

leitz

# Tools for MDF door manufacturing



# Medium-density fibreboard (MDF) – machined precise and cost-effective

MDF is ideal for furniture fronts as it is dimensionally stable, smooth and homogeneous. It allows precise profiling and high-quality finishes. Thanks to its dimensional stability and bending strength, MDF is frequently used for kitchen, bathroom and living room furniture fronts.

Diamond-tipped tools are essential for a long tool life. To achieve consistently high machining quality, the use of high-precision ThermoGrip® shrink-fit chucks is recommended.



**QUALITY & FLEXIBILITY**

**Router cutter Diamaster PRO**

**For cleaning the inner corners.**



**QUALITY & FLEXIBILITY**

**Profile cutter Diamaster PRO Z 2**

**With different radii for the outer contour.**



**QUALITY & EFFICIENCY**

**Profile cutter Diamaster PRO Z 1**

**For precise radii in the inner contour.**

## YOUR BENEFITS

- Sharp inner contours
- Versatile use
- Can be resharpened 2–3 times

## AT A GLANCE

- Small diameters
- Long cutting length

## YOUR BENEFITS

- Precise outer contours
- Optimal chip removal
- Can be resharpened 2–3 times

## AT A GLANCE

- Slightly positive shear angle
- For panel thicknesses of 18 and 19 mm
- Radius 1 to 6 mm

## YOUR BENEFITS

- Precise inner contours
- Optimal chip removal
- Can be resharpened 2–3 times

## AT A GLANCE

- Slightly positive shear angle
- Radii in the inner contour
- Radius 3 mm



**QUALITY & FLEXIBILITY**

V-groove router cutter  
Diamaster PRO Z 2

For 45° grooves or chamfers.



**FLEXIBILITY & SUSTAINABILITY**

Profile cutter Diamaster  
PRO Z 2

For face milling MDF with  
rounded corners.



**PRODUCTIVITY & QUALITY**

Planing cutter Diamaster  
PLUS Z 2+2

For face milling MDF.

**YOUR BENEFITS**

- Seamless cut
- Runs very smoothly
- Can be resharpened 2–3 times

**YOUR BENEFITS**

- Versatile use
- For face milling
- Can be resharpened 2–3 times

**YOUR BENEFITS**

- High feed rates possible
- Excellent surface finish
- Can be resharpened 5–8 times

**AT A GLANCE**

- 20 mm cutting length
- For chamfering and grooving
- Extremely long tool life

**AT A GLANCE**

- Diameter 40 mm
- Corner radius 1 mm
- Slightly positive shear angle

**AT A GLANCE**

- Diameter 50 mm
- Slightly positive shear angle

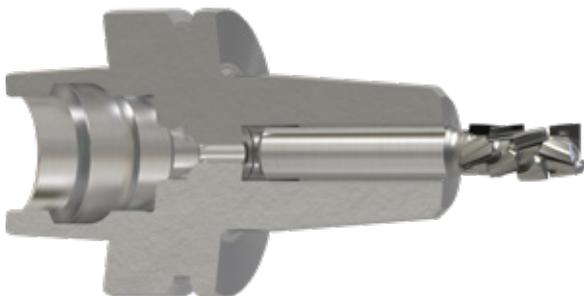
# Ordering information

Description	Application	Cutting material	Standard values for cutting parameters			Dimensions	ID	Availability
			Feed rate [m/min]	RPM [1/min]	Tooth feed rate [mm]			
Router cutter Diamaster PRO Z 1	Acute corners, Grooving	DP	2-3	18,000-24,000	0.1-0.15	D5/GL60/NL12/S8x35/Z1/RL	191086	•
Router cutter Diamaster PRO Z 2	Acute corners, Grooving	DP	3-5	18,000-24,000	0.05-0.15	D6/GL60/NL22/S6x30/Z2/RL	191131	•
Profile cutter Diamaster PRO Z 2	Outer contour corner radius 1 mm, panel thickness 18 mm	DP	10-15	18,000-24,000	0.5-0.65	DP/D27.5/NL18.5/R1/S20x50/GL77	245504	□
	Outer contour corner radius 2 mm, panel thickness 18 mm	DP	10-15	18,000-24,000	0.5-0.65	DP/D27.5/NL18.5/R2/S20x50/GL77	245505	•
	Outer contour corner radius 3 mm, panel thickness 18 mm	DP	10-15	18,000-24,000	0.5-0.65	DP/D27.5/NL18.5/R3/S20x50/GL77	245506	•
	Outer contour corner radius 4 mm, panel thickness 18 mm	DP	10-15	18,000-24,000	0.5-0.65	DP/D27.5/NL18.5/R4/S20x50/GL77	245507	□
	Outer contour corner radius 5 mm, panel thickness 18 mm	DP	10-15	18,000-24,000	0.5-0.65	DP/D27.5/NL18.5/R5/S20x50/GL77	245508	□
	Outer contour corner radius 6 mm, panel thickness 18 mm	DP	10-15	18,000-24,000	0.5-0.65	DP/D27.5/NL18.5/R6/S20x50/GL77	245509	□
	Outer contour corner radius 1 mm, panel thickness 19 mm	DP	10-15	18,000-24,000	0.5-0.65	DP/D27.5/NL19.5/R1/S20x50/GL78	245510	□
	Outer contour corner radius 2 mm, panel thickness 19 mm	DP	10-15	18,000-24,000	0.5-0.65	DP/D27.5/NL19.5/R2/S20x50/GL78	245511	•
	Outer contour corner radius 3 mm, panel thickness 19 mm	DP	10-15	18,000-24,000	0.5-0.65	DP/D27.5/NL19.5/R3/S20x50/GL78	245512	•
	Outer contour corner radius 4 mm, panel thickness 19 mm	DP	10-15	18,000-24,000	0.5-0.65	DP/D27.5/NL19.5/R4/S20x50/GL78	245513	□
	Outer contour corner radius 5 mm, panel thickness 19 mm	DP	10-15	18,000-24,000	0.5-0.65	DP/D27.5/NL19.5/R5/S20x50/GL78	245514	□
	Outer contour corner radius 6 mm, panel thickness 19 mm	DP	10-15	18,000-24,000	0.5-0.65	DP/D27.5/NL19.5/R6/S20x50/GL78	245515	□
	Profile cutter Diamaster PRO Z 1	Inner contour radius 3 mm	DP	5-8	18,000-24,000	0.25-0.35	DP/D14.5/2.5/NL4/S20x55/GL71	191134
V-groove router cutter Diamaster PRO Z 2	45° grooves and chamfers	DP	2-3	18,000-24,000	0.05-0.15	DP/D40/NL20/S20x55/GL90/Z2	191138	•
Profile cutter Diamaster PRO Z 2	Face milling with a corner radius of 1 mm	DP	3-8	18,000-24,000	0.15-0.35	DP/D40/NL12/R1/S20x55/GL70/Z2	191146	•
Planing cutter Dia- master PLUS Z 2+2	Face milling at high feed rates	DP	5-8	18,000-24,000	0.1-0.2	DP/D50/NL18/S20x55/GL82/Z2+2	191137	•
Shrink-fit chuck ThermoGrip® HSK-F 63	For shank diameter 6 mm					d6/D27/A75/L100/HSK-F63	037713	•
	For shank diameter 8 mm					d8/D27/A75/L100/HSK-F63	037714	•
	For shank diameter 20 mm					d20/D42/A75/L100/HSK-F63	037710	•

All tools listed above are suitable for plunging.

- available ex stock
- available at short notice

## ThermoGrip® shrink-fit chuck – the tool chuck for high-performance machining



### AT A GLANCE

- Precision-balanced design for speeds up to 36,000 rpm
- Short, slim design for improved chip flow to the extraction system
- For clamping of carbide and steel shanks
- Clamping eccentricity  $e \leq 0,01$  mm



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