZ	20	■	**166080** ●
500	4,0	2.8	30	KNL	48	WZ	20	■	**166081** ●
550	4.8	3.5	30	KNL	54	WZ	20	■	**166082** ●
600	4.8	3.5	30	KNL	60	WZ	20	■	**166083** ●
700	4.8	3.5	30	KNL	60	WZ	20	■	**166084** ●



Trimming at high feed rates

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

Machine:
Cross, trimming and optimising saws.

Workpiece material:
Solid wood wet and dry across grain, solid wood profiles across grain.

Technical information:
For fast cross-cutting, sizing and optimizing machines. Large lateral tooth clearance and a high number of teeth. Stable corner angle of 20° for tear-free cutting results and long tool life.

Trimming at high feed rates
WK 150 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
Dimter, System TM	400	3.5	2.8	30	2/10/60 2/15/63 2/10/150 2/10/198	120	WZ	10	■	**165450** ●
Dimter, System TM	400	3.5	2.8	30	2/10/60 2/15/63 2/10/150 2/10/198	140	WZ	10	■	**165464** ●
Dimter, System TM	450	3.5	2.8	30	2/10/60 2/15/63 2/10/150 2/10/198	158	WZ	10	■	**165465** ●
Dimter	450	4.8	3.5	30	2/10/60 2/15/63	138	WZ	10	■	**165451** ●
Dimter	450	5,0	3.2	30	2/10/60 2/15/63	108	WZ	10	■	**165452** ●
Dimter, System TM	500	4.8	3.5	30	2/10/60 2/15/63 2/10/150 2/10/198	144	WZ	10	■	**165454** ●
Dimter	500	4.8	3.5	35	2/10/60 2/15/63	144	WZ	10	■	**165455** □
Dimter	500	5.2	3.2	30	2/10/60 2/15/63	120	WZ	10	■	**165453** ●
Dimter	520	4.6	3.4	30	2/10/60 2/15/63	144	WZ	10	■	**165456** ●
Dimter	550	5,0	3.2	30	2/10/60 2/15/63	96	WZ	10	■	**165457** ●
Dimter	550	5.2	3.2	30	2/10/60 2/15/63	120	WZ	10	■	**165459** ●
Dimter, System TM	550	5.2	3.2	30	2/10/60 2/15/63 2/10/150 2/10/198	160	WZ	10	■	**165458** ●
Dimter	600	5.4	4,0	30	2/10/60 2/15/63	172	WZ	10	■	**165461** ●
Dimter	600	5.8	4,0	30	2/10/60 2/15/63	108	WZ	10	■	**165460** ●
Dimter	630	5.4	4,0	30	2/10/60 2/15/63	180	WZ	10	■	**165462** ●
Dimter	700	5.5	4,0	30	2/15/63	200	WZ	10	■	**165463** ●

● available ex stock
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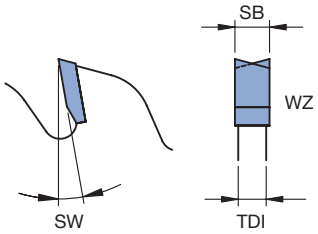
HW



Trimming, crossing and mitre cuts

Application:
For cross cutting, trimming and angled cuts.

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

Workpiece material:
Solid wood beams wet and dry, cross-glued beams.

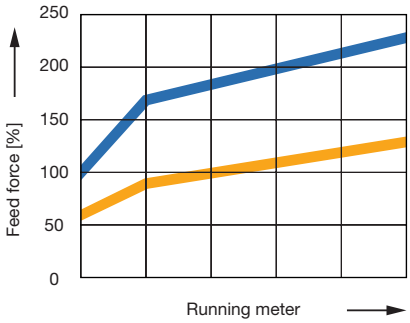
Technical information:
Tooth shape for universal use and with large lateral tooth clearance.

Circular sawblade WZ
WK 150 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
Weinmann	240	3,0	2,0	30	8/6/52	30	WZ	15	■	**165337** ●
Weinmann	370	3.5	2.5	30	KNL	108	WZ	10	■	**165338** ●
Routech	440	7,0	4,0	75	6/9/100 2/8,5/100	12+2+2	WZ	20	■	**165326** ●
Routech	500	4.4	3.2	75	2/8,5/100 6/10,6/100	28+2+2+2	WZ	20	■	**165328** ●
Routech	500	7,0	4,0	75	6/9/100 2/8,5/100	14+2+2+2	WZ	20	■	**165327** ●
Essetre	520	5.4	3.5	60	8/6,5/100	72	WZ	20	■	**165332** ●
Weinmann	555	5.2	3,6/6	55	6/7/75	54+2+2	WZ	20	■	**165325** ●
Essetre	600	5.4	3.5	80	8/9,5/120	72	WZ	20	■	**165333** ●
	600	6,0	4,0	30	2/14/400	48	WZ	15	■	**057570** ●
Routech	600	7,0	4,0	75	6/9/125 2/8,5/125	16+2+2+2	WZ	20	■	**165329** ●
Uniteam	640	5.4	3.6	30	8/6,5/160 8/6,5/130 4/10,5/90	36+2+2	WZ	20	■	**165330** ●
	700	6,0	4.4	30		72	WZ	15	■	**165334** ●
	750	6,0	4.4	30		72	WZ	15	■	**165335** ●
	800	6,0	4.4	30		72	WZ	15	■	**165336** ●
Uniteam	850	8,0	6,0	30	8/6,5/160 8/6,5/130 4/10,5/90	60+2+2+2	WZ	20	■	**165331** ●

HW

Comparison of feed force (MDF 38 mm)



Conventional circular sawblade, Z 48, SB 2.2 mm, WZ

Leitz AccuCut circular sawblade, Z 42, SB 1.8 mm, WZ/WZ/WZ/FZ

Universal sizing - AccuCut

Application:
For cross-cut and sizing.

Machine:
Accu-portable sawblades.

Workpiece material:
Solid wood lengthwise and crosswise as well as glued, chipboard and fibre materials raw, plastic- and paper-coated, veneered, laminated wood (e.g. plywood, multiplex).

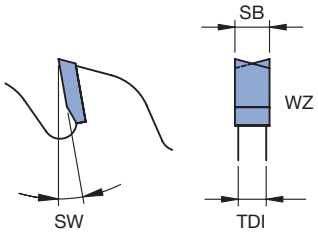
Technical information:
Long battery life due to thin kerf, cutting force-reduced cutting geometry and innovative tooth pitch. Very good cutting quality due to high number of teeth.

Circular sawblade AccuCut
WK 879 2

D mm	SB mm	TDI mm	BO mm	Z	ZF	SW °	WSS	ID
140	1.8	1.2	20	35	WZ/WZ/WZ/FZ	10		**166623** ●
160	1.8	1.2	20	42	WZ/WZ/WZ/FZ	10		**166620** ●
165	1.8	1.2	20	42	WZ/WZ/WZ/FZ	10		**166621** ●
190	1.8	1.2	30	42	WZ/WZ/WZ/FZ	10		**166622** ●

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

HW



Universal sizing

Application:
For cutting along and across grain and sizing.

Machine:
Portable and table saws.

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

Technical information:
Tooth shape for universal use.

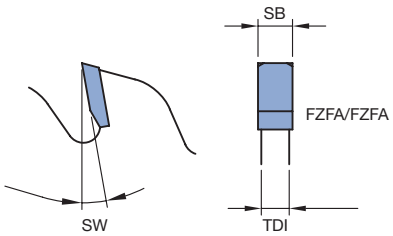
Circular sawblade WZ pos. cutting angle
WK 150 2

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
100	2.4	1.6	12		30	WZ	10		**166109** ●
100	2.4	1.6	22		30	WZ	10		**166110** ●
120	2.4	1.6	20		24	WZ	15		**166111** ●
125	2.4	1.6	20		24	WZ	15		**166112** ●
125	2.4	1.6	20		36	WZ	10		**166113** ●
140	2.4	1.6	20		24	WZ	15		**166114** ●
150	2.8	1.8	20		48	WZ	10		**166115** ●
160	1.6	1.1	20		24	WZ	25		**166100** ●
160	1.8	1.2	20		18	WZ	25		**166101** ●
160	1.8	1.2	20		32	WZ	5		**166102** ●
160	2.5	1.6	20		12	WZ	20		**166116** ●
160	2.5	1.6	20		24	WZ	15		**166117** ●
160	2.5	1.6	20		48	WZ	15		**166118** ●
165	2.2	1.6	20		24	WZ	15		**166119** ●
165	2.2	1.6	20		48	WZ	10		**166104** ●
165	2.4	1.6	20		12	WZ	15		**166103** ●
170	2.5	1.6	30		48	WZ	10		**166120** ●
180	2.5	1.6	20		24	WZ	15		**166121** ●
180	2.5	1.6	20		48	WZ	10		**166122** ●
180	2.5	1.6	30		24	WZ	15		**166123** ●
180	2.5	1.6	30		48	WZ	10		**166105** ●
184	2.5	1.6	20		24	WZ	15		**166124** ●
190	2.5	1.8	30		24	WZ	20		**166128** ●
190	2.8	1.8	16		24	WZ	15		**166125** ●
190	2.8	1.8	16		48	WZ	10		**166126** ●
190	2.8	1.8	30		16	WZ	20		**166127** ●
190	2.8	1.8	30		48	WZ	10		**166129** ●
200	3,0	2,0	30		34	WZ	10		**166130** ●
200	3,0	2,0	30		48	WZ	10		**166131** ●
210	2.4	1.6	30		24	WZ	15		**166133** ●
210	2.4	1.6	30		42	WZ	20		**166134** ●
210	2.4	1.6	30		64	WZ	10		**166135** ●
220	3.2	2.2	30		34	WZ	15		**166136** ●
220	3.2	2.2	30		60	WZ	10		**166107** ●
225	2.6	1.8	30		32	WZ	20		**166137** ●
225	2.6	1.8	30		48	WZ	10		**166138** ●
230	2.5	1.8	30		24	WZ	20		**166140** ●
230	2.5	1.8	30		48	WZ	15		**166108** ●
230	3.2	2.2	30		34	WZ	15		**166141** ●
235	2.5	1.8	30		12	WZ	15		**166158** ●
235	2.5	1.8	30		24	WZ	15		**166156** ●
235	2.5	1.8	30		56	WZ	15		**166157** ●
235	3.2	2.2	30		24	WZ	15		**166142** ●
235	3.2	2.2	30		34	WZ	15		**166143** ●
240	3,0	2,0	30		34	WZ	15		**166144** ●
240	3,0	1.8	30		48	WZ	10		**166145** ●
250	2.8	2,0	30	KNL	24	WZ	25		**166146** ●
250	2.8	2,0	30	KNL	60	WZ	20		**166147** ●

1.7 Portable saws and table-top machines
1.7.1 Circular sawblades WZ

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
260	3.2	2.2	30	KNL	60	WZ	10		**166148** ●
280	3.2	2.2	30	KNL	48	WZ	10		**166149** ●
280	3.2	2.2	30	KNL	60	WZ	10		**166150** ●
315	3,0	2,0	30	KNL	48	WZ	15		**166152** ●
315	3.2	2.2	30	KNL	28	WZ	20		**166151** ●
315	3.2	2.2	30	KNL	72	WZ	10		**166153** ●
355	3.2	2.2	30	KNL	16	WZ	20		**166154** ●
355	3.2	2.2	30	KNL	32	WZ	20		**166155** ●

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



Dry sawing of ferrous metals - DryCut

Application:
For splitting, trimming and sizing.

Machine:
Trimming and mitre saws, portable machines and table saws.

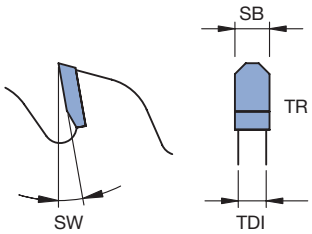
Workpiece material:
Flat and angle steel, pipes, steel plates and profiles, sandwich panels.

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

Circular sawblade DryCut
WK 977 3

D mm	SB mm	TDI mm	BO mm	Z	ZF	SW °	WSS	ID
160	2,0	1.6	20	48	FZFA/FZFA	0	■	**163529** ●
165	2,0	1.6	20	48	FZFA/FZFA	0	■	**163530** ●
190	2,0	1.6	30	54	FZFA/FZFA	0	■	**163531** ●
210	2,0	1.6	30	60	FZFA/FZFA	0	■	**163532** ●
225	2.2	1.8	30	64	FZFA/FZFA	0	■	**163533** ●
254	2.2	1.8	30	72	FZFA/FZFA	0	■	**163534** ●
300	2.2	1.8	30	80	FZFA/FZFA	0	■	**163535** ●
305	2.4	2,0	25.4	80	FZFA/FZFA	0	■	**163536** ●
330	2.4	2,0	30	80	FZFA/FZFA	0	■	**163537** ●
355	2.4	2,0	25.4	80	FZFA/FZFA	0	■	**163538** ●
400	3,0	2.4	30	84	FZFA/FZFA	0	■	**163539** ●

HW



Universal sizing

Application:
For universal use on building sites.

Machine:
Universal cutting saws.

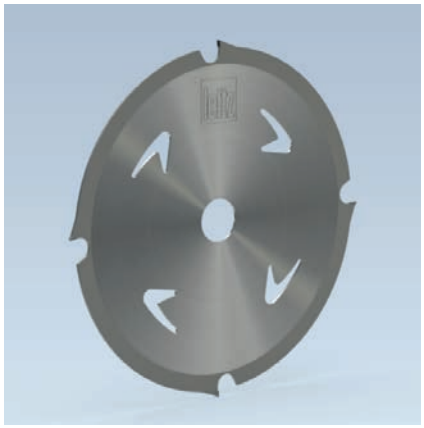
Workpiece material:
Panels and timbers with small concrete and metal inclusions, wood wool (e.g. Heraklith), gypsum plasterboard and form work panel of veneer, gas aerated slabs, Styrodur slabs, roundwood and squared timbers.

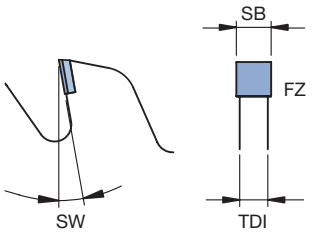
Technical information:
Tool body with round closed form and stable tooth shape. Special tungsten carbide grade for all requirements on construction sites. Noise reducing design.

Circular sawblades TR for saw benches
WK 123 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
350	3.5	2.5	30	KNL	24	TR	10		**166025** ●
400	3.8	2.8	30	KNL	28	TR	10		**166026** ●
450	4,0	3,0	30	KNL	32	TR	10		**166027** ●
500	4,0	3,0	30	KNL	36	TR	10		**166028** ●

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





Cutting facade panels *Excellent*

Application:
For trimming and sizing.

Machine:
Accu-portable sawblades.

Workpiece material:
Gypsum and cement boards.

Technical information:
Thin kerf for low power requirement and long battery life. DP tipping for long tool life. Tool body with cooling holes for dust-free cutting surfaces.

Circular sawblade DP design
WK 100 3 DP

D	SB	TDI	BO	Z	ZF	SW	WSS	ID
mm	mm	mm	mm			°		
160	2.2	1.6	20	4	FZ	5	■	**190752** ●
165	2.2	1.6	20	4	FZ	5	■	**190753** ●
190	2.2	1.6	30	4	FZ	5	■	**190754** ●

Cutting facade panels *Excellent*

Application:
For trimming and sizing.

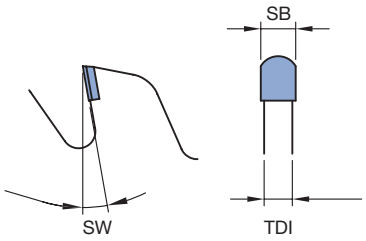
Machine:
Table and sizing saws, portable and radial cross saws.

Workpiece material:
Gypsum and cement boards.

Technical information:
Robust tooth shape and DP mounting for long tool life. Special tool body design for high stability.

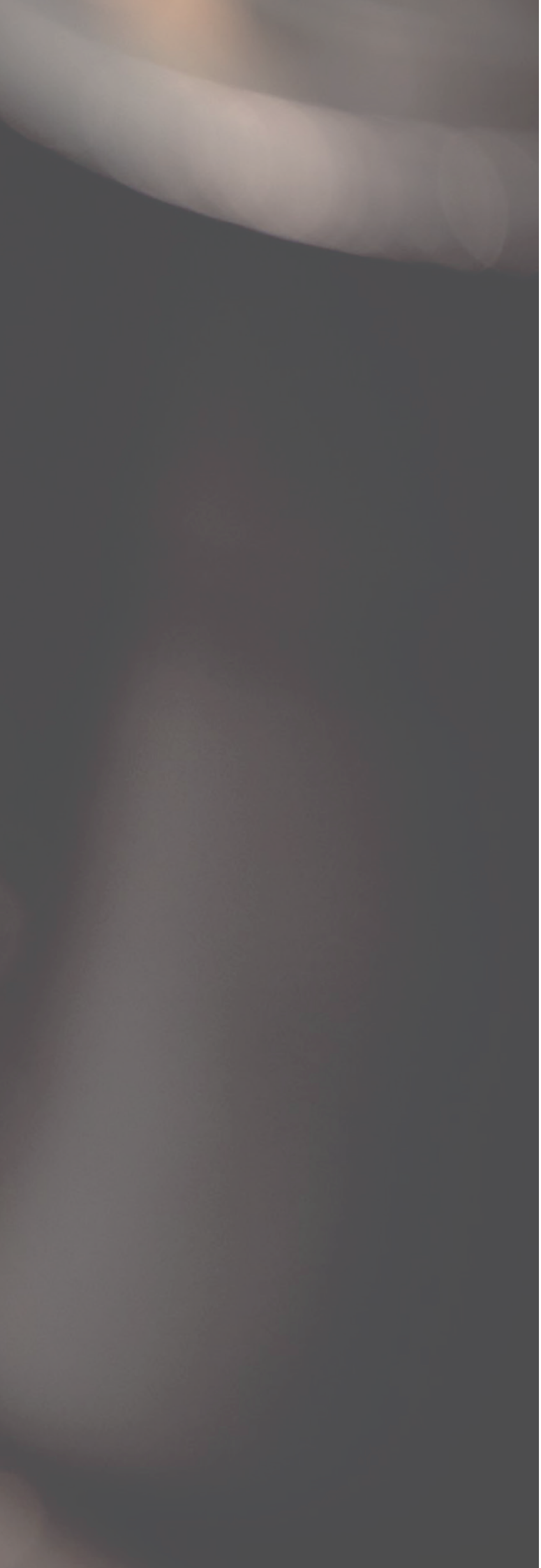
Circular sawblade DP design
WK 808 2 DP

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
160	3.2	2.4	20		4	P	5	■	**190302** ●
184	3.2	2.4	20		4	P	5	■	**190696** ●
190	3.2	2.4	20		4	P	5	■	**190303** ●
190	3.2	2.4	30		4	P	5	■	**190745** ●
225	3.2	2.4	30		6	P	5	■	**190304** ●
300	3.2	2.4	30	KNL	8	P	5	■	**190305** ●

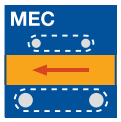


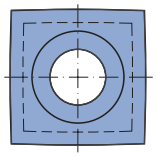
Planing and profiling

Leitz tool programme for wood construction

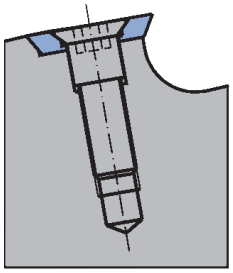


Content chapter
Planing and profiling





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	12,000	**030423** ●
125	166	172	40	2/2	28	12,000	**030467** ●
125	210	216	40	2/2	36	12,000	**030452**
125	236	242	40	2/2	40	12,000	**030466** ●
125	256	262	40	2/2	44	12,000	**030470** ●
140	166	172	50	2/2	28	12,000	**030468**
140	236	242	50	2/2	40	12,000	**030469**

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

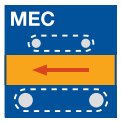
Spare knives:

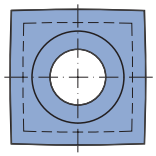
BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	15x15x2,5	HW	10	**009535** ●
Turnblade knife	15x15x2,5	TDC		**602901** ●

Spare parts:

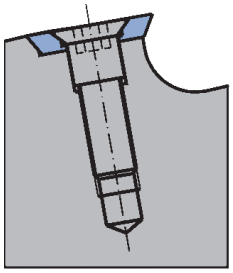
BEZ	ABM mm	ID
Countersink screw, Torx® 20	M5x14.2-8.8	**007394** ●
Torx® key	Torx® 20	**006091** ●

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





HW turnblade knife



Knives mounted on periphery

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	12,000	**132000** □	**132001** □
125	166	26	2/2	28	12,000	**132022** □	**132023** □
125	210	26	2/2	36	12,000	**132008**	**132009**
125	236	26	2/2	40	12,000	**132024** □	**132025** □
125	270	26	2/2	46	8,000	**132012**	**132013**
125	310	26	2/2	54	8,000	**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	12,000	bottom	**132066** □
125	310	26	2/2	2	54	8,000	bottom	**132065** □

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

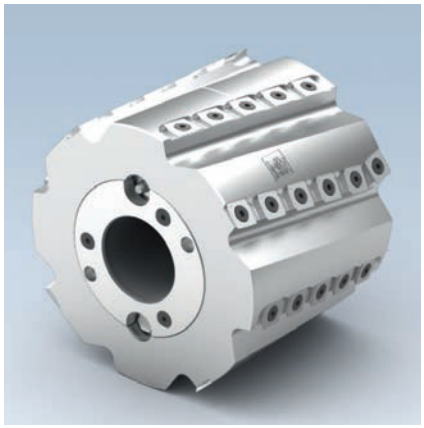
Spare knives:

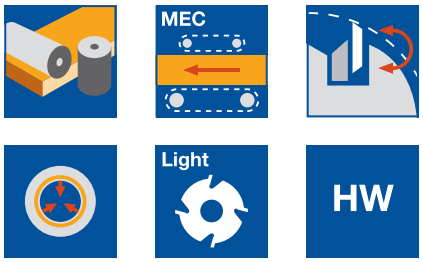
BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	15x15x2,5	HW	10	**009535** ●
Turnblade knife	15x15x2,5	TDC		**602901** ●

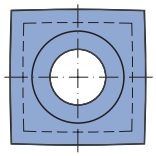
Spare parts:

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

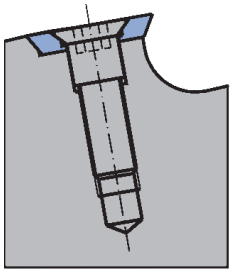
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



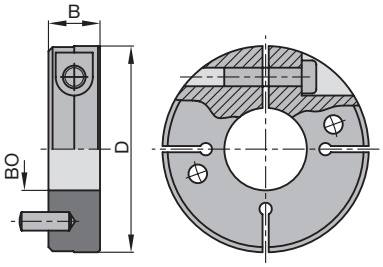




HW turnblade knife



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 profile 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	11,000	**132200**
160	180	50	4/4	11,000	**132201**
160	200	50	4/4	11,000	**132202**
160	230	50	4/4	11,000	**132203**
160	310	50	4/4	11,000	**132204**
200	150	50	6/6	8,000	**132205**
200	180	50	6/6	8,000	**132206**
200	200	50	6/6	8,000	**132207**
200	230	50	6/6	8,000	**132208**
200	310	50	6/6	8,000	**132209**
250	150	50	8/8	6,900	**132210**
250	180	50	8/8	6,900	**132211**
250	200	50	8/8	6,900	**132212**
250	230	50	8/8	6,900	**132213**
250	310	50	8/8	6,900	**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** ●

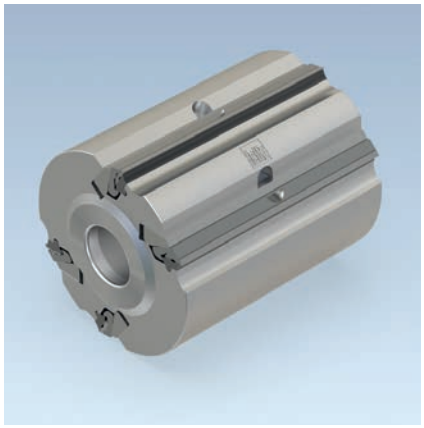
Spare parts:

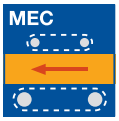
BEZ	ABM mm	ID
Countersink screw, Torx® 20	M5x14.2-8.8	**007394** ●
Torx® key	Torx® 20	**006091** ●

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





Planerhead VariPlan Plus Integral

Application:
Versatile application as planing tool:
For roughing and finishing on a processing spindle.

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

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

Technical information:
Tool with 2 VariPlan ripple knives and 2 straight VariPlan planer knives (constant diameter and resharpenable). Unequally pitched cutting arrangement for optimum chip formation. Light metal tool body. For chip removal > 1 mm.

Planerhead with bore
WW 240 2 09

D mm	SB mm	ND mm	BO mm	BO_{max} mm	QAL	n_{max} min^{-1}	Z	ID
125	130	136	40		HW	12,000	2+2	**131712** ●
125	166	172	40		HW	12,000	2+2	**131713** ●
125	236	242	40		HW	12,000	2+2	**131714** ●
140	130	136	40	50	HW	10,500	2+2	**131715**
140	166	172	40	50	HW	10,500	2+2	**131716**
140	236	242	40	50	HW	10,500	2+2	**131717**

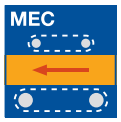
Planerhead with HSK 85 WS
WP 240 2 09

D mm	SB mm	QAL	n_{max} min^{-1}	Z	ID LH	ID RH
125	130	HW	12,000	2+2	**131806** □	**131807** □
125	166	HW	12,000	2+2	**131808** □	**131809** □
125	236	HW	12,000	2+2	**131810** □	**131811** □

Special production tools with deviating cutting widths are not possible!

Spare knives:

BEZ	SB mm	H mm	DIK mm	SET PCS	QAL	ID
Turnblade knife set - VariPlan (ripple)	130	16	3.7	2	HW-MF	**617506** ●
Turnblade knife set - VariPlan (ripple)	166	16	3.7	2	HW-MF	**617571** ●
Turnblade knife set - VariPlan (ripple)	236	16	3.7	2	HW-MF	**617569** ●
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** ●



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

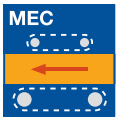
D mm	SB mm	ND mm	BO mm	n_{max} min^{-1}	Z	ID HS	ID HW-MF
125	130	136	40	12,000	2	**134250** □	**134200** ●
125	150	156	40	12,000	2	**134251**	**134201**
125	166	172	40	12,000	2	**134252** □	**134202** ●
125	180	186	40	12,000	2	**134253**	**134203**
125	210	216	40	12,000	2	**134254**	**134204**
125	236	242	40	12,000	2	**134255** □	**134205** ●
125	256	262	40	12,000	2	**134258**	**134208**
125	270	276	40	10,500	2	**134256**	**134206**
125	130	136	40	12,000	4	**134450** □	**134400** ●
125	150	156	40	12,000	4	**134451**	**134401**
125	166	172	40	12,000	4	**134452** □	**134402** ●
125	180	186	40	12,000	4	**134453**	**134403**
125	210	216	40	12,000	4	**134454**	**134404**
125	236	242	40	12,000	4	**134455** □	**134405** ●
125	256	262	40	12,000	4	**134458**	**134408** ●
125	270	276	40	10,500	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** ●
256	16	3.7	2	**610572** □	**617172** ●
270	16	3.7	2		**617165** ●

● 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 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.

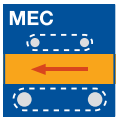
Lightweight aluminium tool body on HSK 85 WS
WP 240 2 05

D mm	SB mm	A mm	n_{max} min^{-1}	Z	QAL	ID LH / bottom	ID RH / top
125	130	26	12,000	2	HW-MF	**134500** □	**134501** □
125	150	26	12,000	2	HW-MF	**134502**	**134503**
125	166	26	12,000	2	HW-MF	**134504** □	**134505** □
125	180	26	12,000	2	HW-MF	**134506**	**134507**
125	210	26	12,000	2	HW-MF	**134508**	**134509**
125	236	26	12,000	2	HW-MF	**134510** □	**134511** □
125	270	26	8,000	2	HW-MF	**134512**	**134513**
125	310	26	8,000	2	HW-MF	**134514**	**134515**
125	130	26	12,000	4	HW-MF	**134600** □	**134601** □
125	150	26	12,000	4	HW-MF	**134602**	**134603**
125	166	26	12,000	4	HW-MF	**134604** □	**134605** □
125	180	26	12,000	4	HW-MF	**134606**	**134607**
125	210	26	12,000	4	HW-MF	**134608**	**134609**
125	236	26	12,000	4	HW-MF	**134610** □	**134611** □
125	270	26	8,000	4	HW-MF	**134612**	**134613**
125	310	26	8,000	4	HW-MF	**134614**	**134615**

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** ●



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 with reference cutterhead Z2 / V2
WP 240 2 08

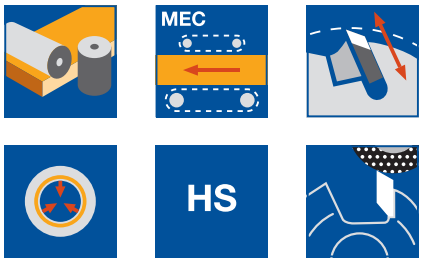
D mm	SB mm	A mm	n_{max} min^{-1}	Z	QAL	DRI	ID
125	236	26	12,000	2	HW-MF	LH / bottom	**134581** □
125	236	26	12,000	4	HW-MF	LH / bottom	**134681** □

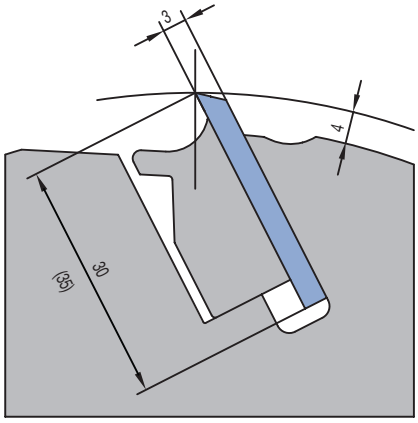
Further dimensions and inch dimensions on request.
Spare knives (HS/HW-MF/HW-RipTec) see section Knives and Spare Parts.

Spare knives:

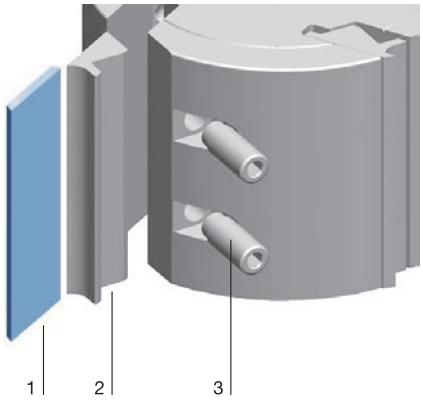
SB mm	H mm	DIK mm	SET PCS	ID HS	ID HW-MF
130	16	3.7	2	**610506** ●	**617106** ●
150	16	3.7	2	**610509** ●	**617109** ●
166	16	3.7	2	**610571** □	**617171** ●
180	16	3.7	2	**610512** ●	**617112** ●
210	16	3.7	2	**610515** ●	**617115** ●
236	16	3.7	2	**610569** □	**617169** ●
270	16	3.7	2		**617165** ●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

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





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	8,100	**142050**
163	160	50	4	HS	8,100	**142051**
163	230	50	4	HS	8,100	**142052**
163	60	50	6	HS	8,100	**142053** ●
163	100	50	6	HS	8,100	**142054** ●
163	130	50	6	HS	8,100	**142055** ●
163	160	50	6	HS	8,100	**142056** ●
163	230	50	6	HS	8,100	**142057** ●
163	60	50	8	HS	8,100	**142058**
163	100	50	8	HS	8,100	**142059**
163	130	50	8	HS	8,100	**142060**
163	160	50	8	HS	8,100	**142061**
163	180	50	8	HS	8,100	**142062**
163	230	50	8	HS	8,100	**142063**
203	100	50	12	HS	6,600	**142064**
203	130	50	12	HS	6,600	**142065**
203	160	50	12	HS	6,600	**142066**
203	180	50	12	HS	6,600	**142067**
203	230	50	12	HS	6,600	**142068**

Lightweight aluminium version on request.

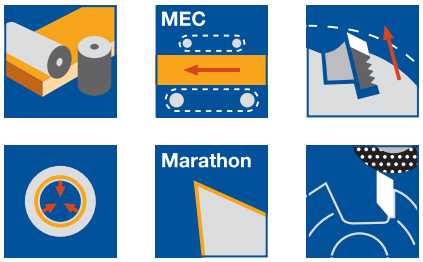
Spare knives:

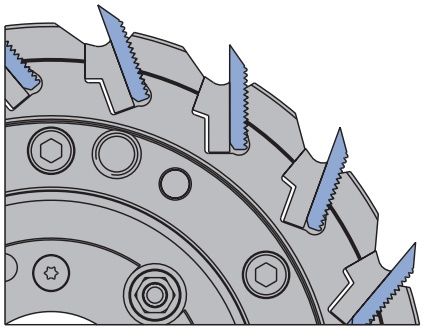
Part-no.	SB mm	H mm	DIK mm	ID HS Classic	ID HS Premium	ID HW	ID MC33
1	60	30	3	**605000**	**027101** ●	**027277** ●	**606700** ●
1	100	30	3	**605002** ●	**027103** ●	**027279** ●	**606702** ●
1	130	30	3	**605005** ●	**027106** ●	**027282** ●	**606705** ●
1	160	30	3	**605045** ●	**027163** ●		**606745** ●
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 planerhead 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	8,000	**142230**
200	230	50	14	8,000	**142231**
200	330	50	14	8,000	**142232**
225	150	50	18	7,200	**142233**
225	230	50	18	7,200	**142234**
225	330	50	18	7,200	**142235**
260	150	50	22	6,200	**142236**
260	230	50	22	6,200	**142237**
260	330	50	22	6,200	**142238**

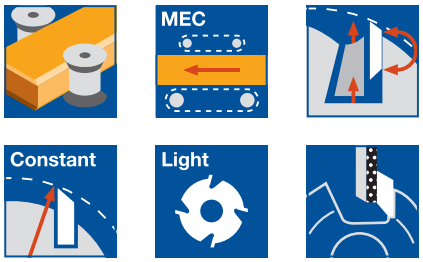
Spare knives:

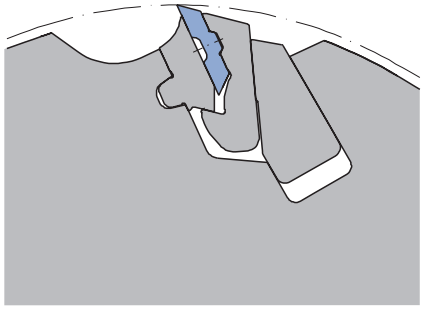
SB mm	H mm	DIK mm	QAL	ID
150	30	5	MC33	**697359** □
230	30	5	MC33	**697360** □
330	30	5	MC33	**697363** □

Spare parts:

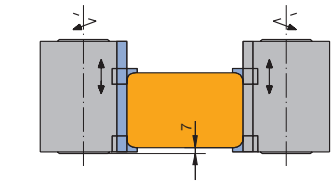
BEZ	ABM mm	BEM	ID
Knife setting device	for TurboPlan		**142290**
Setting gauge for Hydro planerhead	Knife protrusion 3.8 mm		**142291**
Grease gun			**008239** ●
Grease cartridge	for Hydro sleeve		**007934** ●
Jointing stone (round)	12x32	Colour: grey	**008237** ●
Jointing stone (angular)	20x15x60	Colour: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

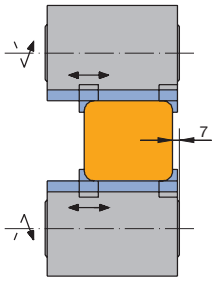
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





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	10,200	2+2	**131060** ●
125	166	172	40	HW	10,200	2+2	**131058** ●
125	236	242	40	HW	10,200	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.

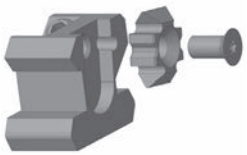
Spare knives:

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** ●

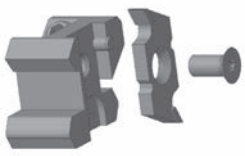
Further profile knives on request.

Spare parts:

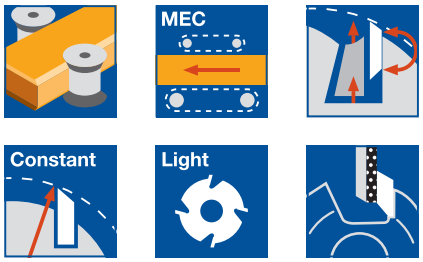
BEZ	ABM mm	ID LH	ID RH
Knife holder for edge knives	D=125, SW=20°	**011301** ●	**011300** ●
Knife holder for grooving knives	D=125, SW=20°, NT=6	**011303** ●	**011302** ●
Allen key	SW 4		**005445** ●
Allen key	SW 5		**005452** ●

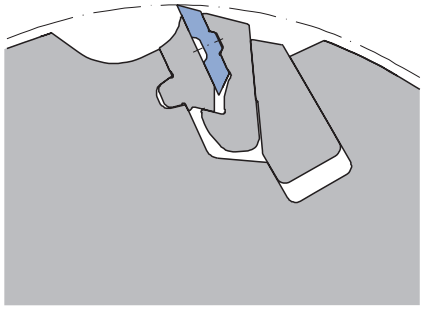


Knife holder to adapt edge knives.

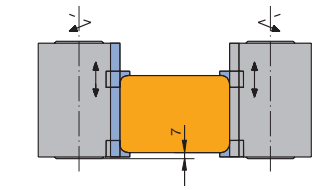


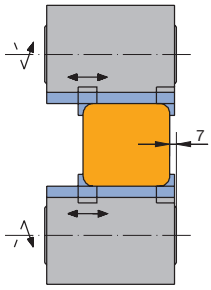
Knife holder to adapt grooving knives.





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	10,200	LH	left/ on bottom	**131120** □
125	130	26	2+2	10,200	RH	right/ on top	**131121** □
125	166	26	2+2	10,200	LH	left/ on bottom	**131116** □
125	166	26	2+2	10,200	RH	right/ on top	**131117** □
125	236	26	2+2	10,200	LH	on bottom	**131118** □
125	236	26	2+2	10,200	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.

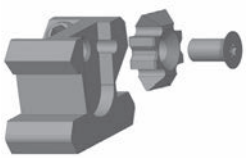
Spare knives:

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** ●

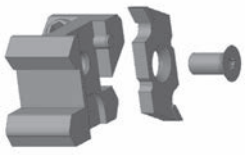
Further profile knives on request.

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** ●

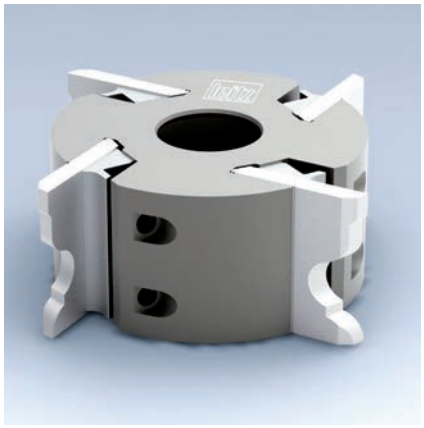


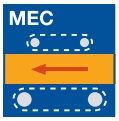
Knife holder to adapt edge knives.

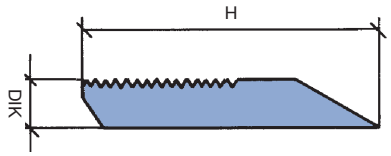


Knife holder to adapt grooving knives.

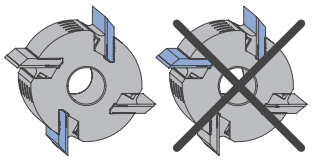
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org







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



Attention:
For safety reasons, always mount knives and 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

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	SB	BO	BO_{max}	n_{max}	Z	ID
mm	mm	mm	mm	min^{-1}		
122	80	40	40	10,300	2	**135805** ●
122	40	40	40	10,300	4	**135802** ●
122	60	35	40	10,300	4	**135806** ●
122	60	40	40	10,300	4	**135808** ●
122	80	40	40	10,300	4	**135809** ●
122	100	35	40	10,300	4	**135810**
122	100	40	40	10,300	4	**135812** ●
122	130	40	40	10,300	4	**135814** ●
122	150	40	40	10,300	4	**135817** ●
122	170	40	40	10,300	4	**135816** ●
122	180	40	40	10,300	4	**135819** ●
122	230	40	40	10,300	4	**135821** ●
122	240	40	40	10,300	4	**135822**
137	60	40	50	9,400	4	**135823**
137	60	50	50	9,400	4	**135825** ●
137	80	50	50	9,400	4	**135826** ●
137	100	40	50	9,400	4	**135827**
137	100	50	50	9,400	4	**135829** ●
137	130	40	50	9,400	4	**135830**
137	130	50	50	9,400	4	**135831** ●
137	150	50	50	9,400	4	**135833** ●
137	180	50	50	9,400	4	**135836**
137	230	50	50	9,400	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.

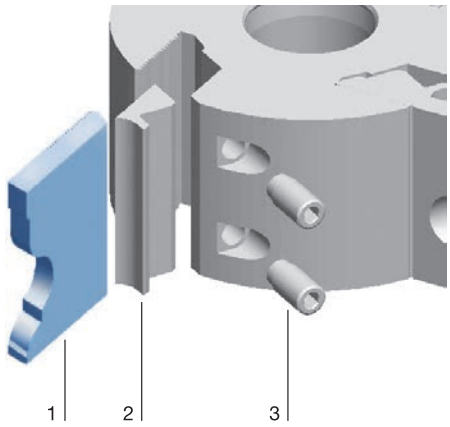
Cutting angle 12°
WM 501 2 05

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

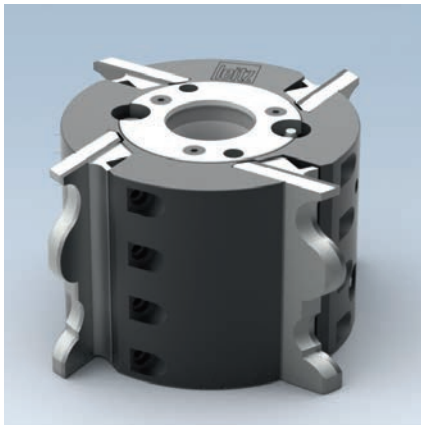
Cutterhead without knives. For blank knives in different dimensions and qualities, see section Knives and Spare Parts.
Lightweight aluminium design on request.

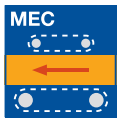
Spare parts:

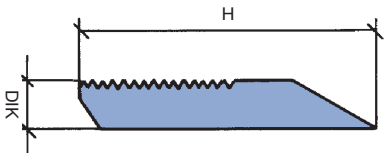
Part-no.	BEZ	ABM mm	for SB mm	ID
2	Clamping wedge	38x25,3x10,8	40	**620700** ●
2	Clamping wedge	58x25,3x10,8	60	**620701** ●
2	Clamping wedge	78x25,3x10,8	80	**620702** ●
2	Clamping wedge	98x25,3x10,8	100	**620703** ●
2	Clamping wedge	128x25,3x10,8	130	**620705** ●
2	Clamping wedge	148x25,3x10,8	150	**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** ●



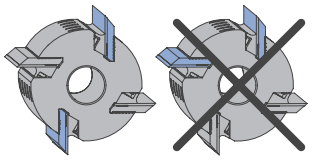
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org







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



Attention:
For safety reasons, always mount knives and 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

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 combinaion with a clamping collar.

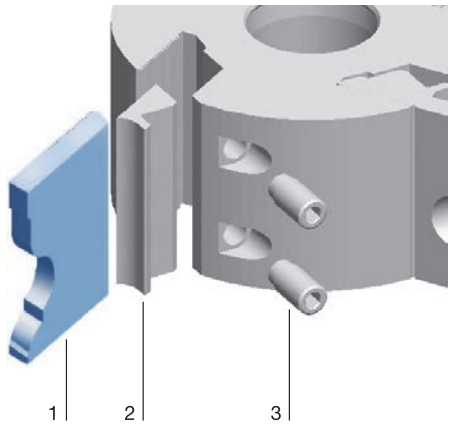
Steel tool body
HM 501 2 05

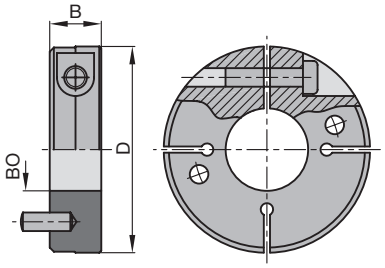
TD mm	SB mm	BO mm	for knife thickness mm	Z	n_{max} min^{-1}	ID
135	100	40	8 - 10	4	9,400	**137035**
135	150	40	8 - 10	4	9,400	**137036**
145	60	50	8 - 10	6	9,100	**137037**
145	100	50	8 - 10	6	9,100	**137038**
150	60	50	8 - 10	4	8,800	**137039** ●
150	100	50	8 - 10	4	8,800	**137040** ●
150	150	50	8 - 10	4	8,800	**137041** ●
150	230	50	8 - 10	4	8,800	**137042** ●
150	60	50	8 - 10	6	8,800	**137043** ●
150	100	50	8 - 10	6	8,800	**137044** ●
150	150	50	8 - 10	6	8,800	**137045** ●
150	230	50	8 - 10	6	8,800	**137046**
165	60	50	8 - 10	8	8,200	**137047**
165	100	50	8 - 10	8	8,200	**137048**
170	60	50	8 - 10	8	8,100	**137049** ●
170	100	50	8 - 10	8	8,100	**137050**
170	150	50	8 - 10	8	8,100	**137051** ●
190	60	50	5	12	7,400	**137052**
190	60	50	5	14	7,400	**137053**

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

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** ●





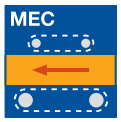
Clamping collar without thread

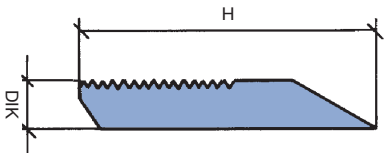
Clamping collars without thread

TD 870 0

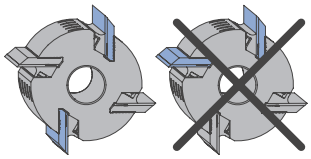
D	B	BO	ID
mm	mm	mm	
100	25	40	**030700** ●
100	25	50	**030702** ●

● 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 and 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

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.

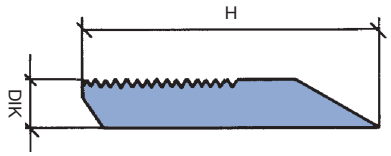
Workpiece material:
Cutting angle 20° for softwood and hardwood in general.
Cutting angle 12° for materials likely to splinter e.g. oak, Douglas fir, merbau and wood fibre materials, e.g. MDF.

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.

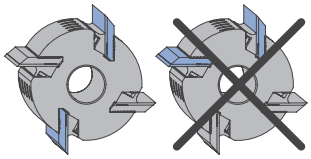
Cutting angle 20°
WP 510 2 02

	TD mm	SB mm	A mm	Z	n_{max} min^{-1}	ID LH / bottom	ID RH / top
	90	40	26	2	12,000	**136200**	**136201**
	90	60	26	2	12,000	**136202** ●	**136203** ●
	90	80	26	2	12,000	**136204** ●	**136205** ●
	90	100	26	2	12,000	**136206** ●	**136207** ●
	90	130	26	2	12,000	**136208** ●	**136209** ●
	90	150	26	2	12,000	**136210**	**136211**
*	90	170	26	2	12,000	**136212** ●	**136213** ●
*	90	210	26	2	12,000	**136216**	**136217**
*	90	240	26	2	12,000	**136218** ●	**136219** ●
	90	270	26	2	8,000	**136220**	**136221**
	90	40	26	4	12,000	**136224** ●	**136225** ●
	90	60	26	4	12,000	**136226** ●	**136227** ●
	90	80	26	4	12,000	**136228** ●	**136229** ●
	90	100	26	4	12,000	**136230** ●	**136231** ●
	90	130	26	4	12,000	**136232** ●	**136233** ●
	90	150	26	4	12,000	**136234**	**136235**
*	90	170	26	4	12,000	**136236** ●	**136237** ●
*	90	210	26	4	12,000	**136240**	**136241**
*	90	240	26	4	12,000	**136242** ●	**136243** ●
*	90	270	26	4	8,000	**136244**	**136245**
	115	80	26	6	10,000	**136198** ●	**136199** ●
	115	130	26	6	10,000	**136400** ●	**136401** ●
	115	170	26	6	10,000	**136402** ●	**136403** ●
	115	240	26	6	8,000	**136404** ●	**136405** ●

* = Not for PKS blank knives H = 70 mm with n = 12000 min^{-1}
Cutterhead without knives. For blank knives in different dimensions and qualities, see section Knives and Spare Parts.



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



Attention:
For safety reasons, always mount knives and 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

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	12,000	**136248** ●	**136249** ●
	90	60	26	2	12,000	**136250** ●	**136251** ●
	90	80	26	2	12,000	**136252**	**136253**
	90	100	26	2	12,000	**136254** ●	**136255** ●
	90	130	26	2	12,000	**136256** ●	**136257** ●
	90	150	26	2	12,000	**136258**	**136259**
*	90	170	26	2	12,000	**136260**	**136261**
*	90	210	26	2	12,000	**136264**	**136265**
*	90	240	26	2	12,000	**136266**	**136267**
	90	40	26	4	12,000	**136270** ●	**136271** ●
	90	60	26	4	12,000	**136272** ●	**136273** ●
	90	80	26	4	12,000	**136274** ●	**136275** ●
	90	100	26	4	12,000	**136276** ●	**136277** ●
	90	130	26	4	12,000	**136278**	**136279**
	90	150	26	4	12,000	**136280**	**136281**
*	90	170	26	4	12,000	**136282**	**136283**
	115	80	26	6	10,000	**136192**	**136193**
	115	130	26	6	10,000	**136194**	**136195**
	115	170	26	6	10,000	**136196**	**136197**

* = Not for PKS blank knives H = 70 mm with n = 12000 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** ●

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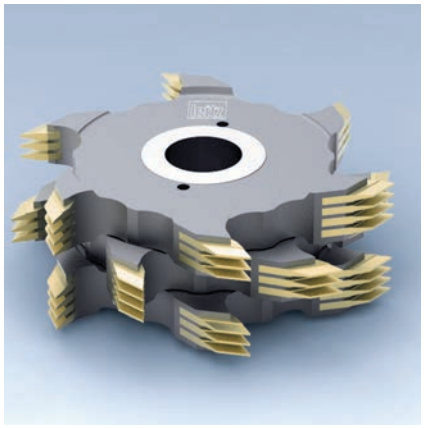
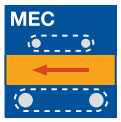
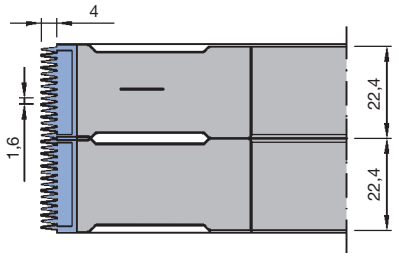
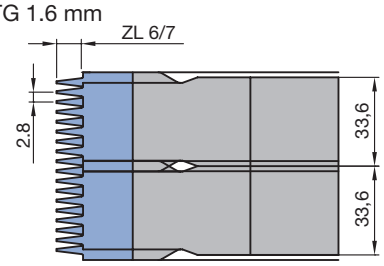


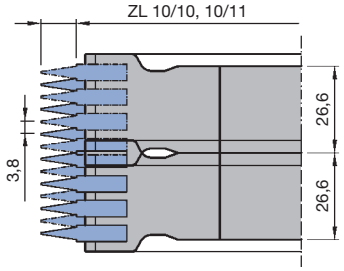




Minifinger joint cutter ZL 4 mm, TG 1.6 mm



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 6 mm for ID **123005** and 8 mm for 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	3/3	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** □

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□ available at short notice
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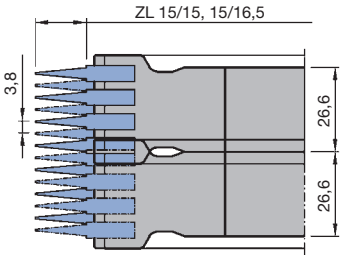
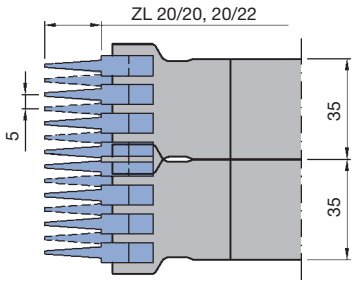
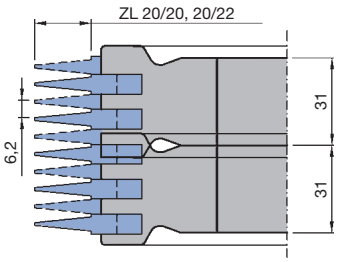


Minifinger joint cutter ZL 15 mm, TG 3.8 mm



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**

● available ex stock
□ available at short notice
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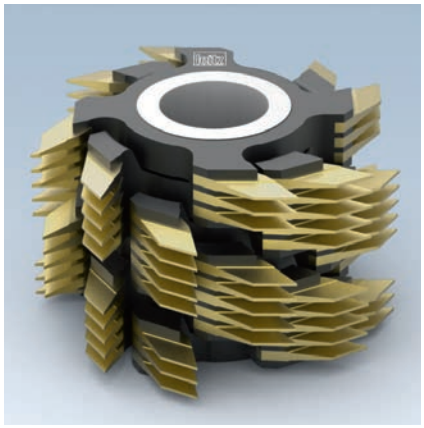
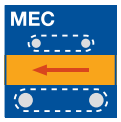
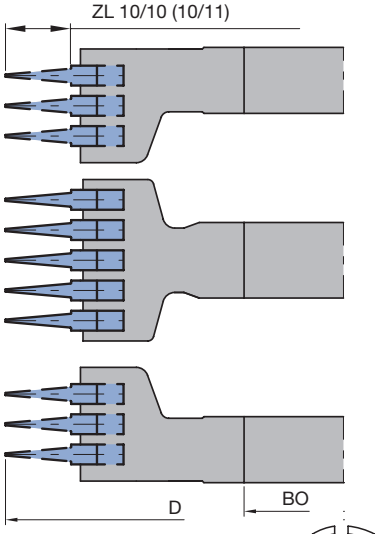
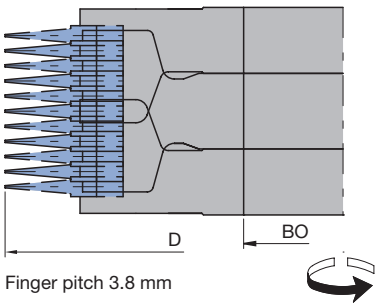




ZL 15/15 (15/16,5)
ZL 10/10 (10/11)



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	70	4	3	MC	**121708**	**121710**
Basic cutter	200	35.4	19	70	4	5	MC	**120725**	**120726**
Bottom final cutter	200	20.2	16.6	70	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
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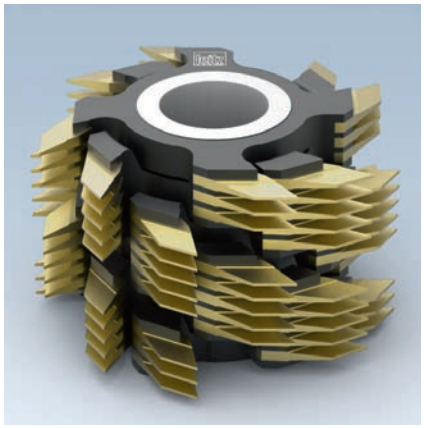
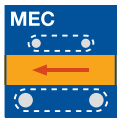
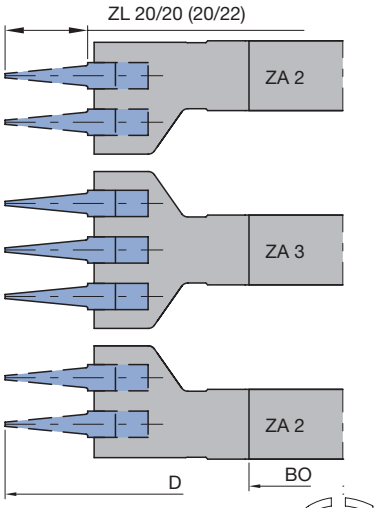
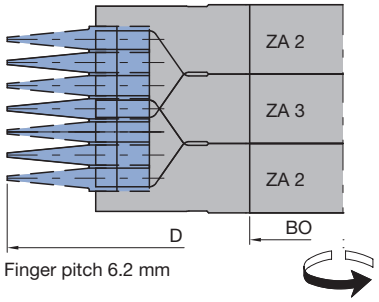






Finger pitch 6.2 mm



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
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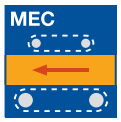


Minifinger joint cutter, Marathon, real Z 6

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.

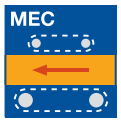
ZL 10 mm, TG 3.8 mm
WF 620 2 06, WF 623 2 06

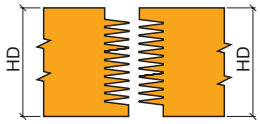
Tool Type	D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ZL mm	ID
Top final cutter	250	26.6	19	50	6	4	MC	10/11	**121012** ●
Basic cutter	250	49.4	26.6	50	6	7	MC	10/11	**120601** ●
Bottom final cutter	250	26.6	19	50	6	4	MC	10/11	**121013** ●

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

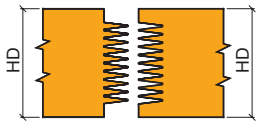
		Basic cutter	Final cutter top	Final cutter bottom
ZA		7	4	4
ND		26,6	19	19
HD	KLH	Cutter quantity	Cutter quantity	Cutter quantity
27	38	0	1	1
53	64,6	1	1	1
80	91,2	2	1	1
106	117,8	3	1	1
133	144,4	4	1	1
160	171	5	1	1
186	197,6	6	1	1
213	224,2	7	1	1
239	250,8	8	1	1
266	277,4	9	1	1
293	304	10	1	1

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 mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	DRI	ID
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 mm	SB mm	BO mm	Z	QAL	ID LH	ID RH
249.7	12	60	6	MC	**122400** □	**122401** □

29479
TB 270 0

d mm	BO mm	NL mm	GL mm	ID
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**

28448
TR 100 0

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

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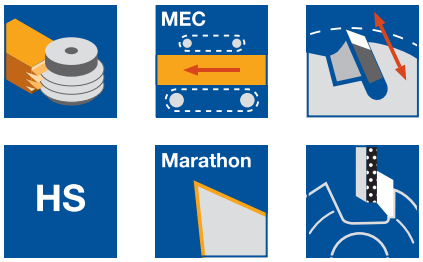
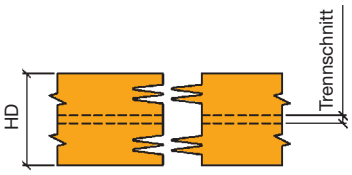


Profile 1 with continuous finger jointing

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	4,000	**135524**	**135525**
2	266.67	50	50	5/5	HS	4,000	**135532**	**135533**
3	266.67	50	50	5/5	HS	4,000	**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	4,000	**135548**	**135549**
2	266.67	50	50	5/5	HS	4,000	**135556**	**135557**
3	266.67	50	50	5/5	HS	4,000	**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	4,000	**135500**	**135501**
2	266.67	50	50	5/5	HS	4,000	**135508**	**135509**
3	266.67	50	50	5/5	HS	4,000	**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** ●

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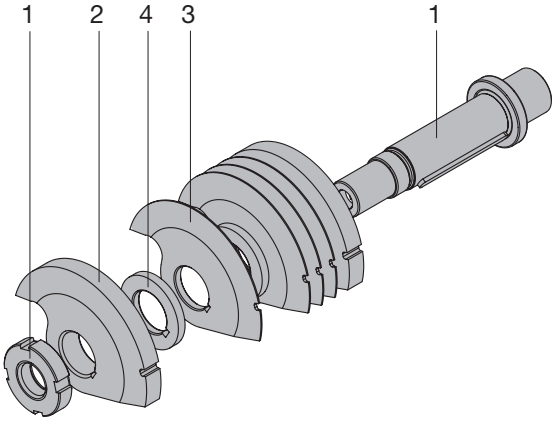
Spare parts:

Part-no.	BEZ	ABM mm	TG mm	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** ●



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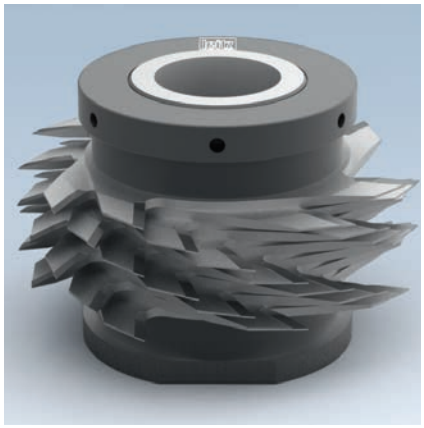
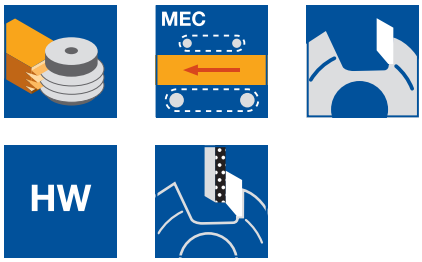




Minifinger disc cutter, HW, with and without shoulder cutter

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	4	9,000	**021511** ●
Minifinger joint cutter	250	3.8	70	6	6,000	**021513** ●
Shoulder cutter	159.8	15.2	70	4	9,000	**021762** ●
Shoulder cutter P3	249.7	15.2	70	6	6,000	**021764** ●
Shoulder cutter P5	239.7	15.2	70	6	6,000	**022153** ●

Clamping element with threaded nut
TB 270 0

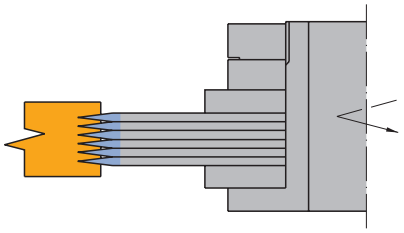
d mm	BO mm	NL mm	GL mm	ID
70	50	116	146	**029695** ●
70	50	80	110	**029473** ●

Spare parts:

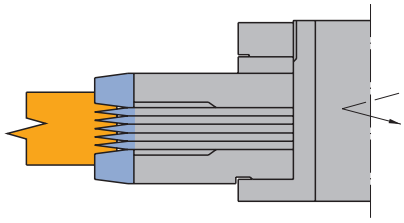
BEZ	ABM mm	ID
Sickle spanner adjustable	D90/155; L290; DIN1816; tenon 6	**005462** ●

Spacers
TR 100 0

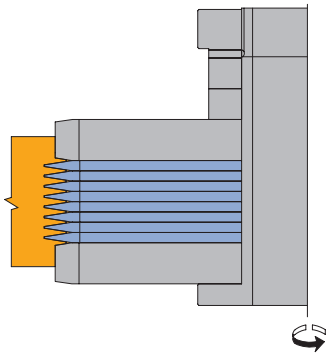
D mm	B mm	BO mm	TG mm	ID
100	3.8	70	3.8	**028437** ●
100	11.4	70	3.8	**028450** ●
100	15.2	70	3.8	**028439** ●
175	11.4	70	3.8	**028678** ●



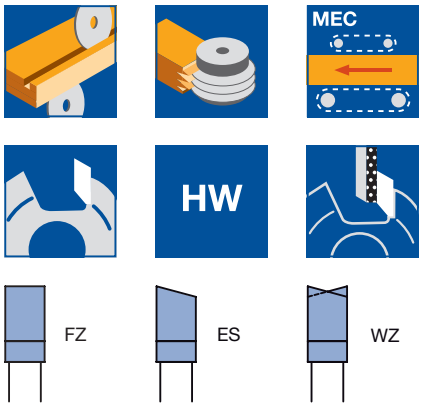
Minifinger joint cutterset without shoulder cutters



Minifinger joint cutterset with shoulder cutters P3



Minifinger joint cutterset with shoulder cutters P5



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	8,000	**061995** ●	**061995** ●

Single scoring saw mounted on flanged sleeve
SK 999 2, 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	7,200	**061986** □	**061987** □
200	4.75	40 DKN	64	ES	HW	7,200	**062632** □	**062633** □

Double scoring saw mounted on flanged sleeve
SK 999 2

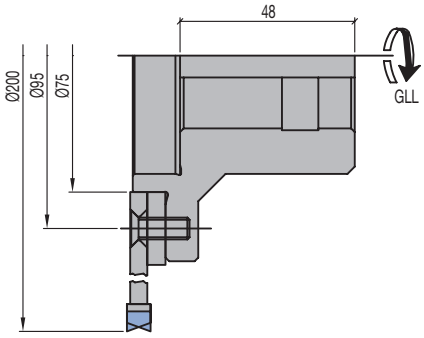
D mm	SB mm	BO mm	Z	ZF	QAL	n_{max} min^{-1}	ID LH	ID RH
200	12.2	40 DKN	48	WZ/WZ	HW	7,200	**061988** □	**061989** □
200	12.3	40 DKN	48	ES/WZ	HW	7,200	**061990** □	**061991** □
190								

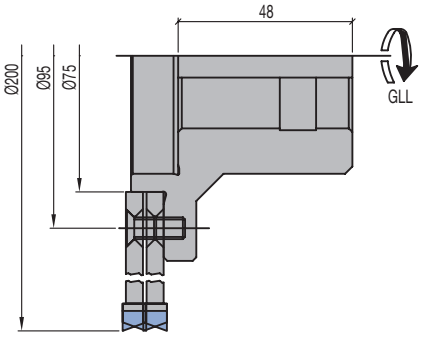
Spare sawblades:

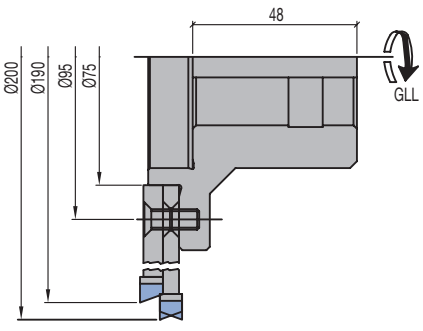
D mm	SB mm	BO mm	Z	ZF	NLA mm	QAL	n_{max} min^{-1}	ID LH	ID RH
200	6.5	75	48	WZ	6NL TK95	HW	7,200	**061992** ●	**061992** ●
190	6.7	75	48	ES	6NL TK95	HW	7,200	**061993** ●	**061994** ●
200	4.75	75	64	ES	6NL TK95	HW	7,200	**062630** ●	**062631** ●

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** ●







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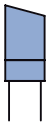
HW


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 sawblade 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

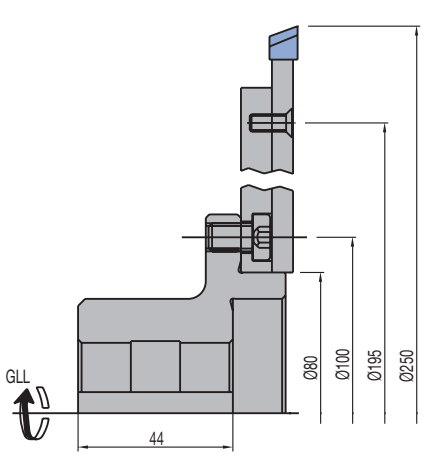
D mm	SB mm	BO mm	Z	ZF	QAL	ID LH	ID RH
250	6.35	40 DKN	80	ES	HW	**062618** □	**062619** □
250	8	40 DKN	60	ES	HW	**062620** □	**062621** □
350	8	40 DKN	72	ES	HW	**062622** □	**062623** □

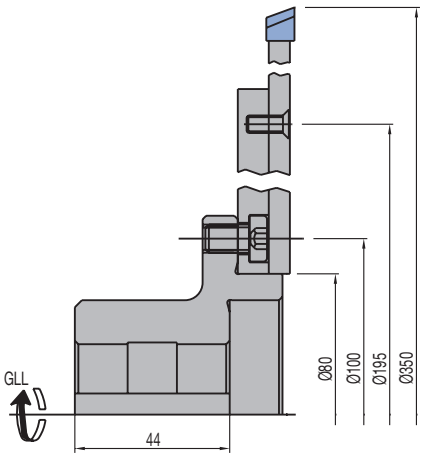
Spare sawblades:

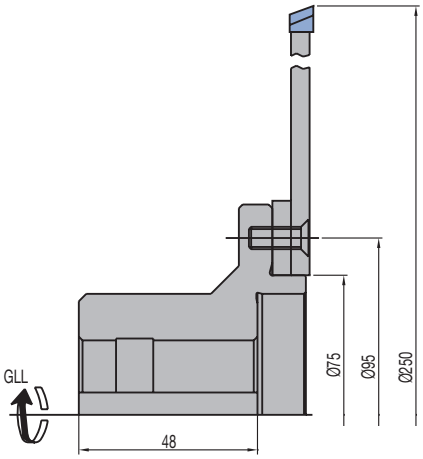
D mm	SB mm	BO mm	Z	ZF	QAL	ID LH	ID RH
250	6.35	75	80	ES	HW	**062624** ●	**062625** ●
250	8	80	60	ES	HW	**062626** ●	**062627** ●
350	8	80	72	ES	HW	**062628** ●	**062629** ●

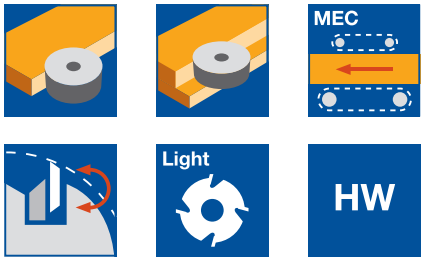
Spare parts:

BEZ	ABM mm	L mm	BO mm	ID
Flanged sleeve	113/80x59x40 DKN	12.7	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

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

Machine	D mm	SB mm	BO mm	Z	V	ID
SCM	350	60	HSK-E 63	4x6	2 x 4+4	**132571** □
SCM	350	60	HSK-E 63	4x6	2 x 4+4	**132572** □
Uniteam	250	50	35 DKN	4x5	2 x 4	**132562** □
Uniteam	250	80	35 DKN	4x8	2 x 4	**132561** □
Uniteam	290	80	HSK-E 63	4x8	2 x 4+4	**132563** □
Uniteam	290	80	HSK-E 63	4x8	2 x 4+4	**132564** □
Uniteam	290	80	HSK-A 100	4x8	2 x 4+4	**132565** □
Uniteam	290	80	HSK-A 100	4x8	2 x 4+4	**132566** □
Uniteam	420	80	HSK-E 63	4x8	2 x 4+4	**132567** □
Uniteam	420	80	HSK-E 63	4x8	2 x 4+4	**132568** □
Uniteam	420	80	HSK-A 100	4x8	2 x 4+4	**132569** □
Uniteam	420	80	HSK-A 100	4x8	2 x 4+4	**132570** □
Weinmann	300	20	55	4x2	2 x 4+4	**132557** □
Weinmann	300	50	55	4x5	2 x 4+4	**132558** □
Weinmann	300	60	55	4x6	2 x 4+4	**132560** □
Weinmann	300	61	55	4x6	2 x 4+4	**132559** □

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** ●

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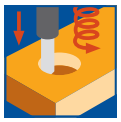
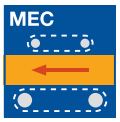
Routing

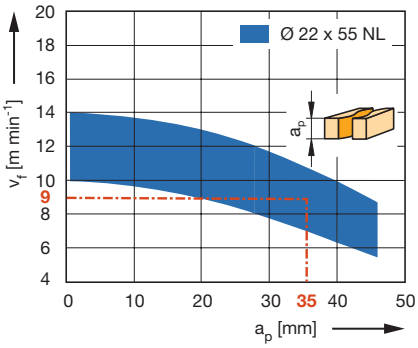
Leitz tool programme for wood construction

Content chapter Routing





Feed speed v_f depending on cutting depth a_p



Workpiece material: Plastic coated chipboard
Operation: Sizing
Speed: n = 18000 min^{-1}
Correction factor for v_f: MDF = 0.8

Roughing router cutter in turnblade design

Application:
Router cutter for sizing and grooving to roughing quality.

Machine:
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, laminated veneer lumber (plywood, multiplex plywood etc.).

Technical information:
Tungsten carbide turnblade knives arranged in irregular pitch for quiet cutting.
With turnblade knife plunging tip.

HW, Z 1+1
WL 101 2

D mm	GL mm	NL mm	S mm	DRI	ID
22	125	55	25x60	RH	**041922** ●

RPM: n = 16000 - 24000 min^{-1}

Spare knives:

BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	9x12x1,5	HW-05F	10	**005158** ●
Turnblade knife	12x12x1.5	HW-05F	10	**005081** ●

Spare parts:

BEZ	ABM mm	ID
Oval head screw Torx® 15	M4x5	**007037** ●
Oval head screw Torx® 15	M4x6	**006225** ●
Torx® key	Torx® 15	**005457** ●

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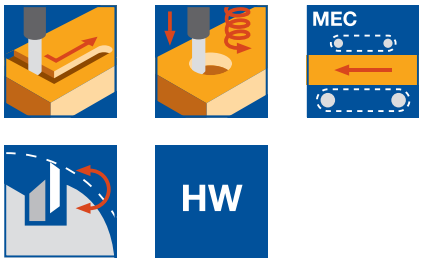
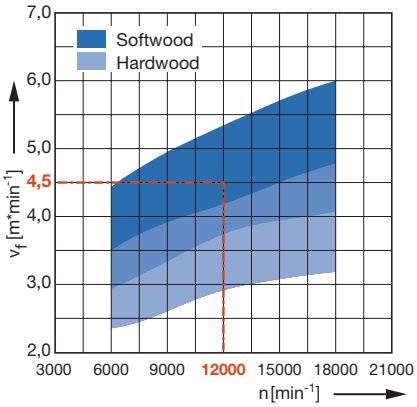
Instruction manual visit www.leitz.org



Feed speed v_f depending on RPM n



Workpiece material: Softwood, Hardwood
Operation: Sizing and grooving
Axial infeed: a_p = 20 - 50 mm
Correction factor for v_f: Glulam = 0.8

Roughing router cutter in turnblade design - HeliCut 11

Application:
Router for sizing and grooving to roughing/finishing quality. Cutting of tenons for frame constructions.

Machine:
Stationary routers with/without CNC control, machining centres, joinery machines, milling maschines with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood, glulam and laminated wood.

Technical information:
Spiral shaped edge arrangement of the tungsten carbide turnblades (4 times turnable). Tungsten carbice turnblade plunging knife with chipbreakers for good chip removal (for D = 40 mm). Tangential fixing of the knives in the dust protected area. Deep boreholes are to be cut circularly.

HW, Z 2+2
WL 101 2

D mm	GL mm	NL mm	S mm	DRI	ID
30	125	60	20x50	RH	**041928** ●
30	195	120	30x53	RH	**041929** ●
40	235	160	30x53	RH	**041927** ●

RPM: n = 6000 - 18000 min^{-1}

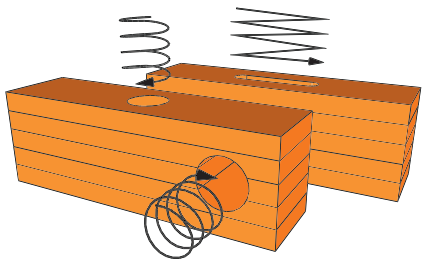
Note:
Tool shank S30x53 with recess suitable for many conventional joinery machines. Not suitable for use in shrink-fit chucks.
On machines with automatic tool changer use collet chuck ER40 together with collet d = 30 mm, ID **679039**.

Spare knives:

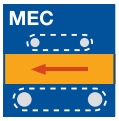
BEZ	Knife	ABM mm	for D mm	QAL	VE PCS	ID
Turnblade knife	Peripheral tip	11x11x1,5		HW	10	**602515** ●
Turnblade knife	Peripheral tip	11x11x1,5		TDC		**602904** ●
Exchange knife	Plunging tip	20,6x12.7x2	30	HW	10	**602531** ●
Exchange knife	Plunging tip	22x12,7x2	40	HW	10	**602516** ●

Spare parts:

BEZ	ABM mm	ID
Countersink screw, Torx® 15	M4x6	**114039** ●
Countersink screw, Torx® 20	M5x6	**114040** ●
Torx® key	Torx® 15	**005457** ●
Torx® key	Torx® 20	**117520** ●



Application notes:
Circular pockets and boreholes of a depth > 1xD have to be cut circularly.
Use ramp-in cutting to produce mortises.



HW

Spiral roughing router cutter

Application:
Router cutter for sizing and grooving in roughing quality.

Machine:
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood, laminated wood for window construction, chipboard and fibre working materials (MDF, HDF etc.), uncoated, laminated veneer lumber (plywood, multiplex plywood etc.).

Technical information:
Solid tungsten carbide with chipbreakers for good chip removal. Long design for large cutting depths (recommended in serveral steps).

Z 3, long design, shank 32 mm
WO 160 2

D mm	GL mm	NL mm	S mm	Z	Twist	DRI	ID
40	283	200	32x65	3	RD	RH	**240531** ●

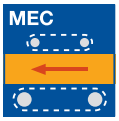
RPM: n_{max} = 12000 min^{-1}

Z 3, long design, shank 20 mm
WO 160 2

D mm	GL mm	NL mm	S mm	Z	Twist	DRI	ID
20	155	90	20x65	3	RD	RH	**240543** ●

RPM: n_{max} = 24000 min^{-1}

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



HW

Spiral roughing router cutter with extended gullet

Application:
Router cutter for sizing and grooving in roughing quality.

Machine:
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

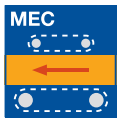
Workpiece material:
Softwood and hardwood, laminated wood for window construction, chipboard and fibre working materials (MDF, HDF etc.), uncoated, laminated veneer lumber (plywood, multiplex plywood etc.).

Technical information:
Solid tungsten carbide with chipbreakers and extended gullet for good chip removal. Extra long design for large cutting depths (recommended in serveral steps).

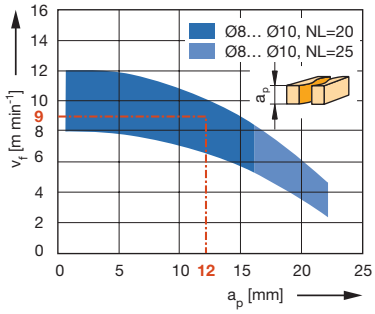
Z 3, extra long design, shank 16 mm
WO 160 2

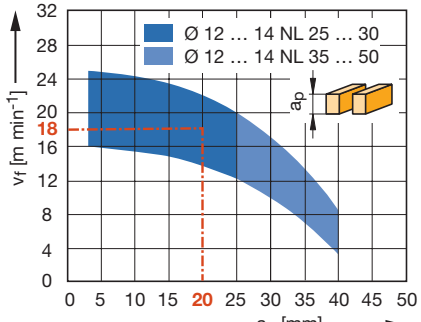
D mm	GL mm	NL mm	S mm	Z	Twist	DRI	ID
25	180	25	16x70	3	RD	RH	**240544** ●

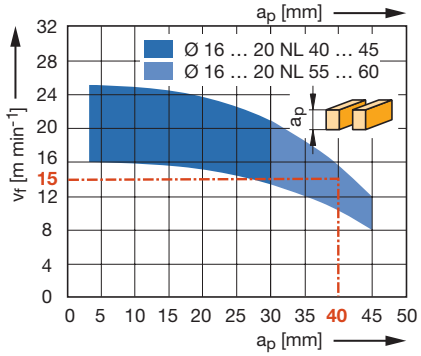
RPM: n_{max} = 18000 min^{-1}



Feed speed v_f depending on cutting depth a_p







Spiral roughing/finishing router cutter Marathon

Application:
Router cutter for sizing and grooving in roughing/finishing quality.

Machine:
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood, laminated wood for window construction, chipboard and fibre working materials (MDF, HDF etc.), uncoated, laminated veneer lumber (plywood, multiplex plywood etc.), plastomers, solid surface material (Corian, Varicor etc.), PVC window profiles.

Technical information:
Solid tungsten carbide. Marathon coating for increased performance time. Short design for increased stability. Long design for increased cutting depth (recommended in several steps). Higher feed speeds than conventional roughing cutters. Extremely smooth running.

Z 2 / Z 3, short design
WO 160 2 12

D mm	GL mm	NL mm	S mm	Z	Twist	ID LH	ID RH
8	65	20	8x40	2	RD		**042277** ●
10	70	25	10x40	2	RD		**042278** ●
10	70	25	10x40	2	LD		**042279** ●
12	70	25	12x40	3	RD		**042280** ●
12	70	25	12x40	3	LD		**042281** ●
14	80	30	14x45	3	RD		**042282** ●
16	100	40	16x55	3	RD		**042273** ●
16	100	40	16x55	3	LD	**042283** ●	**042284** ●
18	90	35	18x50	3	RD		**042285** ●
20	100	45	20x50	3	RD		**042286** ●
25	120	60	25x55	3	RD		**042287** ●

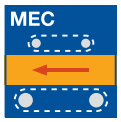
Z 2 / Z 3, long design
WO 160 2 12

D mm	GL mm	NL mm	S mm	Z	Twist	ID LH	ID RH
8	80	25	8x55	2	RD		**042288** ●
12	80	35	12x40	3	RD		**042270** ●
12	80	35	12x40	3	LD	**042289** ●	**042290** ●
12	90	42	12x40	3	RD		**042271** ●
14	110	50	14x55	3	RD		**042272** ●
14	110	50	14x55	3	LD		**042291** ●
16	110	55	16x55	3	RD		**042274** ●
16	110	55	16x55	3	LD	**042292** ●	**042293** ●
18	120	60	18x55	3	RD		**042294** ●
20	120	60	20x55	3	RD		**042275** ●
20	120	60	20x55	3	LD	**042295** ●	**042296** ●
20	130	75	20x50	3	RD		**042276** ●
20	130	75	20x50	3	LD	**042297** ●	

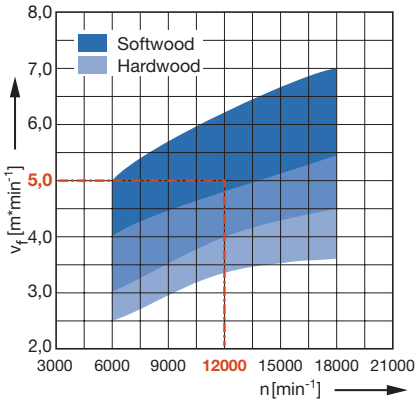
RPM: Wood/wood derived material: n = 16000 - 24000 min^{-1}
Plastics: n = 12000 - 18000 min^{-1}

Workpiece material: Softwood
Operation: Sizing
Speed: n = 18000 min^{-1}
Correction factor for v_f: Hardwood = 0.8; Chipboard = 1.3; Glulam = 0.9

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



Feed speed v_f depending on cutting depth a_p



Workpiece material: Softwood
Operation: Sizing
Axial infeed: a_p = 20 - 50 mm
Correction factor for v_f:
Hardwood = 0.7; Glulam = 0.8

Spiral roughing/finishing router cutter Marathon

Application:
Router cutter for sizing and grooving in roughing/finishing quality.

Machine:
Stationary routers with/without CNC control, machining centres, joinery machines, milling machines with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood, glulam, glue-laminated timber and laminated wood.

Technical information:
Solid tungsten carbide. Marathon coating for increased performance times. Long design for large cutting depths. Higher feed rates with conventional roughing cutters possible. Extremely smooth running.

Z 3, long design, shank 30 mm
WO 160 2 12

D	GL	NL	S	Z	Twist	DRI	ID
mm	mm	mm	mm				
30	195	120	30x53	3	RD	RH	**240305** ●
40	195	120	30x53	3	RD	RH	**240306** ●
40	235	160	30x53	3	RD	RH	**240307** ●

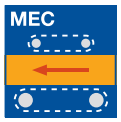
RPM: n = 6000 - 18000 min^{-1}

Note:
Tool shank S30x53 with recess suitable for many conventional joinery machines. Not suitable for use in shrink-fit chucks.
On machines with automatic tool changer use collet chuck ER 40 together with collet d = 30 mm, ID **679039**.

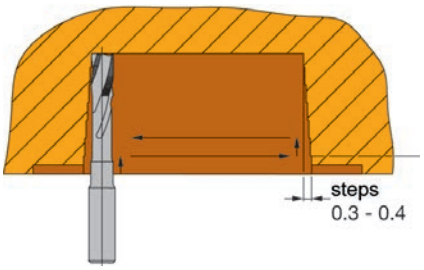
Z 3, long design, shank 32 mm
WO 160 2 12

D	GL	NL	S	Z	Twist	DRI	ID
mm	mm	mm	mm				
30	195	120	32x65	3	RD	RH	**240308** ●
40	195	120	32x65	3	RD	RH	**240309** ●
40	235	160	32x65	3	RD	RH	**240310** ●

RPM: n = 6000 - 18000 min^{-1}



Application example for mortise slot production



Application data:
Infeed at:
a_p 4 - 8 mm per stroke in solid wood;
v_f 10 - 16 m min^{-1};
n = 12000 - 18000 min^{-1}

a_p 8 - 15 mm per stroke in chipboard;
v_f 12 - 18 m min^{-1};
n = 12000 - 18000 min^{-1}

Spiral roughing/finishing router cutter Marathon

Application:
Router cutter for sizing, grooving and mortise slots in roughing/finishing quality.

Machine:
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood, modified timber for window construction, chipboard and fibre working materials (MDF, HDF etc.) uncoated, laminated veneer lumber (plywood, multiplex plywood etc.), PVC window profiles.

Technical information:
Solid tungsten carbide. Marathon coating for increased performance time. Extra long design for increased cutting depth (in several steps). Higher feed speeds than conventional spiral roughing cutters, extremely smooth running.

Z 2 / Z 3, extra long design, for mortise slots
WO 160 2 13

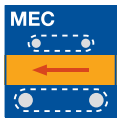
D mm	GL mm	NL mm	AL mm	S mm		Z	Twist	DRI	ID	ID Set HSK-F 63
8	80	25	51	8x25		2	LD	RH	**240010** ●	**240500** □
10	90	30	51	10x35		2	LD	RH	**240011** ●	**240501** □
12	120	35	80	12x35		3	LD	RH	**240012** ●	**240502** □
12	120	35	80	12x35		3	RD	RH	**240000** ●	
14	170	30	95	16x50		3	RD	RH	**240001** ●	
14	190	30	120	16x50		3	RD	RH	**240002** ●	
16	170	50	105	16x50		3	RD	RH	**240003** ●	
16	179	30	120	16x58	*	3	RD	RH	**240004** ●	
16	179	30	120	16x58		3	RD	RH	**240013** ●	
16	179	30	120	20x58	*	3	RD	RH	**240005** ●	
16	179	30	120	20x58		3	RD	RH	**240014** ●	
16	205	30	135	20x50		3	RD	RH	**240006** ●	
17	190	30	120	20x50		3	RD	RH	**240008** ●	
18	170	50	115	20x50		3	RD	RH	**240009** ●	

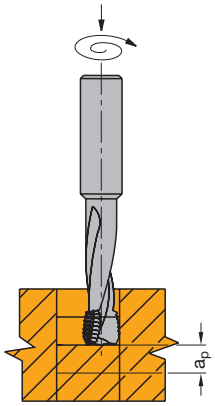
RPM: Wood/wood derived material: D 10-12 mm: n = 18000 - 24000 min^{-1}
Wood/wood derived materials: D 14-18 mm: n = 12000 - 20000 min^{-1}
Plastics: n = 12000 - 18000 min^{-1}

* with clamping flat for HOMAG/WEEKE lock case trimming unit.

Note:
Set HSK-F 63 = tools marked with the note „Set HSK-F 63“ will be supplied mounted in shrink-fit chuck HSK-F 63.

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





Production of keyholes and spyholes by circular cutting

Application data:
a_p 4 - 8 mm per stroke in solid wood;
v_f 10 - 16 m min^{-1};
n = 12000 - 18000 min

a_p 8 - 15 mm per stroke in chipboard;
v_f 12 - 18 m min^{-1};
n = 12000 - 18000 min^{-1}

Spiral roughing/finishing router cutter Marathon

Application:
Router cutter for sizing and cutting spyholes and keyholes in roughing/finishing quality.

Machine:
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood, modified timber for window construction, chipboard and fibre working materials (MDF, HDF etc.) uncoated, laminated veneer lumber (plywood, multiplex plywood etc.).

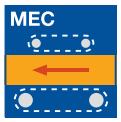
Technical information:
Solid tungsten carbide. Marathon coating for increased performance time. Extra long design for increased cutting depth (in several steps). Higher feed speeds than conventional spiral roughing cutters, extremely smooth running.

Z 3, extra long design for cutting spyholes and keyholes
WO 160 2 14

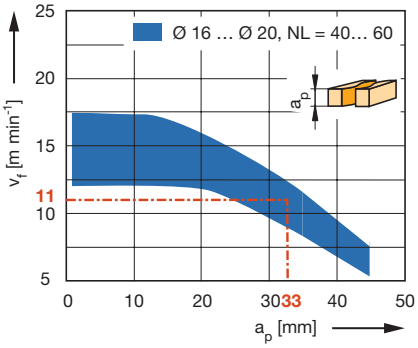
D mm	GL mm	NL mm	AL mm	S mm	Z	DRI	ID	ID Set HSK-F 63
10	95	45		10x40	3	RH	**240100** ●	
12	120	15	75	12x40	2	RH	**240102** ●	
12	140	20	95	12x40	2	RH	**240103** ●	
14	130	50	75	14x50	3	RH	**240104** ●	
14	170	30	95	16x60	3	RH	**240108** ●	**240601** □
16	130	75		16x50	3	RH	**240105** ●	
16	170	50	105	16x55	3	RH	**240107** ●	**240600** □
16	170	30	95	16x60	3	RH	**240106** ●	
25	200	120		25x65	3	RH	**240300** ●	**240800** □

RPM: D 10-12 mm: n = 18000 - 24000 min^{-1}
D 14-18 mm: n = 12000 - 20000 min^{-1}

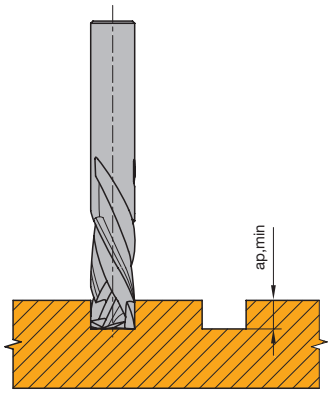
Note:
Set HSK-F 63 = tools marked with the note „Set HSK-F 63“ will be supplied mounted in shrink-fit chuck HSK-F 63.



Feed speed v_f depending on cutting depth a_p



Workpiece material: Softwood
Operation: Sizing
Speed: n = 18000 min^{-1}
Correction factor for v_f: Hardwood = 0.8; Chipboard = 1.2; Glulam = 0.9



Minimum grooving depth $a_{p\ min}$ for tear-free cut

Spiral roughing/finishing router cutter Marathon alternate twist

Application:
Routers for sizing and grooving in roughing/finishing quality and tear-free cutting edges on both sides.

Machine:
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, laminated veneer lumber (plywood, multiplex plywood etc.), plastomers, solid surface material (Corian, Varicor etc.).

Technical information:
Solid tungsten carbide. Marathon coating for increased performance time. Alternate twist for tear-free cut edges on both sides. Higher feed speeds possible than with conventional roughing cutters. Extremely smooth running.

Z 2+2
WO 160 2 16

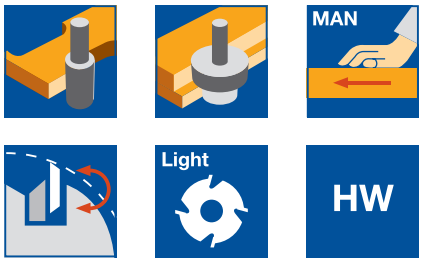
D mm	GL mm	NL mm	S mm	DRI	ID
16	100	40	16x50	RH	**240402** ●
16	110	55	16x50	RH	**240408** ●
20	120	45	20x50	RH	**240400** ●
20	140	75	20x50	RH	**240403** ●

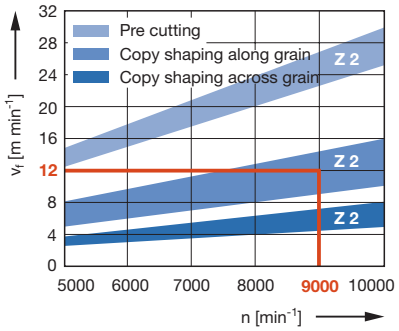
Z 2+2, Nesting types
WO 160 2 16

D mm	D in	GL mm	GL in	NL mm	NL in	S mm	S in	$a_{p\ min}$ mm	DRI	ID
12		80		25		12x40		6	RH	**240404** ●
12		90		35		12x40		12	RH	**240405** ●
12.7	1/2“	76.2	3“	25	1“	12,7x40	1/2“x1 1/2“	6	RH	**240406** ●
12.7	1/2“	88.9	3 1/2“	35	1 3/8“	12,7x40	1/2“x1 1/2“	12	RH	**240407** ●

RPM: n_{max} = 24000 min^{-1}

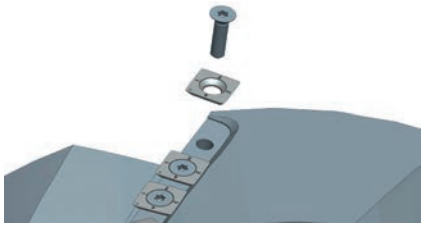
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





Feed speed v_f depending on the number of teeth Z and speed n for solid wood (pre trimming and copy shaping)
Example for tool diameter 125 mm:
n = 9000 min^{-1}
Z 2
Application: copy shaping along the grain
v_f = 12 m min^{-1}

Order example:
Tool set ID **132737** mounted on arbor ID **042951**, HSK-F 63 (A = 80 mm).
When giving the arbor ID observe the required clamping diameter.



Copy shaping cutterhead - HeliCut 15

Application:
For pre-cutting, jointing and copy shaping of large cutting depths, along and across to the fibre direction. For copy shaping of arched workpieces with template, ball bearing and guide ring, as well as for the application on CNC controlled stationary routers e.g. joinery machines, window manufacturing plants.

Machine:
Spindle moulders and profile milling machines, double-end tenoner, stationary routers with/without CNC control.

Workpiece material:
Softwood and hardwood, glulam and laminated wood.

Technical information:
Noise reduced design with staggered knives, applicable for MAN and MEC. Mountable on clamping arbor. Also applicable for rebating. Application of the same knives as peripheral knife and spur. The cutting edges of the HW knives are numbered. No clamping wedges, direct tangential knife clamping thus easy handling of the knife change without further setting gaugesd. By default mounted with HW turnblade knives ID **009543**.

Copy shaping cutterhead - HeliCut 15
SL 499 1, WW 230 2 07

Tool Type	ABM mm	QAL	AM PCS	Z	V	ID
Cutterhead	60x81,5x20	HW-MF	16	2	2	**132600** ●
Cutterhead mounted on arbor	1-part	HW	16	2	2	**132736** □
Cutterhead	80x81,5x30	HW-MF	16	2	2	**132608** ●
Cutterhead mounted on arbor	1-part	HW	16	2	2	**132737** □
Cutterhead	125x93,7x30	HW-MF	20	2	2+2	**132604** ●
Cutterhead mounted on arbor	1-part	HW	20	2	2+2	**132738** □
Cutterhead	125x116,6x30	HW-MF	24	2	2+2	**132605** ●
Cutterhead mounted on arbor	1-part	HW	24	2	2+2	**132739** □

RPM:
D 60 mm: n_{max} = 20000 min^{-1}
D 80 mm: n_{max} = 18000 min^{-1}
D 125 mm: n_{max} = 12000 min^{-1}

More dimensions on request.

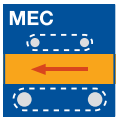
Spare knives:

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

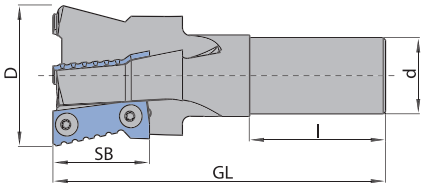
Spare parts:

BEZ	ABM mm	for D mm	ID
Countersink screw, Torx® 20	M5x12	60	**007898** ●
Countersink screw, Torx® 20	M5x14.2-8.8	80	**007394** ●
Countersink screw, Torx® 20	M5x18	125	**114030** ●
Torx® key	Torx® 20		**006091** ●

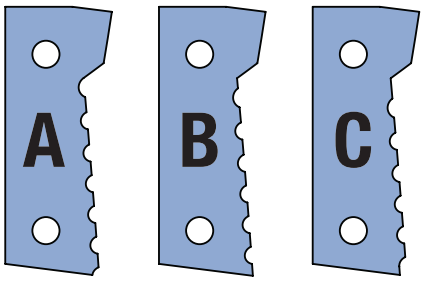
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



HW



Cylindrical shank design



Spare knives Marathon type A, B, C

Dovetail router cutter with exchangeable knives

Application:
For producing dovetail joints especially in the wood and frame construction.

Machine:
Stationary routers with/without CNC control, machining centres, joinery machines, special cutting machines to process frame parts.

Workpiece material:
Softwood and hardwood, glulam and laminted wood.

Technical information:
HW changing knives Z3 with Marathon coating for extremely high performance times. Chipbreakers in roughing/finishing design for small cutting forces and nearly even areas. One knife each of knife type „A“, „B“ and „C“ has to be mounted in the cutter.

With cylindrical shank, incl. knives SB = 38 mm
WG 502 2

D mm	GL mm	SB mm	S mm	DRI	Z	ID without adaptor
60	131	38/51	30x53,5	LH	3	**250000** ●
60	131	38/51	30x53,5	RH	3	**250001** ●

RPM: n = 6000 - 18000 min^{-1}

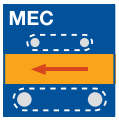
Spare knives:

Part-no.	BEZ	SB mm	Type	ID LH	ID RH
1	Marathon profile knife	38	A	**602517** ●	**602509** ●
1	Marathon profile knife	38	B	**602518** ●	**602510** ●
1	Marathon profile knife	38	C	**602519** ●	**602511** ●
1	Marathon profile knife	51	A	**602520** ●	**602512** ●
1	Marathon profile knife	51	B	**602521** ●	**602513** ●
1	Marathon profile knife	51	C	**602522** ●	**602514** ●

Spare parts:

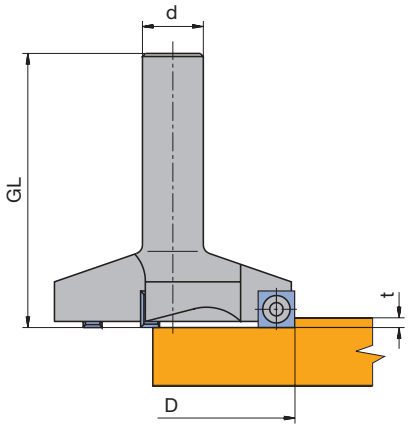
Part-no.	BEZ	ABM mm	ID
2	Oval head screw Torx® 15	M4x6	**006225** ●
3	Torx® key	Torx® 15	**005457** ●

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



HW

Example



t = 0.5 - 10 mm

Surface planing of MDF spoilboards in nesting applications:
t = 0.5 - 1.5 mm
ID **041557** n = 8400 min^{-1}
v_f = 25 - 40 m min^{-1}

Planing cutter - turnblade design HeliPlan

Application:
For surface planing of large workpieces and for cutting wide rebates in one operation.

Machine:
Stationary routers with/without CNC control, machining centres.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.).

Technical information:
Cutting edge with shear angle; reversible and replaceable knives. D 135 and D 180 particularly suitable for planing MDF spoilboards in nesting applications. Excellent cutting result through optimized cutting geometry.

HW, Z 3, Z 4, Z 5
WL 400 2 01

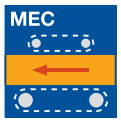
D mm	GL mm	NL mm	S mm	Z	n_{max} min^{-1}	DRI	ID
80	90	15	20x50	3	14,000	RH	**041554** ●
80	100	15	25x60	3	14,000	RH	**041555** ●
135	90	15	25x60	4	10,000	RH	**041556** ●
180	90	15	25x60	5	8,400	RH	**041557** ●

Spare knives:

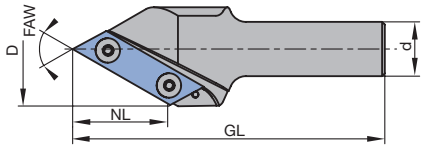
BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	15x15x2,5	HW	10	**009535** ●

Spare parts:

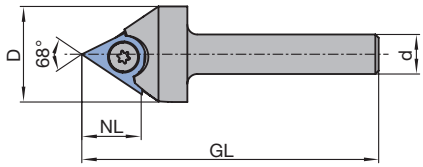
BEZ	ABM mm	ID
Countersink screw, Torx® 20	M5x9	**114049** ●
Torx® key	Torx® 20	**006091** ●



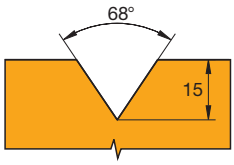
HW



V-groove cutter



V-groove cutter 68° (ID **042932**)



V-groove cutter in turnblade design with point 68° (ID **042932**)

Turnblade finishing cutter, Z 1

Application:
For machining V-groove profiles and for multi-purpose carving operations (decorative groove, 90° corner etc.).

Machine:
Stationary routers with/without CNC-control, milling machines with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

Technical information:
Cutterhead with exchangeable turnblades. 2 or 3 (ID **042932**) performance times through turning the knife. Extra long design (ID **042937**) particularly suitable for carving operations on 5-axes machines.

HW, Z 1
WL 300 2

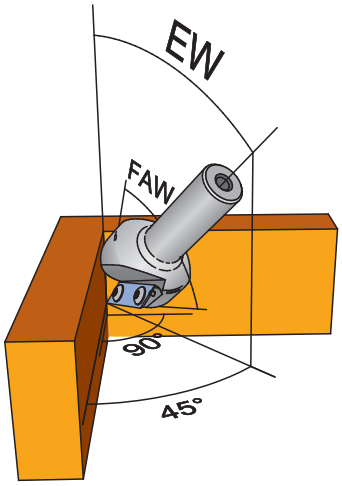
D mm	GL mm	NL mm	S mm	FAW °	Z	P	DRI	ID
29	90	18	12x58	68°	1	1	RH	**042932** ●
35	125	42	20x50	45°	1	2	RH	**042933** ●
42	115	35	20x50	60°	1	3	RH	**042934** ●
42	180	35	20x50	60°	1	3	RH	**042937** ●
54	100	27	20x50	90°	1	4	RH	**042935** ●
54	100	27	20x50	91°	1	5	RH	**042936** ●

Spare knives:

BEZ	ABM mm	P	QAL	ID
Turnblade knife triangular	19x19x2	1	HW	**009528** ●
Turnblade knife	59x12x1,5	2	HW	**602503** ●
Turnblade knife	49x12x1,5	3	HW	**602502** ●
Turnblade knife	39x12x1,5	4/5	HW	**602501** ●

Spare parts:

BEZ	ABM mm	P	ID
Countersink screw, Torx® 20	M5x5	1	**007445** ●
Oval head screw Torx® 15	M4x5	2-5	**007038** ●
Torx® key	Torx® 20	1	**117520** ●
Torx® key	Torx® 15	2-5	**005457** ●



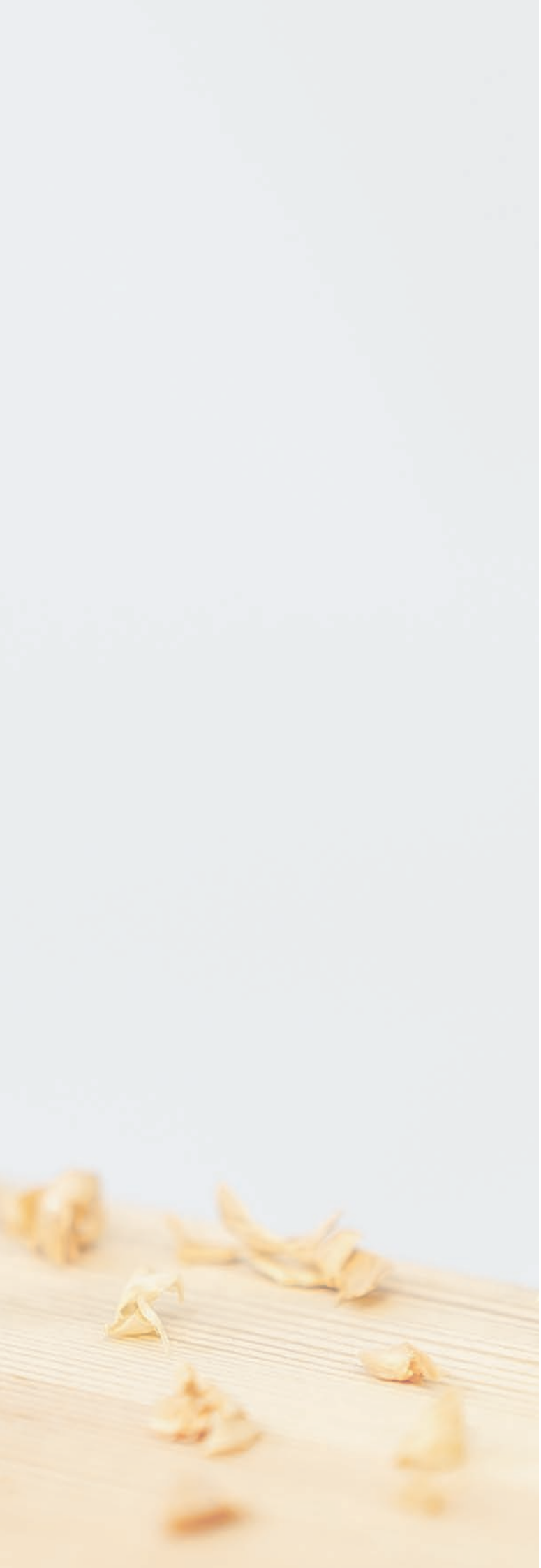
Determination of the adjustment angle EW depending on the bevel angle FAW while finish cutting 90° internal corners.

FAW		EW
45°	=	32.77°
60°	=	45.00°
68°	=	52.26°

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

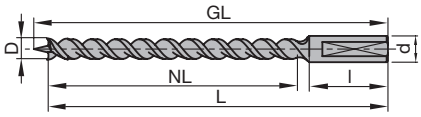
Drilling

Leitz tool programme for wood construction



Content chapter Drilling

HS



HS solid, Z 2 / V 2

Application:
For drilling very deep through holes without interim clearance strokes.

Machine:
Joinery machines, column drilling machines, drilling machines, multi spindle units, special purpose drilling machines, portable drills.

Workpiece material:
Softwood and hardwood.

Technical information:
Design in HS solid, Z 2 / V 2 with long centre point. Polished gullets for perfect chip removal. Extra-long centre point for use of the drills at an angle.

GL 235 mm
WB 120 0 34

D mm	GL mm	NL mm	S mm	QAL	DRI	ID
12	235	165	12x60	HS	RH	**230702** ●
14	235	165	14x60	HS	RH	**230703** ●
16	235	165	16x60	HS	RH	**230704** ●
18	235	165	16x60	HS	RH	**230705** ●
20	235	165	16x60	HS	RH	**230706** ●
22	235	165	16x60	HS	RH	**230707** ●
24	235	165	16x60	HS	RH	**230708** ●
26	235	165	16x60	HS	RH	**230709** ●
32	235	165	16x60	HS	RH	**230710** ●

GL 360 mm
WB 120 0 34

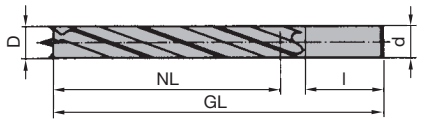
D mm	GL mm	NL mm	S mm	QAL	DRI	ID
12	360	290	12x60	HS	RL	**230713** ●
14	360	290	14x60	HS	RL	**230714** ●
16	360	290	16x60	HS	RL	**230715** ●
18	360	290	16x60	HS	RL	**230716** ●
20	360	290	16x60	HS	RL	**230717** ●
22	360	290	16x60	HS	RL	**230718** ●
24	360	290	16x60	HS	RL	**230719** ●
26	360	290	16x60	HS	RL	**230720** ●
32	360	290	16x60	HS	RL	**230721** ●

GL 460 mm
WB 120 0 34

D mm	GL mm	NL mm	S mm	QAL	DRI	ID
12	460	390	12x60	HS	RL	**230724** ●
14	460	390	14x60	HS	RL	**230725** ●
16	460	390	16x60	HS	RL	**230726** ●
18	460	390	16x60	HS	RL	**230727** ●
20	460	390	16x60	HS	RL	**230728** ●
22	460	390	16x60	HS	RL	**230729** ●
24	460	390	16x60	HS	RL	**230730** ●
26	460	390	16x60	HS	RL	**230731** ●
32	460	390	16x60	HS	RL	**230732** ●

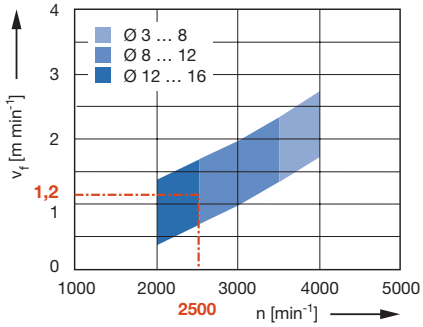
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

HS



WB 120 0 02/05, with single heel

Feed speed v_f depending on the spindle RPM n



Workpiece material:
Softwood
Operation:
Drilling
Correction factor for v_f:
Hardwood = 0.7

HS solid, Z 2 / V 2

Application:
For multi-purpose drilling of tear-free blind holes.

Machine:
Column drilling machines, drilling machines, multi spindle units, special purpose drilling machines, portable drills.

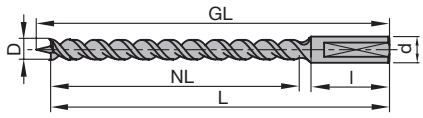
Workpiece material:
Softwood and hardwood, laminated veneer lumber (plywood, multiplex plywood etc.), plastics (thermoplastic).

Technical information:
Design in HS solid with long centre point and round spurs. Shank diameter identical to drill diameter. Design with single heel to reduce friction in the hole.

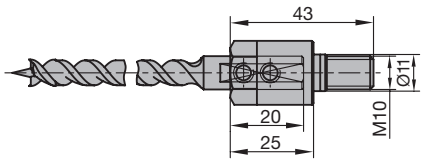
Shank diameter identical to drill diameter
WB 120 0 05

D mm	GL mm	NL mm	S mm	QAL	DRI	ID
3	70	35	3x30	HS	RH	**035852** ●
4	80	45	4x30	HS	RH	**035853** ●
4.5	85	50	4,5x30	HS	RH	**035892** ●
5	90	50	5x30	HS	RH	**035854** ●
5.5	95	55	5,5x35	HS	RH	**035893** ●
6	100	60	6x35	HS	RH	**035855** ●
6.5	105	65	6,5x35	HS	RH	**035894** ●
7	110	65	7x40	HS	RH	**035856** ●
7.5	115	70	7,5x40	HS	RH	**035895** ●
8	120	75	8x40	HS	RH	**035857** ●
10	140	85	10x50	HS	RH	**035859** ●
12	155	95	12x50	HS	RH	**035861** ●

RPM: n = 1500 - 4000 min^{-1}

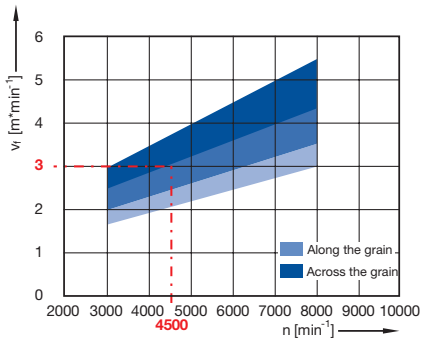


WB 120 0 34, solid tungsten carbide drill



WB 120 0 34, solid tungsten carbide drill with adaptor

Feed speed v_f depending on the spindle RPM n



HW solid, Z 2 / V 2, Marathon

Application:
For drilling very deep holes without interim clearance strokes. Particularly suitable for drilling connection and dowel holes in timber frame and window construction.

Machine:
Stationary routers with/without CNC control, machining centres, special cutting machines to machine frame parts, column drilling machines, drilling machines, multi spindle units, portable drills.

Workpiece material:
Softwood and hardwood, modified timber for window construction, laminated veneer lumber (plywood, multiplex etc.), glued lumber.

Technical information:
Design in solid tungsten carbide, Z 2/V 2 and centre point. Marathon coating for increased performance time. Extra-long centre point for use of the drills at an angle. Very large gullets for perfect chip removal particularly when drilling in end grain. Shank design with reduced clamping area for good centering in shrink and collet chucks.

GL 105 mm
WB 120 0 34

D mm	GL mm	L mm	NL mm	S mm	DRI	ID with adaptor	ID without adaptor
3	105	102	70	10x25	RH	**230121** □	**230021** ●
3.5	105	102	70	10x25	RH	**230122** □	**230022** ●
4.5	105	101	70	10x25	RH	**230123** □	**230023** ●
6	105	100.5	70	10x25	RH	**230108** □	**230008** ●
6	105	100.5	70	10x25	LH	**230109** □	**230009** ●
8	105	99.5	70	10x25	RH	**230110** □	**230010** ●
8	105	99.5	70	10x25	LH	**230111** □	**230011** ●
10	105	98.5	70	10x25	RH	**230112** □	**230012** ●
10	105	98.5	70	10x25	LH	**230113** □	**230013** ●
12	105	97.5	70	10x25	RH	**230114** □	**230014** ●
12	105	97.5	70	10x25	LH	**230115** □	**230015** ●

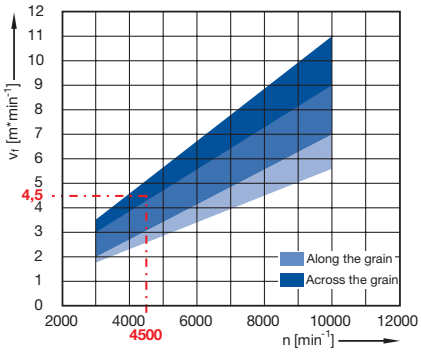
GL 130 mm
WB 120 0 34

D mm	GL mm	L mm	NL mm	S mm	DRI	ID with adaptor	ID without adaptor
6	130	125.5	90	10x30	RH	**230100** □	**230000** ●
6	130	125.5	90	10x30	LH	**230101** □	**230001** ●
6.5	130	125.5	90	10x30	RH	**230120** □	**230020** ●
8	130	124.5	90	10x30	RH	**230102** □	**230002** ●
8	130	124.5	90	10x30	LH	**230103** □	**230003** ●
10	130	123.5	90	10x30	RH	**230104** □	**230004** ●
10	130	123.5	90	10x30	LH	**230105** □	**230005** ●
12	130	122.5	90	10x30	RH	**230106** □	**230006** ●
12	130	122.5	90	10x30	LH	**230107** □	**230007** ●

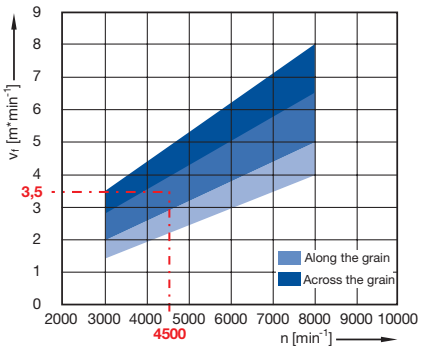
Diameter:
D ≤ 6 mm
Workpiece material:
Softwood
Operation:
Drilling
Correction factor for v_f:
Hardwood = 0.8
Laminated veneer lumber = 1.2

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

Feed speed v_f depending on the spindle RPM n



Diameter:
D = 6 - 12 mm
Workpiece material:
Softwood
Operation:
Drilling
Correction factor for v_f:
Hardwood = 0.8
Laminated veneer lumber = 1.2



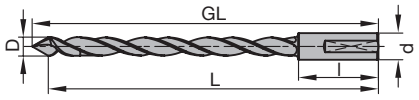
Diameter:
D > 12 mm
Workpiece material:
Softwood
Operation:
Drilling
Correction factor for v_f:
Hardwood = 0.8
Laminated veneer lumber = 1.2

GL 150 mm
WB 120 0 34

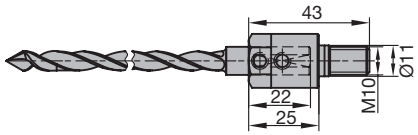
D mm	GL mm	L mm	NL mm	S mm	DRI	ID with adaptor	ID without adaptor
14	150	140.5	100	10x30	RH	**230116** □	**230016** ●
16	150	140	100	10x30	RH	**230118** □	**230018** ●

RPM: n = 3000 - 9000 min^{-1}

HW

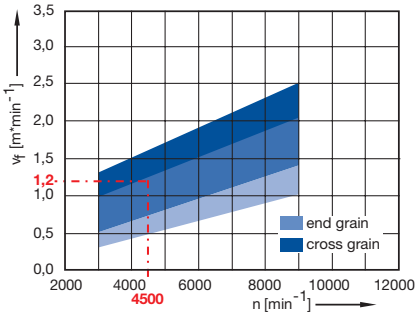


WB 101 0 13, twist drill with V-point



WB 101 0 13, twist drill with V-point, with adaptor

Feed speed v_f depending on the spindle RPM n



Workpiece material:
Softwood
Operation:
Drilling
Correction factor for v_f:
Hardwood = 0.8
Laminated veneer lumber = 1.1

HW solid, Z 2, V-point

Application:
For drilling deep holes. Particularly for timber frame and window construction.

Machine:
Stationary routers with/without CNC control, machining centres, special cutting machines to machine frame parts, column drilling machines, drilling machines, multi spindle units, portable drills.

Workpiece material:
Softwood and hardwood, modified timber for window construction, laminated veneer lumber (plywood, multiplex etc.), glued lumber.

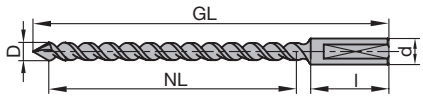
Technical information:
Solid tungsten carbide design, Z 2 with V-point. Design with double heel for improved guidance while drilling and return stroke from the hole. Shank design with reduced clamping area for good centering in shrink and collet chucks.

GL 130 / 160 mm
WB 101 0 13

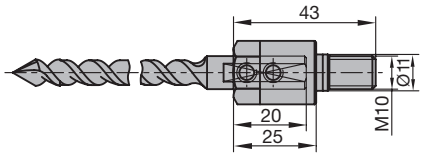
D mm	GL mm	NL mm	S mm	QAL	DRI	ID with adaptor	ID without adaptor
7	130	90	10x30	HW solid	RH	**230451** □	**230351** ●
8	160	120	10x30	HW solid	RH	**230455** □	**230355** ●
9	160	120	10x30	HW solid	RH	**230452** □	**230352** ●
10	160	120	10x30	HW solid	RH	**230453** □	**230353** ●
12	160	120	10x30	HW solid	RH	**230454** □	**230354** ●

RPM: n = 3000 - 9000 min^{-1}

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

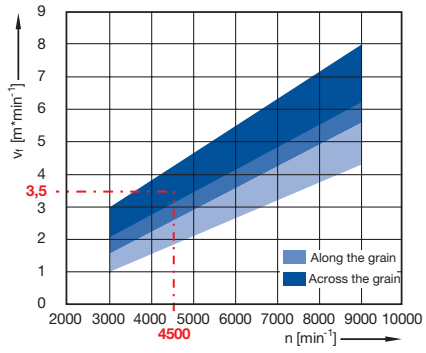


WB 101 0 12,
twist drill with V-point



WB 101 0 12,
twist drill with V-point, with adaptor

Feed speed v_f depending on the spindle RPM n



HW solid, Z 2, V-point, Marathon

Application:
For drilling very deep holes without interim clearance strokes at high feed speed particularly for timber frame and window construction.

Machine:
Stationary routers with/without CNC control, machining centres, special cutting machines to machine frame parts, column drilling machines, drilling machines, multi spindle units, portable drills.

Workpiece material:
Softwood and hardwood, modified timber for window construction, laminated veneer lumber (plywood, multiplex etc.), glued lumber.

Technical information:
Solid tungsten carbide design, Z 2 with V-point. Marathon coating for increased performance time. Very large gullets for perfect chip removal. Shank design with reduced clamping area for good centering in shrink and collet chucks.

GL 130 / 160 mm
WB 101 0 12

D mm	GL mm	NL mm	S mm	DRI	ID with adaptor	ID without adaptor
6	130	90	10x30	RH	**230400** □	**230300** ●
7	130	90	10x30	RH	**230401** □	**230301** ●
8	160	120	10x30	RH	**230405** □	**230305** ●
9	160	120	10x30	RH	**230402** □	**230302** ●
10	160	120	10x30	RH	**230403** □	**230303** ●
12	160	120	10x30	RH	**230404** □	**230304** ●

RPM: n = 3000 - 9000 min^{-1}

Diameter:
D = 6 - 12 mm
Workpiece material:
Softwood
Operation:
Drilling, through hole
Correction factor for v_f:
Hardwood = 0.8
Laminated veneer lumber = 1.2

SP, Z 1 / V 1, threaded tip

Application:
For drilling constructions and joint boreholes especially in the wood and frame construction.

Machine:
Stationary routers with/without CNC control, machining centres, joinery machines, special cutting machines to machine frame parts, column drilling machines, drilling machines, boring aggregates, portable drills.

Workpiece material:
Softwood, glued wood. Limitedly suitable for hardwood.

Technical information:
Z 1 / V 1 design with threaded tip. Threaded tip for easy boring especially when using portable machines. Extremely large gullet areas for excellent chipflow. Hexagon shank from D=8 mm on for excellent transmission of the torque.

GL 235 mm
WB 110 0

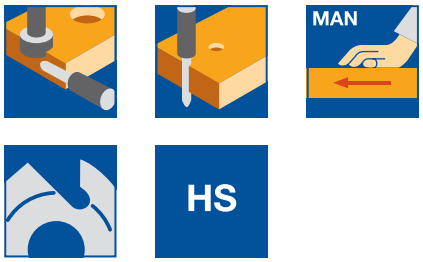
D mm	GL mm	NL mm	S mm	DRI	ID
6	235	160	5.5	RH	**230517** ●
7	235	160	6.5	RH	**230518** ●
8	235	160	7.5	RH	**230519** ●
10	235	160	9.5	RH	**230520** ●
11	235	160	10.5	RH	**230521** ●
12	235	160	11.5	RH	**230522** ●
14	235	160	13	RH	**230523** ●
16	235	160	13	RH	**230524** ●
18	235	160	13	RH	**230525** ●
20	235	160	13	RH	**230526** ●
22	235	160	13	RH	**230527** ●
24	235	160	13	RH	**230528** ●
25	235	160	13	RH	**230529** ●
26	235	160	13	RH	**230530** ●
28	235	160	13	RH	**230531** ●
30	235	160	13	RH	**230532** ●
32	235	160	13	RH	**230533** ●

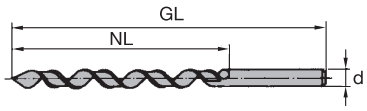
GL 460 mm
WB 110 0

D mm	GL mm	NL mm	S mm	DRI	ID
6	460	400	5.5	RH	**230511** ●
7	460	400	6.5	RH	**230512** ●
8	460	400	7.5	RH	**230513** ●
10	460	400	9.5	RH	**230514** ●
11	460	400	10.5	RH	**230515** ●
12	460	400	11.5	RH	**230500** ●
14	460	400	13	RH	**230501** ●
16	460	400	13	RH	**230502** ●
18	460	400	13	RH	**230503** ●
20	460	400	13	RH	**230504** ●
22	460	400	13	RH	**230505** ●
24	460	400	13	RH	**230506** ●
25	460	400	13	RH	**230507** ●
26	460	400	13	RH	**230508** ●
28	460	400	13	RH	**230509** ●
30	460	400	13	RH	**230510** ●
32	460	400	13	RH	**230516** ●

RPM: n = 500 - 3000 min^{-1}

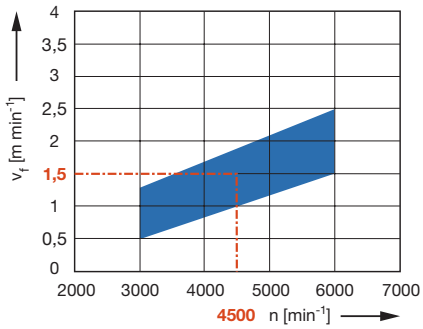
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





WB 100 0, with V-point

Feed speed v_f depending on the spindle RPM n



Workpiece material:
Solid wood
Operation:
Drilling
Correction factor for v_f:
Drilling depth > 4 x D = 0.8

HS solid, Z 1

Application:
For drilling deep holes. Suitable for depths up to approx. 4 x D without interim clearance strokes.

Machine:
Column drilling machines, drilling machines, multi spindle units, special purpose drilling machines, portable drills.

Workpiece material:
Softwood and hardwood.

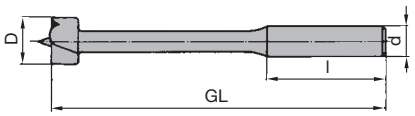
Technical information:
Solid HS design, Z 1. V-point for producing tear-free holes on both sides when drilling through holes. Very large gullets for perfect chip removal particularly when drilling in end grain.

V-point for through hole drilling
WB 100 0

D mm	GL mm	NL mm	S mm	QAL	Z	DRI	ID
5	90	50	5x35	HS	1	RH	**036110** ●
6	100	60	6x35	HS	1	RH	**036111** ●
8	120	80	8x40	HS	1	RH	**036112** ●
10	120	80	10x40	HS	1	RH	**036113** ●
12	140	100	12x40	HS	1	RH	**036114** ●

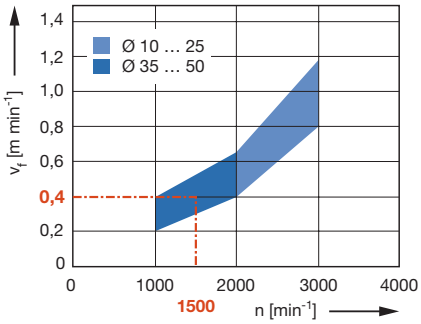
RPM: n = 3000 - 6000 min^{-1}

SP



WB 310 0 02, reinforced shank 13/16 mm

Feed speed v_f depending on the spindle RPM n



Workpiece material:
Softwood
Operation:
Drilling

SP, Z 2 / V 2

Application:
For drilling hinge holes, particularly in furniture construction and for fittings in timber construction.

Machine:
Column drilling machines, special purpose drilling machines, portable drills.

Workpiece material:
Softwood.

Technical information:
SP solid, Z 2/V 2. Shank 10 mm suitable for stationary boring machines and portable drills.

Shank 10 mm
WB 310 0 03

D mm	GL mm	S mm	DRI	ID
15	90	10x55	RH	**036650** ●
20	90	10x55	RH	**036655** ●
25	90	10x70	RH	**036658** ●
30	90	10x70	RH	**036661** ●
35	90	10x65	RH	**036664** ●
40	90	10x65	RH	**036667** ●

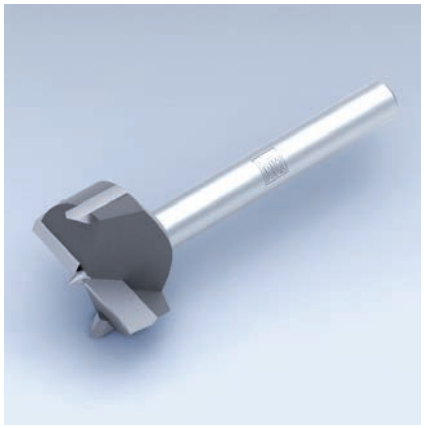
Technical information:
SP solid, Z 2/V 2. Reinforced shank for heavy machining in column drilling machines and powerful portable drills.

Shank 13 / 16 mm, reinforced design
WB 310 0 02

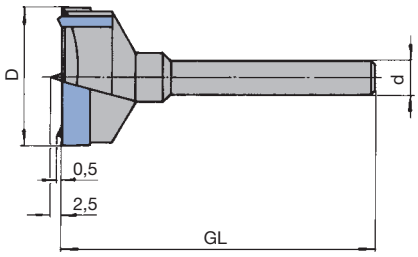
D mm	GL mm	S mm	DRI	ID
10	120	13x50	RH	**036421** ●
12	120	13x50	RH	**036422** ●
15	140	13x50	RH	**036424** ●
20	140	13x50	RH	**036427** ●
25	140	13x50	RH	**036430** ●
30	140	13x50	RH	**036433** ●
35	140	16x50	RH	**036436** ●

RPM: n = 1000 - 3000 min^{-1}

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

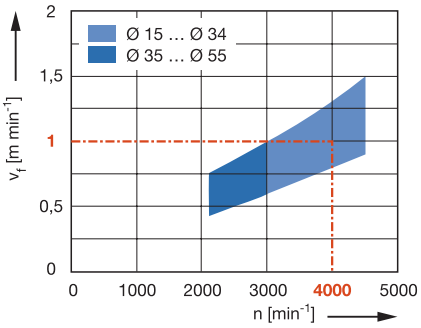


HW



WB 310 0 03, shank 10 mm,
GL = 90 mm

Feed speed v_f depending on the spindle RPM n



Workpiece material:
Hardwood
Operation:
Drilling
Correction factor for v_f:
Chipboard = 1.2
Laminated veneer lumber = 1.1

HW, Z 2 / V 2

Application:
For drilling hinge holes, particularly in furniture construction.

Machine:
Column drilling machines, drilling machines, special purpose drilling machines, portable drills.

Workpiece material:
Softwood and hardwood.

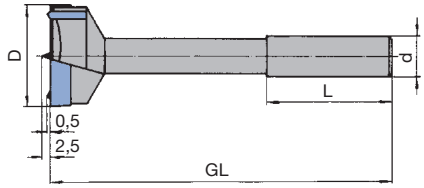
Technical information:
Tungsten carbide design, Z 2/V 2. Shank 10 mm suitable for stationary drilling machines and portable drills.

Shank 10 mm
WB 310 0 03

D mm	GL mm	S mm	DRI	ID
15	90	10x55	RH	**036668** ●
16	90	10x55	RH	**036669** ●
17	90	10x55	RH	**036670** ●
18	90	10x55	RH	**036671** ●
19	90	10x55	RH	**036672** ●
20	90	10x55	RH	**036673** ●
22	90	10x55	RH	**036674** ●
24	90	10x70	RH	**036676** ●
25	90	10x70	RH	**036677** ●
26	90	10x70	RH	**036678** ●
28	90	10x70	RH	**036679** ●
30	90	10x70	RH	**036680** ●
34	90	10x65	RH	**036682** ●
35	90	10x65	RH	**036683** ●
40	90	10x65	RH	**036686** ●

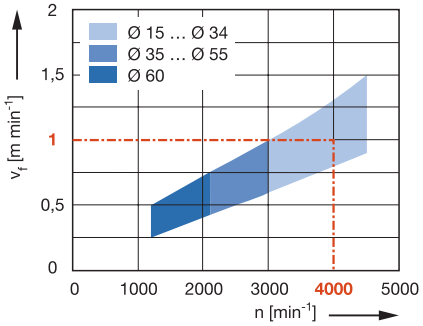
RPM: n = 1200 - 4500 min^{-1}

HW



Tungsten carbide tipping with large resharpening area

Feed speed v_f depending on the spindle RPM n



Workpiece material:
Hardwood
Operation:
Drilling
Correction factor for v_f:
Chipboard = 1.2
Laminated veneer lumber = 1.1

HW, Z 2 / V 2

Application:
For drilling hinge holes, particularly in furniture construction.

Machine:
Column drilling machines, drilling machines, special purpose drilling machines, portable drills.

Workpiece material:
Softwood and hardwood.

Technical information:
Tungsten carbide design, Z 2/V 2. Reinforced shank for heavy machining in column drilling machines and powerful portable drills.

Shank 13 / 16 mm, reinforced design
WB 310 0 02

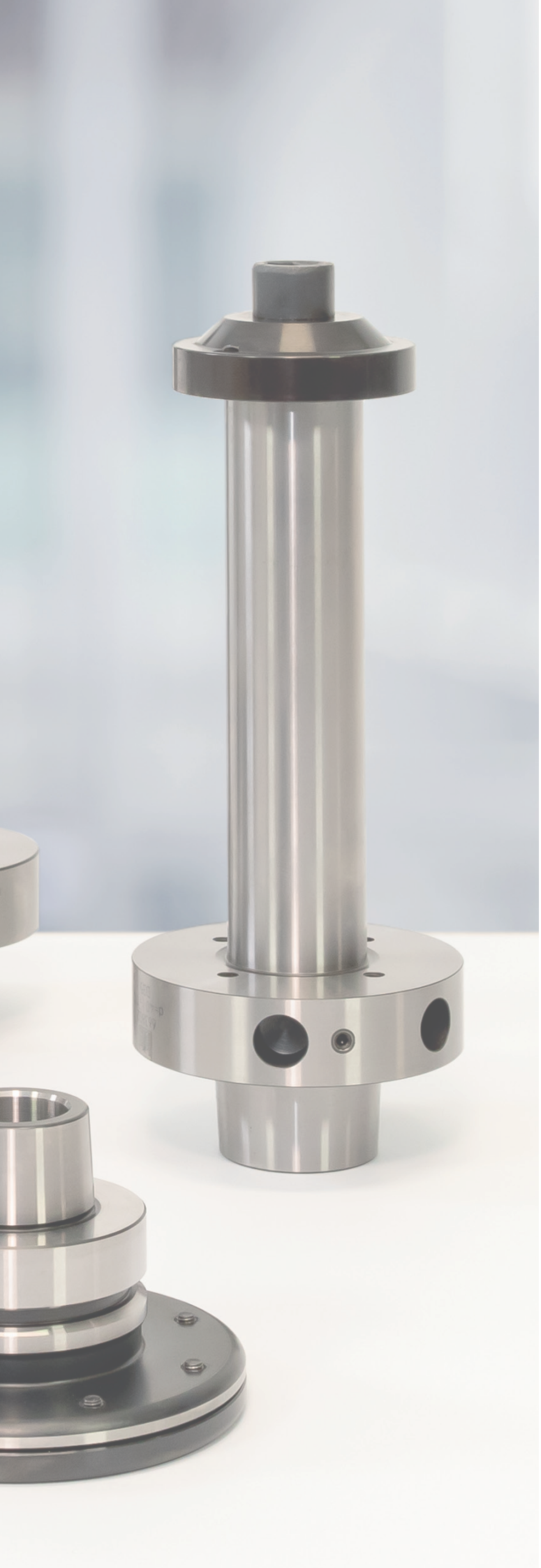
D	GL	S	DRI	ID
mm	mm	mm		
20	140	13x50	RH	**036462** ●
22	140	13x50	RH	**036463** ●
25	140	13x50	RH	**036465** ●
30	140	13x50	RH	**036468** ●
35	140	16x50	RH	**036471** ●
40	140	16x50	RH	**036474** ●
50	150	16x50	RH	**036480** ●
55	150	16x50	RH	**036483** ●
60	150	16x50	RH	**036486** ●

RPM: n = 1200 - 4500 min^{-1}

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

Clamping systems

Leitz tool programme for wood construction



Content chapter
Clamping systems

High requirements on joinery machines

Due to the machining tasks on the workpiece, tools with above-average diameters are used on joinery systems. Due to the high weight of the tools, large chip removal and cutting forces as well as swiveling movements at full speed, the interface between machine and tool has to cope with enormous forces. Leitz offers the right clamping system for the individual machining situation, which meets the high requirements and optimally transfers the performance of the machine to the tool.

Cutting arbors

- Adjusted to machine, tool, machining task on the workpiece and application data
- Designed for maximum speed taking into account tool weight, overhang length and load during machining

Collet chuck

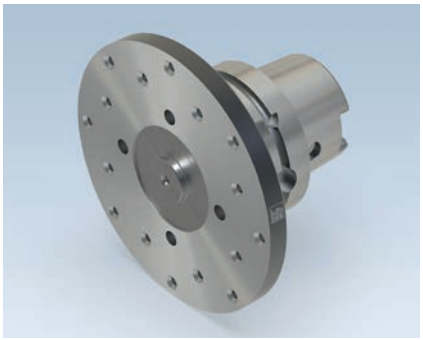
- Very versatile and flexible use by changing to different clamping diameters with different collets
- Low requirements for shank tolerances of the tool
- High economic efficiency

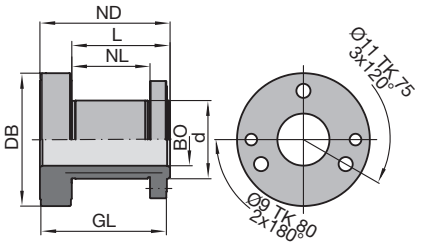
Shrink fit chuck

- Highest accuracy, almost like monolythic tools
- High cost-effectiveness, as the adaptor can be used multiple times
- For maximum tool life and highest cutting speed
- High stability and rigidity
- Perfect for high speed

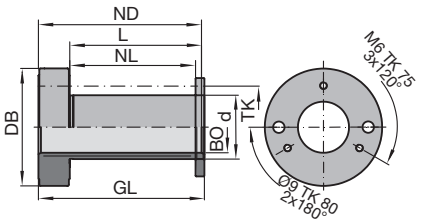
Saw flanges

- Adjusted to the respective sawblade and the operating conditions
- Large forces must be absorbed due to pivoting movements of large and heavy sawblades in speed
- Ideal contact surface for perfect axial runout
- Secure fastening of the main blade
- Guarantee of maximum possible cutting depths

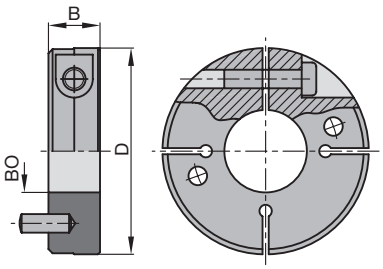




Hydro-Duo clamping element
PH 130 0 01 with clamping nut



Hydro-Duo clamping element
PH 130 0 02 with end ring and
clamping screws



Clamping collar without thread

For spindle without safety device against twisting

Application:
Clamping sleeve for centric, play-free clamping of tools and cutterheads.

Machine:
Machines with high precision spindles e.g. moulders etc.

Technical information:
Hydro-Duo open clamping system, activation of hydro clamping by a grease gun.
Suitable for right and left hand rotation.

With clamping nut
PH 130 0 01

d	BO	NL	L	GL	ND	DB	ID
mm	mm	mm	mm	mm	mm	mm	
60	40	60	75	100	100	102	**030503** ●
60	45	60	75	100	100	102	**030505**
60	50	60	75	100	100	102	**030507** ●
60	50	40	55	80	80	102	**030515** ●

Spare parts:

BEZ	ABM mm	ID
Sickle spanner adjustable	D90/155; L290; DIN1816; tenon 6	**005462** ●
Grease gun		**008239** ●
Grease cartridge	for Hydro sleeve	**007934** ●
Grease nipple	M10x1	**007935** ●

With end ring and clamping screws
PH 130 0 02

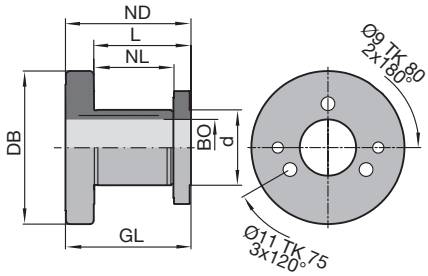
d	BO	NL	L	GL	ND	DB	TK	ID
mm	mm	mm	mm	mm	mm	mm	mm	
50	40	98	105	130	100	92	65	**030600** ●
60	45	28	35	59.5	59.5	102	75	**030605**
60	50	98	105	130	130	102	75	**030602** ●

Spare parts:

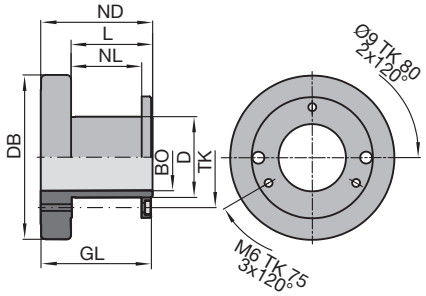
BEZ	ABM mm	ID
Allen key	SW 5	**005452** ●
Grease gun		**008239** ●
Grease cartridge	for Hydro sleeve	**007934** ●
Grease nipple	M10x1	**007935** ●
Cylindrical screw with ISK	M6x70	**005936** ●
Cylindrical screw with ISK	M6x120	**005942** ●

Clamping collars without thread
TD 870 0

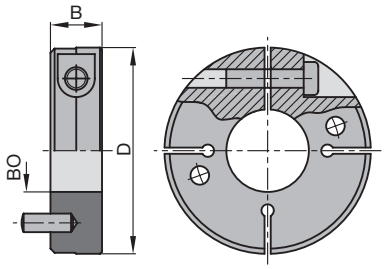
D	B	BO	ID
mm	mm	mm	
100	25	40	**030700** ●
100	25	45	**030701** ●
100	25	50	**030702** ●



Hydro-Duo clamping element
PH 130 0 05 with clamping nut



Hydro-Duo clamping element
PH 130 0 06 with end ring and clamping screws



Clamping collar without thread

For spindle without safety device against twisting

Application:
Clamping sleeve for centric clamping of tools, tool sets and cutterheads.

Machine:
Machines with high precision spindles, e.g. moulders, double-end tenoners, edgebanding machines, window production machines etc.

Technical information:
Hydro-Duo closed hydro clamping system, activation of hydro clamping by internal clamping system without grease gun. Suitable for right and left hand rotation.

With clamping nut
PH 130 0 05

d mm	BO mm	NL mm	L mm	GL mm	ND mm	DB mm	ID
60	45	63	77	100	100	122	**031603**
60	50	63	77	100	100	122	**031601** ●
70	60	43	57	80	80	130	**031605**

Spare parts:

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

With end ring and clamping screws
PH 130 0 06

d mm	BO mm	NL mm	L mm	GL mm	ND mm	DB mm	TK mm	ID
60	50	52	60	83	83	122	75	**031650** ●

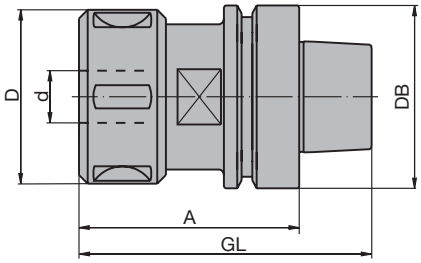
Spare parts:

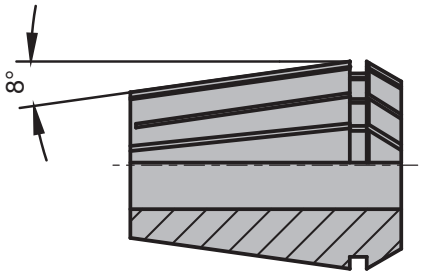
BEZ	ABM mm	ID
Allen key	SW 5	**005452** ●
Cylindrical screw with ISK	M6x70	**005936** ●

Clamping collars without thread
TD 870 0

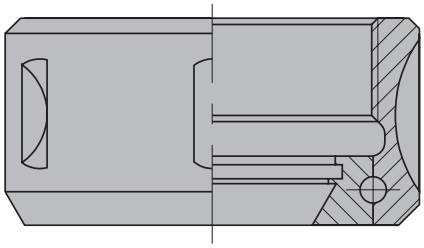
D mm	B mm	BO mm	ID
100	25	45	**030701** ●
100	25	50	**030702** ●

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





Collet angle 8°: DIN ISO 15488



Ball bearing collet nut

Chollet chuck with hollow taper shank HSK-F 80

Application:
Precision tool chuck with collet for clamping shank tools with cylindrical shank and shank diameters up to d_{max} = 30 mm (1“).

Technical information:
Hollow taper shank as per DIN 69893. Exact concentric running through hardened, ground and double slotted collets. Easy handling as loosening the ball bearing collet nut automatically opens the collet. Suitable for right hand and left hand rotation because of ball bearing collet nut. Ball bearing collet nut for increased clamping forces and improved concentricity compared to monobloc design. Tool chuck and collet nut fine balanced. Suitable mounting device VN 799 0 see section Knives and Spare Parts.

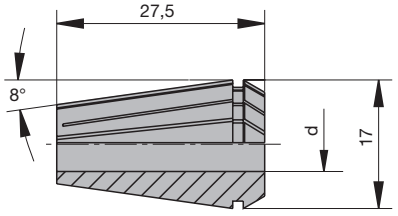
HSK-F 80, DIN 69893, A = 78 mm, diameter range 6-30 mm, short design, 8° taper angle of the collet
PM 350 0 15

d mm	D mm	DB mm	A mm	GL mm	Weight kg	ID
6 - 30	63	80	78	110	1.6	**679044** ●

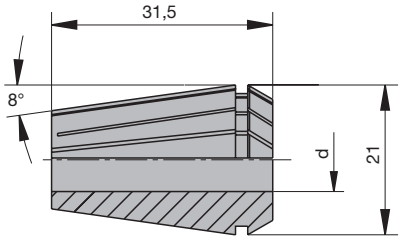
Sales unit consisting of clamping chuck with ball bearing collet nut, without collet or spanner.

Spare parts:

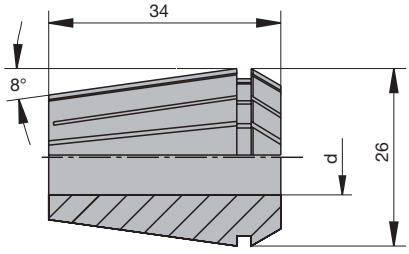
BEZ	ABM mm	for S mm	ID
Collet (8°)		6	**037926** ●
Collet (8°)		8	**037927** ●
Collet (8°)		10	**037928** ●
Collet (8°)		12	**037929** ●
Collet (8°)		14	**037930** ●
Collet (8°)		16	**037931** ●
Collet (8°)		20	**037932** ●
Collet (8°)		25	**037933** ●
Collet (8°)		30	**679039** ●
Collet (8°)		6,35 (1/4“)	**037934** ●
Collet (8°)		9,53 (3/8“)	**037935** ●
Collet (8°)		12,7 (1/2“)	**037936** ●
Collet (8°)		15,88 (5/8“)	**037937** ●
Collet (8°)		19,05 (3/4“)	**037938** ●
Collet (8°)		25,4 (1“)	**037939** ●
Sickle spanner	58/62		**005458** ●
Collet chuck nut with ball bearing	M50x1.5		**006639** ●
Chip-Balluff	511 Bytes		**081309** ●
Chip-Balluf	2047 Bytes		**081330** □



ER 16 collet diamater range 6-10 mm



ER 20 collet diamater range 6-13 mm



ER 25 collet diamater range 6-16 mm

Collets, type ER, DIN ISO 15488

Application:
For collet chucks and multi spindle units and trimming units with 8° taper angle (type ER, DIN ISO 15488).

Technical information:
Double slotted design for maximum clamping forces and concentricity.

Diamater range 6-10 mm, ER 16, Type 426E, DIN ISO 15488
PM 150 0

BEZ	for S mm	d mm	D mm	GL mm	ID
Collet (8°)	6	5,5 - 6	17	27.5	**037972** ●
Collet (8°)	8	7,5 - 8	17	27.5	**037973** ●
Collet (8°)	10	9,5 - 10	17	27.5	**037974** ●
Collet (8°)	6,35 (1/4“)	5,85 - 6,35	17	27.5	**679022** ●
Collet (8°)	9,53 (3/8“)	9,03 - 9,53	17	27.5	**679023** ●

Spare parts:

BEZ	ABM mm	D mm	Diameter range mm	DRI	ID
Sickle spanner	30/32		6 - 10		**005516** ●
Collet chuck nut with ball bearing	M22x1.5	32	6 - 10	RH	**006645** ●

Diamater range 6-13 mm, ER 20, Type 428E, DIN ISO 15488
PM 150 0

BEZ	for S mm	d mm	D mm	GL mm	ID
Collet (8°)	6	5,5 - 6	21	31.5	**037975** ●
Collet (8°)	8	7,5 - 8	21	31.5	**037976** ●
Collet (8°)	10	9,5 - 10	21	31.5	**037977** ●
Collet (8°)	12	11,5 - 12	21	31.5	**037978** ●
Collet (8°)	6,35 (1/4“)	5,85 - 6,35	21	31.5	**679024** ●
Collet (8°)	9,53 (3/8“)	9,03 - 9,53	21	31.5	**679025** ●
Collet (8°)	12,7 (1/2“)	12,2 - 12,7	21	31.5	**679026** ●

Spare parts:

BEZ	ABM mm	D mm	Diameter range mm	DRI	ID
Sickle spanner	34/36		6 - 12,7		**005498** ●
Collet chuck nut with ball bearing	M25x1.5	35	6 - 13	RH	**006647** ●

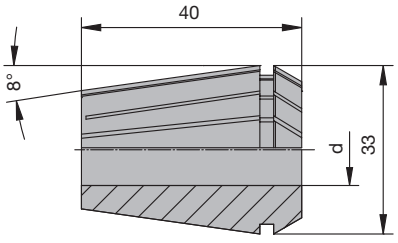
Diamater range 6-16 mm, ER 25, Type 430E, DIN ISO 15488
PM 150 0

BEZ	for S mm	d mm	D mm	GL mm	ID
Collet (8°)	6	5,5 - 6	26	34	**037979** ●
Collet (8°)	8	7,5 - 8	26	34	**037980** ●
Collet (8°)	10	9,5 - 10	26	34	**037981** ●
Collet (8°)	12	11,5 - 12	26	34	**037982** ●
Collet (8°)	14	13,5 - 14	26	34	**037983** ●
Collet (8°)	16	15,5 - 16	26	34	**037984** ●
Collet (8°)	6,35 (1/4“)	5,85 - 6,35	26	34	**679027** ●
Collet (8°)	9,53 (3/8“)	9,03 - 9,53	26	34	**679028** ●
Collet (8°)	12,7 (1/2“)	12,2 - 12,7	26	34	**679029** ●
Collet (8°)	15,88 (5/8“)	15,38 - 15,88	26	34	**679030** ●

Spare parts:

BEZ	ABM mm	D mm	Diameter range mm	DRI	ID
Sickle spanner	40/42		6 - 16		**005518** ●
Collet chuck nut with ball bearing	M32x1.5	42	6 - 16	RH	**006649** ●

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



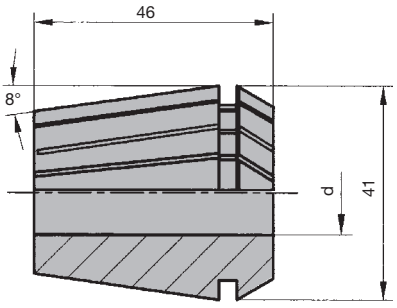
ER 32 collet diamater range 6-20 mm

Diamater range 6-20 mm, ER 32, Type 470E, DIN ISO 15488
PM 150 0

BEZ	for S mm	d mm	D mm	GL mm	ID
Collet (8°)	6	5,5 - 6	33	40	**037439** ●
Collet (8°)	8	7,5 - 8	33	40	**037440** ●
Collet (8°)	10	9,5 - 10	33	40	**037441** ●
Collet (8°)	12	11,5 - 12	33	40	**037442** ●
Collet (8°)	13	12,5 - 13	33	40	**037443** ●
Collet (8°)	14	13,5 - 14	33	40	**037444** ●
Collet (8°)	16	15,5 - 16	33	40	**037445** ●
Collet (8°)	18	17,5 - 18	33	40	**037446** ●
Collet (8°)	20	19,5 - 20	33	40	**037447** ●
Collet (8°)	6,35 (1/4“)	5,85 - 6,35	33	40	**037509** ●
Collet (8°)	9,53 (3/8“)	9,03 - 9,53	33	40	**037510** ●
Collet (8°)	12,7 (1/2“)	12,2 - 12,7	33	40	**037511** ●
Collet (8°)	15,88 (5/8“)	15,38 - 15,88	33	40	**037507** ●
Collet (8°)	19,05 (3/4“)	18,55 - 19,05	33	40	**037506** ●

Spare parts:

BEZ	ABM mm	D mm	Diameter range mm	DRI	ID
Sickle spanner	45/50				**005491** ●
Collet chuck nut with ball bearing	M40x1.5	50	6 - 20	RH	**005718** ●



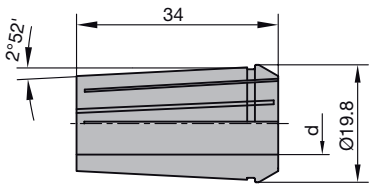
ER 40 collet diamater range 6-26 mm

Diamater range 6-26 mm, ER 40, Type 472E, DIN ISO 15488
PM 150 0

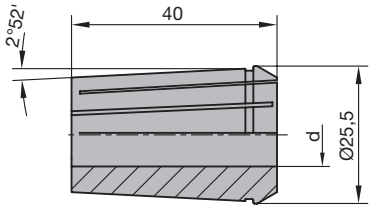
BEZ	for S mm	d mm	D mm	GL mm	ID
Collet (8°)	6	5,5 - 6	41	46	**037926** ●
Collet (8°)	8	7,5 - 8	41	46	**037927** ●
Collet (8°)	10	9,5 - 10	41	46	**037928** ●
Collet (8°)	12	11,5 - 12	41	46	**037929** ●
Collet (8°)	14	13,5 - 14	41	46	**037930** ●
Collet (8°)	16	15,5 - 16	41	46	**037931** ●
Collet (8°)	20	19,5 - 20	41	46	**037932** ●
Collet (8°)	25	24,5 - 25	41	46	**037933** ●
Collet (8°)	30	29,5 - 30	41	46	**679039** ●
Collet (8°)	6,35 (1/4“)	5,85 - 6,35	41	46	**037934** ●
Collet (8°)	9,53 (3/8“)	9,03 - 9,53	41	46	**037935** ●
Collet (8°)	12,7 (1/2“)	12,2 - 12,7	41	46	**037936** ●
Collet (8°)	15,88 (5/8“)	15,38 - 15,88	41	46	**037937** ●
Collet (8°)	19,05 (3/4“)	18,55 - 19,05	41	46	**037938** ●
Collet (8°)	25,4 (1“)	24,9 - 25,4	41	46	**037939** ●

Spare parts:

BEZ	ABM mm	D mm	Diameter range mm	DRI	ID
Sickle spanner	58/62		6 - 25,4		**005458** ●
Collet chuck nut with ball bearing	M50x1.5	63	6 - 25,4	RH	**006639** ●



Collet type 407E diamater range 6-12.7 mm



Collet type 415E diamater range 6-16 mm

Collets, DIN ISO 10897, taper ratio 1:10

Application:
For collet chucks as well as for multi spindle units and trimming units with 2°52‘ taper angle (taper ratio 1:10).

Technical information:
Double slotted design for maximum clamping forces and concentricity.

Diamater range 6-12.7 mm, Type 407E, DIN ISO 10897
PM 150 0

BEZ	for S mm	d mm	D mm	GL mm	ID
Collet (2°52‘)	6	6	19.8	34	**679013** ●
Collet (2°52‘)	7	7	19.8	34	**679015** ●
Collet (2°52‘)	8	8	19.8	34	**679016** ●
Collet (2°52‘)	9	9	19.8	34	**679017** ●
Collet (2°52‘)	10	10	19.8	34	**679019** ●
Collet (2°52‘)	12	12	19.8	34	**679020** ●
Collet (2°52‘)	6,35 (1/4“)	6.35	19.8	34	**679014** ●
Collet (2°52‘)	9,53 (3/8“)	9.53	19.8	34	**679018** ●
Collet (2°52‘)	12,7 (1/2“)	12.7	19.8	34	**679021** ●

Spare parts:

BEZ	ABM mm	D mm	Diameter range mm	DRI	ID
Sickle spanner	34/36		6 - 12,7		**005498** ●
Collet chuck nut	M27x1.5	35		RH	**006653** ●

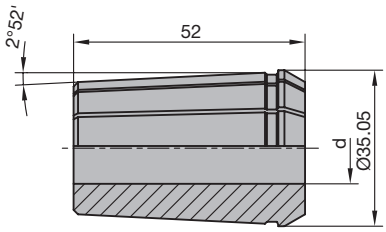
Diamater range 6-16 mm, Type 415E, DIN ISO 10897
PM 150 0

BEZ	for S mm	d mm	D mm	GL mm	ID
Collet (2°52‘)	6	6	25.5	40	**679005** ●
Collet (2°52‘)	8	8	25.5	40	**679032** ●
Collet (2°52‘)	9	9	25.5	40	**679033** ●
Collet (2°52‘)	9.5	9.5	25.5	40	**679034** ●
Collet (2°52‘)	10	10	25.5	40	**679006** ●
Collet (2°52‘)	11	11	25.5	40	**679035** ●
Collet (2°52‘)	12	12	25.5	40	**679036** ●
Collet (2°52‘)	13	13	25.5	40	**679007** ●
Collet (2°52‘)	14	14	25.5	40	**679037** ●
Collet (2°52‘)	16	16	25.5	40	**679008** ●
Collet (2°52‘)	6,35 (1/4“)	6.35	25.5	40	**679009** ●
Collet (2°52‘)	9,53 (3/8“)	9.53	25.5	40	**679010** ●
Collet (2°52‘)	12,7 (1/2“)	12.7	25.5	40	**679011** ●
Collet (2°52‘)	15,88 (5/8“)	15.88	25.5	40	**679012** ●

Spare parts:

BEZ	ABM mm	D mm	Diameter range mm	DRI	ID
Sickle spanner	40/42		6 - 16		**005469** ●
Collet chuck nut with ball bearing	M33x1.5	43		RH	**005685** ●

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



Collet type 462E diamater range 6-25.4 mm

Diamater range 6-25.4 mm, Type 462E, DIN ISO 10897
PM 150 0

BEZ	for S mm	d mm	D mm	GL mm	ID
Collet (2°52')	6	6	35.05	52	**037429** ●
Collet (2°52')	8	8	35.05	52	**037430** ●
Collet (2°52')	10	10	35.05	52	**037431** ●
Collet (2°52')	12	12	35.05	52	**037432** ●
Collet (2°52')	13	13	35.05	52	**037433** ●
Collet (2°52')	14	14	35.05	52	**037434** ●
Collet (2°52')	16	16	35.05	52	**037435** ●
Collet (2°52')	18	18	35.05	52	**037436** ●
Collet (2°52')	20	20	35.05	52	**037437** ●
Collet (2°52')	25	25	35.05	52	**037438** ●
Collet (2°52')	6,35 (1/4“)	6.35	35.05	52	**037495** ●
Collet (2°52')	9,53 (3/8“)	9.53	35.05	52	**037505** ●
Collet (2°52')	12,7 (1/2“)	12.7	35.05	52	**037496** ●
Collet (2°52')	15,88 (5/8“)	15.88	35.05	52	**037502** ●
Collet (2°52')	19,05 (3/4“)	19.05	35.05	52	**037497** ●
Collet (2°52')	25,4 (1“)	25.4	35.05	52	**037508** ●

Spare parts:

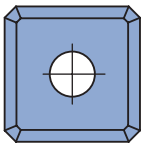
BEZ	ABM mm	D mm	Diameter range mm	DRI	ID
Sickle spanner	58/62		6 - 25,4		**005458** ●
Collet chuck nut with ball bearing	M48x2	60		RH	**005714** ●

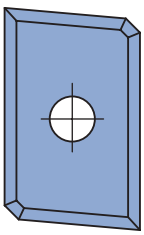
Knives and spare parts

Leitz tool programme for wood construction

Content chapter
Knives and spare parts

Knife type:
Type 1 Type 2





Turnblade knife

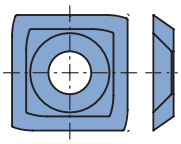
Workpiece material:
Softwood and hardwood

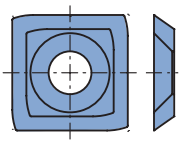
Cutting material:
HW

Knife height 12 mm with bevel

HW
TM 405 0

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





Workpiece material:
Softwood and hardwood

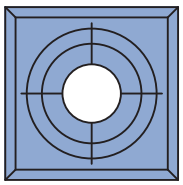
Cutting material:
HW / HW fine grain quality

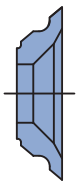
Turnblade knife with radius for calibration moulder System Rotoles

HW
TM 435 0

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

ID = 1 piece.





Turnblade knife with 4 cutting edges

Workpiece material:
Softwood and hardwood

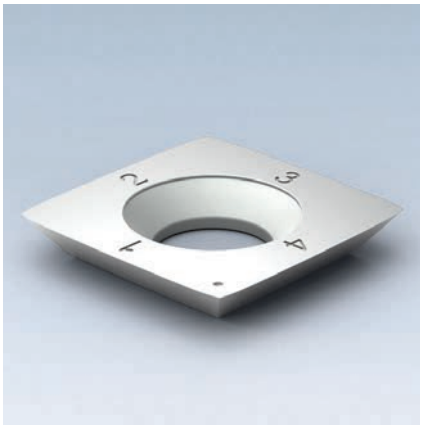
Cutting material:
HW

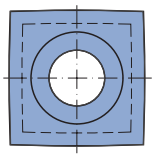
Knife height 21 mm with 4 cutting edges

HW
TM 410 0

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

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





HW turnblade knife

Workpiece material:
Softwood and hardwood

Cutting material:
HW / TDC

Turnblade knives for cutterhead system HeliCut

HW / TDC
TM 135 0, TM 405 0, TM 435 0

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

ID = 1 piece.

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

♦ suitable ◇ partly suitable

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

Cross section of planer knife (HW)

Cutting material:
HS Classic / HS Premium / MC33 / HW
Wedge angle:
40° (HS Classic / HS Premium / MC33)
45° (HW)

Knife height 30 mm

For planerhead wedge-type system WM 200 2 05
TM 100 0, TM 100 0 03, TM 100 0 05

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

ID = 1 piece.

Knife height 35 mm

For long planerheads wedge-type system
TM 100 0, TM 100 0 03, TM 100 0 05

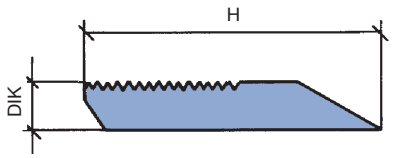
SB mm	H mm	DIK mm	VE PCS	ID HS Classic	ID HS Premium	ID HW	ID MC33
60	35	3	2	**605119**	**027387** ●		**606819** ●
100	35	3	2	**605120**	**027388** ●		**606820** ●
160	35	3	2	**605121**	**027389** ●		**606821** ●
230	35	3	2	**605122**	**027390** ●		**606822** ●
310	35	3	2	**605100**	**027351** ●	**027303**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

ID = 1 piece.

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

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

♦ suitable ◇ partly suitable



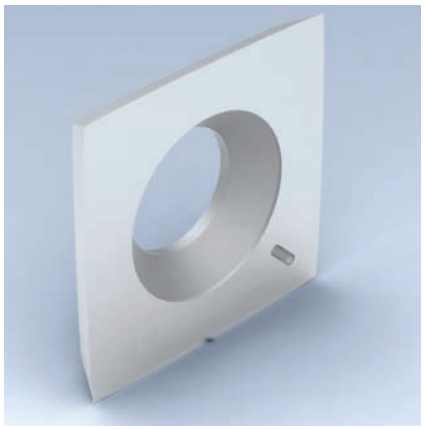
Cutting material:
MC33

Planer knives with 60° back serration

For planerhead with 60° back serrated knife fixture
AT 103 0 29

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

Set of the same weight.

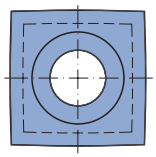


Turnblade planing knives HeliPlan

For cutterhead system HeliPlan
TM 405 0

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

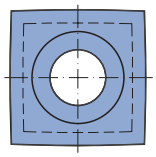
ID = 1 piece.



HW turnblade knife

Workpiece material:
Softwood and hardwood

Cutting material:
HW / TDC



Turnblade planing knives CASTOR

For cutterhead system CASTOR-Finish
TM 405 0

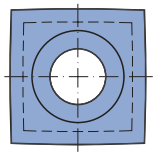
BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	15x15x2,5	HW	10	**009540** ●

ID = 1 piece.

HW turnblade knife

Workpiece material:
Softwood and hardwood

Cutting material:
HW



Turnblade planing knives Silent Power

For cutterhead system Silent Power
TM 405 0

BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	13,8x13,8x2,5	HW	10	**602534** ●

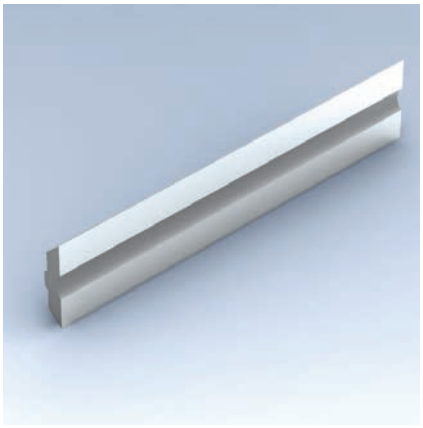
ID = 1 piece

HW turnblade knife

Workpiece material:
Softwood and hardwood

Cutting material:
HW

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

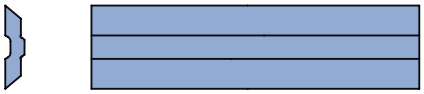


Cutting material recommendation	HS	HW
Solid wood dry	♦	
Solid wood wet	◇	
Hardwood dry		♦
Hardwood wet		♦
Glulam		♦
Clipboard		◇
MDF		◇

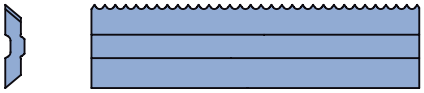
♦ suitable ◇ partly suitable

Cutting material:
HS / HW

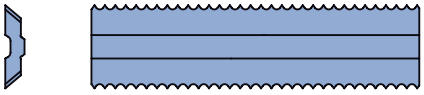
Cutting material:
HW



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



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



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

Turnblade planing knives VariPlan / VariPlan Plus

For cutterhead system VariPlan / VariPlan Plus
AT 103 0 03, AT 103 0 27

SB mm	H mm	DIK mm	SET PCS	ID HS	ID HW Microfinish
50	16	3.7	2	**610500** □	**617100** □
60	16	3.7	2	**610501** □	**617101** □
80	16	3.7	2	**610502** □	**617102** □
100	16	3.7	2	**610504** ●	**617104** □
120	16	3.7	2	**610505** ●	**617105** □
130	16	3.7	2	**610506** ●	**617106** ●
150	16	3.7	2	**610509** ●	**617109** ●
166	16	3.7	2	**610571** □	**617171** ●
170	16	3.7	2	**610511** ●	**617111** ●
180	16	3.7	2	**610512** ●	**617112** ●
190	16	3.7	2	**610514** ●	**617114** ●
210	16	3.7	2	**610515** ●	**617115** ●
230	16	3.7	2	**610516** ●	**617116** ●
236	16	3.7	2	**610569** □	**617169** ●
240	16	3.7	2	**610518** ●	**617118** ●
256	16	3.7	2	**610572** □	**617172** ●
270	16	3.7	2		**617165** ●
310	16	3.7	2	**610522** ●	**617122** ●
330	16	3.7	2		**617124** □
360	16	3.7	2		**617125** □
400	16	3.7	2	**610526** □	**617126** □
410	16	3.7	2	**610527** ●	**617127** □
410	16	3.7	3	**610528** □	
420	16	3.7	2	**610529** □	**617129** □
430	16	3.7	2	**610530** □	**617130** □
500	16	3.7	2	**610533** ●	**617133** □
510	16	3.7	4	**610562** □	**617162** □
520	16	3.7	4	**610563** □	**617163** □
530	16	3.7	2	**610536** □	**617136** □
540	16	3.7	2	**610537** □	**617137** □
600	16	3.7	2	**610538** ●	**617138** □
610	16	3.7	2	**610539** □	**617139** □
630	16	3.7	2	**610541** ●	**617141** □
640	16	3.7	4	**610564** □	**617164** □

For cutterhead system VariPlan Plus
AT 103 0 23, AT 103 0 24

SB mm	H mm	DIK mm	SET PCS	ID HW Integral	ID HW RipTec
100	16	3.7	2	**611904**	**611204** □
120	16	3.7	2	**611905**	**611205** □
130	16	3.7	2	**611906** ●	**611206** ●
150	16	3.7	2	**611909**	**611209** ●
166	16	3.7	2		**611271** ●
170	16	3.7	2	**611911** ●	**611211** ●
180	16	3.7	2	**611912** ●	**611212** ●
190	16	3.7	2	**611914**	**611214** ●
210	16	3.7	2	**611915**	**611215** ●
230	16	3.7	2	**611916**	**611216** ●
236	16	3.7	2		**611269** ●
240	16	3.7	2	**611918** ●	**611218** ●
270	16	3.7	2	**611965**	**611265** ●
310	16	3.7	2	**611922**	**611222** ●

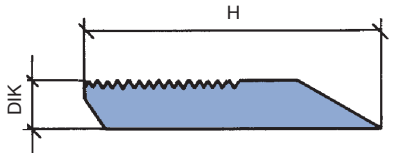
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

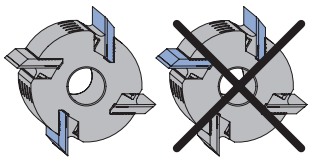
Cutting material recommendation	HS	MC 33
Solid wood dry	♦	♦
Solid wood wet	◇	♦
Hardwood dry	◇	♦
Hardwood wet	◇	♦
Glulam		◇
Thermoplastics (PE, PP, PVC, etc.)	♦	♦
WPC (Wood-Plastic-Composite)	◇	♦

♦ suitable ◇ partly suitable

H	PT
mm	mm
50	15
60	20
70	30

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





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

Cutting material:
HS / MC33

Blank knives with 60° back serration

HS and MC33 blank knives, for profile and hydro profile cutterheads
AT 103 0 28, AT 103 0 29

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

MC33 blank knive set of the same weight.

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

Torque tool set

TorqueVario®-STplus T-handle torque tool set, 11 parts
AT 199 0

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

Application:
Controlled tightening with predefined torque for changing knife tool systems

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

Precision:
±6%, based on national standards

Extra:
Delivery in stable metal box, incl. test protocol

Leitz Service

Tool service in manufacturer quality

Arguments for your success

Tools as good as new – this is based on the philosophy of maximum tool life and perfect machining quality throughout the entire life cycle of Leitz products. The Leitz tool service plays a decisive role in this. Taking the highest quality standards into account, Leitz is able to regrind tools of all types and from all manufacturers and deliver them back to the customer in manufacturer quality for use again – and that means around the globe in over 150 countries.

Your benefits due to …

QUALITY

... in good hands

- Uniform service and quality standards worldwide
- Absolute precision through-out the whole service process
- Handling by qualified Leitz personnel
- Complete service process documentation

RELIABILITY

... with us as your partner

- Local personal contact partner
- Reliable tool collection and delivery
- Transparent pricing

KNOWLEDGE

... through our know-how

- Our own service education center for international employee and customer training
- Continuous updating of qualifications for our employees with special focus on technology and production
- Consultation service in almost all areas of the wood and wood-based materials processing industries

PRODUCTIVITY

... is our incentive

- Quick accessibility, fast reactivity
- Understanding of your production processes
- Short set-up times due to programming aids and application data (Plug-and-Play)
- Optimal use from your tools over their entire life cycle

100

Service locations worldwide

1000

Service employees worldwide

15 Mio

Tools per year

FLEXIBILITY

... through our solutions

- Most modern machines and technologies
- Individual customer care through various service models (e.g. Complete Care)
- Re-grinding tooling from all manufacturers
- Flexible pricing models (square meters, running meters, number of products, ...)

EFFICIENCY

... through our processes

- Simple and short administration processing
- State-of-the-art electronic data collection systems via smartphone or tablet
- Comprehensive and transparent working steps

SUSTAINABILITY

... for the environment

- Raw material and optimized wear – as little as possible, as much as necessary
- Paperless administration and production
- Careful handling of valuable resources

Leitz worldwide

Partner in your market

38
National companies

100
Service locations worldwide

150000
Satisfied customers

3000
Employees

NORTH- & CENTRAL AMERICA

- 3 national companies
- 7 service locations

SOUTH AMERICA

- 1 national company
- 1 production plant
- 3 service locations

EUROPE

- 24 national companies
- 5 production plants
- 65 service locations

ASIA

- 8 national companies
- 1 production plant
- 19 service locations

AUSTRALIA / OCEANIA

- 2 national companies
- 5 service locations

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
LH	=	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
RH	=	right hand rotation
RP	=	radius of cutter
S	=	shank dimension
SB	=	cutting width
SET	=	set
SLB	=	slotting width
SLL	=	slotting length
SLT	=	slotting depth
SP	=	tool steel
ST	=	Cobalt-basis cast alloys, e.g. Stellite™
STO	=	shank tolerance
SW	=	cutting angle
TD	=	diameter of tool body
TDI	=	thickness of tool
TG	=	pitch
TK	=	reference diameter
UT	=	cutting edges with irregular pitch
V	=	number of spurs
v_c	=	cutting speed
v_f	=	feed speed
VE	=	packing unit
VSB	=	adjustment range
WSS	=	workpiece material
Z	=	number of teeth
ZA	=	number of fingers
ZF	=	tooth shape (cutting edge shape)
ZL	=	finger length

Notes to the Lexicon concerning the diagrams and tables

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

Key to pictograms


Sawing, multiple cut


Sawing solid transparent plastic


Copy shaping


Slotting


Profiling


Mechanical knife clamping, adjustable - serrated


Resharpenable cutting face


Sawing, thin kerf


Sawing hollow metal


Rebating


Spiral boring


Profiling joints


Mechanical knife clamping adjustable - plane


Resharpenable clearance face


Sawing, horizontal


Sawing crosscut metal


Bevelling


Non-axial boring


Mortising

Mechanical knife clamping, re-sharpenable and constant diameter

Low noise


Sawing along grain


Scoring, top and bottom


Panel raising


Plug cutting

Mechanical feed


Spindle without twist protection

Optimised chip flow


Sawing across grain


Scoring, hogging


Profiling


Carving

Manual feed


Spindle with anti-twist keyway

SP
Alloyed tool steel


Sawing, universal


Hogging


Profiling joints


Grooving, sizing


Solid metal tool


Spindle with anti-twist hexagon

HL
High-alloyed tool steel


Scoring, sawing


Double hogging


Profiling tongue and groove


Finish sizing


Tipped tool


Hydro clamping system - open

HS
High-speed steel


Scoring and sawing stacks


Hogging, folding


Planing


Grooving, horizontal and vertical

Special body alloy


Hydro clamping system - closed

ST
Stellite


Sawing hollow sections


End trimming


Planing, profiling


Jointing

Light alloy body


Hydro-Duo (bi-directional) clamping

HW
Tungsten carbide


Sawing, honeycomb panels


Edge trimming


Drilling blind holes


Copy shaping


Inter-changeable knives


Hydro clamping arbors

DP
Poly-crystalline diamond (PCD)


Sawing plastic single


Grooving, horizontal and vertical


Drilling, through holes


Rebating


Mechanical knife clamping, reversible


Hydro clamping

DM
Mono-crystalline diamond (MKD)


Sawing plastic stacks


Grooving honeycomb panels


Step drilling


Bevelling


Centrifugal knife clamping, reversible


Shrink-fit clamping

Carbide metal coating


Sawing hollow transparent plastic


Jointing


Counter-sinking


Panel raising


Mechanical knife clamping, non-adjustable

Quick clamping system

Diamond coating

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