Manual feed

Leitz Lexicon Edition 7 | Version 2 | 03/2024

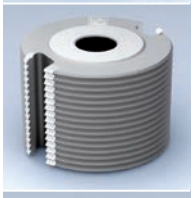
Explanation of abbreviations

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

Notes to the Lexicon concerning the diagrams and tables

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

4. Manual feed



Application

To produce different groove widths, manual or mechanical feed, along or across the grain.

Workpiece material

Softwood and hardwood, glulam, chipboard and fibre materials, uncoated, veneered, plastic and paper coated. Plastics and foams.

Machines

Portable machines, spindle moulders, moulders, double-end tenoners, machining centres, edgebanding machines etc.

Type of feed

Manual feed:
Application only against feed.

Mechanical feed:
Application with or against feed,
for minimum tear out, use with feed necessary.

Tool design

Tipped tools:
With HW or DP. DP tips suitable for abrasive materials.

Replaceable tip tools:
Design with HW turnblade cutters for constant diameter and constant cutting widths.

Two and multiple part tools:
Designed so the cutting width can be adjusted either by spacers (adjustment steps of 0.10 mm) or by a continuously adjustable sleeve for HW or DP tipped tools.

Single tools:
Suitable for use as set.

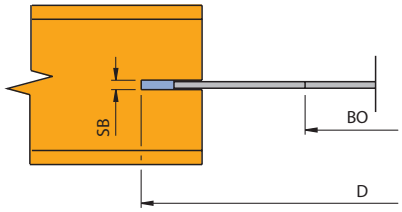
Optimised gullet design DFC:
The DFC concept directs the chips away from the workpiece, so leaving the tool cutting area unhindered. DFC increases tool performance.

Benefits:
– Better product quality by eliminating chip marks or damage to the workpiece edges.
– Reduced tool cutting edge wear by eliminating multiple cutting.

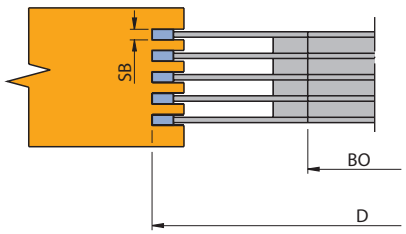
Recommended value for tooth feed rate f_z (in mm)

Solid wood	
Along	0.60 – 0.80 mm
Across	0.30 – 0.40 mm
Glulam	0.40 – 0.50 mm
Chipboard and fibre material	
Without coating	0.50 – 0.70 mm
Coated	0.20 – 0.40 mm
Veneered	0.10 – 0.15 mm
Wood derived materials	
Middle layer	0.30 – 0.60 mm
Top layer	0.08 – 0.12 mm
Plastic	0.20 – 0.50 mm
Polymer compound	0.05 – 0.05 mm
Non-ferrous metals	0.03 – 0.05 mm

$v_f = f_z \cdot n \cdot Z/1000$



Scheme: Grooving in middle layer



Scheme: Set assembly for lock corner joint

Grooving cutters for manual feed

Application:
For grooving with (MEC) or against feed (MAN).

Machine:
Spindle moulders, moulders and double-end tenoners.

Workpiece material:
Solid wood; uncoated, coated and veneered wood derived materials.

Technical information:
Tool body design with round, closed shape.

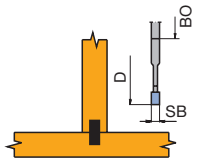
Z 12
WF 100 1 05

D mm	SB mm	TDI mm	BO mm	BO_{max} mm	Z	n min^{-1}	ID
125	1.5	0.8	30	50	12	6200 - 13700	**020241** ●
125	2.0	1.2	30	50	12	6200 - 13700	**020243** ●
125	2.5	1.4	30	50	12	6200 - 13700	**020245** ●
125	3.0	2.0	30	50	12	6200 - 13700	**020246** ●
125	3.5	2.2	30	50	12	6200 - 13700	**020247** ●
125	4.0	2.5	30	50	12	6200 - 13700	**020248** ●
125	4.5	3.0	30	50	12	6200 - 13700	**020249** ●
150	1.5	0.8	30	60	12	5200 - 11400	**020265** ●
150	2.0	1.2	30	60	12	5200 - 11400	**020267** ●
150	2.5	1.4	30	60	12	5200 - 11400	**020269** ●
150	3.0	2.0	30	60	12	5200 - 11400	**020250** ●
150	3.5	2.2	30	60	12	5200 - 11400	**020251** ●
150	4.0	2.5	30	60	12	5200 - 11400	**020252** ●
150	4.5	3.0	30	60	12	5200 - 11400	**020253** ●
150	5.0	3.5	30	60	12	5200 - 11400	**020254** ●
150	6.0	4.5	30	60	12	5200 - 11400	**020255** ●
150	7.0	5.0	30	60	12	5200 - 11400	**020256** ●
150	8.0	6.0	30	60	12	5200 - 11400	**020257** ●
150	9.0	7.0	30	60	12	5200 - 11400	**160100** ●
150	10.0	8.0	30	60	12	5200 - 11400	**160101** ●
180	4.0	2.5	30	70	12	4300 - 9500	**020260** ●
180	5.0	3.5	30	70	12	4300 - 9500	**020261** ●
180	6.0	4.5	30	70	12	4300 - 9500	**020262** ●
180	8.0	6.0	30	70	12	4300 - 9500	**020263** ●
180	10.0	8.0	30	70	12	4300 - 9500	**160102** ●

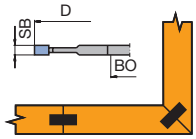
Groove cutter for MEC, see section Panel Processing.
For spacers TR 100 0 used as a set, see section Knives and Spare Parts.

HW

DP



Lamello - T-joint



Lamello - Longitudinal/corner joint

Grooving cutter - lamello joints

Application:
For grooving lamello joints and for cutting grooves for corner joints and longitudinal joints (e.g. picture frames, furniture doors).

Machine:
Portable power tools - grooving cutters (e.g. Lamello etc.).

Workpiece material:
Solid wood; uncoated, coated and veneered wood derived materials.

Technical information:
Tool body design with round, closed shape.

HW tipped
WF 102 1 01

D mm	SB mm	BO mm	NLA mm	Z	V	QAL	n min^{-1}	ID
100	4.0	22	4/4.5/36	2	4	HW	7800 - 13300	**020124** ●

DP tipped
WF 100 1 DP

D mm	SB mm	BO mm	NLA mm	Z	QAL	n min^{-1}	ID
100	4	22	4/4.5/36	4	DP	7800 - 13300	**090017** ●

Grooving cutterhead
WW 102 1 01

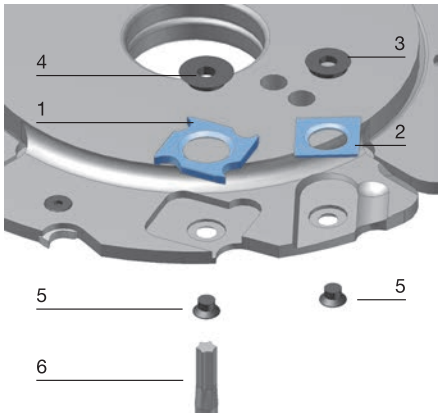
D mm	SB mm	BO mm	NLA mm	Z	V	QAL	n min^{-1}	ID
100	4	22	4/4.5/36	2/2	2/2	HW	7800 - 13300	**020131** ●

Spare knives:

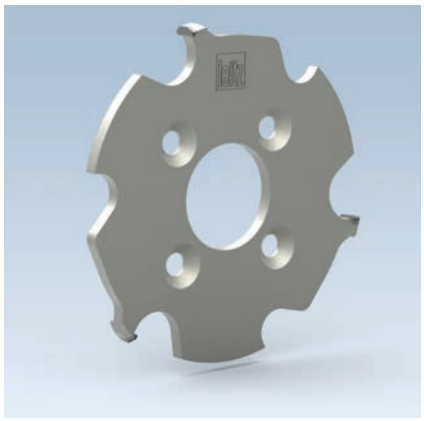
Part-no.	BEZ	QAL	VE PCS	ID
1	Turnblade knife	HW	10	**005114** ●
2	Turnblade spur VS4	HW	10	**005130** ●

Spare parts:

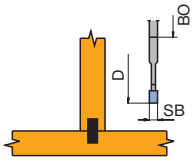
Part-no.	BEZ	ABM mm	ID
3	Special nut for VS	M9.9/1.60	**005654** ●
4	Special nut for WPL	M11.9/2.20	**005653** ●
5	Countersink screw, Torx® 9	M4x0.5x3.2	**006057** ●
6	Torx® key	Torx® 9	**005463** ●



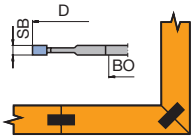
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



DP



Lamello - T-joint



Lamello - Longitudinal/corner joint

Grooving cutter Lamello® Clamex® P-System®

Application:
For grooving lamello joints and for cutting grooves for corner joints and longitudinal joints.

Machine:
Portable power tools - grooving cutters (e.g. Lamello etc.) and for use on CNC machining centres.

Workpiece material:
Solid wood; uncoated, coated and veneered wood derived materials.

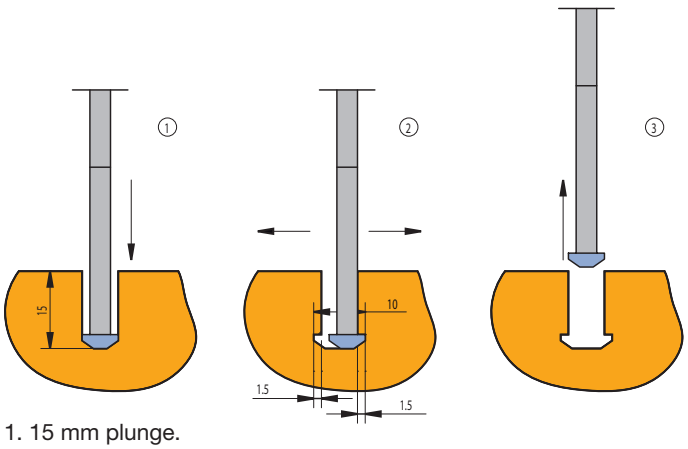
Technical information:
Tool body design with round, closed shape.

DP tipped for Clamex P - connector
WK 100 3 DP, WK 103 2 DP

D	SB	BO	NLA	Z	QAL	n	ZF	DRI	ID
mm	mm	mm	mm			min^{-1}			
100.4	7	16	4/5,5/28	3	DP	7800 - 13300	TR	RH	**192297** ●
100.4	7	22	4/4,3/36	3	DP	7800 - 13300	TR	RH	**192294** ●
100.4	7	30	4/6,6/48	3	DP	7800 - 13300	TR	LH	**192295** ●
100.4	7	30	4/6,6/48	3	DP	7800 - 13300	TR	RH	**090018** ●
100.4	7	30	4/6,6/48	6	DP	7800 - 13300	TR	RH	**192298** ●
100.4	7	30	4/6,9/52 4/6,9/48	6	DP	7800 - 13300	TR	LH, RH	**192311** ●
100.4	7	40	4/5,5/52	3	DP	7800 - 13300	TR	RH	**192296** ●

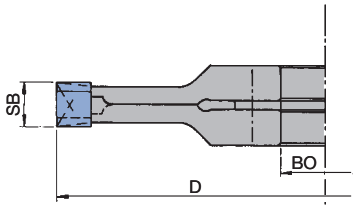
Suitable arbors see section Clamping Systems. Drills for access bore see section Drilling.

Abors with shank to mount the grooving cutter
S16x50,d30,l4,L85 ID **041429**
S25x60,d=30,l=4,L=102 ID **041367**
S20x50,d=30,l=4,L=102 ID **041368**
S25x60,d=30,l=4,L=127 ID **042980**
Drill for access bore hole
D = 6 mm ID **034116**
Shank cutter for CNC: ID **039161**

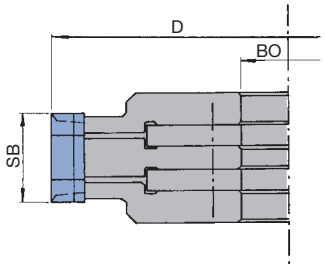


1. 15 mm plunge.
2. 1.5 mm left and right side recesses.
3. Leaving from the middle position.

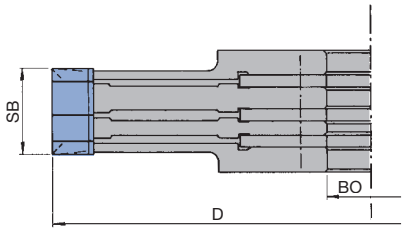




Grooving cutterset, 2 part design



Grooving cutterset with 1 additional extension part



Grooving cutterset with 2 additional extension parts

Grooving cutterset, adjustable with spacers

Application:
For cutting different groove widths.

Machine:
Spindle moulders, moulders, edgebanding machines and stationary routers with/without CNC control, double-end tenoners.

Workpiece material:
Solid wood along grain and across grain; uncoated, coated and veneered wood derived materials in top layer and middle layer.

Technical information:
Adjustment of cutting widths with spacers (adjustment 0.10 mm).

2 part with spurs; SB 1.8 - 23.5 mm
SF 501 1 01

D	SB	BO	BO_{max}	Z	V	NT	n	ID
mm	mm	mm	mm			mm	min^{-1}	
140	1.8 - 3.4	30	35	4	4	20	5500 - 9500	**020545** ●
140	1.8 - 3.4	35	35	4	4	20	5500 - 9500	**020546** □
140	1.8 - 3.4	40	45	4	4	20	5500 - 9500	**020547** □
140	2.2 - 4.0	30	35	4	4	20	5500 - 9500	**020549** ●
140	2.2 - 4.0	35	35	4	4	20	5500 - 9500	**020550** □
140	2.2 - 4.0	40	40	4	4	20	5500 - 9500	**020551** □
140	2.2 - 4.0	50	50	4	4	20	5500 - 9500	**020552** □
150	4.0 - 7.5	30	35	4	4	37.5	5200 - 8900	**020573** ●
150	4.0 - 7.5	40	45	4	4	30	5200 - 8900	**020575** □
150	4.0 - 7.5	50	50	4	4	27.5	5200 - 8900	**020576** □
150	7.5 - 14.5	30	35	4	4	37.5	5200 - 8900	**020580** ●
150	7.5 - 14.5	35	45	4	4	30	5200 - 8900	**020581** □
150	7.5 - 14.5	40	45	4	4	30	5200 - 8900	**020582** □
150	7.5 - 14.5	50	50	4	4	27.5	5200 - 8900	**020583** □
180	6.0 - 11.5	30	35	4	4	45	4300 - 7400	**020584** ●
180	12.0 - 23.5	30	35	4	4	45	4300 - 7400	**020585** ●
180	12.0 - 23.5	40	45	4	4	45	4300 - 7400	**020586** □

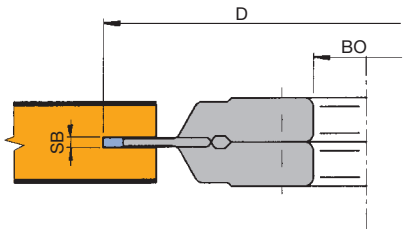
2 part; SB 5.2 - 14 mm
SF 501 1 03

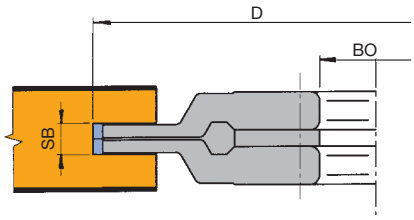
D	SB	BO	BO_{max}	NLA	Z	V	NT	n	ID
mm	mm	mm	mm	mm			mm	min^{-1}	
250	5.2 - 10	30	35	2/10/60	8	8	40	3500 - 6000	**020693** ●
250	5.2 - 10	35	60		8	8	40	3100 - 5300	**020694** □
250	7.2 - 14	35	60		8	8	40	3100 - 5300	**020697**

3 / 4 part; SB 4.0 - 30 mm
SF 501 1, SF 501 1 02

D	SB	BO	BO_{max}	NLA	Z	V	NT	n	ID
mm	mm	mm	mm	mm			mm	min^{-1}	
150	7.5 - 28	50	50		4+4	4	22	5200 - 8900	**020661**
160	4 - 13	30			4	4	35	5000 - 10700	**020667** ●
220	5 - 30	30	35	2/10/60	4+4	4	55	3500 - 6000	**020662** ●

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





Application examples of grooving in the middle layer

Grooving cutterset, adjustable with spacers

Application:
For cutting different groove widths. 2 part design.

Machine:
Spindle moulders, moulders, edgebanding machines and double-end tenoners.

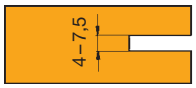
Workpiece material:
Uncoated, coated and veneered wood derived materials.

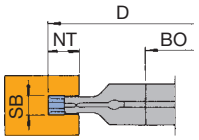
Technical information:
Adjustment of cutting width with spacers (adjustment 0.10 mm).
Diamaster PRO design. Tip height 3.0 mm.

2 part; Diamaster PRO; SB 5.0 - 9.5 mm
SF 501 1 DP

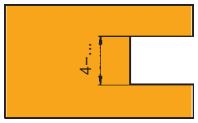
D	SB	BO	BO_{max}	NT	Z	n	ID
mm	mm	mm	mm	mm		min^{-1}	
180	5.0 - 9.5	30	50	25	4/4	4300 - 7400	**090301** ●

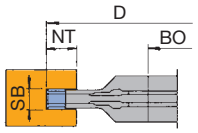
HW





Grooving cutterhead set, 2 part design





Grooving cutterhead set, multi part design

Grooving cutterhead set adjustable with spacers

Application:
For cutting different groove widths.

Machine:
Spindle moulders, moulders, edgebanding machines and stationary routers with/without CNC control, double-end tenoners.

Workpiece material:
Solid wood along grain and across grain; uncoated, coated and veneered wood derived materials in top layer and middle layer.

Technical information:
Adjustment of cutting widths with spacers (adjustment 0.10 mm).

2 part; SB 4.0 - 7.5 mm
SW 501 1 01

D mm	SB mm	BO mm	BO_{max} mm	NT mm	Z	n min^{-1}	ID
150	4.0 - 7.5	30	50	20	2/2	5200 - 10100	**128100** ●
180	4.0 - 7.5	30	50	35	2/2	4300 - 8400	**128101** ●

Extension parts SB 3.8 mm
WW 200 1 NN

D mm	SB mm	BO mm	BO_{max} mm	Z	n min^{-1}	ID
150	3.8	30	50	2	5200 - 10100	**128130**
180	3.8	30	50	2	4300 - 8400	**128131**

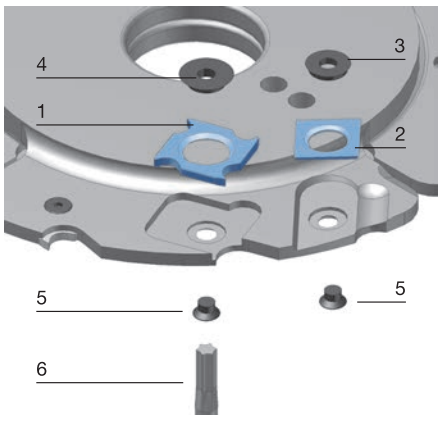
Each extension part increases the cutting widths by 3.6 mm.

Spare knives:

Part-no.	BEZ	ABM mm	QAL	VE PCS	ID
1	Turnblade knife	18x18x1.95	HW	10	**005114** ●
2	Turnblade spur VS4	14x14x1.2	HW	10	**005130** ●

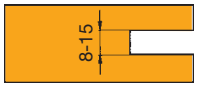
Spare parts:

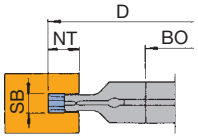
Part-no.	BEZ	ABM mm	ID
3	Special nut for VS	M9.9/1.60	**005654** ●
4	Special nut for WPL	M11.9/2.20	**005653** ●
5	Countersink screw, Torx® 9	M4x0.5x3.2	**006057** ●
6	Torx® key	Torx® 9	**005463** ●
	Setting gauge for knives	0.3/0.8	**005374** ●



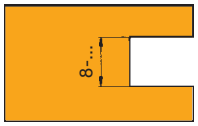
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

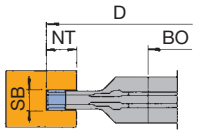
HW





Grooving cutterhead set, 2 part design





Grooving cutterhead set, multi part design

Grooving cutterhead set adjustable with spacers

Application:
For cutting different groove widths.

Machine:
Spindle moulders, moulders, edgebanding machines and stationary routers with/without CNC control, double-end tenoners.

Workpiece material:
Solid wood along grain and across grain; uncoated, coated and veneered wood derived materials.

Technical information:
Adjustment of cutting widths with spacers (adj. range 0.1 mm). Multi part design.

Multi part; SB 8.0 - 30.0 mm
SW 501 1, SW 501 1 01

D mm	SB mm	BO mm	NT mm	Z	n min^{-1}	ID
150	8.0 - 15.4	30	20	2/2	5200 - 10100	**128104** ●
180	8.0 - 15.4	30	35	2/2	4300 - 8400	**128105** ●
200	8.0 - 15.4	30	45	2/2	3900 - 7600	**128106** ●
220	8.0 - 30.0	30	58	2/2	3500 - 6000	**024663** ●

Extension part
SW 501 1, WW 200 1 NN

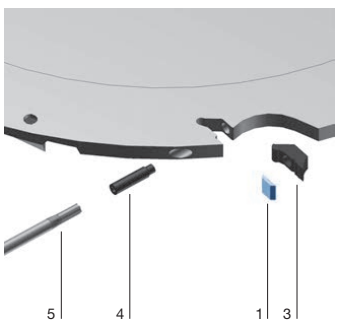
D mm	SB mm	BO mm	BO_{max} mm	Z	n min^{-1}	ID
150	7.7	30	50	2	5200 - 10100	**128134**
180	7.7	30	50	2	4300 - 8400	**128135** ●
200	7.7	30	50	2	3900 - 7600	**128136** ●
220	15	30	45	2	3500 - 6000	**024666** ●

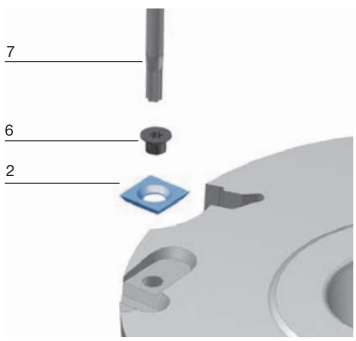
Spare knives:

Part-no.	BEZ	ABM mm	QAL	VE PCS	ID
1	Turnblade knife	7.7x8x1.5	HW-05	10	**005053** ●
1	Turnblade knife	14.7x8x1.5	HW-05	10	**005056** ●
2	Turnblade spur VS1	14x14x2	HW-F	10	**005099** ●
2	Turnblade spur VS2	19x19x2	HW-F	10	**005115** ●

Spare parts:

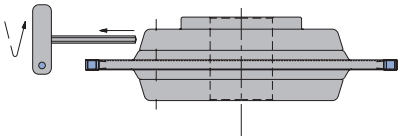
Part-no.	BEZ	ABM mm	ID
3	Clamping wedge	7x18.75x8.27	**009763** ●
3	Clamping wedge	13x18.75x8.27	**009670** ●
4	Allen screw with shank, Torx® 15	M5x20	**007380** ●
4	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
5	Torx® key	Torx® 15	**117507** ●
5	Torx® key	Torx® 25	**117504** ●
6	Countersink screw, Torx® 20	M6x0.5x4.9	**006243** ●
7	Torx® key	Torx® 20	**117503** ●
	Setting gauge for knives	0.3/0.8	**005374** ●



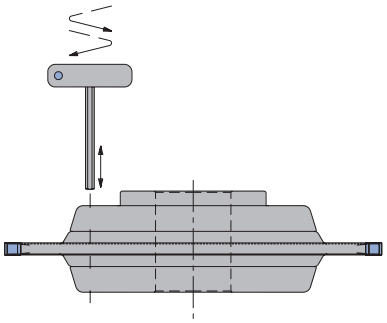


● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

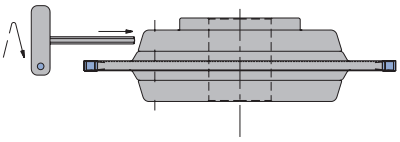
HW



Opening the clamping system



Adjustment: SB larger „+“,
SB smaller „-“



Closing the clamping system

After the tool is mounted on the spindle it can be adjusted and clamped using a hexagon key

Grooving cutterhead - steplessly adjustable

Application:
For cutting different groove widths.

Machine:
Spindle moulders, moulders, edgebanding machines and double-end tenoners.

Workpiece material:
Solid wood; uncoated, coated and veneered wood derived materials.

Technical information:
Stepless adjustment of cutting width possible when installed on machine.
2 part design.

Mounted on sleeve; SB 4.0 - 15.0 mm
SW 502 1 01

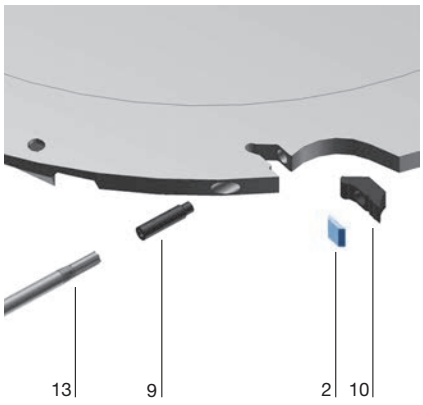
D mm	SB mm	BO mm	BO_{max} mm	NT mm	Z	n min^{-1}	ID
180	4.0 - 7.5	30	35	40	2/2	4300 - 8400	**128154** ●
180	8.0 - 15.0	30	35	40	2/2	4300 - 8400	**128155** ●
180	4.0 - 7.8	40	50	35	2/2	4300 - 8400	**128156**
180	8.0 - 15.0	40	50	35	2/2	4300 - 8400	**128157**

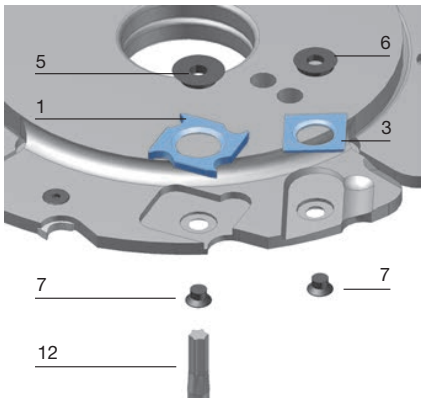
Spare knives:

Part-no.	BEZ	ABM mm	QAL	VE PCS	ID
1	Turnblade knife	18x18x1.95	HW	10	**005114** ●
2	Turnblade knife	7.7x8x1.5	HW-05	10	**005053** ●
3	Turnblade spur VS4	14x14x1.2	HW	10	**005130** ●
4	Turnblade spur VS2	19x19x2	HW-F	10	**005115** ●

Spare parts:

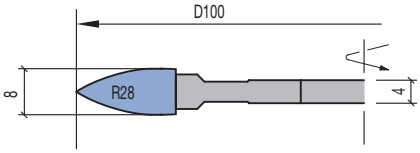
Part-no.	BEZ	ABM mm	ID
5	Special nut for WPL	M11.9/2.20	**005653** ●
6	Special nut for VS	M9.9/1.60	**005654** ●
7	Countersink screw, Torx® 9	M4x0.5x3.2	**006057** ●
8	Countersink screw, Torx® 20	M6x0.5x4.9	**006243** ●
9	Allen screw with shank, Torx® 15	M5x20	**007380** ●
10	Clamping wedge	7x18.75x8.27	**009763** ●
11	Torx® key	Torx® 20	**117503** ●
12	Torx® key	Torx® 9	**005463** ●
13	Torx® key	Torx® 15	**117507** ●
	Setting gauge for knives	0.3/0.8	**005374** ●

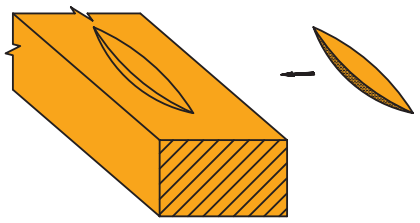




● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

HW





Profile cutter - pitch pockets

Application:
Optimized for milling pitch pockets.

Machine:
Portable machine Lamello Standard and Lamello Top.

Workpiece material:
Softwood and hardwood.

Technical information:
Two reciprocal cutting knives.

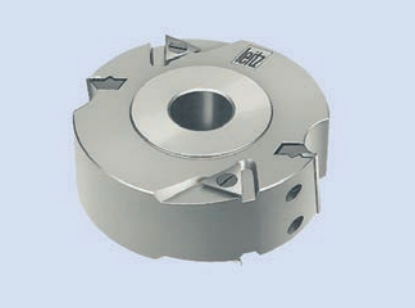
Radii profile
WF 502 1

D mm	SB mm	BO mm	BEM	Z	ID
100	8	22	Size 1-3	1+1	**020126** ●

RPM: n = 7700 - 13000 min^{-1}

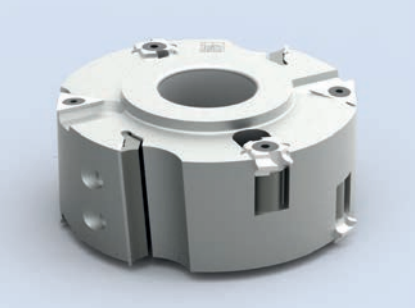
Type of operation	Rebate tools cut on the periphery and the side. The rebated edge is produced by spurs.
Workpiece material	Softwood and hardwood, glulam, chipboard and fibre materials, uncoated, veneered, plastic and paper coated. Plastics and foams.
Machines	Spindle moulders. Edgebanding machines; double-end tenoners. Four-sided moulders.
Application	Jointing and rebating against feed: all panel materials with or without coating. Jointing and rebating with feed: machining solid wood with heavily twisted fibres and risk of tear outs. Only for machines with mechanical feed. Note: Difficult chip removal. Jump cutting: jointing with or against feed across grain to avoid tear outs at the front and rear workpiece edges after edgebanding or lipping.

Tool design



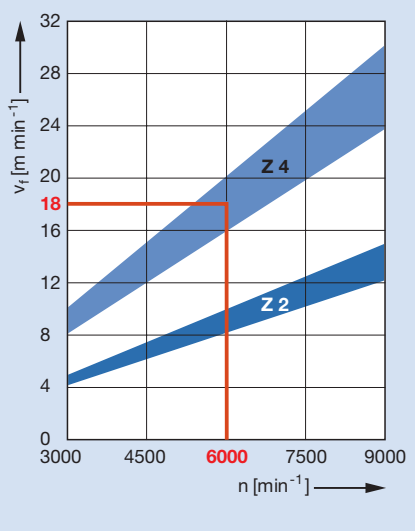
Turnblade rebating cutterhead with alternate shear angle:
Reduced feed and cutting forces achieve clean and tear out free rebating edges. Suitable for all coated and uncoated panel materials as well as solid wood.

2 part tools with alternate shear angle:
Can also be used as adjustable grooving tools.

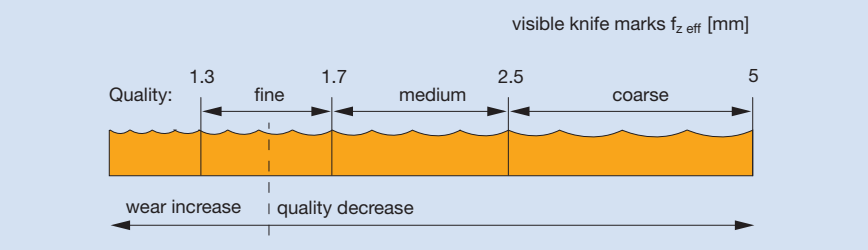


Turnblade rebating cutterhead with additional knives (edge knives):
Multi-purpose tool for jointing, rebating and rounding/bevelling.

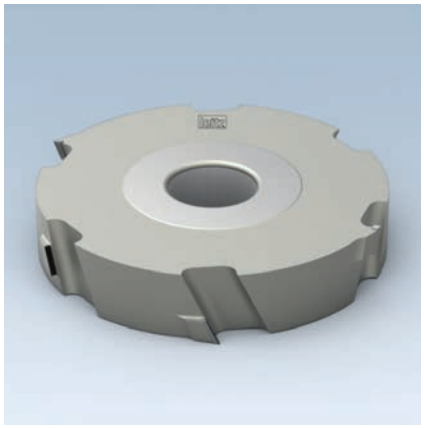
Feed speed depending on RPM and no. of teeth

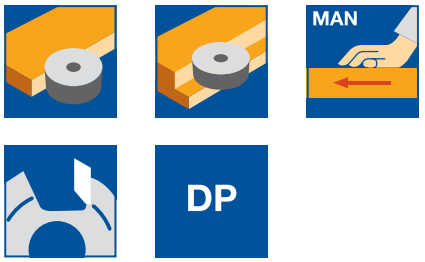


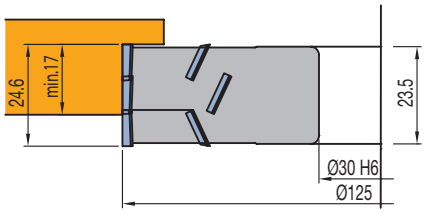
Relation between surface quality and length of knife marks $f_{z\,eff}$



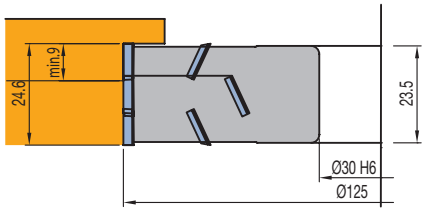
With multi blade tools, only the marks of one knife show on the surface (one knife finish).
Z 2 and Z 4 tools produce the same surface quality with the same machine setting.
High numbers of teeth are required for a high hogging performance.



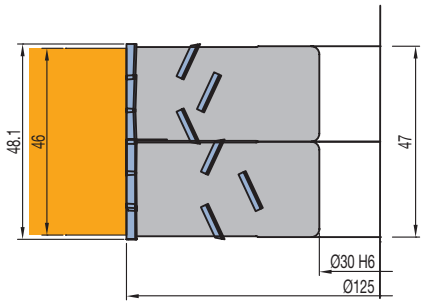




Jointing cutter ID **090853**
Rebate height min. 17 mm



Jointing cutter ID **090872**
Rebating height min. 9 mm



Set existing of ID **090853 and** ID **090872**

Jointing and rebating cutter Diamaster PRO

Application:
Optimized for rebating and jointing with and against feed (e.g. jump cutting). Manual feed only against feed.

Machine:
Spindle moulders and edgebanding machines, double-end tenoners.

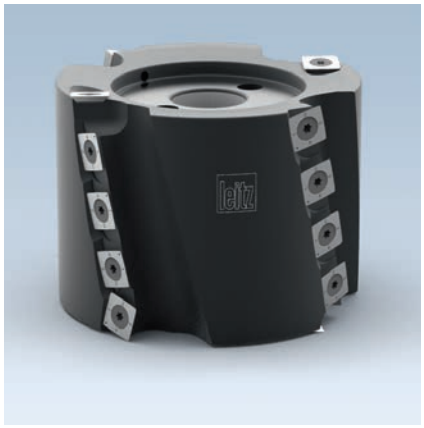
Workpiece material:
Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.) uncoated, laminated veneer lumber (plywood etc.), plastomers, solid surface material (Corian, Varicor etc.) fibre reinforced plastics (GFRP, CFRP etc.).

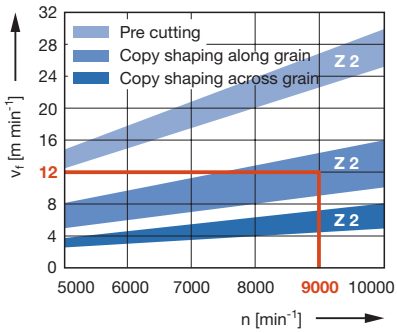
Technical information:
Composite tool with alternate shear angle and main blades with pre-cutting function. Long performance times through polished cutting area. Diamaster PRO design for two resharpening cycles with standard wear. Double sided rebating possible. For larger cutting widths a stacking of various tools is possible. 3.5 mm tipping height. 1.5 mm resharpening area.

Diamaster PRO
WF 400 1 DP

D mm	SB mm	BO mm	Z	ID
125	24.6	30	2/2/2	**090853** ●
125	24.6	30	2/2/2	**090872** ●

RPM: n = 6200 - 13600 min^{-1}





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

Copy shaping cutterhead - HeliCut 15

Application:
For pre-cutting, jointing and copy shaping of large cutting depths. For copy shaping of curved workpieces with template, ball bearing and guide ring.

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

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

Technical information:
Noise reduced design with staggered edges and very deep gullets for improved chip removal. Tungsten carbide cutting edges with Microfinish for perfect surface quality. Rebate tools cut on the periphery and the side.

Cutterhead for copy shaping, grooving and rebating
WW 230 1 07

D mm	SB mm	BO mm	Z	V	QAL	AM PCS	ID
60	81.5	20	2	2	HW-MF	16	**132600** ●
80	81.5	30	2	2	HW-MF	16	**132608** ●
125	93.7	30	2	2+2	HW-MF	20	**132604** ●
125	116.6	30	2	2+2	HW-MF	24	**132605** ●

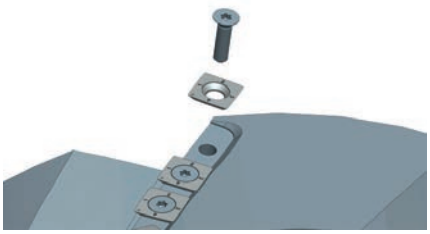
RPM: D 60 mm: n_{max} = 20000 min^{-1}
D 80 mm: n_{max} = 18000 min^{-1}
D 125 mm: n_{max} = 12000 min^{-1}

Spare knives:

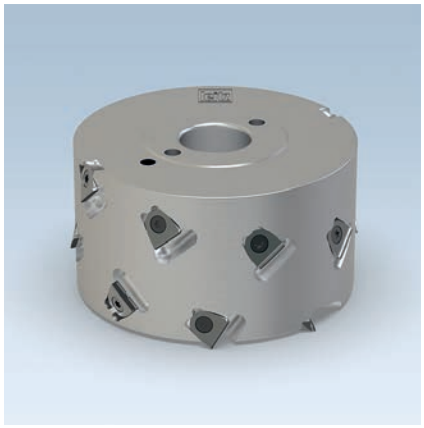
BEZ	ABM mm	QAL	BEM	VE PCS	ID
Turnblade knife	15x15x2,5	HW-MF	HeliCut 15	10	**009543** ●
Turnblade knife	15x15x2,5	HW	HeliCut 15	10	**009549** ●

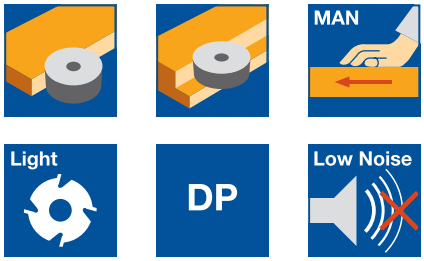
Spare parts:

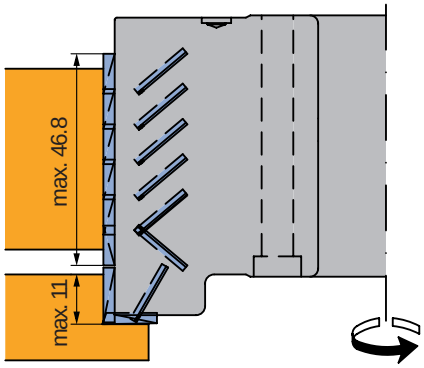
BEZ	ABM mm	for D mm	ID
Countersink screw, Torx® 20	M5x12	60	**007898** ●
Countersink screw, Torx® 20	M5x14.2-8.8	80	**007394** ●
Countersink screw, Torx® 20	M5x18	125	**114030** ●
Torx® key	Torx® 20		**006091** ●



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







Diamaster WhisperCut EdgeExpert jointing and rebating cutterhead

Jointing and rebating cutterhead WhisperCut EdgeExpert

Application:
Optimized for noise reduced rebating and jointing particularly for sensitive decorative papers, foil coatings and veneers.

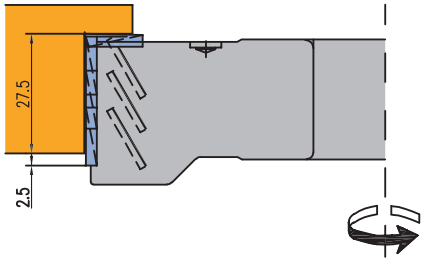
Machine:
Spindle moulders and edgebanding machines.

Workpiece material:
Chip and fibre boards (MDF etc.) raw, veneered, painted and coated; especially for plastic, paper, HPL and anti-fingerprint coatings. Also suitable for surfaces in mat, high gloss or with relief structures.

Technical information:
DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surface. With rebating knife for tear-free rebating edges (up to 11 mm rebating width). Increased shear angle for excellent edge quality on sensitive decorative papers, foil coatings and veneers. Noise reduced design with up to 5 dB(A) noise reduction. Significant weight reduction by using an aluminium alloy tool body. Carrier body for multiple use with exchangeable knives. 0.6 mm resharpening area.

Diamaster WhisperCut EdgeExpert - LowNoise, aluminium alloy tool body
WM 430 2 01

D mm	SB mm	BO mm	n_{max} min^{-1}	Z	DRI	ID
125	59.8	30	13,700	2/2	RH	**192309** ●



Rebating cutterhead WhisperCut PRO

Application:
Optimized for noise reduced rebating of abrasive materials.

Machine:
Spindle moulders.

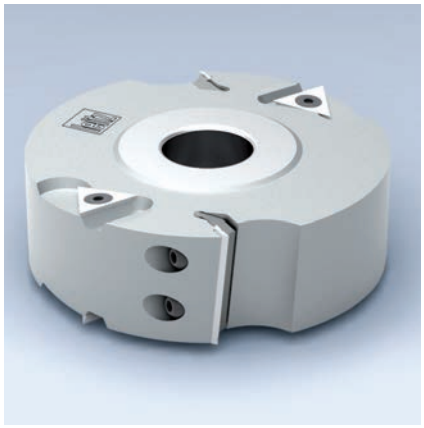
Workpiece material:
Abrasive materials, chip and fibre board (MDF etc.) uncoated, veneered, plastic and paper coated, fibre reinforced plastics (GFRP, CFRP etc.).

Technical information:
DP tipped rebating cutterhead for tear-free edges on sensitive decorative papers, foil coatings and veneers. Noise reduced design with up to 5 dB(A) noise reduction. Significant weight reduction by using an aluminium alloy tool body. Carrier body for multiple use with exchangeable knives. 0.6 mm resharpening area.

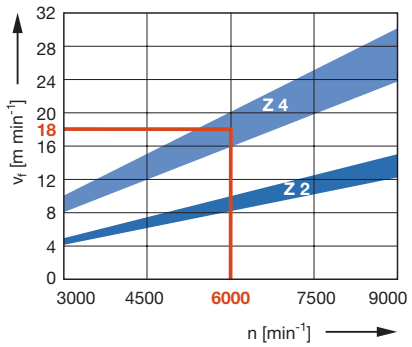
Diamaster WhisperCut PRO - LowNoise, aluminium alloy tool body
WM 430 1 01

D mm	SB mm	BO mm	n_{max} min^{-1}	Z	V	DRI	ID
125	27.5	30	13,700	2	2	RH	**192355** ●

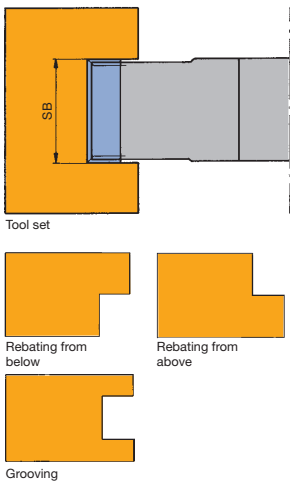
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org







Feed speed v_f depending on the number of teeth Z and speed n for solid wood along grain
Example:
n = 6000 min^{-1}, Z 4: v_f = 18 m min^{-1}



Rebating cutterhead

Application:
For jointing, rebating and grooving.

Machine:
Spindle moulders (running against feed), double-end tenoners, edgebanding machines etc. (running with feed or against feed e.g. jump cutting). Stationary routers with/without CNC control.

Workpiece material:
Softwood and hardwood, glulam, plastics etc.

Technical information:
Cutterhead with alternate shear angle and triangular spurs.

Turnblade rebating cutterhead
WW 420 1, WW 420 1 02

D mm	SB mm	BO mm	BO_{max} mm	Z	V	n_{max} min^{-1}	ID
85	51	30	40	2	4	20200	**024555**
100	51	30	40	2	4	17100	**024568**
125	41	30	40	2	4	13700	**024546** ●
125	51	30	50	2	4	13800	**024569** ●
125	51	40	50	2	4	13800	**024570** □
125	51	50	50	2	4	13800	**024571** □
125	81	30	50	2	4	13700	**024723** ●
150	51	30	40	2	4	11400	**024548** ●
150	61	30	50	4	4	11400	**024543** ●

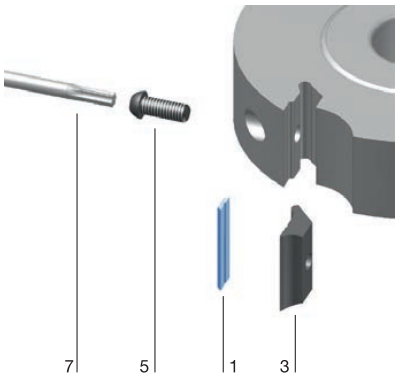
Spare knives:

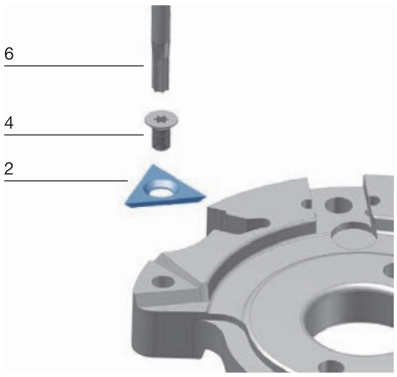
Part-no.	BEZ	ABM mm	QAL	VE PCS	ID
1	Turnblade knife	40x8x1.5	HW-30F	10	**005074** ●
1	Turnblade knife	50x8x1.5	HW-30F	10	**005075** ●
1	Turnblade knife	60x8x1.5	HW-30F	10	**005076** ●
1	Turnblade knife	80x8x1.5	HW-30F	10	**601613** ●
2	Turnblade spur VS2	19x19x2	HW-F	10	**005115** ●

Alternative turnblade knife qualities see section Knives and Spare Parts

Spare parts:

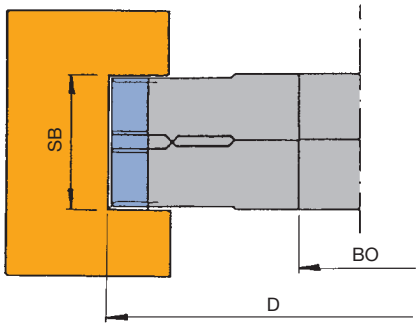
Part-no.	BEZ	ABM mm	ID
3	Clamping wedge	38x18.75x8.27	**009675** ●
3	Clamping wedge	48x18.75x8.27	**009677** ●
3	Clamping wedge	58x18.75x8.27	**009678** ●
3	Clamping wedge	78x18.75x8.27	**009680** ●
4	Countersink screw, Torx® 20	M5x8.5	**007808** ●
5	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
6	Torx® key	Torx® 20	**117503** ●
7	Torx® key	Torx® 25	**117504** ●
	Setting gauge for knives	0.3/0.8	**005374** ●



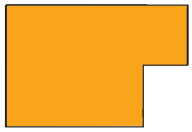


● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

HW

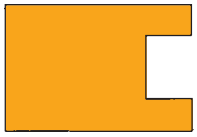


Tool set



Rebating from below

Rebating from above



Grooving

Rebating cutterset, 2 part design

Application:
For jointing, rebating and grooving.

Machine:
Spindle moulders (running against feed), double-end tenoners and edgebanding machines etc. (running with feed or against feed).

Workpiece material:
Softwood and hardwood, glulam, plastics etc.

Technical information:
2 part with spacers adjustable tool set with alternate shear angle and triangular spurs.

SB 26.4 - 98 mm
SW 531 1 01

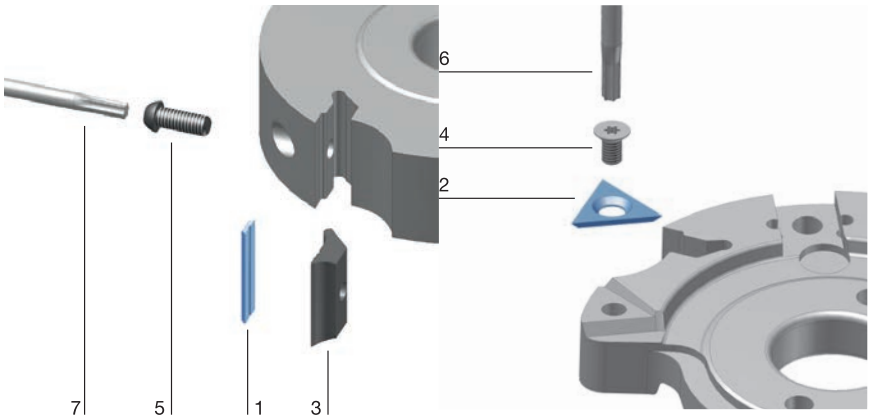
D mm	SB mm	VSB	BO mm	BO_{max} mm	Z	V	n min^{-1}	ID
160	20	26.4 - 38	30	45	4	4	4900 - 9500	**024456** ●
160	20	26.4 - 38	50	50	4	4	4900 - 9500	**024458** □
160	50	56.4 - 98	40	45	4	4	4900 - 9500	**024455**

Spare knives:

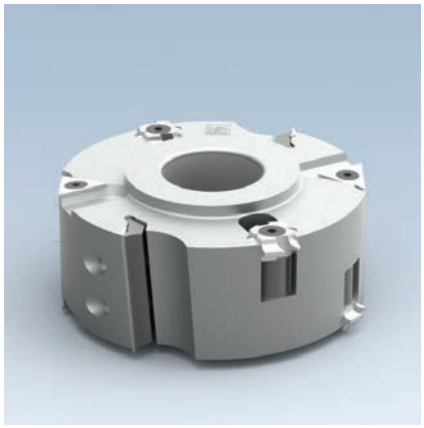
Part-no.	BEZ	ABM mm	QAL	VE PCS	ID
1	Turnblade knife	19.7x8x1.5	HW-30F	10	**005071** ●
1	Turnblade knife	50x8x1.5	HW-30F	10	**005075** ●
1	Turnblade knife	30x8x1.5	HW-30F	10	**005072** ●
2	Turnblade spur VS2	19x19x2	HW-F	10	**005115** ●

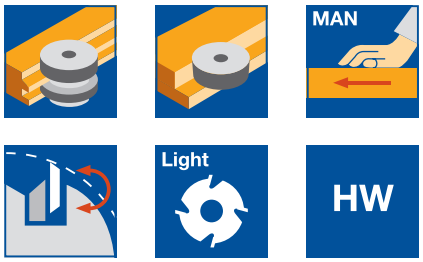
Spare parts:

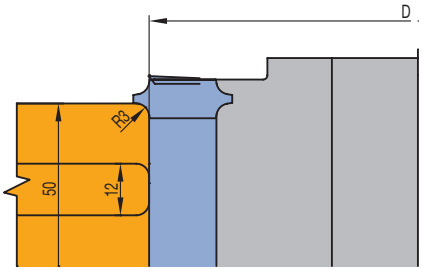
Part-no.	BEZ	ABM mm	ID
3	Clamping wedge	18x18.75x8.27	**009671** ●
3	Clamping wedge	48x18.75x8.27	**009677** ●
3	Clamping wedge	28x18.75x8.27	**009673** ●
4	Countersink screw, Torx® 20	M6x0.5x4.9	**006243** ●
5	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
6	Torx® key	Torx® 20	**117503** ●
7	Torx® key	Torx® 25	**117504** ●
	Setting gauge for knives	0.3/0.8	**005374** ●

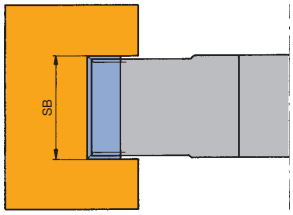


● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org







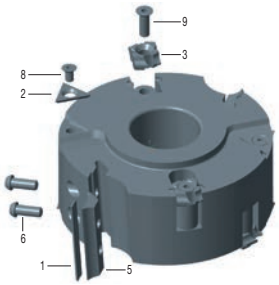


Tool set


Rebating from below


Rebating from above


Grooving



Jointing and rebating cutterhead

Application:
For rebating and jointing, rounding and profiling at the same time.

Machine:
Spindle moulders and moulders, double-end tenoners. Stationary routers with/without CNC control.

Workpiece material:
Softwood and hardwood, glulam, plastics etc.

Technical information:
Cutterhead with turnblade knives. With alternate shear angle, triangle spurs and seating to adapt edging knives.

Cutterhead with seatings for edging knives
WW 420 1 01

D mm	SB mm	BO mm	Z	KM PCS	n min^{-1}	QAL	ID
125	51	30	2	4	6200 - 10600	HW	**029073** ●
125	101	30	2	4	6200 - 10600	HW	**029074**
170	51	30	2	4	4500 - 7800	HW	**029075** ●

Spare knives:

Part-no.	BEZ	ABM mm	R mm	FAW °	QAL	VE PCS	ID
1	Turnblade knife	50x8x1.5			HW-30F	10	**005075** ●
2	Turnblade spur VS2	19x19x2			HW-F	10	**005115** ●
3	Edging knife 45°	KM 21/0		45°	HW-F		**008292** ●
3	Edging knife R1.5	KM 22/4	1.5		HW-F		**008295** ●
3	Edging knife R2	KM 22/3	2		HW-F		**008309** ●
3	Edging knife R3	KM 22/0	3		HW-F		**008293** ●
3	Edging knife R5	KM 24/0	5		HW-F		**008305** ●
3	Edging knife R5	KM 24/1	5		HW-F		**008306** ●

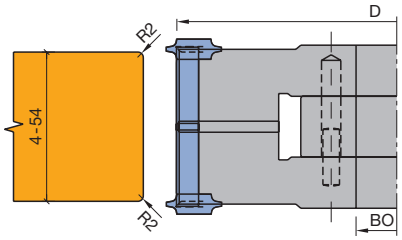
Spare parts:

Part-no.	BEZ	ABM mm	ID
5	Clamping wedge	48x18.75x8.27	**009677** ●
6	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
9	Countersink screw, Torx® 20	M6x30	**006089** ●
	Torx® key	Torx® 20	**117503** ●
	Torx® key	Torx® 25	**117504** ●
	Setting gauge for knives	1.0	**005350** ●
	Spacer	13/6.1x0.1	**028034** ●
	Spacer	13/6.1x0.3	**028035** ●
	Spacer	13/6.1x0.5	**028036** ●
	Spacer	13/6.1x1	**028037** ●
	Spacer	13/6.1x3	**028040** ●
	Spacer	13/6.1x5	**028042** ●

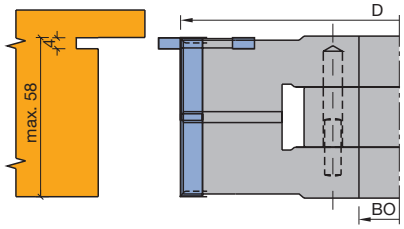
Edging knife set: 2 edging knives each + countersunk screw + set of spacers
TE 540 0

BEZ	FAW °	R mm	QAL	ID
Edge cutterset	45°		HW	**009091** ●
Edge cutterset		1.5	HW	**009092** ●
Edge cutterset		3	HW	**009093** ●
Edge cutterset		5	HW	**009097** ●
Edge cutterset		5	HW	**009098** ●

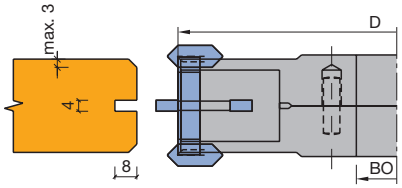

HW



Jointing, rounding



Rebating and seal groove



Groove and chamfers

Rebate cutterset UniCut

Application:
For rebating, jointing, grooving, bevelling and rounding.

Machine:
Spindle moulders, moulders etc.

Workpiece material:
Softwood and hardwood, glulam, plastics etc.

Technical information:
2 part with spacers adjustable tool set for multi-purpose application.

With seatings for edging knives and turnblade grooving knives; SB 30 - 60 mm
AW 330 1 01

Tool no.	D mm	SB mm	BO mm	BO_{max} mm	Z	V	n min^{-1}	ID
1 + 2	160	30 - 60	30	50	2/2	2/2	4900 - 8300	**024056** ●
1 + 2	160	30 - 60	40		2/2	2/2	4900 - 8300	**024062** □

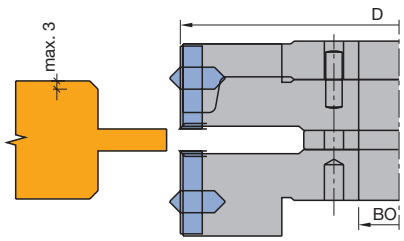
Tool complete with edge rounding knife R 2.
Additionally:
2 grooving knives SB 4 mm with countersunk screws
1 set of spacers D 70 mm for adjusting the tool parts
1 set of spacers D 13.70 mm to adjust the edging/grooving knives
1 setting gauge 0.3/0.8 mm
Tool set in wooden box, BO 30.

Spare knives:

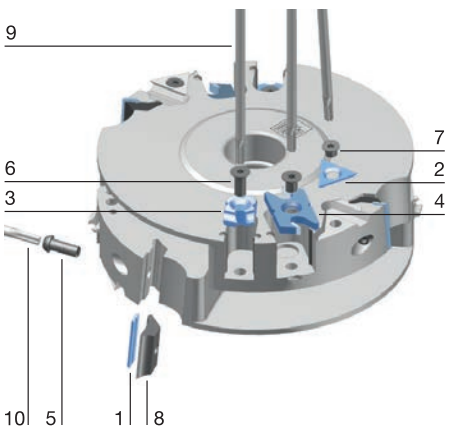
Part-no.	BEZ	ABM mm	QAL	VE PCS	ID
1	Turnblade knife	30x8x1.5	HW-30F	10	**005072** ●
2	Turnblade spur VS2	19x19x2	HW-F	10	**005115** ●
3	Edging knife 45°	KM 21/0	HW-F		**008292** ●
3	Edging knife R2	KM 22/3	HW-F		**008309** ●
4	Turnblade grooving knife NB4	36x20x4	HW-F		**008323** ●

Spare parts:

Part-no.	BEZ	ABM mm	ID
5	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
6	Countersink screw, Torx® 20	M6x30	**006089** ●
7	Countersink screw, Torx® 20	M6x0.5x4.9	**006243** ●
8	Clamping wedge	28x18.75x8.27	**009673** ●
9	Torx® key	Torx® 20	**117503** ●
10	Torx® key	Torx® 25	**117504** ●
	Setting gauge for knives	0.3/0.8	**005374** ●

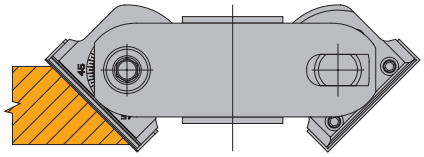


Tongue profile

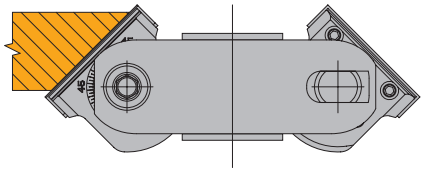


● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

HW



Bevelling from above



Bevelling from below

Bevel cutterhead turnblade, swivelling

Application:
For jointing and bevelling with adjustable bevel angle.

Machine:
Spindle moulders, moulders, edgebanding machines, double-end tenoners and special machines.

Workpiece material:
Softwood and hardwood, laminated veneer lumber, plastomers, limited suitable for MDF and chipboad (uncoated or coated).

Technical information:
Knife holder swivelling adjustable from 0 - 90°. Quick and easy angle adjustment of common angles (15°, 30°, 45°, 60°) by additional locking positions in 15° steps. Free of marks cutting result due to 1-part, continuous cutting edge. Economical due to changeable tungsten carbide turnblades with two cutting edges. Optimized gullet design for improved chip removal.

Turnblade, adjustable bevel angle
WW 430 1 05

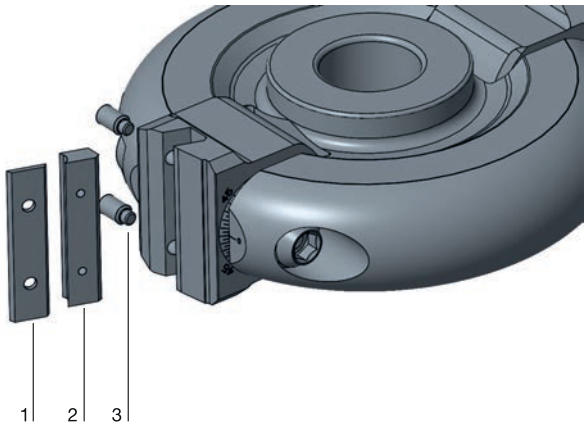
D mm	SB mm	BO mm	BO_{max} mm	Swivel range °	n min^{-1}	Z	ID
150	50	30	40	0 - 90	5000 - 9000	2	**024169** ●
150	50	31.75	40	0 - 90	5000 - 9000	2	**024170** □
150	50	40	40	0 - 90	5000 - 9000	2	**024171** □
170	50	50	60	0 - 90	5000 - 9000	2	**024172** □

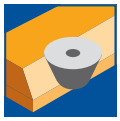
Spare knives:

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

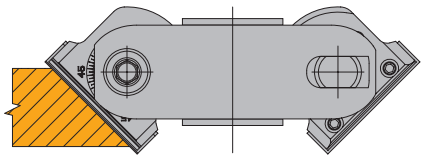
Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge with pin	48x10,88x6	**009766** ●
3	Allen screw	M6x12	**006035**
	Allen key	SW 3	**005433** ●
	Allen key	SW 8, L 100	**005437** ●
	Setting gauge for knives	43x12x6	**005350** ●

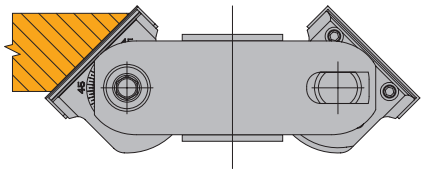




HW



Bevelling from above



Bevelling from below

Bevel cutterhead HeliCut, swivelling

Application:
For jointing and bevelling with adjustable bevel angle.

Machine:
Spindle moulders, moulders, edgebanding machines and double-end tenoners.

Workpiece material:
Softwood and hardwood, laminated veneer lumber, plastomers, technical foams (XPS, PU), limited suitable for MDF and chipboard (uncoated or coated).

Technical information:
Knife holder can be swivelled steplessly on both sides from 0 - 65°. Quick and easy adjustment of conventional angles (15°, 30°, 45°, 60°) due to additional locking positions in 15° steps. Design with divided cutting edges and optimized gullet areas for low-noise working with low cutting pressure even at high cutting performance. Workpiece edges free of tear-out on both sides even in critical materials due to alternating tool angle. Cutting edges with particularly precise geometry and polishing for long tool life and machining of „soft“ materials. Economical due to partially exchangeable solid carbide blades with 4 cutting chamfers.

HeliCut, adjustable bevel angle
WW 430 1 05

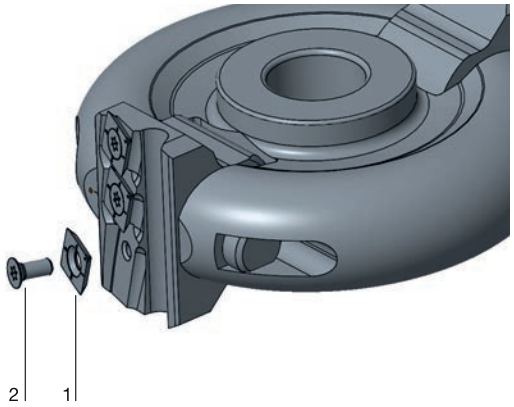
D mm	SB mm	BO mm	BO_{max} mm	Swivel range °	n min^{-1}	Z	ID
150	55	30	40	0 - 65	5000 - 9000	1/1	**024290** ●
150	55	31.75	40	0 - 65	5000 - 9000	1/1	**024262** □
150	55	40	40	0 - 65	5000 - 9000	1/1	**024264** □
170	55	50	60	0 - 65	5000 - 9000	1/1	**024273** □

Spare knives:

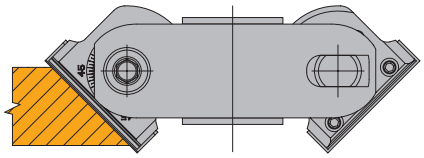
Part-no.	BEZ	ABM mm	ID
1	Turnblade knife	15x15x2,5	**009543** ●

Spare parts:

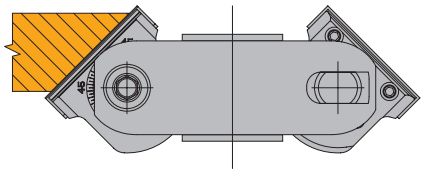
Part-no.	BEZ	ABM mm	ID
2	Countersink screw, Torx® 20	M5x12	**007898** ●
	Torx® key	Torx® 20	**006091** ●
	Allen key	SW 8, L 100	**005437** ●



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



Bevelling from above



Bevelling from below

Bevel cutterhead WhisperCut, swivelling

Application:
For jointing and bevelling with adjustable bevel angle.

Machine:
Spindle moulders, moulders, edgebanding machines and double-end tenoners.

Workpiece material:
Hardwood, chip and fibre board (chipboard, MDF, HDF etc.), plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), solid surface material (e.g. Corian®, Varicor® etc.), fibre reinforced plastics (e.g. GRP, CFRP).

Technical information:
Knife holder swivelling adjustable from 0 - 65°. Quick and easy angle adjustment of common angles (15°, 30°, 45°, 60°) by additional locking positions in 15° steps. Workpiece edges tear-free on both sides due to alternatinv shear angles. Economical due to partial change of diamond cutting edges. Noice reduced design with optimized gullet design for improved chip removal.

WhisperCut, adjustable bevel angle
WW 430 1 05

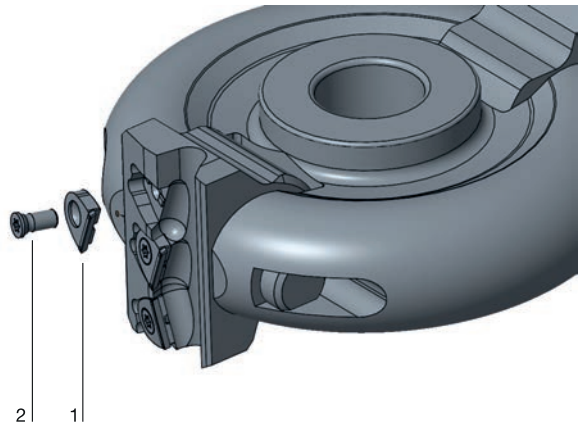
D mm	SB mm	BO mm	BO_{max} mm	Swivel range °	n min^{-1}	Z	ID
150	55	30	40	0 - 65	5000 - 9000	1/1	**024291** ●
150	55	31.75	40	0 - 65	5000 - 9000	1/1	**024263** □
150	55	40	40	0 - 65	5000 - 9000	1/1	**024265** □
170	55	50	60	0 - 65	5000 - 9000	1/1	**024274** □

Spare knives:

Part-no.	BEZ	ABM mm	ID
1	WhisperCut-knife SB14	14x14.2x4.3	**091074** ●

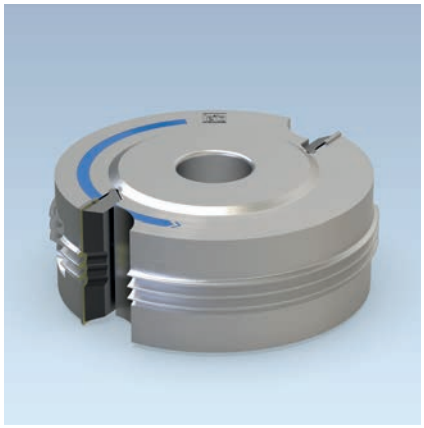
Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Countersink screw, Torx® 20/59°	M5x11.5	**007899** ●
	Torx® key	Torx® 20	**006091** ●
	Allen key	SW 8, L 100	**005437** ●



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

Types of operation	The tools in the following section are suitable for producing glue joints, divided into glue joints (along the grain) and mitre joints.
	Glue joints along grain Glue joint profiles for length grain glue joints have a low profile depth to minimise the material loss at each glue joint. Glue joint profiles do not increase the stability of the glue joint. The profile is used to position the wood precisely, so it does not slip during pressing. Length grain glue joint profiles are not self-locking. The workpieces must remain pressed together until the glue has hardened completely. Profile tools for glue joints along the grain are not suitable for mitre joints.
Workpiece material	Softwood and hardwood.
Machine	Spindle moulders with or without power feed. Four-sided moulders. Double-end tenoners.
Application	Against the feed, always along the grain.
	Mitre joint Solid wood and wood-derived materials cannot be glued on the end faces side without glue joint profiles. Compared to glue joints along the grain, mitre glue joint profiles increase the stability of the joint. These profiles have a greater profile depth, generally 10 mm. Mitre joint profiles must have a straight edge area to create a defined straight joint in the visible area. The profiles are slightly self-locking. This means the workpieces needs to be pressed together briefly and can only be machined after the glue has hardened. Mitre joints are typically used to produce segments for arched windows or profiled mouldings.
Workpiece material	Softwood and hardwood.
Machine	Spindle moulders with clamping device and sliding table. Double-end tenoners. Window machines. Stationary routers with or without CNC control.
Application	Against feed, across or along the grain.





Profile cutterhead ProfilCut Q for glue joint profiles

Application:
To cut glue joint profiles with high fit accuracy. Profile P2-4 for processing with the grain for precise positioning of the wood to be glued. Profile 1 is especially suitable for mitre joint profile/longitudinal glue joint profile and for frames.

Machine:
Spindle moulders and moulders.

Workpiece material:
Softwood and hardwood.

Technical information:
Finger profile in rounded design (softline). Effective wood use through small profile depth.

MAN feed
WE 600 1 53

P	D mm	SB mm	BO mm	BO_{max} mm	Z	n min^{-1}	ID
1	135	30	30	50	2	5700 - 9900	**125125** ●
2	135	50	30	50	2	5700 - 9900	**125126** ●
3	135	60	30	50	2	5700 - 9900	**125127** ●
3	135	60	50		2	5700 - 9900	**125390** □
4	135	80	30	50	2	5700 - 9900	**125128** ●

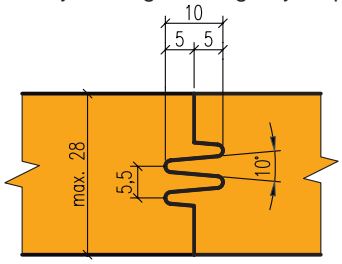
Spare knives:

Part-no.	BEZ	ABM mm	QAL	ID
1	ProfilCut Q knife	30x16x2	MC	**619237** ●
1	ProfilCut Q knife	50x16x2	MC	**619234** ●
1	ProfilCut Q knife	60x16x2	MC	**619235** ●
1	ProfilCut Q knife	80x16x2	MC	**619236**

Spare parts:

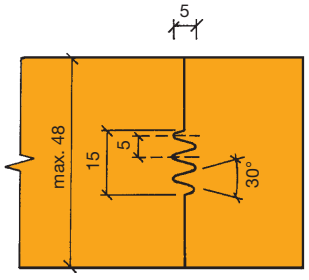
Part-no.	BEZ	ABM mm	ID
2	Clamping wedge profiled	48x23.73x8.27	**629219**
2	Clamping wedge profiled	58x23.73x8.27	**629220**
2	Clamping wedge profiled	78x23.73x8.27	**629221**
2	Clamping wedge profiled	28x23.73x8.27	**629222**
3	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
4	Torx® key	Torx® 25	**117504** ●

Mitre joint/longitudinal glue joint profile

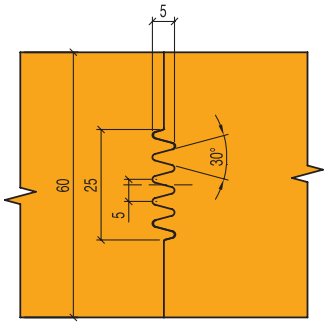


P1

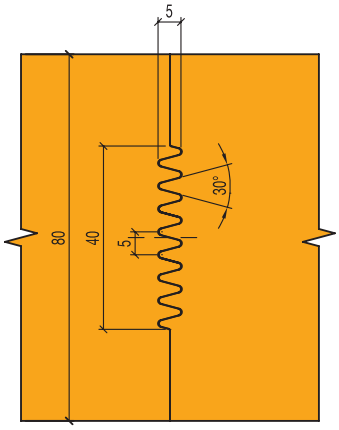
Width glue joint profile



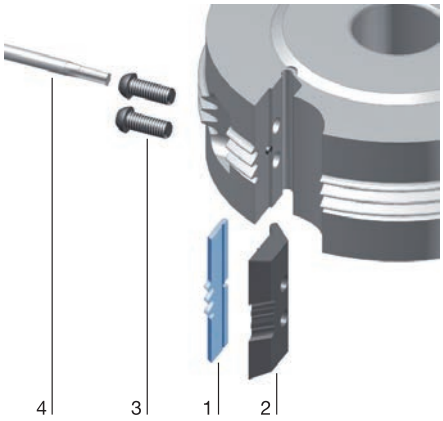
P2



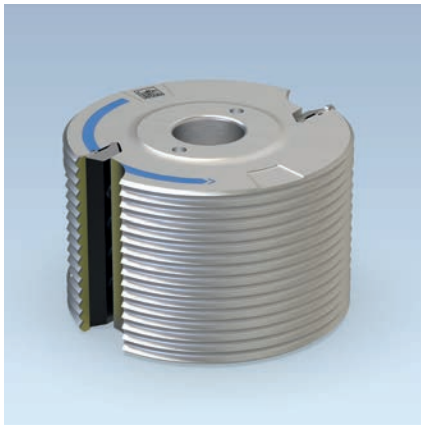
P3



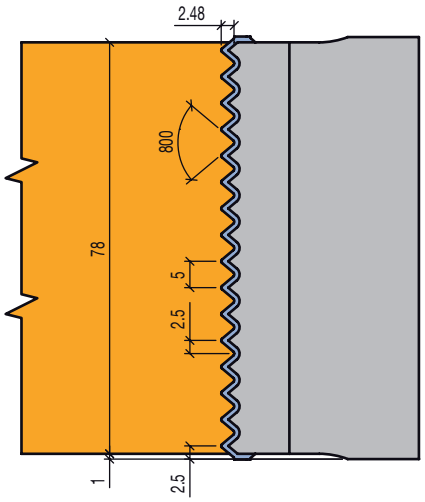
P4

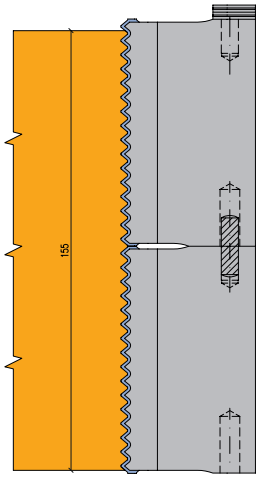


● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org









Tool stackable

Profile cutterhead ProfilCut Q for glue joint profiles

Application:
To cut glue joint profiles in fibre direction with high fit accuracy.

Machine:
Spindle moulders and moulders.

Workpiece material:
Softwood and hardwood.

Technical information:
Finger profile in rounded design (softline). Effective wood use through small profile depth.

Profile cutterhead set
SE 600 1 53

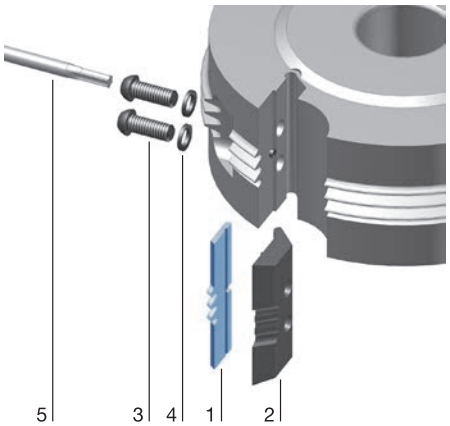
D mm	SB mm	BO mm	Z	ID
125	78	30	2	**126097** ●
125	78	50	2	**126098** ●

Spare knives:

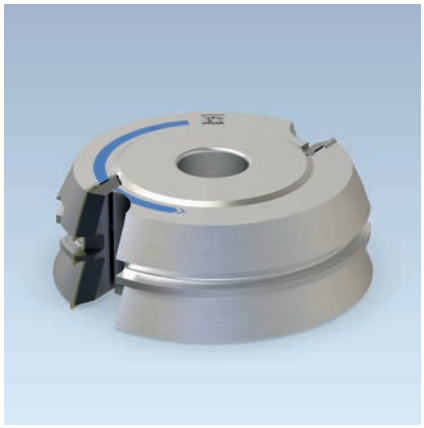
Part-no.	BEZ	ABM mm	QAL	ID
1	ProfilCut Q knife	80.2x14x2.4	MC	**619523**

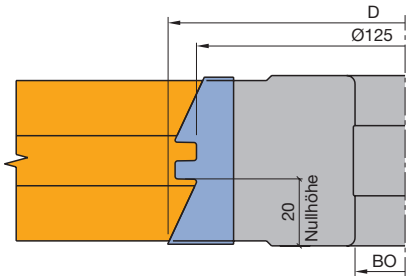
Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge profiled	78x20x8.27	**629214**
3	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
4	Torx® key	Torx® 25	**117504** ●

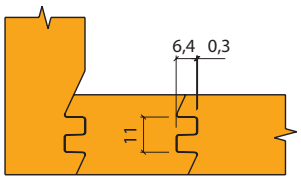


● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





Adjustment scheme



Profile example

Profile cutterhead ProfilCut Q for glue joints along the grain and mitre joints

Application:
For glue joint profiles along grain with precise positioning. Exact positioning of the wood to be glued together and for producing corner joints.

Machine:
Spindle moulders and moulders.

Workpiece material:
Softwood and hardwood, veneered panel materials.

Technical information:
Wood thickness 15 to 48 mm; basic clearance 0.3 mm, side clearance 0.1 mm. Economic wood use due to small profile depth.

Profile depth 6.4 mm
WE 600 1 53

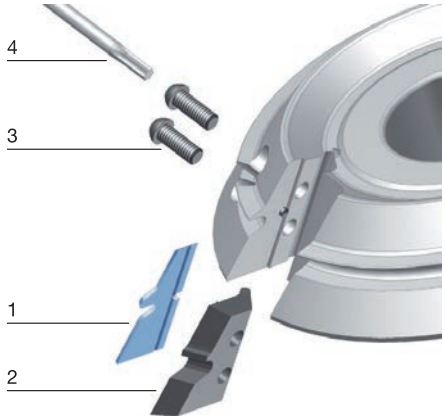
D mm	SB mm	BO mm	BO_{max} mm	Z	n min^{-1}	ID
142	50	30	50	2	5500 - 9400	**125129**

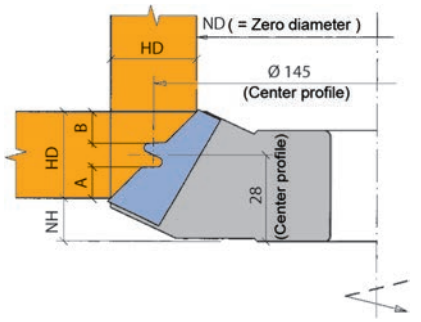
Spare knives:

Part-no.	BEZ	ABM mm	QAL	ID
1	ProfilCut Q knife	50x22x2	MC	**619238**

Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge profiled	48x31.93x8.27	**629223**
3	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
4	Torx® key	Torx® 25	**117504** ●





$$\text{0-height (NH)} = 28 - \frac{\text{wood thickness (HD)}}{2}$$

0-diameter (ND) = Ø 145 – wood thickness (HD)

Profile cutterhead ProfilCut Q for glue joints along the grain and mitre joints

Application:
For 45° glue joint profiles along grain with precise positioning. Exact positioning of the wood to be glued together and for producing corner joints.

Machine:
Spindle moulders and moulders.

Workpiece material:
Softwood and hardwood, veneered panel materials.

Technical information:
Not suitable for melamine or paper coated panel materials.

Profile cutterhead ProfilCut Q 45°
WE 610 1 53

D mm	SB mm	HD mm	BO mm	Z	BO_{max} mm	n min^{-1}	ID
175	40	28	30	2	50	4400 - 7600	**125130** ●
175	40	28	50	2	50	4400 - 7600	**125131** □

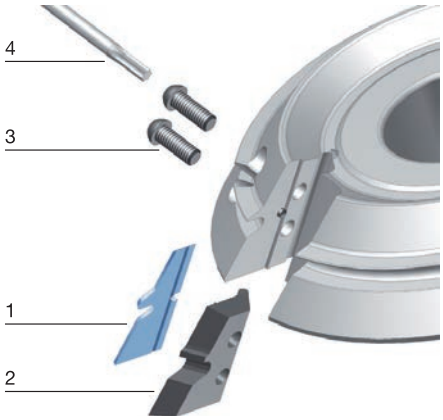
Profile adjustment
Height adjustment by profiling the workpiece flat on the table and vertical against the fence:
Profile height: PH 8.00 mm
Correct adjustment, if dimension A is the same as dimension B.
Formula: A(B) = (HD-PH) / 2

Spare knives:

Part-no.	BEZ	ABM mm	QAL	ID
1	ProfilCut Q knife	40x22x2	MC	**619239** ●

Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge profiled	38x32.11x8.27	**629224**
3	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
4	Torx® key	Torx® 25	**117504** ●

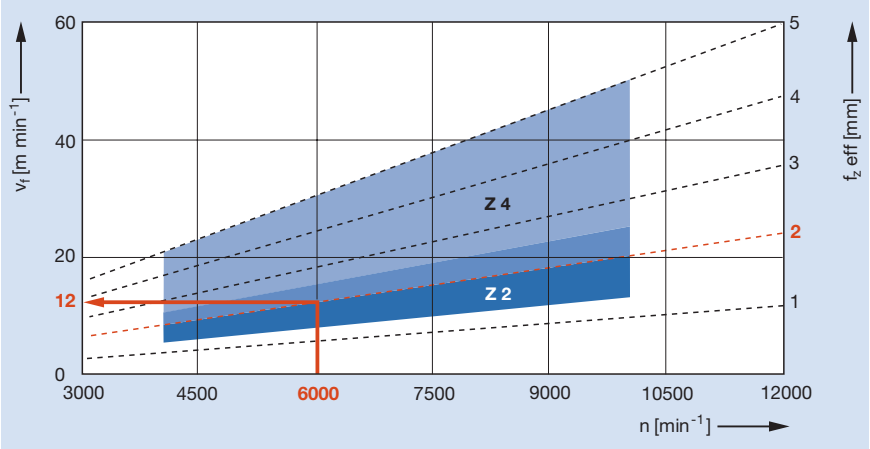


● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

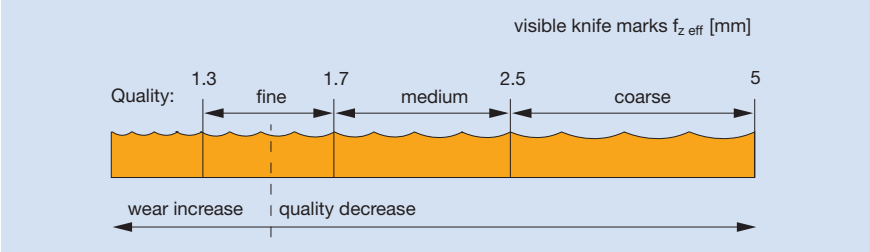
Type of operation

Profiling in craft and industry. As there are many different applications, the features of the tool and the wood types to be processed are described in the respective product pages.

Feed speeds depending on RPM, length of knife marks and number of teeth



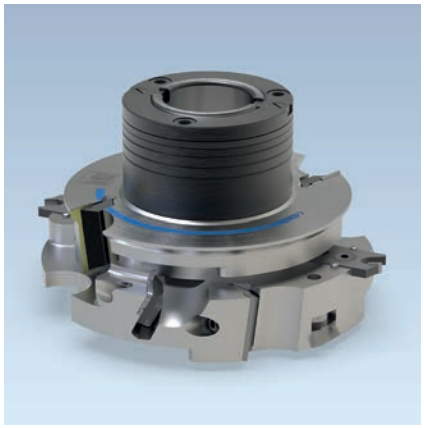
Relation between surface quality and length of knife marks $f_{z\ eff}$

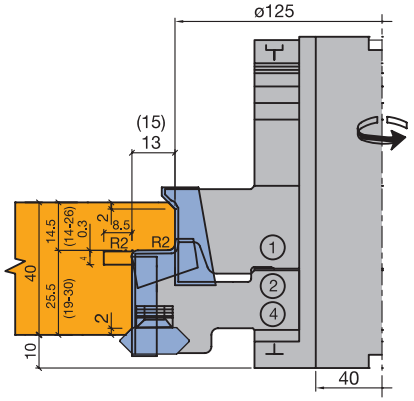


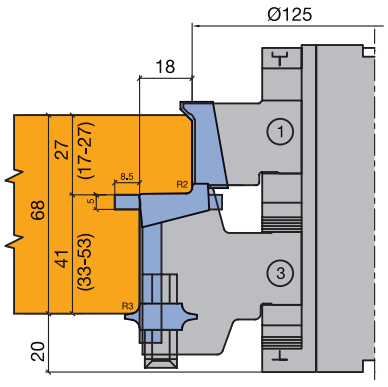
With multi blade tools, only the marks of one knife show on the surface (one knife finish).
Z 2 and Z 4 tools produce the same surface quality with the same machine setting.
High numbers of teeth are required for a high hogging performance.

Workpiece material
Machines
Application

Please refer to the relevant product pages, depending on the operation and profile.







Turnblade ProfilCut Q profile cutterhead set for internal door production

Application:
For external door profiles with single rebate, rebating depth 13/15/18 mm. Extendable for double rebate 12/15 and 15/15.

Machine:
Spindle moulders and moulders.

Workpiece material:
Softwood and hardwood.

Technical information:
Combinable for front door, single and double rebate. Double rebate profiles by using additional tools. Tool body of aluminium. ProfilCut jointing cutterhead with chamfers to edges, rebate cutterhead with turnblade knives, spurs and seatings for edge knives and seal groove knives.

Turnblade / profile cutterhead set
SE 540 1 53

BEM	Tool no.	D_0 mm	BO mm	Z	FAT mm	n_{max} min^{-1}	ID
Single rebate	1/2	125	40	2	13	7200	**126051**
Single rebate	1/4	125	40	2	15	7200	**126052**
Single rebate	1/3	125	40	2	18	7200	**126053**
Double rebate	1/4/5	125	40	2	15/12	7200	**126054**
Double rebate	1/4/6	125	40	2	15/15	7200	**126055**

Set completely mounted on VDS-sleeve.

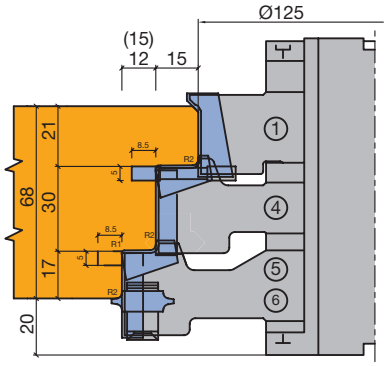
Single tools
TB 100 0 01, WE 500 1 53

BEZ	ABM mm	Tool no.	Z	ID
ProfilCut Q tool	133x30x50	1	2	**125132**
ProfilCut Q tool	151.2x35x50	2	2	**125133**
ProfilCut Q tool	161.2x54.5/58.5x50	3	2	**125134**
ProfilCut Q tool	155.2x35x50	4	2	**125135**
ProfilCut Q tool	179.2x35x50	5	2	**125136**
ProfilCut Q tool	185.2x35x50	6	2	**125137**
Reducing sleeve without collar	40x96x30			**028302** ●

Spare knives:

BEZ	ABM mm	Tool no.	QAL	ID
ProfilCut Q knife	30.2x14.1x2	1	MC	**619240**
ProfilCut Q knife	20.1x12.62x2	2	MC	**413043**
ProfilCut Q knife	25x12.76x2	3	MC	**413017**
ProfilCut Q knife	20.1x12.61x2	4	MC	**413045**
ProfilCut Q knife	20.1x11.89x2	5	MC	**413011**
ProfilCut Q knife	20.1x12.9x2	6	MC	**413015**
Turnblade knife	30x8x1.5	2/4/5/6	HW-05	**005059** ●
Edging knife 45°	KM 21/0	2/4	HW-F	**008292** ●
Edging knife R2	KM 22/3	5/6	HW-F	**008309** ●
Edging knife R3	KM 22/0	3	HW-F	**008293** ●
Turnblade grooving knife NB4	36x20x4	2/4	HW-F	**008323** ●
Turnblade grooving knife NB5	36x20x5	2 - 6	HW-F	**008324** ●

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



Spare parts:

BEZ	ABM mm	Tool no.	ID
Clamping wedge ProfilCut Q	28x20x8.27	1	**629208**
Clamping wedge ProfilCut Q	17x21.22x7.25	2/4/6	**629267**
Clamping wedge	28x18.75x8.27	2/4/5/6	**009673** ●
Clamping wedge ProfilCut Q	22x21.11x7.25	3	**629227**
Clamping wedge	48x18.75x8.27	3	**009677** ●
Clamping wedge ProfilCut Q	17x20x7.25	5	**629226**
Clamping screw w. disc, Torx® 25	M6x18.5	1 - 6	**007442** ●
Countersink screw, Torx® 20	M6x20	2/4	**006087** ●
Countersink screw, Torx® 20	M6x40	3	**006090** ●
Countersink screw, Torx® 20	M6x25	5/6	**006088** ●
Countersink screw, Torx® 20	M6x12	2 - 6	**006084** ●
Cylindrical screw with ISK	M6x93		**007834** ●
Torx® key	Torx® 25	1 - 6	**117504** ●
Torx® key	Torx® 20	1 - 6	**117503** ●
Allen key	SW 5		**005452** ●

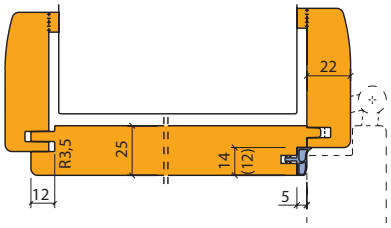
R 1,5 = ID **619391**
R 2,0 = ID **619392**
R 3,0 = ID **619393**
R 4,0 = ID **619394**
R 5,0 = ID **619395**

ID **619396**

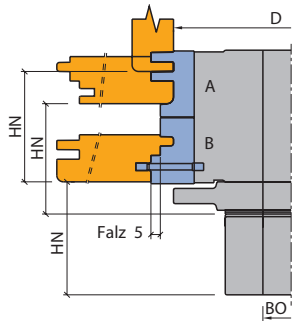
ID **619397**

ID **184008678**
Cut-out for DP edging knives on request





Door lining profile



Lining/decorative panel and rebate lining

Profile cutterhead ProfilCut Q

Application:
For door casing and door linings with 5 mm rebate.

Machine:
Spindle moulders and moulders.

Workpiece material:
Softwood and hardwood, uncoated, plastic coated and veneered chipboard and fibre materials.

Technical information:
Material thickness: 24 to 27 mm (option up to 32 mm with jointing). Seal 14 and 12 mm possible by fitting spacers. Adjustable rebate of 5 mm or 4 mm by changeable profile knives. Rebate 7 mm, 8 mm and 11 mm on request.

Rebate 5 mm
SE 640 1 53

Tool Type	D mm	BO mm	BO_{max} mm	Z	FAT mm	n min^{-1}	ID
With jointing and rounding	125	30	50	2	5	5100 - 8800	**126056** ●
Without jointing and rounding	125	30	50	2	5	5100 - 8800	**126057**

Rebate 4 mm
SE 640 1 53

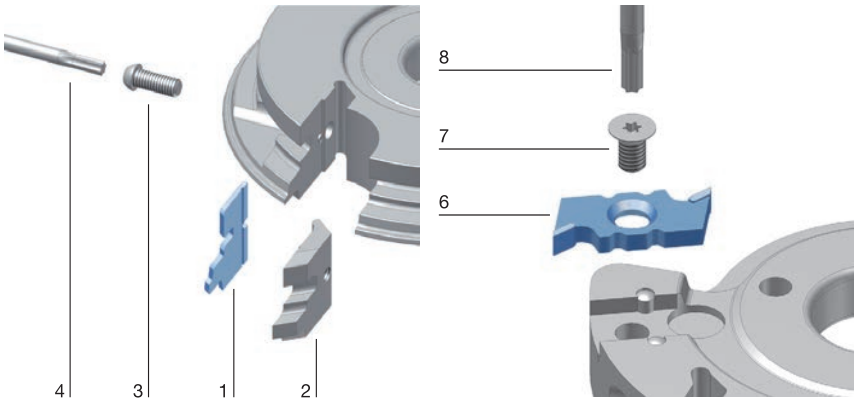
Tool Type	D mm	BO mm	BO_{max} mm	Z	FAT mm	n min^{-1}	ID
With jointing and rounding	125	30	50	2	4	5100 - 8800	**126058**
Without jointing and rounding	125	30	50	2	4	5100 - 8800	**126059**

Spare knives:

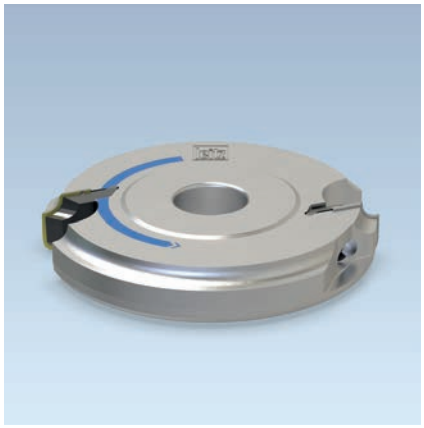
Part-no.	BEZ	ABM mm	QAL	ID
1	ProfilCut Q knife A for jointing	35x22.75x2	MC	**619241**
1	ProfilCut Q knife B 5 mm rebate	35x23.82x2	MC	**619242**
1	ProfilCut Q knife A without jointing	35x22.75x2	MC	**619243**
1	ProfilCut Q knife B 4 mm rebate	35x23.29x2	MC	**619244**
6	Turnblade grooving knife NB4	36x20x4	HW-F	**008323** ●

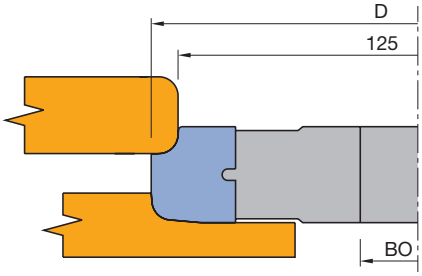
Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge A	33x27.89x8.27	**629229**
2	Clamping wedge B	33x32.72x2	**629230**
3	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
4	Torx® key	Torx® 25	**117504** ●
7	Countersink screw, Torx® 20	M6x12	**006084** ●
8	Torx® key	Torx® 20	**117503** ●



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





Radii profile cutterhead

Profile cutterhead ProfilCut Q

Application:
For different radii profiles with different profile knives. Copy shaping of curved workpieces using template and ball bearing guide ring.

Machine:
Spindle moulders and moulders.

Workpiece material:
Softwood and hardwood.

Technical information:
Production of counter profile possible by combining with the fluting profile.
Tool can be used on both sides as panel raising cutter (straight panel raising).

Radii profile R 2; 3; 5; 7 mm
WE 500 1 53

R mm	D mm	SB mm	BO mm	BO_{max} mm	Z	n min^{-1}	ID
5	139	25	30	50	2	5500 - 9600	**125387** ●

Radii profile R 12; 15; 16; 18; 20 mm
WE 500 1 53

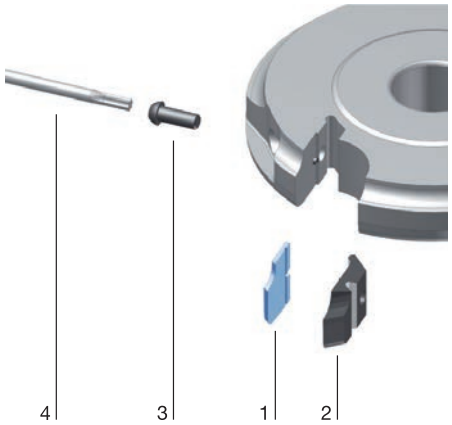
R mm	D mm	SB mm	BO mm	BO_{max} mm	Z	n min^{-1}	ID
12	167	40	30	50	2	4600 - 10200	**125391** ●

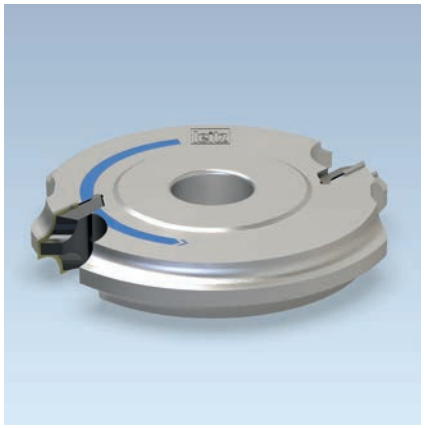
Spare knives:

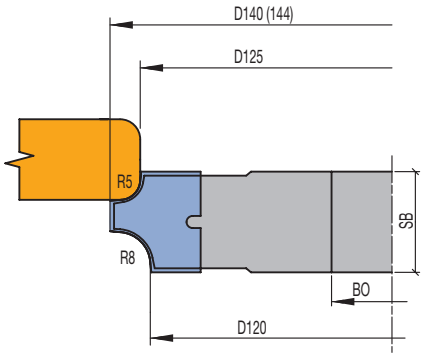
R mm	Part-no.	BEZ	ABM mm	QAL	ID
2	1	ProfilCut Q knife	25x25x2.4	MC	**619504**
3	1	ProfilCut Q knife	25x25x2.4	MC	**619505**
5	1	ProfilCut Q knife	25x25x2.4	MC	**619501**
7	1	ProfilCut Q knife	25x25x2.4	MC	**619502**
12	1	ProfilCut Q knife	40x32.6x2.4	MC	**619516**
15	1	ProfilCut Q knife	40x32.6x2.4	MC	**619517**
16	1	ProfilCut Q knife	40x32.6x2.4	MC	**619518**
18	1	ProfilCut Q knife	40x32.6x2.4	MC	**619519**
20	1	ProfilCut Q knife	40x32.6x2.4	MC	**619520**

Spare parts:

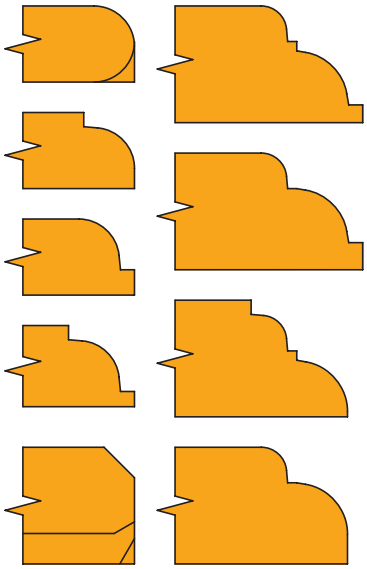
Part-no.	BEZ	ABM mm	ID
2	Clamping wedge profiled	23x35.5x8.27	**629458**
2	Clamping wedge profiled	38x43x8.27	**629460**
3	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
4	Torx® key	Torx® 25	**117504** ●







Profile cutterhead D-140(144) mm



Left = 1 working step
Right = 2 working steps

Profile cutterhead set ProfilCut Q - radii profile

Application:
For different radii profiles with different profile knives. Copy shaping of curved workpieces using template and ball bearing guide ring.

Machine:
Spindle moulders and moulders.

Workpiece material:
Softwood and hardwood.

Technical information:
Cutterhead with changing knives R 5/8, R 6/9, R 7/10, R 3/12, bevelling knives 30/45/60° and axially parallel knives. For cutting radii and dowel profiles as well as bevelling and copy-shaping of curved workpieces using templates.

Radii profile R 5 - 12 mm or 30/45/60° bevel
AE 540 1 53

exist. of	D mm	SB mm	BO mm	BO_{max} mm	R mm	Z	ID
Profile cutterhead	140	25	30	50		2	**126546** ●
Radius knife					5/8		
Radius knife					6/9		
Radius knife					7/10		
Radius knife					3/12		
Bevel knife					30/45/60°		

Set completely in wooden box including radii/bevel knives.
Standard values for feed speed v_f at speed n = 6000 min^{-1}:
Machining along grain: 8 to 10 m min^{-1}.
Machining across grain: 3 to 5 m min^{-1}.
RPM: n = 5400 - 9200 min^{-1}
Zero diameter: 120/125 mm

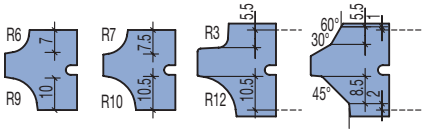
Spare knives:

Part-no.	BEZ	ABM mm	QAL	R mm	FAW °	ID
1	ProfilCut Q knife	25x22x2	MC	5/8		**619445**
1	ProfilCut Q knife	25x22x2	MC	6/9		**619446**
1	ProfilCut Q knife	25x22x2	MC	7/10		**619447**
1	ProfilCut Q knife	29x24.17x2	MC	3/12		**619448**
1	ProfilCut Q knife	29x24.17x2	MC		30/45/60°	**619449**

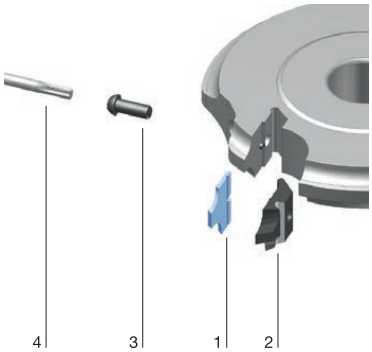
Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge	23x32.5x8.27	**629286** ●
3	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
4	Torx® key	Torx® 25	**117504** ●

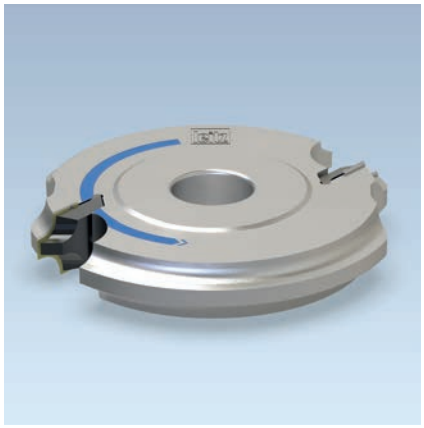
Ball bearing and guide rings - see Lexicon section Knives and Spare Parts.



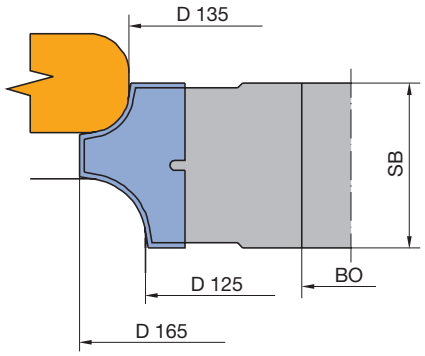
Profile knives radius / bevel



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







Profile cutterhead D-165 mm

Profile cutterhead ProfilCut Q

Application:
For radii and bevel profiles with different profile knives. Copy shaping of curved workpieces using template and ball bearing guide ring.

Machine:
Spindle moulders and moulders.

Workpiece material:
Softwood and hardwood.

Technical information:
Cutterhead with change knives and straight cut. Multi-purpose application for different profiles.

Radii profile R 12 - 20 mm or 45° bevel
WE 500 1 53

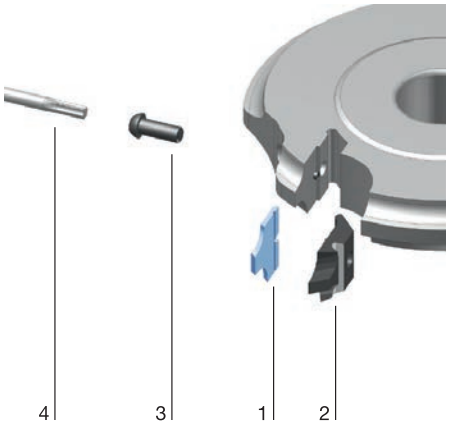
D mm	SB mm	BO mm	BO_{max} mm	Z	R mm	n min^{-1}	ID
165	50	30	50	2	12/18	5500 - 5900	**125388** ●

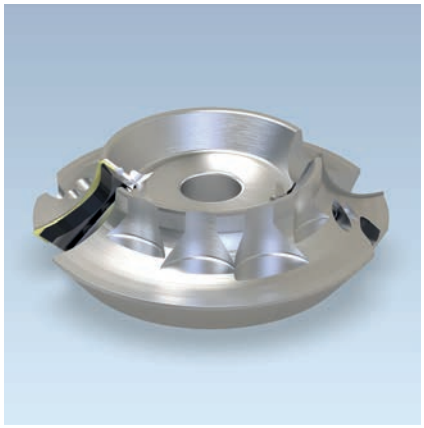
Spare knives:

Part-no.	BEZ	ABM mm	QAL	R mm	FAW °	ID
1	ProfilCut Q knife	50x33.8x2.4	MC	12/18		**619512**
1	ProfilCut Q knife	50x33.8x2.4	MC	14/20		**619513**
1	ProfilCut Q knife	50x33.8x2.4	MC		45	**619514**

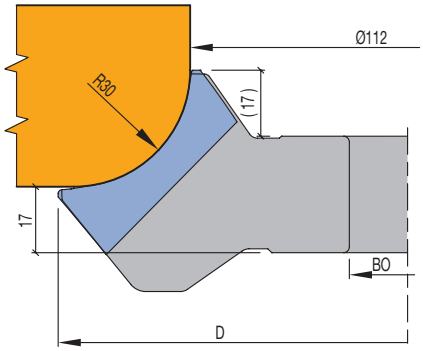
Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge profiled	48x43.5x8.27	**629099**
3	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
4	Torx® key	Torx® 25	**117504** ●

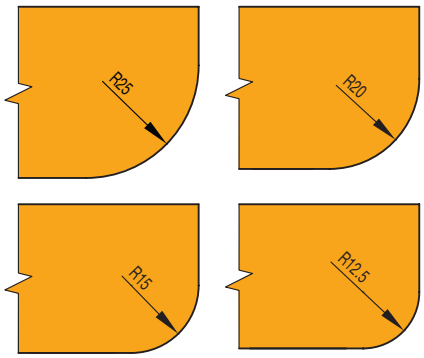








Profile cutterhead D-180 mm



Profile cutterhead ProfilCut Q

Application:
For different radii profiles with different profile knives. Copy shaping of curved workpieces using template and ball bearing guide ring.

Machine:
Spindle moulders and moulders.

Workpiece material:
Softwood and hardwood.

Technical information:
Height and diameter adjustment through recess in the tool basic body per radius. Cutterhead extendable for radii R 12.5 - 30 mm. Replacement knives for dowel cuts on request.

Radii profile R 12.5 - 30 mm
WE 500 1 53

D	SB	BO	BO_{max}	D_0	Z	R	n	ID
mm	mm	mm	mm	mm		mm	min^{-1}	
180	32	30	50	112	2	30	4300 - 7400	**125359** ●

For ball bearings and guide rings see section Knives and Spare Parts.

Standard values for feed speed v_f:
Machining along grain: 8 to 10 m min^{-1}
Machining across grain: 3 to 5 m min^{-1}
at speed n = 6000 min^{-1}.

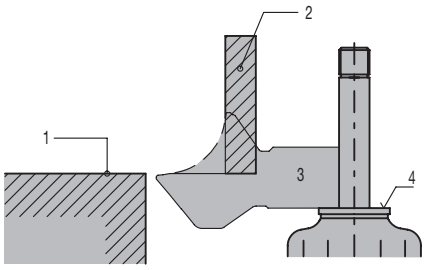
Spare knives:

Part-no.	BEZ	ABM	QAL	R	ID
		mm		mm	
1	ProfilCut Q knife	50x22x2	MC	12.5	**619431**
1	ProfilCut Q knife	50x22x2	MC	15	**619432**
1	ProfilCut Q knife	50x22x2	MC	20	**619433**
1	ProfilCut Q knife	50x22x2	MC	25	**619434**
1	ProfilCut Q knife	50x22x2	MC	30	**619430**

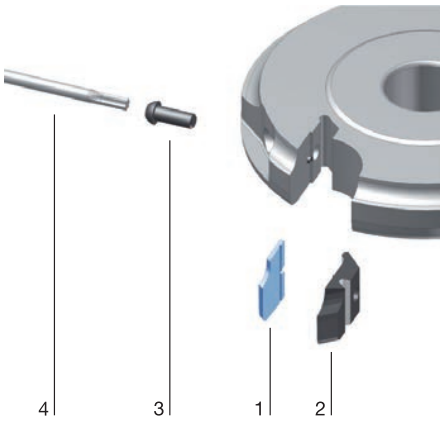
Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge profiled	48x29x8.27	**629284** □
3	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
4	Torx® key	Torx® 25	**117504** ●

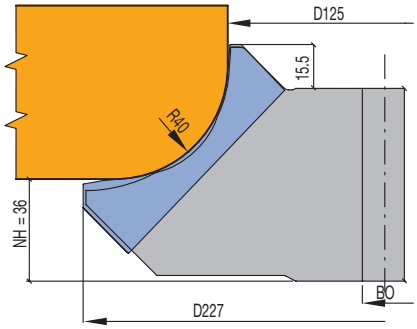
Machine adjustment by recessing the tool.



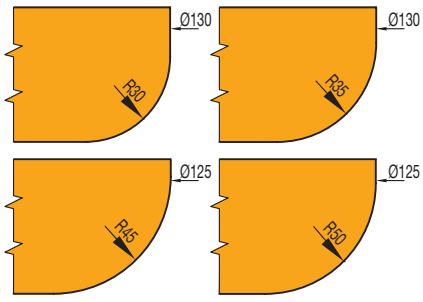
1 = Machine table
2 = Guide
3 = Tool
5 = Spindle



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



Profile cutterhead D-227 mm



Profile cutterhead ProfilCut Q

Application:
For different radii profiles with 10 different profile knives. Copy shaping of curved workpieces using template and ball bearing guide ring.

Machine:
Spindle moulders and moulders.

Workpiece material:
Softwood and hardwood.

Technical information:
Height and diameter adjustment through recess in the tool basic body. Cutterhead extendable for radii R 30 - 50 mm. Replacement knives for dowel cuts on request.

Radii profile R 30 - 50 mm
AE 540 1 53

D mm	SB mm	BO mm	BO_{max} mm	D_0 mm	Z	R mm	n min^{-1}	ID
227	57	30	50	125	2	40	3400 - 7500	**125360** ●

For ball bearings and guide rings see section Knives and Spare Parts.

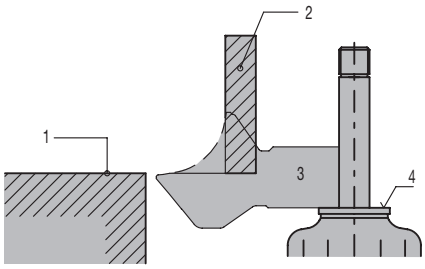
Spare knives:

Part-no.	BEZ	ABM mm	QAL	R mm	ID with relief angle	ID without relief angle
1	ProfilCut Q knife	80.1x30.78x2	MC	30	**619436**	**619440**
1	ProfilCut Q knife	80.1x30.56x2	MC	35	**619437**	**619441**
1	ProfilCut Q knife	80.1x31.08x2	MC	40	**619435**	**619442**
1	ProfilCut Q knife	80.1x29.98x2	MC	45	**619438**	**619443**
1	ProfilCut Q knife	80.1x29.56x2	MC	50	**619439**	
1	ProfilCut Q knife	80.1x29.66x2	MC	50		**619444**

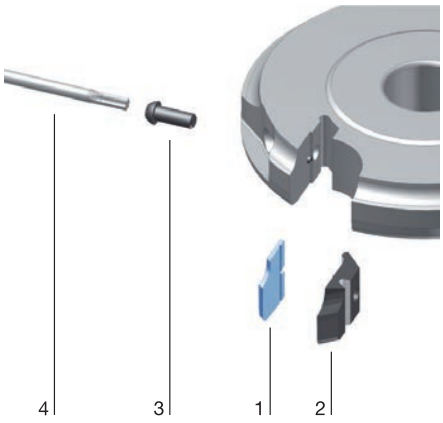
Spare parts:

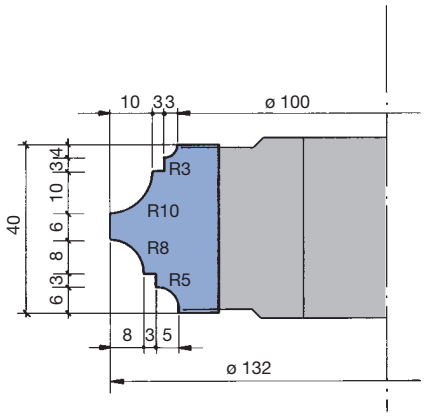
Part-no.	BEZ	ABM mm	ID
2	Clamping wedge ProfilCut	78x39x8.27	**629285** □
3	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
4	Torx® key	Torx® 25	**117504** ●

Machine adjustment by recessing the tool.



1 = Machine table
2 = Fence
3 = Tool
5 = Spindle





Profile cutterhead ProfilCut Q

Application:
For radii and counter profiles. Copy shaping of curved workpieces using template and ball bearing guide ring.

Machine:
Spindle moulders and moulders etc.

Workpiece material:
Softwood and hardwood.

Technical information:
Cutterhead with change knives, straight cut. Multi-purpose use for different profiles in one or several working steps.

Radii profile R 3 - 10 mm
WE 500 1 53

D mm	SB mm	BO mm	BO_{max} mm	Z	n min^{-1}	ID
132	40	30	40	2	5900 - 10100	**125389** ●

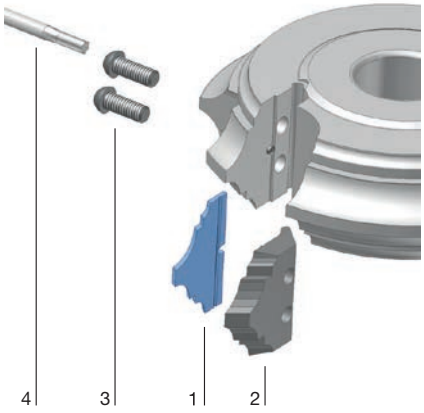
Standard values for feed speed v_f:
Machining along grain: 8 to 10 m min^{-1}
Machining across grain: 3 to 5 m min^{-1}
at speed n = 6000 min^{-1}
For ball bearings and guide rings see section Knives and Spare Parts.

Spare knives:

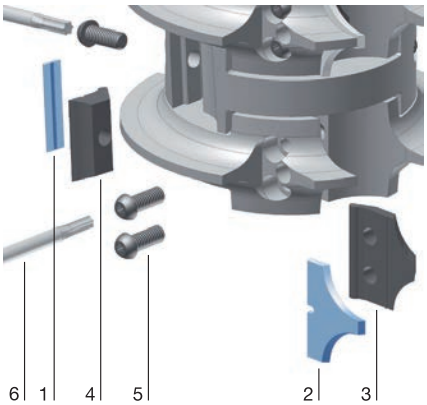
Part-no.	BEZ	ABM mm	QAL	ID
1	ProfilCut Q knife	40.2x28.5x2.4	MC	**619515**

Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge profiled	38x34.5x8.27	**629459**
3	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
4	Torx® key	Torx® 25	**117504** ●



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



Profile cutterhead set ProfilCut Q - bevelling / rounding

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

Machine:
Spindle moulders, copy shaping and profile moulders.

Workpiece material:
Softwood and hardwood.

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

Manual feed
SE 541 1 53

Tool Type	D_0 mm	AW PCS	n min^{-1}	Z	ID
Jointing-rounding	125	2	4200 - 7100	2	**126060**
Rounding-jointing-rounding	125	3	4200 - 7100	2	**126061**
Rounding-rounding	125	2	4200 - 7100	2	**126062**

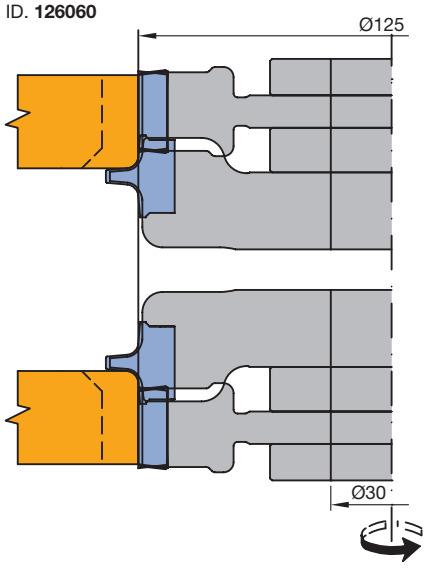
Further radii are available at short notice.

Spare parts:

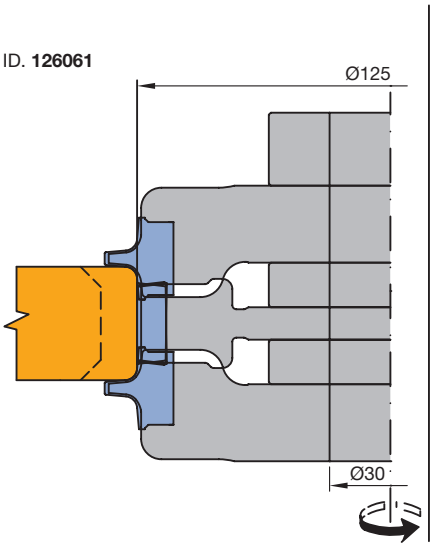
Part-no.	BEZ	ABM mm	Tool no.	ID
3	Clamping wedge	18x22x8.27	1/2/11/12	**629231**
3	Clamping wedge	33x28x8.27	3/4/13/14	**629232**
3	Clamping wedge	38x29.71x8.27	5/15	**629233**
3	Clamping wedge	38x29.71x8.27	6/16	**629234**
3	Clamping wedge	48x31.73x8.27	7/17	**629235**
3	Clamping wedge	48x31.73x8.27	8/18	**629236**
4	Clamping wedge	18x18.75x8.27	20	**009671** ●
4	Clamping wedge	33x18.75x8.27	35	**009674** ●
4	Clamping wedge	48x18.75x8.27	50	**009677** ●
5	Clamping screw w. disc, Torx® 25	M6x18.5		**007442** ●
6	Torx® key	Torx® 25		**117504** ●

Part nos. 1 and 2 - ProfilCut Q and turnblade knives - see detailed information on the following pages.

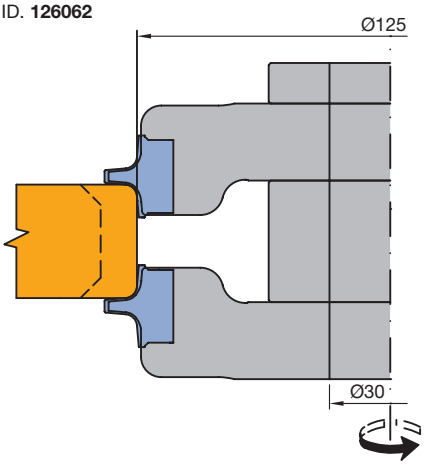
ID. **126060**



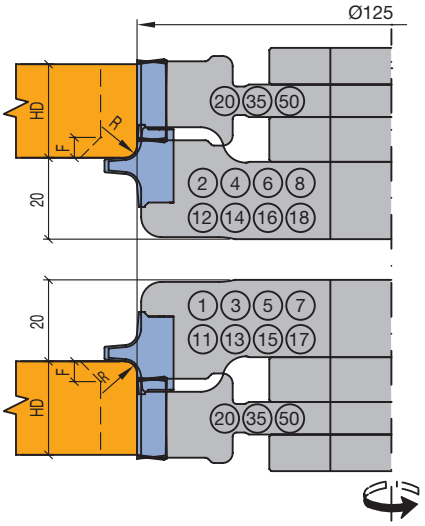
ID. **126061**



ID. **126062**



ID. 126060



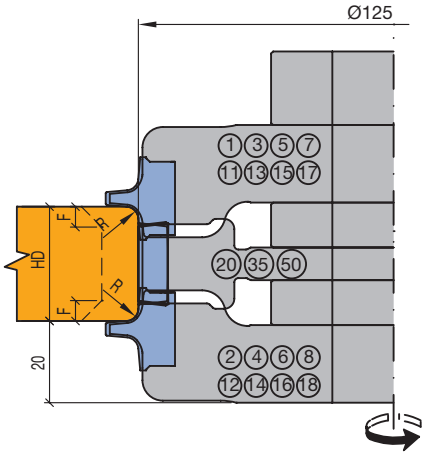
Order example:
-Combination ID 126060
-Profile description top down RL
jointingSB35/R5 or R5/jointingSB35
-Bore diameter 30

Wood thickness (HD):

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

F (bevel) max. = 3, 5, 7x45° or 8x40°

ID. 126061



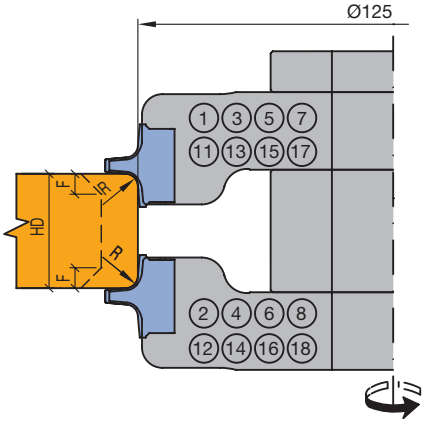
Order example:
-Combination ID 126061
-Profile description top down RL
R5/jointingSB35/R5
-Bore diameter 30

Radii tools	Jointing tool 20	35	50
No.1(11)+2(12)	6	12	24
No.1(11)+4(14)	13	19	31
No.1(11)+6(16)	18	24	36
No.1(11)+8(18)	28	34	46
No.3(13)+2(12)	13	19	31
No.3(13)+4(14)	20	26	38
No.3(13)+6(16)	25	31	43
No.3(13)+8(18)	35	41	53
No.5(15)+2(12)	18	24	36
No.5(15)+4(14)	25	31	43
No.5(15)+6(16)	30	36	48
No.5(15)+8(18)	40	46	58
No.7(17)+2(12)	28	34	46
No.7(17)+4(14)	35	41	53
No.7(17)+6(16)	40	46	58
No.7(17)+8(18)	50	56	68
max. HD	18+R+R (F+F)	33+R+R (F+F)	48+R+R (F+F)

Minimum wood thickness

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

ID. 126062



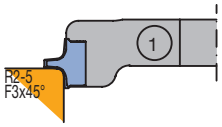
Order example:
-Combination ID 126062
-Profile description top down RL
R5/R5
-Bore diameter 30

Radii tools	
No.1(11)+2(12)	-2
No.1(11)+4(14)	5
No.1(11)+6(16)	10
No.1(11)+8(18)	20
No.3(13)+2(12)	5
No.3(13)+4(14)	12
No.3(13)+6(16)	17
No.3(13)+8(18)	27
No.5(15)+2(12)	10
No.5(15)+4(14)	17
No.5(15)+6(16)	22
No.5(15)+8(18)	32
No.7(17)+2(12)	20
No.7(17)+4(14)	27
No.7(17)+6(16)	32
No.7(17)+8(18)	42

Minimum wood thickness

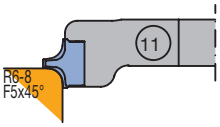
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

Spare part: clamping wedge 629231



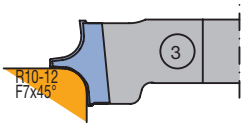
WZ 125375 / ME 619245	R2	
WZ 125138 / ME 619246	R3	
WZ 125139 / ME 619247	R4	
WZ 125140 / ME 619248	R5	
WZ 125141 / ME 619252	F3x45°	

Spare part: clamping wedge 629231



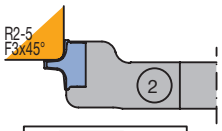
WZ 125146 / ME 619249	R6	
WZ 125147 / ME 619250	R7	
WZ 125148 / ME 619251	R8	
WZ 125149 / ME 619253	F5x45°	

Spare part: clamping wedge 629232



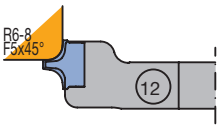
WZ 125154 / ME 619254	R10	
WZ 125155 / ME 619255	R11	
WZ 125156 / ME 619256	R12	
WZ 125157 / ME 619261	F7x45°	

Spare part: clamping wedge 629231



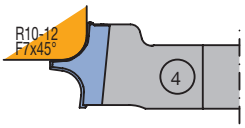
WZ 125376 / ME 619245	R2	
WZ 125142 / ME 619246	R3	
WZ 125143 / ME 619247	R4	
WZ 125144 / ME 619248	R5	
WZ 125145 / ME 619252	F3x45°	

Spare part: clamping wedge 629231



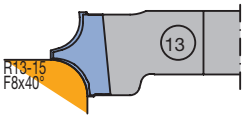
WZ 125150 / ME 619249	R6	
WZ 125151 / ME 619250	R7	
WZ 125152 / ME 619251	R8	
WZ 125153 / ME 619253	F5x45°	

Spare part: clamping wedge 629232



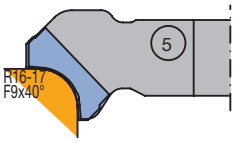
WZ 125158 / ME 619254	R10	
WZ 125159 / ME 619255	R11	
WZ 125160 / ME 619256	R12	
WZ 125161 / ME 619261	F7x45°	

Spare part: clamping wedge 629232



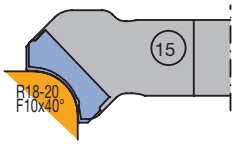
WZ 125162 / ME 619257	R13	
WZ 125163 / ME 619258	R14	
WZ 125164 / ME 619259	R15	
WZ 125165 / ME 619262	F8x40°	

Spare part: clamping wedge 629233



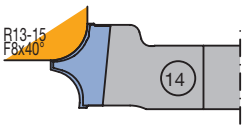
WZ 125170 / ME 619263	R16	
WZ 125171 / ME 619264	R17	
WZ 125172 / ME 619269	F9x40°	

Spare part: clamping wedge 629233



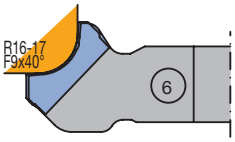
WZ 125176 / ME 619265	R18	
WZ 125177 / ME 619266	R19	
WZ 125178 / ME 619267	R20	
WZ 125179 / ME 619270	F10x40°	

Spare part: clamping wedge 629232



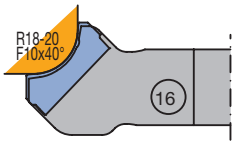
WZ 125166 / ME 619257	R13	
WZ 125167 / ME 619258	R14	
WZ 125168 / ME 619259	R15	
WZ 125169 / ME 619262	F8x40°	

Spare part: clamping wedge 629234



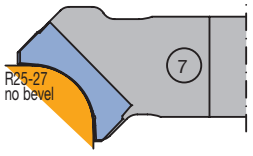
WZ 125173 / ME 619271	R16	
WZ 125174 / ME 619272	R17	
WZ 125175 / ME 619277	F9x40°	

Spare part: clamping wedge 629234



WZ 125180 / ME 619273	R18	
WZ 125181 / ME 619274	R19	
WZ 125182 / ME 619275	R20	
WZ 125183 / ME 619278	F10x40°	

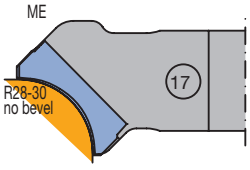
Spare part: clamping wedge 629235



WZ 125184 / ME 619279	R25	
WZ 125185 / ME 619280	R26	
WZ 125186 / ME 619281	R27	

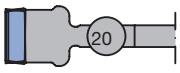
Spare part: clamping wedge 629235

ME



WZ 125190 / ME 619282	R28	
WZ 125191 / ME 619283	R29	
WZ 125192 / ME 619284	R30	

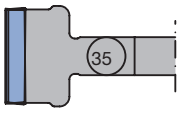
SB 20



WZ 23015 / ME 5071 / VE 10 pcs.)

Wedge 9671

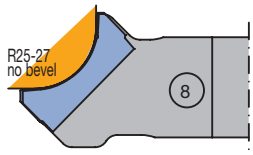
SB 35



WZ 23016 / ME 5073 / VE 10 pcs.)

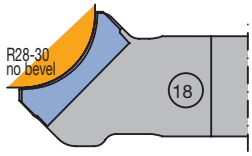
Wedge 9674

Spare part: clamping wedge 629236



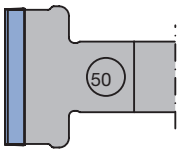
WZ 125187 / ME 619285	R25	
WZ 125188 / ME 619286	R26	
WZ 125189 / ME 619287	R27	

Spare part: clamping wedge 629236



WZ 125193 / ME 619288	R28	
WZ 125194 / ME 619289	R29	
WZ 125195 / ME 619290	R30	

SB 50



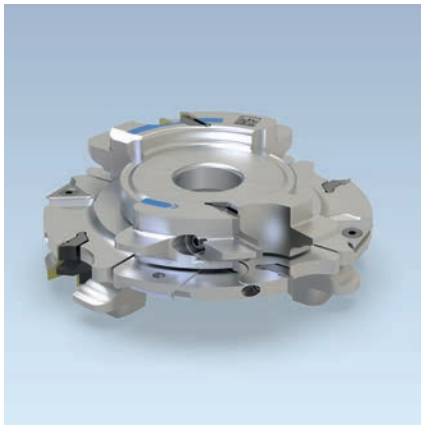
WZ 23017 / ME 5075 / VE 10 pcs.)

Wedge 9677

60x20x30

Spacer set
(one set per cutterhead necessary)

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



Profile cutterhead ProfilCut Q for internal doors

Application:
For internal door profiles and counter profiles.

Machine:
Spindle moulders and moulders.

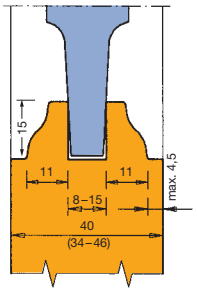
Workpiece material:
Softwood and hardwood.

Technical information:
Cutterhead with change knives, straight cut.

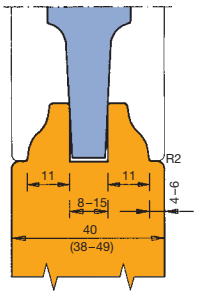
Tool combination DOUBLE profile with jointing
AE 341 1 53, AW 341 1

Tool Type	Tool no.	BO mm	BO_{max} mm	ID
Profile 1 (P2-P5 on request)	1/2/3	30	50	**126532** ●
Profile 1.1 (P2.1-P5.1 on request)	1/2/3/4/5	30	50	**126533**
Profile 6/7	2/4/5/6/7	30	50	**126534**
Profile 6.1/7	2/4.1/5.1/6/7	30	50	**126535**
Profile 8	2/8/9/10	30	50	**126536**
Profile 8.1	2/8.1/9.1/10	30	50	**126537**
Addition for rebates and/or one side	15/16	30	50	**126538**

Combinations complete in wooden boxes.



Profile P 1 closed joint



Profile P 1.1 with open joint

Single tools
SW 501 1, WE 500 1 53, WW 200 1 NN, WW 210 1 NN, WW 410 1 NN

Tool Type	Tool no.	D mm	SB mm	BO mm	ID
Profile cutterhead *	1	155	25	30	**125250** ●
Grooving cutterhead	2	155.2	8 - 15	30	**125089** ●
Profile cutterhead	3	155	25	30	**125251** ●
Profile cutterhead	4	161	30	30	**125252**
Profile cutterhead	5	161	30	30	**125253**
Profile cutterhead	6	155.1	25	30	**125254**
Profile cutterhead	7	155.1	25	30	**125255**
Profile cutterhead	8	165	25	30	**125256**
Profile cutterhead bevel	8.1	165	25	30	**125257**
Profile cutterhead	9	165	25	30	**125258**
Profile cutterhead bevel	9.1	165	25	30	**125259**
Jointing cutterhead	10	125	15	30	**125013**
Rebating cutterhead	15	155	35	30	**125018**
Jointing cutterhead	16	125	30	30	**125019**

* = Profile cutterheads supplied with profile P1.

Spare knives:

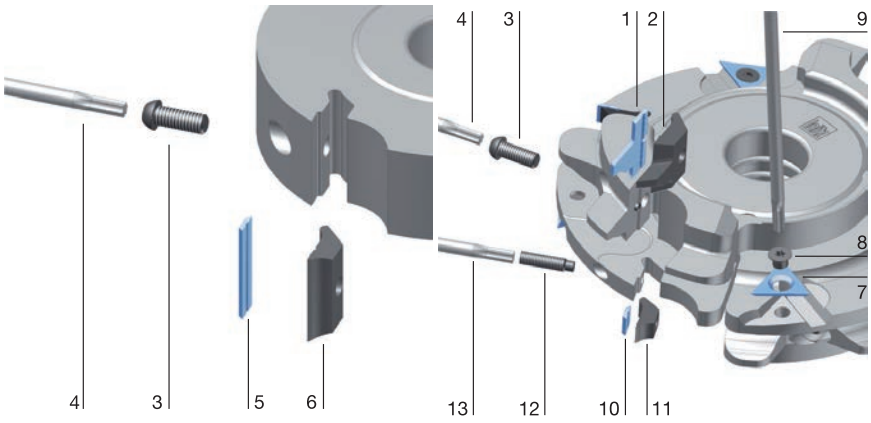
Part-no.	BEZ	ABM mm	P	Tool no.	QAL	VE PCS	ID
1	ProfilCut Q knife	25x27x2	1	1	MC		**619291**
1	ProfilCut Q knife	25x27x2	2	1	MC		**619292**
1	ProfilCut Q knife	25x27x2	3	1	MC		**619293**
1	ProfilCut Q knife	25x27x2	4	1	MC		**619294**
1	ProfilCut Q knife	25x27x2	5	1	MC		**619295**
1	ProfilCut Q knife	25x27x2	1	1	MC		**619296**
1	ProfilCut Q knife	25x27x2	2	3	MC		**619297**
1	ProfilCut Q knife	25x27x2	3	3	MC		**619298**
1	ProfilCut Q knife	25x27x2	4	3	MC		**619299**
1	ProfilCut Q knife	25x27x2	5	3	MC		**619300**
1	ProfilCut Q knife	30x31x2	6/7	3	MC		**619301**
1	ProfilCut Q knife	30x31x2	6/7	5	MC		**619302**
1	ProfilCut Q knife	25x27x2	6/6.1/7	6	MC		**619303**
1	ProfilCut Q knife	25x27x2	6/6.1/7	7	MC		**619304**
1	ProfilCut Q knife	25x32x2	8	8	MC		**619305**
1	ProfilCut Q knife	25x32x2	8.1	8.1	MC		**619306**

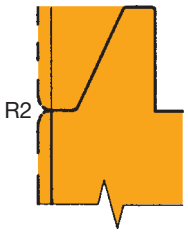
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

Part-no.	BEZ	ABM mm	P	Tool no.	QAL	VE PCS	ID
1	ProfilCut Q knife	25x32x2	8	9	MC		**619307**
1	ProfilCut Q knife	25x32x2	8.1	9.1	MC		**619308**
5	Turnblade knife	14.7x8x1.5		10	HW-30F	10	**005070** ●
5	Turnblade knife	30x8x1.5		16	HW-30F	10	**005072** ●
5	Turnblade knife	35x8x1.5		15	HW-30F	10	**005073** ●
7	Turnblade spur VS2	19x19x2		2/5	HW-F	10	**005115** ●
10	Turnblade knife	7.7x8x1.5		2	HW-30F	10	**005068** ●

Spare parts:

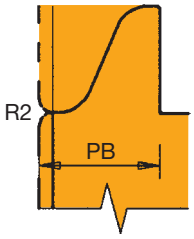
Part-no.	BEZ	ABM mm	P	Tool no.	ID
2	Clamping wedge profiled	23x30x8.27		3	**629237**
2	Clamping wedge profiled	23x30x8.27		1	**629238**
2	Clamping wedge profiled	28x38x8.27	6/6.1/7	4/4.1	**629239**
2	Clamping wedge profiled	28x38x8.27	6/6.1/7	5/5.1	**629240**
2	Clamping wedge profiled	23x37.32x8.27	6/6.1/7	6	**629241**
2	Clamping wedge profiled	23x37.32x8.27	6/6.1/7	7	**629242**
2	Clamping wedge profiled	23x37.2x8.27	8/8.1	8/8.1	**629243**
2	Clamping wedge profiled	23x37.2x8.27	8/8.1	9/9.1	**629244**
3	Clamping screw w. disc, Torx® 25	M6x18.5			**007442** ●
4	Torx® key	Torx® 25			**117504** ●
6	Clamping wedge	13x18.75x8.27		6	**009670** ●
6	Clamping wedge	28x18.75x8.27	1/2/16	4	**009673** ●
6	Clamping wedge	33x18.75x8.27	15	5	**009674** ●
8	Countersink screw, Torx® 20	M6x0.5x4.9			**006243** ●
9	Torx® key	Torx® 20			**117503** ●
11	Clamping wedge	7x18.75x8.27	2	2	**009763** ●
12	Allen screw with shank, Torx® 15	M5x20			**007380** ●
13	Torx® key	Torx® 15			**117507** ●
	Magnetic setting gauge	0.3/0.8			**005376** ●



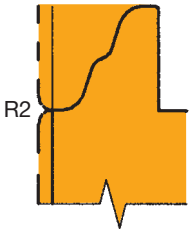


P2/P2.1

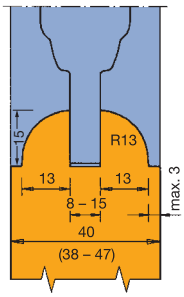
P3/P3.1



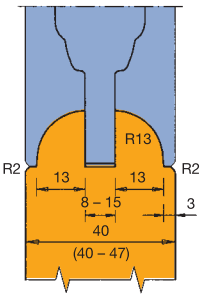
P4/P4.1



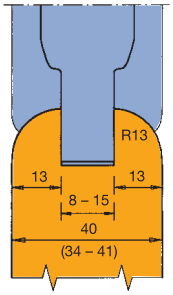
P5/P5.1



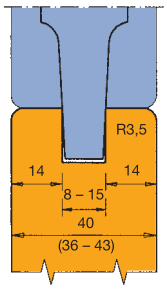
P6



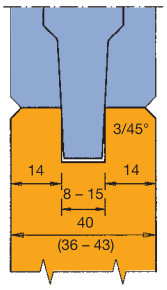
P6.1



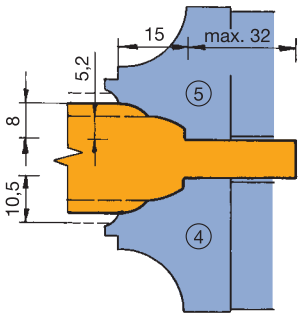
P7



P8

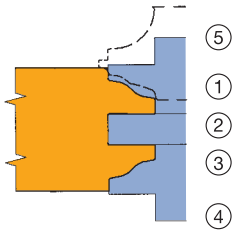


P8.1

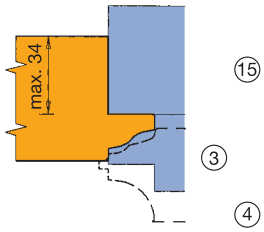


These profile cutterheads can be used for panel raising.

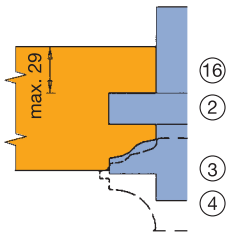
Fig.: Combination options of single tools
Double profile



For profiles P1 - P5.1 along grain

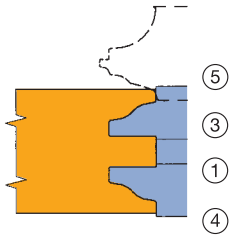


Rebate*

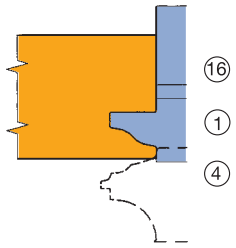


On one side*

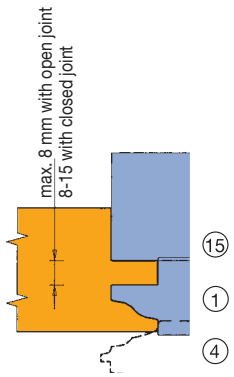
Double profile



Profiles P1 - P5.1 counter profile

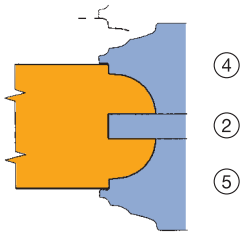


Rebate*

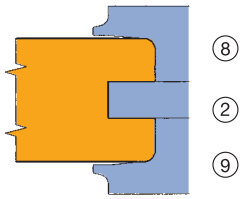


On one side*

* Profiles P1 - P8 (rebate possible and on one side)

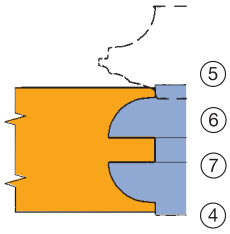


Profiles P6 - P7 along grain

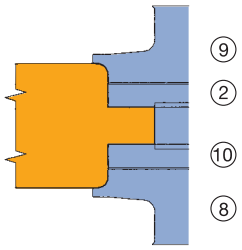


Profile P8 along grain

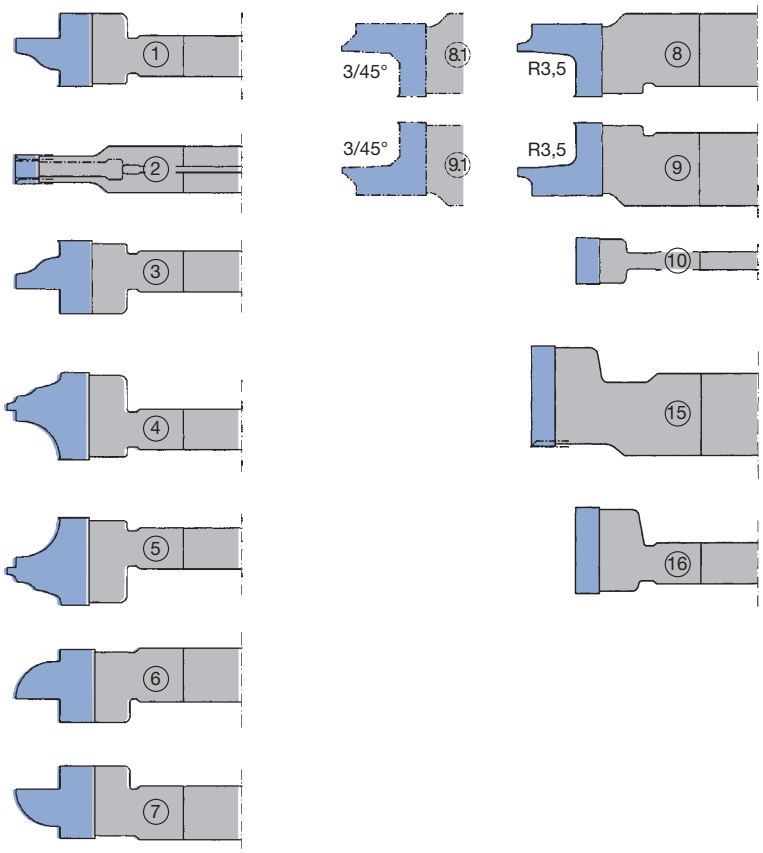
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



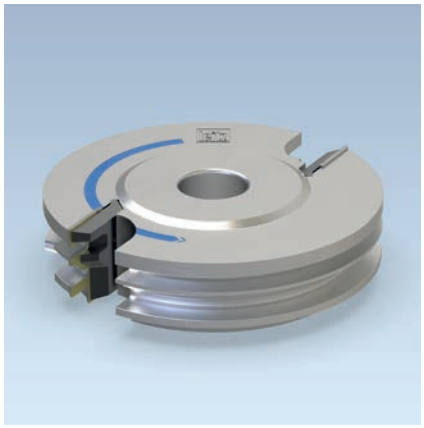
Profiles P6 - P7 counter profile

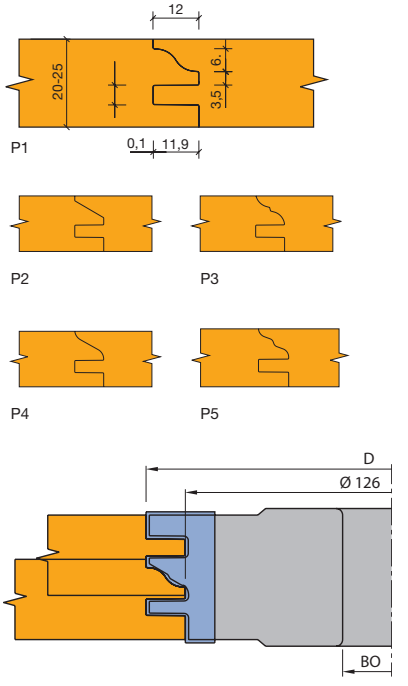


Profile P8 counter profile



Single tools





Profile cutterhead

Profile cutterhead ProfilCut Q for furniture doors

Application:
For profiles and counter profiles for furniture doors.

Machine:
Spindle moulders and moulders.

Workpiece material:
Softwood and hardwood.

Technical information:
Cutterhead with change knives, straight cut.

SB 20 - 25 mm; with closed joint
WE 640 1 53

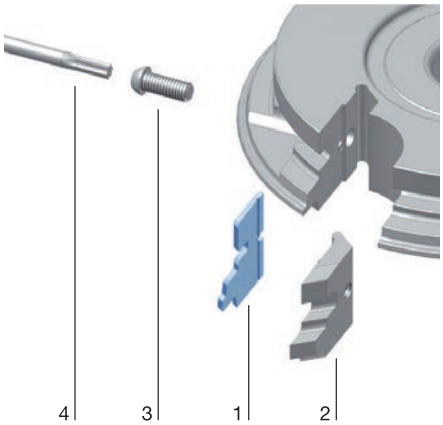
P	D mm	SB mm	BO mm	BO_{max} mm	Z	n min^{-1}	ID
1	150	40	30	50	2	5200 - 8900	**125262** ●
1	150	40	50		2	5200 - 8900	**125392** □

Spare knives:

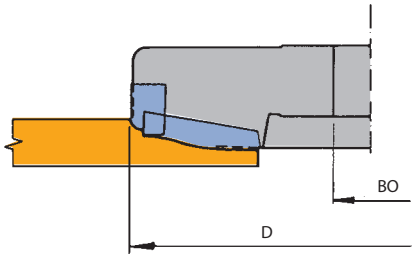
P	Part-no.	BEZ	ABM mm	QAL	ID
1	1	ProfilCut Q knife	40x26x2	MC	**619311**
2	1	ProfilCut Q knife	40x26x2	MC	**619312**
3	1	ProfilCut Q knife	40x26x2	MC	**619313**
4	1	ProfilCut Q knife	40x26x2	MC	**619314**
5	1	ProfilCut Q knife	40x26x2	MC	**619315**

Spare parts:

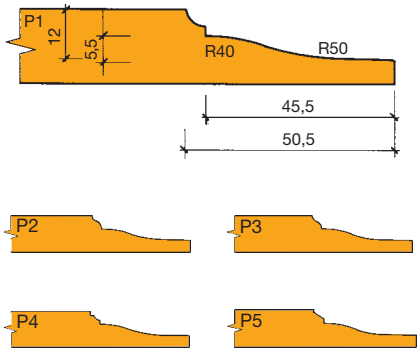
Part-no.	BEZ	ABM mm	ID
2	Clamping wedge profiled	38x36,5x8,27	**629245**
3	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
4	Torx® key	Torx® 25	**117504** ●



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



Single side panel raising



Profile cutterhead ProfilCut Q - panel raising

Application:
For profiling and panel raising 5 different profiles by knife change.

Machine:
Spindle moulders and moulders, double-end tenoners.

Workpiece material:
Softwood and hardwood (along and across grain).

Technical information:
Cutterhead with change knives, shear angle.

Profiling and panel raising, panel raising profile curved
AE 342 1 53

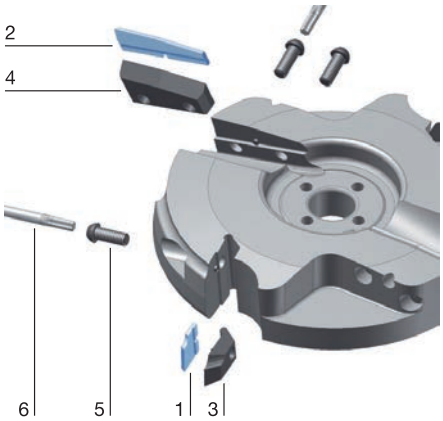
P	D mm	SB mm	BO mm	BO_{max} mm	Z	n min^{-1}	DRI	ID
1	190	40	30	50	2/2	4100 - 7000	RH	**125265** ●

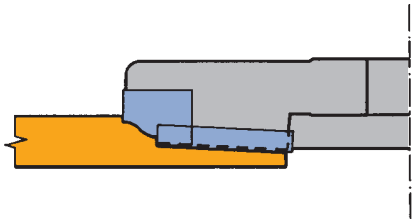
Spare knives:

P	Part-no.	BEZ	ABM mm	ID
1	1	ProfilCut Q knife	20x16x2	**619321** ●
2	1	ProfilCut Q knife	20x16x2	**619322** ●
3	1	ProfilCut Q knife	20x16x2	**619323** ●
4	1	ProfilCut Q knife	20x16x2	**619324**
5	1	ProfilCut Q knife	20x16x2	**619325**
	2	ProfilCut Q knife (pan.rais.)	50x11,68x2	**619326** ●

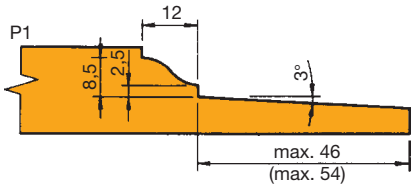
Spare parts:

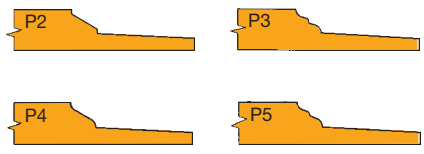
Part-no.	BEZ	ABM mm	ID
3	Clamping wedge profiled	18x26,46x8,27 (P1-5)	**629248**
4	Clamping wedge profiled	47x20.18x7.25 (raised panel)	**629249**
5	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
6	Torx® key	Torx® 25	**117504** ●





Single side panel raising





Profile cutterhead ProfilCut Q - panel raising

Application:
For profiling and panel raising 5 different profiles by knife change.

Machine:
Spindle moulders and moulders, double-end tenoners.

Workpiece material:
Softwood and hardwood (along and across grain).

Technical information:
Cutterhead with change knives, shear angle.

Profiling and panel raising, panel raising profile straight
AE 342 1 53

P	D mm	SB mm	BO mm	BO_{max} mm	Z	n min^{-1}	DRI	ID
1	204	33	30	50	2/2	3800 - 6500	RH	**125266**
1	220	33	30	50	2/2	3500 - 6000	RH	**125267**
1	220	33	50	50	2/2	3500 - 6000	RH	**125268**

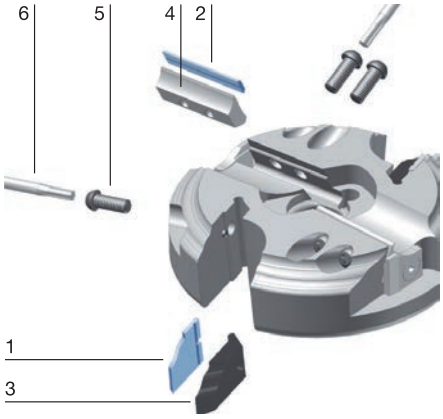
P1 = Profile cutterhead P1.

Spare knives:

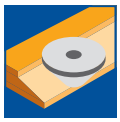
P	Part-no.	BEZ	ABM mm	VE PCS	ID
1	1	ProfilCut Q knife	20x27x2		**619327**
2	1	ProfilCut Q knife	20x27x2		**619328**
3	1	ProfilCut Q knife	20x27x2		**619329**
4	1	ProfilCut Q knife	20x27x2		**619330**
5	1	ProfilCut Q knife	20x27x2		**619331**
	2	Turnblade knife	50x8x1,5	10	**005075** ●
	2	Turnblade knife	60x8x1,5	10	**005076** ●

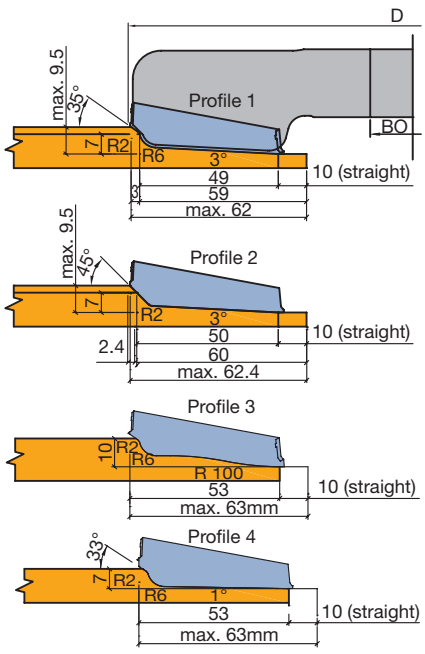
Spare parts:

P	Part-no.	BEZ	ABM mm	ID
1-5	3	Clamping wedge profiled	18x37,46x8,27	**629250**
	4	Clamping wedge panel raising cutter	47x16,8x7,25	**009578** ●
	4	Clamping wedge panel raising cutter	57x16,8x7,25	**009579** ●
	5	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
	6	Torx® key	Torx® 25	**117504** ●



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





Profile cutterhead ProfilCut Q - panel raising

Application:
For profiling and panel raising 4 different profiles by knife change.

Machine:
Spindle moulders and moulders, double-end tenoners.

Workpiece material:
Softwood and hardwood, three layer laminate.

Technical information:
Cutterhead with change knives and shear angle. Tool with 4 profile variants (bevel and quarter round).

Profiling and panel raising using one knife, panel raising profile straight
WE 550 1 53

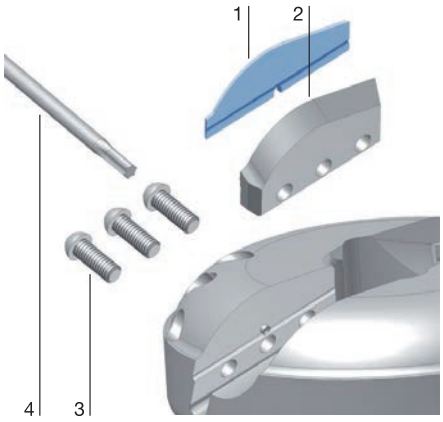
P	D mm	SB mm	BO mm	BO_{max} mm	Z	n min^{-1}	ID
1	200	10 - 37	30	50	2	3900 - 6600	**125269** ●

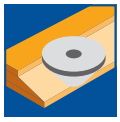
Spare knives:

P	Part-no.	BEZ	ABM mm	QAL	ID
1	1	ProfilCut Q knife	60x14,5x2	MC	**619332** ●
2	1	ProfilCut Q knife	60x14,56x2	MC	**619333** ●
3	1	ProfilCut Q knife	60x14,5x2	MC	**619489**
4	1	ProfilCut Q knife	60x14,5x2	MC	**619490**

Spare parts:

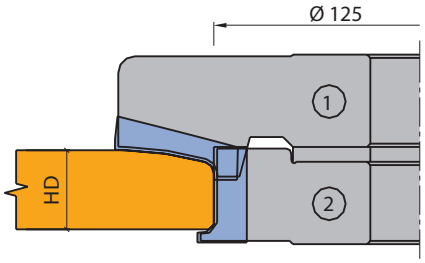
Part-no.	BEZ	ABM mm	ID
2	Clamping wedge profiled	57x23x7,25	**629251**
3	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
4	Torx® key	Torx® 25	**117504** ●

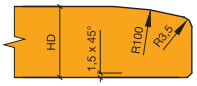




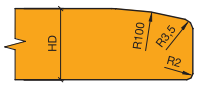


Profile 1.1

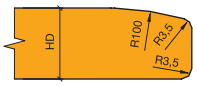




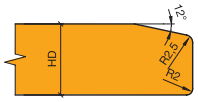
P1.1



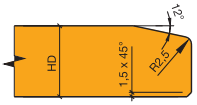
P1.2



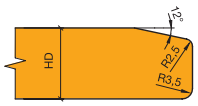
P1.3



P2.2



P2.1



P2.3

Profile cutterhead set ProfilCut Q

Application:
For panel raising of cabinet doors, table tops and worktops.

Machine:
Spindle moulders and moulders, double-end tenoners.

Workpiece material:
Softwood and hardwood, wood derived materials.

Technical information:
Cutterhead with throwaway knives and shear angle. Can be used either as single tool without jointing or as set with jointing cutterhead.

Profile cutterhead set with jointing
SE 500 1 53

P	Tool no.	D mm	SB mm	BO mm	BO_{max} mm	Z	n min^{-1}	ID
1.1	1 / 2	185	29 - 29,5	30	50	2	4200 - 7200	**126066** ●

Single tools
WE 500 1 53, WE 550 1 53

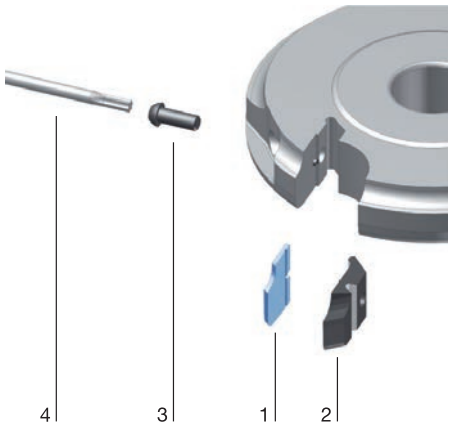
Tool no.	D mm	SB mm	BO mm	BO_{max} mm	Z	n min^{-1}	ID
1	185	10 - 38	30	50	2	4200 - 7200	**125263**
2	135	29 - 29,5	30	50	2	5700 - 9800	**125264**

Spare knives:

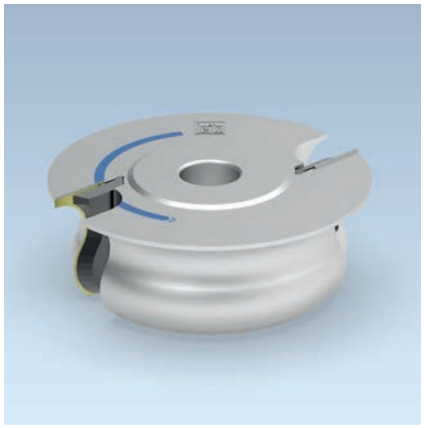
P	Part-no.	BEZ	ABM mm	Tool no.	QAL	ID
1	1	ProfilCut Q knife	40x13,21x2	1	MC	**619316**
2	1	ProfilCut Q knife	40x13,21x2	1	MC	**619317**
1	1	ProfilCut Q knife	30x15,9x2	2	MC	**619318**
2	1	ProfilCut Q knife	30x15,9x2	2	MC	**619319**
3	1	ProfilCut Q knife	30x15,9x2	2	MC	**619320**

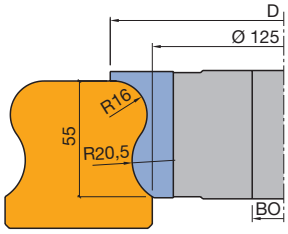
Spare parts:

Part-no.	BEZ	ABM mm	Tool no.	ID
2	Clamping wedge profiled	37x21,38x8,27	1	**629246** ●
2	Clamping wedge profiled	28x24x8,27	2	**629247** ●
3	Clamping screw w. disc, Torx® 25	M6x18.5		**007442** ●
4	Torx® key	Torx® 25		**117504** ●



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





Handrail profile

Profile cutterhead ProfilCut Q for handrail profile

Application:
For handrails. Copy shaping of curved workpieces using template and ball bearing guide ring.

Machine:
Spindle moulders and moulders, machines with/without CNC control.

Workpiece material:
Softwood and hardwood.

Technical information:
Cutterhead with change knives and straight cut.

Handrail profile
WE 500 1 53

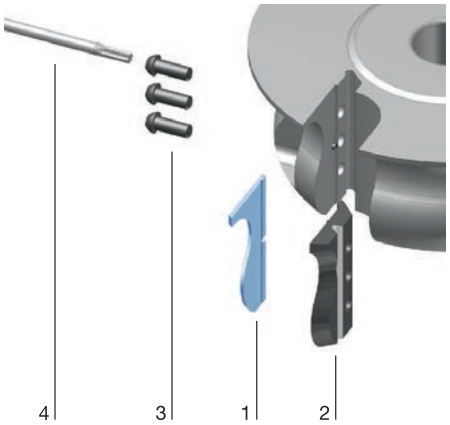
D mm	SB mm	BO mm	BO_{max} mm	Z	n min^{-1}	ID
165	60 - 61	30	50	2	4700 - 8100	**125386** ●

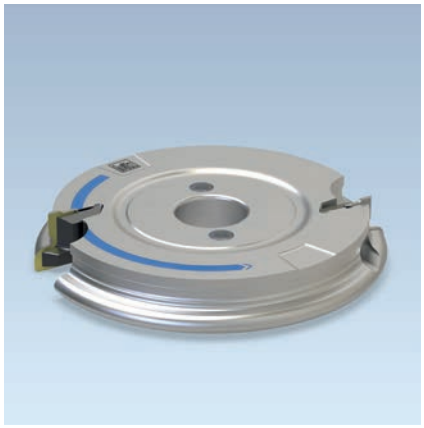
Spare knives:

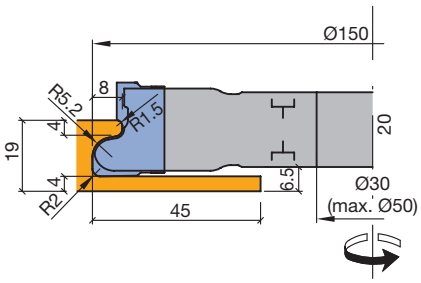
Part-no.	BEZ	ABM mm	QAL	ID
1	ProfilCut Q knife	60x32.7x2.4	MC	**619500**

Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge profiled	58x35x8.27	**629463**
3	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
4	Torx® key	Torx® 25	**117504** ●







Profile Cutterhead ProfilCut Q for grip rails

Application:
For cutting recessed grips.

Machine:
Spindle moulders and moulders.

Workpiece material:
Softwood and hardwood, chip and fibre board, raw or plastic coated, glulam etc.

Technical information:
Maximum operating comfort due to lightweight construction of the tool body. Longer lasting consistent finish cutting quality due to Marathon high performance coating.

MAN feed
WE 500 1 53

D mm	SB mm	BO mm	BO_{max} mm	Z	ID
150	25	30	50	2	**125380** ●

RPM: n_{max} = 12500 min^{-1}

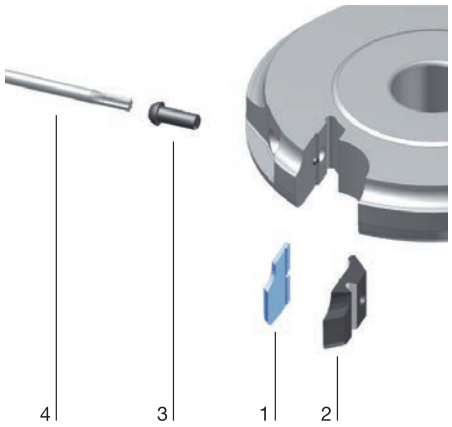
Throwaway knives for other profile variants available on request.

Spare knives:

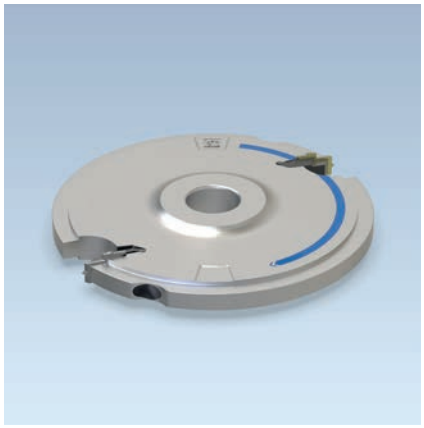
Part-no.	BEZ	ABM mm	QAL	ID
1	ProfilCut Q knife	25.1x21x2.4	MC	**619475**

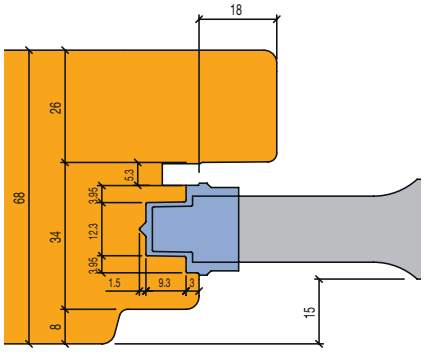
Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge profiled	21x29.5x8.27	**629464**
3	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
4	Torx® key	Torx® 25	**117504** ●



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





Profile cutterhead ProfilCut Q for gear grooves

Application:
For gear grooves.

Machine:
Spindle moulders and moulders.

Workpiece material:
Softwood and hardwood.

Technical information:
Cutterhead with change knives. User friendliness by lightweight construction of the tool body. Longer performance and cut quality due to Marathon high performance coating.

Gear groove
WE 500 1 53

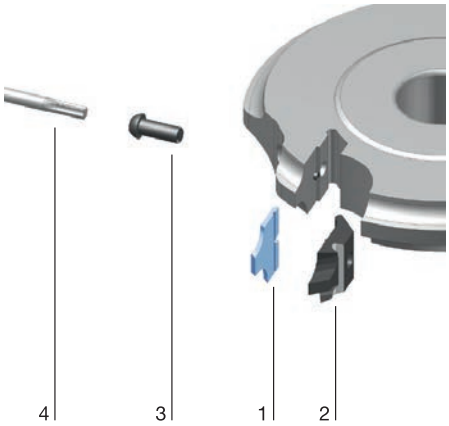
D mm	SB mm	BO mm	BO_{max} mm	Z	n min^{-1}	ID
188.6	21.3/23.1	30	50	2	4100 - 9100	**125393** ●

Spare knives:

Part-no.	BEZ	ABM mm	QAL	ID
1	ProfilCut Q knife	21.3x25x2.4	MC	**619521**

Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge	15.7x33x8.27	**629461**
3	Clamping screw w. disc, Torx® 25	M6x18.5	**007442** ●
4	Torx® key	Torx® 25	**117504** ●

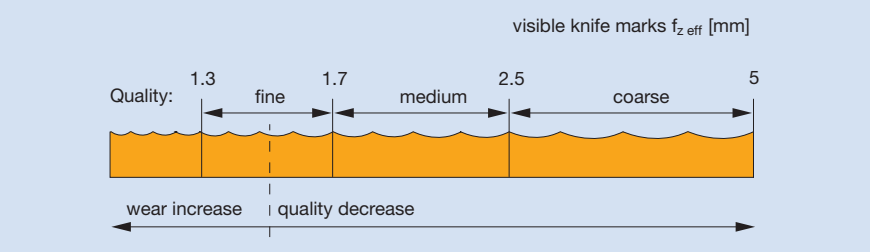


Type of operation

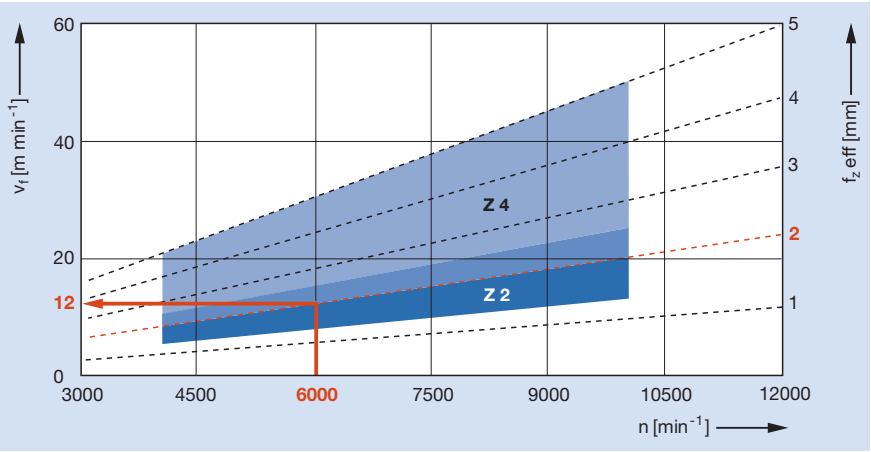
The tools described in the following section are suitable for making many different profiles. This includes profiling in craft or industry, the relevant product descriptions provide a reference when using a specific tool, and the type of woods processed.

The introduction to each section gives general notes and application regulations.

Relation between surface quality and length of knife marks $f_{z\ eff}$



Feed speeds depending on RPM, length of knife marks and number of teeth



With multi blade tools, only the marks of one knife show on the surface (one knife finish). Z 2 and Z 4 tools produce the same surface quality with same machine setting. High numbers of teeth are required for a high hogging performance.

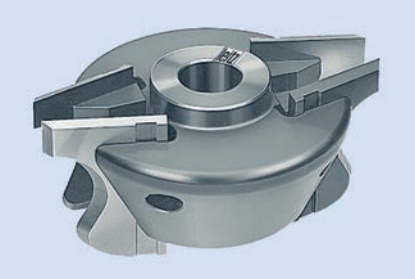
Workpiece materials, machines, application

Please refer to the relevant product pages depending on the operation and profile.

Tool system

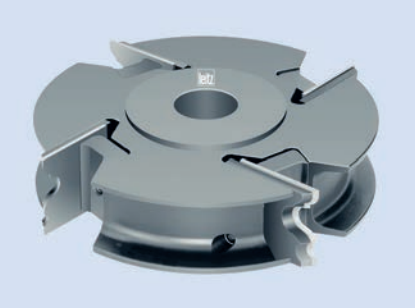
WM 500 1 04 Profile cutterhead with limitor, tool body in aluminium.

For profile depths up to maximum 15 mm and cutting widths of 50 mm. (WM 510 1 03)
For profile depths up to maximum 15 mm and cutting widths of 40 mm. (WM 500 1 04)
For small companies or craft. For spindle moulders or combination machines. More than 127 standard profile cutters and limitors available. If required Leitz can supply profile knives and limitors in HS quality to a special shape. Only a drawing or wood sample of the required profile is necessary to produce the special knives.



WM 530 1 01 Profile cutterhead.
WM 530 1 02 Profile cutterhead.
WM 520 1 Profile cutterhead.
WM 540 1 Profile cutterhead.

For big profile depths up to maximum 45 mm and cutting widths up to 80 mm. Suitable for small and medium sized companies to produce special profiles. For machines with manual feed. Special profile knives in HS quality can be produced by the Leitz service stations on request. Only a sketch or wood sample of the required profile is necessary to produce special profile knives.



Profile cutterhead VariForm.

VariForm cutterheads are available in different designs and dimensions. The tool body is designed for mech. feed without limitor or for manual feed with limitor depending on the application. Please select the correct type of cutterhead for each application from the diagram below.

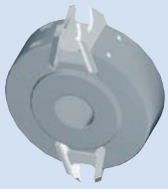
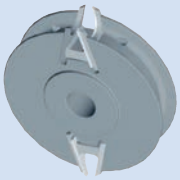
Design variation	Profile depth up to 15/19 mm	Profile depth up to 20 mm	Profile depth up to 35 mm
MAN-feed For spindle moulders	 Multi-purpose tool body	 Part profiled tool body, U-profile	 Profiled tool body, cranked right/left
Cutting width	40/45 mm a. 50/60 mm	45/45 mm a. 50/60 mm	40 mm to 60 mm



Table for diameters when using rebating and profile knives:

D-mm Tool body	D-mm with rebating knife	D-mm with profile knife
93	108	130
114	128	150

Profile cutterhead, aluminium tool body

Application:
For profiling, jointing and rebating.

Machine:
Spindle moulders and moulders.

Workpiece material:
Softwood.

Technical information:
Profile cutterhead with aluminium tool body for standard and special profile knives up to 50 mm cutting width and maximum profile depth 15 mm. Constant diameter by using changeable profile knives. Knife thickness 4 mm.

D 108 mm - 148 mm
WM 500 1 04, WM 500 1 06

D mm	SB mm	BO mm	BO_{max} mm	Z	n min^{-1}	QAL	ID
108	40	30	30	2	6000 - 10000	SP	**025685** ●
128	40 - 50	30	40	2	6000 - 9000	SP	**025815** ●
128	80	30	40	2	6000 - 8000	SP	**025816** ●
148	40 - 50	30	50	2	5500 - 7000	SP	**025691** ●

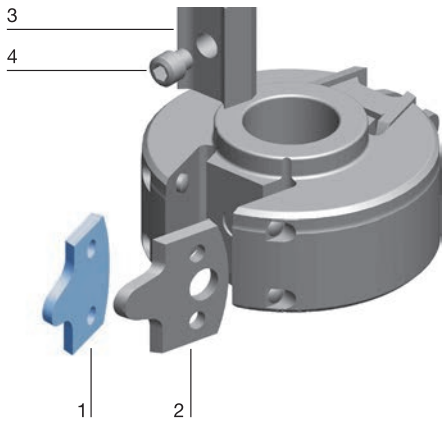
See section Knives and Spare Parts.

Spare knives:

Part-no.	BEZ	ABM mm	QAL	ID
1	Rebate knife	40x32,8x4	SP	**007104** ●
2	Limitor	38,4x32,8x4	ST	**005586** ●

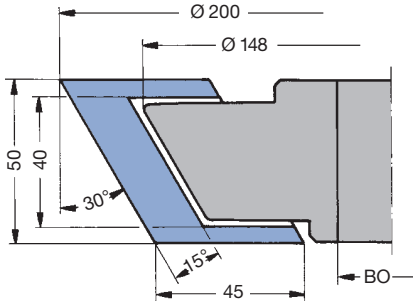
Spare parts:

Part-no.	BEZ	ABM mm	ID
3	Clamping wedge	36x13,21x26	**009756** ●
3	Clamping wedge	56x13,21x26	**009757** ●
4	Allen screw with ISK 5	M10x12	**006044** ●
	Allen key	SW 5	**005446** ●



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

HS



Profile cutterhead

Application:
For deep one-sided profiles, maximum 45 mm depth.

Machine:
Spindle moulders and moulders.

Workpiece material:
Softwood and hardwood.

Technical information:
Cutting width up to 50 mm. See illustration for usable profile area. Knife thickness 4.0 mm.

MAN feed, for one sided profiles with SB 50 mm
WM 530 1 01

D	TD	SB	BO	BO_{max}	Z	n	ID
mm	mm	mm	mm	mm		min^{-1}	
200	148	50	30	40	2	4500 - 7000	**029636** ●

Sales unit without knives and limitors.
Note: State direction of rotation when ordering knives.

Spare knives:

BEZ	BEM	ABM mm	QAL	ID
Blank Knife	R/T	50.4x45x4	HS	**007297** ●
Blank Knife	R/B	50.4x45x4	HS	**007298** ●
Limitor blank	R/T	48.8x45x4	SP	**005603** ●
Limitor blank	R/B	48.8x45x4	SP	**005604** ●

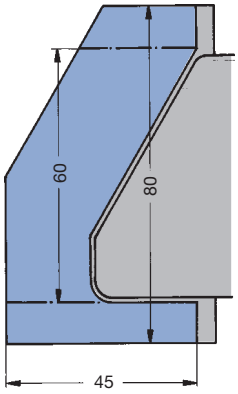
Spare parts:

BEZ	ABM mm	ID
Allen screw	M10x16	**006046**
Allen key	SW 5	**005446** ●
Double wedge	49.2x13.2x26	**009927** ●

HS-special profiles and SP-profile limitors

Profile knives set inc. limitor	PG I	SB = 50 mm
Profile knives set inc. limitor	PG II	SB = 50 mm
Set consists of:	2 HS-Profile knives; 2 SP-Limitors	

Profile knives and limitors produced to customer's profile.
Only use this cutterhead with original Leitz profile knives and limitors!



Profile cutterhead

Application:
For deep one-sided profiles with large profile depth, maximum 45 mm depth. Easy to use, no setting gauge required.

Machine:
Spindle moulders and moulders.

Workpiece material:
Softwood and hardwood.

Technical information:
Cutting width up to 80 mm. See illustration for usable profile area. Knife thickness 4.0 mm.

MAN feed, for one sided profiles with SB 60 - 80 mm
WM 530 1 02

D mm	SB mm	BO mm	BO_{max} mm	HD mm	PT_{max} mm	Z	n min^{-1}	ID
180	60 - 80	30	40	80	45	2	4500 - 6000	**026768** ●
180	60 - 80	40	40	80	45	2	4500 - 6000	**026769** □

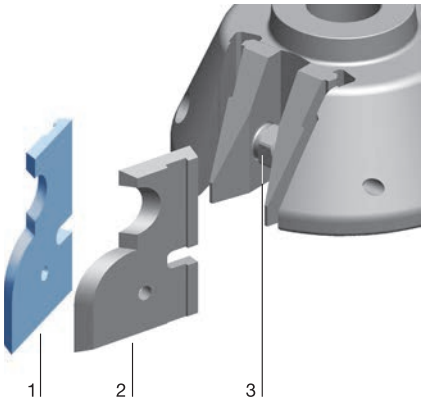
Sales unit without knives and limitors.
Note: State direction of rotation when ordering knives.

Spare knives:

Part-no.	BEZ	ABM mm	QAL	ID
1	Blank Knife R/B	60x60x6	HS	**007280** ●
1	Blank Knife R/B	80x60x6	HS	**007281** ●
1	Blank Knife R/T	60x60x6	HS	**007282** ●
1	Blank Knife R/T	80x60x6	HS	**007283** ●
2	Limitor blank R/B (60)	58x59.2x6	SP	**005596** ●
2	Limitor blank R/B (80)	78x59.2x6	SP	**005597** ●
2	Limitor blank R/T (60)	58x59.2x6	SP	**005598** ●
2	Limitor blank R/T (80)	78x59.2x6	SP	**005599** ●

Spare parts:

Part-no.	BEZ	ABM mm	ID
3	Clamping screw	M16x1.5x36 LH/RH	**005958** ●
	Key	SW 17	**005456** ●

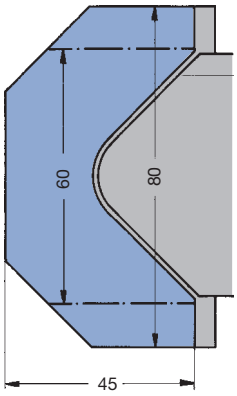


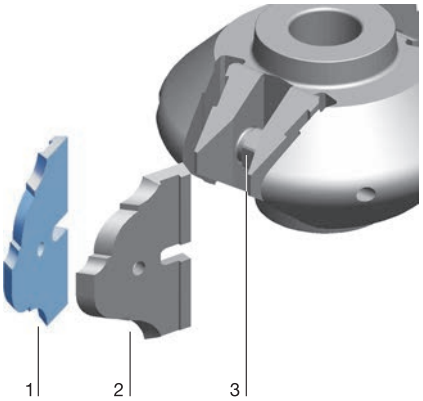
HS-special profiles and SP-profile limitors

PG I	Set of profile knives	SB = 60 mm
PG II	Set of profile knives	SB = 60 mm
PG I	Set of profile knives	SB = 80 mm
PG II	Set of profile knives	SB = 80 mm
Set consists of:		2 HS-Profile knives 2 SP-Limitors

Profile knives and limitors are produced to customer's profile.
Only use this cutterhead with original Leitz profile knives and limitors!

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





Profile cutterhead

Application:
For deep profiles with large profile depth, maximum 45 mm depth, with resharpenable profile knives and limitors. Easy to use, no setting gauge required.

Machine:
Spindle moulders and moulders.

Workpiece material:
Softwood and hardwood.

Technical information:
Cutting width up to 80.0 mm. Symmetrical tool body for right hand or left hand rotation as required.

MAN feed for symmetric profiles SB 60 - 80 mm
WM 520 1

D	SB	BO	BO_{max}	HD	PT_{max}	Z	n	ID
mm	mm	mm	mm	mm	mm		min^{-1}	
180	60 - 80	30	40	80	45	2	4500 - 6000	**026651** ●
180	60 - 80	40	40	80	45	2	4500 - 6000	**026652** □

Sales unit without knives and limitors.
Note: State direction of rotation when ordering knives.

Spare knives:

Part-no.	BEZ	ABM mm	QAL	ID
1	Blank Knife	60x60x6	HS	**007278** ●
1	Blank Knife	80x60x6	HS	**007279** ●
2	Limitor blank	58x59.2x6	SP	**005594** ●
2	Limitor blank	78x59.2x6	SP	**005595** ●

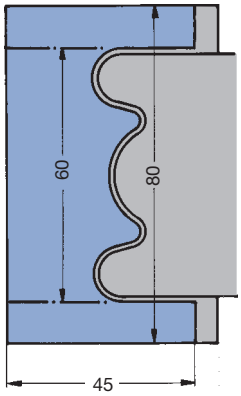
Spare parts:

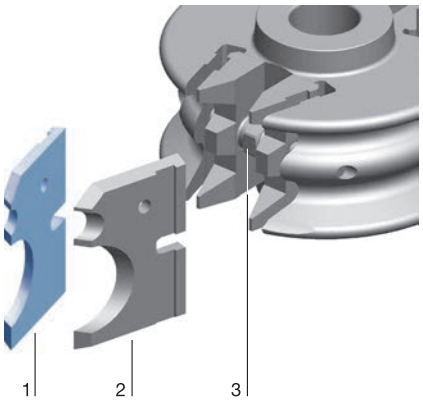
Part-no.	BEZ	ABM mm	ID
3	Clamping screw	M16x1.5x36 LH/RH	**005958** ●
	Key	SW 17	**005456** ●

HS-special profiles and SP-profile limitors

	PG I	Set of profile knives	SB = 60 mm
	PG II	Set of profile knives	SB = 60 mm
	PG I	Set of profile knives	SB = 80 mm
	PG II	Set of profile knives	SB = 80 mm
	Set consists of:		2 HS-Profile knives 2 SP-Limitors

Profile knives and limitors are produced to customer's profile.
Only use this cutterhead with original Leitz profile knives and limitors!





Profile cutterhead

Application:
For deep profiles with large profile depth, maximum 45 mm depth, with resharpenable profile knives and limitors. Easy to use, no setting gauge required.

Machine:
Spindle moulders and moulders.

Workpiece material:
Softwood and hardwood.

Technical information:
Cutting width up to 80.0 mm. Symmetrical tool body for right hand or left hand rotation as required.

MAN feed for symmetric closed profiles SB 60 - 80 mm
WM 540 1

D mm	SB mm	BO mm	BO_{max} mm	HD mm	PT_{max} mm	Z	n min^{-1}	ID
180	60 - 80	30	40	80	45	2	4500 - 6000	**026865** ●
180	60 - 80	40	40	80	45	2	4500 - 6000	**026866** □

Sales unit without knives and limitors.
Note: State direction of rotation when ordering knives.

Spare knives:

Part-no.	BEZ	ABM mm	QAL	ID
1	Blank Knife	60x60x6	HS	**007276** ●
1	Blank Knife	80x60x6	HS	**007277** ●
2	Limitor blank	58x59.2x6	SP	**005600** ●
2	Limitor blank	78x59.2x6	SP	**005601** ●

Spare parts:

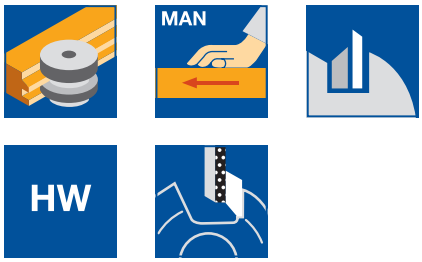
Part-no.	BEZ	ABM mm	ID
3	Clamping screw	M16x1.5x36 LH/RH	**005958** ●
	Key	SW 17	**005456** ●

HS-special profiles and SP-profile limitors

	PG I	Set of profile knives	SB = 60 mm
	PG II	Set of profile knives	SB = 60 mm
	PG I	Set of profile knives	SB = 80 mm
	PG II	Set of profile knives	SB = 80 mm
	Set consists of:		2 HS-Profile knives 2 SP-Limitors

Profile knives and limitors are produced to customer's profile.
Only use this cutterhead with original Leitz profile knives and limitors!

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



Profile cutterhead VariForm

Application:
For cutting profiles. Different knives with maximum 15 mm profile depth can be mounted.

Machine:
Spindle moulders and moulders, double-end tenoners, edgebanding machines etc.

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

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

Tool body, MAN feed, Z 2
TT 531 1

D mm	TD mm	SB mm	BO mm	BO_{max} mm	PT_{max} mm	Z	n_{max} min^{-1}	ID
150	116	40 - 45	30	50	15	2	8000	**135100** ●
150	116	50 - 60	30	50	15	2	8000	**135101** ●

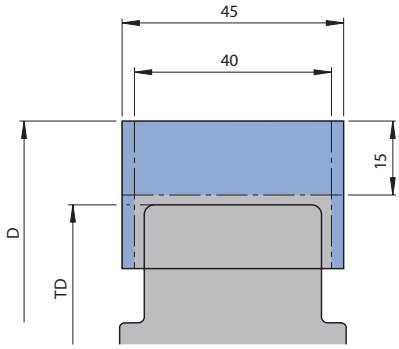
Supplied with clamping wedges, but without backing plates, limitors and knives.

Spare knives:

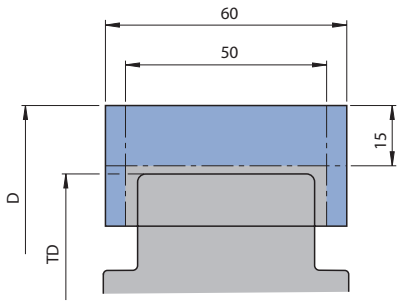
Part-no.	SB mm	H mm	PT_{max} mm	ID HW-10F	ID HW-30F
1	40	40	15	**636227** ●	**636240** ●
1	45	40	15	**636231** ●	**636244** ●
1	50	40	15	**636284** ●	**636272** ●
1	60	40	15	**636288** ●	**636276** ●

Spare parts:

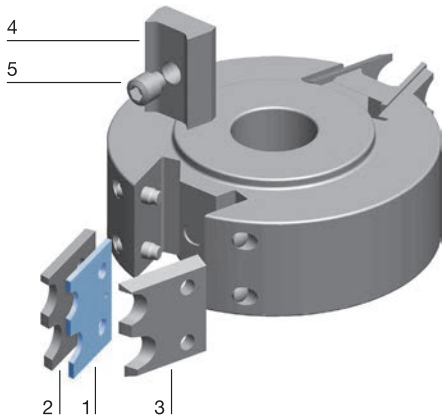
Part-no.	BEZ	ABM mm	for SB mm	ID
2	Backing plate VariForm	for knives 40x40x2.1	40	**645000** ●
2	Backing plate VariForm	for knives 45x40x2.1	45	**645001** ●
2	Backing plate VariForm	for knives 50x40x2.1	50	**645002** ●
2	Backing plate VariForm	for knives 60x40x2.1	60	**645003** ●
3	Limitor VariForm	for knives 40x40x2.1		**640000** ●
3	Limitor VariForm	for knives 45x40x2.1		**640001** ●
3	Limitor VariForm	for knives 50x40x2.1		**640002** ●
3	Limitor VariForm	for knives 60x40x2.1		**640003** ●
4	Clamping wedge	36x13.21x26	40/45	**009756** ●
4	Clamping wedge VariForm	44x13.21x24.25	50/60	**009760** ●
5	Allen screw with ISK 5	M10x12		**006044** ●
	Allen key	SW 5, L100		**117506** ●

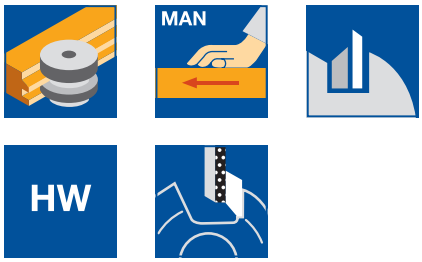


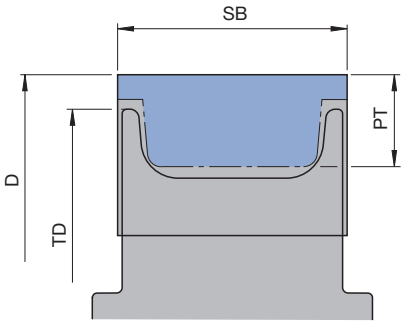
Tool body, SB 40/45 mm



Tool body, SB 50/60 mm







Tool body, U profile

Profile cutterhead VariForm

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

Machine:
Spindle moulders and moulders, double-end tenoners, edgebanding machines etc.

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

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

Part profiled tool body, MAN feed, Z 2 (U-profile).
TT 531 1

D mm	TD mm	SB mm	BO mm	BO_{max} mm	PT_{max} mm	Z	n_{max} min^{-1}	ID
180	165	40	30	50	20	2	7200	**135120** ●
180	165	60	30	50	20	2	7200	**135122** ●

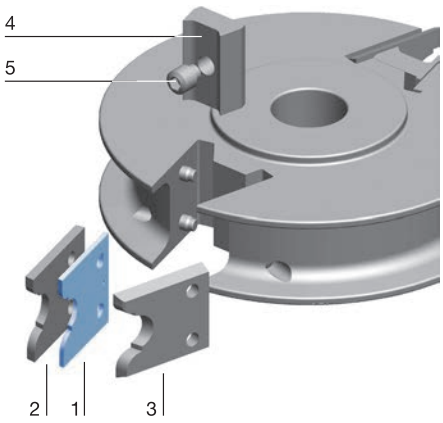
Supplied with clamping wedges, but without backing plates, limitors and knives.

Spare knives:

Part-no.	SB mm	H mm	PT mm	ID HW-10F	ID HW-30F
1	40	45	20	**636226** ●	**636239** ●
1	60	45	20	**636287** ●	**636275** ●

Spare parts:

Part-no.	BEZ	ABM mm	for SB mm	ID
2	Backing plate VariForm	for knives 40x45x2.1		**645004** ●
2	Backing plate VariForm	for knives 60x45x2.1		**645006** ●
3	Limitor VariForm	for knives 40x45x2.1		**640004** ●
3	Limitor VariForm	for knives 60x45x2.1		**640006** ●
4	Clamping wedge	36x13.21x26	40/45	**009756** ●
4	Clamping wedge	56x13.21x26	60	**009757** ●
5	Allen screw with ISK 5	M10x12		**006044** ●
	Allen key	SW 5, L100		**117506** ●



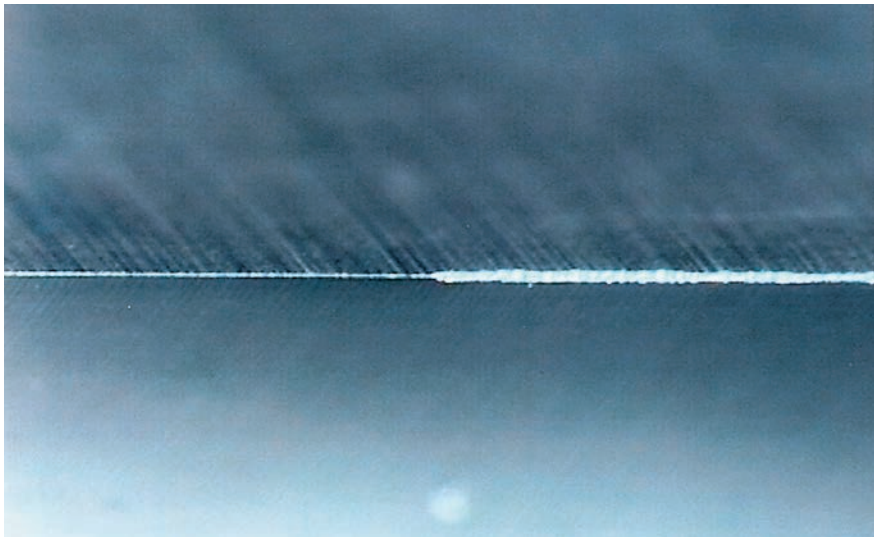
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

Problem	Possible cause	Action
Surface errors Cutting quality	– RPM too low	Increase RPM and cutting speed, increase tool diameter
	– Wrong cutting geometry (shear angle too small for solid wood)	Measure, change tool
	– Spindle and tool tolerances too big	Check motor bearings and tolerances
	– Unbalanced tool	Check and balance
	– Cutting speed too high (tool rubs), number of teeth: feed speed ratio incorrect	Increase feed speed, reduce no. of teeth and RPM
	– Too few teeth, too high feed speed	Adjust number of teeth and feed speed accordingly
Wavy, rough surface	– Irregular workpiece feed	Check feed or conveyor unit
	– Low feed roller pressure, worn feed rollers	Increase feed roller pressure and rema-chine grooves in rollers
	– Workpieces too narrow or too short	Pay attention to machine manufacturer's guidelines
	– Chip removal too high	Pre-relieve or machine in several passes
	– Resin built up, or blunt tool	Clean and sharpen tool regularly
Surface errors Burn marks	– Cutting speed too high	Reduce RPM
	– Feed speed: number of teeth ratio wrong	Adjust number of teeth and feed speed accordingly
	– Tool rotates on stationary workpiece	Ensure constant feed through the machine
Surface errors Tear outs	– Wood moisture content too low	Check drying process
	– Knotty wood	Optimise with crosscut saw and longitudinal joints
Surface errors Chip marks	– Incorrect cutting geometry for workpiece material	Check, adjust or use new tool
	– Gap between knife and wedges	Clean and carefully mount knife and wedge
	– Gullet too small	Check and enlarge
	– Extraction hood and chip removal unit insufficient	Contact machine manufacturer
	– Weak dust extraction	Guideline: 30 m s^{-1} air speed
Profile error in workpiece – angle error – uneven	– Tool profile sets not identical, e.g. with sets for cutting with/against feed	Check and adjust tool set
	– Spindle not exactly vertical in feed direction or table plane	Check spindle is vertical with dial gauge at two positions with moving spindle (top and bottom of spindle)
	– Worn table and fence	Rework or replace table and fence
	– Angle tolerance between table and fence too large or incorrect adjustment of fence and zero line	Check and adjust angles, adjust fence to tool zero diameter
Power consumption of motor Feeding force	– Resin built up on tool, blunt tool	Clean and sharpen tool regularly
	– Tool gullet too small	Check and correct
	– Shear angle too small	Correct or use new tool
	– Cutting section too large	Relieve profile or machine in several passes

Rounding of cutting edges
Mechanical abrasion causes continuous rounding to the cutting edge when machining uniform materials.

The machined surface quality determines the size of the cutting edge wear. As a standard the width of wear VB of 0.2 to maximum 0.3 mm should not be exceeded.

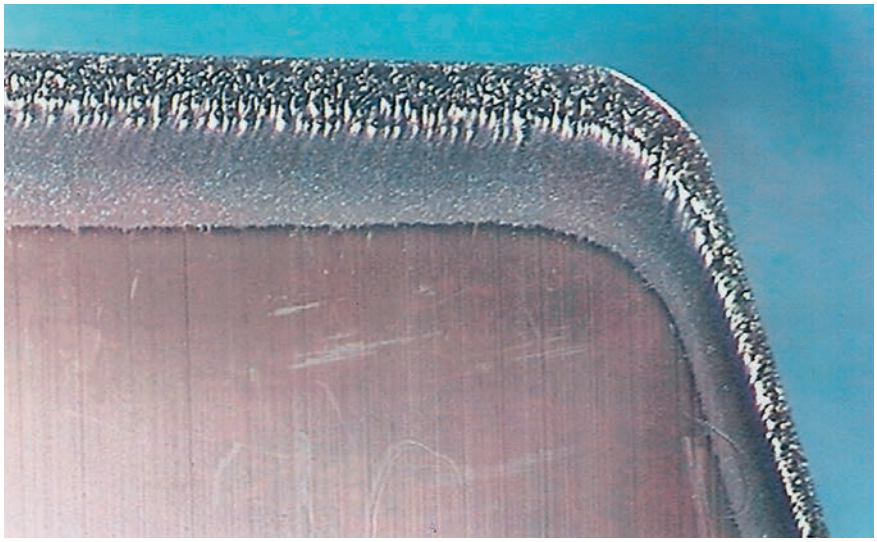
Tipped tools must be resharpened regularly to ensure the economic efficiency of the tool.



Typical cutting edge wear after machining spruce.

Chemical wear to cutting edges
When machining workpiece materials with a high tannic acid content (e.g. oak), the wear to the cutting edges is a combination of mechanical and chemical wear.

The cobalt binder material in the tungsten carbide is etched away by a chemical action prematurely damaging the cutting material.

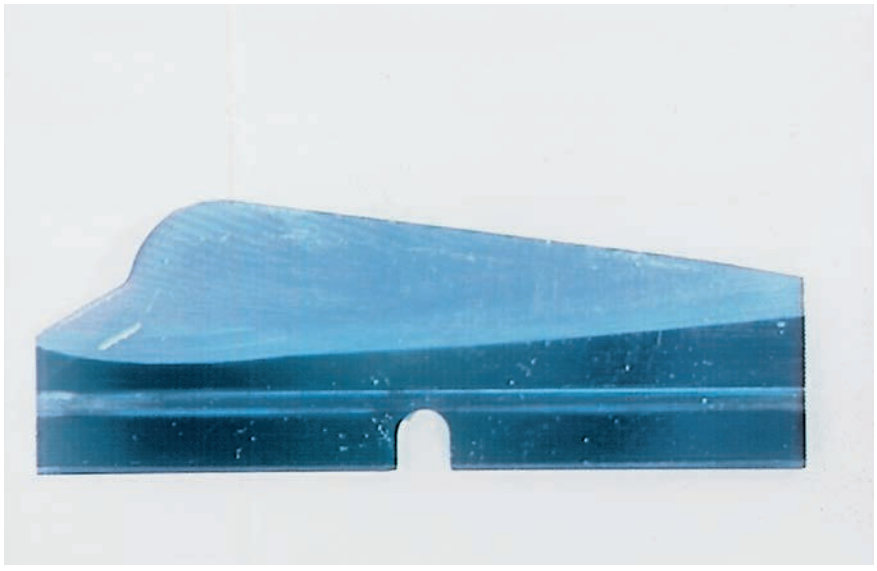


Chemical influence – cutting edge wear – after machining of oak.

Cutting edge damage through incorrect repair
With cutterhead/cutter set tools with HW cutting edges, the knives must be turned or replaced at the end of their performance time.

Resharpening on the face is not possible for safety reasons as it leads to a loss of clamping force and gaps between the knife and the clamping wedge, affect the surface quality.

Tools with turnblade/replaceable knives must be thoroughly cleaned and carefully mounted when changing knives.



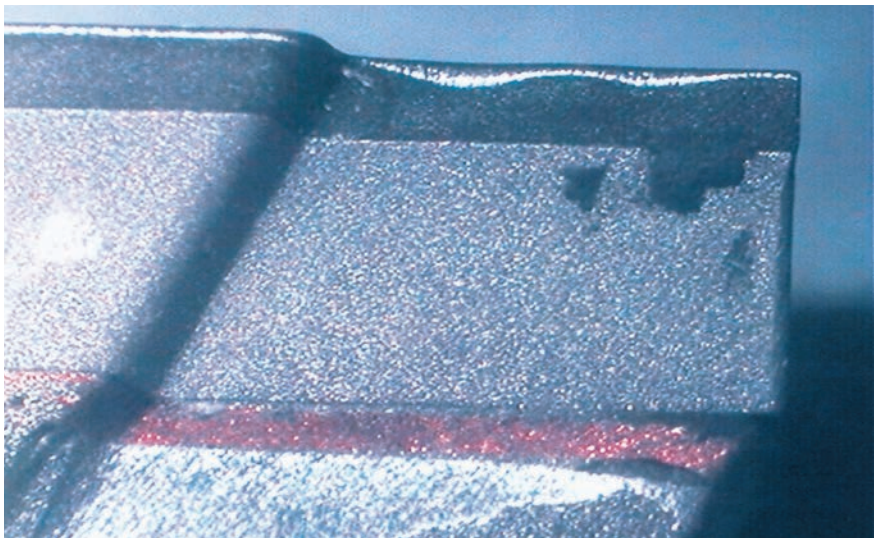
Damaged cutting edges due to incorrect repair.

Rounding of cutting edges
Mechanical abrasion causes continuous rounding to the cutting edge when machining uniform materials.

Resin build up can develop on the cutting edges because of the long performance time.

The machined surface quality determines the size of the cutting edge wear. As a standard the width of wear VB of 0.2 to maximum 0.3 mm should not be exceeded.

Run time performance can be increased by removing the resin build-up.

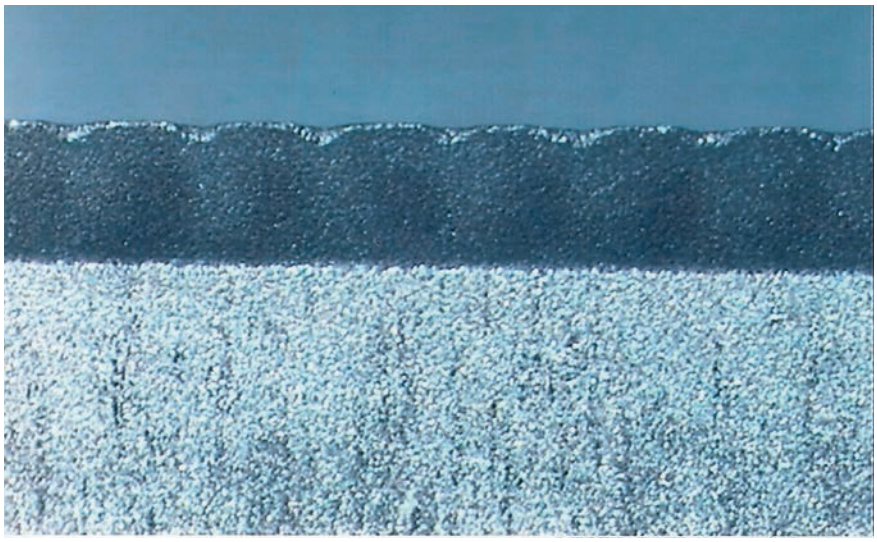


Cutting edge wear after machining GFK.

Rounding cutting edges and small chips
The cutting edge is damaged by small chips not caused by the usual wear when machining some wood-derived materials.

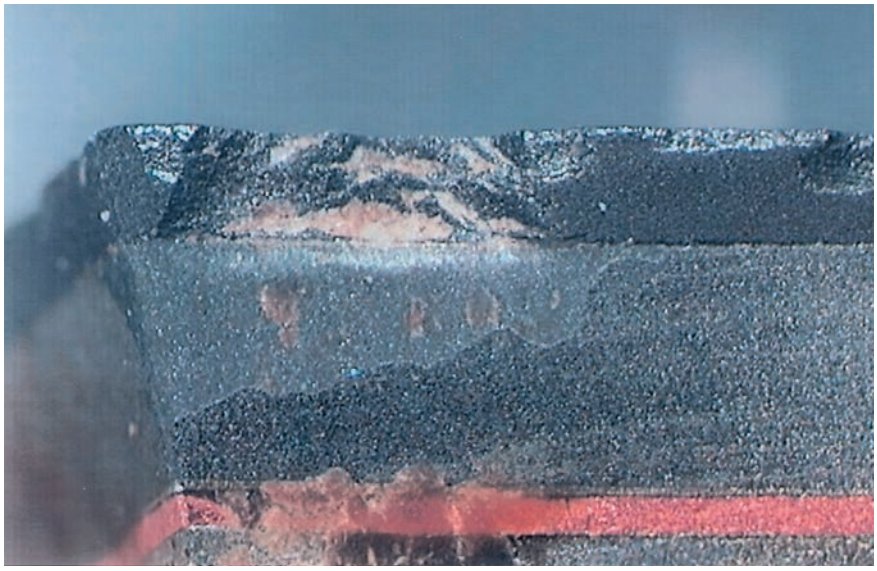
This is usually caused by foreign objects such as mineral particles in the workpiece material.

The wear to the cutting edges and the size of the chips to the cutting edge are important factors for economically efficient repair. Increasing cutting forces can totally destroy the cutting edges.



Cutting edge wear and cracks after machining HPL/CPL.

Cutting edge destruction
The cutting edge can be destroyed when machining non-uniform materials containing mineral or metallic particles. These particles cannot be detected prior to machining and limit the use of DP (DIA) tools for machining such materials.



Cutting edge destruction by metallic particles.

Enquiry/order form special tools – manual feed

Customer details: Customer number: (if known)

☐ Enquiry
☐ Order

Delivery date: (not binding) CW

Company:

Street:

Town/Postcode:

Country:

Phone/fax:

Contact person:

Signature:

Date:

Enquiry/order no.:

Tool ID: (if known)

No. of pieces:

Work piece material:

☐ Solid wood Type:
☐ Wood-derived mat. Type:
☐ Coating Type:
☐ Other Type:
☐ Finish hogging

Moisture content: %
Density: g/cm³
Additional information:

Machine:

(Spindle moulder, moulder, double-end tenoner edgebanding machines, window machines etc.)

Manufacturer:
Year:
Type:

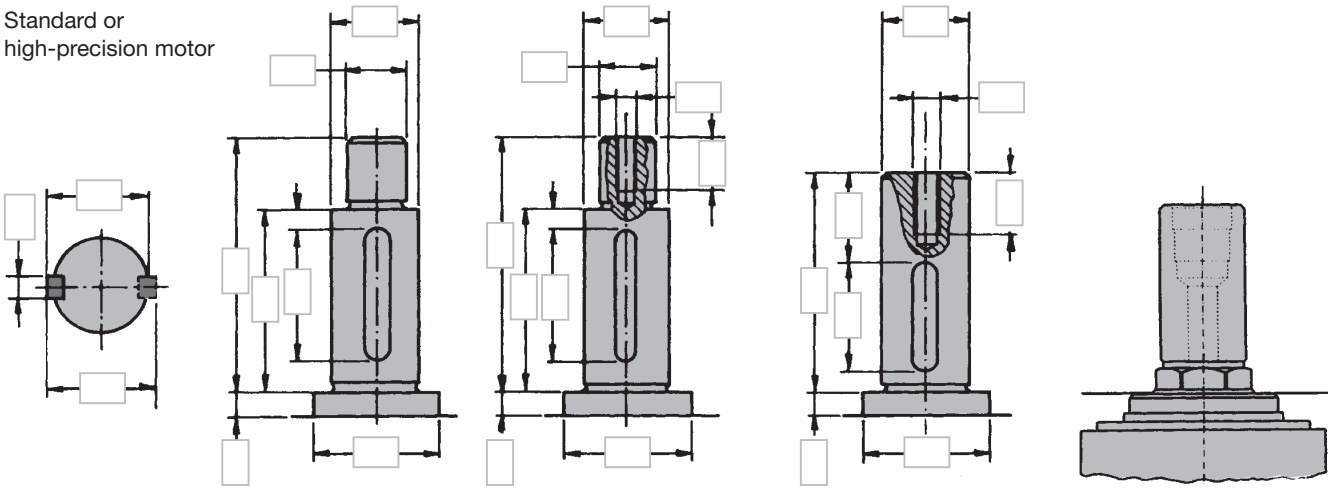
Spindle sequence in feed direction:

e.g.: 1 bottom, 2 right hand, 3 left hand, 4 top, 5 multi-purpose
or: 1 scoring, 2 hogging, 3 cutting, 4 square cutting, 5 finish cutting
or: 1 sawing, 2 slotting/tenoning, 3 cutting with feed, 4 cutting against feed

Motor no.:	Power:	RPM:	Spindle dimension:	add. Information:
1	kW	min^{-1}	mm	
2	kW	min^{-1}	mm	
3	kW	min^{-1}	mm	
4	kW	min^{-1}	mm	
5	kW	min^{-1}	mm	

Please state direction of rotation (LH/RH) or cutting direction (GGL/GLL) for each spindle.

Standard or high-precision motor



Tool:

Tool type (see product information): (e.g. single part/tipped-/tool combination)

Dimension:

Diameter	mm
Cutting width:	mm
Bore:	mm
No. of teeth:	

Direction of rotation:
- ☐ Right hand rotation
- ☐ Left hand rotation

Cutting direction:
- ☐ Against feed
- ☐ With feed

Type of feed:
- ☐ Manual feed (MAN)
- ☐ Mechanical feed (MEC)

Feed speed:	min^{-1}
Cutting width (SB):	mm
Cutting depth:	mm

Cutt. mat:
- ☐ HL
- ☐ HS
- ☐ ST
- ☐ HW
- ☐ DP

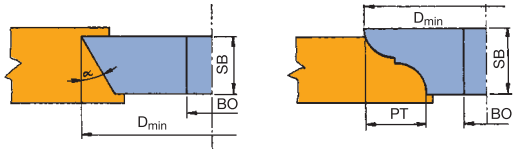
Adapter:
- ☐ No adaptor required
- ☐ Sleeve with anti-twist device
- ☐ Sleeve without anti-twist device
- ☐ Quick clamping element
- ☐ Hydro clamping element

Notes:

Zero-diameter:	mm
Max. diameter.:	mm
Zero-height:	mm
Clamping length:	mm

Application:

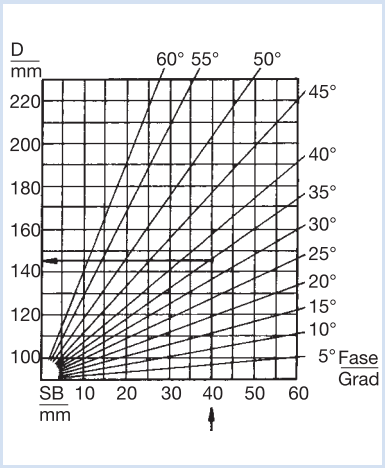
Solid wood	☐ along grain	☐ across grain	☐ end grain
Wood-derived	☐ top layer	☐ middle layer	☐ top layer and middle layer



Technical information:

Tipped tool (bevel-/profile router):
Design: BG-Test, Z 2, round design
mech. feed, Z 3, Z 4, round design,
tooth shape: with/without spurs

Chart to determine min. tool diameter:
Valid for bevel cutterblock BO – 30 mm:
For bore 40 mm:
D + 10 mm
For bore 50 mm:
D + 20 mm



Formula to determine tool diameter:
Valid for profile cutterblock BO – 30 mm:
For bore 40 mm: D + 10 mm
For bore 50 mm: D + 10 mm
Formula: D_{min} = 100 + 2 x PT (mm)

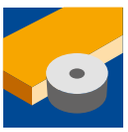
Note:
Angles exceeding 45° and large profile depths require large diameters. The maximum possible RPM for the cutterblock diameter must not be exceeded. Profile sketches or profile drawings must show clearly if the workpiece material (wood) or cutterblock is shown. Please state side to table, direction of rotation, dimensions and conditions of application on all workpiece samples or drawings.

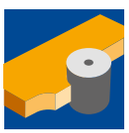
Tool combination with turnblade-/exchangeable knives:
Formula: D_{min} = 80 x 2 x PT (mm) – Valid for BO – 30 mm

Sketch for application plan, profile drawing, special motor spindle, etc.
Please specify workpiece support and fence side and/or workpiece face side top/bottom.

Key to pictograms

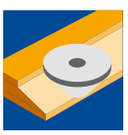

Grooving, horizontal and vertical


Jointing


Copy shaping


Rebating


Bevelling


Panel raising


Profiling


Profiling joints

Manual feed


Tipped tool

Light alloy body


Interchangeable knives


Mechanical knife clamping, reversible


Mechanical knife clamping, non-adjustable


Resharpenable cutting face


Resharpenable clearance face

Alloyed tool steel

High-speed steel

Tungsten carbide

Polycrystalline diamond (PCD)

Carbide metal coating

www.leitz.org