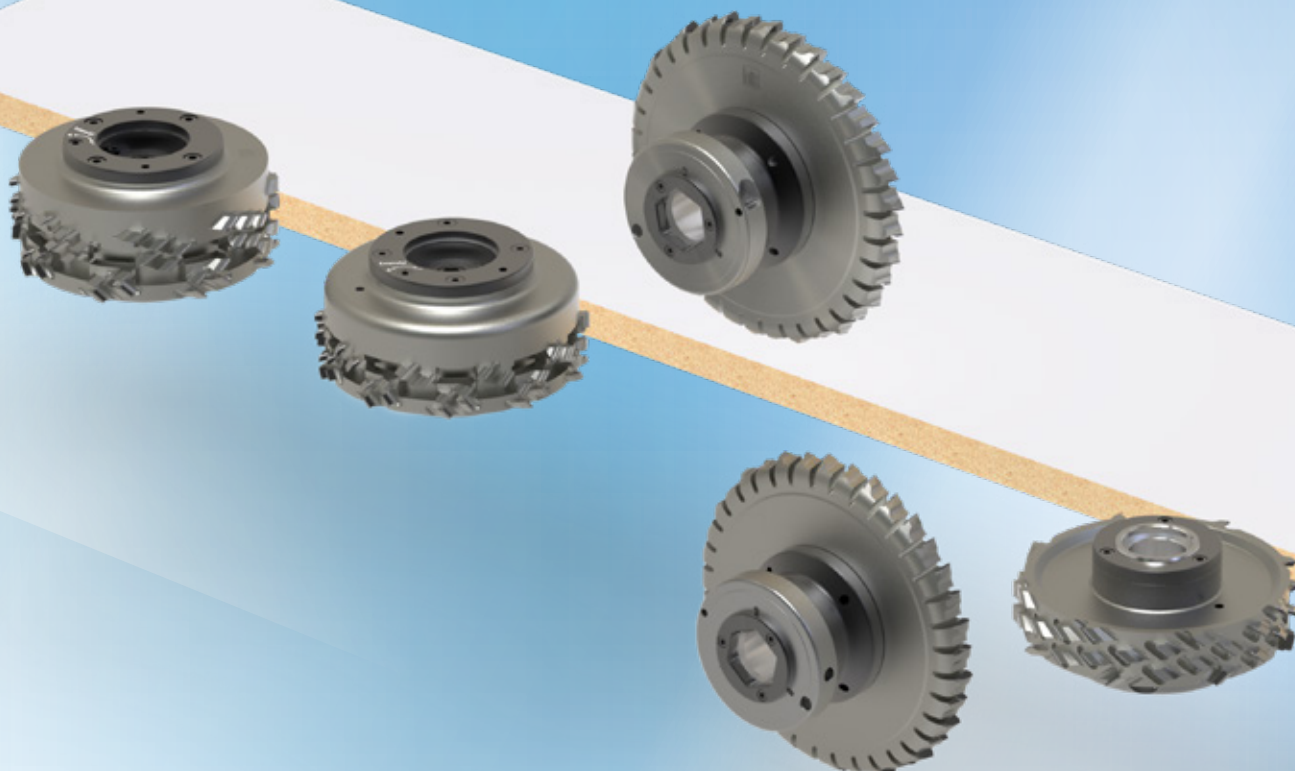


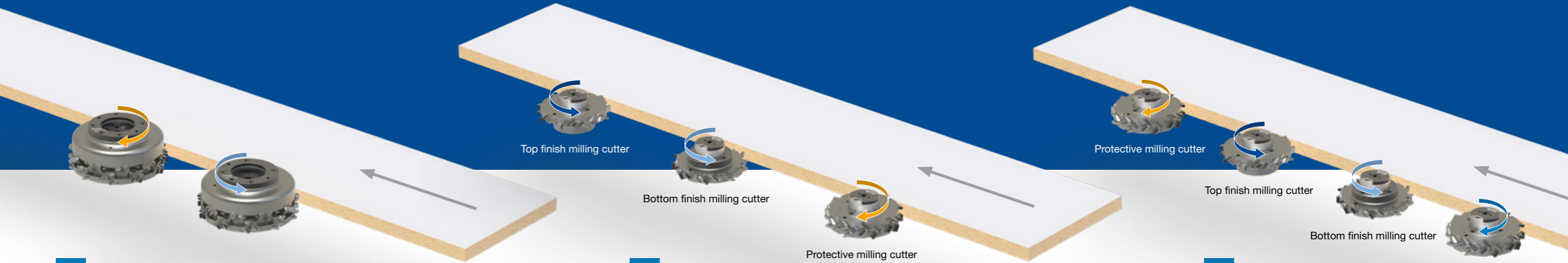
Jointing concepts

The right concept for your requirements



Six different jointing concepts for a wide range of requirements

Furniture panel processing with high quality requirements is an economic challenge in many cases due to the variety of materials. When jointing the furniture panels, there is increased wear on the tools in the area of the covering layers and the processing quality decreases. This results in high costs due to frequent tool changes and excessive stocks of replacement tools. Leitz provides the solution with the help of various jointing concepts that are optimised to the requirements of the respective customer. This enables perfect processing quality of the panel edges and significantly greater efficiency in the overall process.



1

Double jointing adjustable

- YOUR BENEFITS**
- Can be realized with two jointing spindles
 - Longer tool life compared to conventional solutions

- AT A GLANCE**
- Alternating milling
 - Tool life addition through adjustable jointing cutters
 - Jointing cutters are adjusted from the outside to the inside
 - Minimum tool diameter for HF 30 or HSK-F 63 mod. 125 mm



2

Triple jointing

- YOUR BENEFITS**
- Simple tool solution
 - Lower costs per running metre than concept 1, double jointing adjustable
 - Automated adjustment through controlled axes possible

- AT A GLANCE**
- Protective milling cutter and finish cutter
 - Work division of the finish milling cutters: finish milling cutter 1 processes lower panel area, finish milling cutter 2 processes upper panel area
 - Tool life addition through axial adjustment of the finish milling cutters



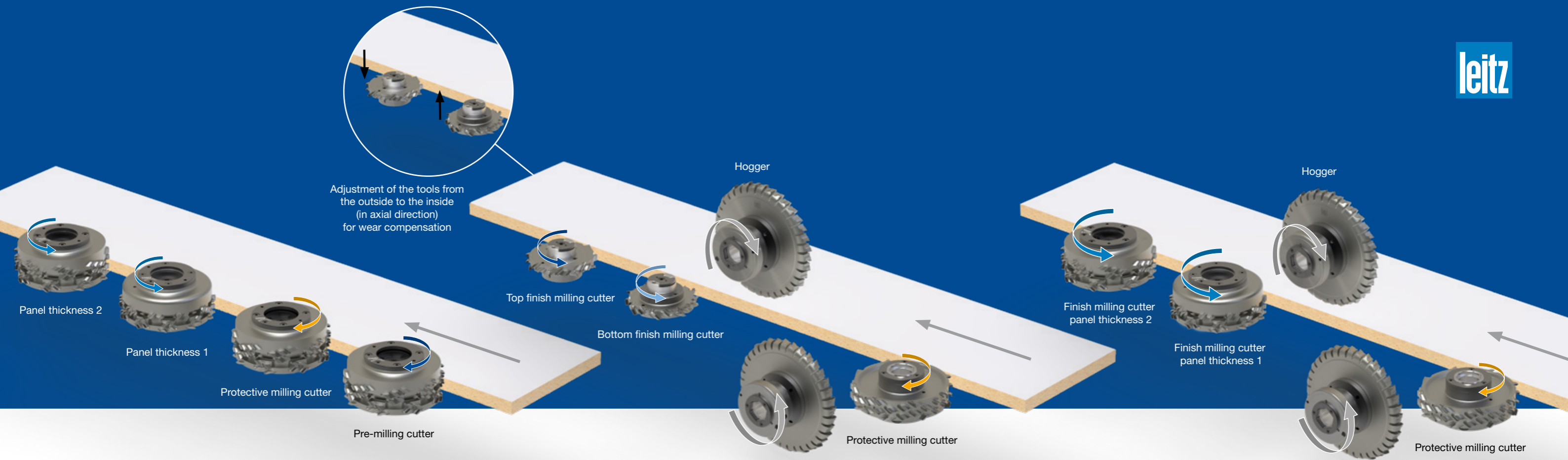
3

Quattro jointing – axially adjustable jointing cutters

- YOUR BENEFITS**
- Extension of tool life by pre-milling (difference to concept 2)
 - Low costs per running metre
 - Automated adjustment possible with controlled axes

- AT A GLANCE**
- Protective milling, pre-milling, finish milling
 - Pre-milling + 0,6 mm on finished edge
 - Work division of the finish jointing cutters: finish milling cutter 1 processes lower panel area, finish milling cutter 2 processes upper panel area
 - Tool life addition through axial adjustment of the finish milling cutters





4

Quattro jointing – adjustable jointing cutters

YOUR BENEFITS

- Two panel thicknesses possible
- Tool life extension through pre-milling
- Low costs per running metre

AT A GLANCE

- Protective milling cutter, pre-milling cutter, 2x finish for one panel thickness each – all jointing cutters adjustable
- Pre-milling with + 0,6 mm to finished edge
- Finish with 2 jointing cutters: adjustable jointing cutter 1 for panel thickness 1, adjustable jointing cutter 2 for panel thickness 2



5

Triple jointing with hoggers

YOUR BENEFITS

- Extension of tool life through pre-milling with hogger
- Lowest costs per running metre
- Automated adjustment possible through controlled axes
- Well suited for large material protrusions
- Cost-effective for large feed rates

AT A GLANCE

- Protective milling cutter and finish milling cutter
- Pre-milling with hogger + 0,6 mm to finished edge
- Work division of the finish milling cutters: finish milling cutter 1 processes lower panel area, finish milling cutter 2 processes upper panel area
- Tool life addition through axial adjustment of the finish milling cutters



6

Adjustable double jointing with hoggers

YOUR BENEFITS

- Two panel thicknesses possible
- Extension of tool life through pre-milling with hogger
- Lower costs per running metre than concept 4

AT A GLANCE

- Protective milling cutter, pre-milling cutter, finish
- Pre-milling with hogger + 0,6 mm to finished edge
- Finish with 2 jointing cutters: adjustable jointing cutter 1 for panel thickness 1, adjustable jointing cutter 2 for panel thickness 2
- Tool life addition through adjustable jointing cutters



Advantages over conventional solutions

- Consistent processing quality with a wide variety of materials
- Lower reject rate
- Longer tool life of the finish milling cutters
- More machine availability due to longer tool life

Selection matrix

	1: Double jointing adjustable	2: Triple jointing	3: Quattro jointing – axially adjustable jointing cutters	4: Quattro jointing – adjustable jointing cutters	5: Triple jointing with hoggers	6: Adjustable double jointing with hoggers
Hogger unit	X	X	X	X	●	●
2 jointing cutter spindles available	●	X	X	X	X	●
3 jointing cutter spindles available	X	●	X	X	●	X
4 jointing cutter spindles available	X	X	●	●	X	X
1 panel thickness	●	●	●	X	●	X
2 panel thicknesses	X	X	X	●	X	●
Batch size 1	X	X	X	X	X	X
Automated adjustment through controlled axes	X	●	●	X	●	X
High productivity	X	X	X	●	●	●

● suitable
X not suitable

General information



Adjustable jointing cutter Diamaster EdgeExpert

More efficiency in furniture construction

YOUR BENEFITS

- Perfect edge quality
- Up to 10 times higher tool life
- Quick and easy resetting
- High cost efficiency

By adjusting the width of the jointing cutters, unused cutting edge areas can be brought into the quality-forming cutting area of the covering layers. Perfect machining quality of the panel edges and significantly more efficiency in the overall process are possible with this Leitz solution.

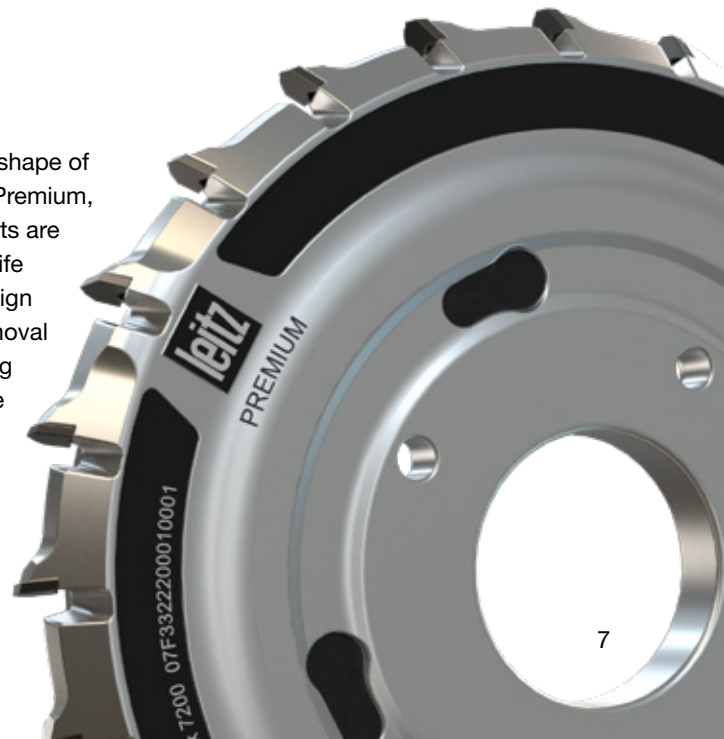
Compact hogger DT Premium

More efficiency in panel processing

YOUR BENEFITS

- Long tool life across a range of materials
- Perfect quality on the edge and machined surface

Thanks to the new tooth shape of the compact hogger DT Premium, optimum machining results are achieved over the entire life cycle of the tool. The design enables efficient chip removal and the vibration-reducing tool body further increase the tool life and thus the economic efficiency.





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