Leitz-Lexicon

Edition 6

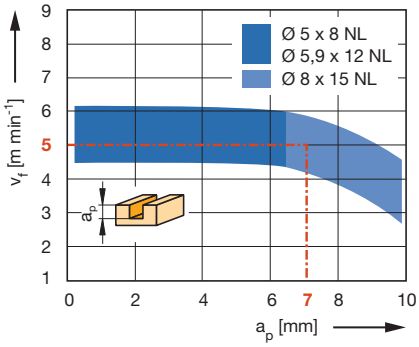
Explanation of abbreviations

A	=	dimension A
a_e	=	cutting thickness (radial)
a_p	=	cutting depth (axial)
ABM	=	dimension
APL	=	panel raising length
APT	=	panel raising depth
AL	=	working length
AM	=	number of knives
AS	=	anti sound (low noise design)
b	=	overhang
B	=	width
BDD	=	thickness of shoulder
BEM	=	note
BEZ	=	description
BH	=	tipping height
BO	=	bore diameter
CNC	=	Computerized Numerical Control
d	=	diameter
D	=	cutting circle diameter
D0	=	zero diameter
DA	=	outside Diameter
DB	=	diameter of shoulder
DFC	=	Dust Flow Control (optimised chip clearance)
DGL	=	number of links
DIK	=	thickness
DKN	=	double keyway
DP	=	polycrystalline diamond
DRI	=	rotation
FAB	=	width of rebate
FAT	=	depth of rebate
FAW	=	bevel angle
FLD	=	flange diameter
f_z	=	tooth feed
$f_{z\ eff}$	=	effective tooth feed
GEW	=	thread
GL	=	total length
GS	=	Plunging edge
H	=	height
HC	=	tungsten carbide, coated
HD	=	wood thickness (thickness of workpiece)
HL	=	high-alloyed tool steel
HS	=	high-speed steel (HSS)
HW	=	tungsten carbide (TCT)
ID	=	ident number
IV	=	insulation glazing
KBZ	=	abbreviation
KLH	=	clamping height
KM	=	edge breaker
KN	=	single keyway
KNL	=	combination pinhole consists of 2/7/42 2/9/46,35 2/10/60
L	=	length
l	=	clamping length
LD	=	left hand twist
LEN	=	Leitz standard profiles
LL	=	left hand rotation
M	=	metric thread
MBM	=	minimum order quantity
MC	=	multi-purpose steel, coated
MD	=	thickness of knife
min^{-1}	=	revolutions per minute (RPM)
MK	=	morse taper
m min^{-1}	=	metres per minute
m s^{-1}	=	metres per second
n	=	RPM
n_{max}.	=	maximum permissible RPM
NAL	=	position of hub
ND	=	thickness of hub
NH	=	zero height
NL	=	cutting length
NLA	=	pinhole dimensions
NT	=	grooving depth
P	=	profile
POS	=	cutter position
PT	=	profile depth
PG	=	profile group
QAL	=	cutting material quality
R	=	radius
RD	=	right hand twist
RL	=	right hand rotation
RP	=	radius of cutter
S	=	shank dimension
SB	=	cutting width
SET	=	set
SLB	=	slotting width
SLL	=	slotting length
SLT	=	slotting depth
SP	=	tool steel
ST	=	Cobalt-basis cast alloys, e. g. Stellit®
STO	=	shank tolerance
SW	=	cutting angle
TD	=	diameter of tool body
TDI	=	thickness of tool
TG	=	pitch
TK	=	reference diameter
UT	=	cutting edges with irregular pitch
V	=	no. of spurs
v_c	=	cutting speed
v_f	=	feed speed
VE	=	packing unit
VSB	=	adjustment range
WSS	=	workpiece material
Z	=	no. of teeth
ZA	=	number of fingers
ZF	=	tooth shape (cutting edge shape)
ZL	=	finger length

5. Routing

HW

Feed speed v_f depending on cutting depth a_p



Workpiece material: Duromers, plastomers, compound materials
Working step: Grooving, sizing
Speed: n = 16000 - 18000 rpm

Grooving cutter, straight cut

Application:
Router cutter for grooving.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools, portable routers.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., laminated wood (plywood etc.), duromers, plastomers, mineral materials (Corian, Varicor etc.), gluelam (HPL, Trespa etc), non-ferrous metals (aluminium, copper etc.).

Technical information:
Straight cut. Ground on edge for plunging. Large resharpening area. Good hogging performance in plastic and compound materials.

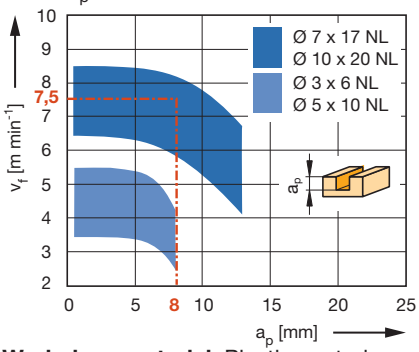
HW solid, Z 1
WO 120-2

D mm	GL mm	NL mm	S mm	QAL	DRI	ID	
5,9	65	12	6x30	HW solid	RL	**044466**	●
8	70	27	8x30	HW solid	RL	**044468**	●

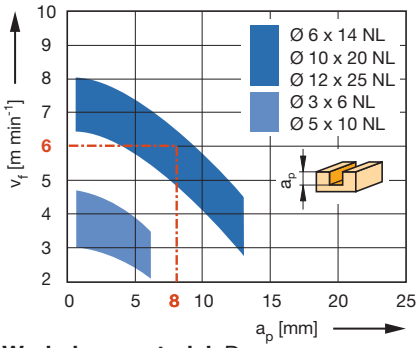
RPM: n max. = 24000 min^{-1}


HW

Feed speed v_f depending on cutting depth a_p



Workpiece material: Plastic coated chipboard
Working step: Grooving
Speed: n = 18000 rpm
Correction factor for v_f:
Solid wood = 0.8; Gluelam = 0.8;
Machining across grain = 0.7



Workpiece material: Duromers, plastomers, Corian
Working step: Grooving
Speed: n = 16000 - 18000 rpm

Grooving cutter, straight cut

Application:
Router cutter for sizing and grooving.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools, portable routers.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.), duromers, plastomers, mineral materials (Corian, Varicor etc.), laminated materials (HPL, Trespa etc.), non-ferrous metals (aluminium, copper etc.).

Technical information:
Straight cut. Ground on edge for plunging. Large resharpening area. Short design for increased stability and low vibration cutting. Long design for deep cutting (recommended in several steps).

HW solid, Z 2, short design
WO 120-1-16

D mm	GL mm	NL mm	S mm	DRI	ID	
3	50	6	6x30	RL	**041979**	●
4	50	7	6x30	RL	**041952**	●
4,5	50	8	6x30	RL	**041953**	●
5	50	10	6x30	RL	**041954**	●
5,5	50	12	6x30	RL	**041955**	●
6	50	14	6x30	RL	**041956**	●
7	55	17	8x30	RL	**041958**	●
8	55	20	8x30	RL	**041985**	●
8,5	65	16	8x30	RL	**041960**	●
9	70	18	10x40	RL	**041961**	●
10	70	20	10x40	RL	**041962**	●
12	70	25	12x40	RL	**041963**	●

HW solid, Z 2, short design, reinforced shank
WO 120-1-16

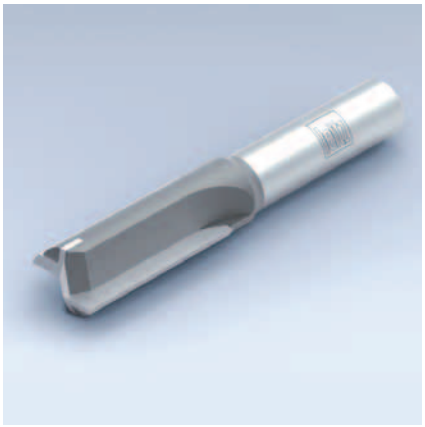
D mm	GL mm	NL mm	S mm	DRI	ID	
3	55	6	8x40	RL	**041981**	●
4	55	10	8x40	RL	**041982**	●
5	55	12	8x40	RL	**041983**	●
6	55	14	8x40	RL	**041984**	●

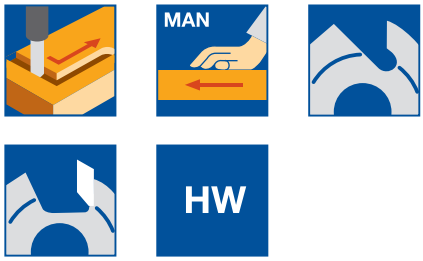
HW solid, Z 2, long design
WO 120-1-16

D mm	GL mm	NL mm	S mm	DRI	ID	
3	60	12	6x30	RL	**041964**	●
4	60	12	6x40	RL	**041965**	●
5	80	18	6x40	RL	**041966**	●

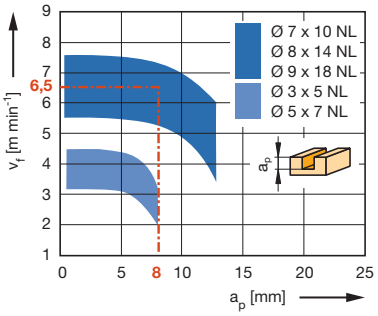
RPM: n max. = 24000 min^{-1}

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

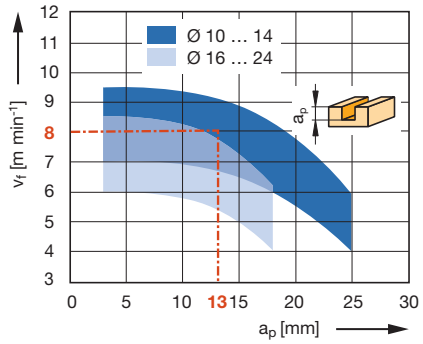




Feed speed v_f depending on cutting depth a_p



Workpiece material: Plastic coated chipboard
Working step: Grooving
Speed: n = 18000 rpm
Correction factor for v_f: Solid wood = 0.8; Gluelam = 0.8; Across grain = 0.7



Workpiece material: Plastic coated chipboard
Working step: Grooving
Speed: n = 18000 rpm
Correction factor for v_f: Solid wood = 0.8; Gluelam = 0.8; Machining across grain = 0.7

Grooving cutter, Z 2

Application:
Router cutter for sizing and grooving.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools, portable routers.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.).

Technical information:
Straight cut, tungsten carbide plunging tip.

HW, Z 2, shank 9.5 / 12 mm
WO 120-1-01

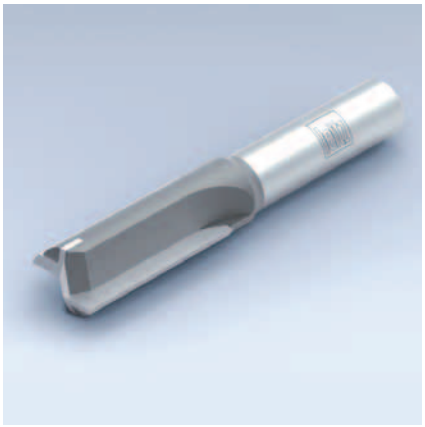
D mm	GL mm	NL mm	S mm	QAL	DRI	ID	
3	34	5	9,5x20	HW solid	RL	**038014**	●
4	37	6	9,5x20	HW solid	RL	**038016**	●
5	39	7	9,5x20	HW solid	RL	**038018**	●
8	48	14	9,5x20	HW solid	RL	**038024**	●
10	52	20	9,5x20	HW	RL	**038028**	●
11	52	25	9,5x20	HW	RL	**038030**	●
12	72	25	12x40	HW	RL	**038115**	●
13	72	25	12x40	HW	RL	**038116**	●
14	76	28	12x40	HW	RL	**038117**	●
15	80	30	12x40	HW	RL	**038118**	●
16	90	35	12x40	HW	RL	**038147**	●
18	90	35	12x40	HW	RL	**038148**	●
20	90	35	12x40	HW	RL	**038149**	●
25	92	41	12x40	HW	RL	**038125**	●
28	94	42	12x40	HW	RL	**038127**	●
30	94	42	12x40	HW	RL	**038128**	●

RPM: D = 3 - 25 mm
n = 16000 - 36000 min^{-1}
D = 26 - 30 mm
n = 16000 - 30000 min^{-1}

HW, Z 2, shank 10 mm
WO 120-1-01

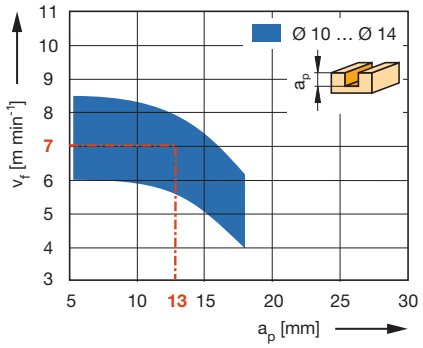
D mm	GL mm	NL mm	S mm	QAL	DRI	ID	
4	60	10	10x35	HW solid	RL	**038053**	●
5	60	12	10x35	HW solid	RL	**038054**	●
6	60	14	10x35	HW solid	RL	**038055**	●
7	60	17	10x35	HW solid	RL	**038056**	●
8	60	20	10x35	HW solid	RL	**038057**	●
10	70	23	10x35	HW	RL	**038058**	●
12	70	23	10x35	HW	RL	**038059**	●
14	70	23	10x35	HW	RL	**038060**	●
16	70	23	10x35	HW	RL	**038062**	●
20	70	23	10x35	HW	RL	**038064**	●

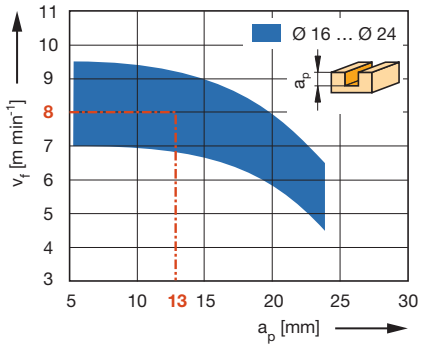
RPM: D = 3 - 25 mm
n = 16000 - 36000 min^{-1}




HW

Feed speed v_f depending on cutting depth a_p





Grooving cutter, Z 2

Application:
Router cutter for sizing and grooving.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools, portable routers.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.).

Technical information:
Straight cut, plunging tip in tungsten carbide (only WO 120-1-10). Ground on end (only WO 110-2), suitable for plunging. Long design for deep cutting (recommended in several steps).

HW, Z 2, shank 12 mm, long design
WO 120-1-01, WO 120-1-10

D mm	GL mm	NL mm	S mm	DRI	ID	
10	90	35	12x40	RL	**072495**	●
12	90	40	12x40	RL	**072496**	●
14	100	50	12x40	RL	**072233**	●
16	90	45	12x40	RL	**072105**	●
16	100	60	12x40	RL	**072234**	●
18	90	45	12x40	RL	**072106**	●
20	90	45	12x40	RL	**072107**	●
22	90	45	12x40	RL	**072108**	●
24	90	45	12x40	RL	**072109**	●
30	90	35	12x40	RL	**072498**	●

Workpiece material: Plastic coated chipboard
Working step: Grooving
Speed: n = 18000 rpm
Correction factor for v_f:
Solid wood = 0.8; Gluelam = 0.8;
Machining across grain = 0.7

RPM: D = 3 - 25 mm
n = 16000 - 36000 min^{-1}
D = 26 - 30 mm
n = 16000 - 30000 min^{-1}

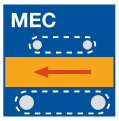
HW, Z 2, inch dimensions, long design
WO 110-2

D in	GL in	NL in	S in	QAL	DRI	ID	
1/8“	1 3/4“	3/8“	1/4“ x 1 1/4“	HW solid	RL	**038069**	●
1/4“	2 1/2“	1 1/4“	1/4“ x 1 1/4“	HW solid	RL	**038083**	●
1/4“	2 3/8“	3/4“	1/2“ x 1 5/8“	HW	RL	**038072**	●
5/16“	2 5/8“	1“	1/2“ x 1 3/8“	HW	RL	**038088**	●
3/8“	2 7/16“	3/4“	1/2“ x 1 5/8“	HW	RL	**038078**	●
3/8“	2 7/8“	1 1/4“	1/2“ x 1 3/8“	HW	RL	**038089**	●
1/2“	2 5/8“	1“	1/2“ x 1 5/8“	HW	RL	**038099**	●
1/2“	2 3/4“	1 1/4“	1/2“ x 1 5/8“	HW	RL	**038079**	●
1/2“	3 1/8“	1 1/2“	1/2“ x 1 3/8“	HW	RL	**038091**	●
1/2“	4 1/2“	2“	1/2“ x 2 1/2“	HW	RL	**038101**	●

Workpiece material:
Plastic coated chipboard
Working step: Grooving
Speed: n = 18000 rpm
Correction factor for v_f:
Solid wood = 0.8; Gluelam = 0.8;
Machining across grain = 0.7

RPM: D = 3 - 25 mm
n = 16000 - 36000 min^{-1}
D = 26 - 30 mm
n = 16000 - 30000 min^{-1}

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



HW

Grooving cutterset, adjustable

Application:
For horizontal grooving in the edge of panels. For cutting panel joint grooves etc.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.).

Technical information:
Grooving cutterset for mounting on cutter arbor, continuous cutting width adjustment without spacers. Grooving depth up to 12 mm.

Adjustable, mounted on cutter arbor
SO 100-2

Tool Type	D mm	Z	BO mm	ID	
Tool set mounted on arbor	100	4/4	20	**426061**	□

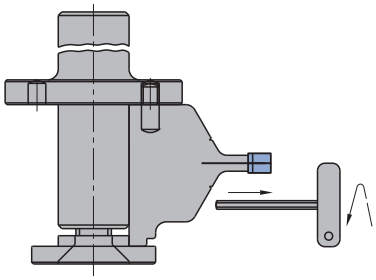
RPM: n max. = 18000 min^{-1}

Adjustable, without cutter arbor
SF 502-2-01

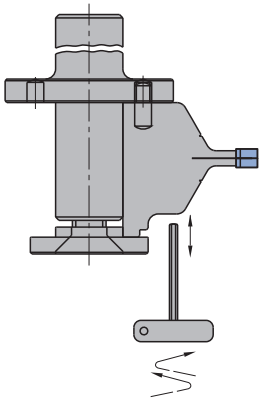
Tool Type	D mm	SB mm	BO mm	ID	
Grooving cutterset with flanged sleeve	100	3,5 - 6,2	20	**020646**	●

RPM: n max. = 18000 min^{-1}

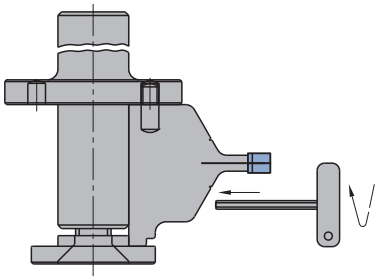
When ordering, select arbors with d-20 mm and clamping length 40 mm.
Cutter arbor see section 8 Clamping systems/Adaptors.



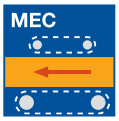
Open clamping system



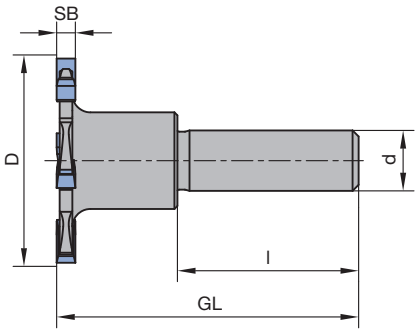
Adjustment SB larger “+”, SB smaller “-”



Close clamping system



HW



Grooving cutter, Z 6

Application:
Routers for cutting additional grooves, for example, wood/alu windows dry glazing systems.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Softwood and hardwood, laminated wood in the window construction.

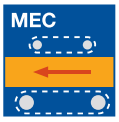
Technical information:
Straight cut. Reinforced body for higher stability.

HW, Z 6
WO 110-2

D mm	GL mm	SB mm	S mm	Z	DRI	ID	
35	50	3,1	10x30	6	RL	**038236**	●

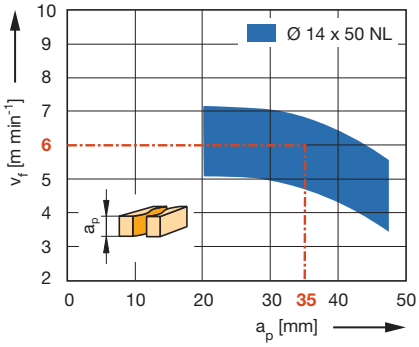
RPM: n = 16000 - 24000 min^{-1}

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



HW

Feed speed v_f depending on grooving depth a_p



Workpiece material: Plastic coated and veneered chipboard
Working step: Sizing
Speed: n = 18000 rpm
Correction factor for v_f:
Machining across grain = 0.7

Grooving cutter with shear angle

Application:
Router cutter for sizing, grooving and cutting apertures.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

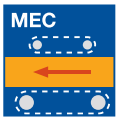
Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.).

Technical information:
Finishing type Z 1+1 particularly for apertures in furniture and doors. Cutting edges with shear angles against feed for tear free edges on both sides.

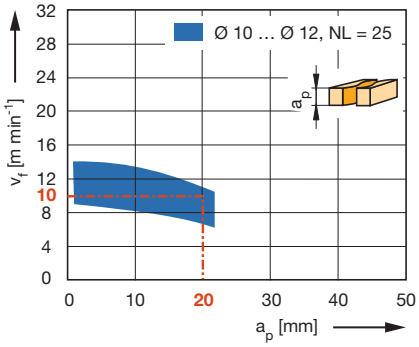
HW, Z 1+1, finishing cut processing
WO 140-2

D mm	GL mm	NL mm	S mm	DRI	ID	
14	100	50	12x50	RL	**038204**	●
14	100	50	14x50	RL	**038205**	●
14	120	50	25x60	RL	**038206**	●

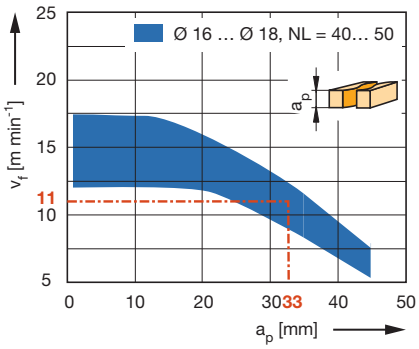
RPM: n max. = 24000 min^{-1}



Feed speed v_f depending on grooving depth a_p



Workpiece material: Softwood
Working step: Sizing
Speed: n = 18000 rpm
Correction factor for v_f:
Hardwood = 0.8; Chipboard = 1.3;
Gluelam = 0.9



Workpiece material: Softwood
Working step: Sizing
Speed: n = 18000 rpm
Correction factor for v_f:
Hardwood = 0.8; Chipboard = 1.2;
gluelam = 0.9

Spiral roughing/finishing router cutter Marathon

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

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF, etc.) uncoated, gluelam (plywood, etc.) gluelam (HPL, Trespa, etc.), duromers, plastomers, mineral working material (Corian, Varicor, etc.).

Technical information:
Solid tungsten carbide, tungsten carbide quality and Marathon coating for increased performance time, particularly in abrasive materials. Recommended for abrasive materials such as HPL/CPL.

HW, Z 2, short design
WO 160-2-15

D mm	D in	GL mm	GL in	NL mm	NL in	S mm	S in	Z	Twist	DRI	ID	
12,7	1/2“	76,2	3“	28,6	1 1/8“	12,7x40	1/2“x1 1/2“	2	RD	RL	**240514**	●
12,7	1/2“	88,9	3 1/2“	38,1	1 1/2“	12,7x40	1/2“x1 1/2“	2	LD	RL	**240515**	●

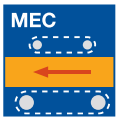
RPM: n max. = 24000 min^{-1}

HW, Z 2, short design, for abrasive materials
WO 160-2-15

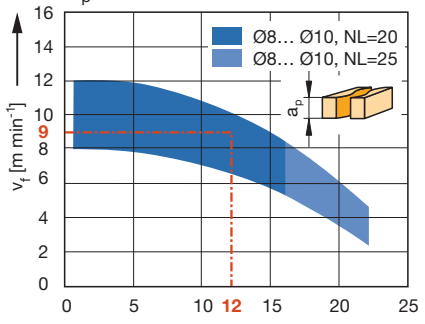
D mm	GL mm	NL mm	S mm	Z	Twist	DRI	ID	
10	70	25	10x40	2	RD	RL	**240200**	●
12	70	25	12x40	2	RD	RL	**240201**	●
16	100	40	16x50	2	RD	RL	**240202**	●
18	100	50	18x50	2	RD	RL	**240203**	●

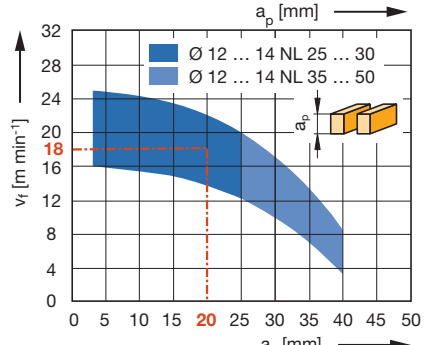
RPM: n max. = 24000 min^{-1}

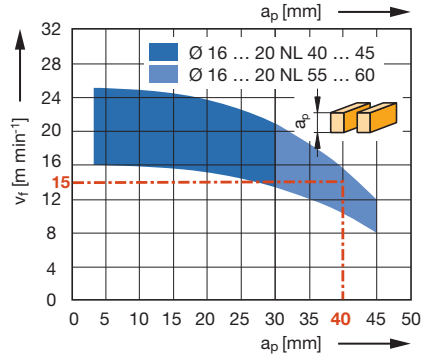
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Feed speed v_f depending on grooving depth a_p







Spiral roughing/finishing router cutter Marathon

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

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Softwood and hardwood, laminated wood in window construction, chipboard and fibre working materials (MDF, HF, etc.), uncoated, gluelam (plywood, etc.), plastomers, mineral working materials (Corian, Varicor, etc.).

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

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

D mm	GL mm	NL mm	S mm	Z	Twist	ID LL	ID RL	
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**	●

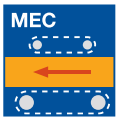
Z 2 / Z 3, long design
WO 160-2-12

D mm	GL mm	NL mm	S mm	Z	Twist	ID LL	ID RL	
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	20x55	3	LD	**042297**		●

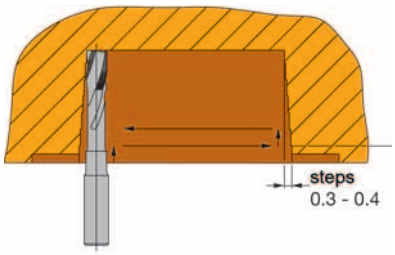
RPM: n max. = 24000 min^{-1}

Workpiece material: Softwood
Working step: Sizing
Speed: n = 18000 rpm
Correction factor for v_f: Hardwood = 0.8; Chipboard = 1.3; Laminated wood = 0.9

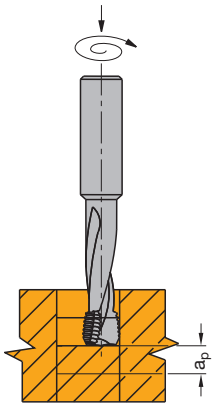
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



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



Production of keyholes and spy holes by circular cutting

Spiral roughing/finishing router cutter Marathon

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

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Softwood and hardwood, laminated wood in window construction, chipboard and fibre working materials (MDF, HF, etc.) uncoated, gluelam (plywood, etc.).

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

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		3	LD	RL	**240010**	●	**240500**	□
10	90	30	51	10x35		3	LD	RL	**240011**	●	**240501**	□
12	120	35	80	12x35		3	LD	RL	**240012**	●	**240502**	□
12	120	35	80	12x35		3	right hand twist	RL	**240000**	●		
14	170	30	95	16x50		3	right hand twist	RL	**240001**	●		
14	190	30	120	16x50		3	right hand twist	RL	**240002**	●		
16	170	50	105	16x50		3	right hand twist	RL	**240003**	●		
16	179	30	120	16x58	*	3	right hand twist	RL	**240004**	●		
16	179	30	120	20x58	*	3	right hand twist	RL	**240005**	●		
16	205	30	135	20x50		3	right hand twist	RL	**240006**	●		
17	170	30	105	20x50		3	right hand twist	RL	**240007**	●		
17	190	30	120	20x50		3	right hand twist	RL	**240008**	●		
18	170	50	115	20x50		3	right hand twist	RL	**240009**	●		

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

* with clamping flat for HOMAG/WEEKE latch hole unit

Note:
HSK-F 63 = tool is supplied shrink-fitted in shrink-fit chuck HSK-F 63.

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

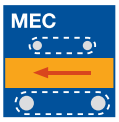
Z 3, extra long design for cutting spyholes and keyholes
WO 160-2-14

D mm	GL mm	NL mm	AL mm	S mm	Z	DRI	ID		ID Set HSK-F 63	
10	95	45		10x40	3	RL	**240100**	●		
11,3	105	15	55	12x45	2	RL	**240101**	●		
12	120	15	75	12x40	2	RL	**240102**	●		
12	140	20	95	12x40	2	RL	**240103**	●		
14	130	50	75	14x50	3	RL	**240104**	●		
14	170	30	95	16x60	3	RL	**240108**	●	**240601**	□
16	130	75		16x50	3	RL	**240105**	●		

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

D mm	GL mm	NL mm	AL mm	S mm	Z	DRI	ID		ID Set HSK-F 63	
16	170	50	105	16x55	3	RL	**240107**	●	**240600**	□
16	170	30	95	16x60	3	RL	**240106**	●		
25	200	120		25x65	3	RL	**240300**	●	**240800**	□

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



Spiral roughing/finishing router cutter Marathon alternate twist

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

Machine:
Overhead routers with/without CNC control, machining centres, special router machines with cutting spindles for mounting shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre working material (MDF, HF, etc.) uncoated, gluelam (plywood, etc.), plastomers, mineral working materials (Corian, Varicar, etc.).

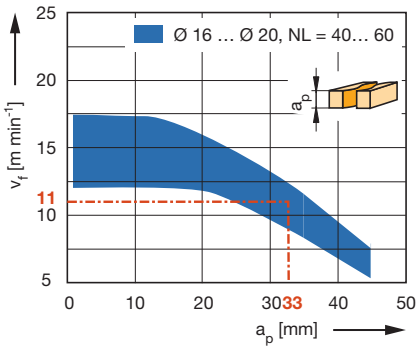
Technical information:
HW solid, Marathon coating for increased performance time. Alternate twist for tear free cut edges on both sides. Higher feed speeds possible than with conventional roughing cutters. Quiet running.

Z 2 + 2
WO 160-2-16

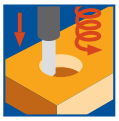
D mm	GL mm	NL mm	S mm	DRI	ID	
16	100	40	16x50	RL	**240402**	●
20	120	45	20x50	RL	**240400**	●
20	130	60	20x50	RL	**240401**	●
20	140	75	20x50	RL	**240403**	●

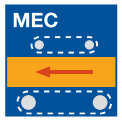
RPM: n max. = 24000 min^{-1}

Feed speed v_f depending on grooving depth a_p

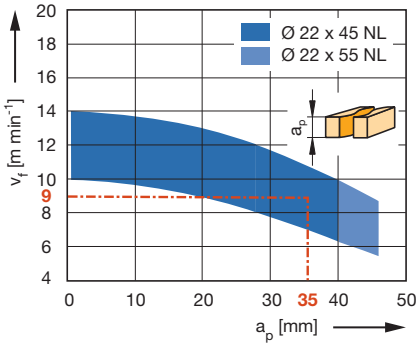


Workpiece material: Softwood
Working step: Sizing
Speed: n = 18000 rpm
Correction factor for v_f:
Hardwood = 0.8; Chipboard = 1.2;
Gluelam = 0.9





Feed speed v_f depending on grooving depth a_p



Workpiece material: Plastic coated chipboard
Working step: Sizing
Speed: n = 18000 rpm
Correction factor for v_f: MDF = 0.8

Roughing router cutter in turnblade design

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

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, gluelam (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

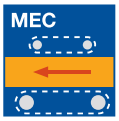
D mm	GL mm	NL mm	S mm	DRI	ID	
22	105	45	20x50	RL	**041923**	●
22	115	45	25x60	RL	**041921**	●
22	125	55	25x60	RL	**041922**	●

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

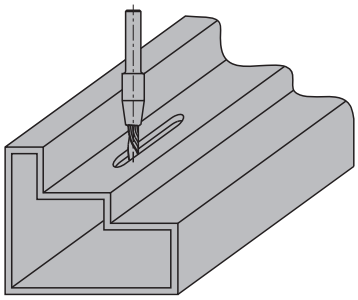
Spare parts:

BEZ	ABM mm	QAL	VE PCS	ID	
Turnblade knife	9x12x1,5	HW-05	10	**005158**	●
Turnblade knife	12x12x1,5	HW-05	10	**005081**	●
Oval head screw Torx® 15	M4x6			**006225**	●
Torx®	Torx® 15			**005457**	●

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



HW



Slotting in hollow sections

Spiral finishing router cutter

Application:
Router cutter for grooving plastic and aluminium profiles. Ideal for cutting drainage grooves in plastic window profiles.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Softwood and hardwood, duromers, plastomers, compound materials (PU with aluminium coating etc.), non-ferrous metals (aluminium, copper etc.).

Technical information:
When cutting aluminium, suitable lubrication (spray or minimum volume lubrication) is necessary.

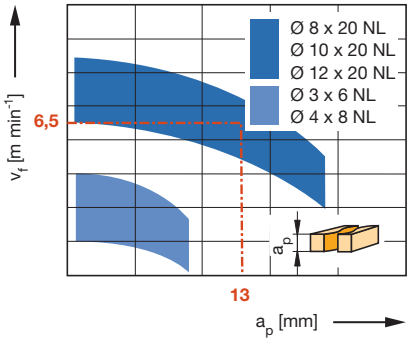
HW solid, Z 1, long design
WO 160-2-07

D mm	GL mm	NL mm	AL mm	S mm	Z	Twist	DRI	ID	
5	78	20	30	8x40	1	RD	RL	**042539**	●
5	95	20	30	8x40	1	RD	RL	**042540**	●
5	110	25	45	8x40	1	RD	RL	**042541**	●

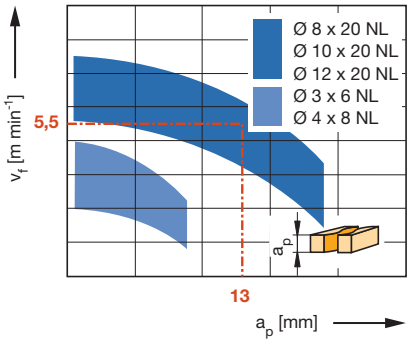
RPM: n = 18000 - 24000 min^{-1}


HW

Feed speed v_f depending on cutting depth a_p



Workpiece material: Softwood
Working step: Sizing
Speed: n = 18000 - 24000 rpm
Correction factor for v_f:
Hardwood = 0.9; Machining across grain = 0.8; Chipboard = 1.1



Workpiece material: Duromers, plastomers, gluelam (HPL), compound materials
Working step: Sizing
Speed: n = 16000 - 24000 rpm

Spiral finishing router cutter

Application:
Router cutter for sizing, grooving and finish cutting to high cutting quality.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.), duromers, plastomers, mineral materials (Corian, Varicor etc.), gluelam (HPL, Trespa etc.), non-ferrous metals (aluminium, copper etc.).

Technical information:
Large twist angle for high shear cut. Check twist direction for good top layer quality. Max. cutting depth 1.0 - 1.5 x diameter. Short design for increased stability and low vibration. Long design for deep cutting (recommended in several steps).

HW solid, Z 1, short design
WO 160-2-03

D mm	D in	GL mm	GL in	NL mm	NL in	S mm	S in	Z	Twist	DRI	ID	
3		50		6		6x30		1	RD	RL	**042723**	●
3		50		6		6x30		1	LD	RL	**042724**	●
4		50		8		6x30		1	RD	RL	**042725**	●
4		50		8		6x30		1	LD	RL	**042726**	●
5		50		10		6x30		1	RD	RL	**042727**	●
5		50		10		6x30		1	LD	RL	**042728**	●
6		50		14		6x30		1	RD	RL	**042729**	●
6		50		14		6x30		1	LD	RL	**042730**	●
6,35	1/4“	50,8	2“	15,88	5/8“	6,35x30	1/4“x1 1/8“	1	RD	RL	**240512**	●
8		65		20		8x40		1	RD	RL	**042731**	●
8		65		20		8x40		1	LD	RL	**042732**	●
10		70		20		10x40		1	RD	RL	**042733**	●
10		70		20		10x40		1	LD	RL	**042734**	●
12		70		20		12x40		1	RD	RL	**042735**	●
12		70		20		12x40		1	LD	RL	**042736**	●

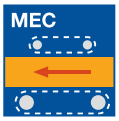
RPM: n = 16000 - 24000 min^{-1}

HW solid, Z 1, long design
WO 160-2-03

D mm	GL mm	NL mm	S mm	Z	Twist	DRI	ID	
4	60	12	6x40	1	RD	RL	**042739**	●
4	60	12	6x40	1	LD	RL	**042740**	●
5	80	18	6x40	1	RD	RL	**042741**	●
5	80	18	6x40	1	LD	RL	**042742**	●
6	80	22	6x40	1	RD	RL	**042743**	●
6	80	22	6x40	1	LD	RL	**042744**	●
8	80	25	8x40	1	RD	RL	**042745**	●
8	80	25	8x40	1	LD	RL	**042746**	●
10	90	32	10x40	1	RD	RL	**042747**	●
10	90	32	10x40	1	LD	RL	**042748**	●
12	90	32	12x40	1	RD	RL	**042749**	●
12	90	32	12x40	1	LD	RL	**042750**	●

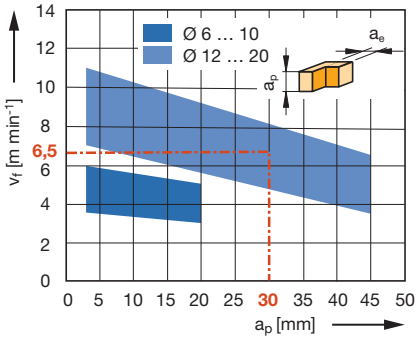
RPM: n = 16000 - 24000 min^{-1}

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

HW

Feed speed v_f depending on grooving depth a_p



Workpiece material: Softwood
Working step: Jointing
Speed: n = 18000 rpm
Correction factor for v_f:
Hardwood = 0.9;
Machining across grain = 0.7

Spiral finishing router cutter

Application:
Router cutter for sizing, grooving and finish cutting to high cutting quality.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.), duromers, plastomers, mineral materials (Corian, Varicor etc.), gluelam (HPL, Trespa etc.).

Technical information:
Ideally used after roughing cutters, finish cut allowance approx. 1-2 mm. Check twist direction for good top layer quality. Short design for increased stability and low vibration. Long design for larger material thickness at reduced feed speeds.

HW solid, Z 2, short design
WO 160-2-05

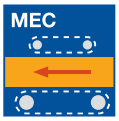
D mm	GL mm	NL mm	S mm	Z	Twist	DRI	ID	
6	60	12	6x30	2	LD	RL	**042457**	●
8	65	20	8x30	2	RD	RL	**042472**	●
10	70	25	10x40	2	RD	RL	**042458**	●
10	70	25	10x40	2	LD	RL	**042459**	●
12	70	25	12x40	2	RD	RL	**042758**	●
12	70	25	12x40	2	LD	RL	**042760**	●
16	100	40	16x50	2	RD	RL	**042761**	●
16	100	40	16x50	2	LD	RL	**042763**	●
20	100	45	20x50	2	RD	RL	**042764**	●

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

HW solid, Z 2, long design
WO 160-2-05

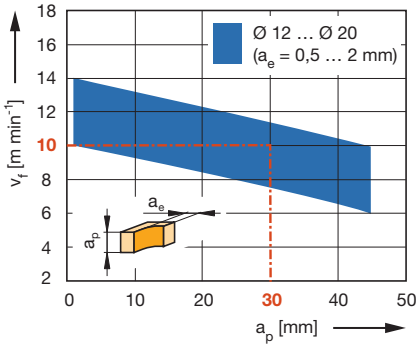
D mm	D in	GL mm	GL in	NL mm	NL in	S mm	S in	Z	Twist	DRI	ID	
12		80		35		12x40		2	RD	RL	**042765**	●
12,7	1/2“	76,2	3“	31,8	1 1/4“	12,7x40	1/2“x1 1/2“	2	LD	RL	**240510**	●
12,7	1/2“	88,9	3 1/2“	31,8	1 1/4“	12,7x40	1/2“x1 1/2“	2	LD	RL	**240511**	●
16		110		55		16x55		2	RD	RL	**042766**	●

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

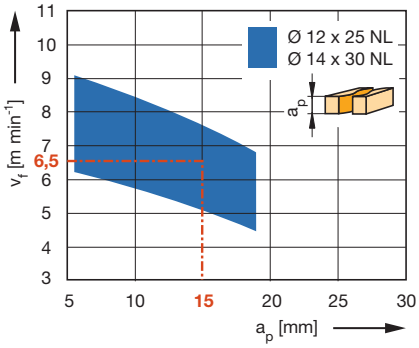


HW

Feed speed v_f depending on grooving depth a_p



Workpiece material: Softwood
Working step: Jointing
Speed: n = 18000 rpm
Correction factor for v_f:
Hardwood = 0.9;
Machining across grain = 0.7



Spiral finishing router cutter

Application:
Router cutter for sizing, grooving and finish cutting to high cutting quality. Z 3 design for high feed speeds.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.), duromers, plastomers, mineral materials (Corian, Varicor etc.), gluelam (HPL, Trespa etc.).

Technical information:
Ideally used after roughing cutters, finish cut allowance approx. 1-2 mm. Check twist direction for good top layer quality. Short design for increased stability and low vibration. Long design for larger material thickness at reduced feed speeds.

HW solid, Z 3, short design
WO 160-2-05

D mm	GL mm	NL mm	S mm	Z	Twist	ID LL		ID RL	
12	70	25	12x40	3	LD			**042486**	●
12	70	25	12x40	3	RD	**042534**	●	**042487**	●
14	80	30	14x40	3	RD			**042461**	●
16	100	40	16x50	3	RD			**042488**	●
16	100	40	16x50	3	LD			**042489**	●
18	90	35	18x50	3	RD			**042474**	●

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

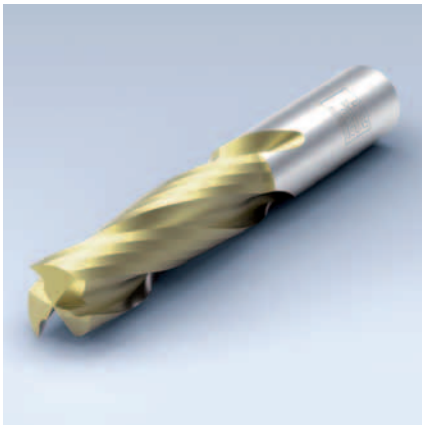
HW solid, Z 3, long design
WO 160-2-05

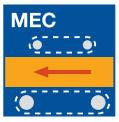
D mm	D in	GL mm	GL in	NL mm	NL in	S mm	S in	Z	Twist	ID LL		ID RL	
8		65		25		8x30		3	LD			**042490**	●
12		80		35		12x40		3	RD			**042460**	●
12,7	1/2“	88,9	3 1/2“	28,6	1 1/8“	12,7x 40	1/2“x 1 1/2“	3	RD			**240509**	●
14		110		50		14x55		3	RD			**042462**	●
16		110		55		16x55		3	RD			**042464**	●
16		110		55		16x55		3	LD	**042473**	●	**042465**	●
18		120		60		18x55		3	RD			**042475**	●
20		120		60		20x55		3	RD			**042466**	●
20		120		60		20x55		3	LD	**042468**	●	**042467**	●
20		130		75		20x50		3	RD			**042549**	●

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

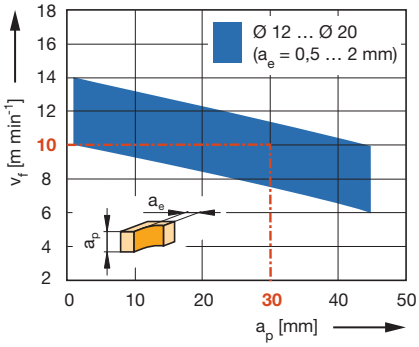
Workpiece material: Duromers, laminated materials (HPL, CPL)
Working step: Sizing
Speed: n = 14000 - 18000 rpm

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





Feed speed v_f depending on grooving depth a_p



Workpiece material: Softwood
Working step: Jointing
Speed: n = 18000 rpm
Correction factor for v_f:
Hardwood = 0.9;
Machining across grain = 0.7

Spiral finishing router cutter Marathon

Application:
Router cutter for sizing, grooving and finish cutting to high cutting quality. Z 3 design for high feed speeds.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

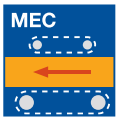
Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.), duromers, plastomers, mineral materials (Corian, Varicor etc.), gluelam (HPL, Trespa etc.).

Technical information:
Marathon coating for increased performance time and reduced resin build up. Ideally used after roughing cutters, finish cut allowance approx. 1-2 mm. Mirror finished cutting area ideal for machining thermoplastics.

HW solid, Z 3
WO 160-2-10

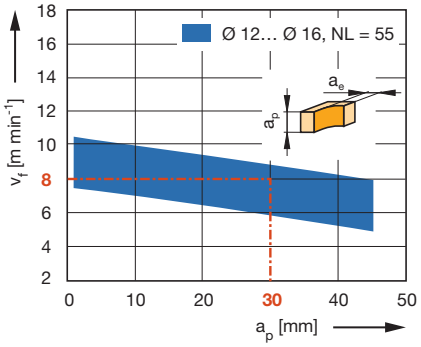
D mm	GL mm	NL mm	S mm	Z	Twist	DRI	ID	
12	80	35	12x40	3	RD	RL	**042790**	●
14	110	50	14x55	3	RD	RL	**042791**	●
16	110	55	16x55	3	RD	RL	**042792**	●
20	120	60	20x55	3	RD	RL	**042793**	●
20	130	75	20x50	3	RD	RL	**042794**	●

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



HW

Feed speed v_f depending on grooving depth a_p



Workpiece material: Softwood
Working step: Jointing
Speed: n = 18000 rpm
Correction factor for v_f:
Hardwood = 0.9;
Machining across grain = 0.7

Spiral finishing router cutter alternate twist angle

Application:
Router cutter for sizing, grooving and finish cutting to high cutting quality. For tear free cut edges on both sides.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.), duromers, plastomers, mineral materials (Corian, Varicor etc.), gluelam (HPL, Trespa etc.).

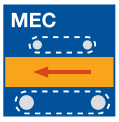
Technical information:
Ideally used after roughing cutters, finish cut allowance approx. 1-2 mm. Alternate twist for tear free cut edges on both sides. Z 1+1 design, suited for solid wood up to 50 mm thickness with roughing cut or 30 mm thickness without roughing cut.

HW solid, Z 1+1
WO 160-2-06

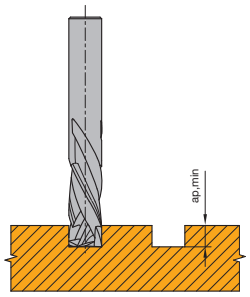
D mm	D in	GL mm	GL in	NL mm	NL in	S mm	S in	ID LL	ID RL
6,35	1/4“	76,2	3“	25,4	1“	6,35x40	1/4“x1 1/2“		**240513** ●
10		70		25		10x40		**042512** ●	**042511** ●
12		80		35		12x40			**042509** ●
16		110		55		16x50			**042543** ●

RPM: n = 16000 - 20000 min^{-1}

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

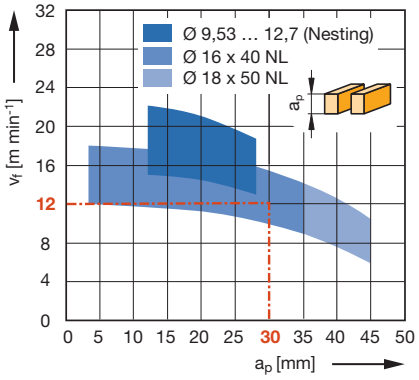


HW



Minimum grooving depth ap min for tear free cut.

Feed speed v_f depending on grooving depth a_p



Workpiece material: Plastic coated and veneered chipboard
Working step: Sizing
Speed: n = 18000 rpm
Correction factor v_f: MDF = 0.8; Machining across grain = 0.7

Spiral finishing router cutter alternate twist angle

Application:
Router cutter for sizing, grooving and finish cutting to high cutting quality. For tear free cut edges on both sides.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.), duromers, plastomers, mineral materials (Corian, Varicor etc.), gluelam (HPL, Trespa etc.).

Technical information:
Ideally used after roughing cutters, finish cut allowance approx. 1-2 mm. Alternate twist for tear free cut edges on both sides. Z 2+2 design for coated chipboard material and fibre material, gluelam, abrasive materials and compound materials with aluminium coating.

HW solid, Z 2+2, for abrasive materials
WO 160-2-06

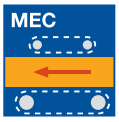
D mm	D in	GL mm	GL in	NL mm	NL in	S mm	S in	DRI	ID	
12		70		25		12x40		RL	**042536**	●
16		100		40		16x50		RL	**042537**	●
18		100		50		18x50		RL	**042538**	●
9,53	3/8“	76,2	3“	28,6	1 1/8“	9,53x40	3/8“x1 1/2“	RL	**240516**	●
12,7	1/2“	70	2 3/4“	25,4	1“	12,7x40	1/2“x1 1/2“	RL	**042795**	●
12,7	1/2“	76,2	3“	31,75	1 1/4“	12,7x40	1/2“x1 1/2“	RL	**042796**	●
12,7	1/2“	88,7	3 1/2“	38,1	1 1/2“	12,7x40	1/2“x1 1/2“	RL	**240517**	●

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

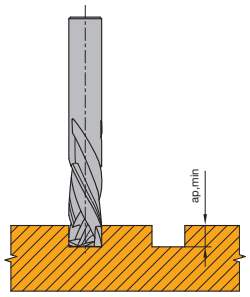
HW solid, Z 2+2, Nesting
WO 160-2-06

D mm	D in	GL mm	GL in	NL mm	NL in	S mm	S in	ap min mm	DRI	ID	
9,53	3/8“	76,2	3“	23	7/8“	9,53x40	3/8“x1 1/2“	5,5	RL	**240518**	●
9,53	3/8“	76,2	3“	28,6	1 1/8“	9,53x40	3/8“x1 1/2“	7	RL	**240503**	●
12,7	1/2“	76,2	3“	32	1 1/4“	12,7x40	1/2“x1 1/2“	5	RL	**240504**	●
12,7	1/2“	76,2	3“	32	1 1/4“	12,7x40	1/2“x1 1/2“	6	RL	**240505**	●
12,7	1/2“	88,9	3 1/2“	34,9	1 3/8“	12,7x40	1/2“x1 1/2“	6	RL	**240506**	●
12,7	1/2“	101,6	4“	43	1 5/8“	12,7x40	3/8“x1 5/8“	20	RL	**240507**	●

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

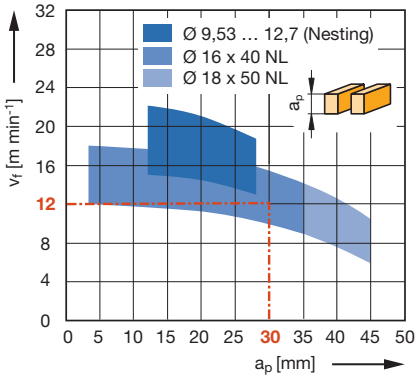


HW



Minimum grooving depth ap min for tear free cut.

Feed speed v_f depending on grooving depth a_p



Workpiece material: Plastic coated and veneered chipboard
Working step: Sizing
Speed: n = 18000 rpm
Correction factor v_f: MDF = 0.8; Machining across grain = 0.7

Spiral finishing router cutter alternate twist angle

Application:
Router cutter for sizing, grooving and finish cutting to high cutting quality. For tear free cut edges on both sides.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.), duromers, plastomers, mineral materials (Corian, Varicor etc.), gluelam (HPL, Trespa etc.).

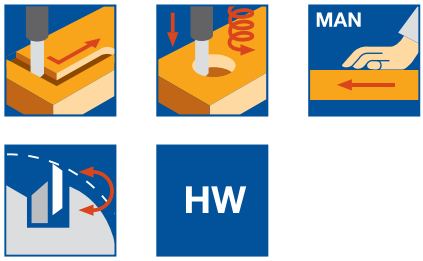
Technical information:
Ideally used after roughing cutters, finish cut allowance approx. 1-2 mm. Alternate twist for tear free cut edges on both sides. Z 2+2 design for coated chipboard material and fibre material, gluelam, abrasive materials and compound materials with aluminium coating.

HW solid, Z 3+3, Nesting
WO 160-2-06

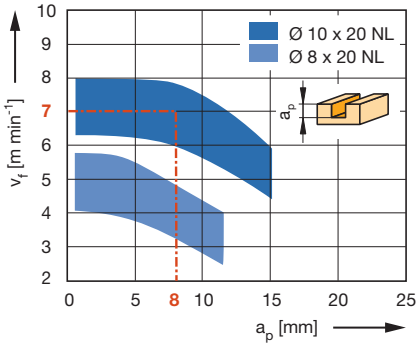
D mm	D in	GL mm	GL in	NL mm	NL in	S mm	S in	ap min mm	DRI	ID	
10		70		24		10x40		8	RL	**042797**	●
9,53	3/8“	76,2	3“	23	7/8“	9,53x40	3/8“x1 1/2“	6	RL	**240508**	●
9,53	3/8“	70	2 3/4“	23	7/8“	9,53x40	3/8“x1 1/2“	8	RL	**042798**	●

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

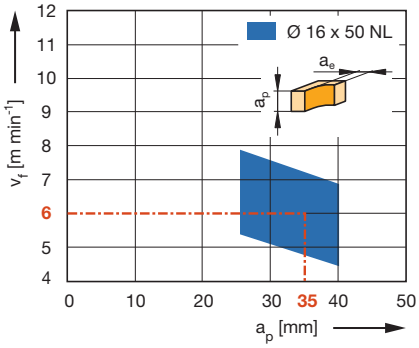
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Feed speed v_f depending on grooving depth a_p



Workpiece material: Plastic coated chipboard
Working step: Grooving, sizing
Speed: n = 18000 rpm
Correction factor for v_f: MDF = 0.8



Workpiece material: Plastic coated chipboard
Working step: Jointing (max. a_e = 3 mm)
Speed: n = 18000 rpm
Correction factor for v_f: MDF = 0.8

Router cutter - turnblade design

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

Machine:
Portable routers, overhead routers with/whithout CNC control, machining centres.

Workpiece material:
Softwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc.

Technical information:
Tungsten carbide turnblade knife clamped by wedge. Design without plunging tip only suitable for ramp plunging. Design with plunging tip suitable for axial plunging.

HW, Z 1, without plunging tip
WL 100-1

D mm	GL mm	NL mm	S mm	DRI	ID
8	65	20	10x40	RL	**041624** ●
9	65	20	10x40	RL	**041631** ●
10	65	20	10x40	RL	**041638** ●
10	70	25	10x40	RL	**041643** ●
11	75	30	10x40	RL	**041655** ●
12	76	30	10x40	RL	**041667** ●
14	86	40	12x40	RL	**041679** ●
16	94	50	12x40	RL	**041685** ●
16	109	50	16x50	RL	**041714** ●
20	99	50	12x40	RL	**041697** ●

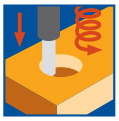
RPM: D 8 - 12 mm: n = 18000 - 24000 min^{-1}
D 14 - 24 mm: n = 16000 - 24000 min^{-1}

Spare knives:

BEZ	QAL	ABM mm	for D mm	NL mm	VE PCS	ID
Turnblade knife	HW-05	20x4,1x1,1	8 - 9	20	10	**005186** ●
Turnblade knife	HW-05	20x5,5x1,1	10 - 12	20	10	**005187** ●
Turnblade knife	HW-05	25x5,5x1,1	10	25	10	**005188** ●
Turnblade knife	HW-05	30x5,5x1,1	11 - 24	30	10	**005189** ●
Turnblade knife	HW-05	40x5,5x1,1	14	40	10	**005190** ●
Turnblade knife	HW-05	50x5,5x1,1	14 - 24	50	10	**005191** ●

Spare parts:

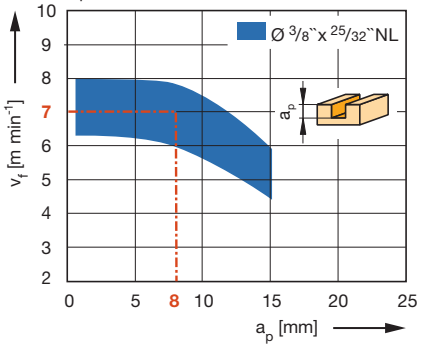
BEZ	ABM mm	for D mm	NL mm	ID
Clamping wedge	17,5x5,15x2,8	8 - 9	20	**009258** ●
Clamping wedge	17,5x6,45x4	10 - 11	20	**009259** ●
Clamping wedge	22,5x6,54x4	10	25	**009260** ●
Clamping wedge	27,5x6,45x4	11	30	**009261** ●
Clamping wedge	27,5x7,35x3,7	12 - 14	30	**009263** ●
Clamping wedge	37,5x7,35x3,7	14	40	**009264** ●
Clamping wedge	47,5x10,28x4,2	16 - 24	50	**009266** ●
Countersink screw, Torx® 8	M2,5x5,7	8 - 11		**006231** ●
Countersink screw, Torx® 8	M3x7.6	12 - 14		**006233** ●
Countersink screw, Torx® 15	M4x9.5	16		**007847** ●
Countersink screw, Torx® 15	M4x11.5	16 - 20		**006234** ●

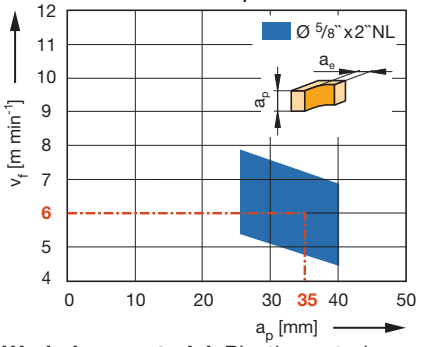


HW

Feed speed v_f depending on grooving depth a_p



Workpiece material: Plastic coated chipboard
Working step: Grooving, sizing
Speed: n = 18000 rpm
Correction factor for v_f: MDF = 0.8



Workpiece material: Plastic coated chipboard
Working step: Jointing (max. chip removal a_e = 3 mm)
Speed: n = 18000 rpm
Correction factor for v_f: MDF = 0.8

Router cutter - turnblade design

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

Machine:
Portable routers, overhead routers with/whithout CNC control, machining centres.

Workpiece material:
Softwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc.

Technical information:
Tungsten carbide turnblade knife clamped by wedge. Design without plunging tip only suitable for ramp plunging. Design with plunging tip suitable for axial plunging.

HW, Z 1, with plunging tip
WL 100-1

D mm	GL mm	NL mm	S mm	DRI	ID
14	107	45	12x40	RL	**041722** ●

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

Spare knives:

BEZ	QAL	ABM mm	for D mm	NL mm	VE PCS	ID
Turnblade knife	HW-05	50x5,5x1,1	14 - 24	50	10	**005191** ●

Spare parts:

BEZ	ABM mm	for D mm	NL mm	ID
Countersink screw, Torx® 8	M3x7.6	12 - 14		**006233** ●
Clamping wedge with plunging tip	45x3,7x7,35	14	45	**009749** ●

HW, Z 1, without plunging tip, inch dimensions
WL 100-1

D in	NL in	GL in	S in	DRI	ID
3/8“	25/32“	2 3/8“	1/2“ x 1 3/8“	RL	**041074** ●
1/2“	1 3/16“	2 3/4“	1/2“ x 1 3/8“	RL	**041060** ●
5/8“	2“	3 11/16“	1/2“ x 1 3/8“	RL	**041065** ●
3/4“	2“	3 7/8“	3/4“ x 1“	RL	**041067** ●

RPM: D 3/8“ - 1/2“: n = 18000 - 24000 min^{-1}
D 5/8“ - 3/4“: n = 16000 - 24000 min^{-1}

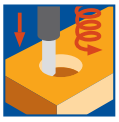
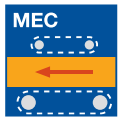
Spare knives:

BEZ	QAL	ABM mm	for D in	NL in	VE PCS	ID
Turnblade knife	HW-05	20x4,1x1,1	5/16“ - 3/8“	25/32“	10	**005186** ●
Turnblade knife	HW-05	30x5,5x1,1	1/2“	1 3/16“	10	**005189** ●
Turnblade knife	HW-05	50x5,5x1,1	5/8“ - 3/4“	2“	10	**005191** ●

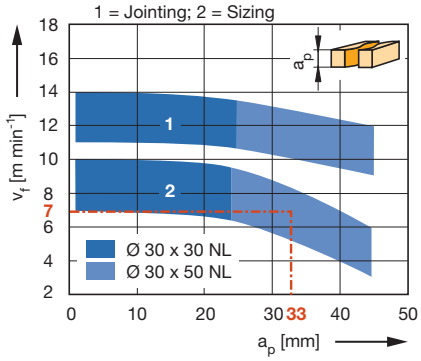
Spare parts:

BEZ	ABM mm	for D in	NL in	ID
Clamping wedge	17,5x5,15x2,8	5/16“ - 3/8“	25/32“	**009258** ●
Clamping wedge	27,5x7,35x3,7	1/2“ - 35/64“	1 3/16“	**009263** ●
Clamping wedge	47,5x10,28x4,2	5/8“ - 3/4“	2“	**009266** ●
Countersink screw, Torx® 8	M2,5x5,7	5/16“ - 3/8“		**006231** ●
Countersink screw, Torx® 8	M3x7.6	1/2“		**006233** ●
Countersink screw, Torx® 15	M4x11.5	5/8“ - 3/4“		**006234** ●

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


Feed speed v_f depending on grooving depth a_p
1 = Jointing cut a_e = 0.5 - 2 mm
2 = Sizing cut



Workpiece material: Plastic coated chipboard
Working step: Jointing, sizing
Speed: n =18,000 rpm
Correction factor for v_f: Machining across grain = 0.7; MDF = 0.8

Turnblade router cutter

Application:
Router cutter for sizing, grooving and finish cutting to finish quality. Z 2 for increased feed rates.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.).

Technical information:
Straight cut. Knife tip designed for stepless cut. Design with plunging tip for axial plunging. Suitable for machining the narrow edge of painted or foil coated MDF.

HW, Z 2
WL 101-2

D mm	GL mm	NL mm	S mm	ID LL		ID RL	
25	125	50	25x60	**040857**	●	**040858**	●
30	105	30	25x60			**040854**	●
30	125	50	25x60			**040853**	●

RPM: n = 14000 - 20000 min^{-1}

Spare knives:

BEZ	Knife	ABM mm	QAL	for D mm	VE PCS	ID	
Turnblade knife	Plunging tip	7,5x12x1,5	HW-05	25	10	**005080**	●
Turnblade knife	Plunging tip	12x12x1,5	HW-05	30	10	**005081**	●
Turnblade knife	Peripheral tip	30x12x1,5	HW-05	30	10	**005161**	●
Turnblade knife	Peripheral tip	50x12x1,5	HW-05	25/30	10	**006506**	●

Spare parts:

BEZ	Knife	ABM mm	for D mm	ID	
Screw	Plunging tip Peripheral tip	M4x5 (head D7)	25/30 25	**007037**	●
Screw	Peripheral tip	M4x5 (head D9)	30	**007038**	●
Torx® key		Torx® 15		**005457**	●

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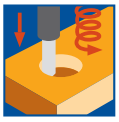
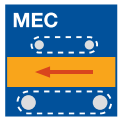
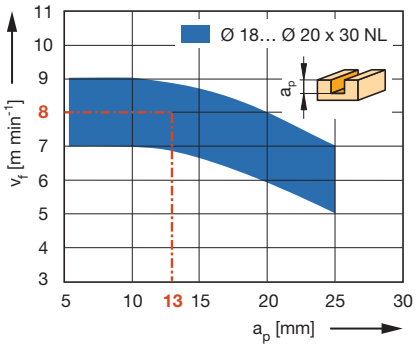
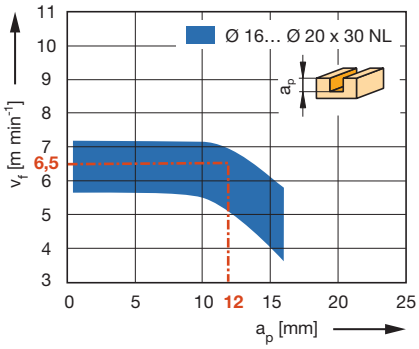




Feed speed v_f depending on grooving depth a_p



Workpiece material: Plastic coated chipboard
Working step: Grooving, sizing
Speed: n = 18000 rpm
Correction factor for v_f: MDF = 0.8



Workpiece material: Hardwood, along grain
Working step: Grooving, sizing
Speed: n = 18000 rpm
Correction factor for v_f: Machining across grain = 0.8

Turnblade router cutter

Application:
Router cutter for sizing and grooving to finish quality. For grooving with constant tool diameter.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.), duromers, plastomers, mineral materials (Corian, Varicor etc.), gluelam (HPL, Trespa etc.).

Technical information:
Straight cut. Knife tip designed for stepless cut. Teflon coated tool body for reduced resin and glue build up. With tungsten carbide plunging tip. Suitable for machining the narrow edge of painted or foil coated MDF.

HW, Z 1, NL 30 mm
WL 101-1

D mm	GL mm	NL mm	S mm	ID LL		ID RL	
16	80	30	10x35			**040861**	●
16	85	30	12x40			**040867**	●
16	95	30	16x50	**040877**	●	**040878**	●
16	95	30	20x50			**040879**	●
16	105	30	25x60			**040872**	●
18	85	30	12x40			**040869**	●
20	85	30	12x40			**040871**	●
20	95	30	20x50			**040882**	●

RPM: n = 16000 - 20000 min^{-1}

Spare knives:

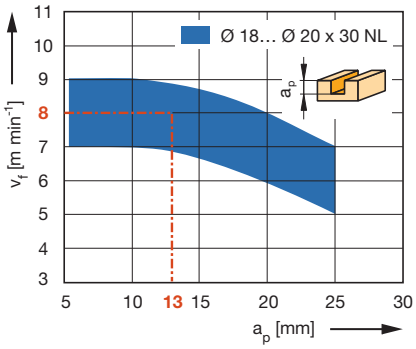
BEZ	Knife	ABM mm	QAL	for D mm	VE PCS	ID	
Turnblade knife	Plunging tip	7,5x12x1,5	HW-05	16 - 18	10	**005080**	●
Turnblade knife	Plunging tip	9x12x1,5	HW-05	20 - 24	10	**005158**	●
Turnblade knife	Peripheral tip	30x12x1,5	HW-05		10	**005161**	●

Spare parts:

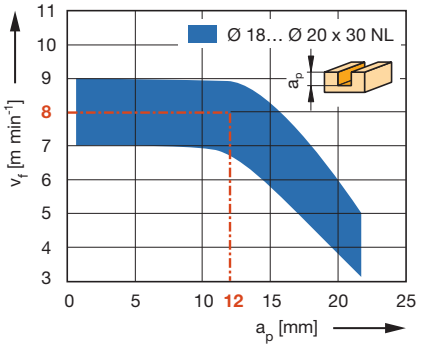
BEZ	Knife	ABM mm	for D mm	ID	
Screw	Plunging tip	M3,5x4 (head D7)	16 - 20	**006068**	●
Screw	Plunging tip	M4x5 (head D7)	22 - 24	**007037**	●
Screw	Peripheral tip	M3,5x4 (head D9)	16 - 20	**006226**	●
Screw	Peripheral tip	M4x5 (head D9)	22 - 24	**007038**	●
Torx® key		Torx® 15		**005457**	●

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

Feed speed v_f depending on grooving depth a_p



Workpiece material: Plastic coated chipboard
Working step: Grooving, sizing
Speed: n = 18000 rpm
Correction factor for v_f: MDF = 0.8



Workpiece material: Softwood, along grain
Working step: Grooving, sizing
Speed: n = 18000 rpm
Correction factor for v_f: Machining across grain = 0.8

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools or portable routers.

Technical information:
Straight cut. Knife tip designed for stepless cut. Teflon coated tool body for reduced resin and glue build up. With tungsten carbide turnblade knife plunging edge.

HW, Z 1, inch dimensions
WL 101-1

D in	NL in	GL in	S in	DRI	ID	
5/8“	1 11/64“	3 5/8“	1/2“ x 1 3/8“	RL	**041084**	●
3/4“	1 11/64“	3 5/8“	1/2“ x 1 3/8“	RL	**041085**	●

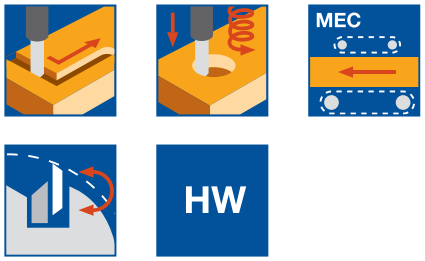
RPM: n = 16000 - 20000 min^{-1}

Spare knives:

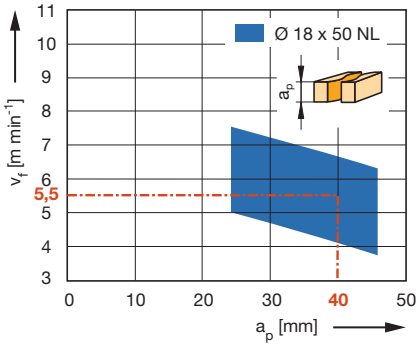
BEZ	Knife	ABM mm	QAL	for D mm	VE PCS	ID	
Turnblade knife	Plunging tip	7,5x12x1,5	HW-05	16 - 18	10	**005080**	●
Turnblade knife	Plunging tip	9x12x1,5	HW-05	20 - 24	10	**005158**	●
Turnblade knife		30x12x1,5	HW-05		10	**005161**	●

Spare parts:

BEZ	Knife	ABM mm	for D mm	for D in	ID	
Screw	Plunging tip	M3,5x4 (head D7)	16 - 20	5/8“ - 3/4“	**006068**	●
Screw	Plunging tip	M4x5 (head D7)	22 - 24		**007037**	●
Screw	Peripheral tip	M3,5x4 (head D9)	16 - 20	5/8“ - 3/4“	**006226**	●
Screw	Peripheral tip	M4x5 (head D9)	22 - 24		**007038**	●
Torx® key		Torx® 15			**005457**	●



Feed speed v_f depending on grooving depth a_p



Workpiece material: Plastic coated chipboard
Working step: Sizing
Speed: n = 18000 rpm
Correction factor for v_f: MDF = 0.8

Turnblade router cutter

Application:
Router cutter for sizing and grooving. For grooving with constant tool diameter.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc.

Technical information:
Straight cut. Teflon coated tool body for reduced resin and glue build up. Limitedly suitable for finish cut. Cutting edge overlap visible on workpiece. With tungsten carbide turnblade knife plunging tip.

HW, Z 1+1, with staggered cutting edges
WL 101-2

D mm	GL mm	NL mm	S mm	DRI	ID	
18	125	50	25x60	RL	**040925**	●
20	133	58	25x60	RL	**040928**	●

RPM: n = 16000 - 20000 min^{-1}

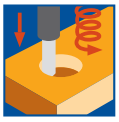
Spare knives:

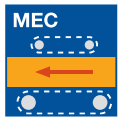
BEZ	Knife	ABM mm	QAL	for D mm	VE PCS	ID	
Turnblade knife	Plunging tip	7,5x12x1,5	HW-05	16 - 18	10	**005080**	●
Turnblade knife	Plunging tip	9x12x1,5	HW-05	20 - 24	10	**005158**	●
Turnblade knife	Peripheral tip	30x12x1,5	HW-05		10	**005161**	●

Spare parts:

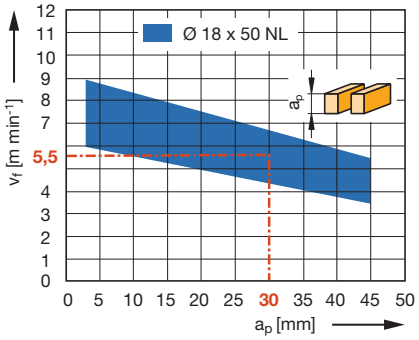
BEZ	Knife	ABM mm	for D mm	ID	
Screw	Plunging tip	M4x5 (head D7)	18 - 24	**007037**	●
Screw	Peripheral tip	M4x5 (head D9)	18 - 24	**007038**	●
Torx® key		Torx® 15		**005457**	●

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





Feed speed v_f depending on grooving depth a_p



Workpiece material: Plastic coated chipboard
Working step: Sizing
Speed: n = 18000 rpm
Correction factor for v_f: MDF = 0.8

Turnblade router cutter

Application:
Router cutter for sizing and grooving to finish quality. For grooving with constant tool diameter.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc.

Technical information:
Straight cut. Teflon coated tool body for reduced resin and glue build up. Limitedly suitable for finish cut. Cutting edge overlap visible on workpiece. With tungsten carbide turnblade knife plunging tip.

HW, Z 1+1, with 50 mm/30 mm turnblade knives
WL 101-1

D mm	GL mm	NL mm	S mm	ID LL		ID RL	
18	115	50	16x50	**040846**	●	**040847**	●
18	115	50	20x50			**040848**	●
18	125	50	25x60	**040849**	●	**040850**	●

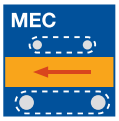
RPM: n = 16000 - 20000 min^{-1}

Spare knives:

BEZ	Knife	ABM mm	QAL	VE PCS	ID	
Turnblade knife	Plunging tip	7,5x12x1,5	HW-05	10	**005080**	●
Turnblade knife	Peripheral tip	30x12x1,5	HW-05	10	**005161**	●
Turnblade knife	Peripheral tip	50x12x1,7	HW-05	10	**007668**	●

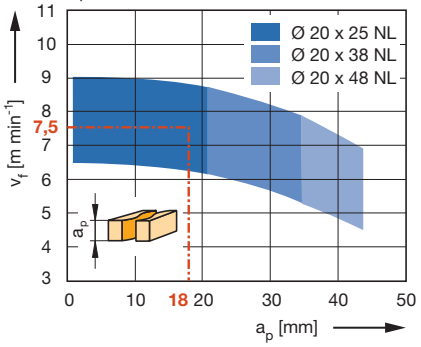
Spare parts:

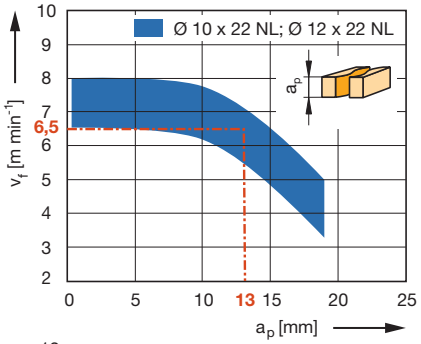
BEZ	Knife	ABM mm	ID	
Screw	Plunging tip	M4x5 (head D7)	**007037**	●
Screw	Peripheral tip	M4x5 (head D9)	**007038**	●
Torx® key		Torx® 15	**005457**	●

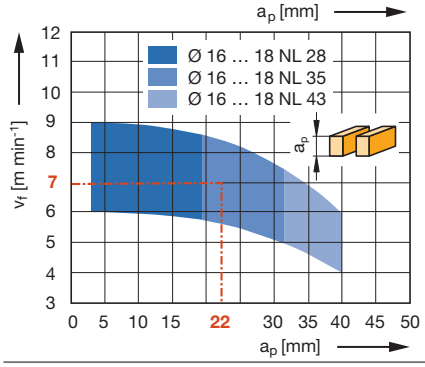



DP

Feed speed v_f depending on grooving depth a_p







Router cutter Diamaster PRO

Application:
Router cutter for sizing and grooving with increased performance time in particle boards. For tear free cut edges on both sides. Suitable for small and medium batch quantities.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc.

Technical information:
Spiral cutting edge arrangement with alternate shear angles and tungsten carbide plunging tip. Resharpenable 3 to 5 times with normal wear. Cuts to be painted in MDF require finishing with tools with continuous edges.

DP, Z 1+1
WO 140-2-50

D mm	GL mm	NL mm	S mm	ID LL	ID RL	
10	70	22	12x40		**091264**	●
12	70	22	12x40		**091265**	●
12	100	28	25x60		**091266**	●
14	90	28	16x50		**091267**	●
16	80	22	16x50		**091268**	●
16	95	22	25x60		**091269**	●
16	90	28	16x50	**091271**	**091270**	●
16	100	28	25x60		**091272**	●
16	95	35	20x50		**091273**	●
16	105	35	25x60		**091274**	●
16	115	43	25x60	**091276**	**091275**	●
18	90	28	20x50		**091277**	●
18	95	35	20x50		**091278**	●
18	105	43	20x50	**091281**	**091280**	●
18	115	43	25x60		**091282**	●
20	90	28	16x50		**091283**	●
20	100	28	25x60	**091285**	**091284**	●
20	95	35	20x50		**091286**	●
20	105	35	25x60		**091287**	●
20	105	43	20x50	**091289**	**091288**	●
20	115	43	25x60		**091290**	●
20	110	48	20x50	**091292**	**091291**	●
20	120	48	25x60	**091294**	**091293**	●
20	125	53	25x60		**091295**	●
20	130	58	25x60		**191041**	●

RPM: n = 18000 - 24000 min^{-1}

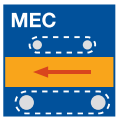
DP, Z 1+1, inch dimensions
WO 140-2-50

D mm	D in	GL mm	GL in	NL mm	NL in	S mm	S in	DRI	ID	
12,7	1/2“	70	2 3/4“	22,23	7/8“	12,7x38	1/2“ x 1 1/2“	RL	**091296**	●
19,05	3/4“	110	4 3/8“	48	1 7/8“	19,05x50	3/4“ x 2“	RL	**091297**	●

RPM: n = 18000 - 24000 min^{-1}

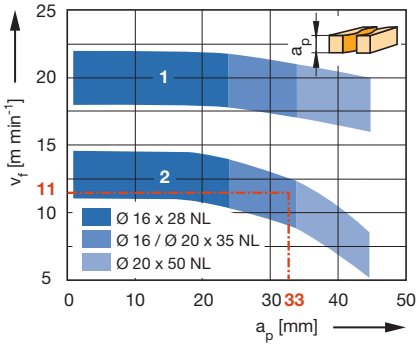
Workpiece material: Plastic coated chipboard
Working step: Sizing
Speed: n = 18000 rpm
Correction factor for v_f: MDF = 0.8; Uncoated chipboard = 1.1; Veneer across grain = 0.7

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



DP

Feed speed v_f depending on grooving depth a_p
1 = Jointing cut a_e 0.5 - 2.0 mm
2 = Sizing cut



Workpiece material: Plastic coated chipboard
Working step: Jointing, sizing
Speed: n = 18000 rpm
Correction factor for v_f: MDF = 0.6; Veneer across grain = 0.7

Router cutter Diamaster PRO

Application:
Router cutter for sizing and grooving with increased performance time in particle boards. For tear free cut edges on both sides. Suitable for medium batch quantities. Z 2+2 for increased feed speeds.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc.

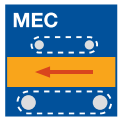
Technical information:
Spiral cutting edge arrangement with alternate shear angles and DP plunging tip. Resharpenable 3 to 5 times with normal wear. Cuts to be painted in MDF require finishing with tools with continuous edges.

DP, Z 2+2
WO 140-2-50

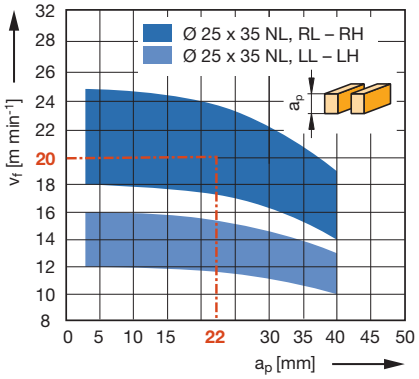
D mm	GL mm	NL mm	S mm	DRI	ID	
16	90	28	20x50	RL	**191042**	●
16	95	35	20x50	RL	**191043**	●
20	95	35	20x50	RL	**191044**	●
20	105	35	25x60	RL	**191045**	●
20	110	50	20x50	RL	**191046**	●
20	120	50	25x60	RL	**191047**	●

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






Feed speed v_f depending on grooving depth a_p



Router cutter Diamaster PRO, Z3+3 / Z2+2
Workpiece material: Plastic coated chipboard
Working step: Sizing
Speed: n = 18000 rpm
Correction factor for v_f: MDF = 0.8; Uncoated chipboard = 1.1; Veneer across grain = 0.7

Router cutter Diamaster PRO

Application:
Router cutter for sizing and grooving with increased performance time in particle boards. For tear free cut edges on both sides of the workpiece. Suitable for right hand and left hand cutting (e.g. protective cutting) without tool change.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., for tear free edges on both sides of coated workpieces.

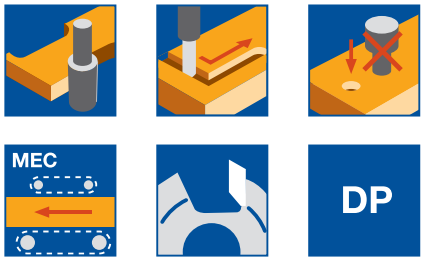
Technical information:
Spiral cutting edge arrangement with tungsten carbide plunging tip. Right hand rotation: Z 3+3, left hand rotation: Z 2+2. Resharpenable 3 to 5 times with normal wear. Right and left hand rotation in one tool (by adjusting the Z-axis and changing the direction of rotation).

DP, RH + LH combination tool
WO 140-2-50

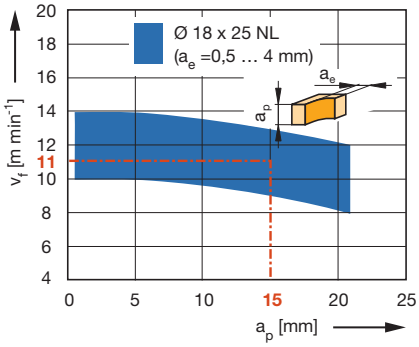
D mm	GL mm	NL mm	S mm	DRI	ID	
25	120	24 + 24	25x50	LL / RL	**191034**	●
25	145	35 + 35	25x55	LL / RL	**191020**	●

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 grooving depth a_p



Workpiece material: Plastic coated chipboard
Working step: Sizing
Speed: n = 18000 rpm
Correction factor for v_f: MDF = 0.9; Veneer across grain = 0.7

Router cutter Diamaster PRO

Application:
Router cutter for sizing and grooving with continuous cutting edge. Suitable for machining edges of painted or foil coated MDF.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

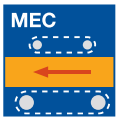
Workpiece material:
Hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., duromers, plastomers, gluelam (HPL, Trespa etc.)

Technical information:
Negative cutting edge shear angles (only for ID **91158**) for tear free edges during grooving and to support the workpiece clamping of smaller parts. Resharpenable 3 to 5 times with normal wear. Maximum chip removal 4 mm; roughing cut required for higher chip removal.

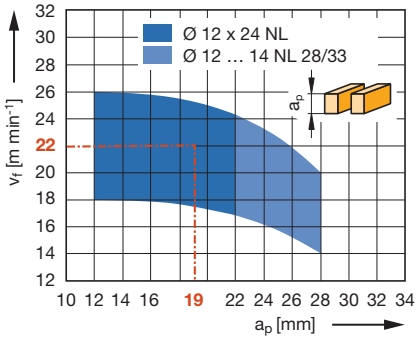
DP, Z 1 / Z 2
WO 140-2-50

D mm	GL mm	NL mm	S mm	Z	DRI	ID	
8	60	12	12x40	1	RL	**090154**	●
10	70	12	12x40	2	RL	**091158**	●
18	90	25	16x50	2	RL	**091190**	●

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


Feed speed v_f depending on grooving depth a_p



Workpiece material: Plastic coated chipboard
Working step: Sizing / Nesting
Speed: n = 24000 rpm
Correction factor for v_f: MDF = 0.8;
Uncoated chipboard = 1.1;
Veneer across grain = 0.7;
Pre-trimming MDF = 1.2

Table of optimal workpiece thickness

Id.	NL	workpiece thickness
191030	19	9 – 16 mm
191031	24	13 – 20 (22) mm
191032	28	19 – 25 mm
191033	33	20 – 28 mm

Router cutter Diamaster PRO^3

Application:
Router cutter for sizing and grooving (Nesting) at high feed speeds. For tear free cut edges on both sides of the workpiece.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc.

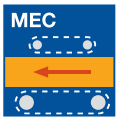
Technical information:
Spiral cutting edge arrangement with alternate shear angles and real - Z 3 over the complete cutting length, with DP plunging tip. Resharpenable up to 3 times for normal wear. Tool body designed in stable material. Important to follow the application data parameters.

DP, Z 3+3, Nesting
WO 140-2-50

D mm	GL mm	NL mm	S mm	DRI	ID	
12	65	19	12x42	RL	**191030**	●
12	70	24	12x42	RL	**191031**	●
12	75	28	12x40	RL	**191032**	●
14	90	33	16x50	RL	**191033**	●

RPM: n max. = 24000 min^{-1}

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



DP

Router cutter Diamaster PLUS

Application:
Router cutter for sizing and grooving with increased performance time in particle boards. For tear free cut edges on both sides.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., duromers, plastomers, gluelam (HPL, Trespa etc.).

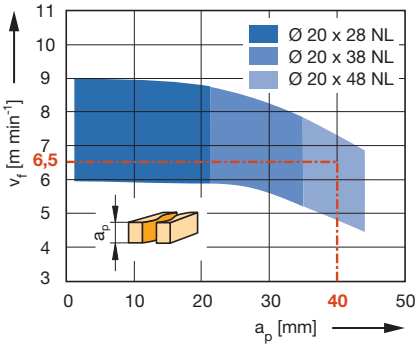
Technical information:
Cutting edges with alternate shear angle and tungsten carbide plunging tip. Resharpenable 5 to 8 times with normal wear. Cuts for painting in MDF require finishing with tools with continuous edges. Stable tipping suitable for machining abrasive and hard to machine materials (HPL, Trespa, GfK, CfK etc.).

DP, Z 1+1
WO 140-2

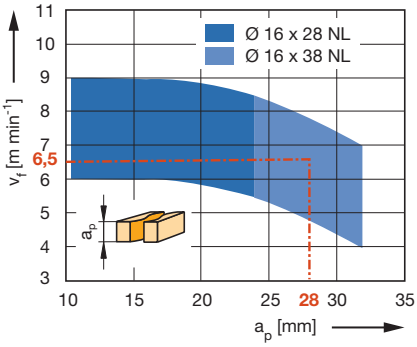
D mm	GL mm	NL mm	S mm	DRI	ID
12	90	24	16x50	RL	**090174** ●
16	90	28	20x60	RL	**090188** ●
18	110	48	20x60	RL	**091101** ●
20	130	58	25x60	RL	**090167** ●

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

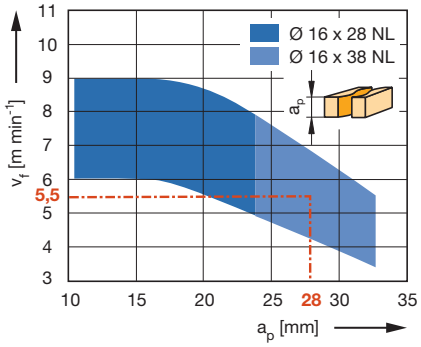
Feed speed v_f depending on grooving depth a_p



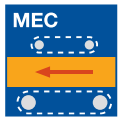
Workpiece material: Plastic coated chipboard
Working step: Sizing
Speed: n = 18000 rpm
Correction factor for v_f: MDF = 0.8; Veneer across grain = 0.7



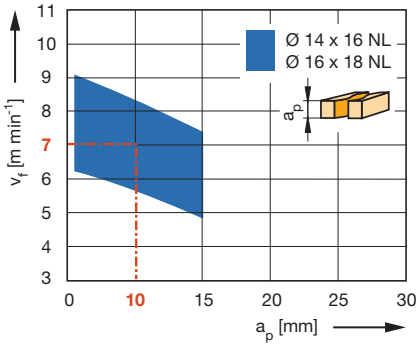
Workpiece material: Plastic coated chipboard
Working step: Sizing
Speed: n = 18000 rpm
Correction factor for v_f: MDF = 0.8; Chipboard = 1.3; Veneer across grain = 0.7



Workpiece material: Glulam
Working step: Sizing
Speed: n = 18000 rpm



Feed speed v_f depending on grooving depth a_p



Workpiece material: Duromers, gluelam (HPL, CPL), fibre reinforced plastics
Working step: Sizing
Speed: n = 12000 - 18000 rpm

Router cutter Diamaster PLUS

Application:
Router cutter for sizing and grooving with stepless cut. Suitable for machining the edges of painted or foil coated MDF.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., duromers, plastomers, gluelam (HPL, Trespa etc.).

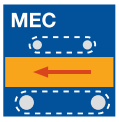
Technical information:
Negative cutting edge shear angles during grooving for tear free edges and to support the clamping of smaller parts. Resharpenable 5 to 8 times with normal wear. The short stable cutting edge ideal for grooving and sizing abrasive and hard to machine materials (HPL, Trespa, GfK, CfK etc.).

DP, Z 2
WO 120-2-60

D mm	GL mm	NL mm	S mm	Z	DRI	ID	
14	80	16	20x50	2	RL	**091157**	●
16	80	18	20x50	2	RL	**091156**	●

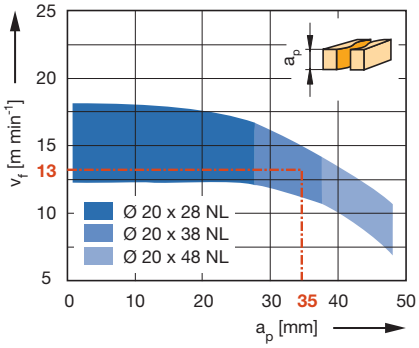
RPM: for wood materials: n = 16000 - 36000 min^{-1}
for plastics: n = 12000 - 18000 min^{-1}

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

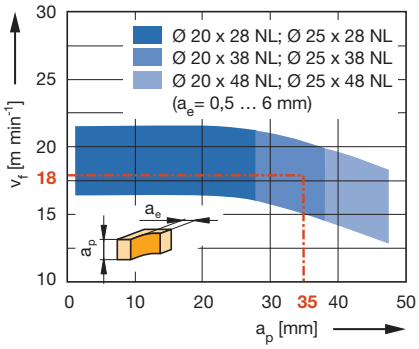


DP

Feed speed v_f depending on grooving depth a_p



Workpiece material: Plastic coated chipboard
Working step: Sizing
Speed: n = 18000 rpm
Correction factor for v_f: MDF = 0.6; Paper coated = 0.8



Workpiece material: Plastic coated chipboard
Working step: Jointing
Speed: n = 18000 rpm
Correction factor for v_f: MDF = 0.9; Paper coated = 0.8; Veneer across grain = 0.8

Router cutter Diamaster QUATTRO

Application:
Router cutter for sizing and grooving with increased performance time in particle boards. For tear free cut edges on both sides. Suitable for medium and large batch quantities. Z 2+2 for increased feed speeds.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc.

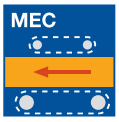
Technical information:
Spiral cutting edge arrangement with alternate shear angles and tungsten carbide plunging tip. Resharpenable 5 to 8 times with normal wear. Cuts for painting in MDF require finishing with tools with continuous edges.

DP, Z 2+2
WO 140-2

D mm	GL mm	NL mm	S mm	ID LL		ID RL	
20	90	28	20x50			**091235**	●
20	110	48	20x50			**091238**	●
20	110	38	25x60			**091241**	●
20	120	48	25x60	**091246**	●	**091247**	●
25	110	38	25x60			**091251**	●
25	120	48	25x60	**091252**	●	**091253**	●

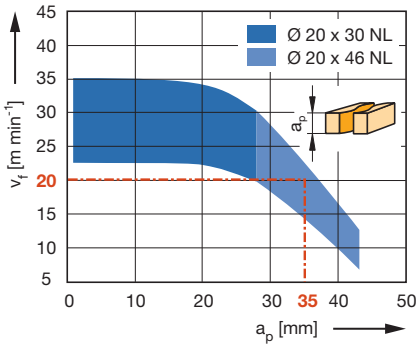
RPM: n = 16000 - 24000 min^{-1}

5

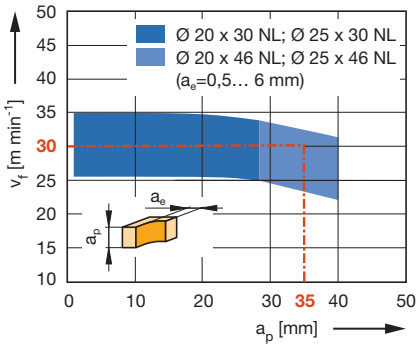


DP

Feed speed v_f depending on grooving depth a_p



Workpiece material: Plastic coated chipboard
Working step: Sizing
Speed: n = 24000 rpm
Correction factor for v_f: MDF = 0.8; Paper coated = 0.8



Router cutter Diamaster PLUS, Z 3+3

Application:
Router cutter for sizing and grooving with increased performance time in particle boards. For tear free cut edges on both sides. Suitable for large batch quantities. Z 3+3 at high feed speeds.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc.

Technical information:
Spiral cutting edge arrangement with alternate shear angles and DP plunging tip. Resharpenable 8 to 12 times with normal wear. Cuts for painting in MDF require finishing with tools with continuous edges. Tools with negative twist to support the workpiece clamping, particularly small parts.

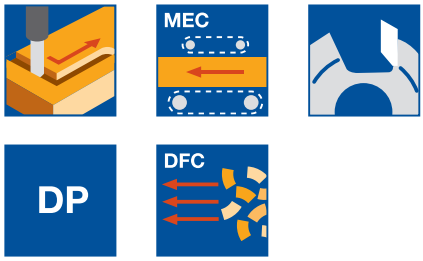
DP, Z 3+3, with negative twist
WO 140-2

D mm	GL mm	NL mm	S mm	ID LL		ID RL	
18	100	24	25x60			**091204**	●
20	90	24	20x50			**091207**	●
20	100	24	25x60			**091209**	●
20	105	30	25x60	**091170**	●	**091171**	●
20	110	38	25x60			**091211**	●
20	120	46	25x60			**091174**	●
25	100	24	25x60			**091213**	●
25	105	30	25x60	**091176**	●	**091177**	●
25	110	38	25x60	**091214**	●	**091215**	●
25	120	46	25x60	**091179**	●	**091180**	●

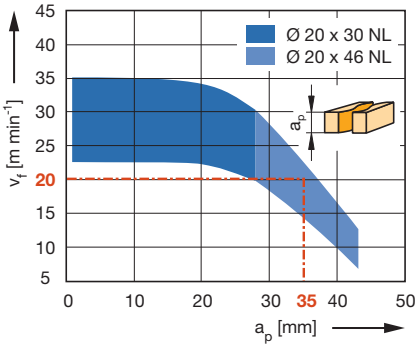
RPM: n = 16000 - 24000 min^{-1}

Workpiece material: Plastic coated chipboard
Working step: Jointing
Speed: n = 24000 rpm
Correction factor for v_f: MDF = 0.9; Paper coated = 0.8; Veneer across grain = 0.8

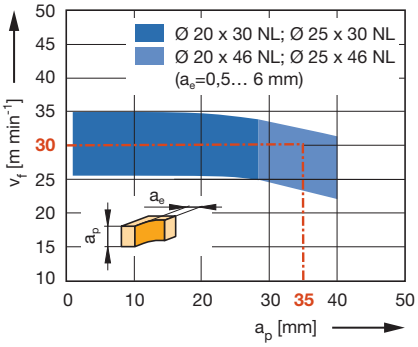
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Feed speed v_f depending on grooving depth a_p



Workpiece material: Plastic coated chipboard
Working step: Sizing
Speed: n = 24000 rpm
Correction factor for v_f: MDF = 0.8; Paper coated = 0.8



Router cutter Diamaster PLUS, Z 3+3

Application:
Router cutter for sizing and grooving with increased performance time in particle boards. For tear free cut edges on both sides. Suitable for large batch quantities. Z 3+3 at high feed speeds.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc.

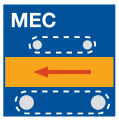
Technical information:
Spiral cutting edge arrangement with alternate shear angles and DP plunging tip. Resharpenable 8 to 12 times with normal wear. Cuts to be painted in MDF require finishing with tools with continuous edges. Tools with positive twist for good chip removal into the extraction system - LEITZ DFC®.

DP, Z 3+3, with positive twist, DFC-design
WO 140-2

D mm	GL mm	NL mm	S mm	ID LL	ID RL	
16	100	24	20x50		**091254**	●
20	105	30	25x60		**191026**	●
25	105	30	25x60		**191027**	●
25	110	38	25x60		**091217**	●
25	120	46	25x60	**091218**	**091219**	●

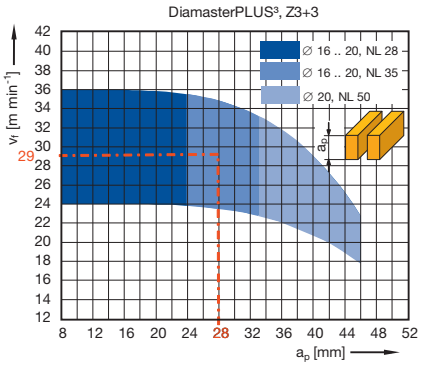
RPM: n = 16000 - 24000 min^{-1}

Workpiece material: Plastic coated chipboard
Working step: Jointing
Speed: n = 24000 rpm
Correction factor for v_f: MDF = 0.9; Paper coated = 0.8; Veneer across grain = 0.8



DP

Feed speed v_f depending on grooving depth a_p



Workpiece material: Plastic coated chipboard
Working step: Sizing
Speed: n = 24000 rpm
Correction factor for v_f: MDF = 0.8; chipboard, uncoated = 1.1; Veneer across grain = 0.7; pre cutting MDF = 1.2

Router cutter Diamaster PLUS³, Z 3+3

Application:
Router cutter for sizing and grooving with increased performance time in particle boards. For tear free cut edges on both sides. Suitable for large batch quantities. Z 3+3 for high feed speeds.

Machine:
Overhead routers with/without CNC control, machining centres, special router machines with spindles to mount shank tools.

Workpiece material:
Chipboard and fibre working materials (MDF, HF, etc.), uncoated, plastic coated, veneered, etc.

Technical information:
Spiral cutting edge arrangement with alternate shear angles and real-Z3 over the complete cutting length. DP plunging tip. Resharpenable 8 to 12 times with normal wear. Cuts to be painted in MDF require finishing with tools with continuous edges. Tools with negative twist support the tool clamping especially for small parts.

DP, Z 3+3, with negative shear angle
WO 140-2

D mm	GL mm	NL mm	S mm	ID LL		ID RL	
16	85	28	20x50			**191048**	●
16	95	35	20x50	**191050**	●	**191049**	●
20	85	28	20x50			**191051**	●
20	105	35	25x60	**191053**	●	**191052**	●
20	120	50	25x60	**191055**	●	**191054**	●

RPM: n = 18000 - 24000 min^{-1}

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

Reciprocating slotting cutter

Application:
Router cutter for cutting tear free longitudinal slots with step wise infeed.

Machine:
Special routers with reciprocating spindles.

Workpiece material:
Softwood and hardwood, gluelam.

Technical information:
HS design: for softwood and hardwood. Tungsten carbide design: for softwood and hardwood and glued boards. Suitable for right hand and left hand rotation, tools resharpenable on the narrow side. Diameter constant after sharpening.

HS, Z 2
WB 510-0

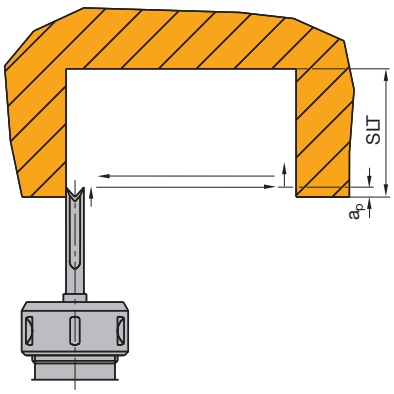
D mm	GL mm	S mm	SLT mm	QAL	ID	
6	90	13x40	38	HS	**037020**	●
8	95	13x40	42	HS	**037022**	●
9	100	13x40	45	HS	**037023**	●
10	105	13x40	50	HS	**037024**	●
12	115	13x40	60	HS	**037026**	●
13	120	13x40	65	HS	**037027**	●

RPM: n = 4500 - 9000 min^{-1}

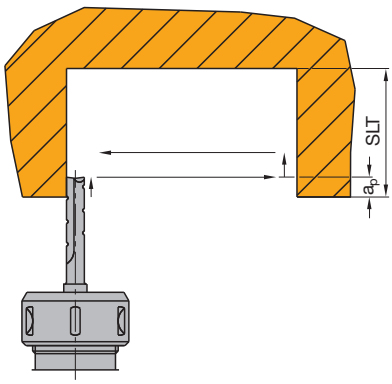
HW tipped, Z 2
WB 510-0

D mm	GL mm	S mm	SLT mm	QAL	ID	
8	95	13x40	42	HW	**037028**	●
10	105	13x40	50	HW	**037029**	●

RPM: n = 6000 - 15000 min^{-1}



Example of slot production
a_p = 0.8 mm (reciprocating movement)



Example of slot production
a_p = 5 - 15 mm per stroke

Slot mortise bits

Application:
Router cutter for cutting tear free longitudinal slots with step wise infeed.

Machine:
Slot mortiser.

Workpiece material:
Softwood and hardwood.

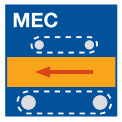
Technical information:
Straight cut with chip breaker for reduced cutting forces. High tool rigidity from special heat treatment.

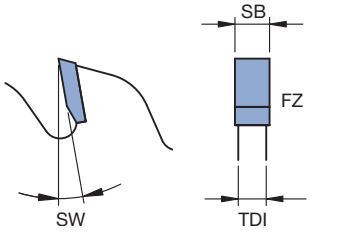
SP, Z 2
WB 401-0, WB 401-1

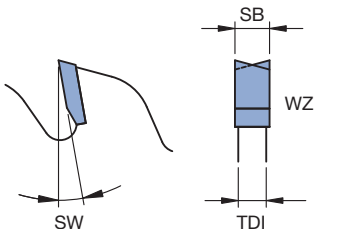
D mm	GL mm	S mm	SLT mm	ID LL		ID RL	
6	120	13x50	60	**037140**	●	**037163**	●
8	130	13x50	70	**037142**	●	**037165**	●
8	130	16x50	70			**037182**	●
10	140	13x50	80	**037144**	●	**037167**	●
10	140	16x50	80			**037183**	●
12	150	13x50	90	**037146**	●	**037169**	●
12	150	16x50	90			**037184**	●
13	155	13x50	95			**037170**	●
14	160	13x50	100	**037148**	●	**037171**	●
14	160	16x50	100			**037185**	●
15	165	13x50	105			**037172**	●
16	170	16x50	110	**037150**	●	**037173**	●
18	180	16x50	120			**037174**	●
20	185	16x50	125			**037175**	●
22	190	16x50	130			**037176**	●
24	195	16x50	135			**037177**	●

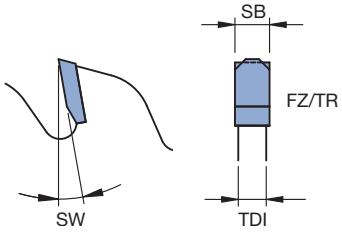
RPM: n = 6000 - 12000 min^{-1}

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









Circular sawblades for processing units

Application:
For sizing, dividing and grooving.

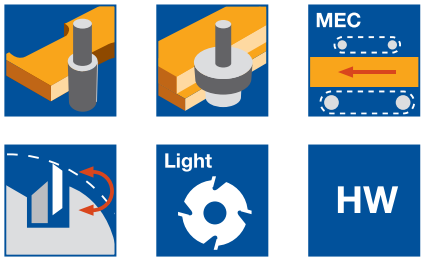
Machine:
Overhead routers with/without CNC control, aggregates on CNC machining centres.

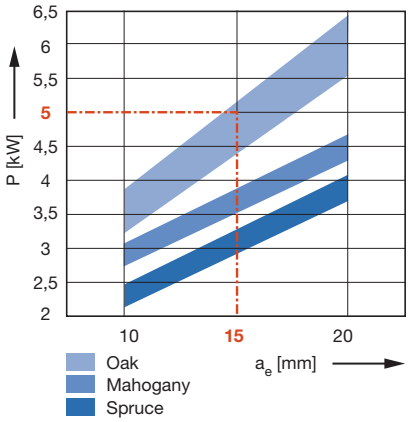
Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.).

Technical information:
Mounting on sawblade flange or machine aggregate, in some cases additional pinholes must be drilled before mounting. When sizing coated wood derived materials, first score with feed on little infeed (1 -2 mm) and then split against feed.

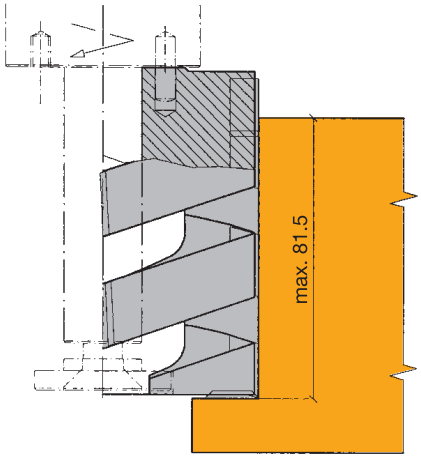
Multi purpose cuts and grooving
WK 250-2, WK 800-2, WK 850-2, WK 850-2-01, WK 850-2-03, WK 850-2-10, WK 850-2-MA

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW Degree	ID	
Biesse	180	3,2	2,2	30	4/5,5/45	58	WZ	10	**058322**	□
Biesse	180	3,2	2,2	30	2/6/42	58	WZ	10	**058323**	□
Biesse	215	4,0	2,8	35	6/5,5/54 2/6/50	50	WZ	10	**058321**	●
Biesse	250	3,2	2,2	35	2/6/50	60	WZ	10	**069546**	□
Biesse	250	3,2	2,2	48	4/5,5/61	60	WZ	10	**069547**	□
Biesse	270	3,2	2,2	35	2/6/50 6/5,5/54	60	WZ	10	**058233**	●
Holz Her	180	3,5	2,5	30	4/5,5/52	36	WZ	10	**058076**	□
Holz Her	180	3,2	2,2	30	2/6/42	58	WZ	10	**058323**	□
Holz Her	220	3,2	2,2	30	2/7/42	64	WZ	10	**060662**	□
Holz Her	220	3,2	2,2	30	4/5,5/45	64	WZ	10	**060663**	□
Holz Her	250	3,2	2,2	30	KNL	60	WZ	10	**058382**	●
Homag	125	2,4	1,6	30	8/6,5/48	36	WZ	10	**058234**	●
Homag	180	3,5	2,5	30	4/5,5/52	36	WZ	10	**058076**	□
Homag	220	3,2	2,2	40	8/5,5/52	64	FZ/TR	10	**061363**	□
Homag	240	3,0	1,8	30	4/5,5/52	48	WZ	10	**058077**	□
Homag	240	3,0	1,8	40	8/5,5/52	48	WZ	10	**070125**	□
Homag	240	3,2	2,2	40	8/5,5/52	54	FZ/TR	10	**059703**	□
Homag	280	3,2	2,2	30	KNL	48	WZ	10	**060672**	●
Universal	120	4,0	3,0	20	1/6/46	30	WZ	10	**058226**	●
Universal	150	4,0	3,0	20		30	WZ	10	**058227**	●
Universal	160	4,0	3,0	20	1/6/46	36	WZ	10	**058228**	●
Universal	180	4,0	3,0	20	1/6/46	42	WZ	10	**058229**	●
Universal	200	4,0	3,0	20	1/6/46	42	WZ	10	**058230**	●
Universal	250	3,2	2,2	30	KNL	48	WZ	10	**058202**	●
Weeke	125	2,4	1,6	30	8/6,5/48	36	WZ	10	**058234**	●
Weeke	125	3,2	2,5	30	8/5,5/48	36	FZ	10	**060641**	●
Weeke	125	4,0	2,8	30	8/5,5/48	36	FZ	10	**061300**	●
Weeke	220	3,2	2,2	40	8/5,5/52	64	FZ/TR	10	**061363**	□
Weeke	240	3,0	1,8	30	4/5,5/52	48	WZ	10	**058077**	□
Weeke	240	3,0	1,8	40	8/5,5/52	48	WZ	10	**070125**	□
Weeke	240	3,2	2,2	40	8/5,5/52	54	FZ/TR	10	**059703**	□





Motor power P depends on workpiece material and cutting depth a_e. For tool diameter D-80mm, Z 2, workpiece thickness a_p = 60 mm, n = 12000 rpm and vf 4 m/min^{-1}



Rebating

Copy shaping cutterhead

Application:
For pre cutting, jointing, copy shaping and rebating. Particularly suitable for deep cutting depths. Roughing cut quality for subsequent profiling and jointing.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.).

Technical information:
Tungsten carbide turnblade knives Z 2 with shear angle in spiral arrangement for high cut performance and optimised chip removal. Staggered cut for reduced cutting forces. With spurs for tear free rebating in softwood and hardwood.

HW, Z 2+2 / V2 / V4
SL 499-2, WW 220-1, WW 499-2

Tool Type	ABM mm	QAL	AM PCS	Z	V	ID	
Cutterhead	80x80,7/83x20	HW	12	2	2	**407193**	●
Cutterhead mounted on arbor	1 part	HW	12	2	2	**426047**	□
Cutterhead	125x80,9x30;	HW	12	2	4	**407196**	●
Cutterhead mounted on arbor	1 part	HW	12	2	4	**426050**	□
Cutterhead	125x94,8x30	HW	14	2	4	**410696**	●
Cutterhead mounted on arbor	1 part	HW	14	2	4	**426084**	□
Cutterhead	125x120,8x30	HW	18	2	4	**411197**	□
Cutterhead mounted on arbor	1 part	HW	18	2	4	**426091**	□

RPM: D 80 mm: n max. = 18000 min^{-1}
D 125 mm: n max. = 12200 min^{-1}

Tool with HW turnblade knives for solid wood.
Cutter arbor see section 8 Clamping systems.

Please note:
When ordering - only use the following cutter arbors:

D	clamping length	d
80 mm	70 mm	20 mm
125 mm	80 mm	30 mm

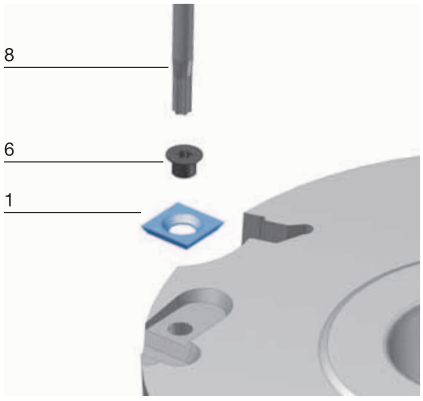
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

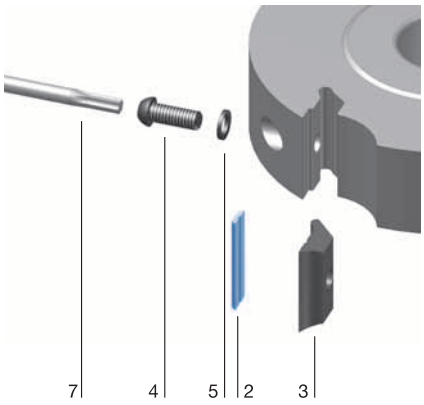
Spare knives:

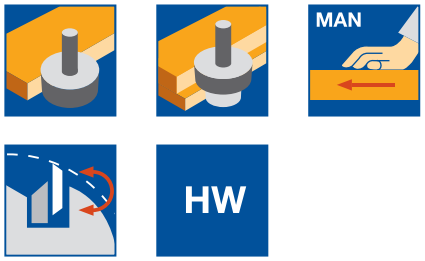
Part-no.	BEZ	ABM mm	QAL	VE PCS	ID	
1	Turnblade spur VS1	14x14x2	HW-F	10	**005099**	●
2	Turnblade knife	14,7x8x1,5	HW-30F	10	**005070**	●

Spare parts:

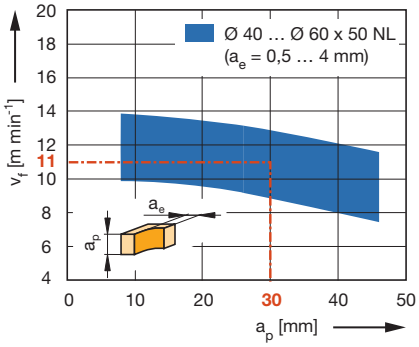
Part-no.	BEZ	ABM mm	ID	
3	Clamping wedge	13x18,75x8,27	**009670**	●
4	Clamping screw, Torx®	M6x18,5	**007818**	●
5	Washer	D9x1,2	**006747**	●
6	Countersink screw, Torx®	M5x8,5	**007808**	●
7	Torx® key	Torx® 25	**117504**	●
8	Torx® key	Torx® 20	**117503**	●
	Setting gauge	0,3/0,8	**005374**	●







Feed speed v_f depending on grooving depth a_p



Workpiece material: Plastic coated chipboard
Working step: Jointing
Speed: n = 16000 rpm
Correction factor for v_f: MDF = 0.9;
Paper coated = 0.8;
Machining across grain = 0.7

Jointing rebating cutterhead in turnblade design

Application:
For jointing and rebating with constant tool diameter.

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

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.).

Technical information:
Tungsten carbide turnblade knife Z 2 with straight cut for stepless finish on pre cut workpieces or workpieces sized by roughing cutters. With spurs for tear free rebates in softwood and hardwood. Quiet running from closed, round tool body.

HW, Z 2 / V2
WL 402-1

D mm	GL mm	SB mm	S mm	ID	
40	120	50	25x60	**039235**	●
50	120	50	25x60	**039239**	●
60	113	50	25x60	**039243**	●

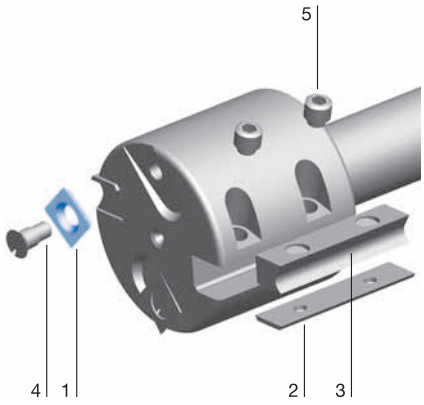
RPM: n max. = 18000 min^{-1}

Spare knives:

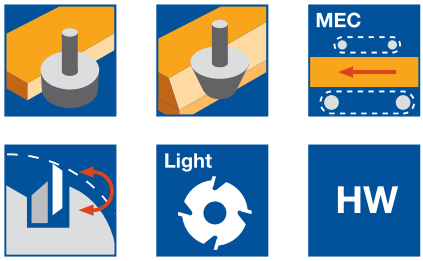
Part-no.	BEZ	ABM mm	QAL	VE PCS	ID	
1	Turnblade spur VS1	14x14x2	HW-F	10	**005099**	●
2	Turnblade knife	50x12x1,5	HW-05	10	**005086**	●

Spare parts:

Part-no.	BEZ	ABM mm	for D mm	ID	
3	Clamping wedge	48x11,6x9		**009871**	●
4	Screw with slot	M5x12		**005744**	●
5	Allen screw	M8x14	60	**006073**	●
5	Allen screw	M8x8	40 / 50	**006245**	●
	Allen Key	SW 4		**005445**	●



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



Jointing cutterhead set with edging knives

Application:
For jointing and rounding or bevelling narrow edges with a constant tool diameter.

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

Workpiece material:
Softwood and hardwood, compound materials of solid wood and wood derived materials, uncoated, plastic coated, veneered etc., gluelam (plywood etc.).

Technical information:
Tungsten carbide turnblade knives Z 2 with shear angles. Narrow edge profiling with edging knives mounted on both sides of tool. Quiet running due to closed, round tool body.

HW, Z 2, with seatings for edging knives
SL 299-2

Tool Type	ABM mm	QAL	Z	ID	
Tool set without arbor, with spacer	85x50x20,1 part	HW	2	**125038**	●
Tool set mounted on arbor	1 part,HD40	HW	2	**426000**	□
Tool set without arbor, with spacer	110x100x28x30	HW	2	**411179**	●
Tool set mounted on arbor	1 part	HW	2	**426085**	□

RPM: D 85 mm: n max. = 17900 min^{-1}
D 110 mm: n max. = 15600 min^{-1}

Unless stated otherwise, tools are right hand rotation.
Cutter arbor see section 8 Clamping systems.

Spare knives:

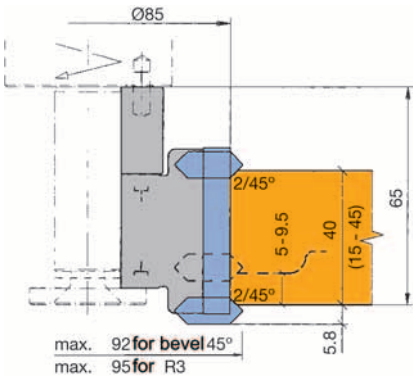
BEZ	ABM mm	QAL	R mm	FAW	VE PCS	ID	
Turnblade knife	50x8x1,5	HW-05			10	**005402**	●
Turnblade knife	100x8x1,5	HW-05				**005405**	●
Edging knife	KM 12/4	HW-F	1,5			**008272**	●
Edging knife	KM 12/3	HW-F	2			**008307**	●
Edging knife	KM 12/0	HW-F	3			**008270**	●
Edging knife	KM 15/0	HW-F	3			**008275**	●
Edging knife	KM 12/1	HW-F	3			**008271**	●
Edging knife	KM 11/0	HW-F		45°		**008268**	●

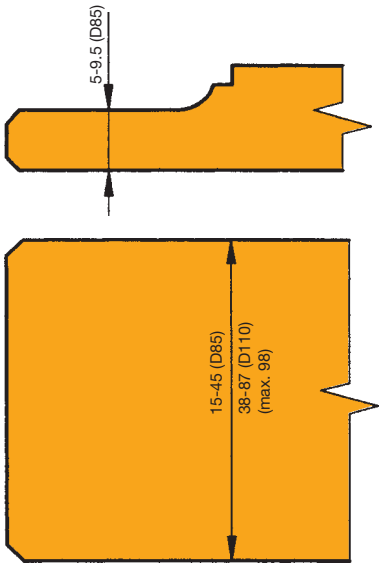
Spare parts:

BEZ	ABM mm	ID	
Clamping wedge	48x18,75x8,27	**009677**	●
Clamping wedge	98x18,75x8,27	**009681**	●
Clamping screw, Torx®	M6x18,5	**007818**	●
Countersink screw, Torx®	M6x35	**007098**	●
Washer	D9x1,2	**006747**	●
Torx®	Torx® 20	**117503**	●
Torx®	Torx® 25	**117504**	●
Magnetic setting gauge	0,3/0,8	**005376**	●

Order example:
Tool set ID **426000** mounted on arbor ID **041125**, shank 25x60 mm.
When ordering, choose arbors with d-20 mm and clamping length 55 mm.

Examples





● available ex stock
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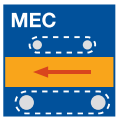
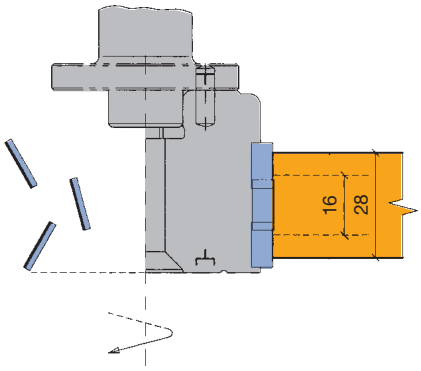


DP



Example

Jointing cutterset Diamaster

Application:
For jointing and copy shaping. For tear free workpiece edges on both sides.

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

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.).

Technical information:
Knives with alternate shear angles. Resharpenable and replaceable DP knives Z 2+2. Resharpening area 3.5 mm. Diameter constant after resharpening by adjustable DP knives. Quiet running through closed, round tool body. Adjustable knives for closed glue joints of glued edges.

DP, Z 2+2
WM 230-2

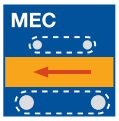
Tool Type	ABM mm	QAL	Z	ID	
Cutterhead	70x33/50x20	DP	2/2/2	**090926**	●
Cutterhead mounted on arbor	1 part/HD28	DP	2/2/2	**426051**	□

RPM: n max. = 18000 min^{-1}

Unless stated otherwise, tools are right hand rotation.
Cutter arbor see section 8 Clamping systems.

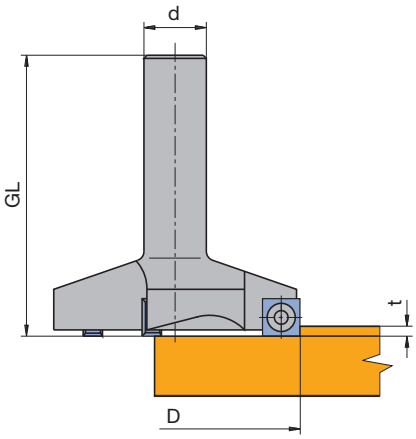
Order example:
Tool set ID **426051** mounted on arbor ID **041126**, shank 25x60 mm.
When ordering, choose arbors with d-20 mm and maximum clamping length for the tool.

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



HW

Example



t = 0.5 - 10 mm

Surface planing during nesting:
t = 0.5 - 1.5 mm
ID **041552** n = 8400 rpm
v_f = 25 - 40 m/min

Planing cutter - turnblade design

Application:
For surface planing of large workpieces and for cutting deep rebates in one working step.

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

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.), duromers, plastomers, mineral materials (Corian, Varicor etc.).

Technical information:
Cutting edge with shear angle; reversible and replaceable cutting edges. D 135 and D 180 particularly suitable for planing MDF slave panels during nesting. Knives with radii for mark free cut quality in solid wood or MDF on request.

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

D mm	GL mm	NL mm	S mm	Z	$n_{max.}$	DRI	ID
80	90	12	20x50	3	14000	RL	**041550** ●
80	100	12	25x60	3	14000	RL	**041551** ●
135	90	12	25x60	4	10000	RL	**041553** ●
180	90	12	25x60	5	8400	RL	**041552** ●

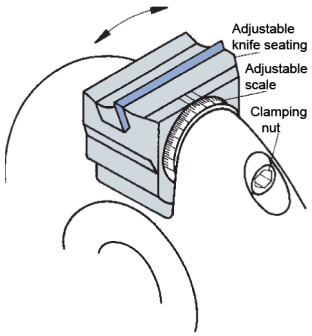
Spare knives:

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

Spare parts:

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


HW



Bevel cutterhead with swivelling knife holder

Bevelling cutterhead, adjustable

Application:
For jointing, bevelling and raised panels with steplessly adjustable bevel angles from 0 to 85°.

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

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.).

Technical information:
Tungsten carbide turnblade knives Z 2. Accurate and clearly readable angle scale for precise and quick adjustment to the required bevel angle. Bevelling of workpiece both at top and bottom.

Z 2
WP 341-1-01

D mm	GL mm	SB mm	S mm	DRI	ID
100	100	40	20x50	RL	**042852** ●
100	110	40	25x60	RL	**042850** ●

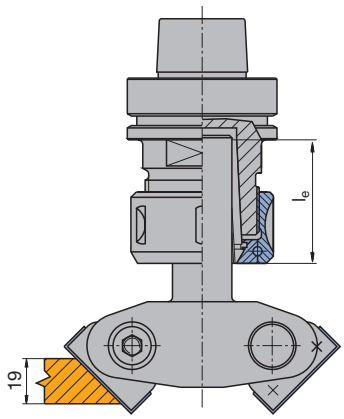
RPM: n max. = 12000 min^{-1}

Spare knives:

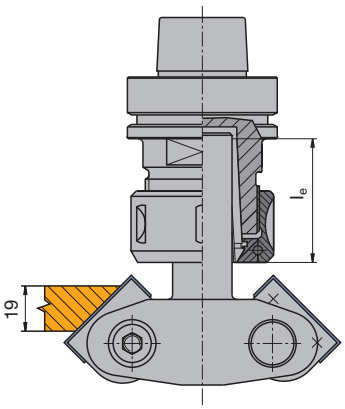
Part-no.	BEZ	ABM mm	QAL	VE PCS	ID
1	Turnblade knife	40x12x1,5	HW-05	10	**005085** ●

Spare parts:

Part-no.	BEZ	ABM mm	BEM	ID
2	Clamping wedge with pin	38x10,88x6		**005348** ●
3	Allen screw	M6x12	ISK 3	**006035** ●
	Allen Key	SW 8, L 100		**005437** ●
	Allen Key	SW 3		**005433** ●



Bevelling from above



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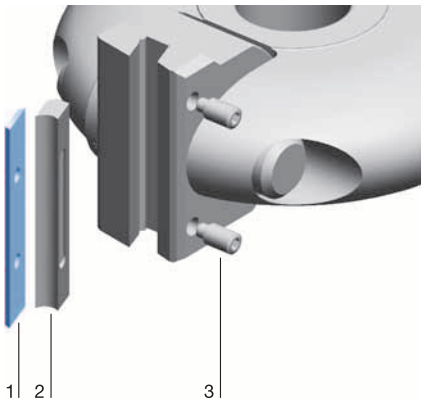

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□ available at short notice
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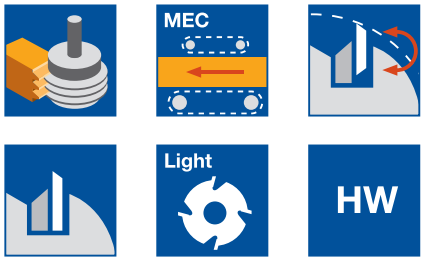
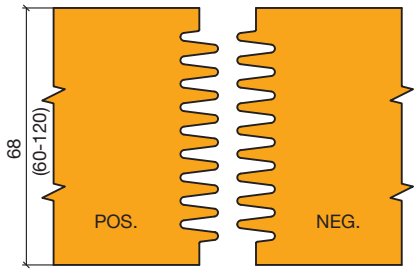




Glue joint profile positive (POS.) and counter profile negative (NEG.)

Note:
For special machine applications (e.g. on Weinig Conturex), the profile and counter profile must be ordered in RL.

Profile cutterhead set - glue joint profile

Application:
For cutting longitudinal joints for dimensionally stable construction parts, windows and doors e.g. round arched joints, stairs and frame construction parts.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood, modified wood in window construction, compound materials of solid wood and wood derived material, uncoated, plastic coated, veneered, etc. gluelam (plywood, etc.).

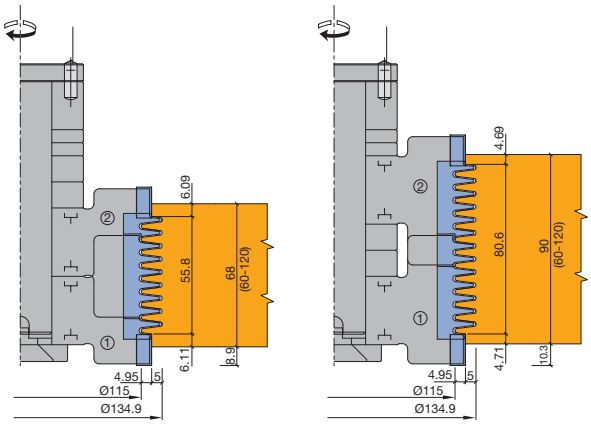
Technical information:
Adjustable finger fit by mounting the shoulder cutters in different knife seatings. Variable wood thickness through different set construction or cutting process in several passes (profile splitting).

ZL 10 mm, TG 6.2 mm, HD 60 - 120 mm
SE 699-2-50

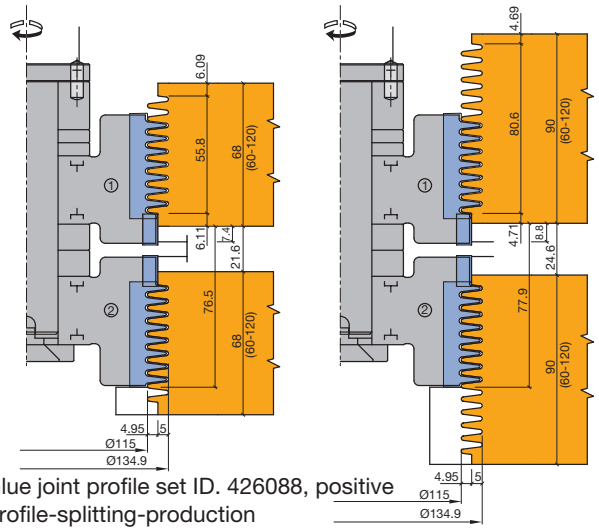
Tool Type	DRI	Tool no.	Z	ID	
Tool set glue joint profile (pos.) mounted on arbor	RL	1, 2	2/2	**426086**	□
Tool set glue joint counter profile (neg.) mounted on arbor	LL	1, 2	2/2	**426087**	□
Tool set glue joint - profile splitting profile pos. mounted on arbor	RL	1, 2	2/2	**426088**	□
Tool set glue joint - profile splitting profile neg. mounted on arbor	LL	1, 2	2/2	**426089**	□
Tool set glue joint - profile splitting profile neg. mounted on arbor	RL	3, 4	2/2	**426090**	□
Glue joint cutter set, pos. (RL) or neg. (LL)	RL	1, 2	2/2	**126046**	●
Glue joint cutter set, neg.	RL	3, 4	2/2	**126047**	●

RPM: n max. = 12700 min^{-1}

Note:
When ordering always state wood thickness (HD). Example: HD 68 mm tool without any special information is mounted positive rh, negative lh. Always 1 tool set profile (pos.) and counter profile (neg.) glue joints required to produce the workpieces without reclamping. Cutter arbor see section 8 Clamping systems.



Glue joint profile set ID. 426086, positive
Conventional production



Glue joint profile set ID. 426088, positive
Profile-splitting-production

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

Single tools
WE 600-1-50

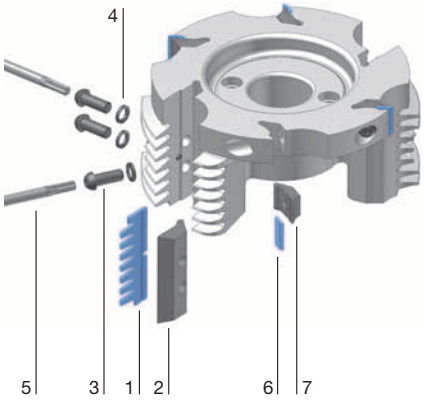
Tool Type	Tool no.	ABM mm	Z	ID	
Profile cutterhead	1	134.9x62.6x30	2/2	**411180**	●
Profile cutterhead	2	134.9x62.6x30	2/2	**411182**	●
Profile cutterhead	3	134.9x62.6x30	2/2	**411184**	●
Profile cutterhead	4	134.9x62.6x30	2/2	**411185**	●

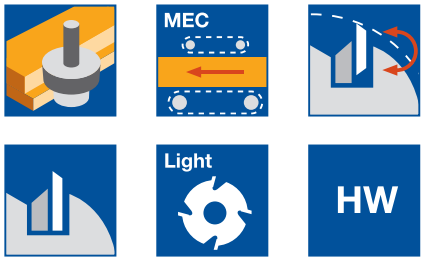
Spare knives:

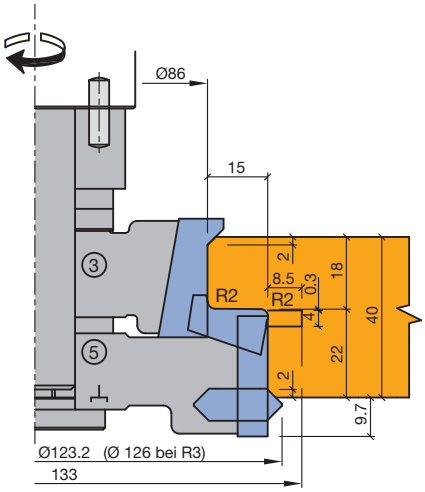
Part-no.	BEZ	Tool no.	ABM mm	QAL	VE PCS	ID	
1	ProfilCut knife	1	50.1x20.5x2	HW		**619230**	●
1	ProfilCut knife	2	50.1x20.5x2	HW		**619231**	●
1	ProfilCut knife	3	50.1x20.5x2	HW		**619232**	●
1	ProfilCut knife	4	50.1x20.5x2	HW		**619233**	●
6	Turnblade knife	1, 2, 3, 4	14,7x8x1,5	HW-30F	10	**005070**	●

Spare parts:

Part-no.	BEZ	Tool no.	ABM mm	ID	
2	Clamping wedge profiled	1, 2, 3, 4	48x18x8,27	**629107**	●
3	Clamping screw, Torx® 25		M6x18,5	**007818**	●
4	Washer		D9x1,2	**006747**	●
5	Torx® key		Torx® 25	**117504**	●
7	Clamping wedge	1, 2, 3, 4	13x18,75x8,27	**009670**	●
	Magnetic setting gauge		0,3/0,8	**005376**	●

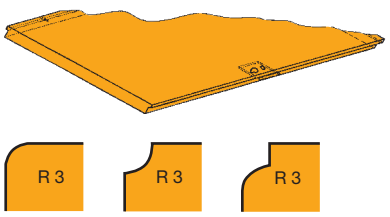






Adjustment scheme:
Max. D = 133 mm for groove
Max. D = 123.2 mm for bevel 45°
Max. D = 126 mm for radius R3

Examples



Profile cutterhead set - door processing

Application:
For profiling and rebating internal single rebate doors, rebate depth 15 mm.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood, compound materials of solid wood and wood derived materials, uncoated, plastic coated, veneered, etc., gluelam (plywood, etc.).

Technical information:
Variable profile overlap by exchange profile edging knives.
Adjustable rebate dimensions: rebate width 22 mm, rebate depth 15 mm.
Seal groove profile by mounting grooving knives SB 4 mm. Constant tool diameter.

Single rebate 15 mm
WE 500-2-50, SE 540-2-50, SG 599-2-50

Tool Type	Tool no.	ABM mm	Z	ID	
Profile cutterhead	3	94x30x20	2	**407741**	●
Profile cutterhead	5	116.2x35x20	2	**407742**	●
Tooling set with spacers, without arbor	3 + 5	116.2,d20,2 part	2	**126032**	●
Tooling set mounted on arbor	3 + 5	D0=86;D=116,2; 2 part	2	**426072**	□

RPM: n max. = 13000 min^{-1}

Unless stated otherwise, tools are right hand rotation.
Cutter arbor see section 8 Clamping systems.

Spare knives:

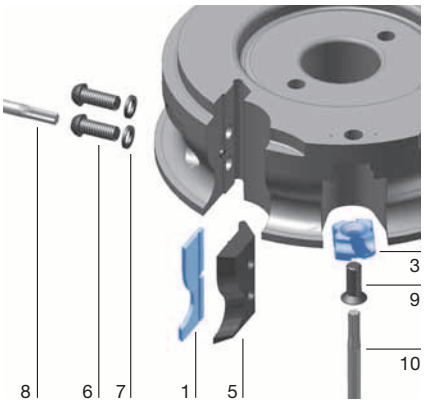
Part-no.	Tool no.	BEZ	ABM mm	QAL	R mm	FAW	VE PCS	ID	
1	3	ProfilCut knife	30.2x14.1x2	HW		45°		**407759**	●
1	3	ProfilCut knife	30.2x14.2x2	HW	1,5			**407760**	●
1	3	ProfilCut knife	30.2x14.21x2	HW	2			**407761**	●
1	3	ProfilCut knife	30.2x14.22x2	HW	3			**407762**	●
1	3	ProfilCut knife	30.2x15.3x2	HW	4			**407763**	●
1	3	ProfilCut knife	30.2x15.31x2	HW	5			**407764**	●
1	3	ProfilCut knife, flute	30.2x14.1x2	HW	3			**407765**	●
1	5	ProfilCut knife	20.1x12.61x2	HW	2			**407793**	●
2	5	Turnblade knife	30x8x1,5	HW-05			10	**005059**	●
3	5	Edging knife	KM 11/0	HW-F		45°		**008268**	●
4	5	Turnblade grooving knife NA4	35,2x15x4	HW-F				**008317**	●

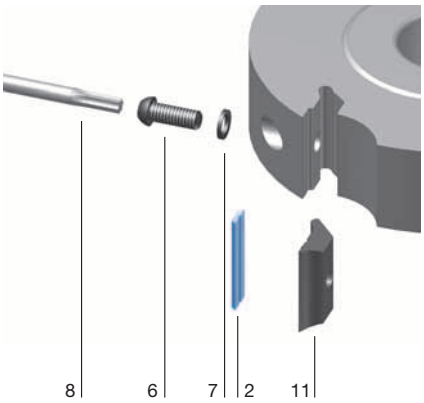
Spare parts:

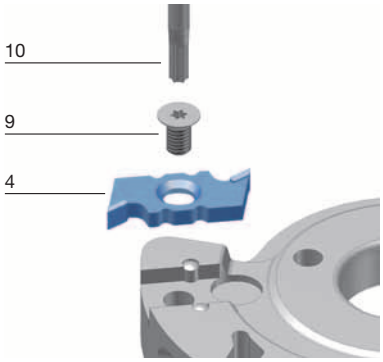
Part-no.	Tool no.	BEZ	ABM mm	ID	
5	3	Clamping wedge profiled	28x22.05x8.27	**629074**	●
5	5	Clamping wedge profiled	17x21.22x7.25	**629075**	●
6		Clamping screw, Torx® 25	M6x18,5	**007818**	●
7		Washer	D9x1,2	**006747**	●
8		Torx® key	Torx® 25	**117504**	●
9		Countersink screw, Torx®	M6x0,5x4,9	**006243**	●

5.3 Profiling
5.3.2 Tools for internal doors

Part-no.	Tool no.	BEZ	ABM mm	ID	
10		Torx® key	Torx® 20	**117503**	●
11	5	Clamping wedge	28x18,75x8,27	**009673**	●
		Magnetic setting gauge	0,3/0,8	**005376**	●







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Profile cutterhead set ProfilCut
Panel raising and edge rounding

Application:
For panel raising profiles for framed doors, ceilings, wall coverings etc. and for edge profiling solid wood.

Machine:
Overhead routers with/without CNC control, special routers with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood.

Technical information:
Panel raising and edge profile with one tool. Cutterhead with throwaway knives and shear angle.

Panel raising depth max. 34 mm
WE 550 2 50, SG 599 2 50

Tool Type	P	ABM mm	Z	$n_{max.}$	ID	
Cutterhead	1	125x60/48x20	2	12200	**023238**	●
Cutterhead mounted on arbor		1 part			**426045**	□

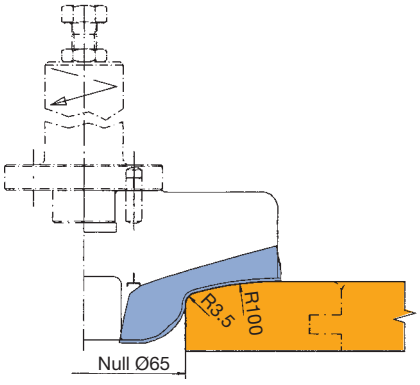
Unless stated otherwise, tools are right hand rotation.
Cutter arbor see section 8 Clamping systems.

Spare knives:

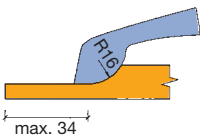
Part-no.	BEZ	P	ABM mm	QAL	ID	
1	ProfilCut knife	1	60x19,88x2	HW	**619002**	●
1	ProfilCut knife	2	60x20,34x2	HW	**619003**	●

Spare parts:

Part-no.	BEZ	ABM mm	ID	
2	Clamping wedge profiled	57x28,38x7,25	**629000**	●
3	Clamping screw, Torx® 25	M6x18,5	**007818**	●
4	Washer	D9x1,2	**006747**	●
5	Torx® key	Torx® 25	**117504**	●



Edge profile



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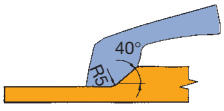

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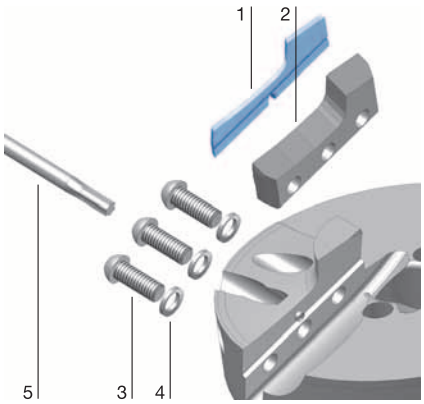

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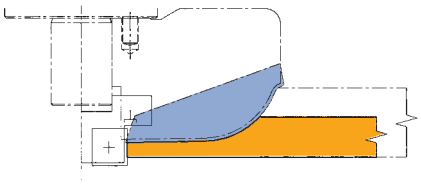
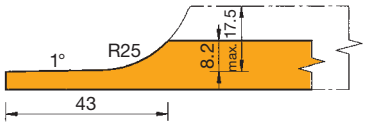
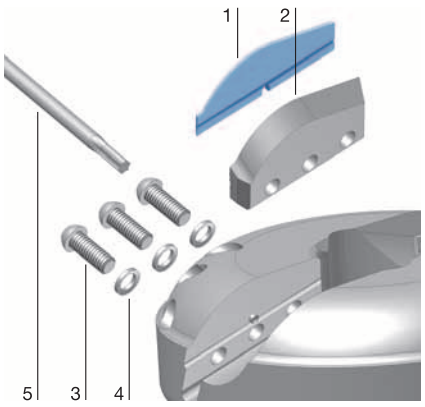


Examples





Profile cutterhead set ProfilCut
Panel raising

Application:
For panel raising profiles for framed doors, ceilings, wall coverings etc.

Machine:
Overhead routers with/without CNC control, special routers with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood.

Technical information:
Panel edge jointing by mounting an additional jointing cutterhead ID **041221**. Cutterhead with throwaway knives and shear angle.

Panel raising depth max. 49 mm
WE 550-2-50, SG 599-2-50

Tool Type	ABM mm	Z	$n_{max.}$	ID	
Cutterhead	132x43x20	2	11600	**125034**	●
Cover plate	46x9.5x20			**007925**	●
Cutterhead mounted on arbor	1 part			**426022**	□

Unless stated otherwise, tools are right hand rotation.
Cutter arbor see section 8 Clamping systems.

Spare knives:

Part-no.	BEZ	ABM mm	QAL	VE PCS	ID	
	Turnblade knife	12x12x1,5	HW-05	10	**005081**	●
1	ProfilCut knife	60x20,47x2	HW		**619100**	●

Spare parts:

Part-no.	BEZ	ABM mm	ID	
2	Clamping wedge profiled	57x28,97x7,25	**629030**	●
3	Clamping screw, Torx®	M6x18,5	**007818**	●
4	Washer	D9x1,2	**006747**	●
5	Torx® key	Torx® 25	**117504**	●
	Oval head screw Torx® 15	M4x6	**006225**	●
	Torx® key	Torx® 15	**117507**	●

Jointing
WW 200-2-NN

Tool Type	ABM mm	QAL	Z	ID	
Jointing cutterhead	30/46x12/22.5x20	HW	2	**041221**	●

Profile cutterhead set ProfilCut Panel raising

Application:
For panel raising profiles for framed doors, ceilings, wall coverings etc.

Machine:
Overhead routers with/without CNC control, special routers with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood.

Technical information:
Panel edge jointing by mounting an additional jointing cutterhead ID **041221**. Cutterhead with throwaway knives and shear angle. Profile can be changed by replacing the knives.

Panel raising depth max. 40 / 50 mm with/without jointing
WE 550-2-50, SG 599-2-50

Tool Type	P	ABM mm	QAL	Z	$n_{max.}$	ID	
Cutterhead	1	110x40/40x20	HW	2	13800	**023237**	●
Cover plate		46x9.5x20	HW			**007925**	●
Cutterhead mounted on arbor		1 part	HW			**426043**	□

Unless stated otherwise, tools are right hand rotation.
Cutter arbor see section 8 Clamping systems.

Spare knives:

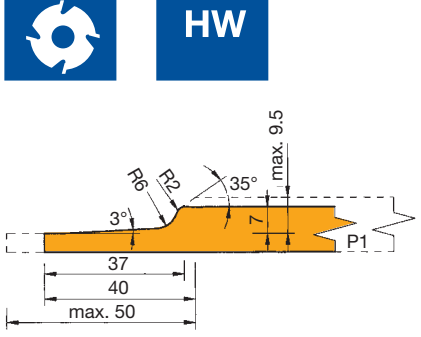
Part-no.	BEZ	P	ABM mm	QAL	VE PCS	ID	
	Turnblade knife		12x12x1,5	HW-05	10	**005081**	●
1	ProfilCut knife	1	50x14,5x2	HW		**009492**	●
1	ProfilCut knife	2	50x14,56x2	HW		**009493**	●

Spare parts:

Part-no.	BEZ	ABM mm	ID	
2	Clamping wedge profiled	47x23x7,25	**009741**	●
3	Clamping screw, Torx® 25	M6x18,5	**007818**	●
4	Washer	D9x1,2	**006747**	●
5	Torx® key	Torx® 25	**117504**	●
	Oval head screw Torx® 15	M4x6	**006225**	●
	Torx® key	Torx® 15	**117507**	●

Jointing
WW 200-2-NN

Tool Type	ABM mm	QAL	Z	ID	
Jointing cutterhead	30/46x12/22.5x20	HW	2	**041221**	●



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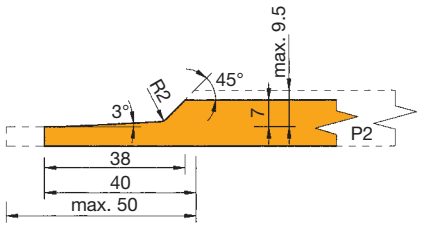

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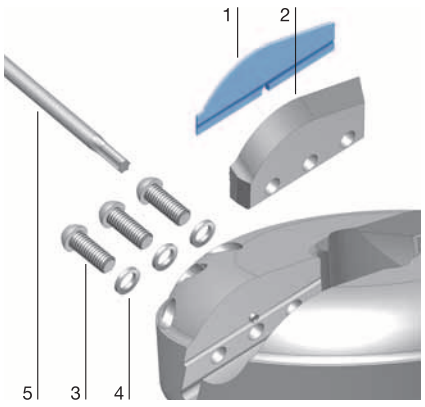

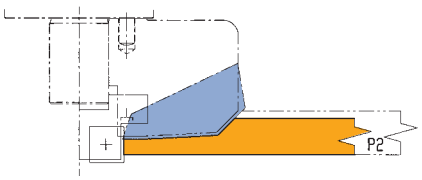

Example

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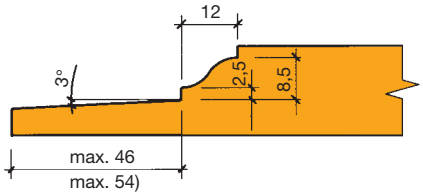

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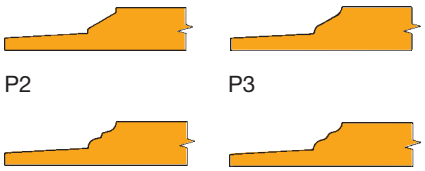
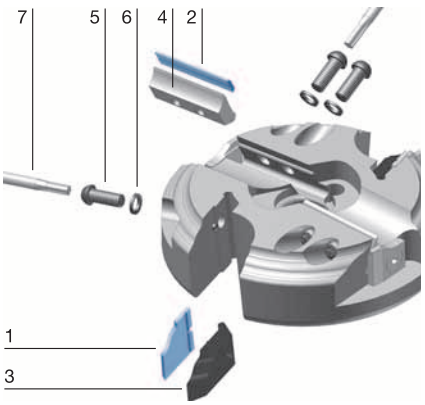


P2 P3

P4 P5

Profiles



Profile cutterhead set ProfilCut Panel raising

Application:
For panel raising profiles for framed doors, ceilings, wall coverings etc.

Machine:
Overhead routers with/without CNC control, special routers with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood.

Technical information:
Panel edge jointing by mounting an additional jointing cutterhead ID **041221**. Cutterhead with throwaway knives and shear angle. Profile can be changed by replacing the knives.

Panel raising depth max. 54 mm
WE 550-2-50, SG 599-2-50

Tool Type	P	ABM mm	QAL	Z	$n_{max.}$	ID	
Cutterhead	1	124x20/36x20	HW	2/2	12300	**041223**	●
Cover plate		46x9.5x20	HW			**007925**	●
Cutterhead mounted on arbor	1	1 part	HW	2/2	12300	**426030**	□

Unless stated otherwise, tools are right hand rotation with profile P1.
Cutter arbor see section 8 Clamping systems.

Spare knives:

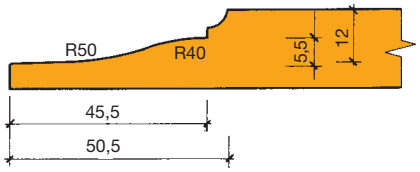
Part-no.	BEZ	P	ABM mm	QAL	VE PCS	ID	
	Turnblade knife		12x12x1,5	HW-05	10	**005081**	●
1	Profile knife profile 1	1	20x27x2	HW		**007560**	●
1	Profile knife profile 2	2	20x27x2	HW		**007561**	●
1	Profile knife profile 3	3	20x27x2	HW		**007562**	●
1	Profile knife profile 4	4	20x27x2	HW		**007563**	●
1	Profile knife profile 5	5	20x27x2	HW		**007564**	●
2	Turnblade knife		40x8x1,5	HW-30F	10	**005074**	●

Spare parts:

Part-no.	BEZ	P	ABM mm	ID	
3	Clamping wedge profiled	1-5	18x37,46x8,27	**009722**	●
4	Clamping wedge	Panel raising	37x16,8x7,25	**009577**	●
5	Clamping screw, Torx® 25		M6x18,5	**007818**	●
6	Washer		D9x1,2	**006747**	●
7	Torx® key		Torx® 25	**117504**	●
	Oval head screw Torx® 15		M4x6	**006225**	●
	Torx® key		Torx® 15	**117507**	●
	Cover plate		46x9.5x20	**007925**	●

Jointing
WW 200-2WW 200-2-NN

Tool Type	ABM mm	QAL	Z	ID	
Jointing cutterhead	30/46x12/22.5x20	HW	2	**041221**	●

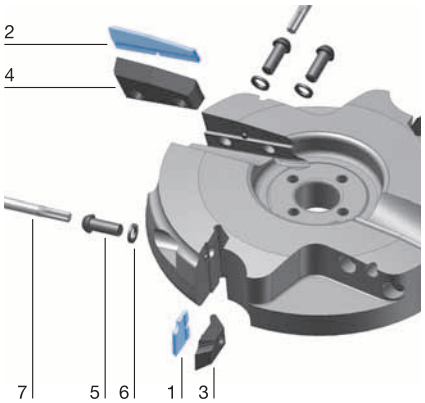


P1

P2 P3

P4 P5

Profiles



Profile cutterhead set ProfilCut Panel raising

Application:
For panel raising profiles for framed doors, ceilings, wall coverings etc.

Machine:
Overhead routers with/without CNC control, special routers with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood.

Technical information:
Panel edge jointing by mounting an additional jointing cutterhead ID **041221**. Cutterhead with throwaway knives and shear angle. Profile can be changed by replacing the knives.

Panel raising depth max. 50 mm
WE 550-2-50, SG 599-2-50

Tool Type	P	ABM mm	QAL	Z	$n_{max.}$	ID	
Cutterhead	1	131x20/36x20	HW	2/2	11600	**023220**	●
Cover plate		46x9.5x20	HW			**007925**	●
Cutterhead mounted on arbor	1	1 part	HW	2/2	11600	**426031**	□

Unless stated otherwise, tools are right hand rotation with profile P1.
Cutter arbor see section 8 Clamping systems.

Spare knives:

Part-no.	BEZ	P	ABM mm	QAL	VE PCS	ID	
	Turnblade knife		12x12x1,5	HW-05	10	**005081**	●
1	ProfilCut knife	1	20x16x2	HW		**007655**	●
1	ProfilCut knife	2	20x16x2	HW		**007656**	●
1	ProfilCut knife	3	20x16x2	HW		**007657**	●
1	ProfilCut knife	4	20x16x2			**007658**	●
1	ProfilCut knife	5	20x16x2	HW		**007659**	●
2	ProfilCut knife (pan.rais.)		50x11,68x2	HW		**007600**	●

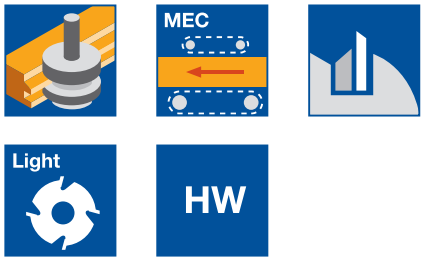
Spare parts:

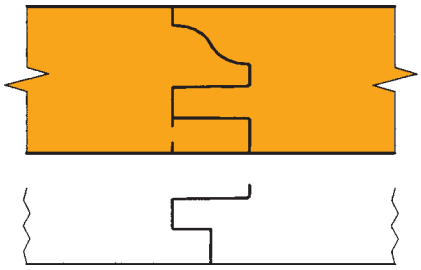
Part-no.	BEZ	P	ABM mm	ID	
3	Clamping wedge profiled	1-5	18x26,46x8,27 (P1-5)	**009725**	●
4	Clamping wedge profiled	panel raising	47x20.18x7.25 (raised panel)	**009982**	●
5	Clamping screw, Torx® 25		M6x18,5	**007818**	●
6	Washer		D9x1,2	**006747**	●
7	Torx® key		Torx® 25	**117504**	●
	Oval head screw Torx® 15		M4x6	**006225**	●
	Cover plate		46x9.5x20	**007925**	●

Jointing
WW 200-2-NN

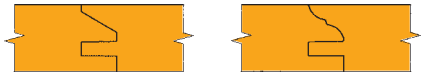
Tool Type	ABM mm	QAL	Z	ID	
Jointing cutterhead	30/46x12/22.5x20	HW	2	**041221**	●

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

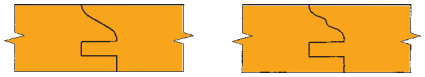




P1



P2 P3



P4 P5

Profile examples

Profile cutterhead set ProfilCut Door frame

Application:
For profiles and counter profiles in solid wood frame furniture doors.

Machine:
Overhead routers with/without CNC control, special routers with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood.

Technical information:
3 tool sets with 5 profiles for single side profiled frames and inserted or beaded panels. Additional profiles by remounting the single tools.

Frame profile one side, 12 mm tongue
SE 640-2-50, AG 341-2-50

Tool Type	Tool no.	Z	$n_{max.}$	ID	
Profile set	1	2	14500	**126006**	●
Counter profile set	2,3	2/2	14500	**126007**	●
Tool set profile and counter profile mounted on arbor				**043098**	□

Frame profile one side, 12 mm rebate
SE 640-2-50, AG 341-2-50

Tool Type	Tool no.	Z	$n_{max.}$	ID	
Profile set	1,3	2/2	14500	**126008**	●
Counter profile set	2,4	2/2	14500	**126009**	●
Tool set profile and counter profile mounted on arbor				**043099**	□

Frame profile one side, 6 mm tongue
SE 640-2-50, AG 341-2-50

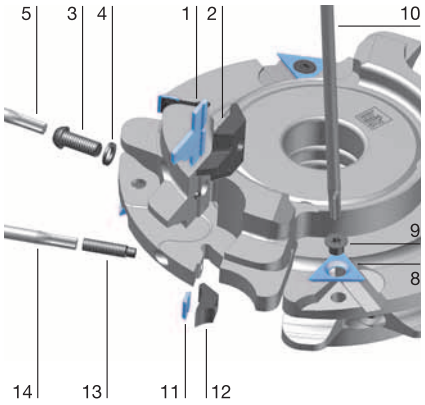
Tool Type	Tool no.	Z	$n_{max.}$	ID	
Profile set	1,5	2/2	14500	**126010**	●
Counter profile set	2,5	2/2	14500	**126011**	●
Tool set profile and counter profile mounted on arbor				**043100**	□

Single tools
WE 500-2-50, WW 410-2-NN

Tool Type	Tool no.	ABM mm	Z	ID	
Profile cutterhead	1	109,1x30x20	2	**023968**	●
Profile cutterhead	2	109,0x20x20	2	**023969**	●
Rebating cutterhead	3	109,0x15x20	Z2/V2	**023970**	●
Profile cutterhead	4	85x15x20	2	**023971**	●
Rebating cutterhead	5	97x15x20	Z2/V2	**023972**	●

Cutter arbor see section 8 Clamping systems.

Tools supplied with profile 1 unless ordered otherwise.

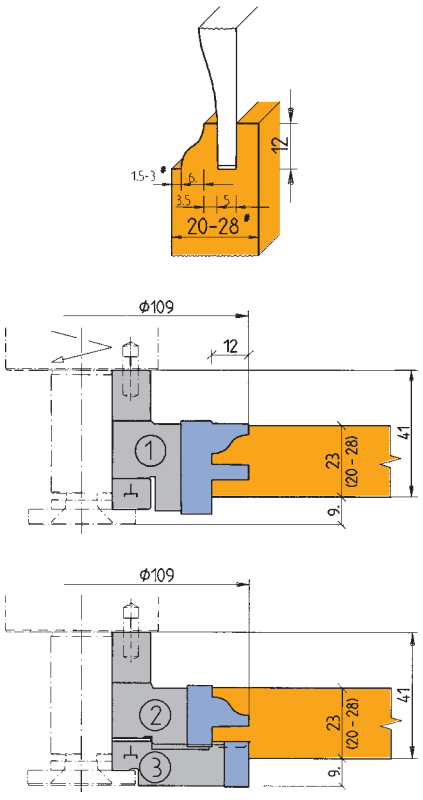


Spare knives:

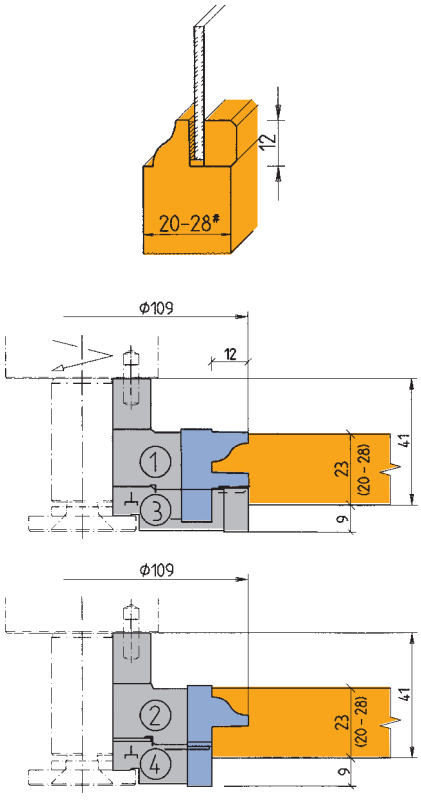
Part-no.	BEZ	P	Tool no.	ABM mm	QAL	VE PCS	ID
1	ProfilCut knife	1	1	30x23,2x2	HW		**009215** ●
1	ProfilCut knife	2	1	30x23,2x2	HW		**009216** ●
1	ProfilCut knife	3	1	30x23,2x2	HW		**009217** ●
1	ProfilCut knife	4	1	30x23,2x2	HW		**009218** ●
1	ProfilCut knife	5	1	30x23,2x2	HW		**009219** ●
1	ProfilCut knife	1	2	20x23x2	HW		**009225** ●
1	ProfilCut knife	2	2	20x23x2	HW		**009226** ●
1	ProfilCut knife	3	2	20x23x2	HW		**009227** ●
1	ProfilCut knife	4	2	20x23x2	HW		**009228** ●
1	ProfilCut knife	5	2	20x23x2	HW		**009229** ●
8	Turnblade spur VS2		3, 5	19x19x2	HW-F	10	**005115** ●
11	Turnblade knife		3, 4, 5	14,7x8x1,5	HW-30F	10	**005070** ●

Spare parts:

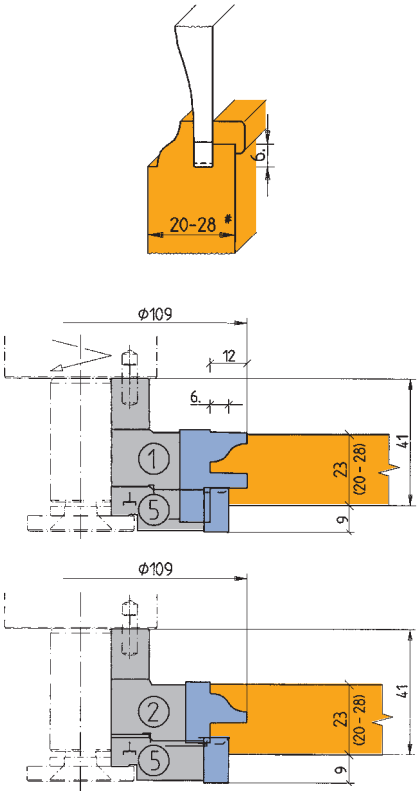
Part-no.	BEZ	Tool no.	ABM mm	P	ID
2	Clamping wedge profiled	1	28x29x8,27	1-5	**009726** ●
2	Clamping wedge profiled	2	18x29x8,27	1-5	**009728** ●
3	Clamping screw, Torx® 25		M6x18,5		**007818** ●
4	Washer		D9x1,2		**006747** ●
5	Torx® key		Torx® 25		**117504** ●
9	Countersink screw, Torx® 20		M5x8,5		**007808** ●
10	Torx® key		Torx® 20		**117503** ●
12	Clamping wedge	3, 4, 5	13x18,75x8,27		**009670** ●
	Magnetic setting gauge		0,3/0,8		**005376** ●



Tongue 12 mm, inserted panel

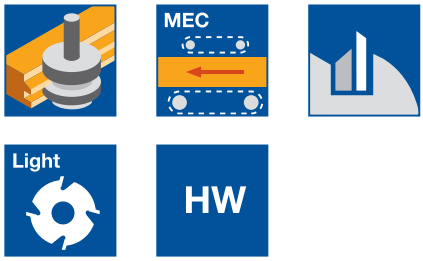


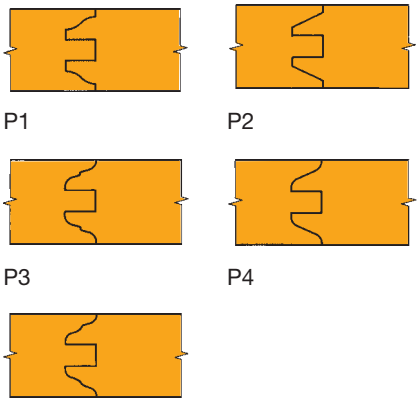
Rebate 12 mm, beaded panels



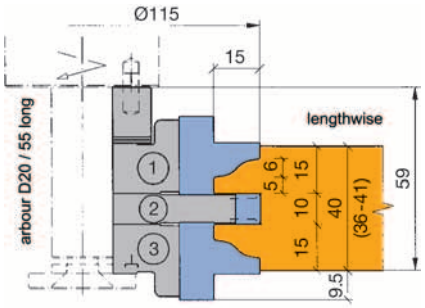
Tongue 6 mm,
inserted and beaded panels

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





Profiles



Frame profiled on two sides - profile

Profile cutterhead set ProfilCut Door frame

Application:
For profiles and counter profiles in solid wood frame furniture doors.

Machine:
Overhead routers with/without CNC control, special routers with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood.

Technical information:
Tool sets with 5 profile choices for frames with profiles on two sides and inserted or beaded panels. Additional tools available for changing from frames with profiles on both sides to frames with profiles on one side.

Frame profile two sides, 15 mm tongue
SE 640-2-50, AG 341-2-50

Tool Type	Tool no.	Z	$n_{max.}$	ID	
Profile set	1,2,3	Z2/V2	13200	**126012**	●
Counter profile set	1,3	Z2	13200	**126013**	●
Tool set profile and counter profile mounted on arbor				**126513**	□

Frame profile one side, 15 mm rebate
SE 640-2-50, AG 341-2-50

Tool Type	Tool no.	Z	$n_{max.}$	ID	
Profile set	3,5	Z2/V2	13200	**126014**	●
Counter profile set	1,4	Z2	13200	**126015**	●
Tool set profile and counter profile mounted on arbor				**126514**	□

Frame profile two sides, 15 mm tongue, profile and counter profile
SE 640-2-50, SG 699-2-50

Tool Type	Tool no.	Z	$n_{max.}$	ID	
Profile and counter profile set	3,1,2,3	Z2/V2	13200	**126016**	●
Tool set profile and counter profile mounted on arbor			13200	**126515**	□

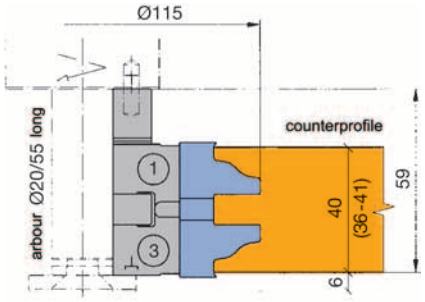
Additional tool (conversion from tongue 15 mm to rebate 15 mm)
WW 410-2-NN, WW 211-2

Tool Type	Tool no.	Z	$n_{max.}$	ID	
Profile set	5	Z2/V2	13200	**125032**	●
Counter profile set	4	2	13200	**023085**	●

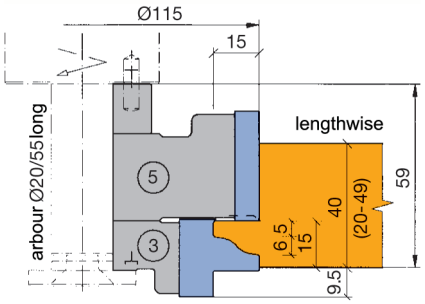
Cutter arbor see section 8 Clamping systems.

Wood thickness:
frame profile two sides HD 36 - 41 mm
frame profile one side HD 20 - 49 mm

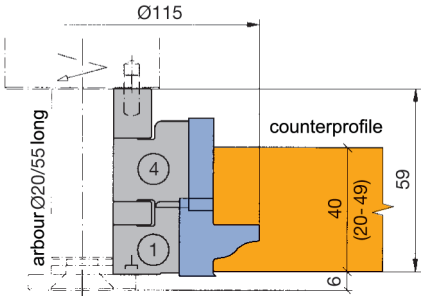
5



Frame profiled on two sides - counter profile



Frame profiled on one side - profile



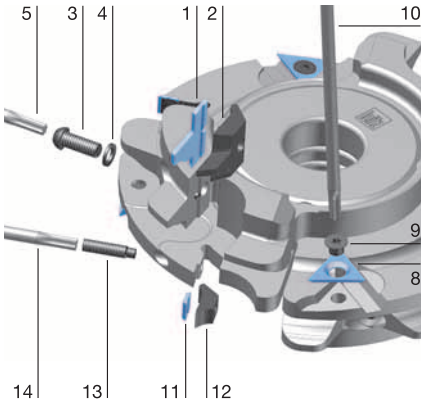
Frame profiled on one side - counter profile

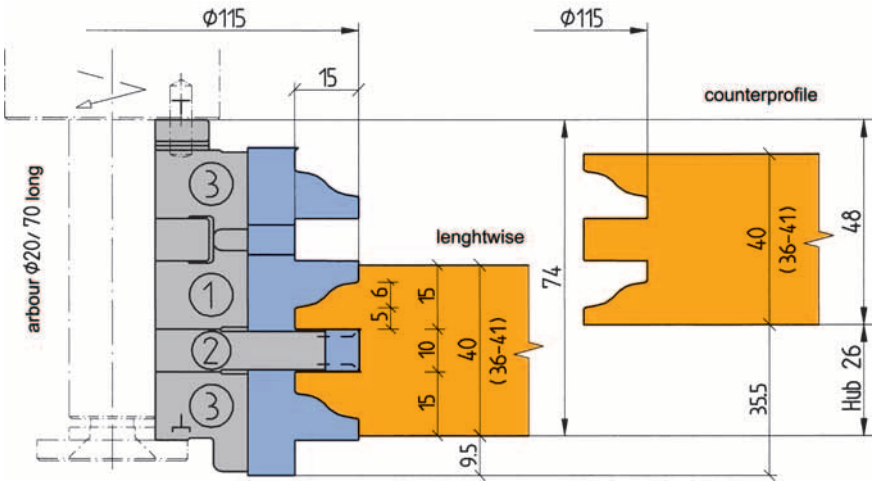
Spare knives:

Part-no.	BEZ	P	Tool no.	ABM mm	QAL	VE PCS	ID
1	ProfilCut knife	1	3	25x27x2	HW		**619054** ●
1	ProfilCut knife	2	3	25x27x2	HW		**619055** ●
1	ProfilCut knife	3	3	25x27x2	HW		**619056** ●
1	ProfilCut knife	4	3	25x27x2	HW		**619057** ●
1	ProfilCut knife	5	3	25x27x2	HW		**619058** ●
1	ProfilCut knife	1	1	25x27x2	HW		**619059** ●
1	ProfilCut knife	2	1	25x27x2	HW		**619060** ●
1	ProfilCut knife	3	1	25x27x2	HW		**619061** ●
1	ProfilCut knife	4	1	25x27x2	HW		**619062** ●
1	ProfilCut knife	5	1	25x27x2	HW		**619063** ●
11	Turnblade knife		2	9,7x8x1,5	HW-30F	10	**005197** ●
11	Turnblade knife		5	35x8x1,5	HW-30F	10	**005073** ●
11	Turnblade knife		4	30x8x1,5	HW-30F	10	**005072** ●
15	Turnblade spur VS2		2, 5	19x19x2	HW-F	10	**005115** ●

Spare parts:

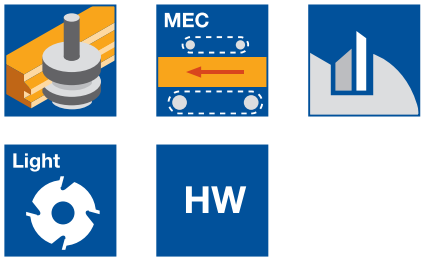
Part-no.	BEZ	Tool no.	ABM mm	ID
2	Clamping wedge profiled	3	23x34x8,27	**629013** ●
2	Clamping wedge profiled	1	23x34x8,27	**629012** ●
3	Clamping screw, Torx® 25		M6x18,5	**007818** ●
4	Washer		D9x1,2	**006747** ●
5	Torx® key		Torx® 25	**117504** ●
9	Countersink screw, Torx® 20		M6x0,5x4,9	**006243** ●
10	Torx® key		Torx® 20	**117503** ●
12	Clamping wedge	2	9x18,75x8,27	**009764** ●
12	Clamping wedge	4	28x18,75x8,27	**009673** ●
12	Clamping wedge	5	33x18,75x8,27	**009674** ●
13	Allen screw with shank, Torx® 15		M5x20	**007380** ●
14	Torx® key		Torx® 15	**117507** ●
	Magnetic setting gauge		0,3/0,8	**005376** ●

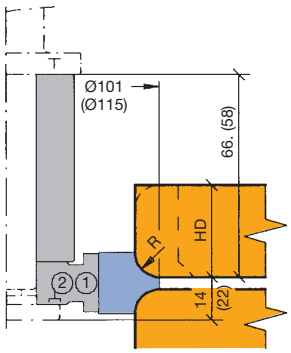




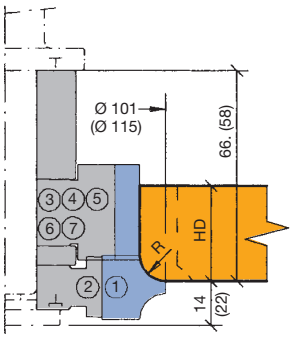
Frame profiled on two sides
Tool sets for profile and counter profile mounted on arbor

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





Combination ID **022907**



Combination ID **022908**

wood thickness	or	or	or	or	or	
tool combination	3 3 / 1 2	4 4 / 1 2	5 5 / 1 2	6 6 / 1 2	7 7 / 1 2	or
max. HD	19 + R	29 + R	39 + R	14 + R	49 + R	
min. HD	–	–	–	–	–	

Profile cutterhead set ProfilCut

Application:
Multi purpose tool set for bevelling and rounding, optional jointing of the workpiece edge.

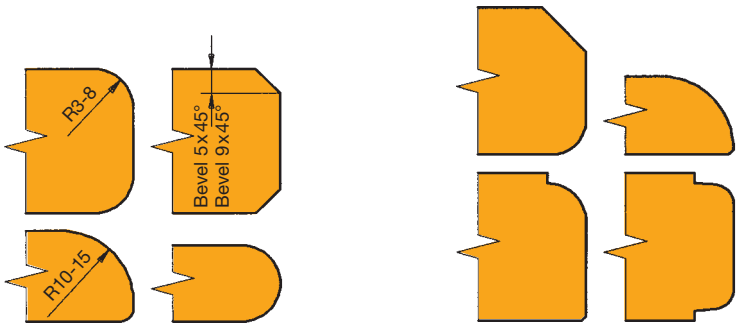
Machine:
Overhead routers with/without CNC control, special routers with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood.

Technical information:
By combining jointing and bevelling or rounding cutterheads several different profiles and wood thicknesses can be covered. Different radii or bevel profile knives can be mounted in one cutterhead.

Jointing, rounding or bevelling tool
SG 599-2-50

Tool Type	R mm	BEM	$n_{max.}$ min^{-1}	ID	
Rounding		No. of tools 1	12000	**022907**	□
Jointing rounding		No. of tools 2	12000	**022908**	□
Rounding jointing rounding	3 - 8	No. of tools 3	12000	**022909**	□
Rounding jointing rounding	3 - 8 10 - 15	No. of tools 3	12000	**022910**	□
Rounding rounding	3 - 8 10 - 15	No. of tools 2	12000	**022911**	□

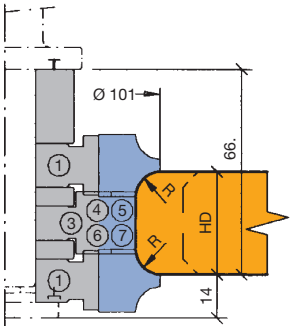


Profiles

Single tools
WE 500-2-50, WW 211-2

Tool Type	Tool no.	ABM mm	QAL	Z	R mm	FAW	ID	
Profile cutterhead	1	101x20x20	HW	2	3		**023069**	□
Profile cutterhead	1	101x20x20	HW	2	4		**023070**	□
Profile cutterhead	1	101x20x20	HW	2	5		**023071**	●
Profile cutterhead	1	101x20x20	HW	2	6		**023072**	□
Profile cutterhead	1	101x20x20	HW	2	7		**023073**	□
Profile cutterhead	1	101x20x20	HW	2	8		**023074**	□
Profile cutterhead	1	101x20x20	HW	2		5/45°	**023075**	□
Profile cutterhead	2	115x35x20	HW	2	10		**023978**	●
Profile cutterhead	2	115x35x20	HW	2	11		**023979**	□
Profile cutterhead	2	115x35x20	HW	2	12		**023980**	□
Profile cutterhead	2	115x35x20	HW	2	13		**023981**	□
Profile cutterhead	2	115x35x20	HW	2	14		**023982**	□

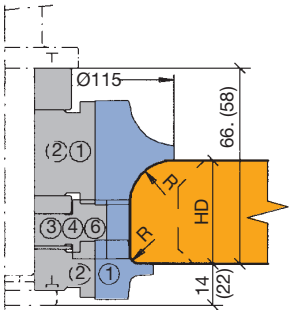
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Combination ID **022909** Combination with tool 2 not possible

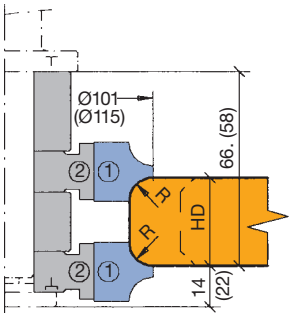
wood thickness					
tool combination	①③①	①④①	①⑤①	①⑥①	①⑦①
max. HD	17+R+R	27+R+R	37+R+R	13+R+R	47+R+R
min. HD	21	31	41	16	51

no combination possible with tool 2



Combination ID **022910** Combination 1 and 1 see ID **022909** (Combinations of tool 2 and 2, or tool 5 and 7 not possible)

wood thickness				
tool combination	①①	②②	②①	or
max. HD	57	41	49	
min. HD	R + R	R + R	R + R	
	but min. 10		but min. 17	
	but min. 24			



Combination ID **022911**
Chart data of bevelling knives:
R = bevel 5 (9)x45°, min. wood thickness is calculated with bevel 5 (9)x54°

wood thickness				
tool combination	②③①	②④①	②⑥①	or
max. HD	17+R+R	27+R+R	13+R+R	
min. HD	28	38	23	

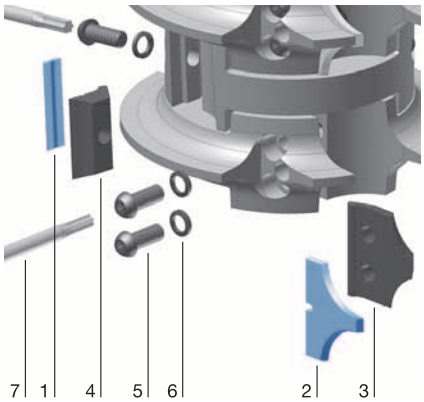
Tool Type	Tool no.	ABM mm	QAL	Z	R mm	FAW	ID	
Profile cutterhead	2	115x35x20	HW	2	15		**023983**	□
Profile cutterhead	2	115x35x20	HW	2		9/45°	**023984**	□
Jointing cutterhead	3	85x20x20	HW	2			**023084**	●
Counter profile set	4	85x30x20	HW	2			**023085**	●
Jointing cutterhead	5	85x40x20	HW	2			**023086**	●
Jointing cutterhead	6	85x15x20	HW	2			**023976**	●
Jointing cutterhead	7	85x50x20	HW	2			**023977**	●

Spare knives:

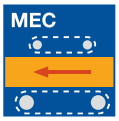
Part-no.	BEZ	Tool no.	ABM mm	QAL	R mm	FAW	VE PCS	ID	
1	Turnblade knife	6	14,7x8x1,5	HW-30F			10	**005070**	●
1	Turnblade knife	3	19,7x8x1,5	HW-30F			10	**005071**	●
1	Turnblade knife	4	30x8x1,5	HW-30F			10	**005072**	●
1	Turnblade knife	5	40x8x1,5	HW-30F			10	**005074**	●
1	Turnblade knife	7	50x8x1,5	HW-30F			10	**005075**	●
2	ProfilCut knife	1	20x18x2	HW	3			**008583**	●
2	ProfilCut knife	1	20x18x2	HW	4			**008584**	●
2	ProfilCut knife	1	20x18x2	HW	5			**008585**	●
2	ProfilCut knife	1	20x18x2	HW	6			**008586**	●
2	ProfilCut knife	1	20x18x2	HW	7			**008587**	●
2	ProfilCut knife	1	20x18x2	HW	8			**008588**	●
2	ProfilCut knife	1	20x18x2	HW	5	45°		**008589**	●
2	ProfilCut knife	2	35x25,2x2	HW	10			**009120**	●
2	ProfilCut knife	2	35x25,2x2	HW	11			**009121**	●
2	ProfilCut knife	2	35x25,2x2	HW	12			**009122**	●
2	ProfilCut knife	2	35x25,2x2	HW	13			**009123**	●
2	ProfilCut knife	2	35x25,2x2	HW	14			**009124**	●
2	ProfilCut knife	2	35x25,2x2	HW	15			**009125**	●
2	ProfilCut knife	2	35x25,2x2	HW	9	45°		**009126**	●

Spare parts:

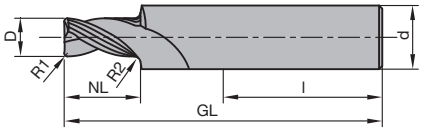
Part-no.	BEZ	Tool no.	ABM mm	ID	
3	Clamping wedge	1	18x22x8,27	**009649**	●
3	Clamping wedge	2	33x29x8,27	**009752**	●
4	Clamping wedge	3	18x18,75x8,27	**009671**	●
4	Clamping wedge	4	28x18,75x8,27	**009673**	●
4	Clamping wedge	5	38x18,75x8,27	**009675**	●
4	Clamping wedge	6	13x18,75x8,27	**009670**	●
4	Clamping wedge	7	48x18,75x8,27	**009677**	●
5	Clamping screw, Torx® 25		M6x18,5	**007818**	●
6	Washer		D9x1,2	**006747**	●
7	Torx® key		Torx® 25	**117504**	●
	Allen Key		SW 4	**005445**	●



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



HW



Profile router

Application:
Router for changing the profile rebate in windows, for mullion and transom.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood, laminated wood in the window construction.

Technical information:
HW solid. Large spiral angle for optimum chip removal. Pre cutting with spiral roughing/finishing cutter Marathon recommended.

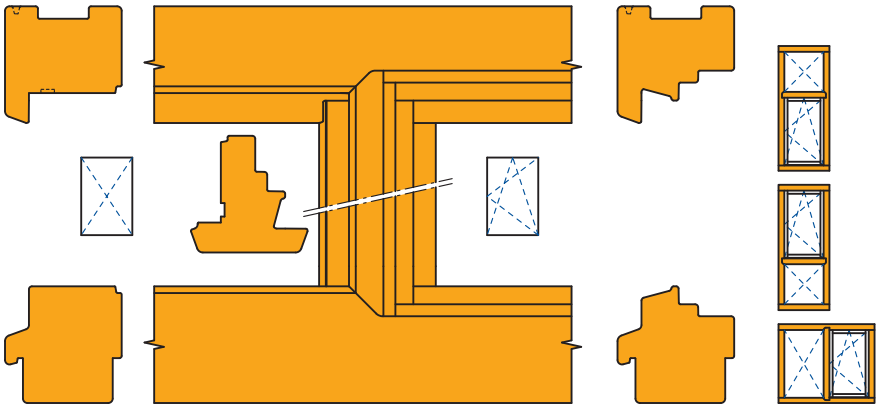
Profile router for rebate changing cuts
WO 531-2

D mm	GL mm	NL mm	S mm	Z	DRI	Twist	ID	ID Set HSK-F 63
12	100	24	20x50	2	RL	RD	**245001** ●	**245101** □
12	100	30	20x50	2	RL	RD	**245000** ●	**245100** □

RPM: n = 18000 - 24000 min^{-1}

Note:
HSK-F 63 = tool is supplied mounted in shrink-fit chuck HSK-F 63

Example:
Rebate change to window profiles



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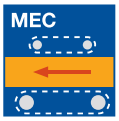
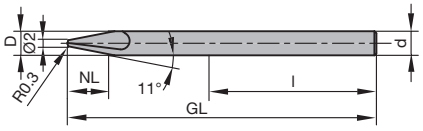
□ available at short notice
Instruction manual visit www.leitz.org



HW



Profile router Kolibri

Application:
Routers to pre cut the cross grain profile as protection against break outs on slot/tenon or counter profiles.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood, laminated wood in window construction.

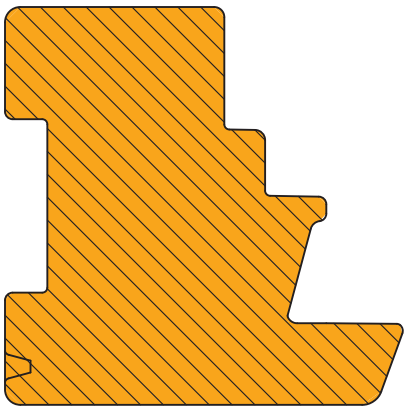
Technical information:
HW solid. Pre cutting working step follows the contour of the subsequent profile.

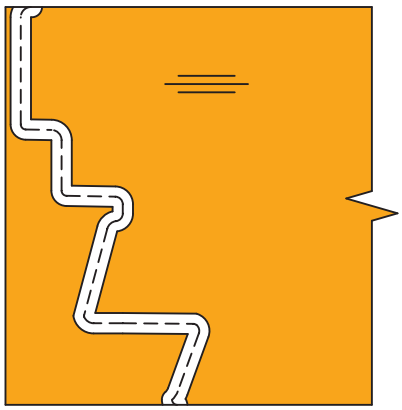
HW solid, Z 2
WO 531-2

D mm	GL mm	NL mm	S mm	Z	DRI	ID
6	77	5	6x40	2	RL	**039160** ●

RPM: n = 18000 - 24000 min^{-1}

Example:
Pre cutting on the longitudinal wood with the Kolibri profile cutter before counter profiling.





5

HW

Profile cutterhead - radii/bevel profile

Application:
For rounding workpieces with different radii or 45° bevelling.

Machine:
Overhead routers with/without CNC control, special routers with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.), duromers, plastomers, mineral materials (Corian, Varicor etc.).

Technical information:
Multi purpose use on top or bottom of workpiece up to HD approx. 35 mm. Suitable for cutting narrow internal radii on workpieces. One tool body can be used for radii from 2 to 5 mm and 45° bevels.

Cutterhead with cutterset/radii profiles
AG 740-2

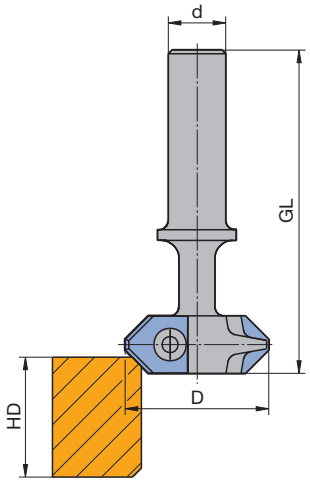
Tool Type	D mm	S mm	Z	ID
1 tool body + 2 pcs. R2, R3, R4, R5 knives each in wooden box	40	16x60	2	**043105** ●

Spare knives:

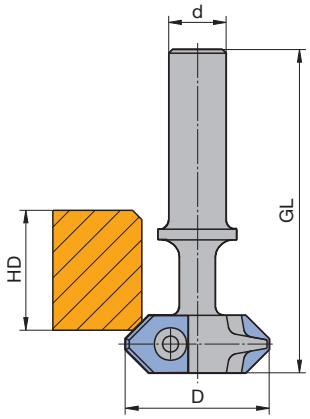
BEZ	ABM mm	QAL	R mm	FAW	ID
Profile knife	16x17,5x2	HW	2,0		**005132** ●
Profile knife	16x17,5x2	HW	3,0		**005133** ●
Profile knife	16x17,5x2	HW	4,0		**005134** ●
Profile knife	16x17,5x2	HW	5,0		**005135** ●
Profile knife	16x17,5x2	HW		45°	**009525** ●

Spare parts:

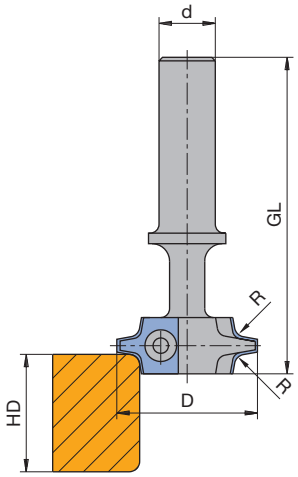
BEZ	ABM mm	ID
Oval head screw Torx® 15	M4x6	**006225** ●
Torx® key	Torx® 15	**005457** ●



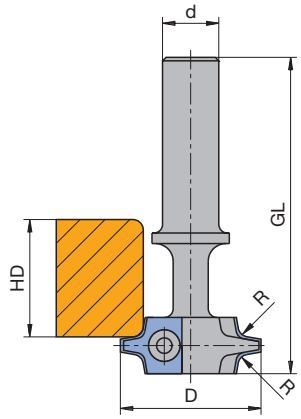
Bevel on the top side of the workpiece



Bevel on the bottom side of the workpiece

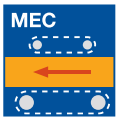


Radius on the top side of the workpiece

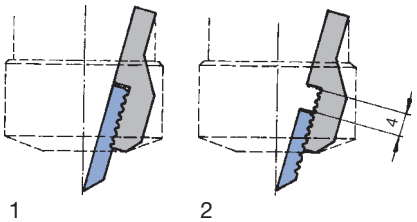


Radius on the bottom side of the workpiece

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

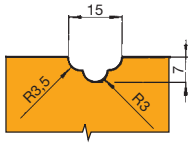


HW

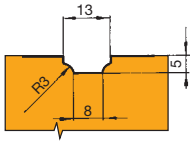


1 2

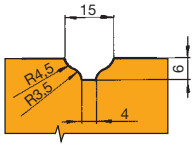
1 = Knife as new
2 = Maximum adjustment of resharpened knife



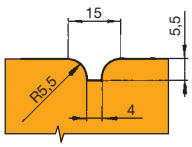
P1



P2



P3



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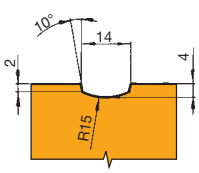
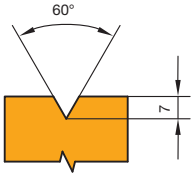


P5



P6

Profiles

Multi purpose profile cutterhead, Z 1

Application:
For cutting decorative grooves and internal profiles.

Machine:
Overhead routers with/without CNC control, special routers with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.).

Technical information:
Cutterhead with resharpenable profile knife. Form fit, play free knife mounting by precise serration. Different profiles in one tool body. Special profiles can be ground into the blank knife on request and available with DP tipping for long performance time in wood derived materials.

For profiles, Z 1, cutting in end grain
WP 500-1

D mm	GL mm	S mm	Z	ID
15	88,5	16x50	1	**042930** ●
15	98,5	25x60	1	**042931** ●

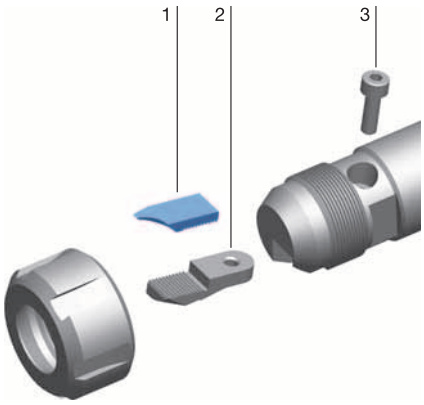
Sales unit consisting of cutterhead with clamping wedge and nut but without HW knife blank.

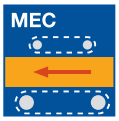
Spare knives:

Part-no.	BEZ	P	ABM mm	QAL	ID
1	Profile knife	1	20,7x9x3	HW	**006945** ●
1	Profile knife	2	20,7x9x3	HW	**006946** ●
1	Profile knife	3	20,7x9x3	HW	**006947** ●
1	Profile knife	4	20,7x9x3	HW	**006948** ●
1	Profile knife	5	20,7x9x3	HW	**006949** ●
1	Profile knife	6 (V-Nut 60°)	20,7x9x3	HW	**006950** ●
1	Serrated blank		9x21,7x3	HW	**007490** ●

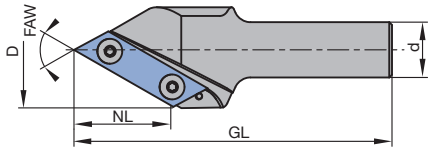
Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge with serration	9x27,4x7	**009584** ●
3	Cylindrical screw with ISK	M4x16	**005847** ●
	Sickle spanner	34/36	**005498** ●
	Allen Key	SW 3	**005433** ●

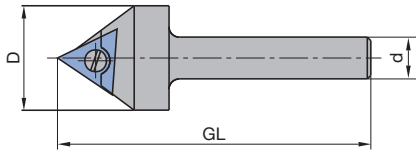




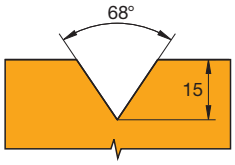
HW



V groove cutter



V groove cutter 68° (ID **042932**)



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

Multi purpose profile cutterhead, Z 1

Application:
Suitable for V grooving profiles and for multi purpose finish cutting (decorative groove, 90° corner etc.).

Machine:
Overhead routers with/without CNC control, special routers with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.).

Technical information:
Cutterhead with exchangeable turnblades. 2 or 3 (ID **042932**) performance times through turning the knife.

Cutting in end grain, Z 1
WL 300-2

D mm	GL mm	NL mm	S mm	FAW	Z	P	DRI	ID	
30	90	15	12x40	68°	1	1	RL	**042932**	●
35	125	42	20x50	45°	1	2	RL	**042933**	●
42	115	35	20x50	60°	1	3	RL	**042934**	●
54	100	27	20x50	90°	1	4	RL	**042935**	●
54	100	27	20x50	91°	1	5	RL	**042936**	●

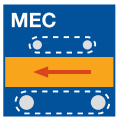
Spare knives:

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**	●

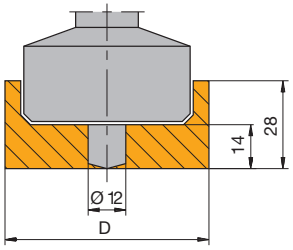
Spare parts:

BEZ	ABM mm	P	ID	
Countersink screw	M5x5	1	**007381**	●
Screw	M4x5	2 - 5	**007038**	●
Torx® key	Torx® 15	2 - 5	**005457**	●

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



HW



Profile area

Multi purpose profile cutterhead, Z 2

Application:
For cutting decorative grooves, internal profiles and combined external and internal profiles.

Machine:
Overhead routers with/without CNC control, special routers with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.).

Technical information:
Cutterhead with profiled throwaway knives. One knife with centre cutting design. Knives with shear angle. Different profiles possible in one tool body. Special profiles ground into blank knives and backing plates on request. Use cutterhead WP 500-1 for smaller decorative groove profiles (d < 15 mm).

For profiles, Z 2, cutting in end grain
WG 502-2-01

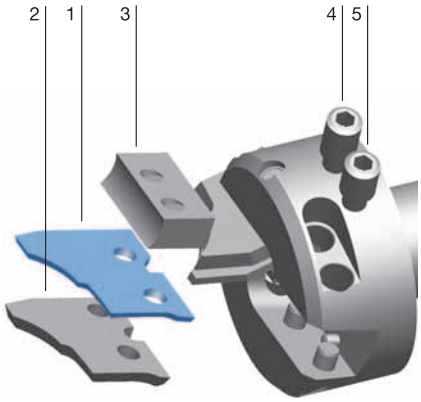
D mm	GL mm	SB mm	S mm	Z	DRI	ID	
65	95	14 - 28	16x50	2	RL	**042872**	●
65	95	14 - 28	20x50	2	RL	**042873**	●
65	105	14 - 28	25x60	2	RL	**042870**	●

Sales unit consisting of cutterhead with clamping wedge but without profiled HW knives and backing plates. Tip with 1 replaceable profile knife and backing plate each, version A and 1 replaceable profile knife and backing plate each, version B.

Minimum order quantity:
Replaceable profile knife: 6 pcs. each A and B
Backing plates: 1 pc. each A and B
Profile examples see below.

Spare parts:

Part-no.	BEZ	ABM mm	QAL	ID	
1	Blank knife	35,5x30,5x2	HW	**007488**	●
1	Blank knife	35,5x30,5x2	HW	**007489**	●
2	Backing plate A	34x28x4		**007923**	●
2	Backing plate B	34x28x4		**007924**	●
3	Clamping wedge	25x15x8		**009969**	●
4	Allen screw	M8x16		**006042**	●
5	Allen screw	M8x14		**006073**	●
	Allen Key	SW 4		**005445**	●

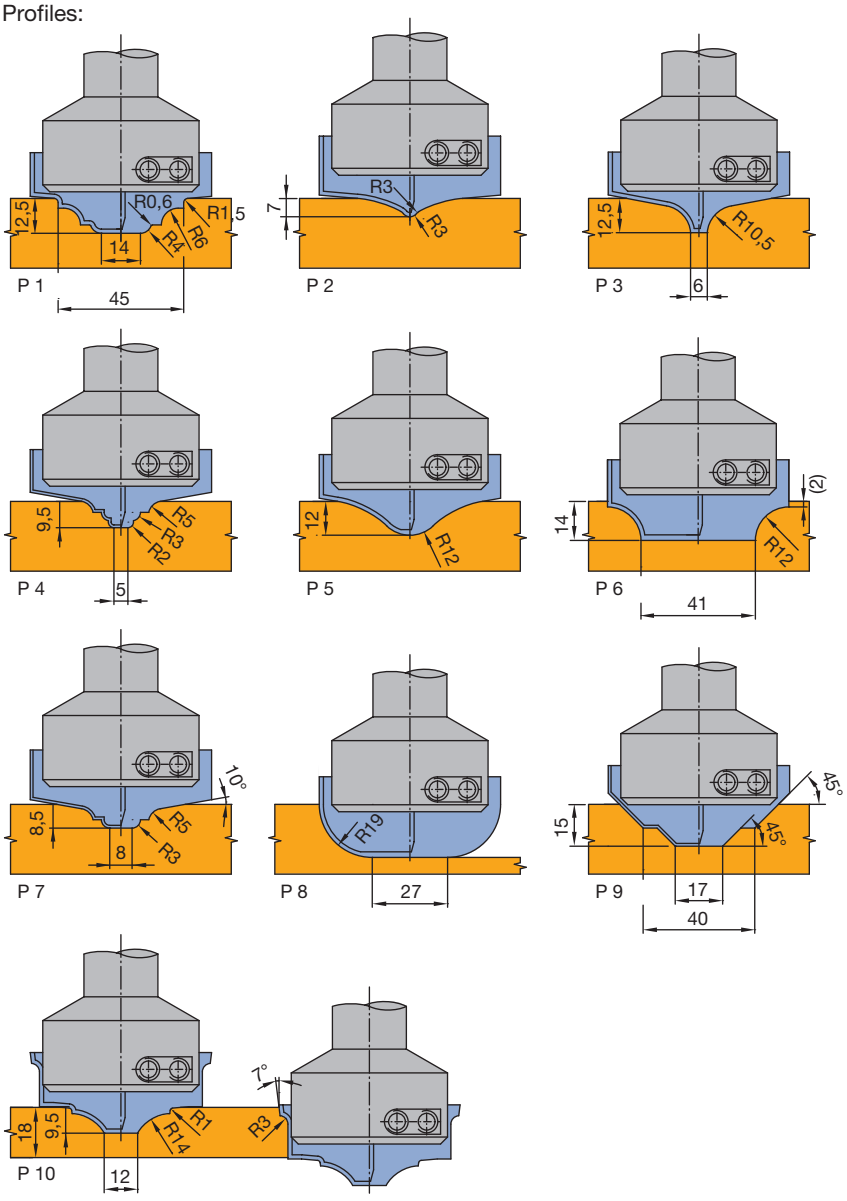


Sets of profile knives and backing plates
AT 103-0

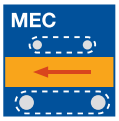
P	ID Profile cutter-set	ID Set of backing plates
1	**692000** □	**692200** □
2	**692001** □	**692201** □
3	**692002** □	**692202** □
4	**692003** □	**692203** □
5	**692004** □	**692204** □
6	**692005** □	**692205** □
7	**692006** □	**692206** □
8	**692007** □	**692207** □
9	**692008** □	**692208** □
10	**692009** □	**692209** □

Set of profile knives consisting of 1 profile knife design A and B each.
Set of backing plates consisting of 1 backing plate design A and B each.
Minimum order quantity: set of profile knives: 6 pcs., set of backing plates: 1 pc.

Profiles:



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



HS

Carving bit

Application:
Router cutter for carving copy shaping with large chip removal.

Machine:
Carving machines, portable routers.

Workpiece material:
Softwood and hardwood.

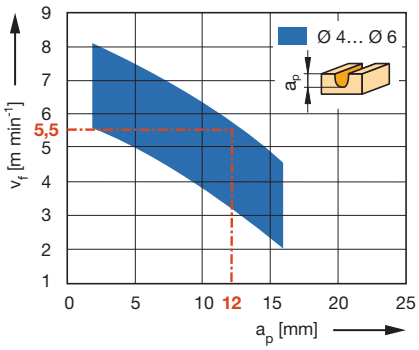
Technical information:
Cutting on end and on periphery, large resharpening area. Low feed forces from spiral cutting edges.

HS solid, Z 1, Z 2
WO 590-2-01, WO 590-2-02

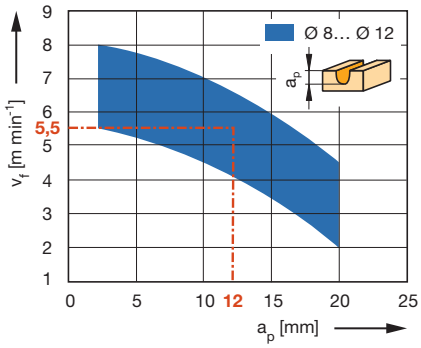
D mm	GL mm	S mm	Z	ID LL		ID RL	
2	82	9x50	1	**039130**	●	**039131**	●
3	82	9x50	1	**039132**	●	**039133**	●
4	82	9x50	2	**039040**	●	**039041**	●
5	86	9x50	2	**039042**	●	**039043**	●
6	86	9x50	2	**039044**	●	**039045**	●
8	90	9x50	2	**039046**	●	**039047**	●
10	90	9x50	2	**039048**	●	**039049**	●
12	90	9x50	2	**039050**	●	**039051**	●
15	95	9x50	2	**039052**	●	**039053**	●
18	95	9x50	2	**039054**	●	**039055**	●
22	95	9x50	2	**039056**	●	**039057**	●
24	95	9x50	2	**039058**	●	**039059**	●

RPM: n = 12000 - 24000 min^{-1}

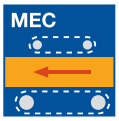
Feed speed v_f depending on grooving depth a_p



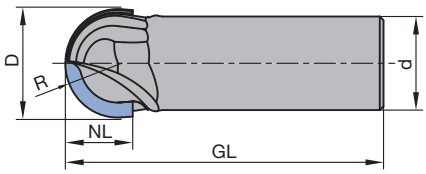
Workpiece material: Softwood
Working step: Copy shaping
Speed: n = 18000 rpm
Correction factor for v_f: Hardwood 0.8



Workpiece material: Softwood
Working step: Copy shaping
Speed: n = 18000 rpm
Correction factor for v_f: Hardwood 0.8



DP



Router cutter - Profile Diamaster PDM

Application:
Routers to cut radius profiles in panels for furniture and interior construction.

Machine:
Overhead routers with/without CNC control, machining centres, special routers with spindles to mount shank tools.

Workpiece material:
Chipboard and fibre materials (MDF, HF, etc.), uncoated, plastic coated, veneered, etc.

Technical information:
DP profile edges with shear angles. 3 to 5 times resharpenable for normal wear.

DP, Z 2
WO 531-2-51

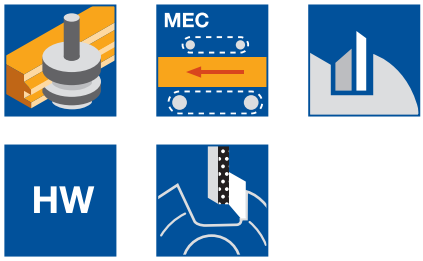
D mm	GL mm	NL mm	S mm	R mm	DRI	ID
20	75	12	20x55	10	RL	**191035**
20	80	12	25x60	10	RL	**191036**
30	80	18	20x55	15	RL	**191037**
30	85	18	25x60	15	RL	**191038**
40	95	24	20x55	20	RL	**191039**
40	95	24	25x60	20	RL	**191040**

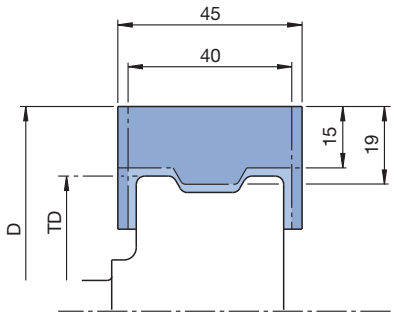
RPM: n = 18000 - 24000 min^{-1}

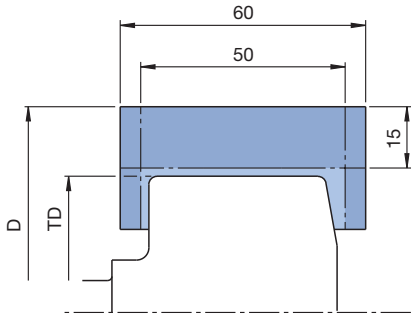
More profiles on request.

Example:
MDF wall covering

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







Profile area

Profile cutterhead VariForm with backing plates

Application:
For cutting different profiles. Profile can be changed by replacing profile knives and backing plates.

Machine:
Overhead routers with/without CNC control, special routers with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood (HW-30F), chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.) (HW-10F).

Technical information:
Three point knife clamping for high precision and safety. Economic, resharpenable 3 to 4 times. Modular system: use the same profile knives in different tool bodies on different machines.

Tool body, mech. feed, Z 2
TU 531-2

D mm	TD mm	SB mm	S mm	$PT_{max.}$ mm	DRI	ID
110	76	40/45	25x60	15	RL	**135400** ●
110	76	50/60	25x60	15	RL	**135401** ●

RPM: n max. = 12000 min^{-1}

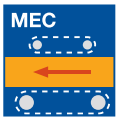
With clamping wedges, but without backing plates and knives.

Spare knives:

BEZ	H mm	SB mm	$PT_{max.}$ mm	ID HW-10F	ID HW-30F
Blank knife VariForm	40	40	15	**636227** ●	**636240** ●
Blank knife VariForm	40	45	15	**636231** ●	**636244** ●
Blank knife VariForm	40	50	15	**636284** ●	**636272** ●
Blank knife VariForm	40	60	15	**636288** ●	**636276** ●

Spare parts:

Tool Type	ABM mm	H mm	for SB mm	$PT_{max.}$ mm	ID
Backing plate	for knives 40x40x2.1	40	40	15	**645000** ●
Backing plate	for knives 45x40x2.1	40	45	15	**645001** ●
Backing plate	for knives 50x40x2.1	40	50	15	**645002** ●
Backing plate	for knives 60x40x2.1	40	60	15	**645003** ●
Clamping wedge	36x13,5x26		40/45		**009761** ●
Clamping wedge	44x13,5x26		50/60		**009762** ●
Allen screw	M10x12				**006044** ●
Key	SW 5, L100				**117506** ●



HS ST HW

Recommendation of cutting material:

	HS	ST	HW	HW
				M-Syst.
Softwood	♦	♦		
Hardwood		◇	♦	♦
Gluelam			◇	♦
Chipboard				♦
MDF				◇
Mineral materials				◇
HPL				◇

♦ suitable
◇ conditionally suitable

Profile cutterhead for serrated back blank knives

Application:
For cutting different profiles.

Machine:
Overhead routers with/without CNC control, special routers with spindles to mount shank tools.

Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood etc.).

Technical information:
High precision knife clamping through serrated back knives. Wide range of different cutting materials to suit the workpiece material.

Z 2
WP 510-2-01

D mm	TD mm	SB mm	GL mm	S mm	Z	DRI	$n_{max.}$ min^{-1}	ID	
100	63	40	100	25x60	2	RL	12000	**042890**	●

Sales unit consisting of cutterhead and clamping system, but without knives.

Blank knives with thickness 6 mm
TC 110-0

SB mm	H mm	DIK mm	ID HS		ID HW		ID ST	
40	41,5	6	**007327**	●	**007486**	●	**007763**	●

Spare parts:

BEZ	BEM	ABM mm	ID	
Clamping wedge	for standard blanks	39x18,5x7,2	**009970**	●
Allen screw		M8x14	**006073**	●
Allen Key		SW 4, L 71	**005468**	●

Blank knives with micro serration
TC 110-0-15

BEZ	SB mm	DIK mm	QAL	ID	
Backing plate	40	6		**008181**	●
Blank knife	40	2,5	HW	**009423**	●

Micro serrated knives and backing plates can only be used in WP 510-2-01 cutterheads if the MS clamping wedge is used.

Spare parts:

BEZ	BEM	ABM mm	ID	
Clamping wedge MS	for micro serrated knives	39x18x6	**009771**	●
Allen screw		M8x14	**006073**	●
Allen Key		SW 4, L 71	**005468**	●

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

Inquiry/order form special tools – routing

Customer details: Customer number: (if known) ☐☐☐☐☐☐☐☐

☐ Inquiry ☐ Order

Delivery date: (not binding) ☐☐ CW

Company:

Street:

Post code/place:

Country:

Phone/fax:

Contact person:

Signature:

Date:

Inquiry/order no.:

Tool ID: (if known)

Quantity:

Workpiece material:

Solid wood Type:

Wood-derived material Type:

Other Type:

Direction of machining for solid wood or veneered workpieces:

☐ along grain

☐ across grain

Type of coating:

Additional information:

Machine:

Manufacturer:

Range of RPM: min^{-1}

Adaptor
(e. g. SK 30, HSK-F 63 etc.):

Tool:

Tool type (see selection pages):

Dimensions:

Diameter: mm

Cutting width: mm

Shank diameter: mm

No. of teeth:

Cutting material:

☐ HS

☐ HW

☐ ST

☐ DP Type of feed:

☐ Mech. feed

☐ Manual feed

Direction of rotation:

☐ left hand

☐ right hand

State profile with sketch or drawing:

☐ Cutting on periphery only

☐ Cutting in end grain (ramp plunging possible)

☐ for plunging in z-axis

Arrangement of cutting edges:

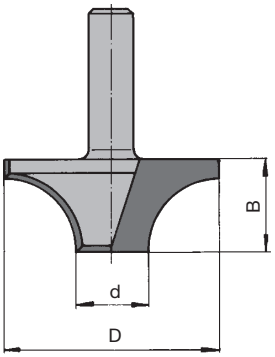
☐ with shear angle on one side

☐ with alternate shear angle

☐ Please tick the appropriate box

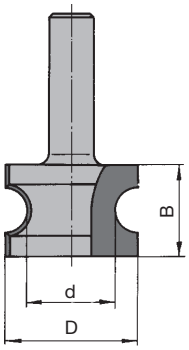
Examples for profile groups 1 and 2:

WO 521-1
open profile



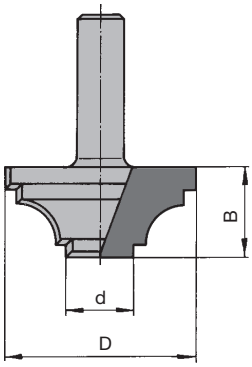
Profile group 1:
cutting on periphery
with bottom knife for
cutting in end grain

WO 522-1
closed profile



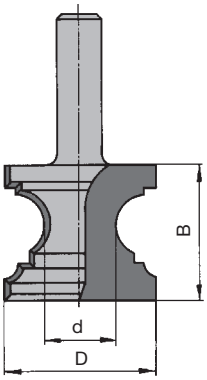
Profile group 1:
cutting on periphery

WO 521-2
open profile



Profile group 2:
cutting on periphery
with bottom knife for
cutting in end grain

WO 522-2
closed profile



Profile group 2:
cutting on periphery
with bottom knife for
cutting in end grain

Sketch for application plan, profile drawing, special motor spindle etc.
Enter on sketch which side of workpiece to table i. e. face side on top/bottom

Key to pictograms


Sawing, multiple cut


Scoring, hogging


Profiling


Carving

Manual feed


Spindle with anti-twist keyway

SP
Alloyed tool steel


Sawing, thin kerf


Hogging


Profiling joints


Grooving, sizing


Solid metal tool


Spindle with anti-twist hexagon

HL
High-alloyed tool steel


Sawing, horizontal


Double hogging


Profiling tongue and groove


Finish sizing


Tipped tool


Hydro clamping system - open

HS
High-speed steel


Sawing along grain


Hogging, folding


Planing


Grooving, horizontal and vertical

Special body alloy


Hydro clamping system - closed

ST
Stellite


Sawing across grain


End trimming


Planing, profiling


Jointing

Light alloy body


Hydro-Duo (bi-directional) clamping

HW
Tungsten carbide


Sawing, universal


Edge trimming


Drilling blind holes


Copy shaping


Inter-changeable knives


Hydro clamping arbors

DP
Poly-crystalline diamond (PKD)


Scoring, sawing


Grooving, horizontal and vertical


Drilling, through holes


Rebating


Mechanical knife clamping, reversible


Hydro clamping

DM
Mono-crystalline diamond (MKD)

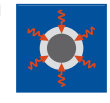

Scoring and sawing stacks


Grooving honeycomb panels


Step drilling


Bevelling


Centrifugal knife clamping, reversible


Shrink-fit clamping

Carbide metal coating


Sawing hollow sections


Jointing


Counter-sinking


Panel raising


Mechanical knife clamping, non-adjustable

Quick clamping system

Diamond coating


Sawing, honeycomb panels


Copy shaping


Slotting


Profiling


Mechanical knife clamping, adjustable - serrated


Resharpenable cutting face


Sawing hollow transparent plastic


Rebating


Spiral boring


Profiling joints


Mechanical knife clamping adjustable - plane


Resharpenable clearance face


Sawing solid transparent plastic


Bevelling

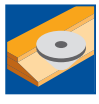

Non-axial boring


Mortising

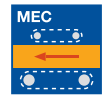
Mechanical knife clamping, re-sharpenable and constant diameter

Low noise

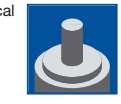

Scoring, top and bottom


Panel raising


Plug cutting



Mechanical feed


Spindle without twist protection

Optimised chip flow