

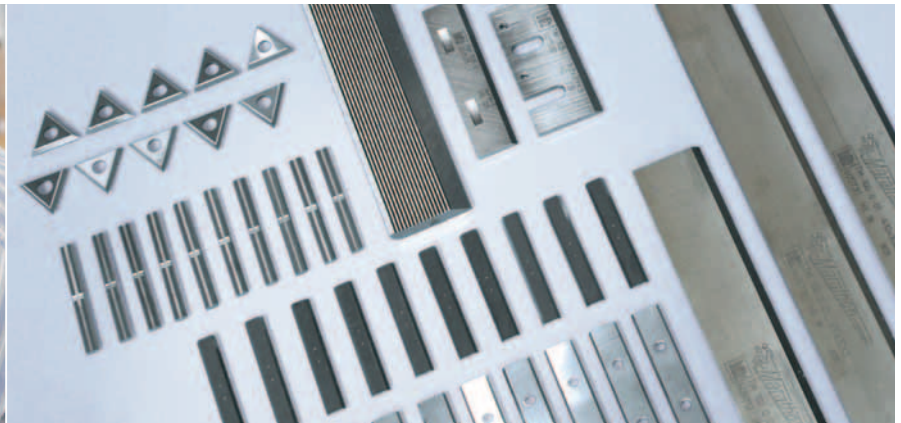


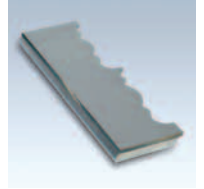
Leitz-Lexicon

Edition 6

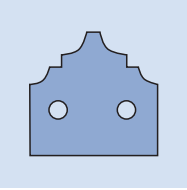
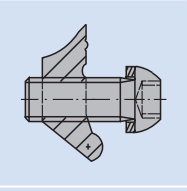
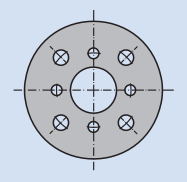
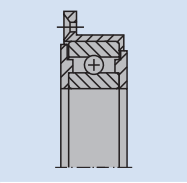
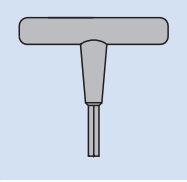
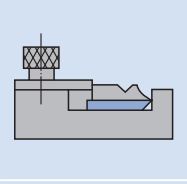
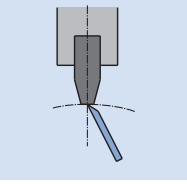
Explanation of abbreviations

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





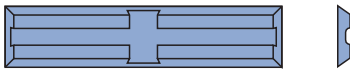
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9. Knives and spare parts

9.1 Knives and blank knives

9.1.1 Turnblade knives



Turnblade knife for router cutter
WL 100-1

Workpiece material:
Softwood and hardwood

Cutting material:
HW

Knife height up to 5.5 mm

HW-05

TM 410-0

SB mm	H mm	DIK mm	KBZ	QAL	VE PCS	ID
20	4,1	1,1	WL 100-1	HW-05	10	005186 ●
20	5,5	1,1	WL 100-1	HW-05	10	005187 ●
25	5,5	1,1	WL 100-1	HW-05	10	005188 ●
30	5,5	1,1	WL 100-1	HW-05	10	005189 ●
40	5,5	1,1	WL 100-1	HW-05	10	005190 ●
50	5,5	1,1	WL 100-1	HW-05	10	005191 ●

ID = 1 piece



Turnblade knife HW

Workpiece material:
Softwood and hardwood

Cutting material:
HW fine grain quality

Knife height 8 mm

HW-30F

TM 410-0

SB mm	H mm	DIK mm	KBZ	QAL	VE PCS	ID
7,7	8	1,5	WP 8/8	HW-30F	10	005068 ●
9,7	8	1,5	WP 8/10	HW-30F	10	005197 ●
11,7	8	1,5	WP 8/12	HW-30F	10	005069 ●
14,7	8	1,5	WP 8/15	HW-30F	10	005070 ●
19,7	8	1,5	WP 8/20	HW-30F	10	005071 ●
25	8	1,5	WP 8/25	HW-30F	10	005198 ●
30	8	1,5	WP 8/30	HW-30F	10	005072 ●
35	8	1,5	WP 8/35	HW-30F	10	005073 ●
40	8	1,5	WP 8/40	HW-30F	10	005074 ●
45	8	1,5	WP 8/45	HW-30F		007679 □
50	8	1,5	WP 8/50	HW-30F	10	005075 ●
60	8	1,5	WP 8/60	HW-30F	10	005076 ●
70	8	1,5	WP 8/70	HW-30F		007680 □
80	8	1,5	WP 8/80	HW-30F	10	005077 ●
100	8	1,5	WP 8/100	HW-30F		005184 ●
120	8	1,5	WP 8/120	HW-30F		005185 ●

ID = 1 piece



Turnblade knife HW

Cutting material:
HW fine grain quality

Cutting edges with microfinish for high
surface quality and cutting performance

HW-30F Microfinish

TM 410-0

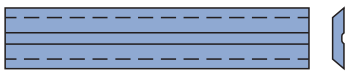
SB mm	H mm	DIK mm	KBZ	QAL	VE PCS	ID
7,7	8	1,5	WP 8/8 MF	HW-30F	10	007517 ●
9,7	8	1,5	WP 8/10 MF	HW-30F	10	007518 ●
11,7	8	1,5	WP 8/12 MF	HW-30F	10	007519 ●
14,7	8	1,5	WP 8/15 MF	HW-30F	10	007520 ●
19,7	8	1,5	WP 8/20 MF	HW-30F	10	007521 ●
25	8	1,5	WP 8/25 MF	HW-30F	10	007522 ●
30	8	1,5	WP 8/30 MF	HW-30F	10	007523 ●
35	8	1,5	WP 8/35 MF	HW-30F	10	007524 ●
40	8	1,5	WP 8/40 MF	HW-30F	10	007525 ●
45	8	1,5	WP 8/45 MF	HW-30F		007683 □
50	8	1,5	WP 8/50 MF	HW-30F		007526 ●
60	8	1,5	WP 8/60 MF	HW-30F		007527 ●
70	8	1,5	WP 8/70 MF	HW-30F		007684 □
80	8	1,5	WP 8/80 MF	HW-30F		007528 ●
100	8	1,5	WP 8/100 MF	HW-30F		007529 ●
120	8	1,5	WP 8/120 MF	HW-30F		007530 ●

ID = 1 piece

9. Knives and spare parts

9.1 Knives and blank knives

9.1.1 Turnblade knives



Turnblade knife HW

Workpiece material:

For abrasive wood derived materials and plastics

Cutting material:

HW

HW-05

TM 410-0

SB mm	H mm	DIK mm	KBZ	QAL	VE PCS	ID
7,7	8	1,5	WP 8/8 B	HW-05	10	005053 ●
9,7	8	1,5	WP 8/10 B	HW-05	10	005054 ●
11,7	8	1,5	WP 8/12 B	HW-05	10	005055 ●
14,7	8	1,5	WP 8/15 B	HW-05	10	005056 ●
19,7	8	1,5	WP 8/20 B	HW-05	10	005057 ●
25	8	1,5	WP 8/25 B	HW-05	10	005058 ●
30	8	1,5	WP 8/30 B	HW-05	10	005059 ●
35	8	1,5	WP 8/35 B	HW-05	10	005400 ●
40	8	1,5	WP 8/40 B	HW-05	10	005401 ●
45	8	1,5	WP 8/45 B	HW-05	10	007681 ●
50	8	1,5	WP 8/50 B	HW-05	10	005402 ●
60	8	1,5	WP 8/60 B	HW-05	10	005403 ●
70	8	1,5	WP 8/70 B	HW-05	10	007682 ●
80	8	1,5	WP 8/80 B	HW-05	10	005404 ●
100	8	1,5	WP 8/100 B	HW-05	10	005405 ●
120	8	1,5	WP 8/120 B	HW-05	10	005406 ●

ID = 1 piece



Turnblade knife HW

Workpiece material:

For extremely abrasive wood derived materials and plastics

Cutting material:

HW UF-ultra-fine grain quality

Cutting edges with microfinish for high surface quality and cutting performance

HW-02UF Microfinish

TM 410-0

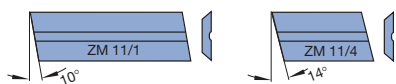
SB mm	H mm	DIK mm	KBZ	QAL	VE PCS	ID
19,7	8	1,5	WP 8/20 D	HW-02UF	10	601001 ●
30	8	1,5	WP 8/30 D	HW-02UF	10	601002 ●
40	8	1,5	WP 8/40 D	HW-02UF	10	601003 ●
50	8	1,5	WP 8/50 D	HW-02UF	10	601004 ●

ID = 1 piece



Turnblade knife
ZM 10/1

Turnblade knife
ZM 10/4



Turnblade knife
ZM 11/1

Turnblade knife
ZM 11/4

Knife height 8 mm (bevel/tenoning tools)

HW-F

TM 410-0

SB mm	H mm	DIK mm	KBZ	QAL	ID
21	8	1,5	ZM 10/1	HW-F	005004 ●
15	8	1,5	ZM 10/4	HW-F	005050 ●
21	8	1,5	ZM 11/1	HW-F	005006 ●
15	8	1,5	ZM 11/4	HW-F	005051 ●

ID = 1 piece

Workpiece material:

Softwood and hardwood

Cutting material:

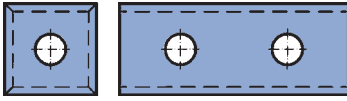
HW fine grain quality

9. Knives and spare parts

9.1 Knives and blank knives

9.1.1 Turnblade knives

Knife type:
Type 1 Type 2



Turnblade knife

Workpiece material:

Solid wood, wood derived materials

Cutting material:

HW

Knife height 12 mm

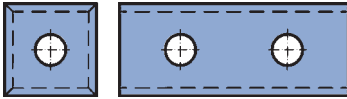
HW-05

TM 405-0

Knife	SB mm	H mm	DIK mm	KBZ	QAL	VE PCS	ID
1	7,5	12	1,5	WP 12/7,5	HW-05	10	005080 ●
1	9	12	1,5	WP 12/9	HW-05	10	005158 ●
1	12	12	1,5	WP 12/12	HW-05	10	005081 ●
2	15	12	1,5	WP 12/15	HW-05	10	005082 ●
2	20	12	1,5	WP 12/20	HW-05	10	005083 ●
2	30	12	1,5	WP 12/30	HW-05	10	005084 ●
2	40	12	1,5	WP 12/40	HW-05	10	005085 ●
2	50	12	1,5	WP 12/50	HW-05	10	005086 ●
2	60	12	1,5	WP 12/60	HW-05	10	005087 ●

ID = 1 piece

Knife type:
Type 1 Type 2



Turnblade knife

Workpiece material:

For abrasive wood derived materials and plastics

Cutting material:

HW fine grain quality

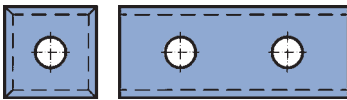
HW-03F

TM 405-0

Knife	SB mm	H mm	DIK mm	QAL	VE PCS	ID
1	20	12	1,5	HW-03F	10	006904 ●
2	30	12	1,5	HW-03F	10	006905 ●
2	50	12	1,5	HW-03F	10	006906 ●

ID = 1 piece

Knife type:
Type 1 Type 2



Turnblade knife

Workpiece material:

For extremely abrasive wood derived materials and plastics

Cutting material:

HW UF-ultra-fine grain quality

HW-02UF

TM 405-0

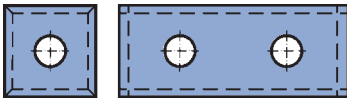
Knife	SB mm	H mm	DIK mm	KBZ	QAL	VE PCS	ID
1	12	12	1,5	WB 12/12 D	HW-02UF	10	602000 ●
2	20	12	1,5	WP 12/20 D	HW-02UF	10	602001 ●
2	30	12	1,5	WP 12/30 D	HW-02UF	10	602002 ●
2	40	12	1,5	WP 12/40 D	HW-02UF	10	602003 ●
2	50	12	1,5	WP 12/50 D	HW-02UF	10	602004 ●

ID = 1 piece

9. Knives and spare parts

9.1 Knives and blank knives

9.1.1 Turnblade knives



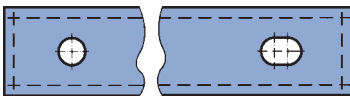
Turnblade knife with polished face

Workpiece material:

Solid wood, wood derived materials

Cutting material:

HW



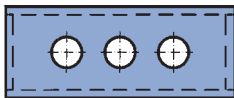
Turnblade knife with polished face

Workpiece material:

For extremely abrasive wood derived materials and plastics

Cutting material:

HW UF-ultra-fine grain quality



Turnblade knife with polished face and 3 holes

Workpiece material:

HW-05 for solid wood, wood derived materials HW-02UF for extremely abrasive wood derived materials and plastics

Cutting material:

HW / HW-UF

Knife height 12 mm with polished face

HW-05

TM 405-0

SB mm	H mm	DIK mm	QAL	VE PCS	ID
30	12	1,5	HW-05	10	005161 ●
50	12	1,5	HW-05	10	006506 ●

ID = 1 piece

HW-02UF

TM 405-0

SB mm	H mm	DIK mm	QAL	VE PCS	ID
30	12	1,5	HW-02UF	10	602005 ●
50	12	1,5	HW-02UF	10	602006 ●

ID = 1 piece

HW-05 / HW-02UF with 3 holes

TM 405-0

SB mm	H mm	DIK mm	QAL	VE PCS	ID
50	12	1,7	HW-05	10	007668 ●
50	12	1,5	HW-02UF	10	602007 ●

ID = 1 piece



Turnblade knife

Workpiece material:

Softwood and hardwood

Cutting material:

HW

Knife height 12 mm (slotting tools)

HW

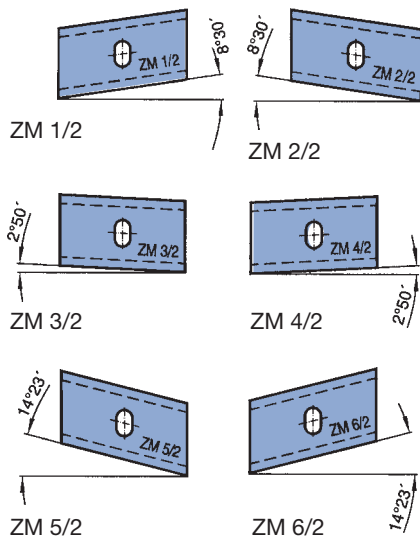
TM 405-0

SB mm	H mm	DIK mm	KBZ	QAL	ID
7,6	12	1,5	SM 1/1	HW	005120 ●
9,6	12	1,5	SM 1/2	HW	005121 ●
11,6	12	1,5	SM 1/3	HW	005122 ●

9. Knives and spare parts

9.1 Knives and blank knives

9.1.1 Turnblade knives



Knife height 12 mm (tenoning tools)

HW

TM 405-0

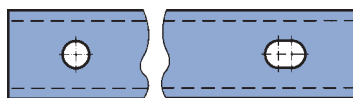
SB mm	H mm	DIK mm	KBZ	QAL	ID
21,5	12	1,5	ZM 1/2	HW	005124 ●
21,5	12	1,5	ZM 2/2	HW	005125 ●
21,5	12	1,5	ZM 3/2	HW	005126 ●
21,5	12	1,5	ZM 4/2	HW	005127 ●
21,5	12	1,5	ZM 5/2	HW	005128 ●
21,5	12	1,5	ZM 6/2	HW	005129 ●

Workpiece material:

Softwood and hardwood

Cutting material:

HW



Turnblade knife

Knife height 13 mm

HW

TM 405-0

SB mm	H mm	DIK mm	QAL	VE PCS	ID
80	13	2,2	HW	10	005096 ●
100	13	2,2	HW	10	005097 ●
120	13	2,2	HW	10	005098 ●

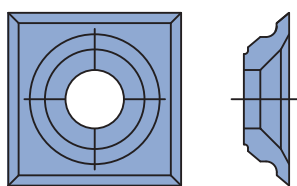
Workpiece material:

Softwood and hardwood

Cutting material:

HW

ID = 1 piece



Turnblade knife with 4 cutting edges

Knife height 21 mm with 4 cutting edges

HW

TM 410-0

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

Workpiece material:

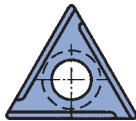
Softwood and hardwood

Cutting material:

HW



VS 1



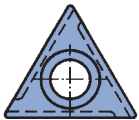
VS 3L



VS 2



VS 4



VS 3R

Spurs

HW / DP
TM 480-0

SB mm	H mm	DIK mm	KBZ	QAL	VE PCS	ID
14	14	2	VS 1	HW-F	10	005099 ●
14	14	1,2	VS 4	HW	10	005130 ●
14	14	1,2	Holz-Her	HW	10	602500 ●
15	15	2		HW		005100 ●
19		2	VS 2	HW-F	10	005115 ●
19		2	VS 2MF	HW-F	10	009541 ●
19		2	VS 2R*	HW-F	10	006615 ●
19		2	VS 2L*	HW-F	10	006616 ●
19		2	VS 2	DP*	10	006607 ●
19		2	VS 3R	HW-F		005116 ●
19		2	VS 3L	HW-F		005159 ●

* Spurs with reduced slotting depth. Knives can be used in VS2 knife seating.
MF Cutting edge with Microfinish for high surface quality and cutting performance.
DP* diamond coated.

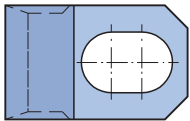
ID = 1 piece

Workpiece material:

Solid wood, wood derived materials

Cutting material:

HW fine grain quality / DP*



Spur knife VS 801

Spur knives resharpenable

HS / HW
TM 180-0

SB mm	H mm	DIK mm	QAL	ID
22	38	7	HS	006505 ●
22	38	7	HW	006605 ●

Workpiece material:

Softwood and hardwood

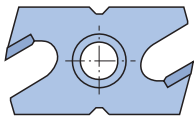
Cutting material:

HS / HW

9. Knives and spare parts

9.1 Knives and blank knives

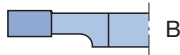
9.1.3 Grooving knives / profile grooving knives



Grooving knife



Grooving knife mirror image



Grooving knife image

Workpiece material:

Softwood and hardwood

Cutting material:

HW fine grain quality

Grooving knives - length cutting

Mechanical feed

TM 460-0

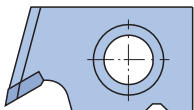
SB mm	KBZ	QAL	ID
3	NA 3B	HW-F	008315 ●
3	NA 3S	HW-F	008316 ●
3	NAK 3B*	HW-F	616002 ●
3	NAK 3S*	HW-F	616003 ●
4,5	NA 4,5	HW-F	008333 ●
4	NA 4	HW-F	008317 ●
5	NA 5	HW-F	008318 ●
7	NA 7	HW-F	008319 ●
8	NAN 8	HW-F	008349 ●
9	NA 9	HW-F	008320 ●

Manual feed

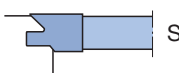
TM 460-1

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

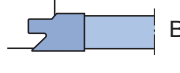
* Grooving knife with reduced grooving depth



Profile grooving knife



Profile grooving knife mirror image



Profile grooving knife image

Workpiece material:

Softwood and hardwood

Cutting material:

HW fine grain quality

Profile grooving knives

For sealing strip

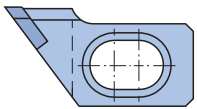
TM 160-0

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

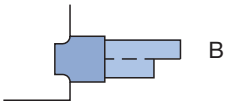
9. Knives and spare parts

9.1 Knives and blank knives

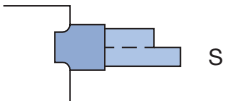
9.1.3 Grooving knives / profile grooving knives



Profile grooving knife



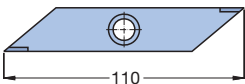
Profile grooving knife image



Profile grooving knife mirror image

Workpiece material:
Softwood and hardwood

Cutting material:
HW



Profile grooving knife



Grooving knife



Grooving knife 15°
bevel image



Grooving knife 20°
bevel image



Grooving knife 20°
bevel mirror image

Cutting material:
HW

Profile grooving knives

For EURO Groove
TM 240-0

SB mm	KBZ	QAL	ID
11	NH 1B	HW	008313 ●
11	NH 1S	HW	008342 ●

For slot and tenon tools
TM 661-0

SB mm	FAW	KBZ	QAL	ID
5,1		ND 5,1	HW	008311 ●
5,3		ND 5,3	HW	008263 ●
6,1		ND 6,1	HW	008314 ●
5,2	15°	NE 1B	HW	008266 ●
5,2	20°	NE 2B	HW	008264 ●
5,2	20°	NE 2S	HW	008265 ●

Lamello turnblade knives

HW
TM 463-0

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

ID = 1 piece



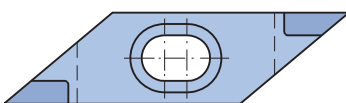
Lamello turnblade knives

Cutting material:
HW

Rhomboid turnblade knives

HW-F
TM 461-0

SB mm	H mm	DIK mm	KBZ	QAL	ID
45,416	12	5,6	RMA 5,6	HW-F	008329 ●
45,416	12	6,6	RMA 6,6	HW-F	008330 ●



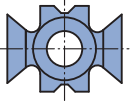
Rhomboid turnblade knives

Cutting material:
HW fine grain quality

9. Knives and spare parts

9.1 Knives and blank knives

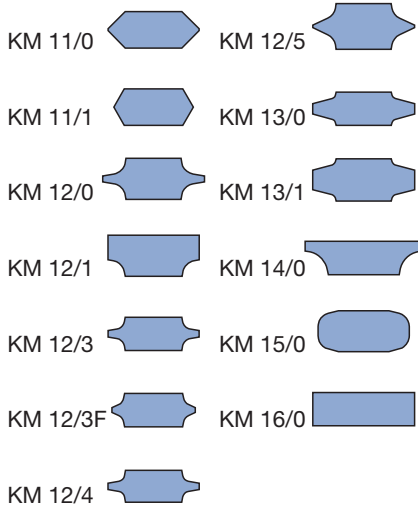
9.1.4 Edging knives



Mechanical feed

HW-F

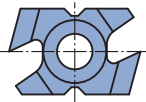
TM 462-0



SB mm	H mm	DIK mm	KBZ	QAL	ID
20	15	8	KM 11/0 45°	HW-F	008268 ●
20	15	7	KM 12/4 R1,5	HW-F	008272 ●
20	15	7,3	KM 12/3 R2	HW-F	008307 ●
22,3	15	9	KM 12/0 R3	HW-F	008270 ●
22	15	9	KM 15/0 R3	HW-F	008275 ●
20	15	9	KM 12/1 R3	HW-F	008271 ●
17,5	15	8	KM 11/1 60°	HW-F	008269 ●
18,3	15	7,3	KM 12/3F R2F	HW-F	008308 ●
22,3	15	10	KM 12/5 R3F	HW-F	008273 ●
22,3	15	7,3	KM 13/0 Groove 5	HW-F	008274 ●
22,3	15	9	KM 13/1 Groove 7	HW-F	008287 ●
22,3	15	7,3	KM 16/0	HW-F	008286 ●
22,3			KM 14/0 R5	HW-F	008347 ●

Workpiece material:
Softwood and hardwood

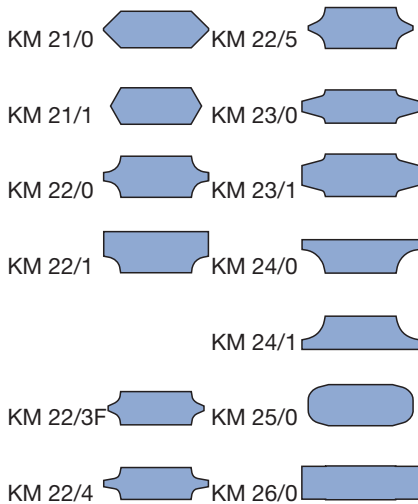
Cutting material:
HW fine grain quality



Manual feed

HW-F

TM 462-1



SB mm	H mm	DIK mm	KBZ	QAL	ID
23	15	7,3	KM 22/3 R2	HW-F	008309 ●
23	15	8	KM 21/0 45°	HW-F	008292 ●
23	15	9	KM 22/1 R3	HW-F	008290 ●
25,7	15	7,3	KM 24/0 R5	HW-F	008305 ●
23	15	7	KM 22/4 R1,5	HW-F	008295 ●
23	15	9	KM 25/0 R3	HW-F	008291 ●
25,7	15	9,3	KM 23/1 Groove 7	HW-F	008298 ●
25,7	15	7,3	KM 24/1 R5	HW-F	008306 ●
23	15	9	KM 22/0 R3	HW-F	008293 ●
20,5	15	8	KM 21/1 60°	HW-F	008294 ●
21	15	7,3	KM 22/3F R2F	HW-F	008310 ●
23	15	9	KM 22/5 R3F	HW-F	008296 ●
25,7	15	7,3	KM 23/0 Groove 5	HW-F	008297 ●
25,7	15	7,3	KM 26/0	HW-F	008299 ●

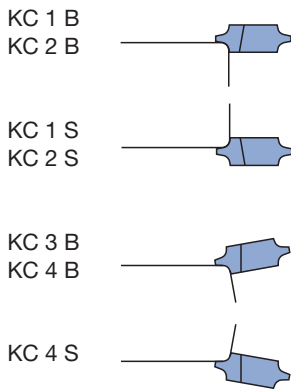
Workpiece material:
Softwood and hardwood

Cutting material:
HW fine grain quality

9. Knives and spare parts

9.1 Knives and blank knives

9.1.4 Edging knives



With bevelled cutting area

HW-F

TM 462-0

SB mm	H mm	DIK mm	KBZ	QAL	ID
20	15	8,3	KC 1B (R2)	HW-F	008334 ●
20	15	10	KC 2B (R3)	HW-F	008335 ●
20	15	8,3	KC 1S (R2)	HW-F	008336 ●
20	15	10	KC 2S (R3)	HW-F	008337 ●
18,3	15	8,3	KC 3B (R2)	HW-F	008338 ●
20	15	10	KC 4B (R3)	HW-F	008339 ●
20	15	10	KC 4S (R3)	HW-F	008341 ●

Workpiece material:

Softwood and hardwood

Cutting material:

HW fine grain quality



KM/1-0



KM/4-0

Previous design

HW

TM 462-0, TM 405-0

KBZ	QAL	ID
KM 1/0	HW	008277 ●
KM 4/0	HW	008276 ●

Workpiece material:

Softwood and hardwood

Cutting material:

HW

9. Knives and spare parts

9.1 Knives and blank knives

9.1.5 Planer knives

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

◆ suitable ◇ partly suitable



Cross section of planer knife (HS / MC)



Cross section of planer knife (HW)

Cutting material:

HS / MC / HW

Wedge angle:

40° (HS / MC)

50° (HW)

Knife height 30 mm

For planerhead wedge-type system WM 200-2-05

TM 100-0, TM 100-0-01

SB mm	H mm	DIK mm	VE PCS	ID HS	ID HW	ID MC
60	30	3	2	027101	027277	605700
80	30	3	2	027102	027278	605701
100	30	3	2	027103	027279	605702
110	30	3	2	027104	027280	605703
120	30	3	2	027105	027281	605704
130	30	3	2	027106	027282	605705
150	30	3	2	027107	027283	605706
170	30	3	2	027108	027284	605707
180	30	3	2	027109	027285	605708
190	30	3	2	027144	027322	605709
210	30	3	2	027110	027286	605710
230	30	3	2	027111	027287	605711
240	30	3	2	027134	027323	605712
250	30	3	2	027161		605713
260	30	3	2	027112	027288	605714
270	30	3	2	027162		605715
310	30	3	2	027113	027289	605716
360	30	3	2	027114	027292	605729
400	30	3	2	027115		605730
410	30	3	2	027116	027293	605731
460	30	3	2	027130	027295	605732
500	30	3	2	027117		605733
510	30	3	2	027118	027296	605734
600	30	3	2	027119		605735
610	30	3	2	027120	027297	605736
630	30	3	2	027125	027298	605737
640	30	3	2	027121	027299	605738
710	30	3	2	027122	027300	605739
810	30	3	2	027123	027302	605740

ID = 1 piece

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

◆ suitable ◇ partly suitable



Cross section of planer knife (HS / MC)

Cutting material:

HS / MC

Wedge angle:

30°

For hydro planerhead HM 200-2-05

TM 100-0-01, TM 100-0-02

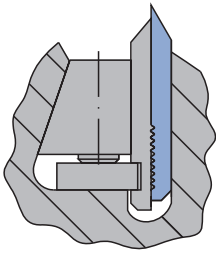
SB mm	H mm	DIK mm	VE PCS	ID HS	ID MC
60	30	3	2	009362	605717
100	30	3	2	009350	605718
130	30	3	2	009351	605719
150	30	3	2	009352	605720
160	30	3	2	009363	605721
180	30	3	2	009353	605722
210	30	3	2	009364	605723
230	30	3	2	009354	605724
260	30	3	2	009355	605725
310	30	3	2	009365	605726
320	30	3	2	009366	605941

ID = 1 piece

9. Knives and spare parts

9.1 Knives and blank knives

9.1.5 Planer knives



Cutting material:
HS

Wedge angle:
30°

Knife height 30 mm

For hydro planerhead RotaPlan Plus
TM 110-0-05

SB mm	H mm	DIK mm	VE PCS	QAL	ID
100	30	3	2	HS	605500 ●
130	30	3	2	HS	605501 ●
160	30	3	2	HS	605502 ●
230	30	3	2	HS	605503 ●

ID = 1 piece

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

◆ suitable ◇ partly suitable



Cross section of planer knife (HS / MC)



Cross section of planer knife (HW)

Cutting material:
HS / MC / HW

Wedge angle:
40° (HS / MC)
50° (HW)

Knife height 35 mm

For long planerheads wedge-type system
TM 100-0, TM 100-0-01

SB mm	H mm	DIK mm	VE PCS	ID HS	ID HW	ID MC
310	35	3	2	027351 ●	027303 ●	605800 ●
320	35	3	2	027352 ●	027304 ●	605801 ●
330	35	3	2	027353 ●	027305 ●	605802 ●
360	35	3	2	027354 ●	027306 ●	605803 ●
400	35	3	2	027355 ●	027307 ●	605804 ●
410	35	3	2	027356 ●	027308 ●	605805 □
450	35	3	2	027357 ●	027309 ●	605806 □
460	35	3	2	027358 ●	027310 ●	605807 □
500	35	3	2	027359 ●	027311 ●	605808 □
510	35	3	2	027360 ●	027312 ●	605809 □
600	35	3	2	027361 ●	027313 ●	605810 □
610	35	3	2	027362 ●	027314 ●	605811 □
630	35	3	2	027363 ●	027315 ●	605812 □
635	35	3	2	027364 ●	027316 ●	605813 □
640	35	3	2	027365 ●	027317 ●	605814 □
700	35	3	2	027366 ●	027318 ●	605815 □
710	35	3	2	027367 ●	027319 ●	605816 □
740	35	3	2	027368 ●	027320 ●	605817 □
810	35	3	2	027369 ●	027321 ●	605818 □

ID = 1 piece

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

◆ suitable ◇ partly suitable



Cross section of planer knife (HS / MC)

Wedge angle:
30°

Cutting material:
HS / MC

For hydro planerhead RotaPlan HM 200-2-06
TM 100-0-01, TM 100-0-02

SB mm	H mm	DIK mm	VE PCS	ID HS	ID MC
60	35	3	2	009342 ●	605950 □
100	35	3	2	009343 ●	605951 □
160	35	3	2	009344 ●	605952 □
230	35	3	2	009345 ●	605953 □
320	35	3	2	009346 ●	605954 □

ID = 1 piece

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

◆ suitable ◇ partly suitable



Cross section of planer knife (HS / MC)



Cross section of planer knife (HW)

Cutting material:
HS / HW



Grooving knife



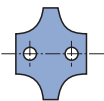
Bevel knife



Fluting knife



Half-fluting knife



Radius knife

Cutting material:
HS / HW

Knives for cassette system

Planer knives 30 mm with threaded bore

TM 105-0

SB mm	H mm	DIK mm	VE PCS	ID HS	ID HW
130	30	3	2	006825	006915 ●
150	30	3	2	006928	006931 ●
180	30	3	2	006826	006916 ●
190	30	3	2	006929	006932 ●
230	30	3	2	006827	006917 ●
240	30	3	2	006926	006933 ●

ID = 1 piece

Profile knives for cassette system

TM 160-0, TM 435-0

BEZ	SB mm	H mm	DIK mm	QAL	DRI	ID
Bevelling knife 45°	18	32,2	12	HW	LL	006890 ●
Bevelling knife 45°	18	32,2	12	HW	RL	006891 ●
Grooving knife, SB 8	18	35,7	9,5	HW	LL	006896 ●
Grooving knife, SB 8	18	35,7	9,5	HW	RL	006897 ●
Fluting knife, R4	18	30	10	HW	LL	006898
Fluting knife, R4	18	30	10	HW	RL	006899
Half-fluting knife R5	18	31,2	10	HW	LL	006900
Half-fluting knife R5	18	31,2	10	HW	RL	006901
Half-fluting knife R3	18	29,2	10	HW	LL	006902
Half-fluting knife R3	18	29,2	10	HW	RL	006903
Radius knife R 3	30	29	4	HS	LL / RL	007660 ●
Radius knife R 4	30	31	4	HS	LL / RL	007661 ●
Radius knife R 6	30	35	4	HS	LL / RL	007663
Radius knife R 7	30	37	4	HS	LL / RL	007664
Radius knife R 8	30	39	4	HS	LL / RL	007665 ●
Radius knife R 9	30	41	4	HS	LL / RL	007666
Radius knife R 10	30	43	4	HS	LL / RL	007667 ●
Radius knife R 5	30	33	4	HS	LL / RL	007662 ●

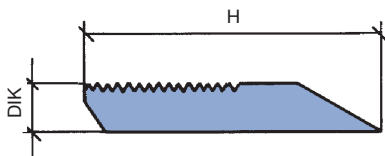
9. Knives and spare parts

9.1 Knives and blank knives

9.1.5 Planer knives

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

◆ suitable ◇ partly suitable



Knife height 40 mm

For 60° serrated back knife planer heads

AT 103-0-22

SB mm	H mm	DIK mm	SET PCS	QAL	ID
40	40	5	2	MC	697156 ●
60	40	5	2	MC	697157 ●
80	40	5	2	MC	697158 ●
100	40	5	2	MC	697159 ●
130	40	5	2	MC	697160 ●
150	40	5	2	MC	697161 ●
170	40	5	2	MC	697162 ●
180	40	5	2	MC	697163 ●
190	40	5	2	MC	697164 ●
210	40	5	2	MC	697165 ●
230	40	5	2	MC	697166 ●
240	40	5	2	MC	697167 ●
270	40	5	2	MC	697168 ●
310	40	5	2	MC	697169 ●

Set of the same weight.

Cutting material:

MC

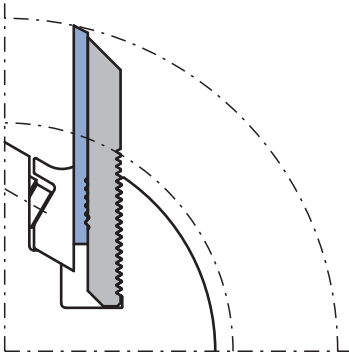
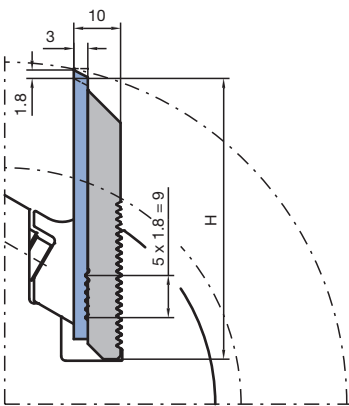
9. Knives and spare parts

9.1 Knives and blank knives

9.1.5 Planer knives

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

◆ suitable ◇ partly suitable



Knife height 40 mm - Powerknife system PKS®

For 60° serrated back knife planer heads

AT 103 0 26, AT 107 0 26

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

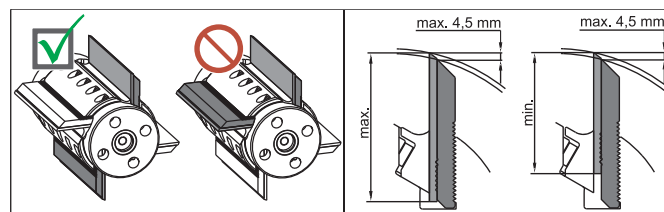
Set of the same weight.

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

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

Attention:

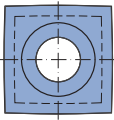
Maximum knife protrusion above the backing plate 4.5 mm. For safety reasons, only mount knives and backing plates of same weight in opposite seatings.



9. Knives and spare parts

9.1 Knives and blank knives

9.1.5 Planer knives



HW turnblade knife

Workpiece material:
Softwood and hardwood

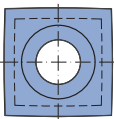
Cutting material:
HW

Turnblade planing knives Heliplan

For cutterhead system HeliPlan
TM 405-0

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

ID = 1 piece



HW turnblade knife

Workpiece material:
Softwood and hardwood

Cutting material:
HW

Turnblade planing knives CASTOR

For cutterhead system CASTOR
TM 405-0

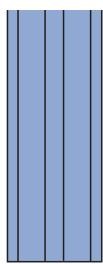
BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	15x15x2,5	HW	10	009540 ●

ID = 1 piece

Turnblade planing knives CentroStar, CentroFix, QuickFix

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

◆ suitable ◇ partly suitable



Turnblade knife CentroFix

Cutting material:
HS

For cutterhead system CentroStar, CentroFix, QuickFix - HS
AT 103-0-02, AT 103-0-20

SB mm	H mm	DIK mm	SET PCS	QAL	ID
100	12	2,7	4	HS	610203 ●
120	12	2,7	4	HS	610204 ●
124,6	12	2,7	4	HS	610244 ●
130	12	2,7	4	HS	610205 ●
136	12	2,7	4	HS	610206 ●
150	12	2,7	4	HS	610208 ●
170	12	2,7	4	HS	610210 ●
180	12	2,7	4	HS	610211 ●
186	12	2,7	3	HS	610247 ●
190	12	2,7	4	HS	610212 ●
210	12	2,7	4	HS	610213 ●
230	12	2,7	4	HS	610214 ●
240	12	2,7	4	HS	610215 ●
260	12	2,7	4	HS	610017 ●
310	12	2,7	4	HS	610018 ●
400	12	2,7	4	HS	610022 ●
410	12	2,7	4	HS	610023 ●
410	12	2,7	3	HS	610043 ●
420	12	2,7	4	HS	610024 ●
430	12	2,7	4	HS	610025 ●
500	12	2,7	4	HS	610028 ●
510	12	2,7	4	HS	610029 ●
520	12	2,7	4	HS	610030 ●
530	12	2,7	4	HS	610031 ●
540	12	2,7	4	HS	610032 ●
610	12	2,7	4	HS	610034 ●
630	12	2,7	4	HS	610036 ●
640	12	2,7	4	HS	610038 ●
710	12	2,7	4	HS	610040 ●
810	12	2,7	4	HS	610042 ●

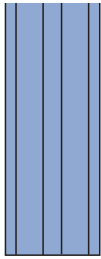
9. Knives and spare parts

9.1 Knives and blank knives

9.1.5 Planer knives

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

◆ suitable ◇ partly suitable



Turnblade knife CentroFix

Cutting material:

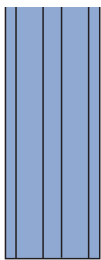
MC

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

SB	H	DIK	SET	QAL	ID
mm	mm	mm	PCS		
100	12	2,7	4	MC	610278 ●
120	12	2,7	4	MC	610279 ●
130	12	2,7	4	MC	610280 ●
150	12	2,7	4	MC	610281 ●
180	12	2,7	4	MC	610282 ●
230	12	2,7	4	MC	610283 ●
240	12	2,7	4	MC	610284 ●
310	12	2,7	4	MC	610285 ●

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

◆ suitable ◇ partly suitable



Turnblade knife CentroFix

Cutting material:

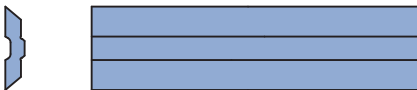
HW-F

For cutterhead system CentroStar, CentroFix, QuickFix - HW-F AT 103-0-20, TM 410-0-02

SB	H	DIK	SET	QAL	ID
mm	mm	mm	PCS		
100	12	2,7	2	HW-F	610606 ●
120	12	2,7	2	HW-F	610610 ●
130	12	2,7	2	HW-F	610612 ●
136	12	2,7	2	HW-F	610614 ●
150	12	2,7	2	HW-F	610616 ●
170	12	2,7	2	HW-F	610620 ●
180	12	2,7	2	HW-F	610621 ●
190	12	2,7	2	HW-F	610625 ●
210	12	2,7	2	HW-F	610627 ●
230	12	2,7	2	HW-F	610629 ●
240	12	2,7	2	HW-F	610631 ●
400	12	2,7	1	HW-F	612016 ●
410	12	2,7	1	HW-F	612017 ●
420	12	2,7	1	HW-F	612018 ●
430	12	2,7	1	HW-F	612019 ●
500	12	2,7	1	HW-F	612022 ●
510	12	2,7	1	HW-F	612023 ●
520	12	2,7	1	HW-F	612024 ●
530	12	2,7	1	HW-F	612025 ●
540	12	2,7	1	HW-F	612026 ●

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

◆ suitable ◇ partly suitable



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

Cutting material:
HS / HW

Turnblade planing knives VariPlan / VariPlan PLUS

For cutterhead system VariPlan / VariPlan PLUS

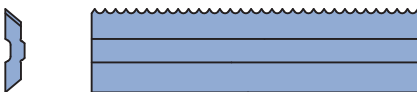
AT 103-0-03, AT 103-0-27

SB mm	H mm	DIK mm	SET PCS	ID HS	ID HS Mi- crofinish	ID HW	ID HW Mi- crofinish	
50	16	3,7	2	610500	□	610700	□	
60	16	3,7	2	610501	●	610701	●	
80	16	3,7	2	610502	●	610702	●	
100	16	3,7	2	610504	●	617004	□	
120	16	3,7	2	610505	●	617005	□	
130	16	3,7	2	610506	●	617006	●	
136	16	3,7	2	610508	●	610708	●	
150	16	3,7	2	610509	●	617009	●	
170	16	3,7	2	610511	●	617011	●	
180	16	3,7	2	610512	●	617012	●	
190	16	3,7	2	610514	●	617014	●	
210	16	3,7	2	610515	●	617015	●	
230	16	3,7	2	610516	●	617016	●	
240	16	3,7	2	610518	●	617018	●	
270	16	3,7	2		617065	●	617165	●
310	16	3,7	2	610522	●	617022	●	
330	16	3,7	2		617024	□	617124	□
360	16	3,7	2		617025	□	617125	□
400	16	3,7	2	610526	□	610726	□	
410	16	3,7	2	610527	□	610727	□	
410	16	3,7	3	610528	□			
420	16	3,7	2	610529	□	610729	□	
430	16	3,7	2	610530	□	610730	□	
500	16	3,7	2	610533	□	610733	□	
510	16	3,7	4	610562	□	610762	□	
520	16	3,7	4	610563	□	610763	□	
530	16	3,7	2	610536	□	610736	□	
540	16	3,7	2	610537	□	610737	□	
600	16	3,7	2	610538	□	610738	□	
610	16	3,7	2	610539	□	610739	□	
630	16	3,7	2	610541	□	610741	□	
640	16	3,7	4	610564	□	610764	□	

For cutterhead system VariPlan PLUS

AT 103-0-23, AT 103-0-24

SB mm	H mm	DIK mm	SET PCS	ID HW Integral	ID HW RipTec
100	16	3,7	2	611904	□
120	16	3,7	2	611905	□
130	16	3,7	2	611906	●
150	16	3,7	2	611909	●
170	16	3,7	2	611911	●
180	16	3,7	2	611912	●
190	16	3,7	2	611914	●
210	16	3,7	2	611915	●
230	16	3,7	2	611916	●
240	16	3,7	2	611918	●
270	16	3,7	2	611965	●
310	16	3,7	2	611922	●
330	16	3,7	2	611924	□
360	16	3,7	2	611925	□



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



Turnblade knife VariPlan HW RipTec
resharpenable, for precutting soft and
hardwood

Cutting material:
HW

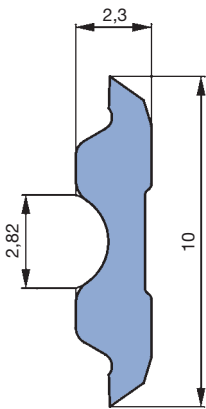
9. Knives and spare parts

9.1 Knives and blank knives

9.1.5 Planer knives

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

◆ suitable ◇ partly suitable



Turnblade knife TriTec

Workpiece material:
Softwood and hardwood

Cutting material:
HS

For:

Long cutterheads

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

Cutterheads

with centrifugal force clamping system for 4-side moulding machines (e.g. Weinig, SCM, Leadermac)

Turnblade planing knives TriTec

For cutterhead system Tersa, HS

AT 103-0-12

SB mm	H mm	DIK mm	QAL	SET PCS	ID
60	10	2,3	HS	4	610900 □
80	10	2,3	HS	4	610901 □
100	10	2,3	HS	4	610902 □
110	10	2,3	HS	4	610903 □
120	10	2,3	HS	4	610904 ●
130	10	2,3	HS	4	610905 ●
140	10	2,3	HS	4	610906 ●
150	10	2,3	HS	4	610907 □
170	10	2,3	HS	4	610908 ●
180	10	2,3	HS	4	610909 ●
190	10	2,3	HS	4	610910 ●
200	10	2,3	HS	4	610911 ●
210	10	2,3	HS	4	610912 □
220	10	2,3	HS	4	610913 ●
230	10	2,3	HS	4	610914 ●
240	10	2,3	HS	4	610915 ●
250	10	2,3	HS	4	610916 □
260	10	2,3	HS	4	610917 ●
265	10	2,3	HS	4	610918 ●
270	10	2,3	HS	4	610919 ●
300	10	2,3	HS	4	610920 □
310	10	2,3	HS	4	610921 ●
350	10	2,3	HS	4	610922 □
360	10	2,3	HS	4	610923 □
400	10	2,3	HS	4	610924 ●
410	10	2,3	HS	4	610925 ●
420	10	2,3	HS	4	610926 □
430	10	2,3	HS	4	610927 ●
450	10	2,3	HS	4	610928 □
460	10	2,3	HS	4	610929 □
500	10	2,3	HS	4	610930 ●
510	10	2,3	HS	4	610931 ●
520	10	2,3	HS	4	610932 ●
530	10	2,3	HS	4	610933 ●
600	10	2,3	HS	4	610934 □
610	10	2,3	HS	4	610935 ●
630	10	2,3	HS	4	610936 ●
640	10	2,3	HS	4	610937 ●
660	10	2,3	HS	4	610938 □
710	10	2,3	HS	4	610939 □
740	10	2,3	HS	4	610940 □
810	10	2,3	HS	4	610941 ●

Further dimensions on request.

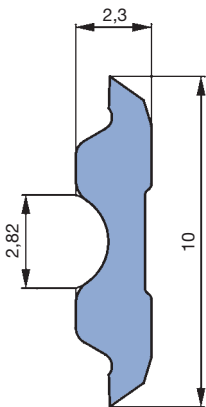
9. Knives and spare parts

9.1 Knives and blank knives

9.1.5 Planer knives

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

◆ suitable ◇ partly suitable



Turnblade knife MicroTec

Cutting material:

HW

Please note:

Knives longer than 540 mm are cut into pieces.

For:

Long cutterheads

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

Cutterheads

with centrifugal force clamping system for 4-side moulding machines (e.g. Weinig, SCM, Leadermac)

Turnblade planing knives MicroTec

For cutterhead system Tersa, HW

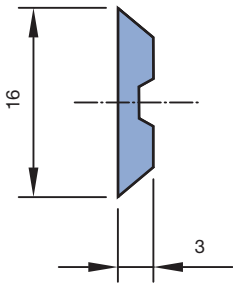
AT 103-0-12

SB mm	H mm	DIK mm	QAL	SET PCS	ID
60	10	2,3	HW	2	610950 □
80	10	2,3	HW	2	610951 □
100	10	2,3	HW	2	610952 □
110	10	2,3	HW	2	610953 □
120	10	2,3	HW	2	610954 □
130	10	2,3	HW	2	610955 □
140	10	2,3	HW	2	610956 □
150	10	2,3	HW	2	610957 □
170	10	2,3	HW	2	610958 □
180	10	2,3	HW	2	610959 □
190	10	2,3	HW	2	610960 □
200	10	2,3	HW	2	610961 □
210	10	2,3	HW	2	610962 □
220	10	2,3	HW	2	610963 □
230	10	2,3	HW	2	610964 □
240	10	2,3	HW	2	610965 □
250	10	2,3	HW	2	610966 □
260	10	2,3	HW	2	610967 □
265	10	2,3	HW	2	610968 □
270	10	2,3	HW	2	610969 □
300	10	2,3	HW	2	610970 □
310	10	2,3	HW	2	610971 □
350	10	2,3	HW	2	610972 □
360	10	2,3	HW	2	610973 □
400	10	2,3	HW	2	610974 □
410	10	2,3	HW	2	610975 □
420	10	2,3	HW	2	610976 □
430	10	2,3	HW	2	610977 □
450	10	2,3	HW	2	610978 □
460	10	2,3	HW	2	610979 □
500	10	2,3	HW	2	610980 □
510	10	2,3	HW	2	610981 □
520	10	2,3	HW	2	610982 □
530	10	2,3	HW	2	610983 □

Further dimensions on request.

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

◆ suitable ◇ partly suitable



Cutting material:
HS / MC / HW

Turnblade planing knives Centrolock

For cutterhead system Centrolock
AT 103-0-13

SB mm	H mm	DIK mm	SET PCS	ID HS	ID HW	ID MC
20	16	3	2	611800	611860	611830
60	16	3	2	611801	611861	611831
80	16	3	2	611802	611862	611832
100	16	3	2	611803	611863	611833
130	16	3	2	611804	611864	611834
150	16	3	2	611805	611865	611835
170	16	3	2	611806	611866	611836
180	16	3	2	611807	611867	611837
190	16	3	2	611808	611868	611838
230	16	3	2	611809	611869	611839
240	16	3	2	611810	611870	611840
260	16	3	2	611811	611871	611841
270	16	3	2	611812	611872	611842
310	16	3	2	611813	611873	611843
460	16	3	2	611814	611874	

Cutting material:
HS

Spiral planer knife

Throw-away knife for spiral planerhead
TM 101-0

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

Cutting material:
HS

Resharpener knife for spiral planerhead
TM 106-0

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

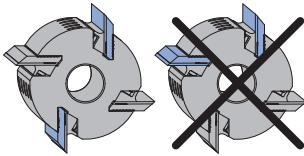
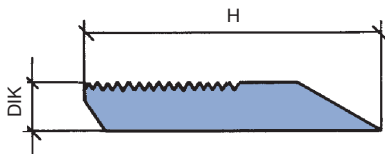
9. Knives and spare parts

9.1 Knives and blank knives

9.1.6 Blank knives

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

◆ suitable ◇ partly suitable



Warning:

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

Cutting material:

HS

Blank knives with 60° back serration

HS, for profile and hydro profile cutterheads

TC 110-0

SB mm	H mm	DIK mm	PT _{max.} mm	VE PCS	QAL	ID
40	45	6	5	2	HS	007299 ●
60	45	6	5	2	HS	007300 ●
80	45	6	5	2	HS	007301 ●
60	50	5	15	2	HS	007320 ●
40	55	6	18	2	HS	007329 ●
60	55	6	18	2	HS	007330 ●
80	55	6	18	2	HS	007331 ●

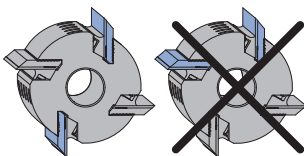
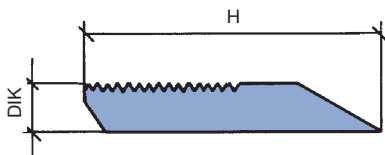
ID = 1 piece

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

◆ suitable ◇ partly suitable

H mm	QAL	PT mm
50	MC	15
60	MC	20
70	MC	30

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



Warning:

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

Cutting material:

MC

The Leitz MC cutting quality replaces previous designs in HS and HS-Marathon.

Blank knives with 60° back serration

MC Marathon, for profile- and hydro profile cutterheads

AT 103-0-22

SB mm	H mm	DIK mm	PT _{max.} mm	SET PCS	QAL	ID
40	50	8	15	2	MC	697107 ●
60	50	8	15	2	MC	697108 ●
80	50	8	15	2	MC	697109 ●
100	50	8	15	2	MC	697110 ●
130	50	8	15	2	MC	697111 ●
150	50	8	15	2	MC	697112 ●
170	50	8	15	2	MC	697132 ●
180	50	8	15	2	MC	697133 □
190	50	8	15	2	MC	697134 □
210	50	8	15	2	MC	697135 □
230	50	8	15	2	MC	697113 ●
240	50	8	15	2	MC	697136 ●
260	50	8	15	2	MC	697114 □
270	50	8	15	2	MC	697137 □
310	50	8	15	2	MC	697138 ●
40	60	8	20	2	MC	697115 ●
60	60	8	20	2	MC	697116 ●
80	60	8	20	2	MC	697117 ●
100	60	8	20	2	MC	697118 ●
130	60	8	20	2	MC	697119 ●
150	60	8	20	2	MC	697120 ●
170	60	8	20	2	MC	697139 ●
180	60	8	20	2	MC	697140 □
190	60	8	20	2	MC	697141 □
210	60	8	20	2	MC	697142 □
230	60	8	20	2	MC	697143 ●
240	60	8	20	2	MC	697144 ●
260	60	8	20	2	MC	697122 □
270	60	8	20	2	MC	697145 □
310	60	8	20	2	MC	697146 ●
40	70	8	30	2	MC	697123 ●
60	70	8	30	2	MC	697124 ●
80	70	8	30	2	MC	697125 ●
100	70	8	30	2	MC	697126 ●
130	70	8	30	2	MC	697127 ●
150	70	8	30	2	MC	697128 ●
170	70	8	30	2	MC	697147 ●
180	70	8	30	2	MC	697129 ●
190	70	8	30	2	MC	697148 □
210	70	8	30	2	MC	697149 □
230	70	8	30	2	MC	697130 □
240	70	8	30	2	MC	697150 ●
260	70	8	30	2	MC	697131 □
270	70	8	30	2	MC	697151 □
310	70	8	30	2	MC	697152 □

Set of the same weight.

9. Knives and spare parts

9.1 Knives and blank knives

9.1.6 Blank knives

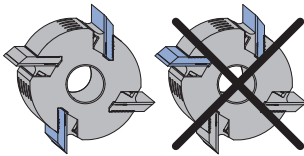
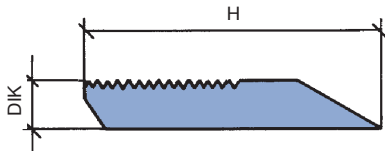
Cutting material recommendation	HS	MC
Solid wood dry	◆	◆
Solid wood wet	◇	◆
Hardwood dry	◇	◆
Hardwood wet	◇	◆
Glulam		◇
Thermoplastics (PE, PP, PVC, etc.)	◆	◆
WPC (Wood-Plastic-Composite)	◇	◆

HS and MC blank knives for cutting to required cutting widths

TC 110-0, TC 110-0-01

SB	H	DIK	PT _{max.}	ID	ID
mm	mm	mm	mm	HS	MC
400	50	8	15		635156 ●
400	60	8	20		635158 ●
400	70	8	30		635160 ●
650	50	8	15	635000 ●	635157 □
650	60	8	20	635001 ●	635159 □
650	70	8	30	635002 ●	635161 □

ID = 1 piece



Warning:

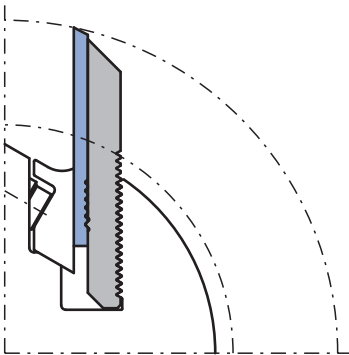
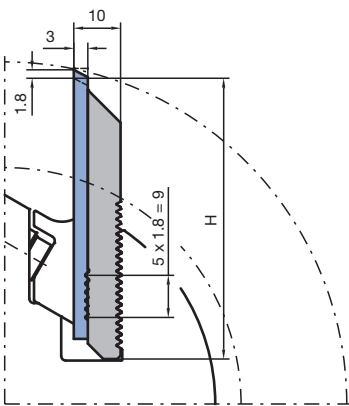
For safety reasons, always mount knives of the same weight in opposite seatings.

Cutting material:

HS / MC

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

◆ suitable ◇ partly suitable



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

Attention:

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

Powerknife system PKS® blank knives / backing plates

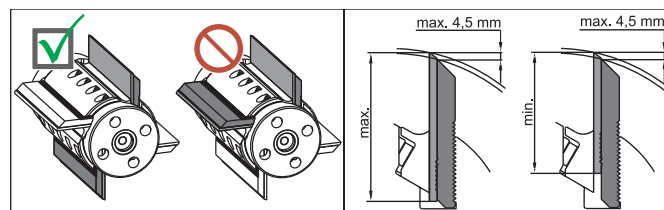
For profile- and hydro profile cutterheads, PT 15 mm
AT 103-0-26, AT 107-0-26

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

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

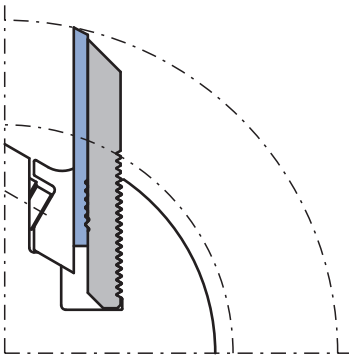
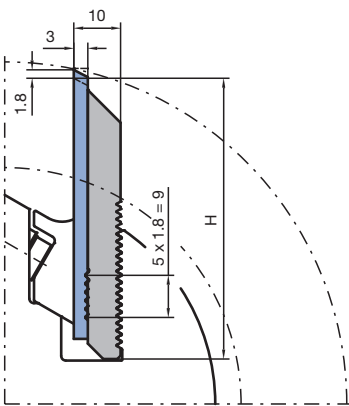
Set of the same weight.

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



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

◆ suitable ◇ partly suitable



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

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

Powerknife system PKS® blank knives / backing plates

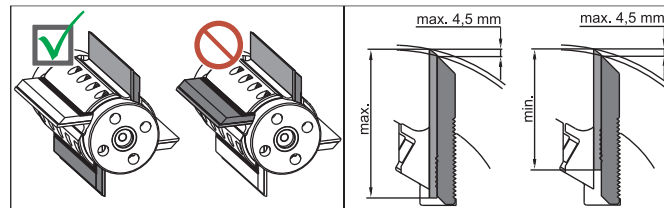
For profile- and hydro profile cutterheads, PT 20 mm
AT 103-0-26, AT 107-0-26

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

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

Set of the same weight.

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



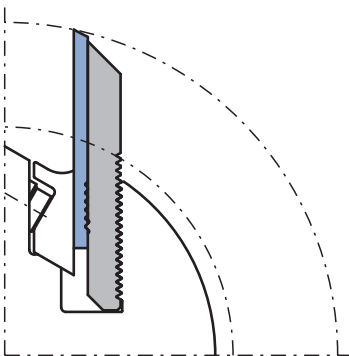
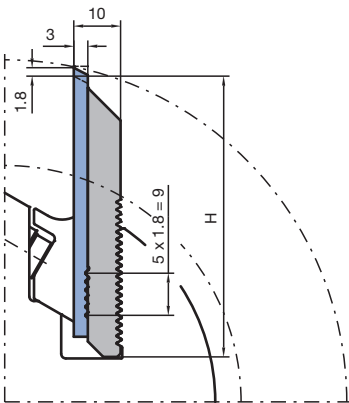
9. Knives and spare parts

9.1 Knives and blank knives

9.1.6 Blank knives

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

◆ suitable ◇ partly suitable



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

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

Powerknife system PKS® blank knives / backing plates

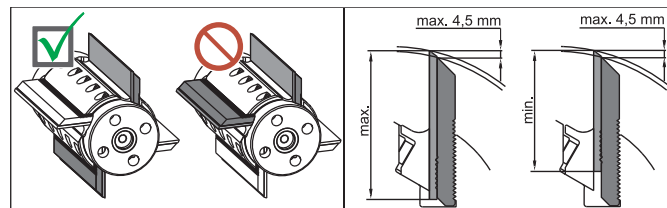
For profile- and hydro profile cutterheads, PT 30 mm
AT 103-0-26, AT 107-0-26

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

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

Set of the same weight.

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





Workpiece material:
Softwood

Cutting material:
SP

For multi-purpose profile cutterheads:
WM 502-2
WM 510-1-01
WM 510-1-02

Profiles to scale 1:1 can be found on the
Leitz Homepage www.leitz.org.

Profile knives for multi-purpose cutterheads

Knives

TM 135-1

LEN Profile	ID	LEN Profile	ID	LEN Profile	ID	LEN Profile	ID
1	026101 ●	23	026123 ●	45	026183 ●	67	026255 ●
2	026102 ●	24	026124 ●	46	026184 ●	68	026256 ●
3	026103 ●	25	026125 ●	47	026185 ●	69	026257 ●
4	026104 ●	26	026126 ●	48	026186 ●	70	026258 ●
5	026105 ●	27	026127 ●	49	026187 ●	71	026259 ●
6	026106 ●	28	026128 ●	50	026188 ●	72	026260 ●
7	026107 ●	29	026129 ●	51	026189 ●	73	026261 ●
8	026108 ●	30	026130 ●	52	026190 ●	74	026262 ●
9	026109 ●	31	026131 ●	53	026191 ●	75	026263 ●
10	026110 ●	32	026132 ●	54	026192 ●	76	026264 ●
11	026111 ●	33	026133 ●	55	026193 ●	77	026292 ●
12	026112 ●	34	026134 ●	56	026194 ●	80	026294 ●
13	026113 ●	35	026135 ●	57	026195 ●	83	690000 ●
14	026114 ●	36	026136 ●	58	026196 ●	84	690001 ●
15	026115 ●	37	026175 ●	59	026197 ●	87	690002 ●
16	026116 ●	38	026176 ●	60	026198 ●	91	690003 ●
17	026117 ●	39	026177 ●	61	026199 ●	92	690004 ●
18	026118 ●	40	026178 ●	62	026200 ●	97	690005 ●
19	026119 ●	41	026179 ●	63	026251 ●	100	690006 ●
20	026120 ●	42	026180 ●	64	026252 ●	127	690007 ●
21	026121 ●	43	026181 ●	65	026253 ●		
22	026122 ●	44	026182 ●	66	026254 ●		

Sold in pairs only.

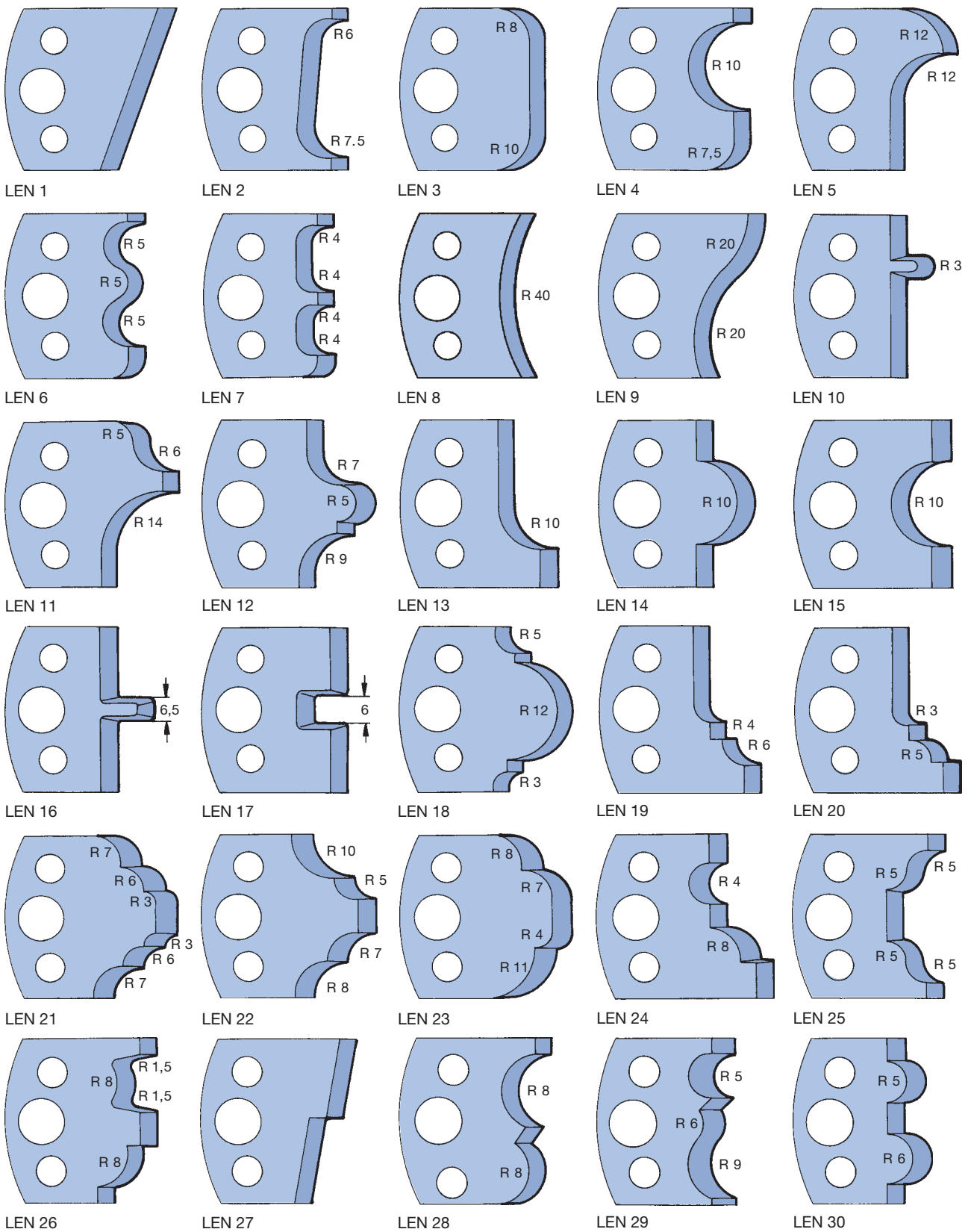
Limitors

TA 300-1

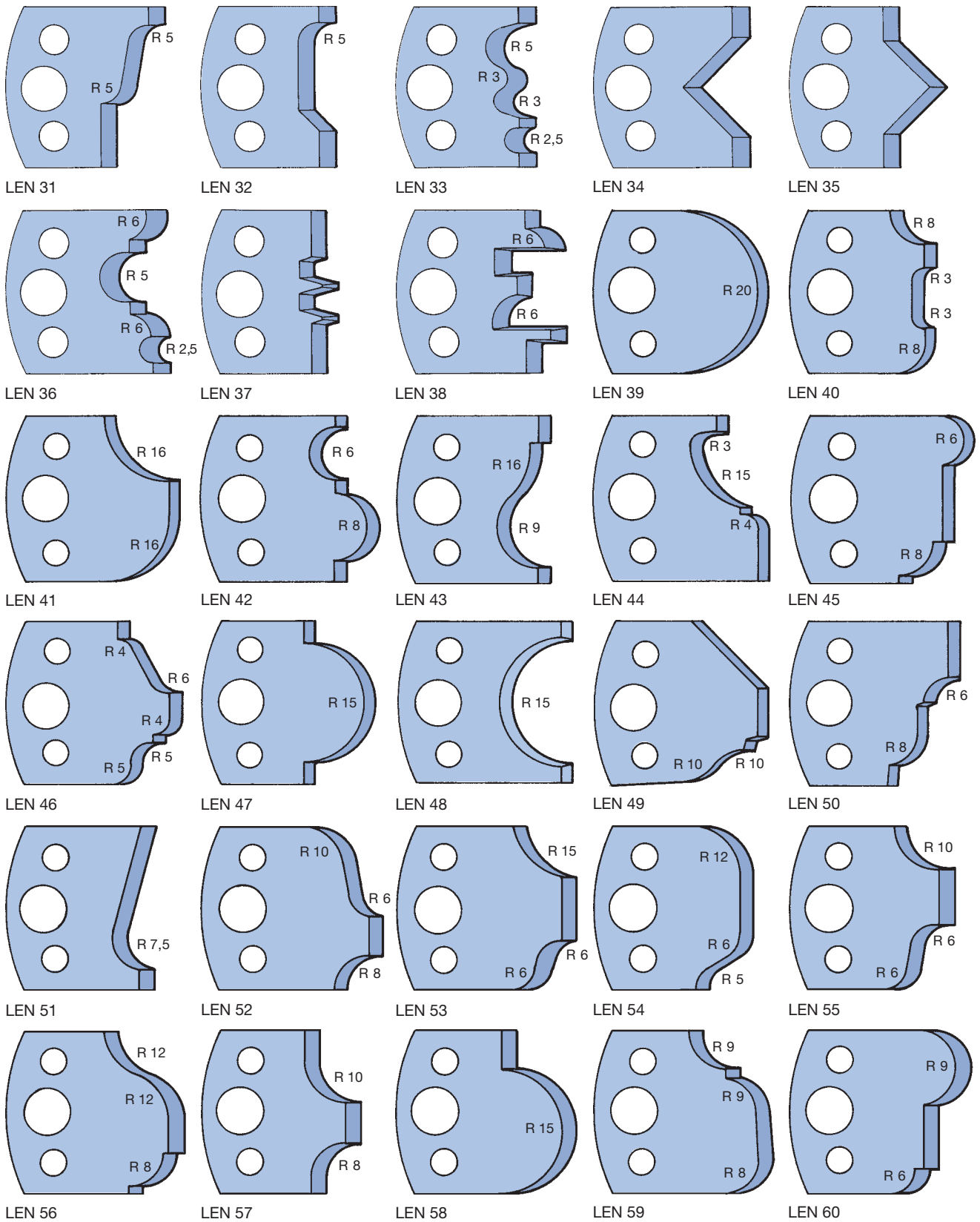
LEN Profile	ID	LEN Profile	ID	LEN Profile	ID	LEN Profile	ID
1	026301 ●	23	026323 ●	45	026390 ●	67	026412 ●
2	026302 ●	24	026324 ●	46	026391 ●	68	026413 ●
3	026303 ●	25	026325 ●	47	026392 ●	69	026414 ●
4	026304 ●	26	026326 ●	48	026393 ●	70	026415 ●
5	026305 ●	27	026327 ●	49	026394 ●	71	026416 ●
6	026306 ●	28	026328 ●	50	026395 ●	72	026417 ●
7	026307 ●	29	026329 ●	51	026396 ●	73	026418 ●
8	026308 ●	30	026330 ●	52	026397 ●	74	026419 ●
9	026309 ●	31	026331 ●	53	026398 ●	75	026420 ●
10	026310 ●	32	026332 ●	54	026399 ●	76	026421 ●
11	026311 ●	33	026333 ●	55	026400 ●	77	026422 ●
12	026312 ●	34	026334 ●	56	026401 ●	80	026423 ●
13	026313 ●	35	026335 ●	57	026402 ●	83	695000 ●
14	026314 ●	36	026336 ●	58	026403 ●	84	695001 ●
15	026315 ●	37	026382 ●	59	026404 ●	87	695002 ●
16	026316 ●	38	026383 ●	60	026405 ●	91	695003 ●
17	026317 ●	39	026384 ●	61	026406 ●	92	695004 ●
18	026318 ●	40	026385 ●	62	026407 ●	97	695005 ●
19	026319 ●	41	026386 ●	63	026408 ●	100	695006 ●
20	026320 ●	42	026387 ●	64	026409 ●	127	695007 ●
21	026321 ●	43	026388 ●	65	026410 ●		
22	026322 ●	44	026389 ●	66	026411 ●		

Sold in pairs only.





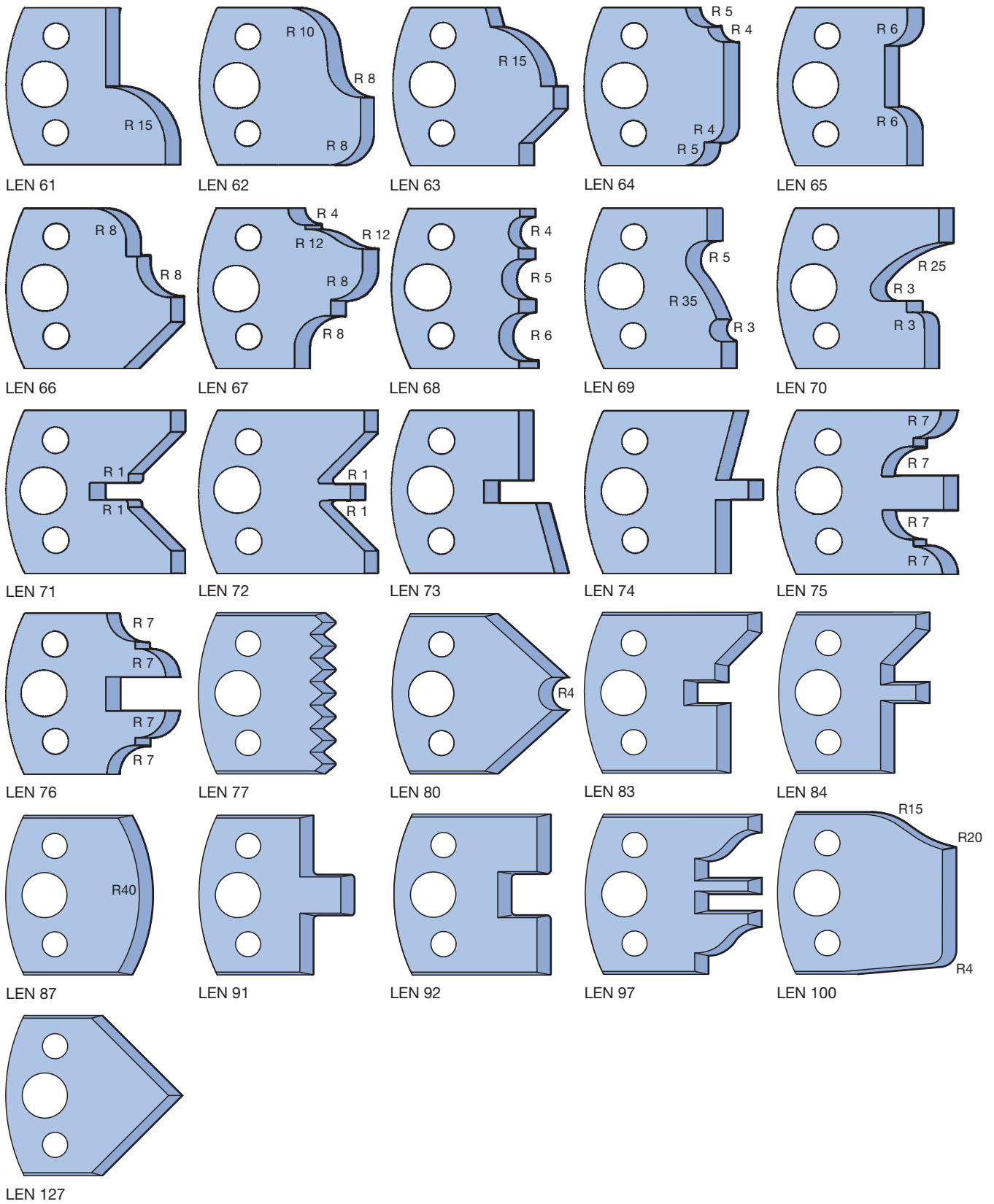
Profiles to scale 1:1 can be found on the Leitz Homepage www.leitz.org.



Profiles to scale 1:1 can be found on the Leitz Homepage www.leitz.org.



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

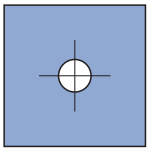


Profiles to scale 1:1 can be found on the Leitz Homepage www.leitz.org.

9. Knives and spare parts

9.1 Knives and blank knives

9.1.7 Profile knives



Turnblade knife for SW 521-2

Workpiece material:

Soft and hardwood, plastic coated and veneered chipboard and fibre materials (chipboard, MDF, HF, etc.)

Cutting material:

HW

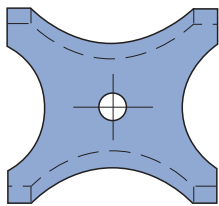
Turnblade knives for SW 521-2

HW-05

TM 405-0

SB mm	H mm	DIK mm	QAL	VE PCS	ID
12	12	1,5	HW-05	10	005081 ●
17	17	2	HW-05	10	005101 ●
30	12	1,5	HW-05	10	005084 ●
19	19	2	HW-05	10	005102 ●

ID = 1 piece



Profile knife for SW 541-2

Workpiece material:

Soft and hardwood, plastic coated and veneered chipboard and fibre materials (chipboard, MDF, HF, etc.)

Cutting material:

HW

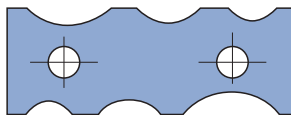
Profile knives for SW 541-2

HW

TM 435-0

SB mm	H mm	DIK mm	QAL	R mm	VE PCS	ID
13	16	2	HW	3	10	005104 ●
20	21	2	HW	5	10	005106 ●
20	21	2	HW	8	10	005109 ●
26	24	2	HW	9	10	005110 ●
26	24	2	HW	12	10	005113 ●

ID = 1 piece



Profile knife for WW 500-1

Workpiece material:

Soft and hardwood, plastic coated and veneered chipboard and fibre materials (chipboard, MDF, HF, etc.)

Cutting material:

HW

Profile knives for WW 500-1

HW

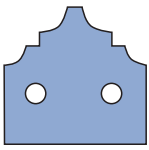
TM 435-0

SB mm	QAL	R mm	ID
50	HW	8, 10, 12	005425 ●
30	HW	3, 4, 5	005424 ●

9. Knives and spare parts

9.1 Knives and blank knives

9.1.7 Profile knives



Profile knife for WE 500-1-01

Workpiece material:

Soft and hardwood, plastic coated and veneered chipboard and fibre materials (chipboard, MDF, HF, etc.)

Cutting material:

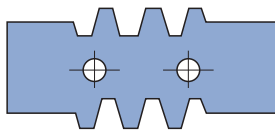
HW

Profile knives for WE 500-1-01

HW

TM 135-0

SB mm	QAL	ID
40	HW	006921 ●



Profile knife for WW 600-1

Workpiece material:

Soft and hardwood, plastic coated and veneered chipboard and fibre materials (chipboard, MDF, HF, etc.)

Cutting material:

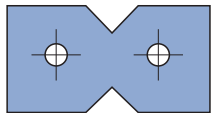
HW

Profile knives for WW 600-1

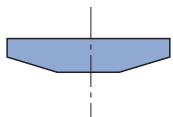
HW

TM 435-0

SB mm	QAL	ID
50	HW	005193 ●



Profile knife for WW 610-1



Profile knife for WW 610-1 in cross section

Workpiece material:

Soft and hardwood, plastic coated and veneered chipboard and fibre materials (chipboard, MDF, HF, etc.)

Cutting material:

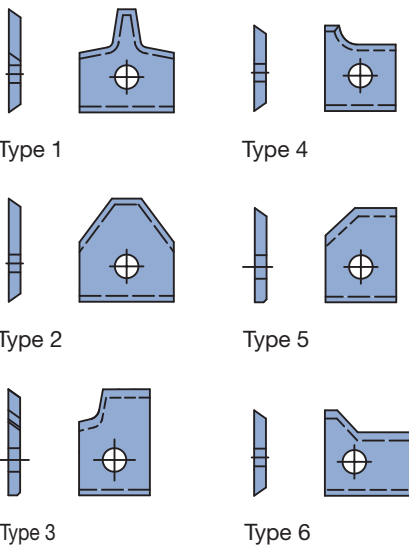
HW

Profile knives for WW 610-1

HW

TM 435-0, TM 440-0

BEZ	ABM mm	QAL	ID
Turnblade profile knife	40x22,32x2	HW	005192 ●
Turnblade bevel grooving knife	25x15x4,54	HW	008288 ●



Type 1

Type 4

Type 2

Type 5

Type 3

Type 6

Cutting material:
HW

Profile knives for edge finishing

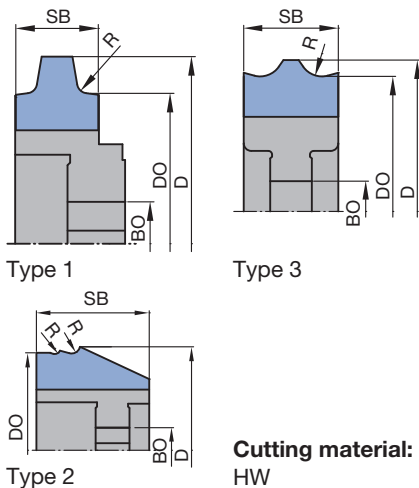
Profile knives for edge finishing

TM 135-0

SB mm	H mm	DIK mm	QAL	Knife	R mm	FAW	ID LL	ID RL
16	17,5	2	HW	1	2,0		005132	005132
16	17,5	2	HW	1	3,0		005133	005133
16	17,5	2	HW	1	4,0		005134	005134
16	17,5	2	HW	1	5,0		005135	005135
16	17,5	2	HW	2		45°		009525
12	18	2	HW	3	2,0		074033	074034
13	15	2	HW	3	2,0		073505	073504
12	14,5	2	HW	4	2,0		075342	075341
12	18	2	HW	3	3,0		074035	074036
12	17	2	HW	3	2,0		073554	073555
12	17	2	HW	3	3,0		073558	073559
12	14,5	2	HW	4	3,0		075301	075300
12	16	2	HW	5		45°	073541	073540
14,5	14,5	2	HW	4	2,5		073543	073544
14,5	14,5	2	HW	6		45°		073545
13	15	2	HW	3	3,0		073509	073508

Profile knives for system Biesse

TM 135-0



Type 1

Type 3

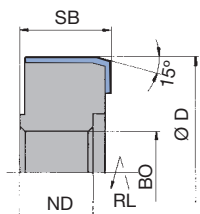
Type 2

Cutting material:
HW

Type	BEZ	ABM mm	QAL	R mm	VE PCS	ID LL	ID RL
1	Exchange knife	16x17x2	HW	1,0	10	074600	074600
1	Exchange knife	16x17x2	HW	1,5	10	074601	074601
1	Exchange knife	16x17x2	HW	2,0	10	074602	074602
1	Exchange knife	16x17x2	HW	2,5	10	074603	074603
1	Exchange knife	16x17x2	HW	3,0	10	074604	074604
2	Exchange knife	40x17x2	HW	1,0	10	074610	074611
2	Exchange knife	40x17x2	HW	1,5	10	074612	074613
2	Exchange knife	40x17x2	HW	2,0	10	074614	074615
2	Exchange knife	40x17x2	HW	2,5	10	074616	074617
2	Exchange knife	40x17x2	HW	3,0	10	074618	074619
3	Exchange knife	20x16x2	HW	1,0	10	074620	074620
3	Exchange knife	20x16x2	HW	1,5	10	074621	074621
3	Exchange knife	20x16x2	HW	2,0	10	074622	074622
3	Exchange knife	20x16x2	HW	2,5	10	074623	074623
3	Exchange knife	20x16x2	HW	3,0	10	074624	074624

Profile knives for system Holz Her

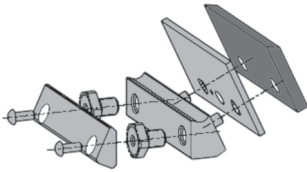
TM 435-0



Type 4:
WW 500-2-03

Cutting material:
HW

BEZ	ABM mm	QAL	VE PCS	DRI	ID
Turnblade knife	30x12x1,5,PT1,3	HW	10	RL	005088
Turnblade knife	30x12x1,5,PT1,3	HW	10	LL	005089



Workpiece material:

Softwood and hardwood, thermoplastics

Cutting material:

HW-30F

System benefits:

Knife resharpenable 3 to 4 times on the face.

High precision and safety by 3-point knife clamping

Profiling cassette system

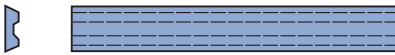
For machine Martin T 90 and T 45 Contour

BEZ	SB mm	ID
Clamping wedge cassette (without blank knife backing plate)	30	623800
Clamping wedge cassette (without blank knife backing plate)	45	623801
Clamping wedge cassette (without blank knife backing plate)	60	623802
Clamping wedge cassette (without blank knife backing plate)	125	623803
Blank knife (PT 10)	30	636254
Blank knife (PT 10)	45	636255
Blank knife (PT 10)	60	636295
Blank knife (PT 10)	125	636296
Backing plate (PT 10)	30	645010
Backing plate (PT 10)	45	645011
Backing plate (PT 10)	60	645012
Backing plate (PT 10)	125	645013
Key		117515

9. Knives and spare parts

9.1 Knives and blank knives

9.1.8 For portable planers and semi-stationary machines



Turnblade knife

Workpiece material:

Softwood and hardwood, chipboard and fibre materials, glulam

Cutting material:

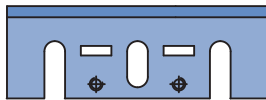
HW

Planer knives for portable planers

Turnblade knives HW

TM 410-0

Machine	SB mm	H mm	DIK mm	QAL	ID
AEG Bosch Haffner Holz-Her Mafell Metabo Scheer Festool	75,5	5,5	1,1	HW	005064 ●
Black & Decker	75,7	5,5	1,2	HW	005199 ●
ELU	80,5	5,9	1,2	HW	005131 ●
AEG Mafell Makita Metabo Black & Decker ELU De Walt	82	5,5	1,1	HW	005066 ●



Makita

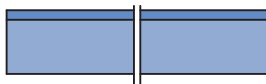
Planer knife HS / HW

TM 105-0

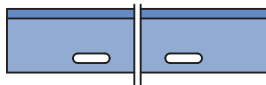
Machine	SB mm	H mm	DIK mm	ID HS	ID HW
Makita	82	29	3	027530 ●	027598 ●

Cutting material:

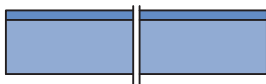
HS / HW



Kity



Metabo



Scheppach

Planer knives for semi-stationary machines

HS

TM 100-0, TM 105-0

Machine	SB mm	H mm	DIK mm	QAL	ID
Kity	260	20	2,5	HS	027154 ●
Metabo	263	20	3	HS	027157 ●
Scheppach	260	18	3	HS	027158 ●

Workpiece material:

Softwood and hardwood, chipboard and fibre materials, glulam

Cutting material:

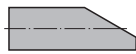
HS



Allen screws

TK 505-0

ABM mm	for ProFix	ID
M5x11 SW 2,5	PF 20	007840 ●
M6x12 SW 3	PF 20	007825 ●
M6x16 SW 3	PF 20	007826 ●
M6x25 SW 3	PF 20	007851 ●
M6x35 SW 3	PF 20	007852 ●
M6x50 SW 3	PF 20	007853 ●
M8x1x11,5 SW 4	PF 25	007811 ●
M8x1x13 SW 4	PF 25	007066 ●
M8x1x18 SW 4	PF 25	007824 ●
M8x1x30 SW 4	PF 25	007848 ●
M8x1x40 SW 4	PF 25	007849 ●
M8x1x50 SW 4	PF 25	007850 ●



Pressure pins

TK 515-0

ABM mm	for ProFix	ID
5x9 without bevel	PF 20	008839 ●
5x18 with bevel	PF 20	008837 ●
7x22 with bevel	PF 25	008836 ●



Screws for knife stop disc

TK 500-0

ABM mm	for ProFix	ID
M3x7 Torx® 10	PF 20	007819 ●
M4x8 Torx® 20	PF 25	007820 ●



Knife stop discs

TK 540-0

ABM mm	for ProFix	ID
10x2	PF 20	006749 ●
15x2,5	PF 25	006743 ●

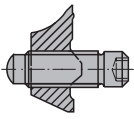


ProFix F ripple planerhead PF25

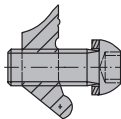
Spare knives

TM 269-0-10

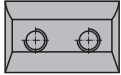
SB mm	QAL	ID
80	HW	011039 ●
90	HW	011040 ●
120	HW	011049 ●



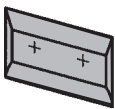
Clamping wedge
for WP 8, M5



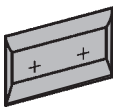
Clamping wedge
for WP 8, M 6



Clamping wedge
for WP 8



Clamping wedge
for ZM 11,
OFZS-RL



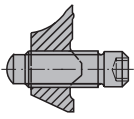
Clamping wedge
for ZM 10,
OFZS-RL

Turnblade knife 8 mm WP 8

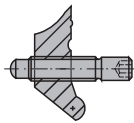
Clamping wedges

TD 110-0

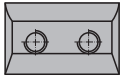
B mm	BEM	GEW	for knives	FAW	ID Cross grain processing	ID Standard
7		M5	7,7		622002	● 009763 ●
9		M5	9,7		622003	● 009764 ●
11		M6	11,7		622004	● 009669 ●
13		M6	14,7		622005	● 009670 ●
18		M6	19,7		622006	● 009671 ●
23		M6	25		622007	● 009672 ●
28		M6	30		622008	● 009673 ●
33	1-hole	M6	35		622031	● 009674 ●
33	2-holes	M6	35		622030	● 622030 ●
38		M6	40		622010	● 009675 ●
43		M6	45		622011	● 009676 ●
48		M6	50		622012	● 009677 ●
58		M6	60		622013	● 009678 ●
68		M6	70		622014	● 009679 ●
78		M6	80		622015	● 009680 ●
98		M6	100		622016	● 009681 ●
118		M6	120		622017	● 009682 ●
13		M6	ZM 11/5	8°	622018	● 009683 ●
13		M6	ZM 10/5	8°	622019	● 009684 ●
13		M6	ZM 11/4	14°	622020	● 009685 ●
13		M6	ZM 10/4	14°	622021	● 009686 ●
19		M6	ZM 11/1	10°	622022	● 009687 ●
19		M6	ZM 10/1	10°	622023	● 009688 ●
24		M6	ZM 11/8	10°	622024	● 009689 ●
24		M6	ZM 10/8	10°	622025	● 009690 ●
29		M6	ZM 11/2	8°	622026	● 009691 ●
29		M6	ZM 10/2	8°	622027	● 009692 ●
29		M6	ZM 11/6	14°	622028	● 009693 ●
29		M6	ZM 10/6	14°	622029	● 009694 ●



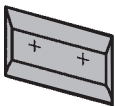
Clamping wedge for WP 8, type 1



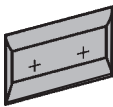
Clamping wedge for WP 8, type 2



Clamping wedge for WP 8



Clamping wedge for ZM 11, OFZS-RL

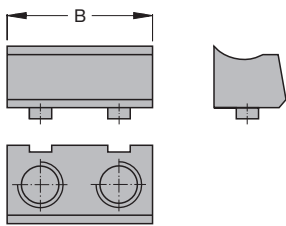


Clamping wedge for ZM 10, OFZS-RL

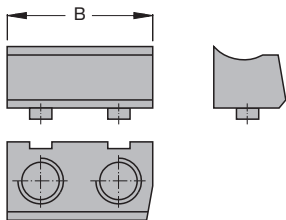
Turnblade knife 8 mm WP 8

Clamping wedges for previous design
TD 110-0

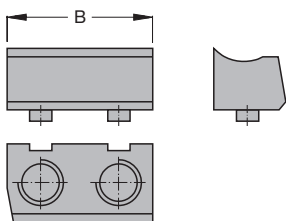
B mm	BEM	GEW	for knives	Type	FAW	ID
7		M4	7,7	1		009243 ●
7		M4	7,7	2		009667 ●
8		M4	9,7	1		009299 □
8		M4	9,7	2		009668 ●
10		M6	11,7	1		009244 ●
13		M6	14,7	1		009245 ●
18		M6	19,7	1		009246 ●
23		M6	25	1		009298 □
28		M6	30	1		009247 ●
33		M6	35	1		009248 ●
38		M6	40	1		009249 ●
43		M6	45	1		009621 □
48		M6	50	1		009250 ●
58	Previous 2-hole design	M6	60	1		009251 □
58	Previous 3-hole design	M6	60	1		009964 ●
68		M6	70	1		009622 □
78		M6	80	1		009252 ●
98		M6	100	1		009267 ●
118		M6	120	1		009268 ●
19		M6	ZM 10/1	1	9°50'	009276 ●
13		M6	ZM 10/4	1	14°	009933 □
19		M6	ZM 11/1	1	9°50'	009277 □
13		M6	ZM 11/4	1	14°	009934 ●



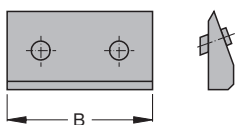
Clamping wedge, flat - Type 1



Clamping wedge, flat, right hand rotation, bottom cutting first - Type 2



Clamping wedge, flat, left hand rotation, bottom cutting first - Type 3



Counter wedge with pin - Type 4

Turnblade knife 12 mm WP 12

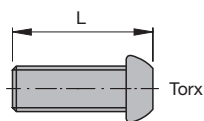
Clamping wedges with counter wedges TD 200-0

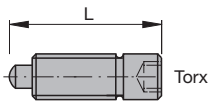
B mm	GEW	for knives	Type	ID
6,8	M5	7,5	1	005213 ●
10	M6	12	1	005216 ●
		15		
26	M8	30	1	005231 ●
46	M8	50	1	005241 □
56	M8	60	1	005246 □
10	M6	12	2	005217 ●
		15		
26	M8	30	2	005232 ●
10	M6	12	3	005218 ●
		15		
26	M8	30	3	005233 ●
6,8		7,5	4	005214 ●
10		12	4	005219 ●
		15		
18		20	4	009824 ●
28		30	4	009825 ●
48		50	4	009826 ●
58		60	4	009827 ●

Clamping screws

Clamping screws for WP 8 clamping wedge for SB 12 mm and greater TK 500-0

ABM mm	BEM	ID
M6x18,5	Torx® 25	007818 ●

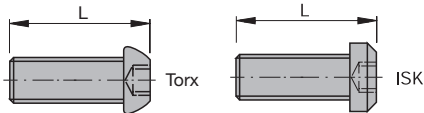




Clamping screws

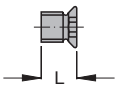
Allen screw for WP 8 clamping wedge and cutting width < 12 mm
TK 505-0

ABM mm	BEM	BEM	ID
M5x20	Torx® 15		007380 ●
M4x20	Torx® 8	For former design	006081 ●
M6x20	Torx® 20	For former design	006080 ●



Clamping screw for ProfilCut clamping from SB 12 mm on
TK 500-0

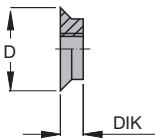
ABM mm	BEM	BEM	ID
M6x18,5	Torx® 25		007818 ●
M6x19	ISK 5	For former design	007043 ●
M8x19	ISK 6	For former design	007044 ●



Clamping screw for WP 18 + VS 4 (Lamello)

TK 500-0

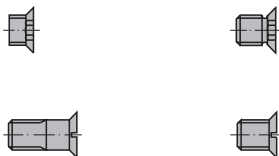
ABM mm	BEM	for knives	ID
M4x0,5x3,2	Torx® 9	WP 18/1,95	006057 ●
M4x0,5x4,2	Torx® 9	WP 18/2,5	005724 ●



Nuts for WP 18 + VS 4 (Lamello)

TK 510-0

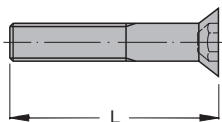
ABM mm	for knives	ID
M 11,9/2,20	WP 18/1,95	005653 ●
M 11,9/2,75	WP 18/2,5	005686 ●
M9,9/1,60	VS 4	005654 ●



Countersunk screws for VS 1, VS 2 and VS 3

TK 500-0, TK 100-0

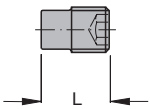
ABM mm	BEM	BEM	ID
M6x0,5x4,9	T 20 for steel-body		006243 ●
M5x8,5	T 20 for aluminium tool body		007808 ●
M5x12		For former design	005744 ●
M5x6		For former design	005758 ●



Countersunk screws for grooving- and edging knives

TK 500-0

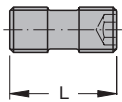
ABM mm	BEM	ID
M6x10	Torx® 20	006083 ●
M6x12	Torx® 20	006084 ●
M6x14	Torx® 20	006085 ●
M6x16	Torx® 20	006086 ●
M6x25	Torx® 20	006088 ●
M6x30	Torx® 20	006089 ●
M6x35	Torx® 20	007098 ●
M6x40	Torx® 20	006090 ●



Allen screws for clamping wedges 12 mm knife system

TK 105-0

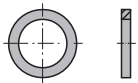
ABM mm	BEM	ID
M5x12	ISK 2,5	006032 ●
M6x12	ISK 3	006035 ●
M8x12	ISK 4	006041 ●



Double-threaded allen screws for 12 mm slot and tenon clamping wedges, previous design

TK 505-0

ABM mm	BEM	ID
M4x18	Torx [®] 8	006094 ●
M6x18	Torx [®] 15	006095 ●

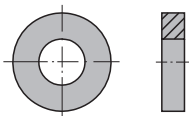


Spacers and shims

Washer for WP 8 and ProfilCut

TK 540-0

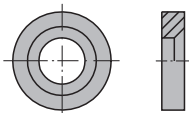
ABM mm	GEW	ID
9/6,2x1,2	for M6	006753 ●



Previous ProfilCut - design

TK 540-0

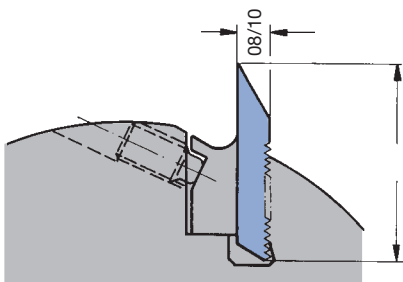
ABM mm	GEW	BEM	ID
10/6,4x1,2	for M6	Former ProfilCut design	006739 ●
12,5/8,4x1,2	for M8	Former ProfilCut design	006740 ●



Spacers for grooving- and edging knives

TR 100-0

ABM mm	BEM	ID
13/6,1x0,1		028034 ●
13/6,1x0,3		028035 ●
13/6,1x0,5		028036 ●
13/6,1x1		028037 ●
13/6,1x3		028040 ●
13/6,1x5		028042 ●
13/6,1x12		028045 ●
13/6,1x3	With counterbore	028185 ●
13/6,1x5	With counterbore	028173 ●

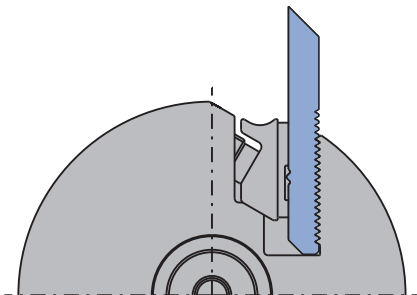


Profile cutterhead
Knife thickness 8 - 10 mm

Serrated back profile cutterheads

Filler pieces for knife thickness 8 - 10 mm
TD 510-0-05

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



Profile cutterhead
PKS-system

Filler pieces for profiling PKS-System backing plates
TF 200-0

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

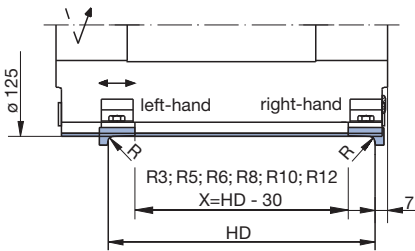
D	SB	ND	BO	BO _{max.}	n _{max.}	ID
mm	mm	mm	mm	mm	min ⁻¹	
125	130	136	40	45	9000	031700 ●
125	180	186	40	45	9000	031701 ●
125	230	236	40	45	9000	031702 ●
140	130	130	50	60	8000	031703
140	180	180	50	60	8000	031704
140	230	230	50	60	8000	031705

Universal planerhead, VariPlan/ProFix system, for jointing and profiling

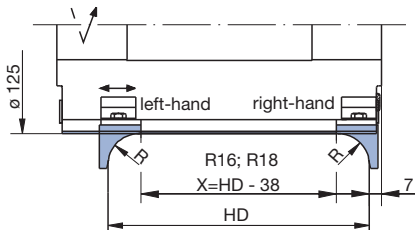
Spare profile knives for ID 031700 - 031705

TM 265-0, TM 265-0-10

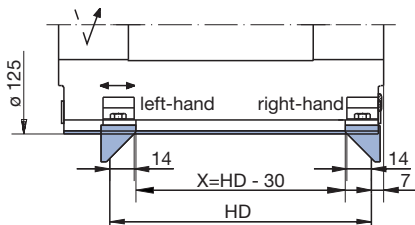
ABM	QAL	R	FAW	DRI	ID
mm		mm			
SB20	HS	3		LL	012031 ●
SB20	HS	3		RL	012032 ●
SB20	HS	4		LL	012033 ●
SB20	HS	4		RL	012034 ●
SB20	HS	6		LL	012035 ●
SB20	HS	6		RL	012036 ●
SB20	HS	8		LL	012037 ●
SB20	HS	8		RL	012038 ●
SB20	HS	10		LL	012039 ●
SB20	HS	10		RL	012040 ●
SB20	HS	12		LL	012041 ●
SB20	HS	12		RL	012042 ●
SB24	HS	16		LL	012043
SB24	HS	16		RL	012044
SB24	HS	18		LL	012045
SB24	HS	18		RL	012046
SB20	HS		14x45°	LL	012047 ●
SB20	HS		14x45°	RL	012048 ●
SB20 flute	HS	10		LL	012049
SB20 flute	HS	10		RL	012050
SB20	HW	3		LL	012051
SB20	HW	3		RL	012052 ●
SB20	HW	4		LL	012053 ●
SB20	HW	4		RL	012054 ●
SB20	HW	6		LL	012055 ●
SB20	HW	6		RL	012056 ●
SB20	HW	8		LL	012057 ●
SB20	HW	8		RL	012058 ●
SB20	HW	10		LL	012059 ●
SB20	HW	10		RL	012060 ●
SB20	HW	12		LL	012061 ●
SB20	HW	12		RL	012062 ●
SB24	HW	16		LL	012063
SB24	HW	16		RL	012064
SB24	HW	18		LL	012065
SB24	HW	18		RL	012066
SB20	HW		14x45°	LL	012067 ●
SB20	HW		14x45°	RL	012068 ●
SB20 flute	HW	10		LL	012069
SB20 flute	HW	10		RL	012070



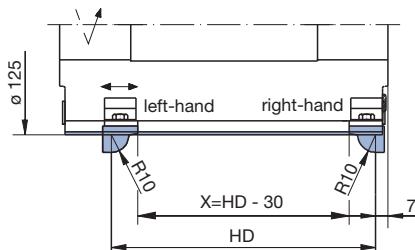
With radius knife R3 to R13 mm
 HD max. = cutting width of cutterhead - 10 mm, HD min. = 30 mm



With radius knife R16 to R18 mm
 HD max. = cutting width of cutterhead - 10 mm, HD min. = 38 mm



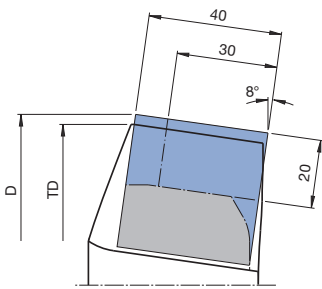
HD max. = cutting width of cutterhead - 10 mm, HD min. = 14 mm
 Bevel = 30 mm (lower wood thickness possible for smaller bevels) e.g. bevel 10 mm, HD min. = 21 mm



With fluting knife
 HD max. = cutting width of cutterhead - 10 mm, HD min. = 30 mm

9. Knives and spare parts

9.2 Spare parts and clamping parts 9.2.3 For planing- / profile cutterheads

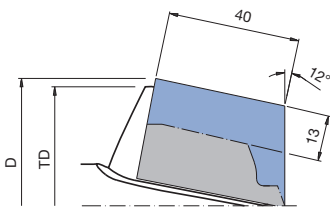


Tool body cranked 8°, right hand rotation, large diameter on top, SB 30-50 mm

Cranked profile cutterhead VariForm, for CNC

Blank knives for tool body 8° cranked, HW, spare knife for ID 135420 -135425
TC 105-0

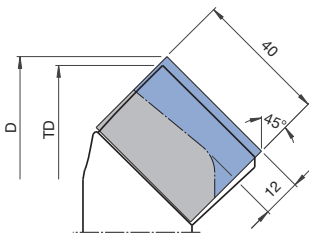
H mm	SB mm	PT _{max.} mm	ID HW-10F	ID HW-30F
40	30	20	636220	636233 ●
40	40	15	636227	636240 ●
40	50	15	636284	636272 ●



Tool body cranked 12°, right hand rotation, large diameter on top, SB 40 mm

Blank knives for tool body 12° cranked, HW, spare knife for ID 135428 - 135429
TC 105-0

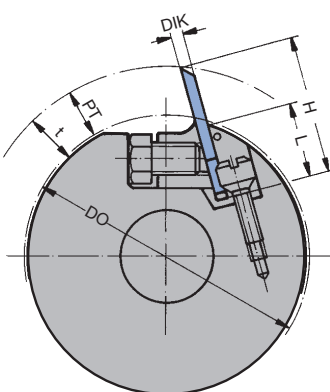
H mm	SB mm	PT _{max.} mm	ID HW-10F	ID HW-30F
30	40	30	636253	636252 ●



Tool body cranked 45°, right hand rotation, large diameter on top, SB 40 mm

Blank knives for tool body 45° cranked, HW, spare knife for ID 135426 - 135427
TC 105-0

H mm	SB mm	PT _{max.} mm	ID HW-10F	ID HW-30F
30	40	30	636225	636238 ●



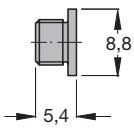
Workpiece material:
Softwood and hardwood

Cutting material:
SP / HS

Profile cutterhead WM 502-2

TC 105-0

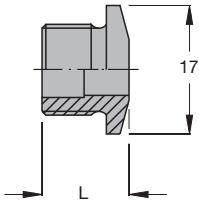
BEZ	SB mm	QAL	ID
Profile blank knife	40	SP	007601 ●
Profile blank knife	50	SP	007602 ●
Profile blank knife	60	SP	007603 ●
Profile blank knife	40	HS	007284 ●
Profile blank knife	50	HS	007285 ●
Profile blank knife	60	HS	007286 ●



Flat head screw for rhomboid knife RMA

TK 500-0

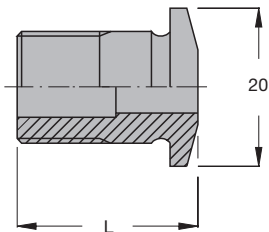
ABM mm	BEM	ID
M6x0,5x5,4	Torx® 20	007036 ●



Clamping screws for grooving knives and Exakt and RA knives

TK 500-0

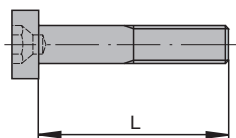
ABM mm	BEM	ID
M12x1x6,3	ISK 6	005733 ●
M12x1x7,7	ISK 6	005734 ●
M12x1x9,2	ISK 6	005735 ●
M12x1x11	ISK 6	005736 ●
M12x1x13,5	ISK 6	005737 ●
M12x1x14,5	ISK 6	005738 ●



Clamping screws for DuFix knives

TK 500-0

ABM mm	BEM	ID
M12x1x20,8	ISK 6	005726 ●
M12x1x22,5	ISK 6	005727 ●
M12x1x24	ISK 6	005728 ●
M12x1x26	ISK 6	005729 ●
M12x1x28	ISK 6	005730 ●
M12x1x30	ISK 6	005731 ●
M12x1x36	ISK 6	005732 ●



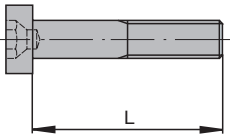
Cylindrical screws for screwed sets

Cylindrical screws with ISK 5 for clamping sleeves

TK 100-0

ABM mm	ID
M6x50	005932 ●
M6x55	005933 ●
M6x60	005934 ●
M6x65	005935 ●
M6x70	005936 ●
M6x73	007831 ●
M6x80	005938 ●
M6x83	007832 ●
M6x88	007833 ●
M6x100	005940 ●
M6x93	007834 ●
M6x105	007835 ●
M6x113	007836 ●
M6x120	005942 ●
M6x130	006542 ●
M6x140	006296 ●
M6x150	006290 ●

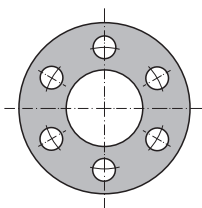




Cylindrical screws with ISK 4 for cutter arbors

TK 100-0

ABM mm	ID
M5x25	007057 ●
M5x30	007092 ●
M5x35	007058 ●
M5x40	007854 ●
M5x45	007093 ●
M5x50	007082 ●
M5x55	007094 ●
M5x60	007083 ●
M5x65	007095 ●
M5x70	007084 ●
M5x75	007096 ●
M5x80	007097 ●



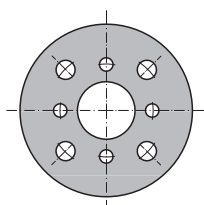
With pinholes

TR 100-0

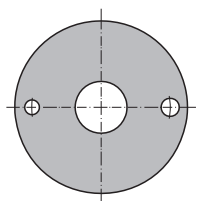
D mm	B mm	BO mm	NLA mm	ID
45	3	20	4/6/32	028088 ●
45	5	20	4/6/32	028089 ●
45	10	20	4/6/32	028090 ●
45	20	20	4/6/32	028639 ●
45	0,1	20	4/6/32	029208 ●
45	0,3	20	4/6/32	029209 ●
45	0,5	20	4/6/32	029210 ●
45	1	20	4/6/32	029211 ●
60	0,1	30	6/7/48	027914 ●
60	0,3	30	6/7/48	027915 ●
60	0,5	30	6/7/48	027916 ●
60	1	30	6/7/48	027917 ●
60	3	30	6/7/48	028580 ●
60	4	30	6/7/48	028581 ●
60	5	30	6/7/48	028582 ●
60	6	30	6/7/48	028583 ●
60	7	30	6/7/48	028584 ●
60	8	30	6/7/48	028585 ●
60	10	30	6/7/48	028586 ●
60	11	30	6/7/48	028587 ●
60	12	30	6/7/48	028588 ●
60	15	30	6/7/48	028589 ●
60	17,5	30	6/7/48	028590 ●
60	20	30	6/7/48	028591 ●
70	0,1	30	6/7/58	027952 ●
70	0,3	30	6/7/58	027953 ●
70	0,5	30	6/7/58	027954 ●
70	1	30	6/7/58	027955 ●
70	3	30	6/7/58	028599 ●
70	4	30	6/7/58	028600 ●
70	5	30	6/7/58	028601 ●
70	6	30	6/7/58	028602 ●
70	7	30	6/7/58	028603 ●
70	8	30	6/7/58	028604 ●
70	10	30	6/7/58	028605 ●
70	12	30	6/7/58	028606 ●
70	15	30	6/7/58	028607 ●
70	20	30	6/7/58	028608 ●
60	0,1	35	6/7/48	027930 ●
60	0,3	35	6/7/48	027931 ●
60	0,5	35	6/7/48	027932 ●
60	1	35	6/7/48	027933 ●
60	3	35	6/7/48	028592 ●
60	4	35	6/7/48	028593 ●
60	5	35	6/7/48	028594 ●
60	6	35	6/7/48	028595 ●
60	7	35	6/7/48	028596 ●
60	8	35	6/7/48	028597 ●
60	10	35	6/7/48	028598 ●
62	0,1	35	4/7/52	028667 ●
62	0,3	35	4/7/52	028668 ●
62	0,5	35	4/7/52	028669 ●
62	1	35	4/7/52	028670 ●
65	3	35	4/7/52	028671 ●
65	4	35	4/7/52	028672 ●
65	5	35	4/7/52	028673 ●
70	0,1	35	6/7/58	027966 ●



D mm	B mm	BO mm	NLA mm	ID
70	0,3	35	6/7/58	027967 ●
70	0,5	35	6/7/58	027968 ●
70	1	35	6/7/58	027969 ●
70	3	35	6/7/58	028609 ●
70	4	35	6/7/58	028610 ●
70	5	35	6/7/58	028611 ●
70	6	35	6/7/58	028612 ●
70	7	35	6/7/58	028613 ●
70	8	35	6/7/58	028614 ●
70	10	35	6/7/58	028615 ●
70	20	35	6/7/58	028616 ●
70	0,1	40	6/7/58	027978 ●
70	0,3	40	6/7/58	027979 ●
70	0,5	40	6/7/58	027980 ●
70	1	40	6/7/58	027981 ●
70	3	40	6/7/58	028617 ●
70	4	40	6/7/58	028618 ●
70	5	40	6/7/58	028619 ●
70	6	40	6/7/58	028620 ●
70	7	40	6/7/58	028621 ●
70	8	40	6/7/58	028622 ●
70	10	40	6/7/58	028623 ●
70	12	40	6/7/58	028624 ●
70	15	40	6/7/58	028625 ●
70	20	40	6/7/58	028626 ●
76,5	0,1	50	6/7/65	028005 ●
76,5	0,3	50	6/7/65	028006 ●
76,5	0,5	50	6/7/65	028007 ●
76,5	1	50	6/7/65	028008 ●
77	3	50	6/7/65	028627 ●
77	4	50	6/7/65	028628 ●
77	5	50	6/7/65	028629 ●
77	6	50	6/7/65	028630 ●
77	8	50	6/7/65	028631 ●
77	10	50	6/7/65	028632 ●
77	20	50	6/7/65	028633 ●
90	0,1	60	6/7/75	028020 ●
90	0,3	60	6/7/75	028021 ●
90	0,5	60	6/7/75	028022 ●
90	1	60	6/7/75	028023 ●
90	3	60	6/7/75	028634 ●
90	4	60	6/7/75	028635 ●
90	5	60	6/7/75	028636 ●
90	10	60	6/7/75	028637 ●
90	20	60	6/7/75	028638 ●



Spacers with 4+4 pinholes

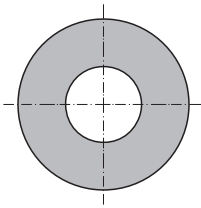


Spacers with 2 pinholes

With pinholes

TR 100-0

D mm	B mm	BO mm	NLA mm	ID
90	0,1	30	4/7/48 4/10/60	028422 ●
90	0,3	30	4/7/48 4/10/60	028423 ●
90	0,5	30	4/7/48 4/10/60	028424 ●
90	1	30	4/7/48 4/10/60	028425 ●
90	3	30	4/7/48 4/10/60	028426 ●
90	5	30	4/7/48 4/10/60	028427 ●
90	10	30	4/7/48 4/10/60	028428 ●
90	20	30	4/7/48 4/10/60	028429 ●
100	0,1	30	1/8,5/80 1/10,5/80	028029 ●
100	0,3	30	1/8,5/80 1/10,5/80	028030 ●
100	0,5	30	1/8,5/80 1/10,5/80	028031 ●
100	1	30	1/8,5/80 1/10,5/80	028032 ●

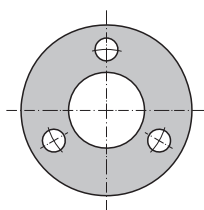


Without pinholes

TR 100-0

D mm	B mm	BO mm	ID
34	0,1	20	028400 ●
34	0,3	20	028401 ●
34	0,5	20	028402 ●
34	1	20	028403 ●
34	3	20	028404 ●
34	4	20	028405 ●
34	5	20	028406 ●
50	0,1	30	027901 ●
50	0,3	30	027902 ●
50	0,5	30	027903 ●
50	1	30	027904 ●
50	3	30	027905 ●
50	4	30	027906 ●
50	5	30	027907 ●
50	6	30	027908 ●
50	7	30	027909 ●
50	8	30	027910 ●
50	10	30	027911 ●
50	14	30	027912 ●
50	20	30	027913 ●
60	3	30	027918 ●
60	4	30	027919 ●
60	5	30	027920 ●
60	6	30	027921 ●
60	7	30	027922 ●
60	8	30	027923 ●
60	10	30	027924 ●
60	11	30	027925 ●
60	12	30	027926 ●
60	15	30	027927 ●
60	17,5	30	027928 ●
60	20	30	027929 ●
60	1	31,75	028661 ●
60	3	31,75	028662 ●
60	5	31,75	028663 ●
60	10	31,75	028664 ●
60	15	31,75	028665 ●
60	20	31,75	028666 ●
60	3	35	027934 ●
60	4	35	027935 ●
60	5	35	027936 ●
60	6	35	027937 ●
60	7	35	027938 ●
60	8	35	027939 ●
60	10	35	027940 ●
60	0,1	40	027941 ●
60	0,3	40	027942 ●
60	0,5	40	027943 ●
60	1	40	027944 ●
60	3	40	027945 ●
60	4	40	027946 ●
60	5	40	027947 ●
60	6	40	027948 ●
60	7	40	027949 ●
60	8	40	027950 ●
60	9	40	028449 ●
60	10	40	027951 ●

D mm	B mm	BO mm	ID
70	3	30	027956 ●
70	4	30	027957 ●
70	5	30	027958 ●
70	6	30	027959 ●
70	7	30	027960 ●
70	8	30	027961 ●
70	10	30	027962 ●
70	12	30	027963 ●
70	15	30	027964 ●
70	20	30	027965 ●
70	3	35	027970 ●
70	4	35	027971 ●
70	5	35	027972 ●
70	6	35	027973 ●
70	7	35	027974 ●
70	8	35	027975 ●
70	10	35	027976 ●
70	20	35	027977 ●
70	3	40	027982 ●
70	4	40	027983 ●
70	5	40	027984 ●
70	6	40	027985 ●
70	7	40	027986 ●
70	8	40	027987 ●
70	10	40	027988 ●
70	12	40	027989 ●
70	15	40	027990 ●
70	20	40	027991 ●
70	0,1	50	027992 ●
70	0,3	50	027993 ●
70	0,5	50	027994 ●
70	1	50	027995 ●
70	3	50	027996 ●
70	4	50	027997 ●
70	5	50	027998 ●
70	6	50	027999 ●
70	7	50	028000 ●
70	8	50	028001 ●
70	10	50	028002 ●
70	15	50	028003 ●
70	20	50	028004 ●
77	3	50	028009 ●
77	4	50	028010 ●
77	5	50	028011 ●
77	6	50	028012 ●
77	8	50	028013 ●
77	10	50	028014 ●
77	20	50	028015 ●
90	3	60	028024 ●
90	4	60	028025 ●
90	5	60	028026 ●
90	10	60	028027 ●
90	20	60	028028 ●
100	4	30	028033 ●

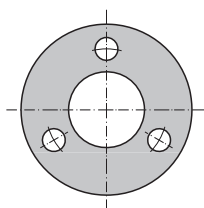


Spacers hardened and high precision for Hydro and Hydro-Duo clamping sleeves to fill the clamping length.

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

TR 100-0

D mm	B mm	BO mm	NLA mm	ID
70	3	40	2/7/58	028500 ●
70	4	40	2/7/58	028501 ●
70	5	40	2/7/58	028502 ●
70	6	40	2/7/58	028503 ●
70	8	40	2/7/58	028504 ●
70	10	40	2/7/58	028505 ●
70	15	40	2/7/58	028506 ●
70	20	40	2/7/58	028507 ●
77	3	50	2/9/65	028508 ●
77	4	50	2/9/65	028509 ●
77	5	50	2/9/65	028510 ●
77	6	50	2/9/65	028511 ●
77	8	50	2/9/65	028512 ●
77	10	50	2/9/65	028513 ●
77	15	50	2/9/65	028514 ●
77	20	50	2/9/65	028515 ●
90	10	50	2/9/65	030681 ●
90	15	50	2/9/65	030682 ●
90	20	50	2/9/65	030683 ●
90	10	60	3/9/75	030684 ●
90	15	60	3/9/75	030685 ●
90	20	60	3/9/75	030686 ●



High precision spacers for Hydro- and Hydro-Duo clamping sleeves

High-precision spacers for adjusting tongue and groove cuttersets

TR 100-0, AT 100-0

D mm	B mm	BO mm	NLA mm	BEM	ID
90	3,1	60	3/9/75		030687 ●
90	3,3	60	3/9/75		030688 ●
90	3,5	60	3/9/75		030689 ●
90	3,7	60	3/9/75		030690 ●
90	3,9	60	3/9/75		030691 ●
90	4,1	60	3/9/75		030692 ●
90	4,3	60	3/9/75		030693 ●
90	4,5	60	3/9/75		030694 ●
90	4,7	60	3/9/75		030695 ●
90	4,9	60	3/9/75		030696 ●
90	5	60	3/9/75		030697 ●
90	5,1	60	3/9/75		030698 ●

Set of spacers (13 pieces) 1x (3.3-5.1)
2x (3.1) each

028454 ●

AT 100-0-01

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

Set consisting of:

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

AT 100-0-02

Total clamping length of 11 mm. By adding additional spacers 10.0 mm and 20.0 mm, adjustment up to 41.0 mm is possible.

Set consisting of:

- 2 pieces: B 0.1 mm
- 1 piece: B 0.3 mm
- 1 piece: B 0.5 mm
- 2 pieces: B 1.0 mm
- 1 piece: B 3.0 mm
- 1 piece: B 5.0 mm

Spacer sets

Set of standard cutter spindle spacers

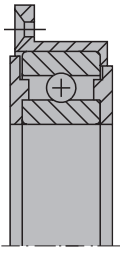
AT 100-0-01

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

Set of standard spacers

AT 100-0-02

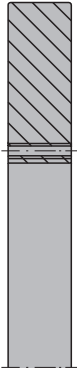
D mm	BO mm	ID
60	30	028451 ●
70	35	028452 ●
70	40	028453 ●



Ball bearings

TL 510-0

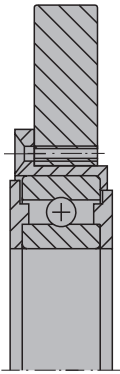
BEZ	D mm	BO mm/in	ID
Ball bearing III	62	30	027701 ●
Ball bearing III	62		027704 ●
Ball bearing IV	72	40	027702 ●
Ball bearing IV	84	50	027703 ●



Guide rings

TR 500-0

BEZ	D mm	ID
Guide ring III	75	027751 ●
Guide ring III	80	027752 ●
Guide ring III	85	027753 ●
Guide ring III	90	027754 ●
Guide ring III	95	027755 ●
Guide ring III	100	027756 ●
Guide ring III	105	027757 ●
Guide ring III	110	027758 ●
Guide ring III	112	027797 ●
Guide ring III	115	027759 ●
Guide ring III	120	027760 ●
Guide ring III	125	027761 ●
Guide ring III	130	027762 ●
Guide ring III	135	027763 ●
Guide ring III	140	027764 ●
Guide ring III	145	027765 ●
Guide ring III	150	027766 ●
Guide ring IV	90	027772 ●
Guide ring IV	95	027773 ●
Guide ring IV	100	027774 ●
Guide ring IV	105	027775 ●
Guide ring IV	110	027776 ●
Guide ring IV	112	027798 ●
Guide ring IV	115	027777 ●
Guide ring IV	120	027778 ●
Guide ring IV	125	027779 ●
Guide ring IV	130	027780 ●
Guide ring IV	135	027781 ●
Guide ring IV	140	027782 ●
Guide ring IV	145	027783 ●
Guide ring IV	150	027784 ●
Guide ring VI	100	027785 ●
Guide ring VI	105	027786 ●
Guide ring VI	110	027787 ●
Guide ring VI	115	027788 ●
Guide ring VI	120	027789 ●
Guide ring VI	125	027790 ●
Guide ring VI	130	027791 ●
Guide ring VI	135	027792 ●
Guide ring VI	140	027793 ●
Guide ring VI	145	027794 ●
Guide ring VI	150	027795 ●

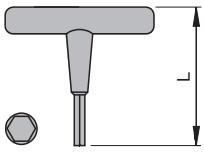


Ball bearing and guide ring set
consisting of:
Ball bearing size III with 9 or 12 guide
rings in 5 mm diameter steps each.

Ball bearing guide set

AT 102-0

exist. of	ABM mm	ID
TR 500-0 D mm 85-90-95-100-105-110-115-120-125-130-135-140 TL 500-0	13 pcs.,d30	027851 ●
TR 500-0 D mm 85-90-95-100-105-110-115-120-125-130-135-140 TL 500-0	13 pcs.,d31.75	027853 ●
TR 500-0 D mm 85-90-95-100-105-110-115-120-125 TL 500-0	10 pcs.,d30	027852 ●
TR 500-0 D mm 85-90-95-100-105-110-115-120-125 TL 500-0	10 pcs.,d31.75	027854 ●



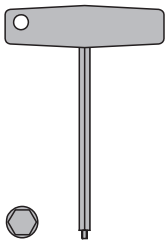
Hexagon key, L 75 - 100 mm

Hexagon allen keys

T-handle without tenon

TH 500-0

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

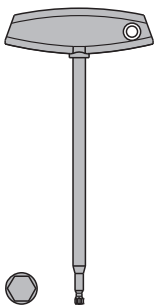


Hexagon key, with tenon

T-handle with tenon

TH 500-0

ABM mm	ID
SW 5	005452 ●
SW 6	005494 ●

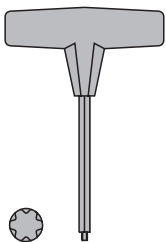


Hexagon key, for quick-change sleeve

For quick-change sleeve

TH 505-0

ABM mm	L mm	ID
SW 6	240	117516 ●



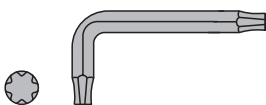
Torx® key with T-handle

Torx® keys

T-handle

TH 500-0

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



Torx® key, 90° angle

90° angle

TH 500-0

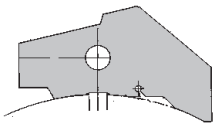
ABM mm	L mm	ID
Torx® 20	140	117511 ●



Torque wrench in box

AT 199-0

BEZ	exist. of	ID
Torque wrench set in box	1 piece bit insert hex 4 mm 1 piece bit insert hex 5 mm 1 piece bit insert hex 6 mm 1 piece bit insert hex 8 mm 1 piece bit insert hex 10 mm 1 piece bit insert Torx [®] 8 1 piece bit insert Torx [®] 15 1 piece bit insert Torx [®] 20 1 piece bit insert Torx [®] 25 1 piece bit insert Torx [®] 40 1 piece bit holder 1/4" - 1 1/4" 1 torque wrench 1/4" 3-30Nm Set in aluminium box	009102 ●



Setting gauge for Hydro planerheads / planerhead wedge-type system

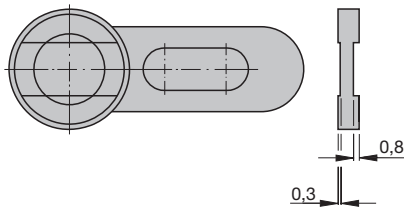
VN 265-0

ABM mm	ID
D143	007988 ●
D163	007989 ●
D203	008002 ●
D125/140	005361 ●



Setting gauge
0.3/0.8 mm

Setting gauge
1 mm

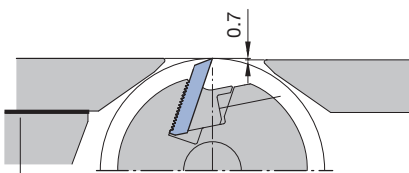


Magnetic setting gauge 0.3/0.8 mm

Setting gauges for turnblades

VN 230-0

BEZ	ABM mm	ID
Setting gauge	0,3/0,8	005374 ●
Setting gauge for knives	1,0	005350 ●
Magnetic setting gauge	0,3/0,8	005376 ●



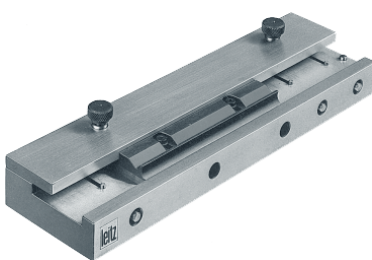
spacer inlay
(0,7 mm)

Bed spacer plate for 4-side moulding machine

TF 200-0

BEZ	ABM mm	DIK mm	ID
Table spacer plate	235x100x0,7	0,7	008352

The spacer plate is required, in combination with the Leitz ripple technology, to adjust the work table after finish planing (chip removal 0.7 mm).



Application:

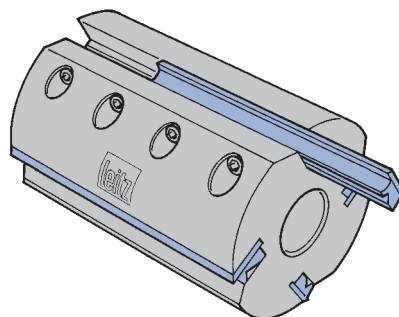
Adjustment of cassettes (knife and clamping wedge) for mounting in planerhead WM 200-2-03.

- Base plate with pressure elements including stop rail and insert device.
- All parts hardened and ground.
- Suitable for cutting widths up to 260 mm.

Setting device for planerhead cassette system

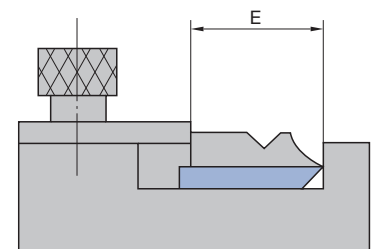
VN 265-0

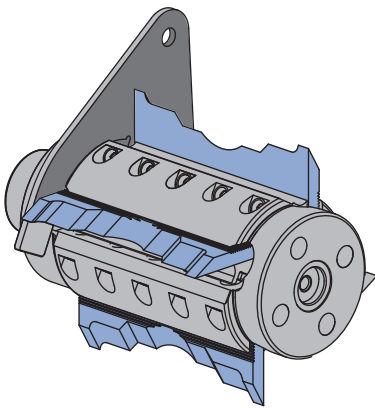
BEZ	ID
Setting device for knives	029755 ●



Planerhead cassette system

Setting device:

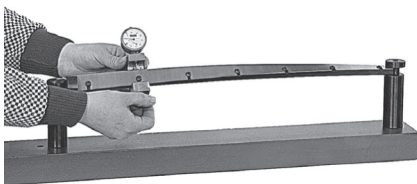




Setting gauge for profile cutterhead with HSK-85 WS adaptor

VN 230-0

BEZ	ID
Knife setting gauge for axial positioning of profile knives	008353 ●



For long planerhead in spiral design

VN 265-0

BEZ	ID
Setting gauge with dial gauge	029780 ●
Base plate with holder	029781 ●
Setting device	029782 ●

Application:

Pre-adjustment of resharpened HS knives for long planerhead in spiral design.

- Precise setting of HS knives for easy and quick knife change.
- Suitable for cutting widths from 410 to 640 mm.



Mounting device

VN 799-0

BEZ	ID
Mounting device for SK 30/BT30 with grooves and notches	079000 ●
Mounting device for SK40	079001 ●
Mounting device for HSK-F50	079002 ●
Mounting device for HSK-E63 and HSK-F63	079003 ●
Mounting device for SCM/Morbidelli ISO30	079004 ●
Mounting device for CMS ISO30	079005 ●
Mounting device for Alberti HSK-E 40	079006 ●

Application:

For mounting shank tools in clamping chucks or tools with bores on arbors with adaptors for automatic tool change.

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



Mounting device

Mounting device for tools with HSK 85 / HSK-F 63 adaptor
VN 799-0

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

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

Application:

For mounting saws, cutting tools, cutting tool sets and cutterheads.



Mounting device

Clamping device for drills with 10 mm shank and clamping flat
VN 799-0

BEZ	ID
Clamping device for drill 10 mm shank	079020 ●

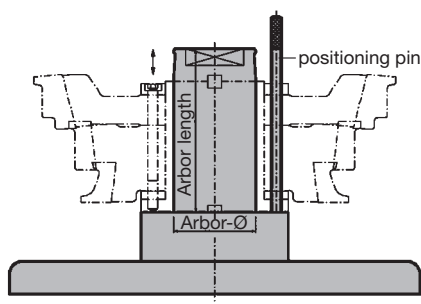
For clamping drills (10 mm shank with clamping flat) when altering the length adjusting screw.

Advantages:

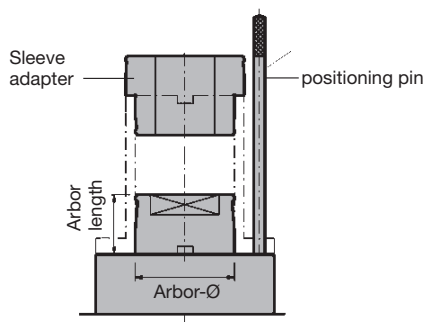
- reduced risk of injury when adjusting the tools
- easy and stable tool clamping during mounting



Mounting device with large arbor



Mounting device with short arbor with using a sleeve adapter



Application:

For assembly and de-assembly of tools with bore on clamping sleeves, or tools mounted together by spacers as tool set.

Mounting device for tool sets with and without clamping sleeve

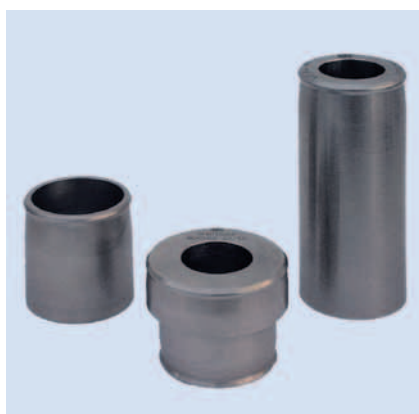
XI 500 0

BEZ	D mm	NL mm	ID
Mounting device without arbor			079011 ●
Arbor long	30	100	079012 ●
Arbor long	35	100	079013 ●
Arbor long	40	100	079014 ●
Arbor long	50	100	079015 ●
Arbor short	30	30	079016 ●
Arbor short	35	30	079017 ●
Arbor short	40	30	079018 ●
Arbor short	50	30	079019 ●

Advantages:

- Reduced risk of injury when mounting tools.
- No twisting as the tool set is positioned on the mounting device.
- Easy mounting of tools and parts for a screwed tool set with position indicated by a centring pin.

Short arbor when using a sleeve adaptor (see following page).

**Application:**

The adaptors are placed on the spindle (thread) before the tools are mounted.

- Then the tools can be mounted on the spindle over this adaptor which prevents the tools from jamming on the spindle.
- Even if the tools are placed on the spindle crooked, the tools are automatically centralised by the collar.
- Remove the adaptor after completing the tool mounting process.

Spindle adaptor for mounting tools on machine spindle**Weinig machine**

TH 599-0

Model	D mm	NL mm	ID
Hydromat with counter bearing	50	50	027879 ●
UC 10 spindle length 640	50	110	027880 ●
UC 10, UC 6 spindle length 320			

SCM machine

TH 599-0

Model	D mm	NL mm	ID
Windor spindle length 320-660	50	45	027882 ●

Gabbiani machine

TH 599-0

Model	D mm	NL mm	ID
Spindle with counter bearing	50	80	027886 ●

Beth machine

TH 599-0

Model	D mm	NL mm	ID
Spindle length 320	50	40	027887 ●

Sleeve adaptor for mounting tools on clamping sleeve

TH 599-0

d mm	Tool bore mm	D mm	NL mm	ID
50	60	60/50	40	027881 ●
40	50	50/40	40	027889 ●
40	60	60/40	40	027888 ●

Joint stones for Leitz Marathon planer knife

FS 100-0, FS 199-0

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

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