

Sawing

Leitz Lexicon Edition 7

Version 3

11/2024



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
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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
$f_{z\text{ eff}}$	= 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
I	= clamping length
LD	= left hand twist
LEN	= Leitz standard profiles

LH	= left hand rotation
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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
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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
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V	= number of spurs
v_c	= cutting speed
v_f	= feed speed
VE	= packing unit
VSB	= adjustment range

WSS	= workpiece material
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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.

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125	3,2	22	24	HW	KON/WZ	5	165551	48
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150	4,4	45	28	HW	KON/WZ	5	165558	48, 53
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210	2,4	30	24	HW	WZ	15	166133	75
210	2,4	30	42	HW	WZ	20	166134	75
210	2,8	30	60	HW	WZ	-5	166252	77
210	2,8	30	60	HW	FZ/TR	-5	166358	79
210	3,2	30	18	HW	FZ	20	165109	19
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216	3,0	30	48	HW	WZ	-5	166254	77
216	3,0	30	64	HW	WZ	-5	166255	77
216	3,0	30	64	HW	FZ/TR	-5	166359	79
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220	1,3	60	32	HW	FZ	25	057478	12
220	1,3	65	24	HW	FZ	25	057477	12
220	1,3	65	32	HW	FZ	25	057479	12
220	1,4	60	32	HW	FZ	20	057464	12
220	1,4	60	24	HW	FZ	25	057480	12
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220	2,5	30	45	DP	HZFA/ WZFA	10	190717	71
220	2,5	40	45	DP	HZFA/ WZFA	10	190718	71
220	3,0	30	70	HW	WZ/WZ/FZ	10	161255	70
220	3,0	40	70	HW	WZ/WZ/FZ	10	161256	70
220	3,1	45	48	DP	KON/FZ	10	190744	50
220	3,2	30	72	HW	FZ/TR	-5	166360	79
220	3,2	30	64	HW	FZ/TR	10	163000	34
220	3,2	30	42	HW	HZ/DZ	10	163050	33
220	3,2	30	36	HW	WZ	10	163110	27
220	3,2	30	60	HW	WZ	10	163111	27
220	3,2	30	60	HW	WZ	10	166107	75
220	3,2	30	34	HW	WZ	15	166136	75
220	3,2	45	60	HW	KON/FZ	5	165638	49
220	3,35	30	48	HW	FZ/TR	10	165676	51
220	3,8	60	24	HW	WZ	20	165260	13
220	3,8	60	24	HW	WZ	20	165262	13
220	3,8	65	24	HW	WZ	20	165261	13
220	5,0	30	24	HW	FZ	20	165251	13
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225	1,6	60	32	HW	FZ	25	057482	12
225	1,8	60	25	HW	FZ	20	057448	12
225	2,0	40	40	HW	FZ	20	163600	12
225	2,0	60	25	HW	FZ	20	057449	12
225	2,2	30	64	HW	FZFA/FZFA	0	163533	80
225	2,4	30	24	HW	FZ	15	165304	18
225	2,6	30	68	HW	FZ/TR	-5	166361	79
225	2,6	30	48	HW	WZ	10	166138	75
225	2,6	30	32	HW	WZ	20	166137	75
225	2,8	30	24	HW	FZ	15	165305	18

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225	5,0	30	24	HW	FZ	20	165252	13
225	5,0	60	40	HW	FZ	20	165256	13
230	2,5	30	48	HW	WZ	15	166108	75
230	2,5	30	24	HW	WZ	20	166140	75
230	3,2	30	34	HW	WZ	15	166141	75
235	2,5	30	24	HW	WZ	15	166156	75
235	2,5	30	56	HW	WZ	15	166157	75
235	3,2	30	24	HW	WZ	15	166142	75
235	3,2	30	34	HW	WZ	15	166143	75
240	2,5	30	50	DP	HZFA/ WZFA	10	190719	71
240	2,5	40	50	DP	HZFA/ WZFA	10	190720	71
240	2,8	40	24	HW	FZ	15	165306	18
240	3,0	30	75	HW	WZ/WZ/FZ	10	161257	70
240	3,0	30	48	HW	WZ	10	166145	75
240	3,0	30	34	HW	WZ	15	166144	75
240	3,0	40	75	HW	WZ/WZ/FZ	10	161258	70
240	3,0	40	30	HW	WZ	15	165337	25
250	1,7	30	80	HW	WZ	10	058520	29
250	1,7	60	36	HW	FZ	20	057433	12
250	1,7	60	25	HW	FZ	20	057450	12
250	2,0	30	100	HW	FZFA/FZFA	-5	060275	62
250	2,0	60	36	HW	FZ	20	057434	12
250	2,0	60	25	HW	FZ	20	057451	12
250	2,0	80	36	HW	WZ	15	163576	16
250	2,0	100	48	DP	FZ	3	190678	56
250	2,0	100	48	DP	FZ	3	190679	56
250	2,0	115	48	DP	FZ	3	190680	56
250	2,2	100	36	DP	FZ	3	190681	56
250	2,2	100	36	DP	FZ	3	190682	56
250	2,2	100	48	DP	FZ	3	190684	56
250	2,2	100	48	DP	FZ	3	190685	56
250	2,2	115	36	DP	FZ	3	190683	56
250	2,2	115	48	DP	FZ	3	190686	56
250	2,4	30	48	HW	WZ	-5	166256	77
250	2,4	30	60	HW	WZ	-5	166257	77
250	2,4	30	40	HW	WZ	10	163112	27
250	2,4	30	80	HW	WZ	10	163113	27
250	2,4	30	24	HW	FZ	20	163558	17
250	2,4	40	24	HW	FZ	20	163552	17
250	2,4	60	24	HW	FZ	20	163700	17
250	2,4	60	40	HW	FZ	20	163701	17
250	2,4	70	24	HW	FZ	20	163553	17
250	2,4	80	32	HW	WZ	15	163577	16
250	2,4	80	40	HW	WZ	15	163509	18
250	2,4	80	24	HW	FZ	20	163554	17
250	2,5	30	50	DP	HZFA/ WZFA	10	190721	71
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250	2,8	30	60	HW	WZ	20	166147	76
250	2,8	30	24	HW	WZ	25	166146	76
250	2,8	70	24	HW	FZ	15	165308	18
250	3,0	30	80	HW	WZ/WZ/FZ	10	161259	70
250	3,2	30	48	HW	HZ/DZ	-5	163076	33
250	3,2	30	80	HW	WZ	-5	163225	28
250	3,2	30	80	HW	WZ	-5	166258	77
250	3,2	30	60	HW	FZ/TR	-5	166362	79

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250	3,2	30	80	HW	FZ/TR	5	166306	78	300	2,8	80	28	HW	WZFA	15	165310	18
250	3,2	30	54	HW	HZ/DZ	10	161300	32	300	2,8	80	48	HW	TR/TR	15	165311	18
250	3,2	30	60	HW	FZ/TR	10	163002	34	300	2,8	80	30	HW	FZ	25	163556	17
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250	3,2	30	48	HW	HZ/DZ	10	163051	33	300	3,0	30	96	HW	FZFA/FZFA	5	161006	63
250	3,2	30	40	HW	WZ	10	163114	27	300	3,0	50	100	HW	WZ/WZ/FZ	10	161266	70
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250	3,2	30	80	HW	WZ	10	163116	27	300	3,2	30	96	HW	FZ/TR	-5	161381	61
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250	3,2	30	48	DP	DZ/TR	10	190748	67	300	3,2	30	96	HW	WZ	-5	165515	23
250	3,2	30	60	HW	TR/TR	15	161135	45	300	3,2	30	72	HW	FZ/TR	-5	165825	60
250	3,2	30	18	HW	FZ	20	165110	19	300	3,2	30	96	HW	FZ/TR	-5	165826	60
250	3,2	30	18	HW	FZ	20	166050	20	300	3,2	30	120	HW	FZ/TR	-5	165827	60
250	3,2	30	24	HW	WZ	20	166076	20	300	3,2	30	96	HW	FZ/TR	5	161360	59
250	3,2	32	60	HW	FZ/TR	5	166307	78	300	3,2	30	96	HW	FZ/TR	5	161361	59
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250	3,2	40	80	HW	FZ/TR	5	166309	78	300	3,2	30	72	HW	FZ/TR	5	165726	58
250	3,2	70	20	HW	WZ	20	165200	15	300	3,2	30	96	HW	FZ/TR	5	165727	58
250	3,2	100	48	HW	FZ	10	061434	56	300	3,2	30	8	DP	P	5	190305	83
250	3,5	30	18	HW	FZ	25	165008	14	300	3,2	30	72	HW	FZ/TR	10	163005	34
250	3,5	80	18	HW	FZ	25	165009	14	300	3,2	30	96	HW	FZ/TR	10	163006	34
250	3,8	60	24	HW	WZ	20	165264	13	300	3,2	30	36	HW	WZ	10	163119	27
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250	4,4	30	42	HW	KON/FZ	5	165639	49	300	3,2	30	72	HW	WZ	10	163121	27
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250	4,4	80	18	HW	FZ	25	165001	14	300	3,2	30	72	HW	TR/TR	15	161138	45
250	4,55	30	48	HW	FZ/TR	10	165677	51	300	3,2	30	72	HW	TR/TR	15	161139	45
250	5,0	30	24	HW	FZ	20	165253	13	300	3,2	30	72	HW	TR/TR	15	163370	44
250	5,0	30	36	HW	FZ	20	165254	13	300	3,2	30	24	HW	FZ	20	165111	19
250	8,0	80	24	HW	FZ	15	165257	13	300	3,2	30	28	HW	WZ	20	166077	20
254	2,2	30	72	HW	FZFA/FZFA	0	163534	80	300	3,2	32	72	HW	FZ/TR	-5	165828	60
255	2,8	30	60	HW	WZ	-5	166259	77	300	3,2	32	96	HW	FZ/TR	-5	165829	60
255	2,8	30	80	HW	WZ/WZ/FZ	10	161200	30	300	3,2	32	120	HW	FZ/TR	-5	165830	60
260	2,4	30	68	HW	FZ/TR	-5	166364	79	300	3,2	70	24	HW	WZ	20	165201	15
260	2,5	30	60	HW	WZ	-5	166250	77	300	3,4	80	28	HW	FZ	15	165312	18
260	2,5	30	80	HW	WZ	-5	166251	77	300	3,5	30	96	HW	WZ	-5	161330	24
260	3,2	30	60	HW	WZ	10	166148	76	300	3,5	30	96	HW	WZ	-5	161331	24
270	2,4	60	28	HW	FZ	20	163702	17	300	3,5	30	96	HW	WZ	5	163200	28
275	3,2	30	88	HW	FZ/TR	-5	166365	79	300	3,5	30	14	HW	FZ	20	166051	20
275	3,4	40	72	HW	FZ/TR	5	166310	78	300	3,5	30	20	HW	FZ	25	165010	14
280	2,5	30	55	DP	HZFA/ WZFA	10	190722	71	300	3,5	70	20	HW	FZ	25	165011	14
280	3,0	30	85	HW	WZ/WZ/FZ	10	161260	70	300	3,5	80	20	HW	FZ	25	165012	14
280	3,2	30	60	HW	FZ/TR	10	163004	34	300	3,6	30	20	HW	FZ/TR	10	163500	65
280	3,2	30	48	HW	WZ	10	166149	76	300	3,6	30	42	HW	FZ/TR	10	163501	65
280	3,2	30	60	HW	WZ	10	166150	76	300	4,0	30	24	HW	FZ	20	165102	19
280	3,2	30	60	HW	TR/TR	15	161136	45	300	4,0	80	28	HW	TR/TR	15	165313	18
280	3,2	32	96	HW	FZ/TR	5	165725	58	300	4,0	80	48	HW	TR/TR	15	165314	18
280	4,4	30	48	HW	KON/FZ	5	165640	49	300	4,3	30	48	DP	KON/FZ	10	190743	50
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300	5,0	30	20	HW	FZ	25	165002	14
300	8,0	80	24	HW	FZ	15	165258	13
303	3,2	30	60	HW	HZ/DZ	-5	163077	33
303	3,2	30	100	HW	WZ/WZ/FZ	10	161201	30
303	3,2	30	68	HW	HZ/DZ	10	161301	32
303	3,2	30	60	HW	HZ/DZ	10	163054	33
303	3,2	30	60	DP	DZ/TR	10	190673	67
303	3,2	30	96	DP	DZ/TR	10	190674	67
303	3,2	30	60	DP	HZFA/ WZFA	10	190698	31
303	3,2	30	60	DP	HZFA/ WZFA	10	190728	71
303	3,5	30	96	HW	WZ	-5	163226	28
303	3,5	30	60	HW	TR/TR	10	161028	64
303	3,5	30	60	HW	HZ/DZ	10	163052	33
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310	4,4	60	72	HW	TR/TR	15	161144	45
310	4,4	60	72	HW	FZ/TR	15	163405	42
315	3,0	30	48	HW	WZ	15	166152	76
315	3,2	30	72	HW	WZ	10	166153	76
315	3,2	30	28	HW	WZ	20	166151	76
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330	3,2	30	96	HW	FZ/TR	-5	165831	60
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350	3,2	30	108	HW	FZ/TR	5	165730	58
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350	3,5	30	96	HW	FZFA/FZFA	5	161007	63
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350	3,5	30	84	HW	FZ/TR	10	163007	34
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350	3,5	30	72	HW	HZ/DZ	10	163053	33
350	3,5	30	54	HW	WZ	10	163123	27
350	3,5	30	72	HW	WZ	10	163124	27
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350	3,5	70	28	HW	WZ	20	165203	15
350	3,6	30	16	HW	WZ	15	165975	69
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350	4,4	60	72	HW	TR/TR	15	163380	44, 52-53
350	4,4	60	72	HW	FZ/TR	15	163409	42, 52-53
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360	4,4	30	72	HW	TR/TR	15	163382	44, 54
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380	4,4	60	72	HW	TR/TR	15	163384	44, 53
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400	3,5	30	96	HW	WZ	10	163130	27
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D mm	SB mm	BO mm	Z	QAL	ZF	SW °	ID	Page
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460	4,4	30	72	HW	FZ/TR	15	163434	43, 54
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470	4,8	70	72	HW	TR/TR	15	163392	45
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D mm	SB mm	BO mm	Z	QAL	ZF	SW °	ID	Page
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500	4,4	30	120	HW	FZ/TR	-5	165848	60
500	4,4	30	120	HW	FZ/TR	5	165740	58
500	4,4	30	100	DP	HZFA	5	762341	63
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520	4,8	70	72	HW	FZ/TR	15	163444	43
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550	4,4	30	110	DP	HZFA	5	762342	63
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550	5,2	80	60	HW	WZ	15	163318	41
555	5,2	55	54	HW	WZ	20	165325	25
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600	4,6	30	140	HW	FZ/TR	5	165747	58
600	4,8	30	120	DP	HZFA	5	762343	63
600	4,8	30	60	HW	WZ	20	166083	20
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D mm	SB mm	BO mm	Z	QAL	ZF	SW °	ID	Page
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600	5,4	80	42	HW	WZ	25	165207	15
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600	5,8	60	60	HW	FZ/TR	22	163446	43, 52
600	5,8	60	72	HW	FZ/TR	22	163447	43, 52
600	6,0	30	48	HW	WZ	15	057570	25
600	7,0	75	16	HW	WZ	20	165329	25
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630	5,4	30	180	HW	WZ	10	165462	22
640	5,4	30	36	HW	WZ	20	165330	25
650	5,0	30	144	HW	FZ/TR	5	165749	58
670	5,8	60	42	HW	FZ/TR	22	163448	43
680	5,5	40	42	HW	FZFA/FZFA	10	165934	66
680	6,2	40	60	HW	FZ/TR	22	163449	43, 54
700	4,2	30	42	HW	WZ	20	166611	76
700	4,8	30	60	HW	WZ	20	166084	20
700	5,5	30	200	HW	WZ	10	165463	22
700	6,0	30	72	HW	WZ	15	165334	25
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720	6,5	40	60	HW	FZ/TR	22	163451	43, 54
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750	6,0	30	72	HW	WZ	15	165335	25
750	7,0	80	70	HW	FZ/TR	22	163453	43
800	6,0	30	72	HW	WZ	15	165336	25
850	8,0	30	60	HW	WZ	20	165331	25

1. Sawing

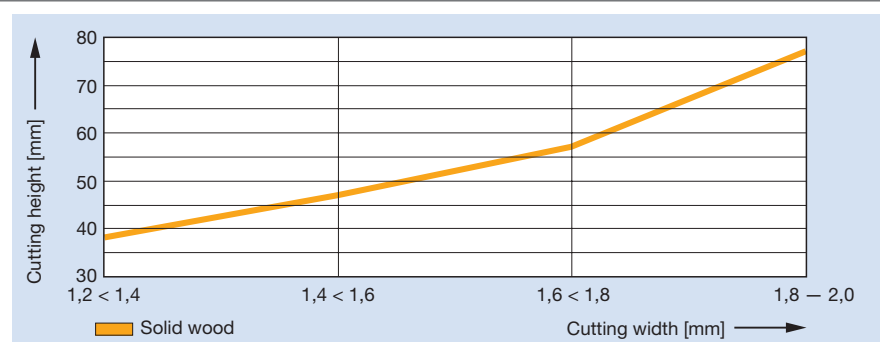
1.1 Solid wood cutting along grain

Application	For splitting or edging timber, for cutting lamellae on horizontal and vertical spindles.		
Workpiece material	Softwood and hardwood, wet, frozen, dry or long fibre materials.		
Machine	Edging, single blade, multi blade sawblades as well as sawblades with either one or two spindles. Circular saw benches or moulders.		
Tooth shape	 	FZ (square teeth): For multi-purpose application – particularly suitable for wet and dry wood.	
	 	TR (trapezoidal teeth): Recommended for cutting dry wood with minimum marking.	
	 	WZ (alternative top bevel teeth): Ideal for long-fibred wood. Higher quality on the exit surface.	

Thin kerf sawblades

Application area	– Sawmill industry (laminating strips, lumber etc.). – Solid board production (lamellos and core materials for multiple layer panels etc.). – Parquet flooring industry (for core and surface materials, lamellos). – Moulding products (mouldings, lippings, rulers etc.). – Sport industry (skis, table tennis rackets etc.).
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Cutting height diagram



Thin kerf circular sawblades –
Cutting height depends on the sawblade cutting width SB.

Technical notes

- Recommendations:
- Mount thin kerf sawblades on hydro sleeves.
 - Check the sawblade clamping flange diameter.
 - Check the cutting height and the tooth progression (feed rate).
 - Resharpen and clean resin residues regularly.

1. Sawing

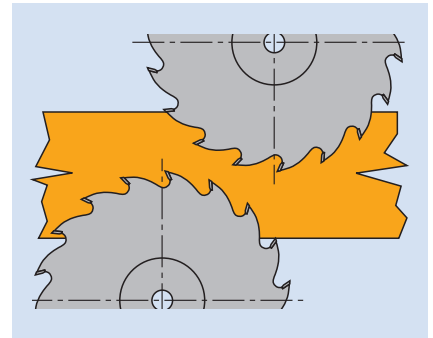
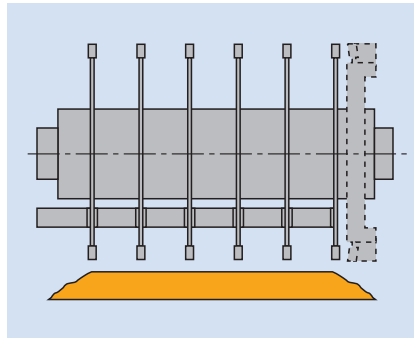
1.1 Solid wood cutting along grain

Advantages

- Environmentally friendly use of resources.
- Reduced chips and dust.
- Optimised timber usage.
- More strips from workpiece with standard cuts.

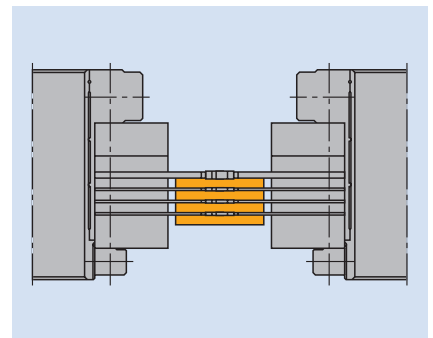
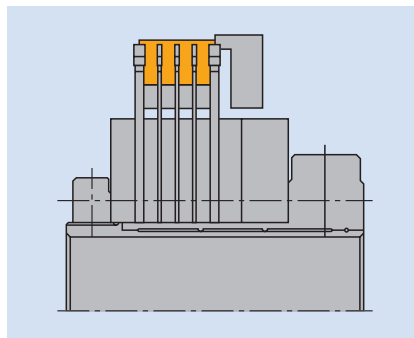
Machine types

Single or multi spindle multi blade machines without automatic feed



To avoid bending the sawblade, we recommend using wide sawblades or hoggers on the motorside. Riving knives are recommended when cutting thin lamella; a split machine table is necessary.

Multi spindle machines with automatic feed (for horizontal and vertical cutting)

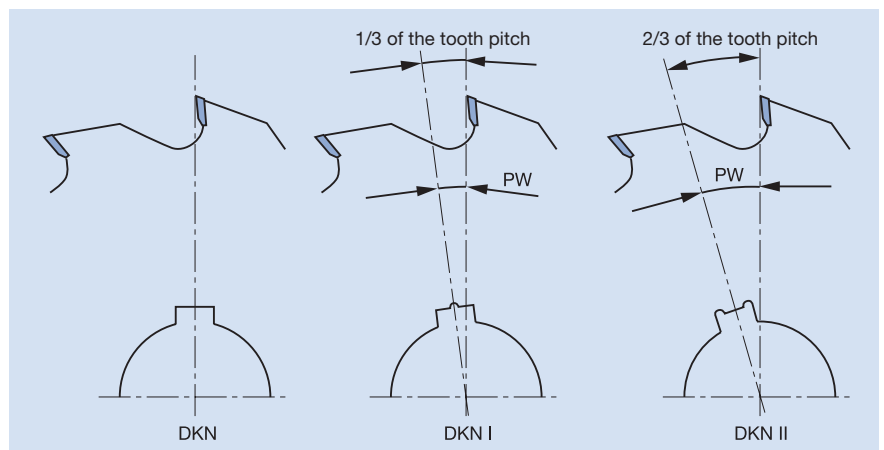


The saw spindle should have high precision bearings for accuracy.

Precise and stable feeding devices needed for bent, curved or twisted materials.

- Accurate adjustment of spindle and guide needed when sawing vertically (top and bottom side spindles).
- For horizontal cutting, the thickness of riving knives depends on the cutting width of the sawblades. The riving knives must be aligned 100% horizontal.

Position of double keyways for spiral arrangement of circular sawblades



1. Sawing

1.1 Solid wood cutting along grain

1.1.1 Circular sawblades thin kerf



Premium lamella cut - middle cut with extremely reduced cutting width

Application:

For cutting strips and slats along grain on horizontal and vertical spindles.

Machine:

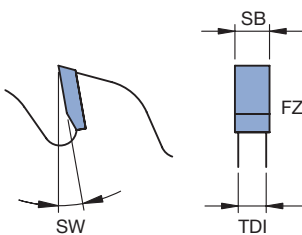
Moulders with/without forced guidance of workpieces. Application on single, double, horizontal or vertical spindles.

Workpiece material:

Softwood and hardwood, dry up to 10 % wood moisture content, quality category 0 to 1.

Technical information:

Noise-reduced and low vibration design due to irregular tooth pitch or odd number of teeth. Cutting width reduction for high wood savings and efficient energy utilisation. Continuous tool body without recess for max. cutting height. Different number of teeth for optimal tooth feeds with different feed speed. Higher cutting performance and less resinification due to special coating of the tool body. Use on hydro sleeves or clamping arbors is recommended, as is the use of high precision spacers to increase the performance of the saws. It is essential to pay attention to the setting of machines with riving knives.



Middle cut

WK 100 2 21

D	SB	TDI	BO	BO _{max}	NLA	FLD	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm			°		
180	1,3	0,8	60	70	3/10/75	100	32	FZ	20	■	057418 ●
180	1,5	1,0	60	70	3/10/75	100	21	FZ	20	■	057443 ●
180	1,8	1,2	60	70	3/10/75	100	21	FZ	20	■	057444 ●
180	1,8	1,3	60	70	3/10/75	100	32	FZ	20	■	057412 ●
200	1,5	1,0	60	80	3/10/75	120	21	FZ	20	■	057445 ●
200	1,5	1,0	60	80	3/10/75	120	36	FZ	20	■	057421 ●
200	1,8	1,2	60	80	3/10/75	120	21	FZ	20	■	057446 ●
220	1,2	0,9	60	80	3/10/75	120	27	FZ	20	■	057475 ●
220	1,2	0,9	65	80	3/11/80	120	24	FZ	20	■	057474 ●
220	1,3	0,9	60	80	3/10/75	120	24	FZ	25	■	057476 ●
220	1,3	0,9	60	80	3/10/75	120	32	FZ	25	■	057478 ●
220	1,3	0,9	65	80	3/11/80	120	24	FZ	25	■	057477 ●
220	1,3	0,9	65	80	3/11/80	120	32	FZ	25	■	057479 ●
220	1,4	1,0	60	80	3/10/75	120	24	FZ	25	■	057480 ●
220	1,4	1,0	60	80	3/10/75	120	32	FZ	20	■	057464 ●
220	1,4	1,0	65	80	3/11/80	120	24	FZ	25	■	057481 ●
220	1,4	1,0	65	80	3/11/80	120	32	FZ	20	■	057465 ●
225	1,5	1,0	60	110	3/10/75	120	25	FZ	20	■	057447 ●
225	1,6	1,2	60	110	3/10/75	130	32	FZ	25	■	057482 ●
225	1,8	1,2	60	110	3/10/75	120	25	FZ	20	■	057448 ●
225	2,0	1,4	40	110	3/10/75	120	40	FZ	20	■	163600 ●
225	2,0	1,4	60	110	3/10/75	120	25	FZ	20	■	057449 ●
250	1,7	1,2	60	120	3/10/75	140	25	FZ	20	■	057450 ●
250	1,7	1,2	60	120	3/10/75	140	36	FZ	20	■	057433 ●
250	2,0	1,4	60	120	3/10/75	140	25	FZ	20	■	057451 ●
250	2,0	1,4	60	120	3/10/75	140	36	FZ	20	■	057434 ●



Lamella cut - shoulder cut

Application:

For cutting along grain - shoulder cuts in combination with middle cut sawblades.

Machine:

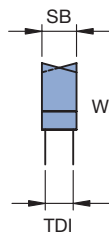
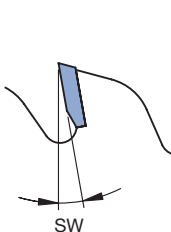
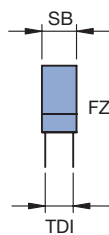
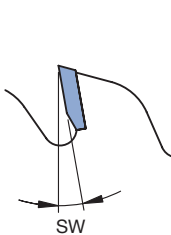
Moulders with/without forced guidance of workpieces. Application on single, double, horizontal or vertical spindles.

Workpiece material:

Softwood and hardwood, dry up to 10 % wood moisture content, quality category 0 to 1.

Technical information:

Suitable for utilisation as a set in combination with thin kerf sawblades for middle cuts. Solid design to increase the rigidity of the set. Higher cutting performance and less resin formation by special coated toolbody.



Shoulder cuts

WK 100 2 21

D	SB	TDI	BO	NLA	DKN	FLD	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm			°		
200	5,0	4,0	30	3/10/75		120	24	FZ	20	■	165250 ●
220	5,0	4,0	30	3/10/75		120	24	FZ	20	■	165251 ●
225	5,0	4,0	30	3/10/75		120	24	FZ	20	■	165252 ●
225	5,0	4,0	60	3/10/75		120	40	FZ	20	■	165256 ●
250	5,0	4,0	30	3/10/75		140	24	FZ	20	■	165253 ●
250	5,0	4,0	30	3/10/75		140	36	FZ	20	■	165254 ●
250	8,0	6,0	80	4/7/95	13/89	100	24	FZ	15	■	165257 ●
				2/13/100							
300	8,0	6,0	80	4/7/95	13/89	100	24	FZ	15	■	165258 ●
				2/13/100							

Technical information:

Suitable for utilisation as a set in combination with thin kerf sawblades for middle cuts. Special cutting edge geometry for cut pitch and lower cutting forces. For cutting pressure reduction and reduction of burn marks even at lower feed rates. Higher cutting performance and less resin formation by special coated toolbody.

Shoulder cuts - reduced number of teeth

WK 150 2, WK 150 2 21

D	SB	TDI	BO	NLA	FLD	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm			°		
180	3,8	3,0	60	3/10/75	100	24	WZ	20	■	165255 ●
				3/11/80						
200	3,8	3,0	60	3/10/75	100	24	WZ	20	■	165259 ●
				3/11/80						
220	3,8	3,0	60	3/10/75	120	24	WZ	20	■	165260 ●
				3/11/80						
220	3,8	3,0	65	3/10/75	120	24	WZ	20	■	165261 ●
				3/11/80						
220	3,8	3,0	60	3/10/75	120	24	WZ	20	■	165262 ●
				3/11/80						
225	3,8	3,0	60	3/10/75	120	24	WZ	20	■	165263 ●
				3/11/80						
250	3,8	3,0	60	3/10/75	120	24	WZ	20	■	165264 ●
				3/11/80						

1. Sawing

1.1 Solid wood cutting along grain 1.1.2 Circular sawblades with wiper teeth



Lamella cut with internal and external wiper teeth

Application:

For cutting along grain - shoulder and trimming cuts.

Machine:

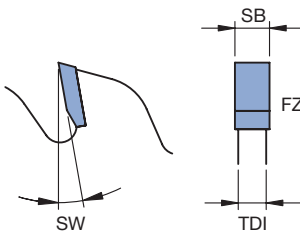
Edging, single blade, multi blade saws as well as saws with one or two spindles.

Workpiece material:

Softwood and hardwood wet, frozen, dry. Long fibre materials (poplar, balsa etc.)

Technical information:

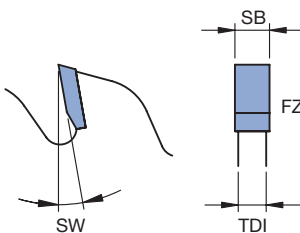
With two internal and external (from D 280 mm) raker blades. Solid design especially for edge cuts. Large lateral tooth protrusions. For universal use in dry, wet and frozen soft and hard woods. Higher cutting performance and less resinification due to special coating of the tool body.



Square and shoulder cut

WK 150 2

D	SB	TDI	BO	BO _{max}	NLA	DKN	FLD _{max}	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm	mm			°		
250	4,4	2,8	30	80	KNL		130	18	FZ	25	■	165000 ●
250	4,4	2,8	80		6/5,5/91	19/89	130	18	FZ	25	■	165001 ●
					4/6,6/95	13/89						
					2/13/100							
300	5,0	3,2	30	80	KNL		110	20	FZ	25	■	165002 ●
350	5,0	3,2	30	100	KNL		130	24	FZ	25	■	165003 ●
350	5,0	3,2	80	100	6/5,5/91	19/89	130	24	FZ	25	■	165004 ●
					4/6,6/95	13/89						
					2/13/100							
400	5,0	3,2	30	120	KNL		150	28	FZ	25	■	165005 ●
400	5,0	3,2	80	120	6/5,5/91	19/89	150	28	FZ	25	■	165006 ●
					4/6,6/95	13/89						
					2/13/100							
450	5,0	3,2	30	120	KNL		160	28	FZ	25	■	165007 ●



Application:

For cutting along grain - middle cuts.

Middle cut

WK 100 2 43

D	SB	TDI	BO	BO _{max}	NLA	DKN	FLD _{max}	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm	mm			°		
250	3,5	2,2	30	80	KNL		130	18	FZ	25	■	165008 ●
250	3,5	2,2	80		6/5,5/91	19/89	130	18	FZ	25	■	165009 ●
					4/6,6/95	13/89						
					2/13/100							
300	3,5	2,2	30	80	KNL		110	20	FZ	25	■	165010 ●
300	3,5	2,2	70			21x83	110	20	FZ	25	■	165011 ●
300	3,5	2,2	80			23x90	110	20	FZ	25	■	165012 ●
						13x89						
350	4,0	2,8	30	100	KNL		130	24	FZ	25	■	165013 ●
350	4,0	2,8	80	100	6/5,5/91	19/89	130	24	FZ	25	■	165014 ●
					4/6,6/95	13/89						
					2/13/100							
400	4,0	2,8	30	120	KNL		150	28	FZ	25	■	165015 ●
400	4,0	2,8	80	120	6/5,5/91	19/89	150	28	FZ	25	■	165016 ●
					4/6,6/95	13/89						
					2/13/100							
450	4,4	3,0	30	120	KNL		160	28	FZ	25	■	165017 ●

1. Sawing

1.1 Solid wood cutting along grain 1.1.2 Circular sawblades with wiper teeth



Lamella cut with internal and external wiper teeth

Application:

For cutting along grain - middle cuts.

Machine:

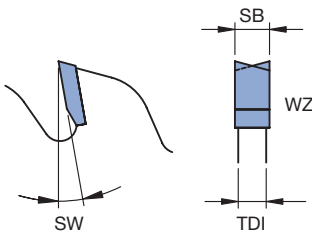
Edging, single blade, multi blade saws as well as saws with one or two spindles.

Workpiece material:

Softwood and hardwood, dry up to 15% wood moisture content. Long fibre materials (poplar, balsa etc.).

Technical information:

With two external and two or four internal wiper teeth. Tooth shape WZ best suited for cuts in long-fibred woods such as poplar. Lower power consumption due to tooth shape WZ. Higher cutting performance and less resinification due to special coating of the tool body.



Middle cut

WK 150 2

D	SB	TDI	BO	BO _{max}	NLA	DKN	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm			°		
250	3,2	2,2	70			20,6/83	20	WZ	20	■	165200 ●
300	3,2	2,2	70	80		20,6/83	24	WZ	20	■	165201 ●
320	3,2	2,2	70	80		20,6/83	28	WZ	20	■	165202 ●
350	3,5	2,5	70	100		20,6/83	28	WZ	20	■	165203 ●
400	4,0	2,8	70	100		20,6/83	24	WZ	20	■	165204 ●
500	5,0	3,5	30	100	KNL		28	WZ	20	■	165205 ●
550	5,0	3,2	80		2/13/100		36	WZ	25	■	165206 ●
600	5,4	3,8	80		2/13/100		42	WZ	25	■	165207 ●

1. Sawing

1.1 Solid wood cutting along grain 1.1.2 Circular sawblades with wiper teeth



Lamella cut with external wiper teeth *Premium*

Application:

For cutting of thin slats on horizontal spindles.

Machine:

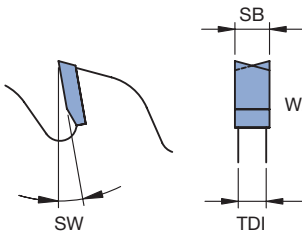
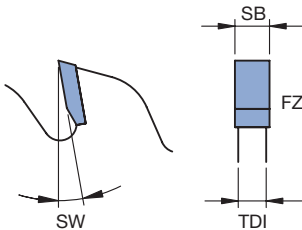
Edging, single blade, multi blade saws as well as saws or moulders with one or two spindles.

Workpiece material:

Softwood, dry up to 10% wood moisture content.

Technical information:

With two external raker blades giving better chip ejection. Higher cutting performance and less resinification due to special coating of the tool body. Special limiter shape for protection of the teeth when used in woods with loose knots and in cracked woods.



Middle cut

WK 100 2, WK 150 2

D	SB	TDI	BO	DKN	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
200	2,0	1,4	30		24	FZ	20	■	163575 ●
250	2,0	1,4	80	19/89	36	WZ	15	■	163576 ●
250	2,4	1,6	80	19/89	32	WZ	15	■	163577 ●
300	2,8	1,8	80	19/89	28	WZ	15	■	163578 ●

1. Sawing

1.1 Solid wood cutting along grain

1.1.2 Circular sawblades with wiper teeth



Lamella cut with internal wiper teeth *Premium* - reduced cutting width

Application:

For cutting of thin slats on horizontal spindles.

Machine:

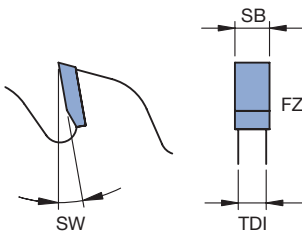
Edging, single blade, multi blade saws as well as saws or moulders with one or two spindles.

Workpiece material:

Softwood and hardwood, dry up to 10% wood moisture content.

Technical information:

With internal raker blades for better dimensional stability. Efficient energy and wood utilisation due to reduced cutting widths. Special limiter shape (up to D 250 mm) to protect the teeth when used in wood with loose knots and cracked wood. From D 300 mm large gullet areas for better chip ejection. Higher cutting performance and less resinification due to special coating of the tool body.



Middle cut

WK 100 4 , WK 100 2

D	SB	TDI	BO	BO _{max}	DKN	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm			°		
200	2,4	1,6	30			24	FZ	25	■	163560 ●
200	2,4	1,6	40	60		24	FZ	20	■	163550 ●
220	2,4	1,6	30			24	FZ	25	■	163559 ●
220	2,4	1,6	40	80		24	FZ	20	■	163551 ●
250	2,4	1,6	30			24	FZ	20	■	163558 ●
250	2,4	1,6	40	90		24	FZ	20	■	163552 ●
250	2,4	1,6	70		21/83	24	FZ	20	■	163553 ●
250	2,4	1,6	80		19x89 13x89	24	FZ	20	■	163554 ●
300	2,8	1,8	30	100		30	FZ	25	■	163555 ●
300	2,8	1,8	80		19x89 13x89	30	FZ	25	■	163556 ●
350	2,8	1,8	30	110		30	FZ	25	■	163557 ●



Lamella cut with internal and external wiper teeth *Premium* - reduced cutting width

Application:

For cutting of thin slats on vertical spindles.

Machine:

Edging, single blade, multi blade saws as well as saws or moulders with one or two spindles.

Workpiece material:

Softwood and hardwood, dry up to 10% wood moisture content.

Technical information:

With two external and internal raker blades for increased stability also for larger cutting depths. Efficient energy and wood utilization through reduced cutting widths. Higher cutting performance and less resinification through special coating of the tool body.



Middle cut

WK 100 2

D	SB	TDI	BO	BO _{max}	NLA	FLD _{max}	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm			°		
250	2,4	1,6	60	80	3/10/75	100	24	FZ	20	■	163700 ●
250	2,4	1,6	60	80	3/10/75	120	40	FZ	20	■	163701 ●
270	2,4	1,6	60	80	3/10/75	120	28	FZ	20	■	163702 ●

- Solid wood
- Board, coated
- Board, uncoated
- Non-ferrous metals
- Plastics
- Mineral materials
- Composites
- Steel, thin-walled

1. Sawing

1.1 Solid wood cutting along grain 1.1.3 Circular sawblades without wiper teeth



Lamella cut for glueable cuts

Application:

For cutting along grain - glueable middle and lamellae cuts on horizontal spindles.

Machine:

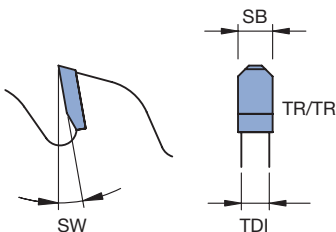
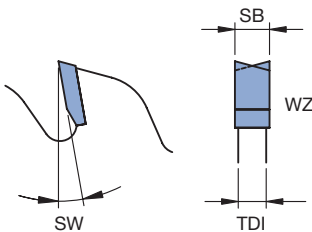
Single blade, multi blade saws as well as saws and moulders with one or two spindles.

Workpiece material:

Softwood and hardwood, dry up to 10% wood moisture content.

Technical information:

Special tooth geometry for glueable cutting areas. Noise-reduced design due to irregular tooth pitch. Continuous tool body without recess. Increased cutting performance and less resinification through special coating of the tool body.



Middle cut

WK 100 2, WK 150 2, WK 152 2, WK 158 2

Machine	D	SB	TDI	BO	BO _{max}	NLA	DKN	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm	mm	mm			°		
	180	2,2	1,4	30	60	3/10/75		18	FZ	15	■	165300 ●
	180	2,4	1,6	30	60	3/10/75		24	FZ	15	■	165301 ●
	200	2,4	1,6	30	60	3/10/75		18	FZ	15	■	165302 ●
	200	2,4	1,6	30	60	3/10/75		24	FZ	15	■	165303 ●
	225	2,4	1,6	30	60	3/10/75		24	FZ	15	■	165304 ●
	225	2,8	2,0	30	60	3/10/75		24	FZ	15	■	165305 ●
	240	2,8	2,0	40	60	3/10/75		24	FZ	15	■	165306 ●
Raimann	250	2,4	1,6	80		6/5,5/91	19/89	40	WZ	15	■	165309 ●
						4/6,6/95		13/89				
						2/13/100						
	250	2,8	2,0	30	100	3/10/75		24	FZ	15	■	165307 ●
	250	2,8	2,0	70	100		21/80	24	FZ	15	■	165308 ●
Raimann	300	2,8	1,8	80		6/5,5/91	19/89	28	WZFA	15	■	165310 ●
						4/6,6/95		13/89				
						2/13/100						
Raimann	300	2,8	2,0	80		6/5,5/91	19/89	48	TR/TR	15	■	165311 ●
						4/6,6/95		13/89				
						2/13/100						
Raimann	300	3,4	2,2	80		6/5,5/91	19/89	28	FZ	15	■	165312 ●
						4/6,6/95		13/89				
						2/13/100						
Raimann	300	4,0	2,8	80		6/5,5/91	19/89	28	TR/TR	15	■	165313 ●
						4/6,6/95		13/89				
						2/13/100						
Raimann	300	4,0	2,8	80		6/5,5/91	19/89	48	TR/TR	15	■	165314 ●
						4/6,6/95		13/89				
						2/13/100						



Lamella cut

Application:

For cutting along grain - shoulder and trimming cuts.

Machine:

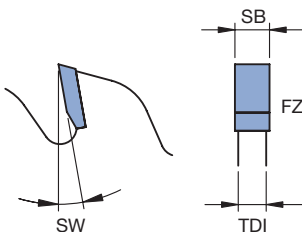
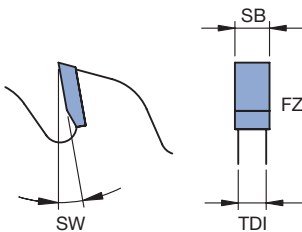
Edging, single blade, multi blade saws as well as saws with one or two spindles.

Workpiece material:

Softwood and hardwood wet and dry.

Technical information:

Large gullet area and large lateral tooth protrusion. Solid desing particularly for edge cuts. For universal use in dry and wet soft and hard woods. Design without raker blades. Partially suitable for larger cutting depths and the use in frozen woods.



Shoulder and square cut

WK 100 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
250	4,0	2,6	30	KNL	18	FZ	20	■	165101 ●
300	4,0	2,6	30	KNL	24	FZ	20	■	165102 ●
350	4,4	3,0	30	KNL	24	FZ	20	■	165104 ●
400	5,0	3,2	30	KNL	28	FZ	20	■	165105 ●
450	5,0	3,2	30	KNL	28	FZ	20	■	165106 ●
500	5,0	3,2	30	KNL	32	FZ	20	■	165107 ●

Middle cut

WK 100 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
200	3,2	2,2	30	KNL	18	FZ	25	■	165108 ●
210	3,2	2,2	30	KNL	18	FZ	20	■	165109 ●
250	3,2	2,2	30	KNL	18	FZ	20	■	165110 ●
300	3,2	2,2	30	KNL	24	FZ	20	■	165111 ●
350	3,2	2,2	30	KNL	24	FZ	20	■	165113 ●
400	4,0	2,8	30	KNL	28	FZ	20	■	165114 ●
450	4,0	2,8	30	KNL	28	FZ	20	■	165115 ●
500	4,0	2,8	30	KNL	32	FZ	20	■	165116 ●

1. Sawing

1.1 Solid wood cutting along grain

1.1.3 Circular sawblades without wiper teeth



Sizing solid wood along grain

Application:

For cutting along grain - sizing wood.

Machine:

Edging, single blade, multi blade saws as well as saws with one or two spindles.

Workpiece material:

Softwood and hardwood, dry up to 15% wood moisture content.

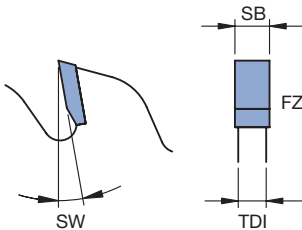
Technical information:

Design with chip thickness limitation for limited chip removal per tooth and reduced feed speeds.

Circular sawblade FZ with thickness limitation

WK 100 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
250	3,2	2,2	30	KNL	18	FZ	20	■	166050 ●
300	3,5	2,4	30	KNL	14	FZ	20	■	166051 ●
350	3,5	2,4	30	KNL	16	FZ	20	■	166052 ●
400	4,0	2,8	30	KNL	18	FZ	20	■	166053 ●
450	4,0	2,8	30	KNL	20	FZ	20	■	166054 ●
500	4,0	2,8	30	KNL	24	FZ	20	■	166055 ●



Universal sizing

Application:

For multi-purpose application in solid wood.

Machine:

Trimming and cross cutting saws.

Workpiece material:

Softwood and hardwood wet and dry.

Technical information:

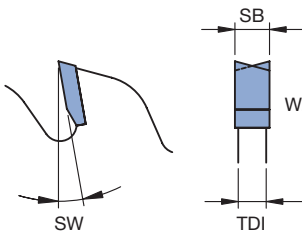
Design with chip thickness limitation for limited chip removal per tooth and reduced feed speeds. Tooth shape WZ for cuts in long-fibred woods such as poplar and for cuts in wet woods. Lower power consumption due to tooth shape WZ. Also suitable for cuts across the grain.



Circular sawblade WZ with thickness limitation

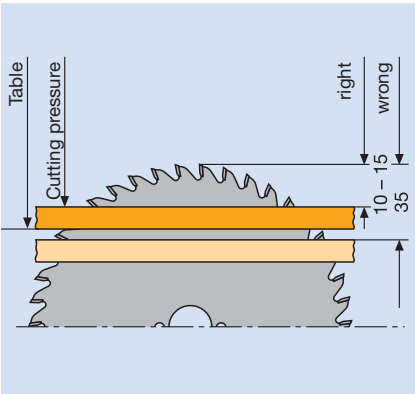
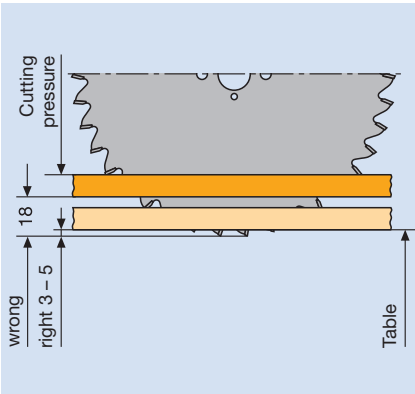
WK 150 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
250	3,2	2,2	30	KNL	24	WZ	20	■	166076 ●
300	3,2	2,2	30	KNL	28	WZ	20	■	166077 ●
350	3,2	2,2	30	KNL	32	WZ	20	■	166078 ●
400	4,0	2,8	30	KNL	36	WZ	20	■	166079 ●
450	4,0	2,8	30	KNL	42	WZ	20	■	166080 ●
500	4,0	2,8	30	KNL	48	WZ	20	■	166081 ●
550	4,8	3,5	30	KNL	54	WZ	20	■	166082 ●
600	4,8	3,5	30	KNL	60	WZ	20	■	166083 ●
700	4,8	3,5	30	KNL	60	WZ	20	■	166084 ●



1. Sawing

1.2 Solid wood cutting across grain

Application area	For trim, cross, mitre and sizing cuts.
Workpiece material	Solid wood with or without coating, plywood, glulam, solid surface materials.
Machine	Combined table, mitre, radial, underfloor and optimising saws.
Application	 The cutting force of sawblades with a positive cutting angle and the spindle below the workpiece or for sawblades with a negative cutting angle and the spindle above the workpiece. Press the material onto the table.  On radial saws, the use of sawblades with a negative cutting angle cutting against the feed is obligatory (see EN 1870-17). The negative cutting angle presses the material onto the table.
Tooth shape	  WZ (alternative top bevel teeth): Multi purpose tooth shape, economical to purchase and maintain – suitable for solid wood and wood derived materials.

1. Sawing

1.2 Solid wood cutting across grain 1.2.1 Circular sawblades for optimising saws



Trimming at high feed rates

Application:

For trimming and cross cutting with cycle times of 0.3 - 1.0 sec.

Machine:

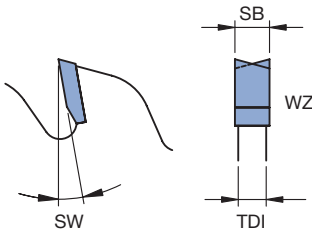
Cross, trimming and optimising saws.

Workpiece material:

Solid wood wet and dry across grain, solid wood profiles across grain.

Technical information:

For fast cross-cutting, sizing and optimizing machines. Large lateral tooth clearance and a high number of teeth. Stable corner angle of 20° for tear-free cutting results and long tool life.



Trimming at high feed rates

WK 150 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
Dimter, System TM	400	3,5	2,8	30	2/10/60 2/15/63 2/10/150 2/10/198	120	WZ	10	■	165450 ●
Dimter, System TM	400	3,5	2,8	30	2/10/60 2/15/63 2/10/150 2/10/198	140	WZ	10	■	165464 ●
Dimter, System TM	450	3,5	2,8	30	2/10/60 2/15/63 2/10/150 2/10/198	158	WZ	10	■	165465 ●
Dimter	450	3,9	3,2	30	2/15/63	136	WZ	10	■	165466 ●
Dimter, System TM	450	4,8	3,5	30	2/10/60 2/15/63 2/10/150 2/10/198	138	WZ	10	■	165451 ●
Dimter	450	5,0	3,2	30	2/10/60 2/15/63	108	WZ	10	■	165452 ●
Dimter, System TM	500	4,8	3,5	30	2/10/60 2/15/63 2/10/150 2/10/198	144	WZ	10	■	165454 ●
Dimter	500	4,8	3,5	35	2/10/60 2/15/63	144	WZ	10	■	165455 □
Dimter	500	5,2	3,2	30	2/10/60 2/15/63	120	WZ	10	■	165453 ●
Dimter	520	4,6	3,4	30	2/10/60 2/15/63	144	WZ	10	■	165456 ●
Dimter	550	5,0	3,2	30	2/10/60 2/15/63	96	WZ	10	■	165457 ●
Dimter	550	5,2	3,2	30	2/10/60 2/15/63	120	WZ	10	■	165459 ●
Dimter, System TM	550	5,2	3,2	30	2/10/60 2/15/63 2/10/150 2/10/198	160	WZ	10	■	165458 ●
Dimter	600	5,4	4,0	30	2/10/60 2/15/63	172	WZ	10	■	165461 ●
Dimter	600	5,8	4,0	30	2/10/60 2/15/63	108	WZ	10	■	165460 ●
Dimter	630	5,4	4,0	30	2/10/60 2/15/63	180	WZ	10	■	165462 ●
Dimter	700	5,5	4,0	30	2/15/63	200	WZ	10	■	165463 ●

1. Sawing

1.2 Solid wood cutting across grain

1.2.2 Circular sawblades WZ with neg. cutting angle



Trimming with negative cutting angle

Application:

For trimming and cross cutting - positioning of workpiece under the sawblade.

Machine:

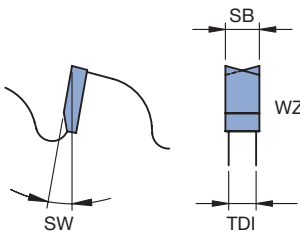
Cross, trimming, mitre and radial saws as well as double mitre cutting saws.

Workpiece material:

Softwood and hardwood wet and dry, laminated veneer lumber (e.g. plywood, multiplex plywood).

Technical information:

Especially for machines with positioning of the saw shaft above the workpiece. Negative cutting angle for improved workpiece clamping.



Circular sawblade WZ with neg. cutting angle

WK 160 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
300	3,2	2,4	30	KNL	60	WZ	-5	■	165514 ●
300	3,2	2,4	30	KNL	96	WZ	-5	■	165515 ●
305	3,2	2,4	30	KNL	60	WZ	-5	■	165516 ●
350	3,2	2,4	30	KNL	36	WZ	-5	■	165517 ●
350	3,2	2,4	30	KNL	60	WZ	-5	■	165518 ●
350	3,5	2,8	30	KNL	108	WZ	-5	■	165519 ●
355	3,2	2,4	30	KNL	72	WZ	-5	■	165520 ●
400	3,8	2,8	30	KNL	42	WZ	-5	■	165521 ●
400	3,8	2,8	30	KNL	60	WZ	-5	■	165522 ●
400	3,8	2,8	30	KNL	120	WZ	-5	■	165523 ●
420	3,5	2,8	40		48	WZ	-5	■	165524 ●
450	3,8	2,8	30	KNL	48	WZ	-5	■	165525 ●
500	4,4	3,2	30	KNL	54	WZ	-5	■	165526 ●

1. Sawing

1.2 Solid wood cutting across grain

1.2.2 Circular sawblades WZ with neg. cutting angle



Trimming with negative cutting angle *Excellent*

Application:

For trimming and cross cutting - positioning of workpiece under the sawblade.

Machine:

Cross, trimming, mitre and radial saws as well as double mitre cutting saws.

Workpiece material:

Softwood and hardwood wet and dry, laminated veneer lumber (e.g. plywood, multiplex plywood).

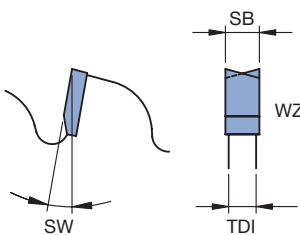
Technical information:

Especially for machines with positioning of the saw shaft above the workpiece.

Negative cutting angle for improved workpiece clamping. **Excellent** design.

Vibration-damping composite construction of the tool body by means of steel foil.

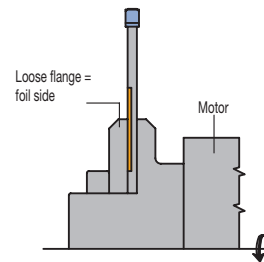
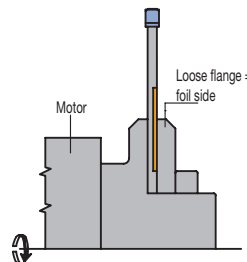
Extreme noise reduction even with increasing dulling of the tool.



Circular sawblade WZ with neg. cutting angle

WK 180 2

D	SB	TDI	BO	NLA	Z	ZF	SW	Foil	WSS	ID
mm	mm	mm	mm	mm			°			
300	3,5	2,6	30	KNL	96	WZ	-5	left	■	161330 ●
300	3,5	2,6	30	KNL	96	WZ	-5	right	■	161331 ●
350	3,5	2,6	30	KNL	108	WZ	-5	left	■	161332 ●
350	3,5	2,6	30	KNL	108	WZ	-5	right	■	161333 ●
400	3,5	2,6	30	KNL	120	WZ	-5	left	■	161334 ●
400	3,5	2,6	30	KNL	120	WZ	-5	right	■	161335 ●





Trimming, crossing and mitre cuts

Application:

For cross cutting, trimming and angled cuts.

Machine:

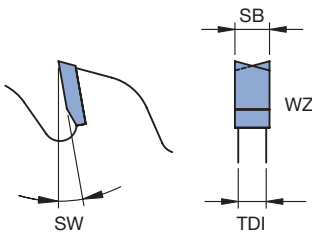
Cross and trimming saws and CNC controlled joinery machines, cross cutting twin saws.

Workpiece material:

Solid wood beams wet and dry, cross-glued beams.

Technical information:

Tooth shape for universal use and with large lateral tooth clearance.



Circular sawblade WZ

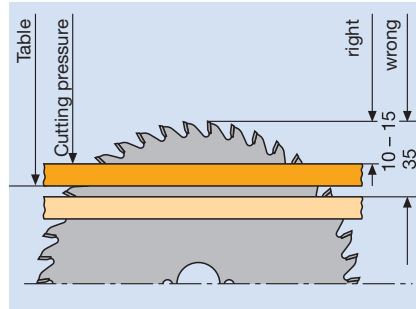
WK 150 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
Weinmann	240	3,0	2,0	40	8/6/52	30	WZ	15	■	165337 ●
Weinmann	370	3,5	2,5	30	KNL	108	WZ	10	■	165338 ●
Routech	440	7,0	4,0	75	6/9/100	12+2+2	WZ	20	■	165326 ●
Routech	500	4,4	3,2	75	2/8,5/100 6/10,6/100	28+2+2+2	WZ	20	■	165328 ●
Routech	500	7,0	4,0	75	6/9/100	14+2+2+2	WZ	20	■	165327 ●
Essetre	520	5,4	3,5	60	8/6,5/100	72	WZ	20	■	165332 ●
Weinmann	555	5,2	3,6/6	55	6/7/75	54+2+2	WZ	20	■	165325 ●
Essetre	600	5,4	3,5	80	8/9,5/120	72	WZ	20	■	165333 ●
	600	6,0	4,0	30	2/14/400	48	WZ	15	■	057570 ●
Routech	600	7,0	4,0	75	6/9/125	16+2+2+2	WZ	20	■	165329 ●
Uniteam	640	5,4	3,6	30	2/8,5/125 8/6,5/160 8/6,5/130 4/10,5/90	36+2+2	WZ	20	■	165330 ●
	700	6,0	4,4	30		72	WZ	15	■	165334 ●
	750	6,0	4,4	30		72	WZ	15	■	165335 ●
	800	6,0	4,4	30		72	WZ	15	■	165336 ●
Uniteam	850	8,0	6,0	30	8/6,5/160 8/6,5/130 4/10,5/90	60+2+2+2	WZ	20	■	165331 ●

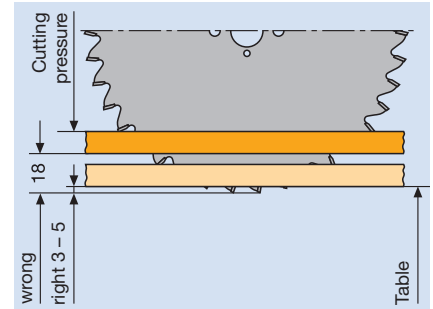
1. Sawing

1.3 Sizing

Working process	For cross cutting and sizing; grooving and cutting also possible if safety regulations are followed.
Workpiece materials	Solid wood, wood derived materials, synthetic materials and light metals.
Machines	Table saws, sizing machines with/without scoring saw, vertical panel sizing saws and twin sizing saws.
Application	Suitable for cutting from below against the feed. On vertical panel sizing machines and twin saw dimension saws cutting from either below or above against the feed.



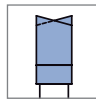
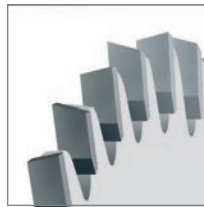
The positive cutting angle presses the material onto the table for sawblades with a positive cutting angle and the spindle below the workpiece.



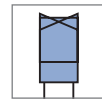
The negative cutting angle presses the material onto the table for sawblades with a negative cutting angle and the spindle above the workpiece.

On radial saw machines, sawblades must be used (see EN1870-17) with a negative cutting angle against the feed.

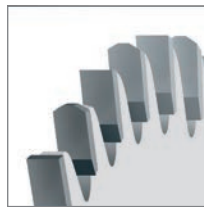
Tooth shape



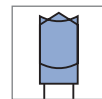
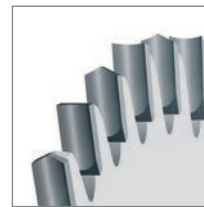
WZ (alternative top bevel teeth):
Multi-purpose tooth shape, economical to purchase and maintain. Ideal for chipboard, veneered chipboard, solid wood, block board, plywood.



WZ/WZ/FZ (alternative/square teeth):
Tooth shape for solid wood, glulam and coated or veneered wood derived materials; tear-free cutting edges and high cut quality. Combinations of tooth forms (WZre, WZli, WZre, WZli, FZ).



FZ/TR (square/trapezoidal teeth):
Tooth shape for plastic and foil coated wood derived materials.
TR/TR (trapezoidal/trapezoidal teeth):
Best tooth shape for cutting hard and abrasive coatings – can be altered from the existing FZ/TR shape.



HZ/DZ (hollow face/inverted V teeth):
Tooth shape for high cutting quality on plastic coated materials, with high upper and lower edge quality on machines without a scoring saw.

1. Sawing

1.3 Sizing

1.3.1 Sizing sawblades WZ



Sizing *Premium*

Application:

For sizing and cross cutting with/without scoring.

Machine:

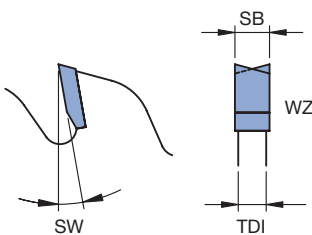
Table and sizing saws.

Workpiece material:

Solid wood across grain, chipboard and fibre materials, laminated veneer lumber (e.g. plywood, multiplex plywood).

Technical information:

Premium design with vibration-damping laser ornaments (from D 200 mm). Marked dimensions with irregular tooth pitch (UT) for noise reduction and improved running behaviour.



Sizing sawblade WZ

WK 170 2

D	SB	TDI	BO	NLA	Z	ZF	Type	SW	WSS	ID
mm	mm	mm	mm	mm				°		
150	3,2	2,2	30		48	WZ		10	■ ■	163100 ●
180	2,4	1,6	30		30	WZ	UT	10	■ ■	163101 ●
180	3,0	2,0	30		24	WZ	UT	10	■ ■	163102 ●
180	3,2	2,2	30		58	WZ		10	■ ■	163103 ●
180	3,5	2,5	30		30	WZ	UT	10	■ ■	163104 ●
200	2,4	1,6	30	KNL	36	WZ	UT	10	■ ■	163105 ●
200	2,4	1,6	30	KNL	60	WZ		10	■ ■	163106 ●
200	3,0	2,0	30	KNL	24	WZ	UT	10	■ ■	163107 ●
200	3,0	2,0	30	KNL	48	WZ	UT	10	■ ■	163108 ●
200	3,0	2,0	30	KNL	60	WZ		10	■ ■	163109 ●
220	3,2	2,2	30	KNL	36	WZ	UT	10	■ ■	163110 ●
220	3,2	2,2	30	KNL	60	WZ		10	■ ■	163111 ●
250	2,4	1,6	30	KNL	40	WZ	UT	10	■ ■	163112 ●
250	2,4	1,6	30	KNL	80	WZ		10	■ ■	163113 ●
250	3,2	2,2	30	KNL	40	WZ	UT	10	■ ■	163114 ●
250	3,2	2,2	30	KNL	60	WZ	UT	10	■ ■	163115 ●
250	3,2	2,2	30	KNL	80	WZ		10	■ ■	163116 ●
300	2,4	1,6	30	KNL	48	WZ	UT	10	■ ■	163117 ●
300	2,4	1,6	30	KNL	96	WZ		10	■ ■	163118 ●
300	3,2	2,2	30	KNL	36	WZ	UT	10	■ ■	163119 ●
300	3,2	2,2	30	KNL	48	WZ	UT	10	■ ■	163120 ●
300	3,2	2,2	30	KNL	72	WZ	UT	10	■ ■	163121 ●
300	3,2	2,2	30	KNL	96	WZ		10	■ ■	163122 ●
350	3,5	2,5	30	KNL	32	WZ	UT	10	■ ■	163134 ●
350	3,5	2,5	30	KNL	54	WZ	UT	10	■ ■	163123 ●
350	3,5	2,5	30	KNL	72	WZ	UT	10	■ ■	163124 ●
350	3,5	2,5	30	KNL	84	WZ	UT	10	■ ■	163125 ●
350	3,5	2,5	30	KNL	108	WZ		10	■ ■	163126 ●
400	3,5	2,5	30	KNL	48	WZ	UT	10	■ ■	163127 ●
400	3,5	2,5	30	KNL	60	WZ	UT	10	■ ■	163128 ●
400	3,5	2,5	30	KNL	84	WZ	UT	10	■ ■	163129 ●
400	3,5	2,5	30	KNL	96	WZ	UT	10	■ ■	163130 ●
400	3,5	2,5	30	KNL	120	WZ		10	■ ■	163131 ●
450	3,8	2,8	30	KNL	66	WZ	UT	10	■ ■	163132 ●
500	3,8	2,8	30	KNL	72	WZ	UT	10	■ ■	163133 ●

1. Sawing

1.3 Sizing

1.3.1 Sizing sawblades WZ



Sizing without scoring *Premium* - Mamba

Application:

For sizing and cross cutting without scoring.

Machine:

Table and sizing saws. Vertical panel sizing saws without scoring unit.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), thin walled plastic profiles (thickness < 2 mm), thin walled plastic honeycomb boards.

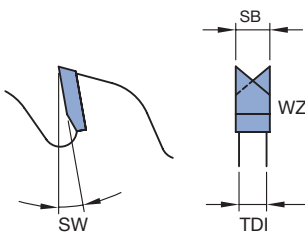
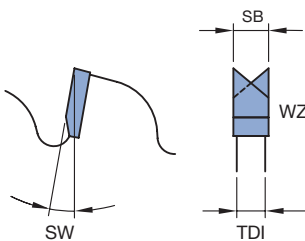
Technical information:

Special WZ with 40° corner angle for tear-free cuts on both sides. **Premium** design with vibration damping laser ornaments. Particularly for machines with positioning of the saw shaft above the workpiece. Negative cutting angle for improved workpiece clamping.

Circular sawblade Mamba, negative cutting angle

WK 880 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
250	3,2	2,2	30	KNL	80	WZ	-5	■	163225 ●
303	3,5	2,5	30	KNL	96	WZ	-5	■	163226 ●



Technical information:

Extremely strong alternate tooth WZ with 40° corner angle for tear-free cuts in coated wood derived materials on both sides. **Premium** design with vibration-damping laser ornaments.

Circular sawblade Mamba, positive cutting angle

WK 870 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
300	3,5	2,5	30	KNL	96	WZ	5	■	163200 ●
350	3,5	2,5	30	KNL	108	WZ	5	■	163201 ●

1. Sawing

1.3 Sizing

1.3.1 Sizing sawblades WZ



Sizing and veneer stack cut - reduced cutting width

Application:

For sizing and cross cutting with and without scoring.

Machine:

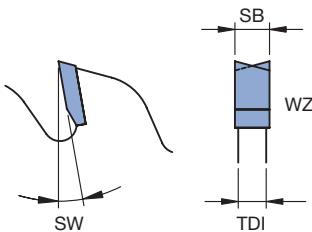
Table, sizing and veneer cutting saws.

Workpiece material:

Solid wood across grain, chipboard and fibre materials, laminated veneer lumber (e.g. plywood, multiplex plywood), veneered board stacks, plastic or derived material honeycomb boards.

Technical information:

Reduced cutting width for better material utilization and lower cutting forces. Marked ID numbers with recessed tool body and thus limited cutting depth.



Circular sawblade WZ

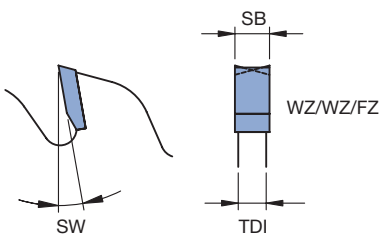
WK 250 2, WK 850 2, WK 850 2 10, WK 850 2 22

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
160	1,8	1,0/2,5	16	1/6/33	48	WZ	10	■	060574 ●
180	1,6	1,0/2,5	16	1/6/33	56	WZ	10	■	060591 ●
180	2,4	1,6	16		58	WZ	10	■	059665 ●
200	2,0	1,4	16		64	WZ	10	■	059666 ●
250	1,7	1,0/2,4	30	KNL	80	WZ	10	■	058520 ●
300	1,7	1,0/2,4	30	KNL	96	WZ	10	■	058521 ●
450	3,0	2,2	30	2/14/125 KNL	120	WZ	20	■	058461 ●

1. Sawing

1.3 Sizing

1.3.2 Sizing sawblades Katana



Sizing cut *Excellent* - Katana

Application:

For sizing and cross cutting without scoring.

Machine:

Table and sizing saws, vertical panel sizing machines without scoring unit, cross, trimming and mitre cutting saws.

Workpiece material:

Solid wood across grain, laminated veneer lumber (e.g. plywood, multiplex plywood), honeycomb boards, thin walled plastic and non-ferrous metal profiles.

Technical information:

Katana tooth combination with alternating rake face bevel for highest cutting quality. High number of teeth for perfect edges and very smooth surfaces. **Excellent** design with plastic filled laser ornaments for vibration damping and reduction of noise level.

Circular sawblade Katana

WK 879 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
255	2,8	2,0	30	KNL	80	WZ/WZ/FZ	10		161200 ●
303	3,2	2,2	30	KNL	100	WZ/WZ/FZ	10		161201 ●
355	3,0	2,2	30	KNL	120	WZ/WZ/FZ	10		161202 ●
400	3,2	2,5	30	KNL	130	WZ/WZ/FZ	20		161203 ●
				2/15/63					
450	3,6	2,8	30	KNL	140	WZ/WZ/FZ	20		161204 ●
				2/15/63					
500	4,0	3,5	30	KNL	150	WZ/WZ/FZ	20		161205 ●
				2/15/63					
550	4,0	3,5	30	KNL	160	WZ/WZ/FZ	20		161206 ●
				2/15/63					

1. Sawing

1.3 Sizing

1.3.3 Sizing sawblades WhisperCut



Sizing *Excellent* - WhisperCut

Application:

For sizing and trimming with scoring.

Machine:

Table and sizing saws, vertical panel sizing saws with scoring unit. Cross, trimming and mitre saws.

Workpiece material:

Solid wood across grain, laminated veneer lumber (e.g. plywood, multiplex plywood), chipboard and fibre materials plastic and paper coated, veneered and honeycomb boards.

Technical information:

Extreme noise reduction. Particularly developed group serration for perfect cutting pitch and reduction of the cutting forces. Universally applicable for most different materials. Standard cutting width of 3.2 mm allows use with standard scoring circular sawblades and standard splitting wedges. 2-fold resharpenable. **Excellent** design with filled laser ornaments for vibration damping and reduction of the noise level.

Circular sawblade WhisperCut

WK 879 2 DP

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
250	3,2	2,4	30	KNL	50	HZFA/WZFA	10		190697 ●
303	3,2	2,4	30	KNL	60	HZFA/WZFA	10		190698 ●
350	3,2	2,4	30	KNL	70	HZFA/WZFA	10		190699 ●

Application:

For scoring with feed.

Machine:

Table and sizing saws, vertical panel sizing saws with scoring unit.

Technical information:

Hollow tooth for tear-free cuts in coated wood materials on both sides. **Excellent** design with filled laser ornaments for vibration damping and reduction of the noise level.

Scoring sawblade WhisperCut

WK 272 2

D	SB	BO	Z	ZF	SW	WSS	ID
mm	mm	mm			°		
80	3,3	20	18	HZ/WZ	10		190700 ●
120	3,3	20	18	HZ/WZ	10		190701 ●
120	3,3	22	18	HZ/WZ	10		190702 ●
125	3,3	20	18	HZ/WZ	10		190703 ●

1. Sawing

1.3 Sizing

1.3.4 Sizing sawblades HZ/DZ



Sizing without scoring *Excellent*

Application:

For sizing and cross cutting without scoring.

Machine:

Table and sizing saws, vertical panel sizing saws without scoring unit.

Workpiece material:

Chipboard and fibre materials plastic and paper coated, veneered.

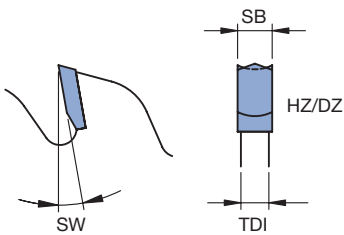
Technical information:

Excellent design with plastic filled laser ornaments for vibration damping and reduction of noise level.

Circular sawblade

WK 874 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
250	3,2	2,2	30	KNL	54	HZ/DZ	10	■	161300 ●
303	3,2	2,2	30	KNL	68	HZ/DZ	10	■	161301 ●
350	3,5	2,5	30	KNL	80	HZ/DZ	10	■	161302 ●



1. Sawing

1.3 Sizing

1.3.4 Sizing sawblades HZ/DZ



Sizing without scoring *Premium*

Application:

For sizing and cross cutting without scoring.

Machine:

Table and sizing saws, vertical panel sizing saws without scoring unit.

Workpiece material:

Chipboard and fibre materials plastic and paper coated, veneered.

Technical information:

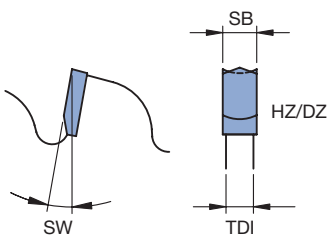
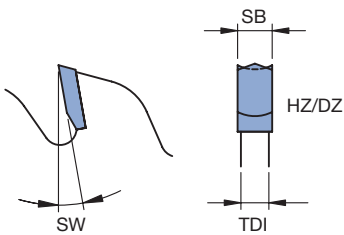
Hollow tooth for tear-free cuts in coated wood materials on both sides. **Premium** version with vibration-damping laser ornaments.



Circular sawblade, positive cutting angle

WK 274 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
220	3,2	2,2	30	KNL	42	HZ/DZ	10	■	163050 ●
250	3,2	2,2	30	KNL	48	HZ/DZ	10	■	163051 ●
303	3,2	2,2	30	KNL	60	HZ/DZ	10	■	163054 ●
303	3,5	2,5	30	KNL	60	HZ/DZ	10	■	163052 ●
350	3,5	2,5	30	KNL	72	HZ/DZ	10	■	163053 ●



Machine:

Vertical panel sizing saws without scoring unit.

Technical information:

Hollow tooth for tear-free cuts in coated wood materials on both sides. **Premium** version with vibration-damping laser ornaments. Especially for machines with positioning of the saw shaft above the workpiece. Negative cutting angle for improved workpiece clamping.

Circular sawblade, negative cutting angle

WK 864 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
250	3,2	2,2	30	KNL	48	HZ/DZ	-5	■	163076 ●
303	3,2	2,2	30	KNL	60	HZ/DZ	-5	■	163077 ●

1. Sawing

1.3 Sizing

1.3.5 Sizing sawblades FZ/TR



Sizing with scoring *Premium*

Application:

For sizing and trimming with scoring.

Machine:

Table and sizing saws, vertical panel sizing saws with scoring unit.

Workpiece material:

Chipboard and fibre materials, paper and plastic coated.

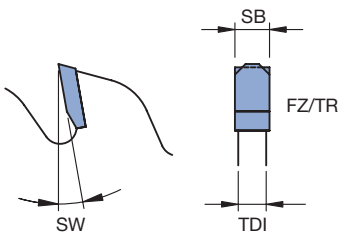
Technical information:

Premium version with vibration-damping laser ornaments. Marked dimensions with irregular tooth pitch (UT) for noise reduction and improved running behaviour.

Circular sawblade

WK 852 2

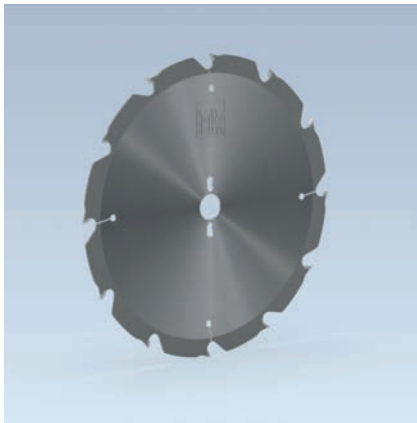
D	SB	TDI	BO	NLA	Z	ZF	Type	SW	WSS	ID
mm	mm	mm	mm	mm				°		
220	3,2	2,2	30	KNL	64	FZ/TR		10	■	163000 ●
250	3,2	2,2	30	KNL	60	FZ/TR	UT	10	■	163002 ●
250	3,2	2,2	30	KNL	80	FZ/TR		10	■	163003 ●
280	3,2	2,2	30	KNL	60	FZ/TR	UT	10	■	163004 ●
300	3,2	2,2	30	KNL	72	FZ/TR	UT	10	■	163005 ●
300	3,2	2,2	30	KNL	96	FZ/TR		10	■	163006 ●
350	3,5	2,5	30	KNL	84	FZ/TR	UT	10	■	163007 ●
350	3,5	2,5	30	KNL	108	FZ/TR		10	■	163008 ●



1. Sawing

1.3 Sizing

1.3.6 Sizing sawblades FZ



Sizing

Application:

For sizing and cross cutting with and without scoring.

Machine:

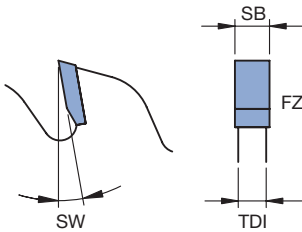
Table and sizing saws.

Workpiece material:

Solid wood along grain.

Technical information:

Low number of teeth for reduction of feed forces and lower power consumption at large cutting depths especially in solid wood longitudinal.



Circular sawblade FZ

WK 120 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
350	3,5	2,5	30	KNL	12	FZ	20	■	163025 ●
400	3,5	2,5	30	KNL	14	FZ	20	■	163026 ●
450	3,8	2,8	30	KNL	16	FZ	20	■	163027 ●

1. Sawing

1.3 Sizing

1.3.6 Sizing sawblades FZ



Sizing, scoring, hogging

Application:

For sizing, cross cutting and scoring with feed, for mounting on hoggers or segment hoggers.

Machine:

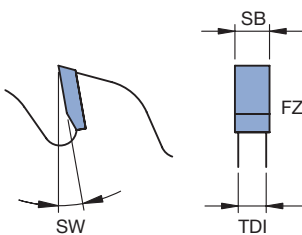
Table, sizing and vertical panel sizing saws.

Workpiece material:

Solid wood along grain, chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood).

Technical information:

Suitable for mounting on spindle, flange sleeve or mounting flange on quick-clamping elements.

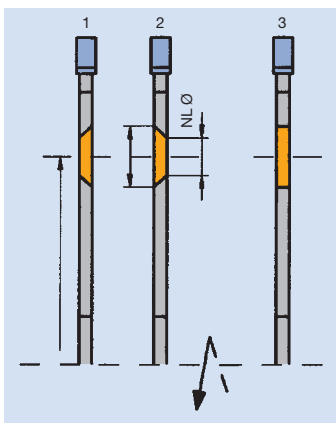


Scoring sawblade respectively circular sawblade for the use with hoggers.

TC-version.

WK 100 2

D	SB	TDI	BO	NLA	Type	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm				°		
150	3,2	2,2	30			42	FZ	10	■ ■	165375 ●
180	3,2	2,2	30			48	FZ	10	■ ■	165378 ●
180	3,2	2,2	65	6/6/90	2	48	FZ	10	■ ■	165379 ●
180	3,2	2,2	65	6/6/90	1	48	FZ	10	■ ■	165380 ●
180	3,2	2,2	65	6/6/90	2	58	FZ	10	■ ■	165381 ●
180	3,2	2,2	65	6/6/90	1	58	FZ	10	■ ■	165382 ●
200	3,2	2,2	30			54	FZ	10	■ ■	165383 ●



Type 1:

Countersink right

Type 2:

Countersink left

Type 3:

Pinhole without countersink

1. Sawing

1.3 Sizing

1.3.6 Sizing sawblades FZ



Sizing, scoring, hogging *Excellent*

Application:

For sizing, cross cutting and scoring with feed, for mounting on hoggers or segment hoggers.

Machine:

Table, sizing and vertical panel sizing saws.

Workpiece material:

Solid wood along grain, chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood).

Technical information:

Suitable for mounting on spindle, flange sleeve or mounting flange on quick-clamping elements.

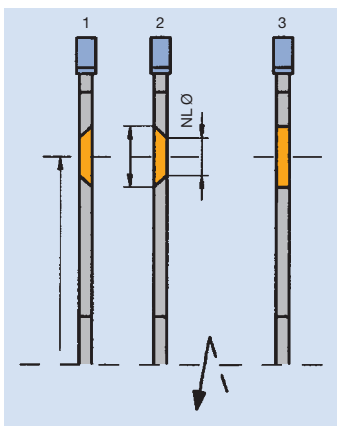
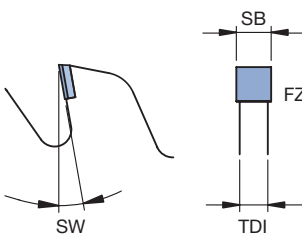


Scoring sawblade respectively circular sawblade for the use with hoggers.

DP-version.

WK 800 2

D	SB	TDI	BO	NLA	Type	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm				°		
180	3,2	2,2	65	6/6/90	2	24	FZ	10		190660 □
180	3,2	2,2	65	6/6/90	1	24	FZ	10		190661 □
180	3,2	2,2	65	6/6/90	2	36	FZ	10		190662 □
180	3,2	2,2	65	6/6/90	1	36	FZ	10		190663 □
180	3,2	2,2	65	6/6/90	2	48	FZ	10		190664 □
180	3,2	2,2	65	6/6/90	1	48	FZ	10		190665 □



Type 1:

Countersink right

Type 2:

Countersink left

Type 3:

Pinhole without countersink



Scoring sawblades with adjustable cutting width

Application:

For scoring with feed.

Machine:

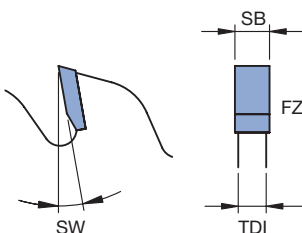
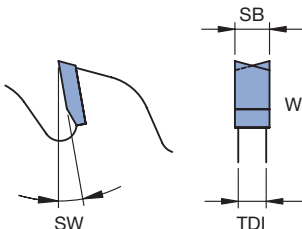
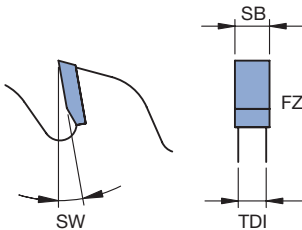
Table and sizing saws, vertical panel sizing saws with scoring unit.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood).

Technical information:

2 part design, adjustable with spacers. Scoring depth 1.50 - 2.00 mm.



Scoring sawblades adjustable, TC-version

WK 200 2, WK 250 2

Machine	D mm	SB mm	BO mm	Z	ZF	SW °	WSS	ID
Felder, Striebig	80	2,8 - 3,8	20	10+10	FZ	10	■	165401 ●
Schelling	100	2,8 - 3,8	20	10+10	FZ	10	■	165402 ●
Altendorf	100	2,8 - 3,8	22	10+10	FZ	10	■	165403 ●
SCM, Felder	120	2,8 - 3,8	20	12+12	FZ	10	■	165404 ●
Altendorf	120	2,8 - 3,8	22	12+12	FZ	10	■	165406 ●
Felder	125	2,8 - 3,8	20	12+12	FZ	10	■	165407 ●
Martin	140	2,8 - 3,8	36	12+12	WZ	10	■	165408 ●
Altendorf	180	3,0 - 3,8	22	18+18	WZ	10	■	165410 ●

Technical information:

Two-part, automatically adjustable through machine control. Scoring depth 1,50 - 2,00 mm.

Scoring sawblades for stepless adjustment, TC-version

WK 200 2

Machine	D mm	SB mm	BO mm	Z	ZF	SW °	WSS	ID
Altendorf	120	2,8 - 3,8	50	12+12	FZ	10	■	165412 ●
Martin T74 Automatic	120	2,8 - 3,6	22	12+12	FZ	10	■	165405 ●
Altendorf	180	3,0 - 3,8	50	18+18	FZ	10	■	165413 ●

1. Sawing

1.3 Sizing

1.3.7 Scoring sawblades for table and panel saws



Scoring sawblades with adjustable cutting width *Excellent*

Application:

For scoring with feed.

Machine:

Table and sizing saws, vertical panel sizing saws with scoring unit.

Workpiece material:

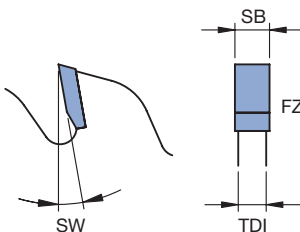
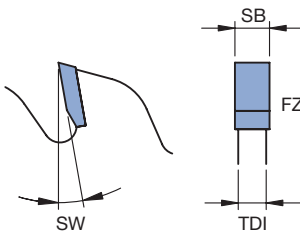
Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood).

Technical information:

2 part design, adjustable with spacers. Scoring depth 1.50 - 2.00 mm.



DP



Scoring sawblades adjustable, DP-version

WK 200 2

D mm	SB mm	BO mm	Z	ZF	SW °	WSS	ID
120	2,8 - 3,8	20	12+12	FZ	10	■	190731 ●
120	2,8 - 3,8	22	12+12	FZ	10	■	190694 ●
125	2,8 - 3,8	20	12+12	FZ	10	■	190695 ●

Technical information:

Two-part, automatically adjustable through machine control. Scoring depth 1,50 - 2,00 mm.

Scoring sawblades for stepless adjustment, DP-version

WK 200 2

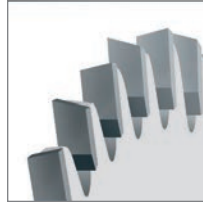
D mm	SB mm	BO mm	Z	ZF	SW °	WSS	ID
120	2,8 - 3,8	50	12+12	FZ	10	■	190704 ●

1. Sawing

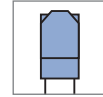
1.4 Panel sizing

Working process	For sizing single boards or boards in stacks.
Workpiece materials	Solid wood, wood derived materials and plastic.
Machines	Table saws and panel sizing saws with pressure clamping beam.
Type of application	Scoring sawblades cut with the feed main sawblades cut against the feed.

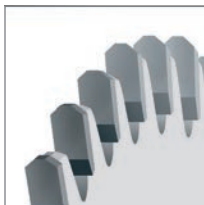
Tooth shape



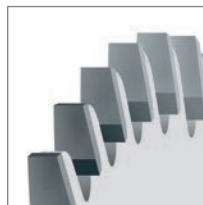
WZ (alternative top bevel teeth):
Multi-purpose tooth shape, economical to purchase and maintain. Ideal for chipboard, veneered chipboard, solid wood, block board, plywood and similar materials.



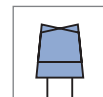
FZ/TR (square/trapezoidal teeth):
Tooth shape for plastic coated and foil coated wood derived materials.



TR/TR (trapezoidal/trapezoidal teeth):
Tooth shape for especially abrasive materials such as HPL or CPL coated wood derived materials.



KON/FZ (flat teeth – conical):
For scoring sawblades. Prevents splitting of the cut edge by the main sawblade as it passes through the bottom surface of the panel.



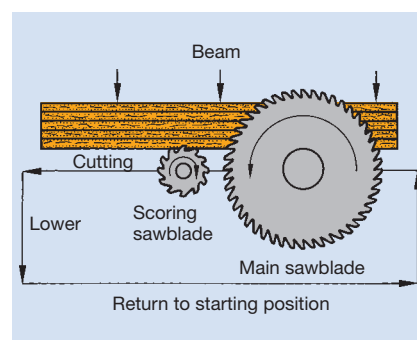
KON/WZ (alternative top bevel teeth – conical): For scoring sawblades. Prevents splitting of the cut edge by the main sawblade as it passes through the bottom surface of the panel with low cutting pressure.

Scoring sawblades

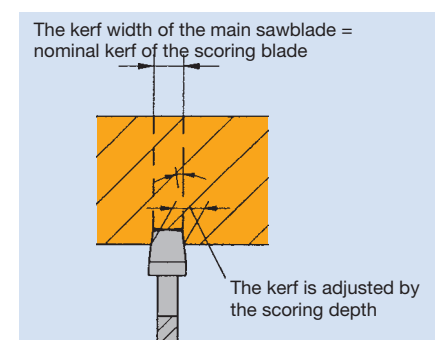
A scoring saw is recommended for a high cut edge quality on both sides of coated panels. The scoring sawblade cutting width (kerf) is slightly larger than the width (kerf) of the main sawblade so the exiting tooth of the main sawblade does not touch the bottom surface cut edge.

As precise, flat workpiece positioning is only possible with pressure clamping, split scoring sawblades are used on table and panel saw.

Schematic representation



Panel sizing machine with scoring saw and top pressure beam.



Setting of conical scoring sawblade. The cutting width (kerf) has to be matched to the cutting width (kerf) of the main saw during maintenance of the tools.



Sizing of single boards and stacks of boards *Premium*

Application:

For panel sizing of single boards and stacks of boards with and without scoring.

Machine:

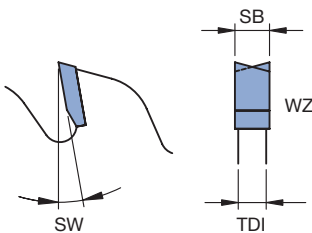
Panel sizing saws with pressure beam.

Workpiece material:

Chipboard and fibre materials, laminated veneer lumber (e.g. plywood, multiplex plywood).

Technical information:

Premium version with vibration-damping laser ornaments.



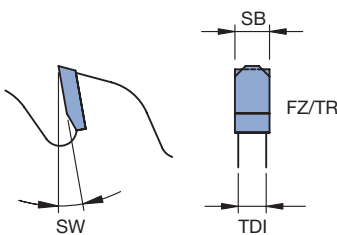
Circular sawblade

WK 250 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
	300	4,4	3,2	30	KNL	48	WZ	15	■	163300 ●
Holz-Her, Mayer, Schelling	350	4,4	3,2	30	KNL	54	WZ	15	■	163301 ●
					2/13/94					
Holz-Her, Mayer, Schelling	350	4,4	3,2	30	KNL	72	WZ	15	■	163302 ●
					2/13/94					
Homag	350	4,4	3,2	60	2/14/100	72	WZ	15	■	163304 ●
Gabbiani, SCM	350	4,4	3,2	80	4/9/100	54	WZ	15	■	163305 ●
					2/14/110					
					2/7/110					
Mayer, Schelling	355	4,4	3,2	30	KNL	72	WZ	15	■	163306 ●
					2/13/94					
Holz-Her, Gieben, Homag	380	4,4	3,2	30	KNL	72	WZ	15	■	163319 ●
					4/13/80					
					2/14/100					
					2/14/125					
Homag	380	4,8	3,5	60	2/14/100	54	WZ	15	■	163307 ●
					2/14/125					
Mayer, Schelling	400	4,4	3,2	30	KNL	60	WZ	15	■	163308 ●
					2/13/94					
Mayer, Schelling	400	4,4	3,2	30	KNL	72	WZ	15	■	163309 ●
					2/13/94					
Schelling	430	4,4	3,2	30	KNL	72	WZ	15	■	163310 ●
Mayer, Schelling	450	4,4	3,2	30	KNL	54	WZ	15	■	163311 ●
					2/13/94					
Mayer, Schelling	450	4,4	3,2	30	KNL	72	WZ	15	■	163312 ●
					2/13/94					
Schelling	480	4,4	3,2	30	KNL	72	WZ	15	■	163313 ●
					2/13/94					
Schelling	500	5,2	3,5	30	KNL	60	WZ	15	■	163314 ●
	500	5,2	3,5	80		60	WZ	15	■	163315 ●
Schelling	520	4,4	3,2	30	2/13/94	72	WZ	15	■	163316 ●
	550	5,2	3,5	30	KNL	60	WZ	15	■	163317 ●
	550	5,2	3,5	80	2/13/100	60	WZ	15	■	163318 ●



HW



Sizing of single boards and stacks of boards *Premium*

Application:

For panel sizing of single boards and stacks of boards with scoring.

Machine:

Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered.

Technical information:

Premium design with vibration damping laser ornaments.

Circular sawblade

WK 852 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
Homag	300	4,4	3,2	30	KNL	60	FZ/TR	15	■	163400 ●
Homag	300	4,4	3,2	60	2/14/100	72	FZ/TR	15	■	163401 ●
Selco	300	4,4	3,2	65	2/9/110	60	FZ/TR	15	■	163402 ●
Homag	300	4,4	3,2	75		60	FZ/TR	15	■	163403 ●
Gabbiani, SCM	300	4,4	3,2	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	60	FZ/TR	15	■	163456 ●
Homag	308	3,2	2,4	60	2/14/100	96	FZ/TR	15	■	163404 ●
Homag	310	4,4	3,2	60	2/14/100	72	FZ/TR	15	■	163405 ●
Felder, Mayer	320	4,4	3,2	30	KNL	60	FZ/TR	15	■	163406 ●
Selco	320	4,4	3,2	65	2/9/110	60	FZ/TR	15	■	163407 ●
Gabbiani, SCM	320	4,4	3,2	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	60	FZ/TR	15	■	163457 ●
Gabbiani, SCM	340	4,4	3,2	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	72	FZ/TR	15	■	163458 ●
Holz-Her, May- er, Schelling	350	4,4	3,2	30	KNL 2/13/94	72	FZ/TR	15	■	163408 ●
Homag	350	4,4	3,2	60	2/14/100	72	FZ/TR	15	■	163409 ●
Homag	350	4,4	3,2	75		72	FZ/TR	15	■	163410 ●
Gabbiani, SCM	350	4,4	3,2	80	4/9/100 2/7/110 2/14/110	72	FZ/TR	15	■	163454 ●
Selco	355	4,4	3,2	65	2/9/110 2/9/100	72	FZ/TR	15	■	163412 ●
Giben, Homag	355	4,4	3,2	75		72	FZ/TR	15	■	163413 ●
Schelling	360	4,4	3,2	30	2/13/94	72	FZ/TR	15	■	163414 ●
Selco	360	4,4	3,2	65	2/9/100 2/9/110	72	FZ/TR	15	■	163415 ●
	370	4,4	3,2	30	2/13/94 KNL	72	FZ/TR	15	■	163416 ●
Giben	380	4,4	3,2	50	2/13/80 6/13/80	72	FZ/TR	15	■	163417 ●
Homag	380	4,4	3,2	60	2/14/100 2/14/125	72	FZ/TR	15	■	163418 ●
Selco	380	4,4	3,2	65	2/9/110	72	FZ/TR	15	■	163461 ●
Homag	380	4,8	3,5	60	2/14/100 2/14/125	72	FZ/TR	15	■	163419 ●
Giben	380	4,4	3,2	75	3/15/75 2/7/110	72	FZ/TR	15	■	163420 ●
Gabbiani, SCM	380	4,4	3,2	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	72	FZ/TR	15	■	163459 ●

1. Sawing

1.4 Panel sizing

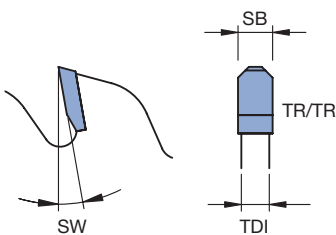
1.4.2 Panel sizing sawblades FZ/TR

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
Mayer, Schelling	400	4,4	3,2	30	KNL 2/13/94	72	FZ/TR	15	■	163421 ●
Anthon	400	4,4	3,2	60	2/11/85	72	FZ/TR	15	■	163422 ●
Giben, Homag	400	4,4	3,2	75	4/15/105 2/7/110	72	FZ/TR	15	■	163423 ●
Gabbiani, Selco, SCM	400	4,4	3,2	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	72	FZ/TR	15	■	163455 ●
Homag	420	4,8	3,5	60	2/14/125 2/19/120	72	FZ/TR	15	■	163426 ●
Schelling	430	4,4	3,2	30	KNL	72	FZ/TR	15	■	163427 ●
Giben	430	4,4	3,2	75	4/15/105 2/7/110	72	FZ/TR	15	■	163428 ●
Selco, Gabbiani, SCM	430	4,4	3,2	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	72	FZ/TR	15	■	163429 ●
Mayer, Schel- ling	450	4,4	3,2	30	KNL 2/13/94	72	FZ/TR	15	■	163430 ●
Homag	450	4,8	3,5	60	2/14/125 2/19/120	72	FZ/TR	15	■	163431 ●
Gabbiani, SCM	450	4,4	3,2	80	2/9/100 2/14/110 2/7/110	72	FZ/TR	15	■	163432 ●
Selco	450	4,8	3,6	80	2/9/130 4/19/120	72	FZ/TR	15	■	163433 ●
Schelling	460	4,4	3,2	30	2/13/94	72	FZ/TR	15	■	163434 ●
Giben	470	4,4	3,2	75	4/15/105	96	FZ/TR	15	■	163435 ●
Schelling	480	4,4	3,2	30	KNL 2/13/94	72	FZ/TR	15	■	163436 ●
Homag	480	4,8	3,5	60	2/19/120	72	FZ/TR	15	■	163437 ●
Selco	480	4,8	3,5	80	2/9/130 4/19/120	72	FZ/TR	15	■	163438 ●
Schelling	500	5,2	3,5	30	KNL	60	FZ/TR	15	■	163439 ●
Anthon, Homag	500	5,2	3,5	60	2/11/115 2/19/120	60	FZ/TR	15	■	163440 □
Selco	510	4,8	3,5	80	2/9/130 4/19/120	72	FZ/TR	15	■	163441 ●
Schelling	520	4,4	3,2	30	2/13/94	72	FZ/TR	15	■	163442 ●
Homag	520	4,8	3,5	60	2/11/115 2/19/120	72	FZ/TR	15	■	163443 ●
Selco	520	4,8	3,5	70	4/11/130	72	FZ/TR	15	■	163444 ●
Gabbiani, SCM	530	4,8	3,5	80	4/9/100 2/14/110 2/7/110	72	FZ/TR	15	■	163460 ●
Homag	570	4,8	3,5	60	2/11/115 2/19/120	60	FZ/TR	22	■	163445 ●
Homag, Anthon	600	5,8	4,0	60	2/19/120 2/11/115 2/11/85	60	FZ/TR	22	■	163446 ●
Homag, Anthon	600	5,8	4,0	60	2/19/120 2/11/115 2/11/85	72	FZ/TR	22	■	163447 ●
Homag	670	5,8	4,2	60	2/11/148 2/19/120	42	FZ/TR	22	■	163448 ●
Schelling	680	6,2	4,2	40	2/13/114 2/13/140	60	FZ/TR	22	■	163449 ●
Anthon	700	6,2	4,4	80	1/17/110	60	FZ/TR	22	■	163450 ●
Schelling	720	6,5	4,5	40	2/13/140 2/13/114	60	FZ/TR	22	■	163451 ●
Homag	730	6,2	4,2	60	2/11/148 2/19/120	60	FZ/TR	22	■	163452 ●
Anthon	750	7,0	5,0	80	1/17/110	70	FZ/TR	22	■	163453 ●

1. Sawing

1.4 Panel sizing

1.4.3 Panel sizing sawblades TR/TR



Sizing of single boards in finish cut quality - RazorCut

Application:

For panel sizing of single boards and stacks of boards with low cutting heights (up to 60 mm) with scoring.

Machine:

Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

Chipboard and fibre materials plastic coated, duroplastics (compact laminate panels, e.g. HPL).

Technical information:

Special cutting geometry for excellent cutting results in finish cut quality. Suitable for high feed speeds in batch size 1 production. Design with irregular pitch and vibration damping laser ornaments for optimal running behaviour.

Circular sawblade RazorCut

WK 878 2 87

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
	300	3,2	2.2	30	KNL	72	TR/TR	15	■ ■	163370 ●
	300	4,4	3.2	30	KNL	60	TR/TR	15	■ ■	163369 ●
Homag	300	4,4	3.2	60	2/14/100	72	TR/TR	15	■ ■	163371 ●
Selco	300	4,4	3.2	65	2/9/110	60	TR/TR	15	■ ■	163372 ●
Giben	320	4,4	3.2	50	3/15/80	60	TR/TR	15	■ ■	163374 ●
Homag	320	4,4	3.2	60	2/14/100	72	TR/TR	15	■ ■	163394 ●
Selco	320	4,4	3.2	65	2/9/110	60	TR/TR	15	■ ■	163375 ●
Giben	320	4,4	3.2	75	3/13/95	60	TR/TR	15	■ ■	163376 ●
					3/7/100					
SCM, Gabbiani	320	4,4	3.2	80	2/14/110	60	TR/TR	15	■ ■	163377 ●
					2/7/110					
					4/9/100					
					4/19/120					
					2/9/130					
SCM, Gabbiani	340	4,4	3.2	80	2/14/110	72	TR/TR	15	■ ■	163378 ●
					2/7/110					
					4/9/100					
					4/19/120					
					2/9/130					
Holz-Her, Mayer, Schelling	350	4,4	3.2	30	KNL	72	TR/TR	15	■ ■	163379 ●
					2/13/94					
Homag	350	4,4	3.2	60	2/14/100	72	TR/TR	15	■ ■	163380 ●
Giben	350	4,4	3,2	75		72	TR/TR	15	■ ■	163395 ●
Selco	355	4,4	3.2	65	2/9/100	72	TR/TR	15	■ ■	163381 ●
					2/9/110					
Schelling	360	4,4	3.2	30	2/13/94	72	TR/TR	15	■ ■	163382 ●
Holz-Her	380	4,4	3.2	30	KNL	72	TR/TR	15	■ ■	163383 ●
Giben	380	4,4	3,2	50	4/13/80	72	TR/TR	15	■ ■	163396 ●
Homag	380	4,4	3.2	60	2/14/100	72	TR/TR	15	■ ■	163384 ●
					2/14/125					
Selco	380	4,4	3.2	65	2/9/110	72	TR/TR	15	■ ■	163386 ●
Homag	380	4,8	3.5	60	2/14/100	72	TR/TR	15	■ ■	163385 ●
					2/14/125					
Homag	380	4,8	3,5	60	2/14/100	84	TR/TR	15	■ ■	163750 ●
					2/14/125					
Mayer, Schelling	400	4,4	3.2	30	KNL	72	TR/TR	15	■ ■	163387 ●
					2/13/94					
Selco	400	4,4	3.2	65	2/9/110	72	TR/TR	15	■ ■	163388 ●
Selco	430	4,4	3.2	65	2/9/110	72	TR/TR	15	■ ■	163389 ●

1. Sawing

1.4 Panel sizing

1.4.3 Panel sizing sawblades TR/TR

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
SCM, Gabbiani, Selco	430	4,4	3,2	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	72	TR/TR	15	■ ■	163397 ●
Homag	450	4,8	3,5	60	2/14/125 2/19/120	72	TR/TR	15	■ ■	163390 ●
Selco	450	4,8	3,5	80	2/9/130 4/19/120	72	TR/TR	15	■ ■	163398 ●
Schelling	460	4,4	3,2	30	2/13/94	72	TR/TR	15	■ ■	163391 ●
Selco	470	4,8	3,5	70	4/11/130	72	TR/TR	15	■ ■	163392 ●
Anthon, Homag	500	4,8	3,5	60	2/11/115 2/19/20	72	TR/TR	15	■ ■	163393 ●
Schelling	520	4,8	3,5	30	2/13/94	72	TR/TR	15	■ ■	163399 ●



Sizing of single boards in finish cut quality - RazorCut PLUS

Application:

For panel sizing of single boards and stacks of boards with low cutting heights (up to 60 mm) with scoring.

Machine:

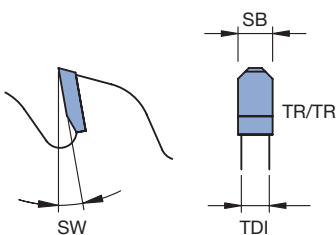
Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

Chipboard and fibre materials plastic coated, duroplastics (compact laminate panels, e.g. HPL).

Technical information:

Optimal cutting quality due to special cutting edge geometry and maximal quite running. Suitable for high feed speeds in batch size 1 production. Design with irregular pitch and vibration damping laser ornaments for optimal running behaviour. Maximal tool life through extremely wear-resistant cutting material.



Circular sawblade RazorCut PLUS

WK 878 2 87

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
	250	3,2	2,2	30	KNL	60	TR/TR	15	■ ■	161135 ●
	280	3,2	2,2	30	KNL	60	TR/TR	15	■ ■	161136 ●
	300	3,2	2,2	30	KNL	72	TR/TR	15	■ ■	161138 ●
Schelling	300	3,2	2,5	30	2/13/94	72	TR/TR	15	■ ■	161139 ●
	300	4,4	3,0	30	KNL	60	TR/TR	15	■ ■	161137 ●
Homag	300	4,4	3,0	60	2/14/100	72	TR/TR	15	■ ■	161140 ●
Selco	300	4,4	3,0	65	2/9/110	60	TR/TR	15	■ ■	161141 ●
SCM, Gabbiani	300	4,4	3,0	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	60	TR/TR	15	■ ■	161142 ●
Homag	308	3,2	2,4	60	2/14/100	96	TR/TR	15	■ ■	161143 ●
Homag	310	4,4	3,2	60	2/14/100	72	TR/TR	15	■ ■	161144 ●
Giben	320	4,4	3,2	50	3/15/80	60	TR/TR	15	■ ■	161145 ●
Selco	320	4,4	3,2	65	2/9/110	60	TR/TR	15	■ ■	161146 ●
SCM, Gabbiani	340	4,4	3,2	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	72	TR/TR	15	■ ■	161148 ●
Holz-Her, Mayer, Schelling	350	4,4	3,2	30	KNL 2/13/94	72	TR/TR	15	■ ■	161149 ●

- Solid wood
- Board, coated
- Board, uncoated
- Non-ferrous metals

- Plastics
- Mineral materials
- Composites
- Steel, thin-walled

1. Sawing

1.4 Panel sizing

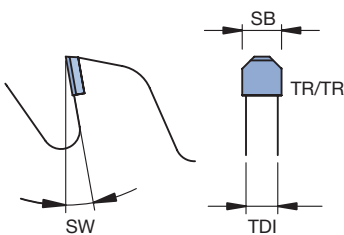
1.4.3 Panel sizing sawblades TR/TR

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
Homag	350	4,4	3,2	60	2/14/100	72	TR/TR	15	 	161150 ●
Giben	350	4,4	3,2	75		72	TR/TR	15	 	161151 ●
Selco	355	4,4	3,2	65	2/9/100	72	TR/TR	15	 	161152 ●
					2/9/110					
Selco	355	4,4	3,2	80	2/9/130	72	TR/TR	15	 	161153 ●
					4/19/120					
Schelling	360	4,4	3,2	30	2/13/94	72	TR/TR	15	 	161154 ●
	370	4,4	3,2	30	KNL	72	TR/TR	15	 	161155 ●
Holz-Her	380	4,4	3,2	30	KNL	72	TR/TR	15	 	161156 ●
Giben	380	4,4	3,2	50	4/13/80	72	TR/TR	15	 	161157 ●
Homag	380	4,4	3,2	60	2/14/100	72	TR/TR	15	 	161158 ●
					2/14/125					
SCM, Gabbiani	380	4,4	3,2	80	2/14/110	72	TR/TR	15	 	161160 ●
					2/7/110					
					4/9/100					
					4/19/120					
					2/9/130					
Homag	380	4,8	3,5	60	2/14/100	72	TR/TR	15	 	161159 ●
					2/14/125					
Mayer, Schelling	400	4,4	3,2	30	KNL	72	TR/TR	15	 	161161 ●
					2/13/94					
Giben, Homag	400	4,4	3,2	75	4/15/105	72	TR/TR	15	 	161162 ●
					2/7/110					
SCM, Gabbiani, Selco	400	4,4	3,2	80	2/14/110	72	TR/TR	15	 	161163 ●
					2/7/110					
					4/9/100					
					4/19/120					
					2/9/130					
Homag	420	4,8	3,5	60	2/14/125	72	TR/TR	15	 	161164 ●
					2/19/120					
Schelling	430	4,4	3,2	30	KNL	72	TR/TR	15	 	161165 ●
Giben	430	4,4	3,2	75	4/15/105	72	TR/TR	15	 	161166 ●
					2/7/110					
SCM, Gabbiani, Selco	430	4,4	3,2	80	2/14/110	72	TR/TR	15	 	161167 ●
					2/7/110					
					4/9/100					
					4/19/120					
					2/9/130					
Mayer, Schelling	450	4,4	3,2	30	KNL	72	TR/TR	15	 	161168 ●
					2/13/94					
Homag	450	4,8	3,5	60	2/14/125	72	TR/TR	15	 	161169 ●
					2/19/120					
Schelling	460	4,4	3,2	30	2/13/94	72	TR/TR	15	 	161170 ●

1. Sawing

1.4 Panel sizing

1.4.3 Panel sizing sawblades TR/TR



Sizing of single boards and stacks of boards *Excellent*

Application:

For panel sizing of single boards and stacks of boards with scoring.

Machine:

Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

Chipboard and fibre materials plastic coated, duroplastics (compact laminate panels, e.g. HPL), fibre reinforced materials (e.g. GFRP, CFRP).

Technical information:

DP equipment for long tool life. **Excellent** version with irregular tooth pitch and filled laser ornaments for vibration damping and reduction of noise level. Coating of the tool body for higher running performance. Mounting height 6 mm for multiple resharping.

Panel sizing sawblade TR/TR, Diamaster PLUS

WK 278 2, WK 858 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
	300	4,4	3,2	30	KNL	60	TR/TR	15		190706 ●
Homag	308	3,2	2,4	60	2/14/100	96	TR/TR	10		190746 ●
Holz-Her, May- er, Schelling	350	4,4	3,2	30	KNL 2/13/94	72	TR/TR	15		190707 ●
Homag	350	4,4	3,2	60	2/14/100 2/14/125	72	TR/TR	15		190708 ●
Homag	380	4,4	3,2	60	2/14/100 2/14/125	72	TR/TR	15		190709 ●
Homag	380	4,8	3,5	60	2/14/100 2/14/125	72	TR/TR	15		190710 ●
Mayer, Schel- ling	400	4,4	3,2	30	KNL 2/13/94	72	TR/TR	15		190711 ●
Homag	450	4,8	3,5	60	2/14/125 2/19/120	72	TR/TR	15		190712 ●

1. Sawing

1.4 Panel sizing

1.4.4 Scoring sawblades for panel saws KON



Scoring sawblade KON/WZ

Application:

For scoring with feed.

Machine:

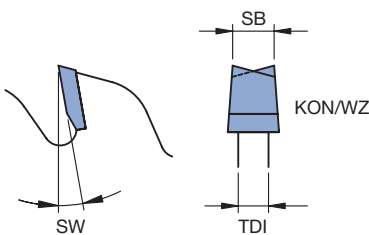
Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood).

Technical information:

Scoring depth 1.50 - 2.00 mm. For universal use in any surface coating. The suitable scoring circular sawblade must be selected depending on the cutting width of the main saw.



Scoring sawblade KON/WZ, TC design

WK 856 2 01, WK 856 2 05

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
	125	3,2	2,5	20		24	KON/WZ	5	■	165550 ●
	125	3,2	2,5	22		24	KON/WZ	5	■	165551 ●
Giben, Homag, Mayer	125	4,4	3,5	45		24	KON/WZ	5	■	165553 ●
Schelling	150	4,4	3,5	20		24	KON/WZ	5	■	165554 ●
Felder, Mayer	150	4,4	3,5	30		36	KON/WZ	5	■	165555 ●
Felder, Mayer	150	4,4	3,5	30		24	KON/WZ	5	■	165556 ●
Homag	150	4,4	3,5	45		24	KON/WZ	5	■	165557 ●
Homag	150	4,4	3,5	45		28	KON/WZ	5	■	165558 ●
	160	3,2	2,5	20		32	KON/WZ	5	■	165559 ●
Steton	160	4,4	3,5	30		36	KON/WZ	5	■	165560 ●
Giben	160	4,4	3,5	45	3/11/70	36	KON/WZ	5	■	165561 ●
Gabbiani	160	4,4	3,5	55	3/7/66 3/6/84	36	KON/WZ	5	■	165562 ●
	180	3,2	2,5	20		36	KON/WZ	5	■	165563 ●
	180	4,4	3,5	20		36	KON/WZ	5	■	165564 ●
Anthon, Homag	180	4,4	3,5	45		30	KON/WZ	5	■	165565 ●
Anthon, Homag	180	4,4	3,5	45		36	KON/WZ	5	■	165566 ●
Giben	180	4,5	3,2	50	3/13/80	36	KON/WZ	5	■	165567 ●
Schelling	200	4,4	3,5	20	2/11/66	36	KON/WZ	5	■	165569 ●
	200	6,2	4,5	20	2/11/66	36	KON/WZ	5	■	165570 ●
	200	3,2	2,5	30	2/10/60	60	KON/WZ	5	■	165571 ●
	200	4,4	3,5	30	2/10/60	36	KON/WZ	5	■	165572 ●
Schelling	200	4,8	3,5	20		36	KON/WZ	5	■	165573 ●
Homag	200	4,4	3,5	45		36	KON/WZ	5	■	165574 ●
Homag	200	5,8	4,6	45		36	KON/WZ	5	■	165575 ●
Selco	200	4,4	3,5	65	2/9/100	36	KON/WZ	5	■	165576 ●
					2/9/110					
Selco	200	4,8	3,5	65	2/9/100	36	KON/WZ	5	■	165577 ●
					2/9/110					
Giben	215	4,4	3,5	50	3/15/80	42	KON/WZ	5	■	165578 ●
					2/7/80					
Schelling	220	6,5	4,5	20	2/11/66	36	KON/WZ	5	■	165579 ●
Homag	280	4,8	3,5	45		72	KON/WZ	5	■	165581 ●
Schelling	300	4,4	3,5	30	2/11/73	48	KON/WZ	5	■	165582 ●
					2/13/94					
Giben	300	4,4	3,5	50	3/15/80	48	KON/WZ	5	■	165583 ●
Selco	300	4,4	3,5	65	2/9/100	72	KON/WZ	5	■	165584 ●
					2/9/110					
Selco	300	4,4	3,5	65	3/15/80	48	KON/WZ	5	■	165585 □
					2/9/110					

1. Sawing

1.4 Panel sizing

1.4.4 Scoring sawblades for panel saws KON



Scoring sawblades KON/FZ

Application:

For scoring with feed.

Machine:

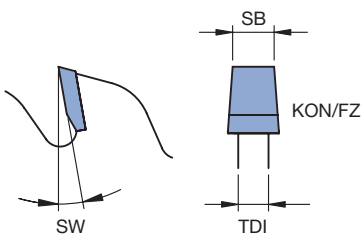
Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood).

Technical information:

Scoring depth 1.50 - 2.00 mm. Recommended especially for use in plastic and HPL-coated panels. The suitable circular scoring sawblade must be selected depending on the cutting width of the main saw.



Scoring sawblades KON/FZ, TC design

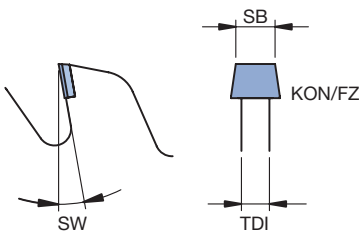
WK 804 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
SCM	100	3,2	2,5	20		20	KON/FZ	5	■	165625 ●
	100	3,2	2,5	22		20	KON/FZ	5	■	165626 ●
	120	3,2	2,5	20		24	KON/FZ	5	■	165627 ●
	125	4,4	3,5	20		24	KON/FZ	5	■	165628 ●
Holz-Her	125	4,4	3,5	45		24	KON/FZ	5	■	165629 ●
Anthon	180	4,4	3,5	20		28	KON/FZ	5	■	165630 ●
Anthon	180	5,8	4,0	20		36	KON/FZ	5	■	165631 ●
Holz-Her	180	4,4	3,5	30	2/10/60	30	KON/FZ	5	■	165632 ●
Homag	180	4,4	3,5	45		36	KON/FZ	5	■	165633 ●
Homag	180	4,8	3,5	45		36	KON/FZ	5	■	165634 ●
Anthon	200	6,8	4,2	20		36	KON/FZ	5	■	165635 ●
Homag	200	4,8	3,5	45		36	KON/FZ	5	■	165636 ●
SCM	200	4,4	3,5	80	2/14/110	36	KON/FZ	5	■	165637 ●
Homag	220	3,2	2,4	45		60	KON/FZ	5	■	165638 ●
	250	4,4	3,5	30	2/10/60	42	KON/FZ	5	■	165639 ●
Holz-Her	280	4,4	3,5	30	2/10/60	48	KON/FZ	5	■	165640 ●
Schelling	300	3,2	2,8	30	2/13/94	72	KON/FZ	5	■	165641 ●

1. Sawing

1.4 Panel sizing

1.4.4 Scoring sawblades for panel saws KON



Scoring sawblades KON/FZ *Excellent*

Application:

For scoring with feed.

Machine:

Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), alu composite panels (e.g. Alucobond®), duroplastics (compact laminate panels, e.g. HPL), fibre reinforced materials (e.g. GFRP, CFRP)

Technical information:

Scoring depth 2.00 - 2.50 mm. Recommended especially for use in plastic and HPL-coated panels. Long tool life due to DP tipping. The suitable circular scoring sawblade must be selected depending on the cutting width of the main saw. Can be used in combination with HW- and DP-tipped main circular sawblades. The cutting width (SB) of the scoring circular sawblades is 0.1 mm less for use in combination with resharpened TC-tipped main circular sawblades.

Scoring sawblades KON/FZ, Diamaster PLUS

WK 804 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
	125	3,1	2,5	20		20	KON/FZ	10		190564 ●
	125	3,1	2,5	22		20	KON/FZ	10		190614 □
Felder, Mayer	150	4,3	3,2	30		24	KON/FZ	10		190565 ●
Gabbiani	160	4,3	3,5	55	3/ 7/ 66	30	KON/FZ	10		190566 ●
Holz-Her	180	4,3	3,5	30	2/10/ 60	30	KON/FZ	10		190567 ●
Homag	180	4,3	3,5	45		30	KON/FZ	10		190568 ●
Homag	180	4,7	3,5	45		30	KON/FZ	10		190569 ●
Schelling	200	4,3	3,5	20	2/11/66	30	KON/FZ	10		190570 ●
	200	4,3	3,5	30	2/10/ 60	30	KON/FZ	10		190571 ●
Homag	200	4,3	3,5	45		30	KON/FZ	10		190572 ●
	200	4,3	3,5	80		30	KON/FZ	10		190616 □
Selco	200	4,3	3,5	65	2/9/100	30	KON/FZ	10		190615 ●
					2/9/110					
					2/14/110					
Homag	200	4,7	3,5	45		30	KON/FZ	10		190573 ●
Selco	200	4,7	3,5	65	2/9/110	30	KON/FZ	10		190574 ●
					2/9/100					
Homag	220	3,1	2,4	45		48	KON/FZ	10		190744 ●
Schelling	300	4,3	3,5	30	2/11/73	48	KON/FZ	10		190743 ●
					2/13/94					

1. Sawing

1.4 Panel sizing

1.4.5 Scoring sawblades - softforming / postforming



Scoring sawblade - softforming / postforming

Application:

For scoring with feed at high feed rates and deep cutting depths.

Machine:

Panel sizing saws with adjustable soft and postforming units and pressure beam.

Workpiece material:

Chipboard and fibre materials paper and plastic coated.

Technical information:

Dimension and tooth shape according to machine manufacturers' specification.

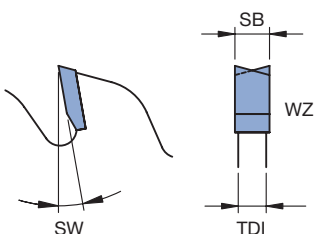
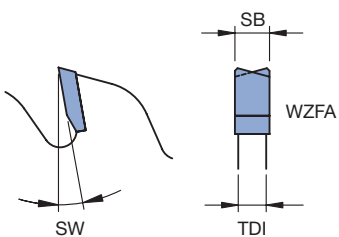
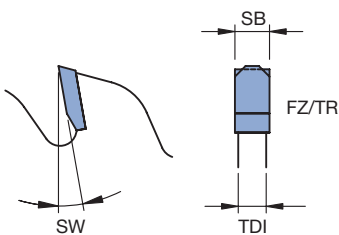
Circular sawblade FZ/TR

WK 852 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	$n_{\max}$	WSS	ID
	mm	mm	mm	mm	mm			°	min ⁻¹		
	220	3,35	2,5	30		48	FZ/TR	10	10400	■	165676 ●
	250	4,55	3,2	30	2/10/60	48	FZ/TR	10	9100	■	165677 ●
Holz-Her	280	4,55	3,2	30	2/10/60	60	FZ/TR	10	8100	■	165678 ●
Homag	350	4,55	3,2	75		72	FZ/TR	10	6500	■	165679 ●
	450	4,8	3,5	30	2/10/60	72	FZ/TR	10	4200	■	165680 ●



HW



Circular sawblade WZFA

WK 251 2, WK 851 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	$n_{\max}$	WSS	ID
	mm	mm	mm	mm	mm			°	min ⁻¹		
	180	4,55	3,2	30		36	WZFA	10	12700	■	165681 ●
Schelling	300	4,55	3,2	30	2/11/73 2/13/94	72	WZFA	10	7600	■	165682 ●
Selco	300	4,55	3,2	65	2/9/110	72	WZFA	10	7600	■	165683 ●

Circular sawblade WZ

WK 850 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	$n_{\max}$	WSS	ID
	mm	mm	mm	mm	mm			°	min ⁻¹		
Homag	280	4,55	3,2	45		84	WZ	10	8100	■	165684 ●

1. Sawing

1.4 Panel sizing

1.4.6 Overview scoring and main sawblades

Machine-Type	Tool Type	ABM mm	Z	QAL	ZF	System	ID
Gabbiani-P60	Main sawblade	300x4.4x80	60	HW	TR/TR	RazorCut PLUS	161142 ●
	Main sawblade	300x4.4x80	60	HW	FZ/TR		163456 ●
	Scoring sawblade	200x4.4x80	36	HW	KON/FZ		165637 ●
Gabbiani-P80	Main sawblade	340x4.4x80	72	HW	TR/TR	RazorCut	163378 ●
	Main sawblade	340x4.4x80	72	HW	TR/TR	RazorCut PLUS	161148 ●
	Main sawblade	340x4.4x80	72	HW	FZ/TR		163458 ●
	Scoring sawblade	200x4.4x80	36	HW	KON/FZ		165637 ●
Gabbiani-G2 115	Main sawblade	400x4.4x80	72	HW	TR/TR	RazorCut PLUS	161163 ●
	Main sawblade	400x4.4x80	72	HW	FZ/TR		163455 ●
	Scoring sawblade	200x4.4x80	36	HW	KON/FZ		165637 ●
Gabbiani-G2 130	Main sawblade	430x4.4x80	72	HW	TR/TR	RazorCut PLUS	161167 ●
	Main sawblade	430x4.4x80	72	HW	FZ/TR		163429 ●
	Scoring sawblade	200x4.4x80	36	HW	KON/FZ		165637 ●
Gabbiani-S95	Main sawblade	380x4.4x80	72	HW	TR/TR	RazorCut PLUS	161160 ●
	Main sawblade	380x4.4x80	72	HW	FZ/TR		163459 ●
	Scoring sawblade	160x4.4x55	36	HW	KON/WZ		165562 ●
	Scoring sawblade	160x4.3/5.1x55	30	DP	KON/FZ		190566 ●
Gabbiani-S115	Main sawblade	400x4.4x80	72	HW	TR/TR	RazorCut PLUS	161163 ●
	Main sawblade	400x4.4x80	72	HW	FZ/TR		163455 ●
	Scoring sawblade	160x4.4x55	36	HW	KON/WZ		165562 ●
	Scoring sawblade	160x4.3/5.1x55	30	DP	KON/FZ		190566 ●
Holz-Her-Tectra 6120 Classic	Main sawblade	350x4.4x30	54	HW	WZ	RazorCut PLUS	163301 ●
	Main sawblade	350x4.4x30	72	HW	WZ		163302 ●
	Main sawblade	350x4.4x30	72	HW	FZ/TR		163408 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR		163379 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR		161149 ●
	Main sawblade	350x4.4x30	72	DP	TR/TR		190707 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ		190567 ●
Holz-Her-Tectra 6120 Dynamic, Lift, Power	Main sawblade	380x4.4x30	72	HW	TR/TR	RazorCut	163383 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ		190567 ●
Holz-Her-Zentrex 6220 Classic	Main sawblade	380x4.4x30	72	HW	TR/TR	RazorCut	163383 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ		190567 ●
Holz-Her-Zentrex 6220 Dynamic, Lift, Power	Main sawblade	430x4.4x30	72	HW	WZ	RazorCut PLUS	163310 ●
	Main sawblade	430x4.4x30	72	HW	FZ/TR		163427 ●
	Main sawblade	400x4.4x80	72	HW	TR/TR		161163 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ		190567 ●
Homag-HKL300	Main sawblade	350x4.4x60	72	HW	WZ	RazorCut PLUS	163304 ●
	Main sawblade	350x4.4x60	72	HW	FZ/TR		163409 ●
	Main sawblade	350x4.4x60	72	HW	TR/TR		163380 ●
	Main sawblade	350x4.4x60	72	HW	TR/TR		161150 ●
	Main sawblade	350x4.4x60	72	DP	TR/TR		190708 ●
	Scoring sawblade	180x4.4x45	30	HW	KON/WZ		165565 ●
	Scoring sawblade	180x4.4x45	36	HW	KON/WZ		165566 ●
	Scoring sawblade	180x4.4x45	36	HW	KON/FZ		165633 ●
	Scoring sawblade	180x4.3/5.1x45	30	DP	KON/FZ		190568 ●
Homag-HKL600	Main sawblade	600x5.8x60	60	HW	FZ/TR		163446 ●
	Main sawblade	600x5.8x60	72	HW	FZ/TR		163447 ●
	Scoring sawblade	200x5.8x45	36	HW	KON/WZ		165575 ●
Homag-HPP130	Main sawblade	300x4.4x60	72	HW	FZ/TR	RazorCut PLUS	163401 ●
	Main sawblade	300x4.4x60	72	HW	TR/TR		161140 ●
	Main sawblade	300x4.4x60	72	HW	TR/TR		163371 ●
	Scoring sawblade	150x4.4x45	24	HW	KON/WZ		165557 ●
	Scoring sawblade	150x4.4x45	28	HW	KON/WZ		165558 ●

1. Sawing

1.4 Panel sizing

1.4.6 Overview scoring and main sawblades

Machine-Type	Tool Type	ABM mm	Z	QAL	ZF	System	ID
Homag- HPP200	Main sawblade	350x4.4x60	72	HW	WZ		163304 ●
	Main sawblade	350x4.4x60	72	HW	FZ/TR		163409 ●
	Main sawblade	350x4.4x60	72	HW	TR/TR	RazorCut	163380 ●
	Main sawblade	350x4.4x60	72	HW	TR/TR	RazorCut PLUS	161150 ●
	Main sawblade	350x4.4x60	72	DP	TR/TR		190708 ●
	Scoring sawblade	200x4.4x45	36	HW	KON/WZ		165574 ●
	Scoring sawblade	200x4.3/5.1x45	30	DP	KON/FZ		190572 ●
Homag- HPP300, HPL300, HKL300	Main sawblade	380x4.8x60	54	HW	WZ		163307 ●
	Main sawblade	380x4.4x60	72	HW	FZ/TR		163418 ●
	Main sawblade	380x4.8x60	72	HW	FZ/TR		163419 ●
	Main sawblade	380x4.4x60	72	HW	TR/TR	RazorCut PLUS	161158 ●
	Main sawblade	380x4.8x60	72	HW	TR/TR	RazorCut PLUS	161159 ●
	Main sawblade	380x4.4x60	72	HW	TR/TR	RazorCut	163384 ●
	Main sawblade	380x4.8x60	72	HW	TR/TR	RazorCut	163385 ●
	Scoring sawblade	180x4.4x45	30	HW	KON/WZ		165565 ●
	Scoring sawblade	180x4.4x45	36	HW	KON/WZ		165566 ●
	Scoring sawblade	180x4.4x45	36	HW	KON/FZ		165633 ●
	Scoring sawblade	180x4.8x45	36	HW	KON/FZ		165634 ●
	Scoring sawblade	180x4.3/5.1x45	30	DP	KON/FZ		190568 ●
	Scoring sawblade	180x4.7/5.5x45	30	DP	KON/FZ		190569 ●
Homag- HPP400	Main sawblade	450x4.8x60	72	HW	FZ/TR		163431 ●
	Main sawblade	450x4.8x60	72	HW	TR/TR	RazorCut	163390 ●
	Main sawblade	450x4.8x60	72	HW	TR/TR	RazorCut PLUS	161169 ●
	Main sawblade	450x4.8x60	72	DP	TR/TR		190712 ●
	Scoring sawblade	180x4.8x45	36	HW	KON/FZ		165634 ●
	Scoring sawblade	180x4.7/5.5x45	30	DP	KON/FZ		190569 ●
Mayer- kappa automatic 80	Main sawblade	300x4.4x30	60	HW	TR/TR	RazorCut	163369 ●
	Main sawblade	300x4.4x30	60	HW	TR/TR	RazorCut PLUS	161137 ●
	Main sawblade	320x4.4x30	60	HW	FZ/TR		163406 ●
	Scoring sawblade	150x4.4x30	36	HW	KON/WZ		165555 ●
	Scoring sawblade	150x4.4x30	24	HW	KON/WZ		165556 ●
	Scoring sawblade	150x4.3/5.1x30	24	DP	KON/FZ		190565 ●
Mayer- kappa automatic 100	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut PLUS	161149 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut	163379 ●
	Main sawblade	350x4.4x30	72	HW	FZ/TR		163408 ●
	Main sawblade	355x4.4x30	72	HW	WZ		163306 ●
	Scoring sawblade	150x4.4x30	36	HW	KON/WZ		165555 ●
	Scoring sawblade	150x4.4x30	24	HW	KON/WZ		165556 ●
	Scoring sawblade	150x4.3/5.1x30	24	DP	KON/FZ		190565 ●
	Main sawblade	350x4.4x30	72	DP	TR/TR		190707 ●
Mayer- kappa automatic 120	Main sawblade	400x4.4x30	72	HW	TR/TR	RazorCut PLUS	161161 ●
	Main sawblade	400x4.4x30	72	HW	TR/TR	RazorCut	163387 ●
	Main sawblade	400x4.4x30	72	HW	FZ/TR		163421 ●
	Main sawblade	400x4.4x30	60	HW	WZ		163308 ●
	Main sawblade	400x4.4x30	72	HW	WZ		163309 ●
	Scoring sawblade	150x4.4x30	36	HW	KON/WZ		165555 ●
	Scoring sawblade	150x4.4x30	24	HW	KON/WZ		165556 ●
	Scoring sawblade	150x4.3/5.1x30	24	DP	KON/FZ		190565 ●
	Main sawblade	400x4.4x30	72	DP	TR/TR		190711 ●
Mayer- kappa automatic 140	Main sawblade	500x5.2x30	60	HW	FZ/TR		163439 ●
	Main sawblade	500x5.2x30	60	HW	WZ		163314 ●
	Scoring sawblade	150x4.4x30	36	HW	KON/WZ		165555 ●
	Scoring sawblade	150x4.4x30	24	HW	KON/WZ		165556 ●
	Scoring sawblade	150x4.3/5.1x30	24	DP	KON/FZ		190565 ●
Schelling- ASH	Main sawblade	720x6.5x40	60	HW	FZ/TR		163451 ●
	Scoring sawblade	220x6.5x20	36	HW	KON/WZ		165579 ●
Schelling- fh3	Main sawblade	300x4.4x30	48	HW	WZ		163300 ●
	Main sawblade	300x4.4x30	60	HW	FZ/TR		163400 ●
	Main sawblade	300x4.4x30	60	HW	TR/TR	RazorCut PLUS	161137 ●
	Main sawblade	300x4.4x30	60	HW	TR/TR	RazorCut	163369 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ		190567 ●

1. Sawing

1.4 Panel sizing

1.4.6 Overview scoring and main sawblades

Machine-Type	Tool Type	ABM mm	Z	QAL	ZF	System	ID
Schelling- fh3 Plus package	Main sawblade	350x4.4x30	54	HW	WZ		163301 ●
	Main sawblade	350x4.4x30	72	HW	WZ		163302 ●
	Main sawblade	350x4.4x30	72	HW	FZ/TR		163408 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut	163379 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut PLUS	161149 ●
	Main sawblade	350x4.4x30	72	DP	TR/TR		190707 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ		190567 ●
Schelling- fh4 (former version)	Main sawblade	350x4.4x30	54	HW	WZ		163301 ●
	Main sawblade	350x4.4x30	72	HW	WZ		163302 ●
	Main sawblade	350x4.4x30	72	HW	FZ/TR		163408 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut	163379 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut PLUS	161149 ●
	Main sawblade	350x4.4x30	72	DP	TR/TR		190707 ●
	Scoring sawblade	300x4.4x30	48	HW	KON/WZ		165582 ●
Schelling- fh4 (new version)	Main sawblade	360x4.4x30	72	HW	FZ/TR		163414 ●
	Main sawblade	360x4.4x30	72	HW	TR/TR	RazorCut PLUS	161154 ●
	Main sawblade	360x4.4x30	72	HW	TR/TR	RazorCut	163382 ●
	Scoring sawblade	200x4.4x20	36	HW	KON/WZ		165569 ●
	Scoring sawblade	200x4.3/5.1x20	30	DP	KON/FZ		190570 ●
Schelling- fh5	Main sawblade	400x4.4x30	60	HW	WZ		163308 ●
	Main sawblade	400x4.4x30	72	HW	WZ		163309 ●
	Main sawblade	400x4.4x30	72	HW	FZ/TR		163421 ●
	Main sawblade	400x4.4x30	72	HW	TR/TR	RazorCut	163387 ●
	Main sawblade	400x4.4x30	72	HW	TR/TR	RazorCut PLUS	161161 ●
	Main sawblade	400x4.4x30	72	DP	TR/TR		190711 ●
	Scoring sawblade	200x4.4x20	36	HW	KON/WZ		165569 ●
	Scoring sawblade	200x4.3/5.1x20	30	DP	KON/FZ		190570 ●
Schelling- fh6	Main sawblade	460x4.4x30	72	HW	FZ/TR		163434 ●
	Main sawblade	460x4.4x30	72	HW	TR/TR	RazorCut	163391 ●
	Main sawblade	460x4.4x30	72	HW	TR/TR	RazorCut PLUS	161170 ●
	Scoring sawblade	200x4.4x20	36	HW	KON/WZ		165569 ●
	Scoring sawblade	200x4.3/5.1x20	30	DP	KON/FZ		190570 ●
Schelling- fh8, fm8	Main sawblade	520x4.4x30	72	HW	WZ		163316 ●
	Main sawblade	520x4.4x30	72	HW	FZ/TR		163442 ●
	Scoring sawblade	200x4.4x20	36	HW	KON/WZ		165569 ●
	Scoring sawblade	200x4.8x20	36	HW	KON/WZ		165573 ●
	Scoring sawblade	200x4.3/5.1x20	30	DP	KON/FZ		190570 ●
Schelling- FSM	Main sawblade	720x6.5x40	60	HW	FZ/TR		163451 ●
Schelling- FTM Option	Main sawblade	680x6.2x40	60	HW	FZ/TR		163449 ●
	Scoring sawblade	220x6.5x20	36	HW	KON/WZ		165579 ●
Schelling- s45	Main sawblade	350x4.4x30	54	HW	WZ		163301 ●
	Main sawblade	350x4.4x30	72	HW	WZ		163302 ●
	Main sawblade	350x4.4x30	72	HW	FZ/TR		163408 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut	163379 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut PLUS	161149 ●
	Main sawblade	350x4.4x30	72	DP	TR/TR		190707 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ		190567 ●
Schelling- s45 Plus package	Main sawblade	400x4.4x30	60	HW	WZ		163308 ●
	Main sawblade	400x4.4x30	72	HW	WZ		163309 ●
	Main sawblade	400x4.4x30	72	HW	FZ/TR		163421 ●
	Main sawblade	400x4.4x30	72	HW	TR/TR	RazorCut	163387 ●
	Main sawblade	400x4.4x30	72	HW	TR/TR	RazorCut PLUS	161161 ●
	Main sawblade	400x4.4x30	72	DP	TR/TR		190711 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ		190567 ●

1. Sawing

1.4 Panel sizing

1.4.6 Overview scoring and main sawblades

Machine-Type	Tool Type	ABM mm	Z	QAL	ZF	System	ID
Selco- EB 100	Main sawblade	360x4.4x65	72	HW	FZ/TR		163415 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ		190615 ●
Selco- EB 70 (kit 80), EB 75, EB 80	Main sawblade	320x4.4x65	60	HW	TR/TR	RazorCut PLUS	161146 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut	163379 ●
	Main sawblade	320x4.4x65	60	HW	FZ/TR		163407 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ		190615 ●
Selco- EB 70 (L)	Main sawblade	300x4.4x65	60	HW	FZ/TR		163402 ●
	Main sawblade	300x4.4x65	60	HW	TR/TR	RazorCut	163372 ●
	Main sawblade	300x4.4x65	60	HW	TR/TR	RazorCut PLUS	161141 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ		190615 ●
Selco- EB 90	Main sawblade	355x4.4x80	72	HW	TR/TR	RazorCut PLUS	161153 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ		190615 ●
Selco- EB 95	Main sawblade	355x4.4x65	72	HW	FZ/TR		163412 ●
	Main sawblade	355x4.4x65	72	HW	TR/TR	RazorCut	163381 ●
	Main sawblade	355x4.4x65	72	HW	TR/TR	RazorCut PLUS	161152 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ		190615 ●
Selco- EB 110, EB 108, EB 120, WN 125, WN 200, WN 600/132, WN 512, WN 600/145, WN 600/162	Main sawblade	400x4.4x80	72	HW	TR/TR	RazorCut PLUS	161163 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ		190615 ●
Selco- EB 120, WN 125	Main sawblade	430x4.4x80	72	HW	TR/TR	RazorCut PLUS	161167 ●
	Main sawblade	430x4.4x80	72	HW	FZ/TR		163429 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ		190615 ●
Selco- WN 600/132, WN 200	Main sawblade	450x4.8x80	72	HW	FZ/TR		163433 ●
	Scoring sawblade	200x4.8x65	36	HW	KON/WZ		165577 ●
	Scoring sawblade	200x4,7/5,5x65	30	DP	KON/FZ		190574 ●
Selco- WN 600/145, WN 512	Main sawblade	480x4.8x80	72	HW	FZ/TR		163438 ●
	Scoring sawblade	200x4.8x65	36	HW	KON/WZ		165577 ●
	Scoring sawblade	200x4,7/5,5x65	30	DP	KON/FZ		190574 ●

1. Sawing

1.4 Panel sizing

1.4.7 Circular sawblades for floor production



Middle cuts

Application:

For cutting of panels along grain for floor production.

Machine:

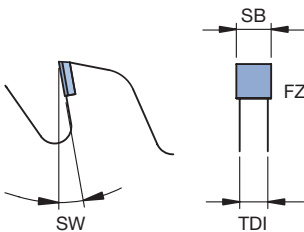
Multi blade saws.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered.

Technical information:

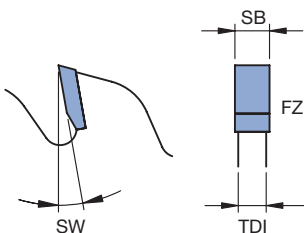
DP tipping for long tool life. Circular sawblades BO = 115 mm for Hydro-Duo sleeve ID **030555** or BO = 110 mm for clamping flange TR 810 0. Tip height 5.5 mm. Tool body coated for higher running performance.



Circular sawblade DP tipped

WK 800 2

Machine	D	SB	TDI	BO	NLA	DKN	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm	mm			°		
Paul	210	2,2	1,6	100	4/7/120	13/109	36	FZ	3	■ ■	190676 □
Paul	210	2,2	1,6	115	8/7/131		36	FZ	3	■ ■	190677 □
Homag	250	2,0	1,6	100	3/18/150		48	FZ	3	■ ■	190678 □
Paul	250	2,0	1,6	100	4/7/140	13/109	48	FZ	3	■ ■	190679 □
Paul	250	2,0	1,6	115	8/7/131		48	FZ	3	■ ■	190680 □
Homag	250	2,2	1,6	100	3/18/150		36	FZ	3	■ ■	190681 □
Paul	250	2,2	1,6	100	4/7/140	13/109	36	FZ	3	■ ■	190682 □
Homag	250	2,2	1,6	100	3/18/150		48	FZ	3	■ ■	190684 □
Paul	250	2,2	1,6	100	4/7/140	13/109	48	FZ	3	■ ■	190685 □
Paul	250	2,2	1,6	115	8/7/131		36	FZ	3	■ ■	190683 □
Paul	250	2,2	1,6	115	8/7/131		48	FZ	3	■ ■	190686 □



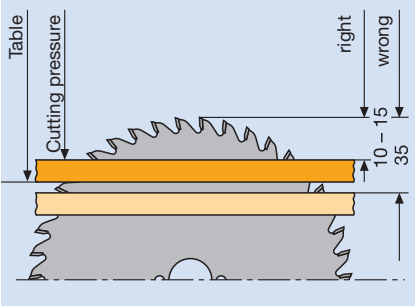
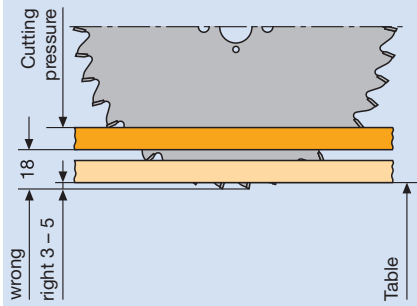
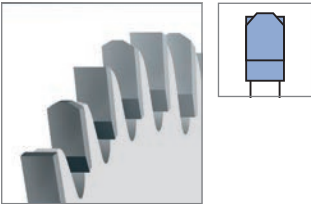
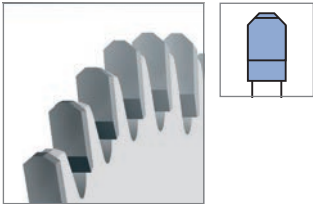
Circular sawblade TC tipped

WK 800 2

D	SB	TDI	BO	NLA	DKN	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm			°		
250	3,2	2,2	100	4/7/140	13/109	48	FZ	10	■ ■	061434 ●

1. Sawing

1.5 Cutting non-ferrous metals and plastics

Working process	For splitting, mitre cutting and sizing. Spray lubrication recommended when machining non-ferrous metal profiles.	
Workpiece materials	Non-ferrous and plastic profiles, composites, insulating material and aluminium compound materials.	
Machines	Splitting, trimming, mitre joint, double cross cutting and sizing machines.	
Application	 Positive cutting angle: The positive cutting angle presses the workpiece onto the table. For circular sawblades with the tooth shape FZ/TR and the spindle below the workpiece for cross and mitre cutting with material thickness > 2.5 mm.  Negative cutting angle: The negative cutting angle presses the workpiece onto the table. For circular sawblades with the tooth shape FZ/TR and the spindle above the workpieces for cross and mitre cutting with material thickness < 2.5 mm.	
Tooth shape	 FZ/TR (square/trapezoidal teeth): Tooth shape for non-ferrous metals and plastic profiles and boards.  TR/TR (trapezoidal/trapezoidal teeth): Tooth shape for better cutting quality with non-ferrous and plastic profiles. If altered from the standard FZ/TR shape.	



Cross and mitre cuts

Application:

For trimming and mitre cuts - positioning of sawblade under the workpiece.

Machine:

Cross, trimming, mitre and radial saws as well as double mitre cutting saws and CNC machining centres.

Workpiece material:

Non-ferrous metal or plastic profiles.

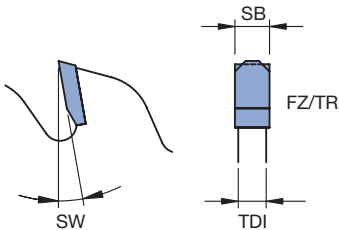
Technical information:

Spray lubrication recommended when processing non-ferrous metal profiles.

Circular sawblade FZ/TR cutting angle 5°

WK 452 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
Elumatec	280	3,2	2,6	32		96	FZ/TR 5		●	165725 ●
	300	3,2	2,6	30	KNL	72	FZ/TR 5		●	165726 ●
	300	3,2	2,6	30	KNL	96	FZ/TR 5		●	165727 ●
Rapid	320	3,2	2,6	30	KNL	84	FZ/TR 5		●	165728 ●
	350	3,4	2,8	30	KNL	84	FZ/TR 5		●	165729 ●
Rapid	350	3,2	2,6	30	KNL	108	FZ/TR 5		●	165730 ●
Emmegi	350	3,2	2,6	32	2/11/63 KNL	84	FZ/TR 5		●	165731 ●
Rapid	370	3,8	3,2	30	KNL	96	FZ/TR 5		●	165732 ●
Rapid	400	3,8	3,2	30	KNL	96	FZ/TR 5		●	165733 ●
Emmegi	400	3,8	3,2	32	2/11/63	96	FZ/TR 5		□	165734 □
Kaltenbach	400	3,8	3,2	50	4/15/80	96	FZ/TR 5		□	165735 □
Rapid, Elumatec	420	3,8	3,2	30	KNL	96	FZ/TR 5		●	165736 ●
	430	3,5	2,8	30	KNL	96	FZ/TR 5		●	165737 ●
	450	3,8	3,2	30	2/11/63 KNL	110	FZ/TR 5		●	165738 ●
Emmegi	450	3,8	3,2	32	2/11/63 KNL	96	FZ/TR 5		●	165739 ●
Rapid, Elumatec	500	4,4	3,8	30	KNL	120	FZ/TR 5		●	165740 ●
Emmegi	500	4,0	3,4	32	2/11/63	96	FZ/TR 5		●	165741 ●
Emmegi	500	4,0	3,4	32	2/11/63	120	FZ/TR 5		●	165742 ●
Elumatec	500	4,4	3,8	32	2/6/75	120	FZ/TR 5		●	165743 ●
					6/9,2-17,2/75					
Emmegi	550	4,0	3,4	32	2/11/63	96	FZ/TR 5		●	165744 ●
Emmegi	550	4,0	3,4	32	2/11/63	126	FZ/TR 5		●	165745 ●
Elumatec	550	4,4	3,8	30	KNL	120	FZ/TR 5		●	165746 ●
Stegmaier	600	4,6	4,0	30	2/11/63	140	FZ/TR 5		●	165747 ●
	600	5,0	4,4	32	2/11/63	132	FZ/TR 5		●	165748 ●
	650	5,0	4,4	30	2/11/63	144	FZ/TR 5		●	165749 ●



1. Sawing

1.5 Cutting non-ferrous metals and plastics

1.5.1 Cross and mitre cut sawblades for profiles



Cross and mitre cuts *Excellent*

Application:

For trimming and mitre cuts - positioning of sawblade under the workpiece.

Machine:

Cross, trimming, mitre and radial saws as well as double mitre cutting saws and CNC machining centres.

Workpiece material:

Non-ferrous metal or plastic profiles.

Technical information:

Spray lubrication is recommended when machining non-ferrous metal profiles.

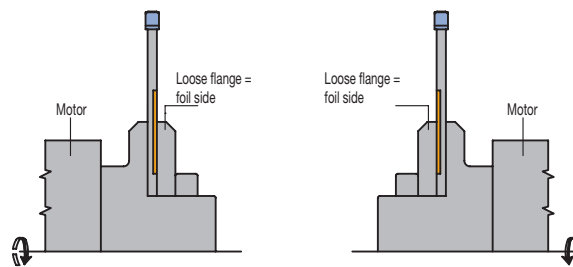
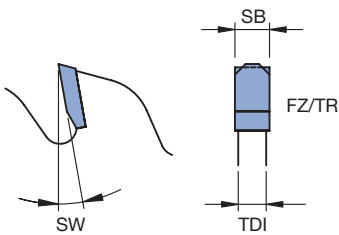
Excellent version. Vibration damping composite construction of the tool body by steel foil. Extreme noise reduction even with increasing dulling of the tool.

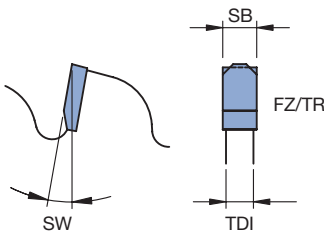


Circular sawblade FZ/TR cutting angle 5°

WK 472 2

D	SB	TDI	BO	NLA	Z	ZF	SW	Foil	WSS	ID
mm	mm	mm	mm	mm			°			
300	3,2	2,6	30	KNL	96	FZ/TR	5	left		161360 ●
300	3,2	2,6	30	KNL	96	FZ/TR	5	right		161361 ●
350	3,2	2,6	30	KNL	108	FZ/TR	5	left		161362 ●
350	3,2	2,6	30	KNL	108	FZ/TR	5	right		161363 ●





Crossing and mitre cuts with negative cutting angle

Application:

For trimming and mitre cuts - positioning of workpiece under the sawblade.

Machine:

Cross, trimming, mitre and radial saws as well as double mitre cutting saws and CNC machining centres.

Workpiece material:

Non-ferrous metal or plastic profiles.

Technical information:

Spray lubrication is recommended when machining non-ferrous metal profiles. Because of the negative cutting angle, it is particularly suitable for profiles where hooking and deformation of the profiles should be avoided. Particularly suitable for cutting from above. Negative cutting angle for improved workpiece clamping.

Circular sawblade FZ/TR cutting angle -5°

WK 462 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
	300	3,2	2,6	30	KNL	72	FZ/TR	-5	■	165825 ●
Elektra Beckum, Elu, DeWalt, Fezer, Lurem, Rapid, Ulmia, Scheppach Fezer, Rapid, Ulmia	300	3,2	2,6	30	KNL	96	FZ/TR	-5	■	165826 ●
	300	3,2	2,6	30	KNL	120	FZ/TR	-5	■	165827 ●
	300	3,2	2,6	32	KNL	72	FZ/TR	-5	■	165828 □
	300	3,2	2,6	32	KNL	96	FZ/TR	-5	■	165829 □
	300	3,2	2,6	32	KNL	120	FZ/TR	-5	■	165830 □
Haffner	330	3,2	2,6	30	KNL	96	FZ/TR	-5	■	165831 ●
	330	3,2	2,6	32	KNL	96	FZ/TR	-5	■	165832 □
Haffner	350	3,4	2,8	30	KNL	84	FZ/TR	-5	■	165833 ●
	350	3,8	3,2	30	KNL	84	FZ/TR	-5	■	165834 ●
	350	3,8	3,2	32	KNL	84	FZ/TR	-5	■	165835 □
	350	3,8	3,2	40	2/10/55 2/11/63 KNL	84	FZ/TR	-5	■	165836 □
Haffner, Ulmia	350	3,2	2,6	30	KNL	108	FZ/TR	-5	■	165837 ●
Eisele, Graule	350	3,6	3,0	40	2/9/55 4/12/64	108	FZ/TR	-5	■	165838 ●
Elumatec	380	3,8	3,2	32		108	FZ/TR	-5	■	165839 ●
	400	3,8	3,2	30	KNL	96	FZ/TR	-5	■	165840 ●
	400	3,8	3,2	32	2/11/63	96	FZ/TR	-5	■	165841 ●
Eisele	400	3,8	3,2	40	2/12/80 4/12/64	96	FZ/TR	-5	■	165842 □
Kaltenbach	400	3,8	3,2	50	4/15/80	96	FZ/TR	-5	■	165843 □
Elumatec, Rapid, Haffner, Wegoma, Ulmia	420	3,8	3,2	30	KNL	108	FZ/TR	-5	■	165844 ●
Graule	420	3,8	3,2	40		108	FZ/TR	-5	■	165845 □
Rapid	450	3,8	3,2	30	KNL	108	FZ/TR	-5	■	165846 ●
Pressta Eisele	450	3,8	3,2	32	2/11/63 KNL	108	FZ/TR	-5	■	165847 ●
Elu, Wegoma, Rapid	500	4,4	3,8	30	2/11/63 6/9/100	120	FZ/TR	-5	■	165848 ●
Graule	520	4,4	3,8	50		120	FZ/TR	-5	■	165849 ●
Rapid	550	4,0	3,4	30	KNL	132	FZ/TR	-5	■	165850 ●
	550	4,0	3,4	32	2/11/63	132	FZ/TR	-5	■	165851 □
Stürtz	600	5,2	4,6	30	KNL	138	FZ/TR	-5	■	165852 ●

1. Sawing

1.5 Cutting non-ferrous metals and plastics

1.5.1 Cross and mitre cut sawblades for profiles



Crossing and mitre cuts with negative cutting angle *Excellent*

Application:

For trimming and mitre cuts - positioning of workpiece under the sawblade.

Machine:

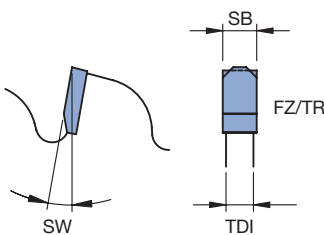
Cross, trimming, mitre and radial saws as well as double mitre cutting saws and CNC machining centres.

Workpiece material:

Non-ferrous metal or plastic profiles.

Technical information:

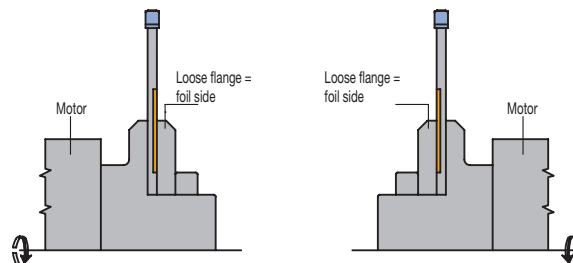
Spray lubrication is recommended when machining profiles made of non-ferrous metal. Negative cutting angle makes it particularly suitable for profiles where hooking and deformation of the profiles are to be avoided. Particularly suitable for cutting from above. Negative rake angle for improved workpiece clamping. **Excellent** version. Vibration damping composite construction of the support body by steel foil. Extreme noise reduction even with increasing dulling of the tool.



Circular sawblade FZ/TR cutting angle -5°

WK 482 2

D	SB	TDI	BO	NLA	Z	ZF	SW	Foil	WSS	ID
mm	mm	mm	mm	mm			°			
300	3,2	2,6	30	KNL	96	FZ/TR	-5	left		161380 ●
300	3,2	2,6	30	KNL	96	FZ/TR	-5	right		161381 ●
350	3,2	2,6	30	KNL	108	FZ/TR	-5	left		161382 ●
350	3,2	2,6	30	KNL	108	FZ/TR	-5	right		161383 ●





Cross and mitre cuts with reduced cutting width *Premium*

Application:

For trimming and sizing.

Machine:

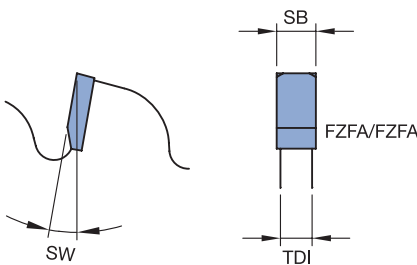
Cross, trimming, mitre and portable saws.

Workpiece material:

Thin walled, non-ferrous metal or plastic profiles, plastic honeycomb boards, fibre reinforced plastics (e.g. GFRP, CFRP), plastic wave boards (e.g. PVC).

Technical information:

Due to reduced cutting width and high number of teeth, especially suitable for thin-walled profiles (wall thickness < 2 mm) and thin panels. Negative cutting angle for smoother running. Special coating of the tool body for less adhesions.



Circular sawblade FZFA cutting angle -5°

WK 467 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
200	1,8	1,4	20	KNL	80	FZFA/FZFA	-5		060274 ●
250	2,0	1,6	30	KNL	100	FZFA/FZFA	-5		060275 ●
300	2,2	1,8	30	KNL	120	FZFA/FZFA	-5		060276 ●
350	2,4	2,0	30	KNL	140	FZFA/FZFA	-5		060279 ●

1. Sawing

1.5 Cutting non-ferrous metals and plastics

1.5.1 Cross and mitre cut sawblades for profiles



Cross and mitre cuts in finish cut quality *Excellent* - GlossCut

Application:

For trimming and mitre cutting.

Machine:

Cross, trimming, mitre and cross cutting twin saws.

Workpiece material:

Non-ferrous metal or plastic profiles, coated and lacquered.

Technical information:

Special design of the cutting area for low-groove and low-burr cutting areas and tear-free cutting edges. **Excellent** version with filled laser ornaments for vibration damping and reduction of noise levels.



Circular sawblade GlossCut

WK 377 2

D	SB	TDI	BO	NLA	Z	ZF	WSS	ID
mm	mm	mm	mm	mm				
300	3,0	2,4	30	KNL	72	FZFA/FZFA		161005 ●
300	3,0	2,4	30	KNL	96	FZFA/FZFA		161006 ●
350	3,5	2,8	30	KNL	96	FZFA/FZFA		161007 ●

Further GlossCut dimensions suitable for portable and semi-stationary machines - see section Portable Saws and Table-Top Machines.



Cross and mitre cuts in finish cut quality *Excellent*

Application:

For trimming and mitre cutting.

Machine:

Cross, trimming, mitre and cross cutting twin saws.

Workpiece material:

Plastic profiles of windows with seals, plastic hollow wall profiles, fibre reinforced plastics.

Technical information:

Special tooth geometry for tear-free cutting edges on the entry and exit side as well as perfect, tear-free cutting of the rubber seal. DP tipping for long tool life even when used in fibre-reinforced profiles.



Circular sawblade HZFA cutting angle 5°, Diamaster PRO

WK 808 2 DP

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
300	4,4	3,6	30	KNL	60	HRFA	5		190666 □
350	4,4	3,6	30	KNL	70	HRFA	5		190667 □
400	4,4	3,6	30	KNL	80	HRFA	5		762339 □
450	4,4	3,6	30	KNL	90	HRFA	5		190668 □
500	4,4	3,6	30	KNL	100	HRFA	5		762341 □
550	4,4	3,6	30	KNL	110	HRFA	5		762342 □
600	4,8	4,0	30	KNL	120	HRFA	5		762343 □

1. Sawing

1.5 Cutting non-ferrous metals and plastics

1.5.2 Circular sawblades für solid panels and blocks



Sizing in finish cut quality *Excellent* - BrillianceCut

Application:

For panel sizing of single boards and stacks of boards without scoring.

Machine:

Table and sizing saws, vertical panel sizing saws, panel sizing saws with pressure beam.

Workpiece material:

Transparent thermoplastics (e.g. PMMA, PC), solid surface materials (e.g. Corian).

Technical information:

Special tooth geometry for very smooth cutting surfaces and tear-free cutting edges. Recommended sawblade projection 5 - 10 mm. **Excellent** version with filled laser ornaments for vibration damping and reduction of noise level. Version with positive cutting angle.

Circular sawblade BrillianceCut

WK 371 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	WSS	ID
	303	3,5	2,5	30	KNL	60	TR/TR		161028 ●
Holz-Her, Mayer, Schelling	350	4,4	3,2	30	2/13/94 KNL	72	WZ/FA		161029 ●
Homag	350	4,4	3,2	60	2/14/100	72	WZ/FA		161030 ●
Homag	380	4,8	3,5	60	2/14/100 2/14/125 2/19/120	84	WZ/FA		161031 ●
Mayer, Schelling	400	4,4	3,2	30	2/13/94 KNL	72	WZ/FA		161032 ●
Mayer, Schelling	450	4,4	3,2	30	2/13/94 KNL	72	WZ/FA		161033 ●
Homag	450	4,8	3,5	60	2/14/125 2/19/120	72	WZ/FA		161034 ●



Sizing in easy melting plastics

Application:

For sizing and cross cutting without scoring.

Machine:

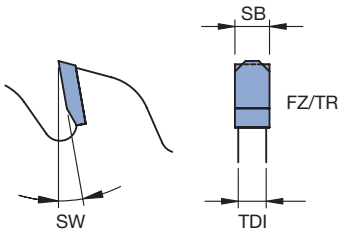
Table and sizing saws, vertical panel sizing saws, panel sizing saws with pressure beam.

Workpiece material:

Easy melting plastics (e.g. PP, PA).

Technical information:

Reduced number of teeth for lower heat generation as well as lower feed forces and lower power consumption even at large cutting depths. Tooth shape for cutting pitch and reduction of heat generation. Large chip spaces for optimum chip transport. Circular saw blade with suitable number of teeth must be selected depending on the material thickness. Low number of teeth for large workpiece thicknesses.



Circular sawblade FZ/TR, cutting angle 10°

WK 372 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
300	3,6	2,2	30	KNL	20	FZ/TR	10	■	163500 ●
300	3,6	2,2	30	KNL	42	FZ/TR	10	■	163501 ●
350	3,8	2,5	30	KNL	24	FZ/TR	10	■	163502 ●
350	3,8	2,5	30	KNL	48	FZ/TR	10	■	163503 ●
400	3,8	2,5	30	KNL	28	FZ/TR	10	■	163504 ●
400	3,8	2,5	30	KNL	54	FZ/TR	10	■	163505 ●



Sizing non-ferrous solid material

Application:

For panel sizing of single boards and stacks of boards without scoring.

Machine:

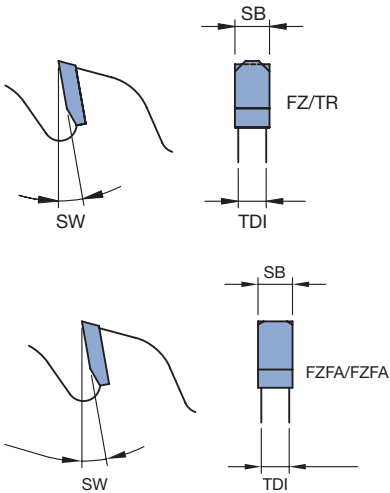
Panel sizing saws with pressure beam.

Workpiece material:

Solid non-ferrous metals (e.g. aluminium or brass panels).

Technical information:

Special cutting geometry for smooth cutting surfaces. Spray lubrication recommended. Reduced number of teeth and large gullet areas for higher feed speeds with the same power consumption.



Circular sawblade FZ/TR und FZFA/FZFA, cutting angle 10°

WK 452 2, WK 457 2, WK 472 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
Schelling	350	3,8	3,0	30	KNL	48	FZFA/FZFA	10	■ ■	165925 ●
					2/13/94					
Mayer	400	4,4	3,5	30	KNL	60	FZFA/FZFA	10	■ ■	165926 ●
Mayer, Schelling	450	4,4	3,5	30	KNL	60	FZ/TR	10	■ ■	165927 ●
					2/13/94					
					2/13/114					
Schelling	460	4,4	3,5	30	2/13/94	48	FZFA/FZFA	10	■ ■	165928 ●
					2/13/114					
Schelling	520	4,4	3,5	30	2/13/94	44	FZFA/FZFA	10	■ ■	165929 ●
					2/13/114					
Schelling	530	4,4	3,5	30	2/13/94	44	FZFA/FZFA	10	■ ■	165930 ●
					2/13/114					
Mayer	570	5,0	4,0	40	2/16/80	48	FZFA/FZFA	10	■ ■	165931 ●
Schelling	620	5,5	4,5	40	2/13/140	36	FZFA/FZFA	10	■ ■	165932 ●
					2/13/114					
Schelling	620	5,5	4,5	40	2/13/140	60	FZ/TR	10	■ ■	165933 ●
					2/13/114					
Schelling	680	5,5	4,5	40	2/13/140	42	FZFA/FZFA	10	■ ■	165934 ●
					2/13/114					

1. Sawing

1.5 Cutting non-ferrous metals and plastics

1.5.2 Circular sawblades für solid panels and blocks



Sizing *Excellent*

Application:

For sizing of single boards.

Machine:

Table, sizing and vertical panel sizing saws.

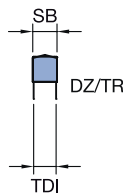
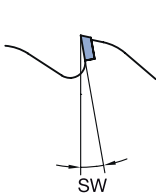
Workpiece material:

Gypsum and cement fibre panels, duroplastics (compact laminated boards, e.g. HPL), fibre reinforced plastics (e.g. GFRP, CFRP), alu composite panels (e.g. Alucobond®). Chipboard and fibre materials plastic coated.

Technical information:

DP tipping and strong tooth shape for long tool life even in highly abrasive materials.

Excellent design with filled laser ornaments for vibration damping and noise reduction. Tool body coated for higher running performance.



Circular sawblade DZ/TR, Diamaster PRO

WK 872 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
180	3,2	2,2	30		36	DZ/TR	10		190747 ●
250	3,2	2,2	30	KNL	48	DZ/TR	10		190748 ●
303	3,2	2,2	30	KNL	60	DZ/TR	10		190673 ●
303	3,2	2,2	30	KNL	96	DZ/TR	10		190674 ●
350	3,5	2,5	30	KNL	72	DZ/TR	10		190749 ●

1. Sawing

1.6 Circular sawblades for CNC

Working process	For sizing, separating and trimming cut.		
Workpiece materials	Solid wood, wood derived materials, plastics.		
Machines	CNC machining centres and aggregates.		
Tooth shape	 	WZ/WZ/FZ (alternative/square teeth): Tooth shape for solid wood, glulam and coated or veneered wood derived materials; tear-free cutting edges and high cut quality. Combinations of tooth forms (WZri, WZle, WZri, WZle, FZ).	

1. Sawing

1.6 Circular sawblades for CNC

1.6.1 Trimming and sizing sawblades



Trimming and sizing on CNC machining centres

Application:

For sizing of panels on CNC machining centres.

Machine:

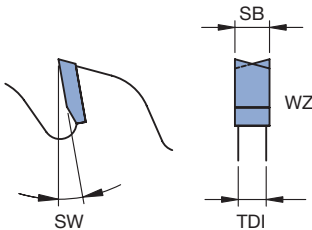
Processing units on CNC machining centres.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), solid wood panels across and along grain and for mitre joints.

Technical information:

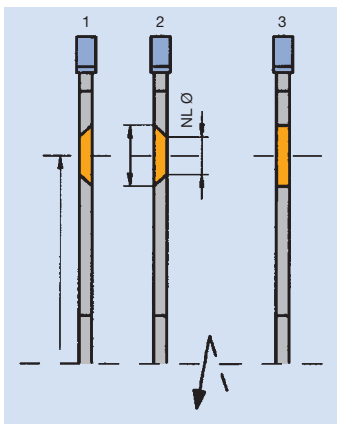
Suitable for mounting on saw flanges of machining units. Balancing quality adapted for use on CNC units. Universal dimensions, among other things, for large cutting depths and cuts.



Circular sawblade WZ for CNC

WK 150 2, WK 850 2

D	SB	TDI	BO	NLA	Type	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm				°		
350	3,6	2,5	30	8/6/90	1	16	WZ	15		165975 ●
				6/6,8/90						
350	3,5	2,7	30	8/6/90	1	72	WZ	15		165976 ●
				6/6,8/90						



Type 1:

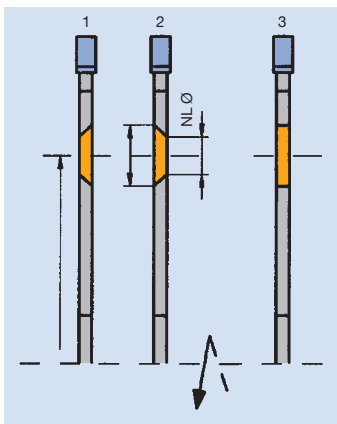
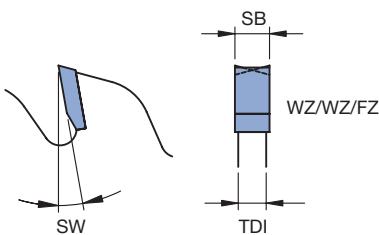
Countersink right

Type 2:

Countersink left

Type 3:

Pinhole without countersink



Type 1:

Countersink right

Type 2:

Countersink left

Type 3:

Pinhole without countersink

Trimming and sizing on CNC machining centres

Excellent - Katana

Application:

For sizing of panels on CNC machining centres.

Machine:

Processing units on CNC machining centres.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), solid wood panels across grain and for mitre joints.

Technical information:

Katana tooth combination with alternating rake face bevel for highest cutting quality. High number of teeth for perfect edges and very smooth surfaces. Very well suited for mitre cuts in coated wood materials. Recommendation for use: When sizing coated wood-derived materials, for best cutting quality, first scribe with a small infeed (1 - 2 mm) in the same direction and then cut in the opposite direction. Suitable for mounting on saw flanges of machining units. Balancing quality adapted for use on CNC aggregates. **Excellent** design with filled laser ornaments for vibration damping and reduction of noise level.

Circular sawblade Katana for CNC

WK 879 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Type Z	ZF	SW °	WSS	ID
	180	3,0	2,2	30			60 WZ/WZ/FZ	10	■	161267 ●
Homag, Weeke	180	3,0	2,2	30	2/7/42 4/5,5/45 2 8/6/90 1	3	60 WZ/WZ/FZ	10	■	161250 ●
Flex 5, Flex 5+	180	3,0	2,2	40	8/6,6/52 2	2	60 WZ/WZ/FZ	10	■	161251 ●
Homag, IMA	200	3,0	2,2	30	2/7/42 4/6/52 2 8/6/90 1	3	65 WZ/WZ/FZ	10	■	161253 ●
IMA	200	3,0	2,2	30	2/7/42 4/6,6/60 2	3	65 WZ/WZ/FZ	10	■	161254 ●
	220	3,0	2,2	30	8/6/90 1 8/6/70	1	70 WZ/WZ/FZ	10	■	161255 ●
Flex 5, Flex 5+, Homag, Weeke	220	3,0	2,2	40	8/6,6/52 2	2	70 WZ/WZ/FZ	10	■	161256 ●
	240	3,0	2,2	30	4/6,6/52 1 4/6,6/52 2 8/6/90 1	1	75 WZ/WZ/FZ	10	■	161257 ●
Flex 5, Flex 5+, Homag	240	3,0	2,2	40	8/6,6/52 2	2	75 WZ/WZ/FZ	10	■	161258 ●
Biesse, Holz-Her	250	3,0	2,2	30	2/7/42 2/6/50 8/6/90 1	3	80 WZ/WZ/FZ	10	■	161259 ●
Homag, Fel-der Format-4	280	3,0	2,2	30	2/7/42 8/6/90 1	3	85 WZ/WZ/FZ	10	■	161260 ●
Biesse	300	3,0	2,2	50	1/6/80 6/5,5/80 3	3	100 WZ/WZ/FZ	10	■	161266 ●
Homag	350	3,5	2,7	30	8/6/90 1	1	110 WZ/WZ/FZ	10	■	161263 ●

● available ex stock

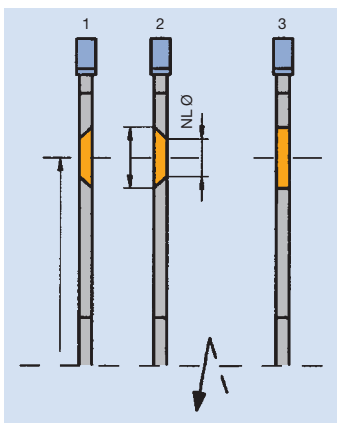
□ available at short notice

Instruction manual visit www.leitz.org

1. Sawing

1.6 Circular sawblades for CNC

1.6.1 Trimming and sizing sawblades



- Type 1:**
Countersink right
- Type 2:**
Countersink left
- Type 3:**
Pinhole without countersink

Trimming and sizing on CNC machining centres

Excellent - WhisperCut

Application:

For sizing of panels on CNC machining centres.

Machine:

Processing units on CNC machining centres.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), solid wood panels across grain and for mitre joints.

Technical information:

Extreme noise reduction. Specially developed group serration for perfect cutting pitch and reduction of cutting forces. High tool life due to stable tooth geometry and DP tipping. Universally applicable for a wide range of materials. Recommendation for use: For optimal cutting quality when sizing coated wood-based materials, first make a scribing cut with the feed (1-2 mm deep), then perform the main cut against the feed on the return stroke. Suitable for mounting on saw flanges of machining units. Balancing quality adapted for use on CNC units. Can be resharpened 2 times.

Excellent design with filled laser ornaments for vibration damping and reduction of noise level.

Circular sawblade WhisperCut for CNC

WK 879 2, WK 879 2 DP

D	SB	TDI	BO	NLA	Type	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm				°		
160	2,5	2,0	20			30	HZFA/WZFA	10		190751 ●
180	2,5	2,0	30	8/6/90	1	35	HZFA/WZFA	10		190713 ●
				2/7/42	3					
				4/6/45	2					
180	2,5	2,0	40	8/6,6/52	2	35	HZFA/WZFA	10		190714 ●
200	2,5	2,0	30	2/7/42	3	40	HZFA/WZFA	10		190715 ●
				4/6/52	2					
				8/6/90	1					
200	2,5	2,0	30	2/7/42	3	40	HZFA/WZFA	10		190716 ●
				4/6,6/60	2					
220	2,5	2,0	30	8/6/90	1	45	HZFA/WZFA	10		190717 ●
220	2,5	2,0	40	8/6,6/52	2	45	HZFA/WZFA	10		190718 ●
240	2,5	2,0	30	4/6,6/52	1	50	HZFA/WZFA	10		190719 ●
				4/6,6/52	2					
				8/6/90	1					
240	2,5	2,0	40	8/6,6/52	2	50	HZFA/WZFA	10		190720 ●
250	2,5	2,0	30	2/7/42	3	50	HZFA/WZFA	10		190721 ●
				2/6/50	3					
				8/6/90	1					
280	2,5	2,0	30	2/7/42	3	55	HZFA/WZFA	10		190722 ●
				8/6/90	1					
303	3,2	2,4	30	KNL	3	60	HZFA/WZFA	10		190728 □
				8/6/90	1					
350	3,2	2,4	30	KNL	3	70	HZFA/WZFA	10		190729 □
				8/6/90	1					

1. Sawing

1.6 Circular sawblades for CNC

1.6.2 Grooving sawblades



Grooving on CNC machining centres

Application:

For grooving.

Machine:

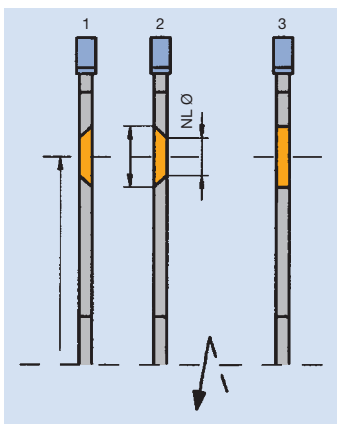
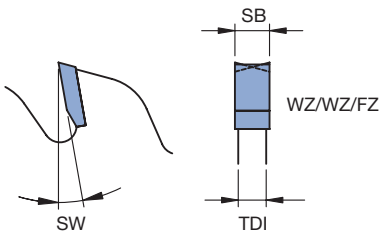
Processing units on CNC machining centres.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood).

Technical information:

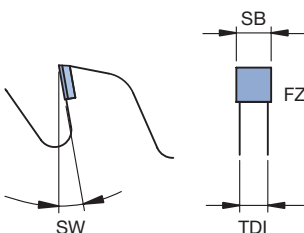
Due to special tooth combination and high number of teeth suitable for tear-free grooves in any coatings. Mounting on saw flange of machining units. Use with feed recommended for best machining quality.



Type 1: Countersink right

Type 2: Countersink left

Type 3: Pinhole without countersink



Grooving circular sawblade WZ/WZ/FZ for CNC, TC tipped

WK 859 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Type Z	ZF	SW °	WSS	ID
	100	3,5	2,5	20		35	WZ/WZ/FZ	15	■	166014 ●
Homag, Weeke	100	3,5	2,5	30		35	WZ/WZ/FZ	15	■	166000 ●
	100	4,0	2,8	20		35	WZ/WZ/FZ	15	■	166015 ●
Homag, Weeke	100	4,0	2,8	30		35	WZ/WZ/FZ	15	■	166008 ●
	100	5,0	3,5	20		35	WZ/WZ/FZ	15	■	166016 ●
Homag, Weeke	100	5,0	3,5	30		35	WZ/WZ/FZ	15	■	166001 ●
	100	8,5	3,5	20		35	WZ/WZ/FZ	15	■	166013 ●
Homag	100	8,5	3,5	30	4/5,5/48 1	35	WZ/WZ/FZ	15	■	166017 ●
					4/5,5/48 2					
SCM, Morbi-	120	3,5	2,5	20	3/4,5/35 1	35	WZ/WZ/FZ	15	■	166002 ●
delli, Holz-Her					3/4,5/35 2					
Biesse, Felder	120	3,5	2,5	35	4/6,3/50 1	35	WZ/WZ/FZ	15	■	166004 ●
					4/6,3/50 2					
SCM, Morbi-	120	4,0	2,8	20	3/4,5/35 1	35	WZ/WZ/FZ	15	■	166009 ●
delli, Holz-Her					3/4,5/35 2					
Biesse, Felder	120	4,0	2,8	35	4/6,3/50 1	35	WZ/WZ/FZ	15	■	166010 ●
					4/6,3/50 2					
SCM, Morbi-	120	5,0	3,5	20	3/4,5/35 1	35	WZ/WZ/FZ	15	■	166003 ●
delli, Holz-Her					3/4,5/35 2					
Biesse, Felder	120	5,0	3,5	35	4/6,3/50 1	35	WZ/WZ/FZ	15	■	166005 ●
					4/6,3/50 2					
Homag, Weeke	125	3,5	2,5	30	4/5,5/48 1	35	WZ/WZ/FZ	15	■	166006 ●
					4/5,5/48 2					
Homag, Weeke	125	4,0	2,8	30	4/5,5/48 1	35	WZ/WZ/FZ	15	■	166011 ●
					4/5,5/48 2					
Homag, Weeke	125	5,0	3,5	30	4/5,5/48 1	35	WZ/WZ/FZ	15	■	166007 ●
					4/5,5/48 2					
Homag	200	5,0	3,5	30	4/5,5/52 1	60	WZ/WZ/FZ	15	■	166012 ●
					4/5,5/52 2					

Technical information:

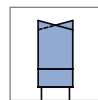
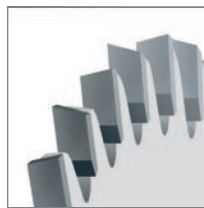
Mounting on saw flange of machining units. Use with feed recommended for tear-free grooves. DP mounting for long tool life.

Grooving circular sawblade FZ for CNC, DP tipped

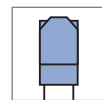
WK 800 2 DP

D mm	SB mm	TDI mm	BO mm	Z	ZF	QAL	SW °	WSS	ID
100	4,0	2,5	20	12	FZ	DP	10	■	192303 ●

Working process	For sizing, trimming and splitting.
Workpiece materials	Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), without coat-ing, with plastic coating, with veneer, glulam, plywood, duroplastics, thermo-plastics, solid surface materials (Corian, Varicor etc.), compound materials (HPL, Tres-pa etc.), non-ferrous metals (aluminium, copper etc.).
Machines	Portable saws, trimming, mitre-joint machines, table saws and radial arm cross cut, light sizing saws.
Types of application	For cutting along and across grain, trimming and mitre cut.

Tooth shapes

WZ (alternative top bevel teeth)



FZ/TR (square/trapezoidal teeth)

Teeth shape	Machine	Area of application
Square teeth	Portable saws	Solid wood along and across the grain, glued materials.
Alternative top bevel teeth – positive	Pull push saw, table and radial arm cross cut saws, light sizing saws.	Uncoated, plastic coated, veneered wood derived materials. Plywood, multiplex plywood. Composite/laminated materials.
Alternative top bevel teeth – negative	Trimming-, pull push saw, table saws and radial arm cross cut saws.	Solid wood across grain. Plastic hollow wall profiles. Non-ferrous metals – extruded profiles and pipes.
Flat/trapezoidal teeth – positive	Portable saws, pull push saw, table saws and radial arm cross cut saws, light sizing saws.	Uncoated wood derived materials, plastic coated, veneered. Non-ferrous metals – extruded profiles and pipes. NE-metals. Al-PU sandwich panels. Plastic hollow wall profiles. Plastic polymers (Corian, Varicor etc.).
Flat/trapezoidal teeth – negative	Portable saws, trimming-, mitre saws, table saws and radial arm cross cut saws.	Non-ferrous metals – extruded profiles/pipes. Plastic hollow wall profiles. Al-PU sandwich panels.
Alternative flat tooth with bevel	Portable saws, trimming-, mitre saws, table saws and radial arm cross cut saws, light sizing saws.	Flat and angle steel, steel plates, pipes, profiles, sandwich panels, composite materials.

Tooth pitch/cut quality

The saw cut quality is determined by the correct choice of the tooth shape and by the distance between the teeth. The distance between the teeth is determined by the tooth pitch.

Number of teeth	Tooth pitch	Cut quality
Low	~ 25 – 50 mm	For coarse cuts.
Medium	~ 14 – 25 mm	For good cutting quality.
High	~ 9 – 14 mm	For clean cuts to a very high quality.

1. Sawing

1.7 Portable saws and table-top machines

1.7.1 Circular sawblades WZ



Universal sizing - AccuCut

Application:

For cross-cut and sizing.

Machine:

Accu-portable sawblades.

Workpiece material:

Solid wood lengthwise and crosswise as well as glued, chipboard and fibre materials raw, plastic- and paper-coated, veneered, laminated wood (e.g. plywood, multiplex).

Technical information:

Long battery life due to thin kerf, cutting force-reduced cutting geometry and innovative tooth pitch. Very good cutting quality due to high number of teeth.

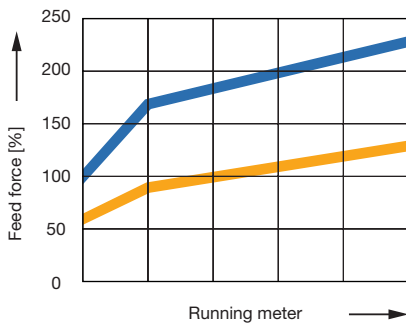


Circular sawblade AccuCut

WK 879 2

D	SB	TDI	BO	Z	ZF	SW	WSS	ID
mm	mm	mm	mm			°		
140	1,8	1,2	20	35	WZ/WZ/WZ/FZ	10		166623 ●
160	1,8	1,2	20	42	WZ/WZ/WZ/FZ	10		166620 ●
165	1,8	1,2	20	42	WZ/WZ/WZ/FZ	10		166621 ●
184	1,8	1,2	20	42	WZ/WZ/WZ/FZ	10		166624 ●
190	1,8	1,2	30	42	WZ/WZ/WZ/FZ	10		166622 ●

Comparison of feed force (MDF 38 mm)



■ Conventional circular sawblade,
Z 48, SB 2.2 mm, WZ

■ Leitz AccuCut circular sawblade,
Z 42, SB 1.8 mm, WZ/WZ/WZ/FZ



Universal sizing

Application:

For cutting along and across grain and sizing.

Machine:

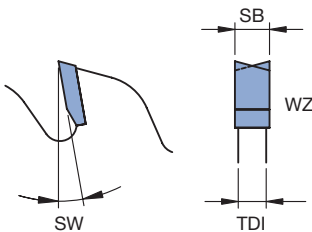
Portable and table saws.

Workpiece material:

Solid wood along and across grain, glued. Chipboard and fibre materials, plastic and paper coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), duroplastics (compact laminated boards, e.g. HPL).

Technical information:

Tooth shape for universal use.



Circular sawblade WZ pos. cutting angle

WK 150 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
100	2,4	1,6	12		30	WZ	10		166109 ●
100	2,4	1,6	22		30	WZ	10		166110 ●
120	2,4	1,6	20		24	WZ	15		166111 ●
125	2,4	1,6	20		24	WZ	15		166112 ●
125	2,4	1,6	20		36	WZ	10		166113 ●
140	2,4	1,6	20		24	WZ	15		166114 ●
150	2,8	1,8	20		48	WZ	10		166115 ●
160	1,6	1,1	20		24	WZ	25		166100 ●
160	1,8	1,2	20		18	WZ	25		166101 ●
160	1,8	1,2	20		32	WZ	5		166102 ●
160	2,5	1,6	20		12	WZ	20		166116 ●
160	2,5	1,6	20		24	WZ	15		166117 ●
160	2,5	1,6	20		48	WZ	15		166118 ●
165	1,8	1,2	20		18	WZ	15		166159 ●
165	2,2	1,6	20		24	WZ	15		166119 ●
165	2,2	1,6	20		48	WZ	10		166104 ●
165	2,4	1,6	20		12	WZ	15		166103 ●
170	2,5	1,6	30		48	WZ	10		166120 ●
180	2,5	1,6	20		24	WZ	15		166121 ●
180	2,5	1,6	20		48	WZ	10		166122 ●
180	2,5	1,6	30		24	WZ	15		166123 ●
180	2,5	1,6	30		48	WZ	10		166105 ●
184	2,5	1,6	20		24	WZ	15		166124 ●
190	1,8	1,2	30		24	WZ	15		166160 ●
190	2,5	1,8	30		24	WZ	20		166128 ●
190	2,8	1,8	16		24	WZ	15		166125 ●
190	2,8	1,8	16		48	WZ	10		166126 ●
190	2,8	1,8	30		16	WZ	20		166127 ●
190	2,8	1,8	30		48	WZ	10		166129 ●
200	3,0	2,0	30		34	WZ	10		166130 ●
200	3,0	2,0	30		48	WZ	10		166131 ●
210	2,4	1,6	30		24	WZ	15		166133 ●
210	2,4	1,6	30		42	WZ	20		166134 ●
210	2,4	1,6	30		64	WZ	10		166135 ●
220	3,2	2,2	30		34	WZ	15		166136 ●
220	3,2	2,2	30		60	WZ	10		166107 ●
225	2,6	1,8	30		32	WZ	20		166137 ●
225	2,6	1,8	30		48	WZ	10		166138 ●
230	2,5	1,8	30		24	WZ	20		166140 ●
230	2,5	1,8	30		48	WZ	15		166108 ●
230	3,2	2,2	30		34	WZ	15		166141 ●
235	2,5	1,8	30		24	WZ	15		166156 ●
235	2,5	1,8	30		56	WZ	15		166157 ●
235	3,2	2,2	30		24	WZ	15		166142 ●
235	3,2	2,2	30		34	WZ	15		166143 ●
240	3,0	2,0	30		34	WZ	15		166144 ●
240	3,0	1,8	30		48	WZ	10		166145 ●
250	2,8	2,0	30	KNL	24	WZ	25		166146 ●
250	2,8	2,0	30	KNL	60	WZ	20		166147 ●
260	3,2	2,2	30	KNL	60	WZ	10		166148 ●

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
280	3,2	2,2	30	KNL	48	WZ	10		166149 ●
280	3,2	2,2	30	KNL	60	WZ	10		166150 ●
315	3,0	2,0	30	KNL	48	WZ	15		166152 ●
315	3,2	2,2	30	KNL	28	WZ	20		166151 ●
315	3,2	2,2	30	KNL	72	WZ	10		166153 ●
355	3,2	2,2	30	KNL	16	WZ	20		166154 ●
355	3,2	2,2	30	KNL	32	WZ	20		166155 ●



Circular sawblades for cutting logs

Application:

For sizing across grain, trimming and cross cutting.

Machine:

Rolling table saws and log saws.

Workpiece material:

Softwood and hardwood wet and dry.

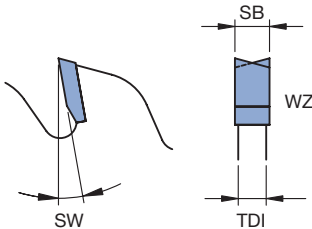
Technical information:

Design with chip thickness limitation. Narrow cutting width and reduced number of teeth for reduced power consumption even with thick logs.

Circular sawblades WZ with thickness limitation

WK 150 4

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
600	3,8	2,8	30	KNL	36	WZ	20		166610 ●
700	4,2	3,2	30	KNL	42	WZ	20		166611 ●





Trimming from the top

Application:

For sizing across grain, trimming and cross cutting.

Machine:

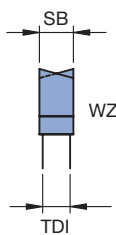
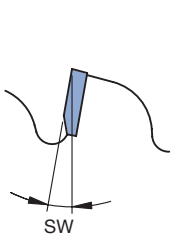
Trimming and mitre saws.

Workpiece material:

Softwood and hardwood wet and dry, laminated veneer lumber (e.g. plywood, multiplex plywood), thin walled plastic profiles (thickness < 2 mm).

Technical information:

Negative cutting angle especially for manually operated machines. Position of spindle above the workpiece.



Circular sawblade WZ cutting angle -5°

WK 160 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
210	2,8	2,0	30		60	WZ	-5	■ ■	166252 ●
216	1,8	1,2	30		48	WZ	-5	■ ■	166260 ●
216	3,0	2,0	30		24	WZ	-5	■ ■	166253 ●
216	3,0	2,0	30		48	WZ	-5	■ ■	166254 ●
216	3,0	2,0	30		64	WZ	-5	■ ■	166255 ●
250	2,4	1,8	30	KNL	48	WZ	-5	■ ■	166256 ●
250	2,4	1,8	30	KNL	60	WZ	-5	■ ■	166257 ●
250	3,2	2,6	30	KNL	80	WZ	-5	■ ■	166258 ●
255	2,8	2,0	30	KNL	60	WZ	-5	■ ■	166259 ●
260	2,5	1,8	30	KNL	60	WZ	-5	■ ■	166250 ●
260	2,5	1,8	30	KNL	80	WZ	-5	■ ■	166251 ●



Trimming cut

Application:

For sizing, trimming and cross cutting.

Machine:

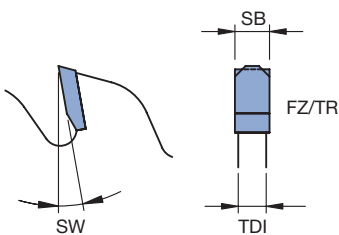
Portable and table saws.

Workpiece material:

Non-ferrous metal profiles, duroplastics (compact laminated boards, e.g. HPL), solid surface materials (e.g. Corian).

Technical information:

Solid tooth shape for universal use.



Circular sawblade FZ/TR cutting angle 5°

WK 452 2, WK 852 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
160	1,8	1,2	20		48	FZ/TR	5	■ ■	166311 ●
160	2,6	1,8	20		48	FZ/TR	5	■ ■	166300 ●
165	1,8	1,2	20		48	FZ/TR	5	■ ■	166312 ●
180	3,2	2,6	16		42	FZ/TR	5	■ ■	166301 ●
190	1,8	1,2	30		54	FZ/TR	5	■ ■	166313 ●
190	2,8	1,8	30		54	FZ/TR	5	■ ■	166302 ●
200	2,8	2,2	20		84	FZ/TR	5	■ ■	166303 ●
200	3,2	2,6	30	KNL	48	FZ/TR	5	■ ■	166304 ●
250	3,2	2,6	30	KNL	60	FZ/TR	5	■ ■	166305 ●
250	3,2	2,6	30	KNL	80	FZ/TR	5	■ ■	166306 ●
250	3,2	2,6	32	2/11/63	60	FZ/TR	5	■ ■	166307 □
250	3,2	2,6	32	2/11/63	80	FZ/TR	5	■ ■	166308 □
250	3,2	2,6	40	2/8/55	80	FZ/TR	5	■ ■	166309 □
				4/12/64					
275	3,4	2,8	40	2/9/55	72	FZ/TR	5	■ ■	166310 ●
				4/12/64					



Trimming from the top

Application:

For sizing across grain, trimming and cross cutting.

Machine:

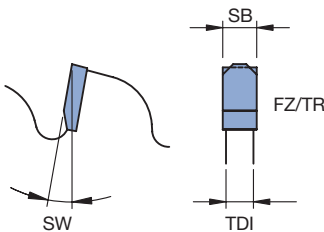
Trimming and mitre saws.

Workpiece material:

Non-ferrous metal or plastic profiles.

Technical information:

Negative cutting angle especially for manually operated machines. Position of spindle above the workpiece.



Circular sawblade FZ/TR cutting angle -5°

WK 462 2

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
160	2,5	1,8	20		56	FZ/TR	-5	■ ■	166350 ●
165	2,2	1,6	20		56	FZ/TR	-5	■ ■	166351 ●
180	3,2	2,6	20		42	FZ/TR	-5	■ ■	166352 ●
190	2,8	2,2	30		68	FZ/TR	-5	■ ■	166354 ●
200	3,2	2,6	30		60	FZ/TR	-5	■ ■	166356 ●
210	2,4	1,6	30		64	FZ/TR	-5	■ ■	166357 ●
210	2,8	2,0	30		60	FZ/TR	-5	■ ■	166358 ●
216	2,2	1,6	30		64	FZ/TR	-5	■ ■	166366 ●
216	3,0	2,4	30		64	FZ/TR	-5	■ ■	166359 ●
220	3,2	2,6	30		72	FZ/TR	-5	■ ■	166360 ●
225	2,6	1,8	30		68	FZ/TR	-5	■ ■	166361 ●
250	3,2	2,6	30	KNL	60	FZ/TR	-5	■ ■	166362 ●
250	3,2	2,6	30	KNL	80	FZ/TR	-5	■ ■	166363 ●
260	2,4	1,8	30	KNL	68	FZ/TR	-5	■ ■	166364 ●
275	3,2	2,6	30	KNL	88	FZ/TR	-5	■ ■	166365 ●



Dry sawing of ferrous metals - DryCut

Application:

For splitting, trimming and sizing.

Machine:

Trimming and mitre saws, portable machines and table saws.

Workpiece material:

Flat and angle steel, pipes, steel plates and profiles, sandwich panels.

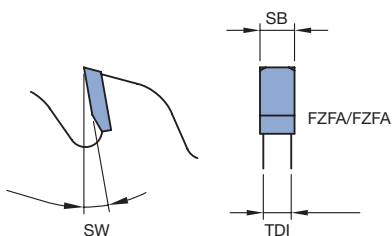
Technical information:

Note: Slow feed! Reduce speed! There may be sparks in use. Pay attention to safety instructions of extraction.

Circular sawblade DryCut

WK 977 3

D	SB	TDI	BO	Z	ZF	SW	WSS	ID
mm	mm	mm	mm			°		
160	2,0	1,6	20	48	FZFA/FZFA	0	■	163529 ●
165	2,0	1,6	20	48	FZFA/FZFA	0	■	163530 ●
190	2,0	1,6	30	54	FZFA/FZFA	0	■	163531 ●
210	2,0	1,6	30	60	FZFA/FZFA	0	■	163532 ●
225	2,2	1,8	30	64	FZFA/FZFA	0	■	163533 ●
254	2,2	1,8	30	72	FZFA/FZFA	0	■	163534 ●
300	2,2	1,8	30	80	FZFA/FZFA	0	■	163535 ●
305	2,4	2,0	25.4	80	FZFA/FZFA	0	■	163536 ●
355	2,4	2,0	25.4	80	FZFA/FZFA	0	■	163538 ●
400	3,0	2,4	30	84	FZFA/FZFA	0	■	163539 ●



1. Sawing

1.7 Portable saws and table-top machines

1.7.4 Circular sawblades for plastics and NF-metals



Sizing in finish cut quality *Excellent* - GlossCut

Application:
For trimming and sizing.

Machine:
Portable and table saws.

Workpiece material:
Transparent thermoplastics (e.g. PMMA, PC), plastic wave boards (e.g. PVC), solid surface materials (e.g. Corian), alu composite panels (e.g. Alucobond®). Non-ferrous metal or plastic profiles.

Technical information:
Special design of the cutting area for low-groove and low-burr cutting surfaces and tear-free cutting edges. **Excellent** design with filled laser ornaments for vibration damping and reduction of noise level (from D 210 mm).

Circular sawblade GlossCut WK 357 2

D	SB	TDI	BO	NLA	Z	ZF	WSS	ID
mm	mm	mm	mm	mm				
160	2,2	1,6	20		48	FZFA/FZFA		161008 •
165	2,2	1,6	20		48	FZFA/FZFA		161009 •
210	2,4	1,8	30		68	FZFA/FZFA		161011 •
250	2,8	2,2	30	KNL	72	FZFA/FZFA		161012 •

Further GlossCut dimensions suitable for sizing, cross cut and mitre cut saws and twin sizing saws - see section Cutting Non-Ferrous Metals And Plastics.



Universal sizing

Application:

For universal use on building sites.

Machine:

Universal cutting saws.

Workpiece material:

Panels and timbers with small concrete and metal inclusions, wood wool (e.g. Heraklith), gypsum plasterboard and form work panel of veneer, gas aerated slabs, Styrodur slabs, roundwood and squared timbers.

Technical information:

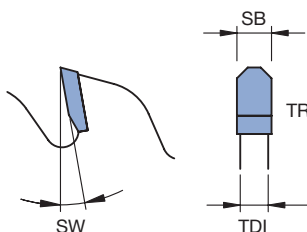
Tool body with round closed form and stable tooth shape. Special tungsten carbide grade for all requirements on construction sites. Noise reducing design.



Circular sawblades TR for saw benches

WK 123 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
350	3,5	2,5	30	KNL	24	TR	10		166025 ●
400	3,8	2,8	30	KNL	28	TR	10		166026 ●
450	4,0	3,0	30	KNL	32	TR	10		166027 ●
500	4,0	3,0	30	KNL	36	TR	10		166028 ●



1. Sawing

1.7 Portable saws and table-top machines 1.7.6 Circular sawblades for fibre cement boards



Cutting facade panels *Excellent*

Application:

For trimming and sizing.

Machine:

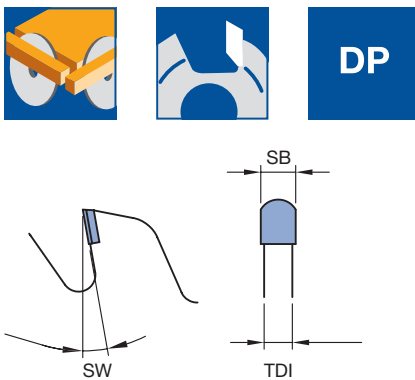
Table and sizing saws, portable and radial cross saws.

Workpiece material:

Gypsum and cement boards.

Technical information:

Robust tooth shape and DP mounting for long tool life. Special tool body design for high stability.



Circular sawblade DP design

WK 808 2 DP

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
160	3,2	2,4	20		4	P	5	■	190302 ●
184	3,2	2,4	20		4	P	5	■	190696 ●
190	3,2	2,4	20		4	P	5	■	190303 ●
190	3,2	2,4	30		4	P	5	■	190745 ●
225	3,2	2,4	30		6	P	5	■	190304 ●
300	3,2	2,4	30	KNL	8	P	5	■	190305 ●



Cutting facade panels *Excellent*

Application:

For trimming and sizing.

Machine:

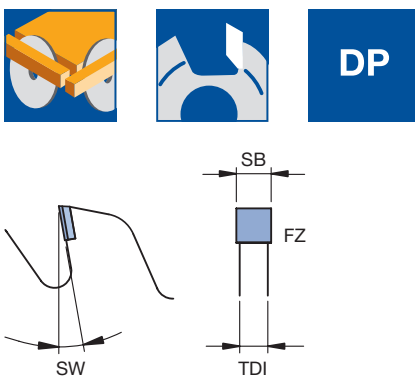
Accu-portable sawblades.

Workpiece material:

Gypsum and cement boards.

Technical information:

Thin kerf for low power requirement and long battery life. DP tipping for long tool life. Tool body with cooling holes for dust-free cutting surfaces.



Circular sawblade DP design

WK 100 3 DP

D mm	SB mm	TDI mm	BO mm	Z	ZF	SW °	WSS	ID
160	2,2	1,6	20	4	FZ	5	■	190752 ●
165	2,2	1,6	20	4	FZ	5	■	190753 ●
190	2,2	1,6	30	4	FZ	5	■	190754 ●

Reducing rings

Technical information:

For reducing the bore of circular sawblades reducing rings can be used.

Attention: When using reducing rings, pay attention to the distance to the flange.

Reducing rings in ruffle design.

Reducing ring riffled

TB 100 0 02

D	BO	DIK	ID
mm	mm	mm	
20	16	1,0	061148 ●
20	16	1,6	061104 ●
30	20	1,4	061149 ●
30	25,4	1,8	061150 ●
32	30	1,8	061151 ●

	Possible cause	Action
Sawblade wobbles	– Thickness of tool is too low.	Select a sawblade with a larger kerf or a smaller diameter or increase flange diameter.
	– Insufficient tooth projection over tool body (sawblade jams in the cut, runs hot, tension lost).	Select a sawblade with a higher lateral tooth projection.
	– Resin/chips on the flanges.	Clean flanges.
	– Flange run out tolerance too high.	Check and correct flange.
	– Defective motor spindle bearing.	Replace motor spindle bearing.
	– Tooth pitch and gullet too small.	Select a sawblade with a higher tooth pitch.
	– Unbalanced sawblade.	Balance the sawblade.
	– Blunt cutting edges.	Resharpener the sawblade.
	– Wrong sawblade tensioning.	Correct sawblade tensioning.
Wavy cut	– Irregular tooth pitch or one sided cut.	Correct sharpening machine adjustment, sharpen the sawblade.
	– Irregular tooth thickness.	Check and correct sawblade kerf.
	– Sawblade is blunt resin build up.	Clean and sharpen the sawblade.
	– Position of fence not parallel to feed direction.	Check and adjust position.
	– One sided load from edge cutting.	Use edging sawblades (hogger).
	– Cutting speed too low.	Select a larger sawblade diameter or increase RPM.
	– Wrong sawblade tensioning.	Correct sawblade tensioning.
Jamming of sawblade in cut	– Slot in saw bed is too big, insufficient chip flow, causing jamming between the saw and slot.	Replace saw bed.
	– Riving knife width is too thin.	Replace riving knife.
	– Gullet too small.	Select sawblade with larger gullet.
Curved cut when double edging	– Sawblades sharpened one sided.	Resharpener sawblade (correct kerf of sawblade and sharpening machine adjustment).
	– Resin and glue on rollers.	Clean and, if necessary, sharpen rollers.
	– Differences in wood thickness.	Improvements necessary at customer.
	– Too high cutting forces on one side.	Optimise cutting force division.
	– Worn conveyor belt guide.	Check and adjust chain guide.
	– Short and uneven workpieces.	Comply with minimum workpiece length required by the machine manufacturer's instructions.
	– When machining short workpieces and when transporting piece by piece.	Pay attention to angular cut off work pieces.

Problem	Possible cause	Action
Exceeded tolerances of horizontally cut lamellas	– Sawblade tensioning not suitable for horizontal application.	Check the sawblade tensioning.
	– High resin build up on tool, tool runs very hot from friction in cut.	Clean sawblades and check if blunt.
	– Thickness and position of riving knife not adjusted to the dimensions of strips and the sawblade kerf.	Use riving knife dimension matching the sawblade kerf. Adjust riving knife spacing to correspond to the thickness of strips.
Tear outs in workpieces coated on both sides when machining without scoring saw	– Sawblade projection over workpiece too small or too big.	Check and adjust sawblade projection.
	– Tooth shape or number of teeth not suitable for the application.	Select a sawblade suitable for the application.
	– Concentric running tolerances of the sawblade too high.	Have the sawblade checked by Leitz service.
	– The flange used on the machine does not correspond to the guidelines for flange diameter and concentric running tolerances.	Check flanges and, if necessary, clean them. If there is a wrong ratio of sawblade diameter to flange diameter, adjust accordingly.
Tear outs on the panel coating when cutting in stacks	– Tool is blunt.	Resharpen main sawblade.
	– Pressure beam cannot press evenly on uneven workpieces.	Check pressing force of pressure beam.
Tear outs where the tool leaves the workpiece when cutting in stacks	– The kerf of the scoring sawblade is too small for the main sawblade in use.	Adjust kerf of scoring sawblade to main sawblade accordingly.

1. Sawing

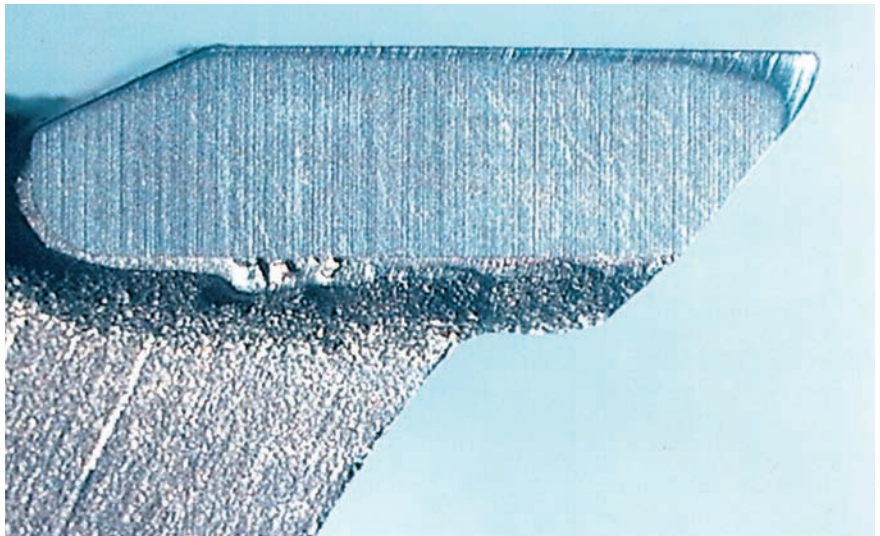
Signs of wear of HW cutting edges and tools

Rounding of cutting edge

Mechanical and chemical wear cause rounding of main and minor cutting edges of a saw tooth.

In wet solid wood (e.g. green wood) chemical wear is approximately the same as mechanical wear.

When using tungsten carbide grades with special binding agents, chemical wear can be reduced. In the wood-working sector, dry wood is machined and mechanical wear dominates.



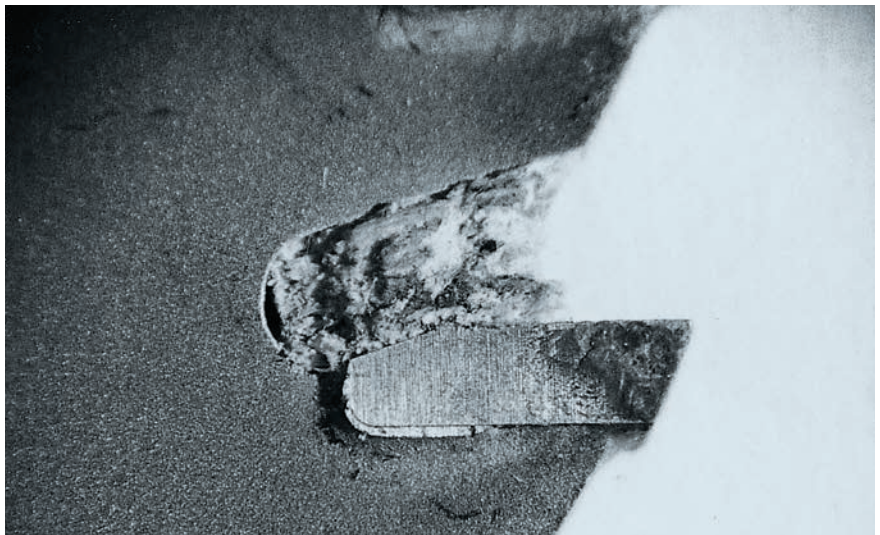
Worn HW saw tooth.

Cutting edge chips and cutting edge fracture

Hard foreign objects in the workpiece cause cutting edge chips and a deterioration of cut quality as well as increased shear forces. Mineral particles in wood derived materials are often the reason for cutting edge chips.

Saw teeth and pieces of the saw body can break off when, due to blunt cutting edges, the feed rate and cutting forces increase considerably.

A too high tooth feed can lead to choking of the lower part of the saw-blade gullet and the tooth breaking off the saw body.



Choked gullet.

Cracking of tool body

Vibrations are caused by high loads on the cutting edges and the tool body (e.g. increased bluntness, high tooth feed or one sided stress). This can cause vibration cracks in the gullet or wiper slots.

High one sided stress, e.g. when edge cutting, leads to bending, chipping or cracking of the tool body.



Fracture in the saw body.

Cutting edge rounding of DP

Mechanical wear of uniform workpiece materials causes rounding of the main and minor cutting edges. Apart from rounding, slight chips caused by foreign objects can occur when machining certain wood derived materials.

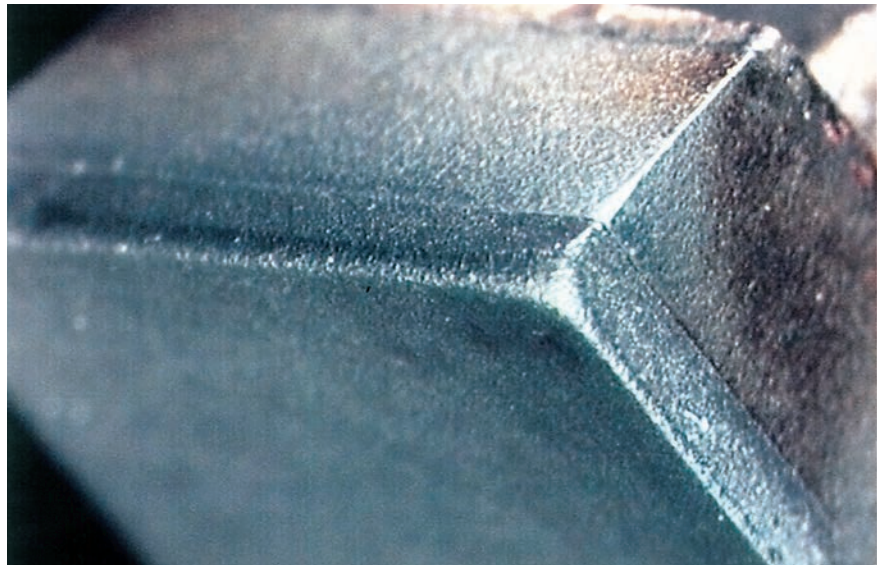
Rounding of the minor cutting edges can lead to reduced performance time and to deterioration in the cut and edge quality.

Action:

- Additional lateral eroding to the tooth relief angle.

This leads to:

- lower lateral tooth projection.
- loss of cutting width.
- higher resharpening costs.



Worn DP saw tooth.

Cutting edge chips and cutting edge fracture

Hard mineral or metallic objects lead to cutting edge chips and to a deterioration in the cut quality.

Cutting edge chips can also be caused by inefficient dust extraction (chip flow).

Extreme bluntness and chips lead to high cutting forces and consequently cracks in the saw body material.

The condition of cutting edges and saw bodies must be checked regularly. When the performance time is up, the tools must be resharpened by experts.



Cutting edge fracture of a DP saw tooth.

Enquiry/order form special tools – sawing



Customer details: Customer number:

(if known)

☐ Enquiry

Delivery date: (not binding)

CW

☐ Order

Company:

Street:

Date:

Post code/place:

Enquiry/order no.:

Country:

Tool ID: (if known)

Phone/fax:

No. of pieces:

Contact person:

Signature:

Workpiece material: (for type, quality and machining method, see selection overview)

Quality:

Machining method:

Cutting height: mm

Cutting method: ☐ single piece

☐ in stacks

Cutting quality: ☐ rough (rough sawn)

☐ fine (cut to size quality)

☐ ultra fine (finish cut quality)

Solid wood: ☐ along grain

☐ across grain

Panel materials: ☐ sizing

☐ square cutting

Machine

Manufacturer:

Type:

Model:

RPM: min⁻¹

Type of feed: ☐ MAN (Hand)

☐ MEC (Mech)

Feed rate: m min⁻¹

Flange diameter: mm

Motor power: kW

Cutting direction: ☐ against feed (GGL)

☐ with feed (GLL)

Tool: (must be completed)

Diameter: mm

Cutting width: mm

Bore: mm

Keyway/double keyway: mm

Pinholes:

Use: ☐ Single tool

☐ Tool set

Cutting material: ☐ Stellite™

☐ HW (TC)

☐ DP (DIA)

(Complete if sawblade design is known)

Number of teeth:

Shape of teeth:

Tool body thickness: mm

Tool body shape (as per drawing): (enter number)

Additional elements of saw body (as per drawing): (enter number)

Standard design: ☐

Low noise design: ☐ with laser ornaments ☐ UT

☐ with damping foil

Direction of rotation ☐ left hand rotation (LL)

(as per drawing): ☐ right hand rotation (RL)

Recessed tool body: Hub diameter: mm

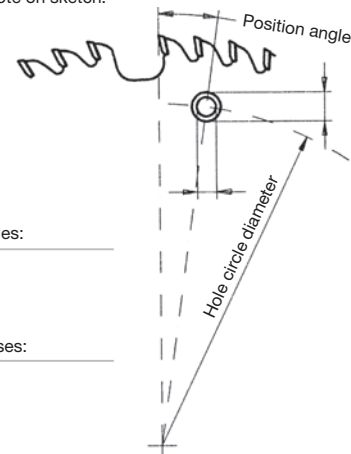
Hub thickness: mm

Position of hub: ☐ Side 1

☐ Side 2

Bore – note on sketch:

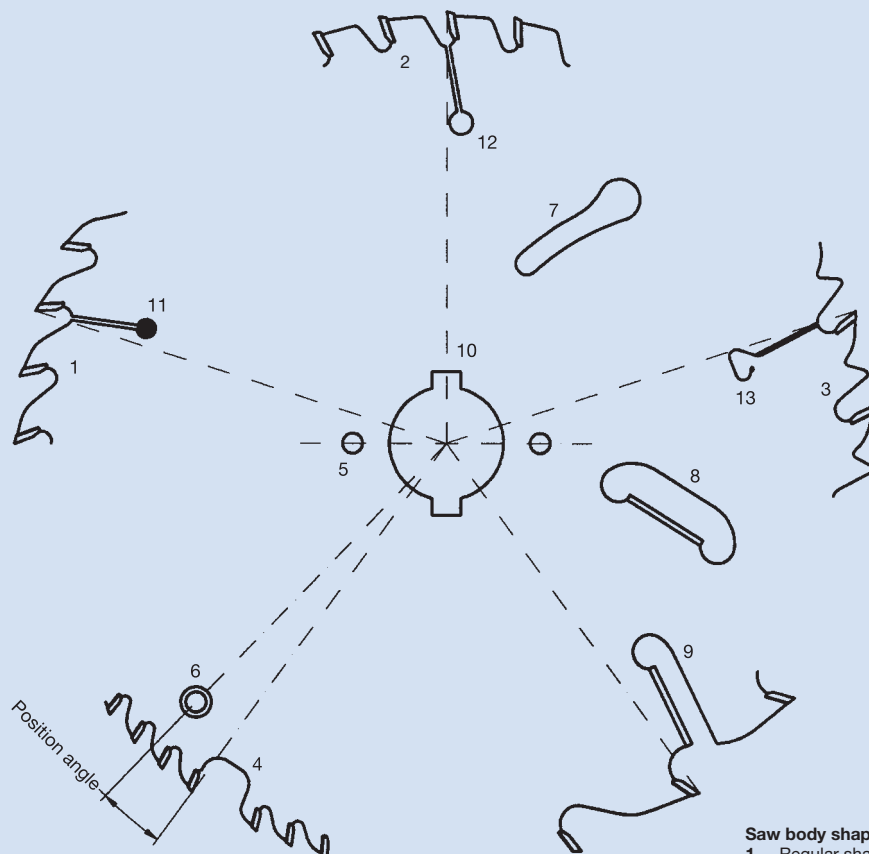
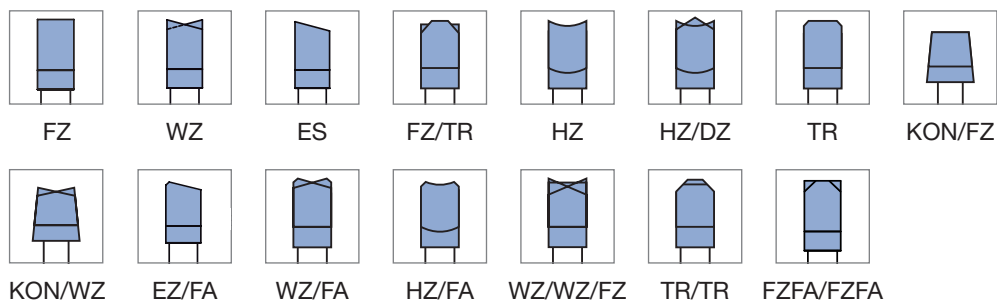
Cut out teeth – note on sketch.



Number of pinholes:

Number of recesses:

Tooth shapes



Saw body shape:

- 1 Regular shape
- 2 Round shape
- 3 Limiter

Cut out:

- 4 Tooth cut out

Pinholes:

- 5 Pinhole
- 6 Pinhole with countersink

Additional elements in the saw body:

- 7 Cooling element
- 8 Wiper slot with HW cutting edge inside
- 9 Wiper slot with HW cutting edge outside
- 10 Keyway or double keyway

Expansion slots:

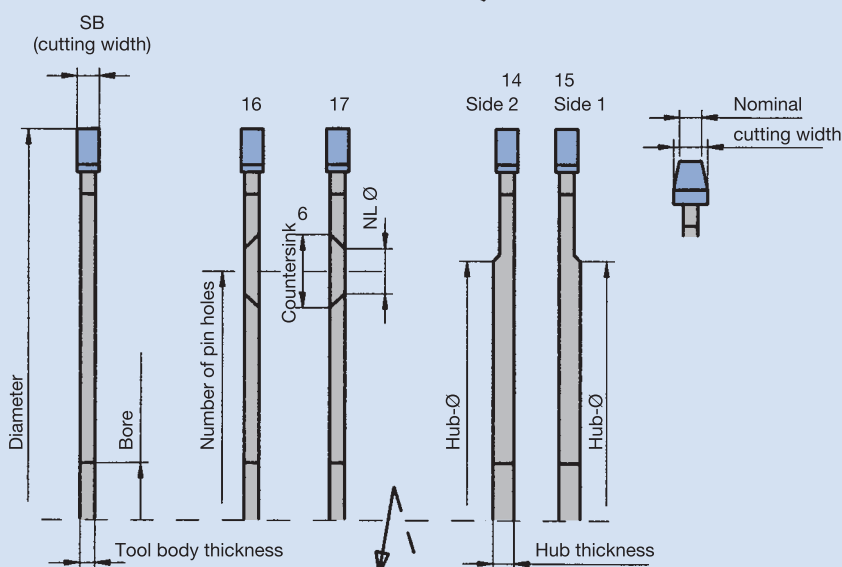
- 11 Expansion slot shape A, with rivets
- 12 Expansion slot shape A
- 13 Expansion slot shape D

Position of hub:

- 14 Position of hub, side 2
- 15 Position of hub, side 1

Direction of rotation:

- 16 Right hand rotation
- 17 Left hand rotation





Sawing
thin kerf



Sawing
hollow metal



Sawing
horizontal



Sawing
crosscut metal



Sawing
along grain



Scoring,
hogging



Sawing
across grain



Grooving,
horizontal and vertical



Sawing
universal



Tipped tool



Scoring,
sawing



Low noise



Scoring and
sawing stacks



Tungsten carbide



Sawing
hollow sections



Polycrystalline
diamond (PCD)



Sawing
plastic single



Sawing
plastic stacks



Sawing
solid transparent plastic

