

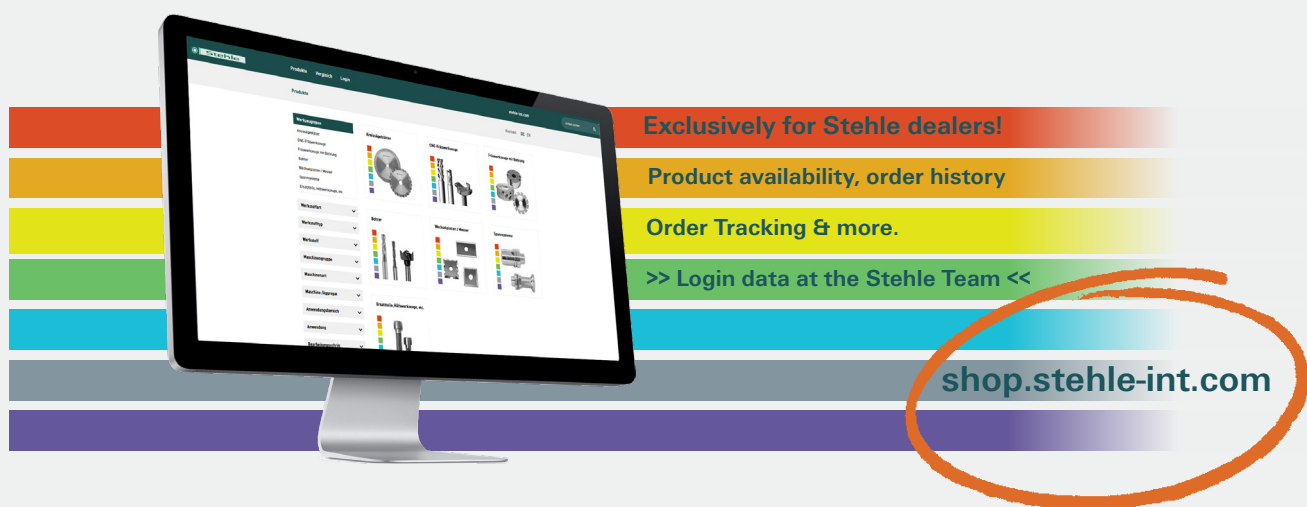


Finger jointing and planing

2025



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TREND-SETTING, INNOVATIVE, RELIABLE



STEHLE – a strong and reliable partner for trading companies. Today and in the future.

”

We have used the last few years to offer retailers a functional and intuitive digital e-shop and are very pleased with the lively and positive use and acceptance and feedback from our customers.

In addition to expanding our international partnerships, we are continuously working on optimizing our Stehle program and adding further digital services, and we also welcome feedback and suggestions for improvement.

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*Enjoy and be successful with our new catalog!
Whether in paper form, on your PC or smartphone!*



Daniel Schrenk,
CEO

Reiner Bix,
Sales Manager Distribution

“

Machines

 Portable saws	 Vertical panel sizing saw	 Four-side planing machine	 Double end tenoners
 Clipping and Mitre Saws	 Multi rip saw	 CNC router	 Not classified
 Table saw	 Portable router	 Spindle Moulder	 Akku-Portable saws
 Horizontal panel sizing saw	 Multi spindle drilling machine	 Edges	

Application

 Abrasive	 Abrasive – excellently suited	 Abrasive – well suited
 Construction	 Construction – excellently suited	 Construction – well suited
 Wood	 Wood – excellently suited	 Wood – well suited
 Wood-based materials	 Wood-based-materials – excellently suited	 Wood-based-materials – well suited
 Aluminium	 Aluminium – excellently suited	 Aluminium – gut geeignet
 Steel	 Steel – excellently suited	 Steel – well suited
 Plastic	 Plastic – excellently suited	 Plastic – well suited

Design / Features

 Aluminium body	 For cross cuts	DM Monocrystalline diamond	 60 m/min Recommended feed	MAN Manual feed
 Steel body	 For profile trimming	VHW Solid tungsten carbide	 max. 20.000 U/min Maximum RPM	MEC Mechanical feed
 Solid tungsten carbide body	 Tungsten carbide quality	SK SK adapters	 Right hand / Left hand	 easyFix - bore
 coated saw blade body	HS High speed steel	BT BT adapters	R/L Rechts-/Links-lauf	 Fibonacci markings
 Low noise level	HS-Super Pulvermetallurgischer Schnellarbeitsstahl	HSK HSK adapters	 Hard wood	
 Resharpener area in mm	HS 3-Plus Pulvermetallurgischer Schnellarbeitsstahl	 No. of ground cutting edges	 Soft woods	

Tooth Configurations

 Flat „F“	F	 Alternate top bevel „WS“	WS	 Inverted-v/ Flat „DA-F“	DA-F
 hollow back tooth	HR	 Alternate top bevel with chamfer „WS-FA“	WS-FA	 inverted-v / flat tooth / hollow-ground tooth	DA-F DU
 Flat with alternating chamfer „F-WFA“	F-WFA	 Triple chip - flat „TR-F“	TR-F	 inverted-v / flat tooth with chamfer / hollow-ground tooth	DA-F-FA DU
 Flat ATB „F-WS-WS“	F-WS-WS	 Triple chip - flat with two-sided chamfer „TR-F-FA“	TR-F-FA	 Conical-flat „KO-F“	KO-F
 alternate top bevel with shear angle „WSA“	WSA	 triple chip / flat - flat / hollow-ground tooth „TR-F-F DU“	TR-F-F DU	 G7	G7
 V-tooth „V“	V	 flat with chamfer „F-FA“	F-FA	 top bevel „ES (right + left)“	ES

Delivery code

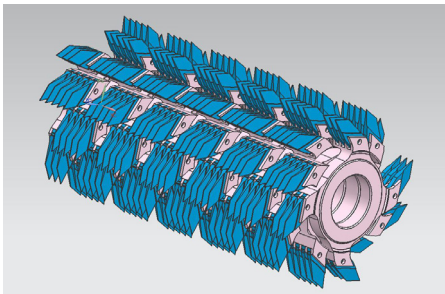
L available from stock	S Production per drawing, Delivery time on request	& Modification and/or mounting of stock parts
O available on short notice	# Discontinued, subject to availability	C Delivery time on request – price scales available

NEW FINGER JOINT CUTTER TYPES AND PROGRAM

With the new and innovative geometry of the finger joint cutters for the production of PUR glueing (with and without fiber) and the new high-performance compact cutters for through feed systems, users now have improved and more efficient systems at their disposal. In addition, a new version of the disk cutters with easyFix bore and Fibonacci arrangement is available.

New in the range for the production of finger joints with PUR glueing

The HS3-Plus tipped tools for finger jointing lines without a cut-to-length unit (indexing lines) are used to produce longitudinal joints. The advantage of the new cutter lies in the cutting angle of the individual cutting edges. Thanks to optimization, this "neutral" design is ideally suited for gluing with PUR glue with and without fiber.

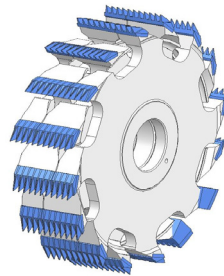


Finger joints with PUR glueing
HS-3Plus Triathlon D170, Z4, 15/15

Our Triathlon coating increases the tool life many times over compared to the HS version.

The cutting pressure is reduced and at the same time a longer tool life is achieved with less risk of tooth breakage. The coating is durable and can be easily resharpener.

In order to guarantee the performance and consistent quality of the tools, a reliable production process is required. This includes criteria such as a reliable brazed joint, hubs and bores ground to micrometer accuracy, high balancing quality and Stehle's repair and sharpening expertise



high-performance tool for through-feed machines
HS-Super Triathlon, D250, 6/7, Z8

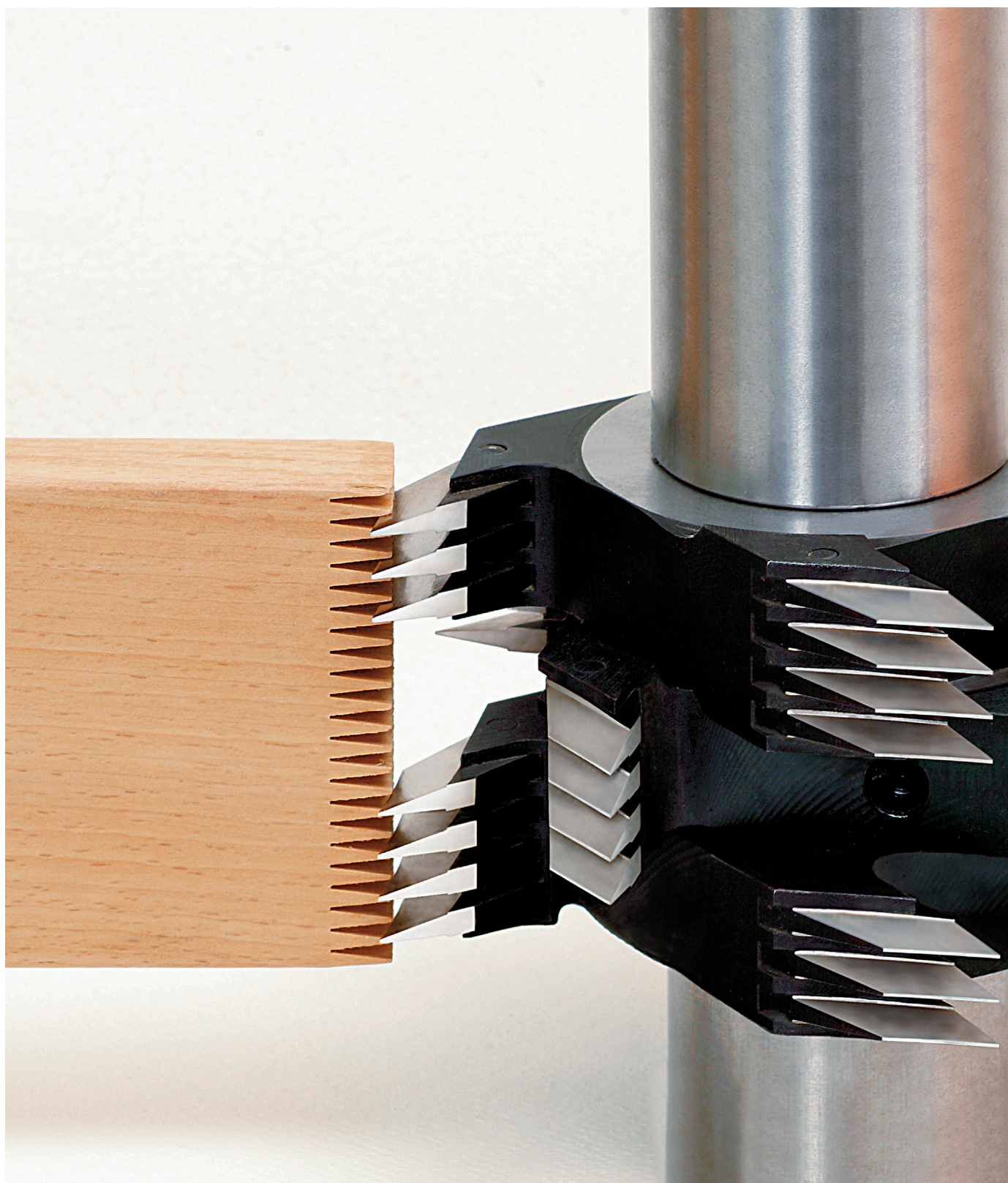
STEHLE FINGER JOINT CUTTER PROGRAM

BY MEANS OF THIS OVERVIEW YOU WILL QUICKLY FIND THE SUITABLE CUTTER

Application Design		Finger Joint Cutters									Disc-Type Finger Joint Cutters									cutterhead			
		Finger Joint Cutters HS			Finger Joint Cutters HS 3Plus			Finger Joint Cutters HW			Finger Joint Cutters HW soft wood			Finger Joint Cutters HW hard wood			Finger Joint Cutters HW exotic wood			Finger Joint Cutterhead			
Glueing	normal	++			++			++			++			++			++			++			
	fiber free	++			o			o			o			o			o			o			
Wood types	Coniferous wood	++			++			o			++			++			o			++			
	Deciduous wood	+			++			++			-			++			++			o			
	Exotic wood	o			+			+			-			+			++			o			
Dimensions on machine	machines (with hogger)	10/11	15/16,5	20/22	6/7	10/11	15/16,5	20/22	10/11	15/16,5	10/11	10/11	15/16,5	-	10/11	15/16,5	-	-					
	machines (without hogger)	10/10	15/15	20/20	-	10/10	15/15	20/20	10/10	15/15	-	-	-	-	-			10/10	10/11	15/15	15/16,5		
Coating possibilities	Non-stick coating	Triathlon									(*)			(*)			(*)			Triathlon			
Comparison of edge lives	uncoated	100%			up to 300%-400 %			up to 400% (increased risk of breaking)			100%			100%			100%			100%			
	Triathlon	up to 200% - -300%			> 500 % (*)			(*)			up to 200%			up to 200%			-			up to 200% - 300%			

*on request

++ very well suited + well suited o possible - not possible / not suitable



FINGER JOINTING / PLANING

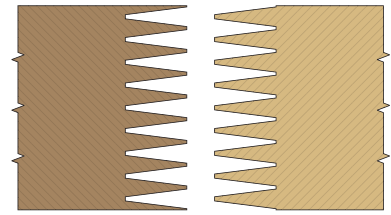
CONTENTS

FINGER JOINTING	finger joint machines	Technical Information / cutter types	1
		Technical Information / types of finger joints	2
		Technical Information / cutter insert	3
		198 Finger Joint Cutters - Z=2+2 and Z=3+3	4
		196 Finger Joint Cutters - Real Z=3, Z=4 and Z=6	6
		198 Finger Joint Cutters HS-Super - Z=4+4 and Z=6+6	8
		196 Finger Joint Cutters - Real Z=8	9
		198 Finger Joint Cutters 3-Plus - Z=2+2 and Z=3+3	10
		196 High Performance Finger Joint Cutters 3 Plus - Real Z=3, Z=4 and Z=6	11
		198 Finger Joint Cutters "TRIATHLON" - Z=2+2 and Z=3+3	14
		196 High Performance Finger Joint Cutters "TRIATHLON" - Real Z=3, Z=4 and Z=6	15
		198 Finger Joint Cutters "TRIATHLON" - Z=6+6	17
		196 High Performance Finger Joint Cutters "TRIATHLON" - Real Z=8	18
		198 Finger Joint Cutters - Z=2+2 and Z=3+3	19
		194 Edge Finger Joint Cutters	20
		199 Finger Joint Cutters / Edge Finger Joint Cutters	21
		195 Finger Joint Cutterheads	23
		200 Finger Joint Cutters / Edge Finger Joint Cutters disc-type	24
		Bushings for Finger Joint Cutters	26
		Saw Hogs HW for finger jointing lines without bushing	27
		Saw Hogs HW mounted on bushing for finger jointing lines	28
		Scoring Saw Blades for finger joint machines	29
		Scoring Saw Blade Set - for finger joint machines	29
PLANING	Saws / Optimizing Chop Saws	OKW	31
		LWR	31
	CNC cutterheads / jointing and rabbeting cutterheads	3520 Shank-Type Cutters with HW Turnover Knives - t3-System	32
		5575 Spiral Cutterheads	33
		5576 Jointing and rabbeting cutterheads	34
		5570 Spiral Cutterheads	35
		556-1 Planing Cutterheads	36
		520-1 Hydro Planing Cutterheads	37
		569 Planing Knives HS - Plus	38
		569 Planing Knives HW	39
		525 Profile Cutterheads	40
		521-1 Hydro Profile Cutterheads	42
		525 Blanks with serrated back HS	44
		464 Multi Dowel Cutterheads	45
		464 HS Knives smooth round bars	46
		464 HS Knives ripple bars	47
	Planing	4000 Tongue and Groove Tools	48

Cutter types

Finger Joint Cutters

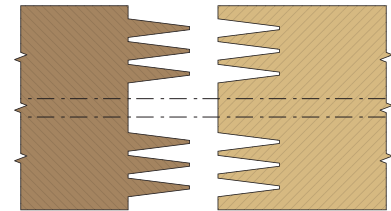
Load bearing longitudinal joints (end-to-end) are produced by finger jointing. The finger length of 30-50 mm which was standard in the past could be reduced thanks to improved tool technology (finger length 10/15/20 mm) with the effect of a significant reduction of wood waste.



Load bearing capacity of the finger joints

The load bearing capacity of the finger joints is strongly correlated with the measurement proportions specified in the DIN norms (e.g. finger length, angle, finger pitch etc).

We distinguish between load bearing capacity I and II. These two groups in turn must comply with particular requirements of finger jointing. The weakening degree, length of finger and angle of flanks are interdependent factors of finger joint profiles. The decisive factor for the load bearing capacity of a finger joint is the weakening degree v . The bigger v is, the lower is the possible load bearing of a finger joint. The following results are valid for each load bearing capacity group:
load bearing capacity group I: v must be $\leq 0,18$
load bearing capacity group II: v can be $\leq 0,25$



Overview

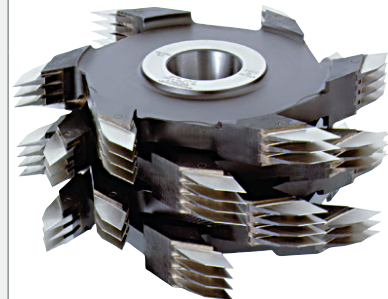
finger joint profiles

finger length L	10	15	20
finger pitch t	3,8	3,8	6,2
width of finger joint bottom b	0,6	0,54	0,9
weakening degree v	0,15	0,14	0,14
load bearing capacity group	I + II	I + II	I + II

compact cutter

e.g. Cutter No. 198/199

HS, HS-Super or HW-tipped, proven performance and extremely robust tooth design and extended edge life.



single cutter

e.g. Cutter No. 200

Individual cutting discs with the possibility to add or remove single discs according to the required cutting height. Further advantage: spiral design permits higher feed speeds with either 4 or 6 discs in operation. Easy handling thanks to the easyFix bore, simple, smooth mounting of the cutter



edge cutter

e.g. Cutter No. 200

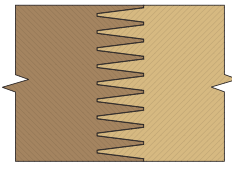
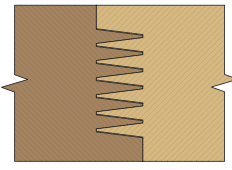
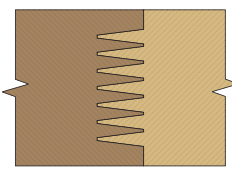
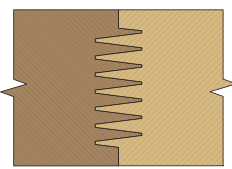
the "half shoulder", "alternating shoulder" or "one-sided shoulder" profiles can be produced with the edge cutters in Z4 or Z6.



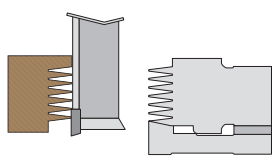
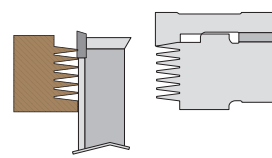
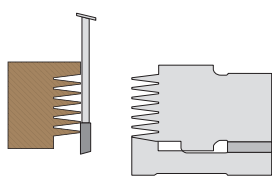
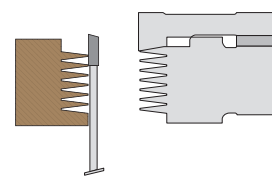
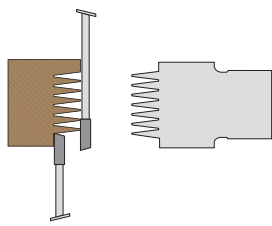
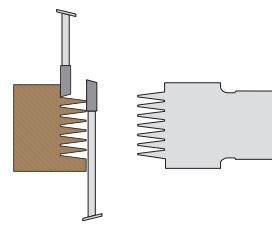
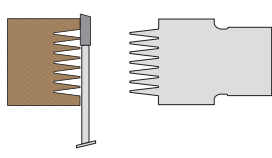
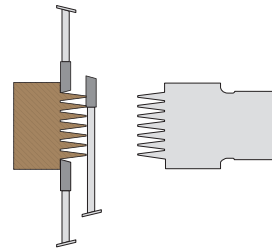
Types of finger joints

Finger Joint Cutters

Depending on the application of the wood joint, profiles can be produced with or without edge fingers. Depending on the machine, the edge joints can be produced with a cross-cutting device or with the respective tools.

a) endless galvanizing without edge cutter (no shoulder)		c) double-sided butt joint edge joints in staggered position "Change shoulder"	
b) double-sided butt joint one-sided edge joints "one-sided shoulder"		d) double-sided butt joint centric edge joints "half shoulder"	

Examples

A • cross cutting from top with hogger • with edge cutting by means of edge finger joint cutters		E • cross cutting from below with hogger • with edge cutting by means of edge finger joint cutters	
B • cross cutting from above with saw blade • with edge cutting by means of edge finger joint cutters		F • cross cutting from below with saw blade • with edge cutting by means of edge finger joint cutters	
C • cross cutting from above with saw blade • bevelling with scoring saw blade from below		G • cross cutting from below with saw blade • bevelling with scoring saw blade from top	
D • cross cutting from below with saw blade		H • cross cutting from below with saw blade • bevelling with scoring saw blade from top and from below	

cutter insert

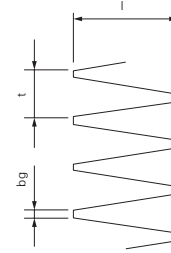
Finger Joint Cutters

Basically, different tools are used depending on the application:

Machines without cross-cutting device

The required finger tools are designed for finger joint profiles 10/10 mm, 15/15 mm and 20/20 mm.

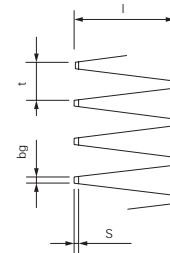
Finger joints with gap "s" can be produced. The gap can vary and depends e.g. on the factors material type, tool and machine.



Machines with cross-cutting device

The required finger tools are designed for the finger joint profiles 10/11 mm, 15/16,5 mm and 20/22 mm.

Thanks to the precise cross cutting of the fingers (adjustment) close fitting finger joints without gap "s" can be produced.

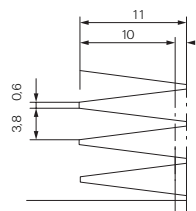


Cross cutting with extended finger joint profile

With the cross-cutting device the actual profile depth can vary between 10 and 11 in the case of finger length 10/11 mm (accordingly, the profile depth can vary between 15 and 16.5 in the case of finger length 15/16.5 mm and between 20 and 22 in the case of finger length 20/22 mm).

The variable profile length allows to change the fitting conditions.

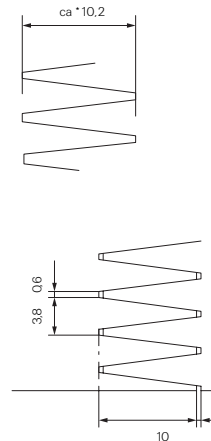
profile example 10/11 mm
before cross cutting



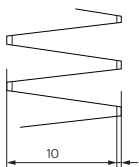
cut to approx. *10.2 mm
close fit profile
= depending on material

1 mm
variable length

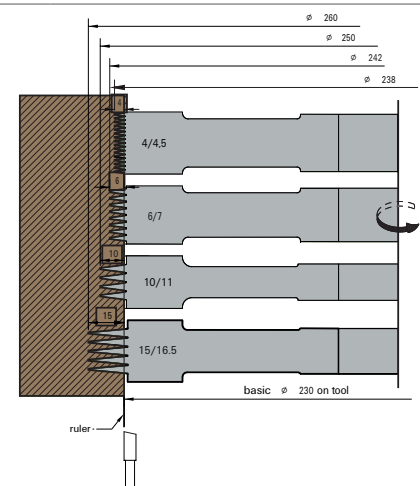
finger joint cut to 10 mm
profile 10/10 with gap



profile example 10/10 mm
without cross cutting
0.32 gap
theoretical value



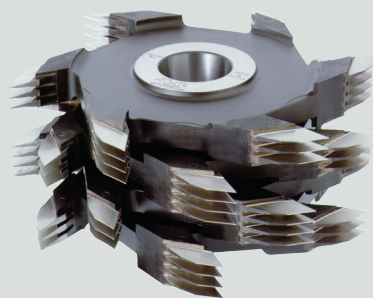
Graphic example of basic dimension
Basic information on the tool diameter



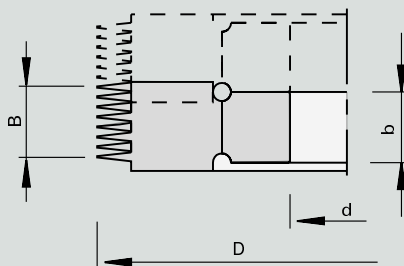
HS 198 Finger Joint Cutters - Z=2+2 and Z=3+3

HS-tipped

Product



Drawing



Machine



Application



Design

HS

MEC



Machine / Application

- finger joint machines
- machines with and without cross-cutting device
- for longitudinal joints in soft woods

Design

- straight tooth front
- secured against twisting
- cutting material: HS-tipped

Advantages

Notes

- extended finger joint profiles 10/11, 15/16,5 and 20/22 only for machines with cross-cutting device

Overview

wood width with finger length of

Number of cutters

	10 or 15 mm fingers	20 mm fingers; pitch 6.2 mm	20 mm fingers; pitch 5.0 mm	
	with B = 28.6	with B = 33	with B = 37	
	24	28	32	1
	51	59	67	2
	77	90	102	3
	104	132	137	4
	131	152	172	5
	157	183	207	6
	184	214	242	7
	210	245	277	8
	237	276	312	9
	264	307	347	10

10 mm fingers

Product features

Order information

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		PU	L	Order-No.
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		[pc.]		
160	28,6	26.6	50	2+2	3.8	10/10	7	9000		1	C	58572497
250	28,6	26.6	50	3+3	3.8	10/10	7	6000		1	C	58572519
160	28,6	26.6	50	2+2	3.8	10/11	7	9000		1	L	58572501
160	32,4	30.4	50	2+2	3.8	10/11	8	9000		1	C	58572509
160	32,4	30.4	50	3+3	3.8	10/11	8	9000		1	C	58572508
250	13,4	11.4	50	3+3	3.8	10/11	3	6000		1	C	58572548
250	17,2	15.2	50	3+3	3.8	10/11	4	6000		1	C	58572547
250	21	19	50	3+3	3.8	10/11	5	6000		1	C	58572546
250	28,6	26.6	50	3+3	3.8	10/11	7	6000		1	L	58572516

15 mm fingers

Product features

Order information

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		PU	L	Order-No.
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		[pc.]		
170	28,6	26.6	50	2+2	3.8	15/15	7	9000		1	L	58572507
170	28,6	26.6	50	3+3	3.8	15/15	7	9000		1	L	58572503
170	28,6	26.6	50	2+2	3.8	15/16,5	7	9000		1	L	58572510
260	28,6	26.6	50	3+3	3.8	15/15	7	6000		1	C	58572520
170	28,6	26.6	50	3+3	3.8	15/16,5	7	9000		1	C	58572690
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000		1	L	58572521

20 mm fingers with 6.2 mm pitch

Product features									Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]		PU [pc.]	L	Order-No.
180	33	31	50	2+2	6.2	20/20	5	9000		1	L	58572512
180	33	31	50	2+2	6.2	20/22	5	9000		1	L	58572514
260	33	31	50	3+3	6.2	20/20	5	6000		1	C	58572522
260	33	31	50	3+3	6.2	20/22	5	6000		1	L	58572518

20 mm fingers with 5.0 mm pitch

Product features									Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]		PU [pc.]	L	Order-No.
260	37	35	50	3+3	5.0	20/22	7	6000		1	C	58572570
180	37	35	50	2+2	5.0	20/22	7	9000		1	C	58572571
180	37	35	50	2+2	5.0	20/20	7	9000		1	C	58572572

15 mm finger joint for PUR glueing

Product features									Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]		PU [pc.]	L	Order-No.
170	28,6	26.6	50	2+2	3.8	15/15	7	9000		1	C	58577100
260	28,6	26.6	50	3+3	3.8	15/15	7	6000		1	C	58577101

20 mm finger joint for PUR glueing

Product features									Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]		PU [pc.]	L	Order-No.
180	33	31	50	2+2	6.2	20/20	5	9000		1	C	58577103
260	33	31	50	3+3	6.2	20/20	5	6000		1	C	58577104

HS**196 Finger Joint Cutters - Real Z=3, Z=4 and Z=6****HS-tipped**

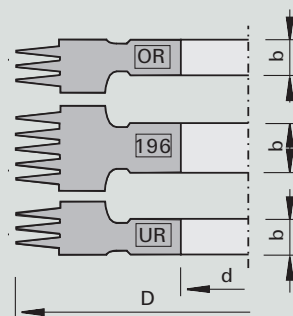
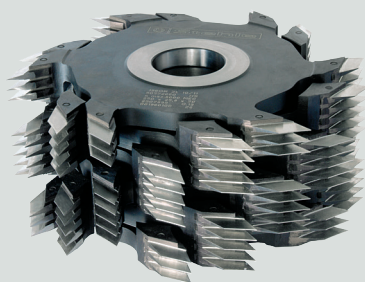
Product

Drawing

Machine

Application

Design

**HS****MEC**

Machine / Application

Design

Advantages

Notes

- high-performance finger joint machines
- machines with and without cross-cutting device
- for longitudinal joints in soft woods

- real Z=3, Z=4 or Z=6 for high feed rates up to 54 m/min
- cutting material: HS-tipped

- constant finger quality even with high feed rates thanks to double number of teeth compared to standard design

- no. of cutters: see table

10 mm + 15 mm fingers with 3.8 mm pitch

wood width	No. of cutters
15	OR + UR
34	OR + 1 + UR
53	OR + 2 + UR
72	OR + 3 + UR
91	OR + 4 + UR
110	OR + 5 + UR
129	OR + 6 + UR
148	OR + 7 + UR
167	OR + 8 + UR
186	OR + 9 + UR
205	OR + 10 + UR
224	OR + 11 + UR
243	OR + 12 + UR
262	OR + 13 + UR
281	OR + 14 + UR
300	OR + 15 + UR
319	OR + 16 + UR

20 mm fingers with 6.2 mm pitch

wood width	No. of cutters
20	OR + UR
38	OR + 1 + UR
57	OR + 2 + UR
76	OR + 3 + UR
94	OR + 4 + UR
113	OR + 5 + UR
132	OR + 6 + UR
150	OR + 7 + UR
169	OR + 8 + UR
187	OR + 9 + UR
206	OR + 10 + UR
224	OR + 11 + UR
243	OR + 12 + UR
262	OR + 13 + UR
280	OR + 14 + UR
299	OR + 15 + UR
317	OR + 16 + UR

10 mm finger joint / bore 50 mm

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	250	26,4	15,4	50	6	3,8	10/11	3	6000	1	C	58572675
MI	250	41	19	50	6	3,8	10/11	5	6000	1	C	58572661
UR	250	26,4	15,4	50	6	3,8	10/11	3	6000	1	C	58572676

15 mm finger joint / bore 50 mm

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	170	25,8	14,8	50	4	3,8	15/15	3	9000	1	C	58572666
MI	170	41	19	50	4	3,8	15/15	5	9000	1	C	58572667
UR	170	25,8	14,8	50	4	3,8	15/15	3	9000	1	C	58572668
OR	170	25,8	14,8	50	4	3,8	15/16,5	3	9000	1	C	58572669
MI	170	41	19	50	4	3,8	15/16,5	5	9000	1	C	58572670
UR	170	25,8	14,8	50	4	3,8	15/16,5	3	9000	1	C	58572671

15 mm finger joint / bore d= 60 mm

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	200	25,8	14,8	60	4	3,8	15/15	3	7000	1	C	58572680
MI	200	41	19	60	4	3,8	15/15	5	7000	1	C	58572681
UR	200	25,8	14,8	60	4	3,8	15/15	3	7000	1	C	58572682

15 mm finger joint / bore d= 70 mm

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	200	25,8	14,8	70	4	3,8	15/15	3	7000	1	C	58572683
MI	200	41	19	70	4	3,8	15/15	5	7000	1	C	58572684
UR	200	25,8	14,8	70	4	3,8	15/15	3	7000	1	C	58572685

20 mm finger joint / bore 50 mm

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	180	27,2	16,7	50	3	6,2	20/20	2	9000	1	C	58572672
MI	180	39,6	18,6	50	3	6,2	20/20	3	9000	1	C	58572673
UR	180	27,2	16,7	50	3	6,2	20/20	2	9000	1	C	58572674

20 mm finger joint / bore d= 70 mm

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	200	27,2	16,7	70	4	6,2	20/20	2	7000	1	C	58572686
MI	200	39,6	18,6	70	4	5,2	20/20	3	7000	1	C	58572687
UR	200	27,2	16,7	70	4	6,2	20/20	2	7000	1	C	58572688

15 mm finger joint for PUR glueing / bore d=50 mm

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	170	25,8	14,8	50	4	3,8	15/15	3	9000	1	C	58577675
MI	170	41	19	50	4	3,8	15/15	5	9000	1	C	58577676
UR	170	25,8	14,8	50	4	3,8	15/15	3	9000	1	C	58577677

15 mm finger joint for PUR glueing / bore d= 60 mm

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	200	25,8	14,8	60	4	3,8	15/15	3	7000	1	C	58577684
MI	200	41	19	60	4	3,8	15/15	5	7000	1	C	58577685
UR	200	25,8	14,8	60	4	3,8	15/15	3	7000	1	C	58577686

15 mm finger joint for PUR glueing / bore d= 70 mm

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	200	25,8	14,8	70	4	3,8	15/15	3	7000	1	C	58577687
MI	200	41	19	70	4	3,8	15/15	5	7000	1	C	58577688
UR	200	25,8	14,8	70	4	3,8	15/15	3	7000	1	C	58577689

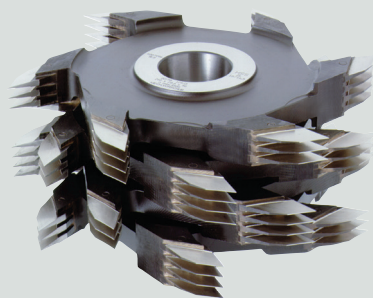
20 mm finger joint for PUR glueing / bore d= 70 mm

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	200	27,2	16,7	70	4	6,2	20/20	2	7000	1	C	58577691
MI	200	39,6	18,6	70	4	5,2	20/20	3	7000	1	C	58577692
UR	200	27,2	16,7	70	4	6,2	20/20	2	7000	1	C	58577693

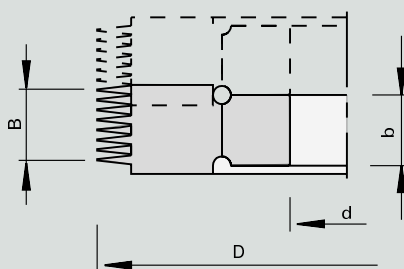
HS**198 Finger Joint Cutters HS-Super - Z=4+4 and Z=6+6**

HS -Super

Product



Drawing



Machine



Application



Design

HS-Super**MEC**

Machine / Application

- finger joint machines
- machines with cross-cutting device
- for longitudinal joints in knotty soft woods

Design

- straight tooth front
- secured against twisting
- cutting material: HS-Super-tipped

Advantages

- 40 % less chips than 10/11
- 2% wood saving compared to 10/11

Notes

- extended finger joint profiles 10/11, 15/16,5 and 20/22 only for machines with cross-cutting device
- no. of cutters: see table

Overview

wood width with finger length of

Number of cutters

4 mm fingers with B = 26	6 mm finger joint with B = 28	
25	23	1
49	51	2
73	79	3
97	107	4
121	135	5
145	163	6
169	191	7
193	219	8
217	247	9
241	275	10

4 mm fingers

Product features

Product features									Order information			
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		PU	L	Order-No.
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		[pc.]		
160	26	25.6	50	2+2	1.6	4/4	16	9000		1	s	50572490

6/7 mm finger joint

Product features

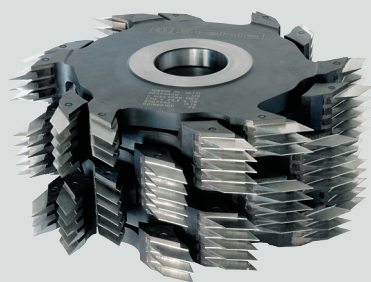
Product features									Order information			
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		PU	L	Order-No.
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		[pc.]		
250	30	28	50	6+6	2.8	6/7	10	6000		1	s	50573700

HS

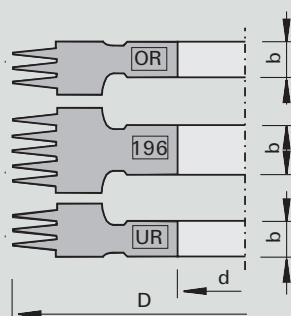
196 Finger Joint Cutters - Real Z=8

HS-Super-tipped

Product



Drawing



Machine



Application



Design

HS-Super

MEC



Machine / Application

- high-performance finger joint machines
- machines with cross-cutting device
- for longitudinal joints in soft woods

Design

- real Z=8 for high feed rates up to 72 m/min
- cutting material: HS-Super tipped

Advantages

- up to 33% more output by Z=8 than 6 wings
- 40% less chips than 10/11
- safe 2% wood than 10/11
- constant finger quality even with high feed rates thanks

Notes

- no. of cutters: see table

6 / 7 mm finger joint with pitch 2.8 mm

wood width	No. of cutters
17	OR + UR
36	OR + 1 + UR
56	OR + 2 + UR
75	OR + 3 + UR
95	OR + 4 + UR
115	OR + 5 + UR
134	OR + 6 + UR
154	OR + 7 + UR
173	OR + 8 + UR
192	OR + 9 + UR
211	OR + 10 + UR

6/7 mm finger joint

Product features								Order information				
	Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax	PU	L	Order-No.
	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]	[pc.]		
OR	250	21,6	12,2	50	8	2,8	6/7	4	6000	1	s	50573681
MR	250	38,4	19,6	50	8	2,8	6/7	7	6000	1	s	50573682
UR	250	21,6	12,2	50	8	2,8	6/7	4	6000	1	s	50573683

HS 198 Finger Joint Cutters 3-Plus - Z=2+2 and Z=3+3

HS 3-Plus

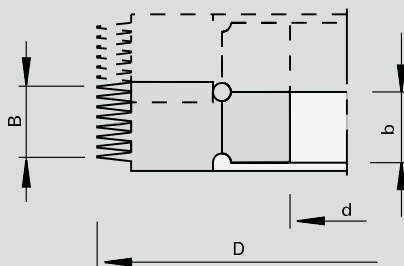
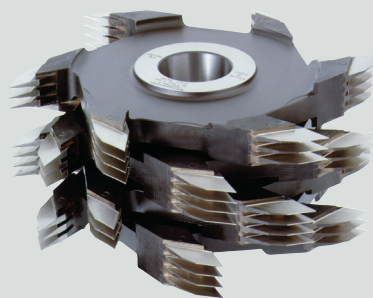
Product

Drawing

Machine

Application

Design

HS
3-Plus

MEC



Machine / Application

- finger joint machines
- machines with and without cross-cutting device
- for longitudinal joints in knotty soft woods

Design

- cutting material: HS 3-Plus

Advantages

- multiple edge lives compared to traditional HS finger joint cutters
- high bending strength
- reduced risk of tooth breaking

Notes

- extended finger joint profiles 10/11, 15/16,5 and 20/22 only for machines with cross-cutting device
- no. of cutters: see table

Overview

wood width with finger length of

Number of
cutters

	10 or 15 mm fingers with B = 28.6	20 mm fingers; pitch 6.2 mm with B = 33	20 mm fingers; pitch 5.0 mm with B = 37	
24	28	32		1
51	59	67		2
77	90	102		3
104	132	137		4
131	152	172		5
157	183	207		6
184	214	242		7
210	245	277		8
237	276	312		9
264	307	347		10

10 mm fingers

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]		PU [pc.]	L	Order-No.
160	28,6	26.6	50	2+2	3.8	10/10	7	9000		1	C	58574497
250	28,6	26.6	50	3+3	3.8	10/10	7	6000		1	C	58574519
160	28,6	26.6	50	2+2	3.8	10/11	7	9000		1	C	58574501
250	28,6	26.6	50	3+3	3.8	10/11	7	6000		1	C	58574516

15 mm fingers

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]		PU [pc.]	L	Order-No.
170	28,6	26.6	50	2+2	3.8	15/15	7	9000		1	L	58574507
260	28,6	26.6	50	3+3	3.8	15/15	7	6000		1	C	58574520
170	28,6	26.6	50	2+2	3.8	15/16,5	7	9000		1	C	58574510
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000		1	C	58574521

20 mm fingers with 6.2 mm pitch

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]		PU [pc.]	L	Order-No.
180	33	31	50	2+2	6.2	20/20	5	9000		1	C	58574512
180	33	31	50	2+2	6.2	20/22	5	9000		1	C	58574514

20 mm fingers with 5.0 mm pitch

Product features									Order information			
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		PU	L	Order-No.
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		[pc.]		
180	37	35	50	2+2	5.0	20/20	7	9000		1	C	58574572
180	37	35	50	2+2	5.0	20/22	7	9000		1	C	58574571

HS 196 High Performance Finger Joint Cutters 3 Plus - Real Z=3, Z=4 and Z=6

Machine / Application

Design

Advantages

Notes

- high-performance finger joint machines
- machines with and without cross-cutting device
- for longitudinal joints in knotty soft woods

- real Z=3, Z=4 or Z=6 for high feed rates up to 54 m/min
- cutting material: HS 3-Plus

- multiple edge lives compared to traditional HS finger joint cutters
- high bending strength
- reduced risk of tooth breaking
- constant finger quality even with high feed rates thanks to double number of teeth compared to standard design

- extended finger joint profiles 10/11, 15/16,5 and 20/22 only for machines with cross-cutting device

Machine / Application	Design	Advantages	Notes
- high-performance finger joint machines - machines with and without cross-cutting device - for longitudinal joints in knotty soft woods	- real Z=3, Z=4 or Z=6 for high feed rates up to 54 m/min - cutting material: HS 3-Plus	- multiple edge lives compared to traditional HS finger joint cutters - high bending strength - reduced risk of tooth breaking - constant finger quality even with high feed rates thanks to double number of teeth compared to standard design	extended finger joint profiles 10/11, 15/16,5 and 20/22 only for machines with cross-cutting device

10 mm + 15 mm fingers with 3.8 mm pitch	
wood width	No. of cutters
15	OR + UR
34	OR + 1 + UR
53	OR + 2 + UR
72	OR + 3 + UR
91	OR + 4 + UR
110	OR + 5 + UR
129	OR + 6 + UR
148	OR + 7 + UR
167	OR + 8 + UR
186	OR + 9 + UR
205	OR + 10 + UR
224	OR + 11 + UR
243	OR + 12 + UR
262	OR + 13 + UR
281	OR + 14 + UR
300	OR + 15 + UR
319	OR + 16 + UR

20 mm fingers with 6.2 mm pitch	
20	OR + UR
38	OR + 1 + UR
57	OR + 2 + UR
76	OR + 3 + UR
94	OR + 4 + UR
113	OR + 5 + UR
132	OR + 6 + UR
150	OR + 7 + UR
169	OR + 8 + UR
187	OR + 9 + UR
206	OR + 10 + UR
224	OR + 11 + UR
243	OR + 12 + UR
262	OR + 13 + UR
280	OR + 14 + UR
299	OR + 15 + UR
317	OR + 16 + UR

10 mm finger joint / bore d= 50 mm

Product features									Order information			
	Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax	PU	L	Order-No.
	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]	[pc.]		
UR	250	26.4	15.4	50	6	3.8	10/11	3	6000	1	C	58574676
OR	250	26.4	15.4	50	6	3.8	10/11	3	6000	1	C	58574675
MI	250	41	19	50	6	3.8	10/11	5	6000	1	C	58574661

15 mm finger joint / bore d= 50 mm

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	170	25,8	14.8	50	4	3.8	15/15	3	9000	1	C	58574666
MI	170	41	19	50	4	3.8	15/15	5	9000	1	C	58574667
UR	170	25,8	14.8	50	4	3.8	15/15	3	9000	1	C	58574668
OR	170	25,8	14.8	50	4	3.8	15/16,5	3	9000	1	C	58574669
MI	170	41	19	50	4	3.8	15/16,5	5	9000	1	C	58574670
UR	170	25,8	14.8	50	4	3.8	15/16,5	3	9000	1	C	58574671

15 mm finger joint / bore d= 60 mm

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	200	25,8	14.8	60	4	3.8	15/15	3	7000	1	C	58574680
MI	200	41	19	60	4	3.8	15/15	5	7000	1	C	58574681
UR	200	25,8	14.8	60	4	3.8	15/15	3	7000	1	C	58574682

15 mm finger joint / bore d= 70 mm

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	200	25,8	14.8	70	4	3.8	15/15	3	7000	1	C	58574683
MI	200	41	19	70	4	3.8	15/15	5	7000	1	C	58574684
UR	200	25,8	14.8	70	4	3.8	15/15	3	7000	1	C	58574685

15 mm finger joint for PUR glueing / bore d=50 mm

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	170	25,8	14.8	50	4	3.8	15/15 PU	3	8000	1	C	58578666
MI	170	41	19	50	4	3.8	15/15 PU	5	8000	1	C	58578667
UR	170	25,8	14.8	50	4	3.8	15/15 PU	3	8000	1	C	58578668

15 mm finger joint for PUR glueing / bore d= 60 mm

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	200	25,8	14.8	60	4	3.8	15/15 PU	3	7000	1	C	58578684
MI	200	41	19	60	4	3.8	15/15 PU	5	7000	1	C	58578685
UR	200	25,8	14.8	60	4	3.8	15/15 PU	3	7000	1	C	58578686

15 mm finger joint for PUR glueing / bore d= 70 mm

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	200	25,8	14.8	70	4	3.8	15/15 PU	3	7000	1	C	58578687
MI	200	41	19	70	4	3.8	15/15 PU	5	7000	1	C	58578688
UR	200	25,8	14.8	70	4	3.8	15/15 PU	3	7000	1	C	58578689

20 mm finger joint / bore d= 50 mm

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	180	27,2	16.7	50	3	6.2	20/20	2	9000	1	C	58574672
MI	180	39,6	18.6	50	3	6.2	20/20	3	9000	1	C	58574673
UR	180	27,2	16.7	50	3	6.2	20/20	2	9000	1	C	58574674

20 mm finger joint / bore d= 70 mm

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	200	27,2	16.7	70	4	6.2	20/20	2	7000	1	C	58574686
MI	200	39,6	18.6	70	4	6.2	20/20	3	7000	1	C	58574687
UR	200	27,2	16.7	70	4	6.2	20/20	2	7000	1	C	58574688

20 mm finger joint for PUR glueing / bore d= 70 mm

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	200	27,2	16.7	70	4	6.2	20/20 PU	2	7000	1	C	58578691
MI	200	39,6	18.6	70	4	6.2	20/20 PU	3	7000	1	C	58578692
UR	200	27,2	16.7	70	4	6.2	20/20 PU	2	7000	1	C	58578693

HS 198 Finger Joint Cutters "TRIATHLON" - Z=2+2 and Z=3+3

HS-tipped

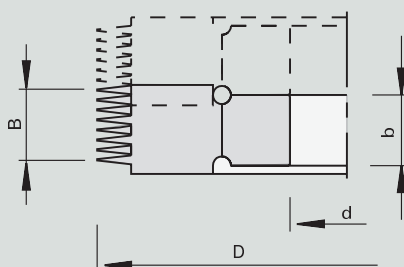
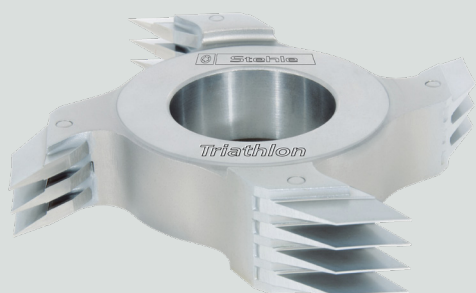
Product

Drawing

Machine

Application

Design



HS

MEC



Machine / Application

- finger joint machines
- machines with and without cross-cutting device
- for longitudinal joints in soft woods

Design

- cutting material: HS coated "TRIATHLON"

Advantages

- multiple edge lives compared to traditional HS finger joint cutters

Notes

- extended finger joint profiles 10/11, 15/16,5 and 20/22 only for machines with cross-cutting device
- no. of cutters: see table

Overview

wood width with finger length of

Number of cutters

	10 or 15 mm fingers	20 mm fingers; pitch 6.2 mm	20 mm fingers; pitch 5.0 mm	
	with B = 28.6	with B = 33	with B = 37	
	24	28	32	1
	51	59	67	2
	77	90	102	3
	104	132	137	4
	131	152	172	5
	157	183	207	6
	184	214	242	7
	210	245	277	8
	237	276	312	9
	264	307	347	10

10 mm fingers

Product features

Order information

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		PU	L	Order-No.
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		[pc.]		
160	28,6	26,6	50	2+2	3,8	10/10	7	9000		1	C	58576497
250	28,6	26,6	50	3+3	3,8	10/10	7	6000		1	C	58576519
160	28,6	26,6	50	2+2	3,8	10/11	7	9000		1	C	58576501
250	28,6	26,6	50	3+3	3,8	10/11	7	6000		1	C	58576516

15 mm fingers

Product features

Order information

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		PU	L	Order-No.
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		[pc.]		
170	28,6	26,6	50	2+2	3,8	15/15	7	9000		1	C	58576507
260	28,6	26,6	50	3+3	3,8	15/15	7	6000		1	C	58576520
170	28,6	26,6	50	2+2	3,8	15/16,5	7	9000		1	C	58576510
260	28,6	26,6	50	3+3	3,8	15/16,5	7	6000		1	C	58576521

20 mm fingers with 6.2 mm pitch

Product features

Order information

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		PU	L	Order-No.
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		[pc.]		
180	33	31	50	2+2	6,2	20/20	5	9000		1	C	58576512
180	33	31	50	2+2	6,2	20/22	5	9000		1	C	58576514

20 mm fingers with 5.0 mm pitch

Product features									Order information			
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		PU	L	Order-No.
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		[pc.]		
180	37	35	50	2+2	5.0	20/20	7	9000		1	C	58576572
180	37	35	50	2+2	5.0	20/22	7	9000		1	C	58576571

HS 196 High Performance Finger Joint Cutters “TRIATHLON” - Real Z=3, Z=4 and Z=6

Machine

Application

Design

HS

MEC

Machine / Application	Design	Advantages	Notes
- high-performance finger joint machines - machines with and without cross-cutting device - for longitudinal joints in soft woods	- real Z=3, Z=4 or Z=6 for high feed rates up to 54 m/min - cutting material: HS coated “TRIATHLON”	- multiple edge lives compared to traditional HS finger joint cutters - high bending strength - reduced risk of tooth breaking - constant finger quality even with high feed rates thanks to double number of teeth compared to standard design	extended finger joint profiles 10/11, 15/16,5 and 20/22 only for machines with cross-cutting device

10 mm + 15 mm fingers with 3.8 mm pitch	
wood width	No. of cutters
15	OR + UR
34	OR + 1 + UR
53	OR + 2 + UR
72	OR + 3 + UR
91	OR + 4 + UR
110	OR + 5 + UR
129	OR + 6 + UR
148	OR + 7 + UR
167	OR + 8 + UR
186	OR + 9 + UR
208	OR + 10 + UR

20 mm fingers with 6.2 mm pitch	
20	OR + UR
38	OR + 1 + UR
57	OR + 2 + UR
76	OR + 3 + UR
94	OR + 4 + UR
113	OR + 5 + UR
132	OR + 6 + UR
150	OR + 7 + UR
169	OR + 8 + UR
187	OR + 9 + UR
206	OR + 10 + UR
224	OR + 11 + UR
243	OR + 12 + UR
262	OR + 13 + UR
280	OR + 14 + UR

10 mm fingers

Product features									Order information			
	Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax	PU	L	Order-No.
	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]	[pc.]		
OR	250	26,4	15.4	50	6	3.8	10/11	3	6000	1	L	58576675
MI	250	41	19	50	6	3.8	10/11	5	6000	1	L	58576661
UR	250	26,4	15.4	50	6	3.8	10/11	3	6000	1	L	58576676

15 mm fingers

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	170	25,8	14.8	50	4	3.8	15/15	3	9000	1	C	58576666
MI	170	41	19	50	4	3.8	15/15	5	9000	1	C	58576667
UR	170	25,8	14.8	50	4	3.8	15/15	3	9000	1	C	58576668
OR	170	25,8	14.8	50	4	3.8	15/16,5	3	9000	1	C	58576669
MI	170	41	19	50	4	3.8	15/16,5	5	9000	1	C	58576670
UR	170	25,8	14.8	50	4	3.8	15/16,5	3	9000	1	C	58576671

20 mm fingers

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	180	27,2	16.7	50	3	6.2	20/20	2	9000	1	C	58576672
MI	180	39,6	18.6	50	3	6.2	20/20	3	9000	1	C	58576673
UR	180	27,2	16.7	50	3	6.2	20/20	2	9000	1	C	58576674

15 mm finger joint for PUR glueing

Product features									Order information			
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	170	25,8	14.8	50	4	3.8	15/15	3	9000	1	L	58577678
MI	170	41	19	50	4	3.8	15/15	5	9000	1	C	58577679
UR	170	25,8	14.8	50	4	3.8	15/15	3	9000	1	C	58577680

HS 198 Finger Joint Cutters "TRIATHLON" - Z=6+6

HS-Super tipped

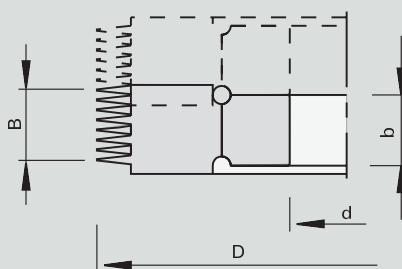
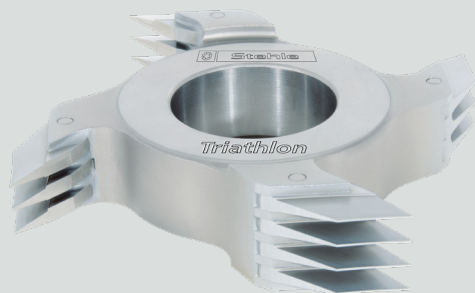
Product

Drawing

Machine

Application

Design



HS-Super

MEC



Machine / Application

- finger joint machines
- machines with cross-cutting device
- for longitudinal joints in soft woods

Design

- cutting material: HS-Super coated "TRIATHLON"

Advantages

- multiple edge lives compared to traditional HS finger joint cutters

Notes

- extended finger joint profiles 6/7 only for machines with cross-cutting device
- no. of cutters: see table

Overview

wood width with finger length of

Number of cutters

with B = 28.6	
23	1
59	2
79	3
107	4
135	5
163	6
191	7
219	8
247	9
275	10

6/7 mm finger joint

Product features

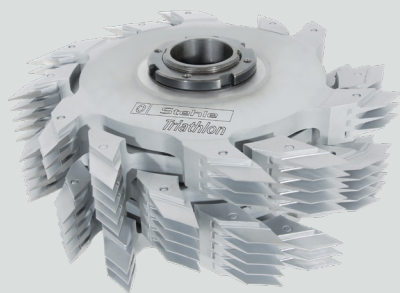
Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]		PU [pc.]	L	Order-No.
250	30	28	50	6+6	2.8	6/7	10	6000		1	S	50576700

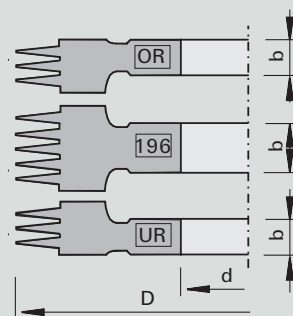
HS**196 High Performance Finger Joint Cutters “TRIATHLON” - Real Z=8**

HS-Super tipped

Product



Drawing



Machine



Application



Design

HS-Super**MEC**

Machine / Application

- high-performance finger joint machines
- machines with cross-cutting device
- for longitudinal joints in soft woods

Design

- real Z=8 for high feed rates up to 72 m/min
- cutting material: HS-Super coated “TRIATHLON”

Advantages

- multiple edge lives compared to traditional HS finger joint cutters
- high bending strength
- reduced risk of tooth breaking
- constant finger joint quality even with high feed rates thanks to double number of teeth compared to standard design

Notes

- extended finger joint profiles 6/7 for machines with cross-cutting device

10 mm + 15 mm fingers with 3.8 mm pitch

wood width	No. of cutters
17	OR + UR
36	OR + 1 + UR
56	OR + 2 + UR
75	OR + 3 + UR
95	OR + 4 + UR
115	OR + 5 + UR
134	OR + 6 + UR
154	OR + 7 + UR
173	OR + 8 + UR
192	OR + 9 + UR
211	OR + 10 + UR

6 mm finger joint

Product features

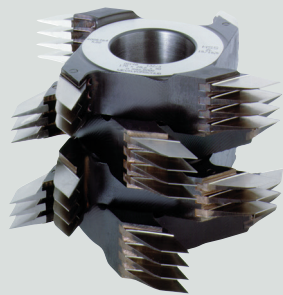
Order information

	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]	PU [pc.]	L	Order-No.
OR	250	21,6	12.2	50	8	2.8	6/7	4	6000	1	L	50577681
MI	250	38,4	19.6	50	8	2.8	6/7	7	6000	1	L	50577682
UR	250	21,6	12.2	50	8	2.8	6/7	4	6000	1	L	50577683
OR	250	21,8	11.7	50	8	2.8	4/4,5	4	6000	1	S	80425335 NEW
MI	250	41	20.8	50	8	2.8	4/4,5	7	6000	1	S	80425336 NEW
UR	250	21,8	11.7	50	8	2.8	4/4,5	4	6000	1	S	80425337 NEW

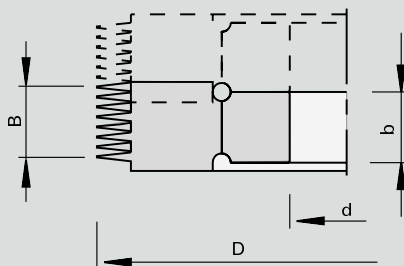
HW 198 Finger Joint Cutters - Z=2+2 and Z=3+3

HW-tipped

Product



Drawing



Machine



Application



Design



HW

MEC

Machine / Application

- finger joint machines
- machines with and without cross-cutting device
- for longitudinal joints in hard and exotic woods

Design

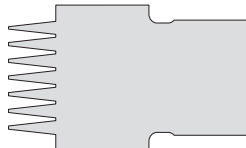
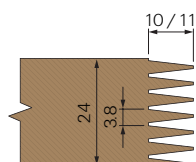
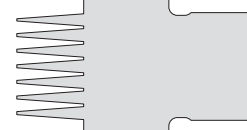
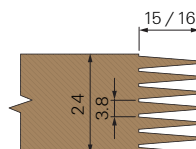
- cutting material: HW

Advantages

- multiple edge lives compared to traditional HS finger joint cutters

Notes

- extended finger joint profiles 10/11, 15/16,5 and 20/22 only for machines with cross-cutting device

**198/H 198** 160x28,6x50
(250x28,6x50)**198/H 198** 170x28,6x50
(260x28,6x50)**10 mm fingers**

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]		PU [pc.]	L	Order-No.
160	28,6	26,6	50	2+2	3,8	10/10	7	9000		1	C	58640100
250	28,6	26,6	50	3+3	3,8	10/10	7	6000		1	C	58640105
160	9,6	7,6	50	2+2	3,8	10/11	2	9000		1	C	58640121
160	13,4	11,4	50	2+2	3,8	10/11	3	9000		1	C	58640122
250	13,4	11,4	50	3+3	3,8	10/11	3	9000		1	C	58640111
160	17,2	15,2	50	2+2	3,8	10/11	4	9000		1	C	58640123
250	17,2	15,2	50	3+3	3,8	10/11	4	6000		1	C	58640110
160	21	19	50	2+2	3,8	10/11	5	9000		1	C	58640124
250	21	19	50	3+3	3,8	10/11	5	6000		1	C	58640109
160	28,6	26,6	50	2+2	3,8	10/11	7	9000		1	L	58640101
250	28,6	26,6	50	3+3	3,8	10/11	7	6000		1	C	58640106

15 mm fingers

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]		PU [pc.]	L	Order-No.
170	28,6	26,6	50	2+2	3,8	15/15	7	9000		1	C	58640102
260	28,6	26,6	50	3+3	3,8	15/15	7	6000		1	C	58640107
170	28,6	26,6	50	2+2	3,8	15/16,5	7	9000		1	C	58640103
260	28,6	26,6	50	3+3	3,8	15/16,5	7	6000		1	C	58640108

194 Edge Finger Joint Cutters

HS/HW-tipped

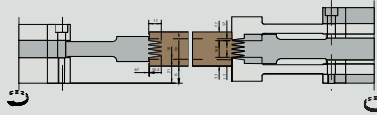
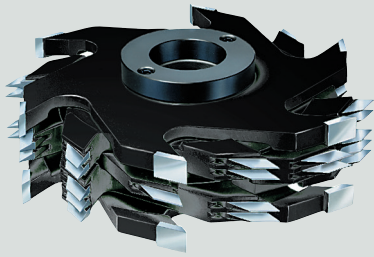
Product

Drawing

Machine

Application

Design



MEC



Machine / Application

Design

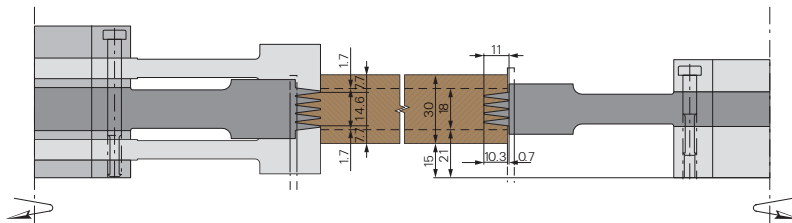
Advantages

Notes

- finger joint machines
- machines with cross-cutting device
- for longitudinal joints with close fit outside joints e.g. windows, furniture parts

- cutting material: HS-tipped for soft woods
- cutting material: HW-tipped for hard and exotic woods

- suitable for 198 finger joint cutters with finger length 10/11 mm



HS-tipped

Product features

Order information

Cutter-no.	Ø D	B	Ø d	Z	Partition	Finger joint length	nmax			PU	L	Order-No.
	[mm]	[mm]	[mm]		[mm]	[mm]	[min-1]			[pc.]		
194.1.3	250	21	50	6	3.8	10	6000	MEC		1	S	58571984

HW-tipped

Product features

Order information

Cutter-no.	Ø D [mm]	B [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	nmax [min-1]			PU [pc.]	L	Order-No.
194.1	160	21	50	4	3.8	10	6000	MEC		1	S	58671985
194.3	160	21	50	4	3.8	10	9000	MEC		1	S	58671984

HS

199 Finger Joint Cutters / Edge Finger Joint Cutters

HSS-/TC-tipped, tight-closing without gap on finger-joint edge

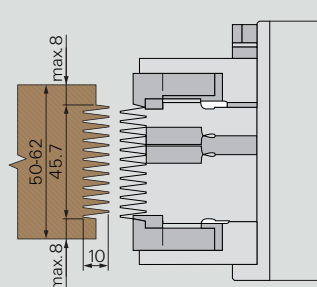
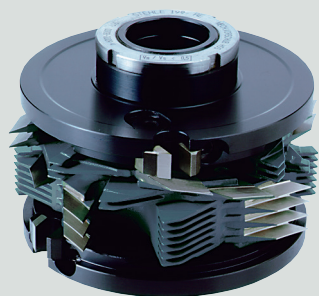
Product

Drawing

Machine

Application

Design


MAN
MEC

Machine / Application

- finger joint machines
- cutter 199 can also be applied on table shapers
- for longitudinal joints with close fit finger joint profile possible

Design

- Cutter 198 MEC
- Cutter 199 MAN
- cutting material: HS-tipped for soft woods
- cutting material: HW-tipped for hard and exotic woods

Advantages

- reduced kick-back behaviour at 199 thanks to a reflector comb located in front of the cutting edges

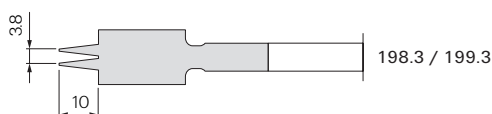
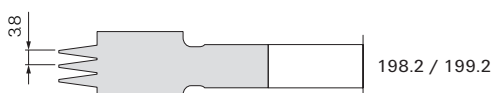
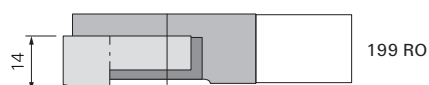
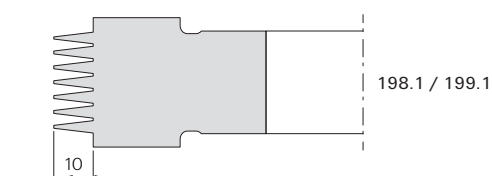
Notes

- edge finger joint cutters can be combined with 199.1 - 199.3 und 198.1 - 198.3

Overview

finger jointing width ZB	no. of cutters/type:	198/199.1	198/199.2	198/199.3	required length of bushing
7,6		-	-	1	80
11,4		-	1	-	80
15,2		-	-	2	80
19		-	1	1	80
22,8		-	2	-	80
26,6		1	-	-	80
30,4		-	2	1	112
34,2		1	-	1	112
38		1	1	-	112
41,8		1	-	2	112
45,6		1	1	1	112
49,4		1	2	-	112
57		1	2	1	130
64,6		2	1	-	130
68,4		2	-	2	130

further finger jointing widths possible



HS-tipped

Product features								Order information				
Cutter-no.	Ø D	B	Ø d	Z	Partition	Number of finger joints [pc.]	nmin-nmax			PU	L	Order-No.
	[mm]	[mm]	[mm]		[mm]		[min-1]			[pc.]		
199.1	160	28,6	50	2+2	3.8	7	6000-9000	MAN		1	C	58572530
199.2	160	13,4	50	2+2	3.8	3	6000-9000	MAN		1	C	58572531
199.3	160	9,6	50	2+2	3.8	2	6000-9000	MAN		1	C	58572532
199 RO	150	20	50	2	3.8		6000-8000	MAN		1	S	58572528
199 RU	150	20	50	2	3.8		6000-8000	MAN		1	S	58572529
198.1	160	28,6	50	2+2	3.8	7		MEC		1	C	58572535
198.2	160	13,4	50	2+2	3.8	3		MEC		1	C	58572533
198.3	160	9,6	50	2+2	3.8	2		MEC		1	C	58572534

HW-tipped

Product features								Order information				
Cutter-no.	Ø D	B	Ø d	Z	Partition	Number of finger joints [pc.]	nmin-nmax			PU	L	Order-No.
	[mm]	[mm]	[mm]		[mm]		[min-1]			[pc.]		
199.1	160	28,6	50	2+2	3.8	7	6000-9000	MAN		1	C	58640114
199.2	160	13,4	50	2+2	3.8	3	6000-9000	MAN		1	C	58640115
199.3	160	9,6	50	2+2	3.8	2	6000-9000	MAN		1	C	58640116
199 RO	150	20	50	2	3.8		6000-8000	MAN		1	S	58640210
199 RU	150	20	50	2	3.8		6000-8000	MAN		1	S	58640211
198.1	160	28,6	50	2+2	3.8	7		MEC		1	C	58640113
198.2	160	13,4	50	2+2	3.8	3		MEC		1	C	58640117
198.3	160	9,6	50	2+2	3.8	2		MEC		1	C	58640118
Spare parts			Dimension [mm]			suitable for				PU [pc.]	L	Order-No.
Inserts for edge finger joint cutters 199 RO (HS)						58572528				2	S	50572550
Inserts for edge finger joint cutters 199 RU (HS)						58572529				2	S	50572551
Adjusting screws			M8x16 DIN 6912			58572528, 58572529				10	S	50949533
Special screws			M12x1x12 SW6			58572528, 58572529				10	L	50930320

HS

195 Finger Joint Cutterheads

with exchangeable HS cutting edges

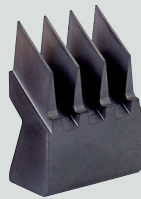
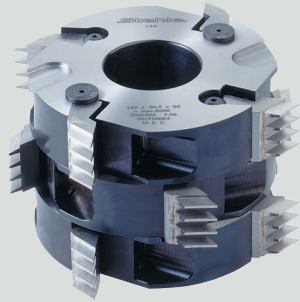
Product

Drawing

Machine

Application

Design



HS

MEC



Machine / Application

- finger joint machines
- for longitudinal joints in highly stressed components

Design

- body made from steel
- 4/6 exchangeable knives (160 mm) or 6/8 exchangeable knives (250 mm) for particularly high feedrates
- secured against twisting
- cutting material: HS or HS-TRIATHLON

Advantages

- multiple edge lives compared to conventional material, increased edge lives and higher wear resistance and gliding features thanks to TRIATHLON coating

Notes

Overview

wood width in mm	Number of cutters	wood width in mm	Number of cutters
27	1	179	6
58	2	210	7
88	3	240	8
118	4	271	9
149	5	297	10

195 Finger Joint Cutterhead Body (without knives)

Product features									Order information		
Ø D [mm]	Ø D1 [mm]	B [mm]	b [mm]	Ø d [mm]	Z	nmax [min-1]			PU [pc.]	L	Order-No.
129.8	160/170	30,4	30.4	50	2+2	8500			1	S	50571101
129.8	160/170	30,4	30.4	50	3+3	8500			1	S	50571102
216	250/260	30,4	30.4	50	2+2	6000			1	S	50571103
216	250/260	30,4	30.4	50	3+3	6000			1	S	50571104
216	250/260	30,4	30.4	50	4+4	6000			1	S	50571105

195 Finger Joint Cutting Edges HS

Knives	PU [pc.]	L	Order-No.
HS Cutting Insert 10/10	4	L	50570980
HS Cutting Insert 10/11	4	L	50570981
HS Cutting Insert 15/15	4	S	50570982
HS Cutting Insert 15/16,5	4	S	50570983
HS TRIATHLON Cutting Insert 15/15	4	S	50576997

195 Finger Joint Cutting Edges HS TRIATHLON

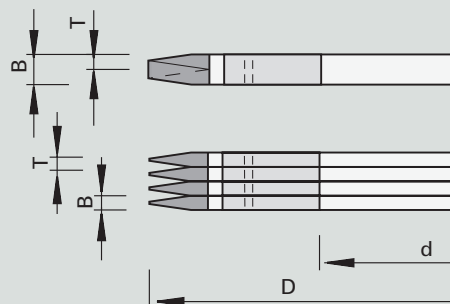
Knives				PU [pc.]	L	Order-No.
HS TRIATHLON Cutting Insert 10/10				4	S	50576991
HS TRIATHLON Cutting Insert 10/11				4	S	50576993
HS TRIATHLON Cutting Insert 15/15				4	S	50576997
HS TRIATHLON Cutting Insert 15/16,5				4	L	192187
Spare parts	Dimension [mm]			PU [pc.]	L	Order-No.
Set Screws - with hexagon socket and dog point	M8x20 DIN EN ISO 4028			10	L	001625
Screwdrivers with sliding handle for hexagon socket	SW4x100			1	L	166091

HW 200 Finger Joint Cutters / Edge Finger Joint Cutters disc-type pitch 3.8 mm

Product



Drawing



Machine



Application



Design



HW

MEC

Machine / Application

- finger joint machines
- machines with cross-cutting device
- for end grain finger jointing of hard and soft woods
- joint with or without glue gap

Design

- high-tensile steel body
- cutting material: HW

Advantages

- extremely long edge lives thanks to the special coordination of cutting material to the material to be cut and the spiral arrangement of the cutting edges

Notes

- adjustable to any wood thickness with bushing
- Edge jointing cutters without easyFix and Fibonacci markings

Finger Joint Cutters

Product features

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]		PU [pc.]	L	Order-No.
160	3,8	3,8	70	4	3,8	10/11	4	11800		1	S	58640178
250	3,8	3,8	70	6	3,8	10/11	6	7400		1	L	58640173

Order information

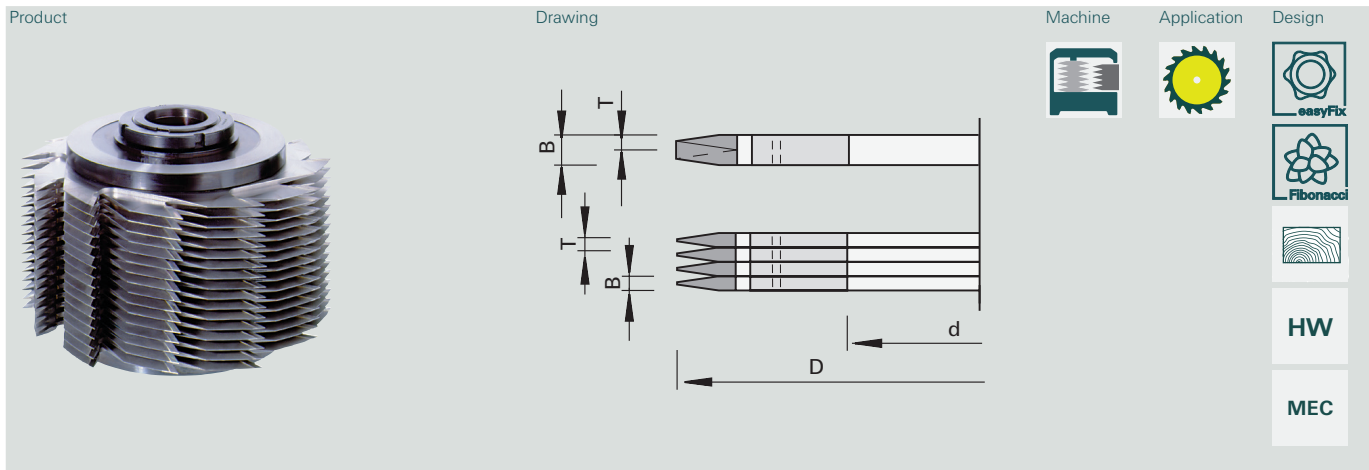
Edge finger Joint Cutter

Product features

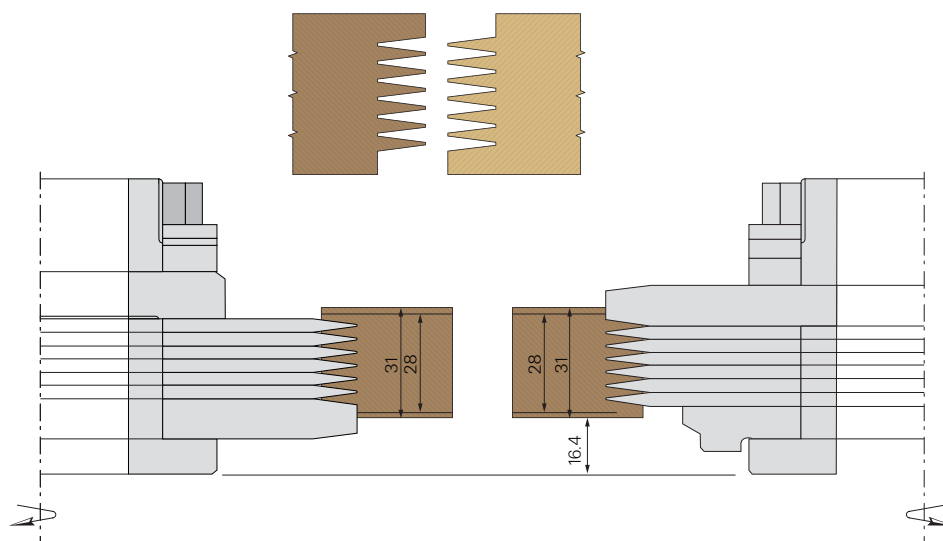
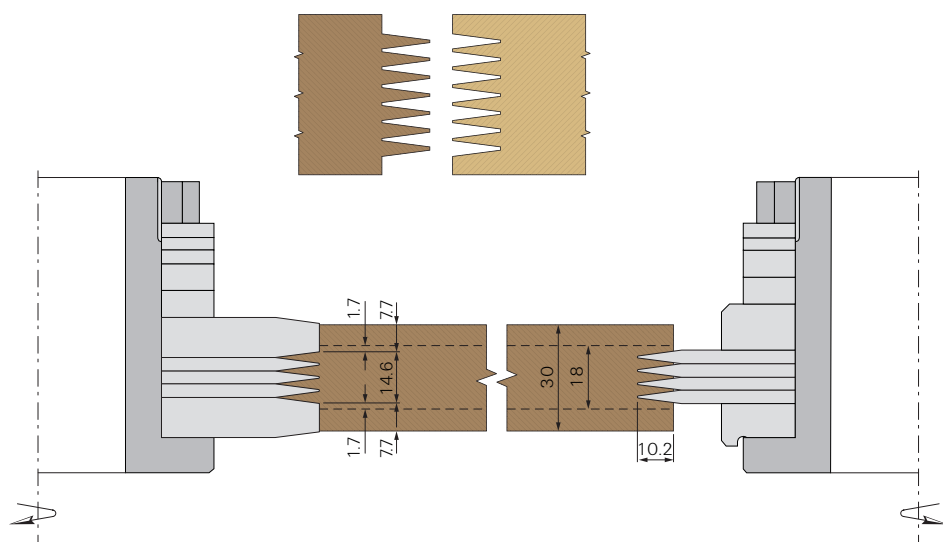
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Partition [mm]	Finger joint length [mm]	Number of finger joints [pc.]	nmax [min-1]		PU [pc.]	L	Order-No.
160	11,2	11,4	70	4	3,8	10		11800		1	L	80478293
160	15,2	15,2	70	4	3,8	10/11	4	11800		1	S	58640185
239	11,2	11,4	70	6	3,8	10		7900		1	L	80478289
249,5	11,4	15,2	70	6	3,8	10/11	6	7400		1	L	58640184
250	11,2	11,4	70	6	3,8	10		7400		1	L	80478292

Order information

HW 200 Finger Joint Cutters / Edge Finger Joint Cutters disc-type pitch 3.8 mm



Machine / Application	Design	Advantages	Notes
- finger joint machines - machines with cross-cutting device - for end grain finger jointing of hard and soft woods - joint with or without glue gap	- high-tensile steel body - cutting material: HW	extremely long edge lives thanks to the special coordination of cutting material to the material to be cut and the spiral arrangement of the cutting edges	- adjustable to any wood thickness with bushing - Edge jointing cutters without easyFix and Fibonacci markings

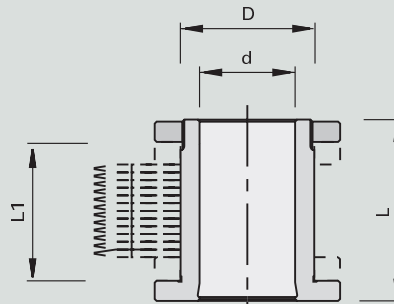


Bushings for Finger Joint Cutters

Product



Drawing



Machine

Application

Design

Machine / Application

- for clamping of finger joint cutters and edge finger joint cutters

Design

- high-tensile steel body
- spacers Ø 97 mm for cutters Ø 160-210 mm (not required)

Advantages

- high concentric and runout accuracy
- for varying wood thicknesses

Notes

- fill intermediate sizes with spacers
- for cutter Ø 250 mm install at least one spacer Ø 177 on top and bottom
- fastening nut or hydraulic clamping for cutter attachment must be ordered separately
- for cutter sets over 100 mm height we recommend hydraulic clamping
- the bushing length depends on the wood height "H" and on the type of nut
- accessories: mounting device, mounting ring and wrench is imperative for self-resharpening

Product features

Order information

Ø D [mm]	Ø d [mm]	L [mm]	L1 [mm]							PU [pc.]	L	Order-No.
70	50	90	57							1	L	178188
70	50	120	87							1	L	181035
70	50	130	97							1	L	178171
70	50	195	162							1	L	178172
70	50	220	187							1	C	178173
70	50	240	207							1	C	178174
Spacer Rings				Ø D [mm]	B [mm]	Ø d [mm]				PU [pc.]	L	Order-No.
				100	7,6	70				1	L	180940
				100	11,4	70				1	L	180941
				175	7,6	70				1	S	186163
				175	11,4	70				1	L	181034
Spare parts				Dimension [mm]						PU [pc.]	L	Order-No.
Mounting Devices										1	L	177103
Pin-type face wrenches										1	L	177102
Fastening Nut				M68x1,5x14						1	L	177104
Hydraulic Clamping Nuts				M68x1,5x56						1	C	178787
Screwdrivers				SW4x100						1	L	166091

Saw Hogs HW for finger jointing lines without bushing

Product	Drawing	Machine	Application	Design
				3-0-1 HW TC06 HW MEC ES

Machine / Application	Design	Advantages	Notes
- finger joint machines - for chip-free cross-cutting of solid woods		- clean, chip-free cuts and long edge lives thanks to special cutting geometry - precise fit for finger joints - Low noise level	- included in delivery: hogger saw blade, flange, screws and screwdrivers (not mounted); sleeve not included in delivery - sense of rotation according to VDMA 8849

Product features										Order information				
Ø D [mm]	B [mm]	b [mm]	L1 [mm]	Ø d [mm]	Z	DKN [mm]				PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
250	8,0	44	59	80	60	12x3,3	Grecon			1	O	182379	O	182378
Spare parts			Dimension [mm]							PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
Hogging Saw Blades			Ø250x8,0/6,1xØ80 Z60							1	L	189223	L	189222
Flanges			Ø210x8,4xØ80							1			L	182377
Countersunk Screws			M8x20 DIN 7991-8.8							10			L	056378
Countersunk Screws			M5x12 T20 D=Ø9,3							10			L	166709
Screwdrivers			T20x100							1			L	166092
Bushings for Grecon			Ø113x59x40DKN							1			L	189100
Bushings for NKT			Ø206x100,3x38 DKN							1			L	178294
Hogging Saw Blades			Ø250x6,3/5xØ75 Z80							1	L	189033	L	189032

Saw Hogs HW mounted on bushing for finger jointing lines

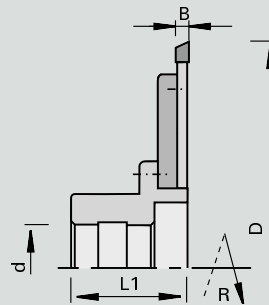
Product

Drawing

Machine

Application

Design



3-0-1

HW
TC05

HW

MEC

ES

Machine / Application

Design

Advantages

Notes

- finger joint machines
- for chip-free cross-cutting of solid woods

- clean, chip-free cuts and long edge lives thanks to special cutting geometry
- precise fit for finger joints
- Low noise level

- sense of rotation acc. to VDMA 8849

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	L1 [mm]	Ø d [mm]	Z	DKN [mm]				PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
250	8,0	44	59	40	60	12x3,3	Grecon			1	O	182599	O	182600
350	10	44	59	40	60+12	12x3,3	Grecon			1	O	182611	O	182612
Spare parts		Dimension [mm]								PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
Hogging Saw Blades		Ø250x8,0/6,1xØ80 Z60								1	L	189223	L	189222
Flanges		Ø210x8,4xØ80								1			L	182377
Countersunk Screws		M8x20 DIN 7991-8.8								10			L	056378
Countersunk Screws		M5x12 T20 D=Ø9,3								10			L	166709
Screwdrivers		T20x100								1			L	166092
Bushings for Grecon		Ø113x59x40DKN								1			L	189100
Hogging Saw Blades		Ø350x10,0xØ80 Z60+12								1	L	189247	L	189246
Hogging Saw Blades		Ø350x10,0xØ80 Z60+12								1	L	189246	L	189247
Hogging Saw Blades		Ø250x6,3/5xØ75 Z80								1	L	189033	L	189032

HW Scoring Saw Blades for finger joint machines

Scoring Saw Blades HW - ATB

Product	Drawing	Machine	Application	Design
				3-0-1 HW TC06 WS

Machine / Application	Design	Advantages	Notes
- finger jointing lines Grecon - for scoring of solid woods	6 countersunk pin holes on both sides each - for left and right hand rotation - tooth configuration: alternate top bevel "WS" - cutting material: HW TC06		along and across the grain, from below

Product features								Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	Hook angle [°]	NL		PU [pc.]	L	Order-No.
200	7,0	4,0	75	48	▲▲▲	10	2x6/6,5/95	Grecon	1		189539

HW Scoring Saw Blades for finger joint machines

Scoring Saw Blades HW - top bevel

Product	Drawing	Machine	Application	Design
				3-0-1 HW TC06 ES

Machine / Application	Design	Advantages	Notes
- finger jointing lines Grecon Combipact - for scoring of solid woods	- tooth configuration: top bevel "ES (right + left)" - cutting material: HW TC06		- along and across the grain, from above and below - sense of rotation see drawing

Product features								Order information						
Ø D	B	b	Ø d	Z	Cutting quality*	Hook angle	NL			PU	L	Order-No. [L]	L	Order-No. [R]
[mm]	[mm]	[mm]	[mm]			[°]				[pc.]				
200	5,1	3.5	75	48	▲▲▲	10	6/7/95	Grecon-Compipact		1	L	188948	L	188947
200	4,7	3.4	75	64	▲▲▲▲	10	6/6,6/95	Grecon HS 120		1	L	189035	L	189034
200	6,0	4.0	75	48	▲▲▲	10	6/6,5/95	Grecon		1			L	189540

Scoring Saw Blade Set - for finger joint machines

Scoring Saw Blade Set HW "ES" - for finger joint machines

Product

Drawing

Machine

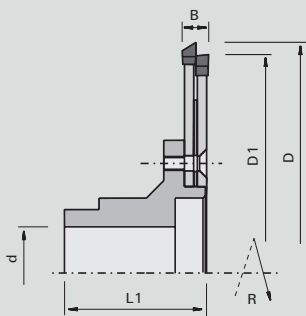
Application

Design



HW
TC06

ES



Machine / Application

- finger jointing lines Grecon Ultra / Profi Joint
- for scoring of solid woods

Design

- tooth configuration: top bevel "ES" (right + left)"
- cutting material: HW TC06

Advantages

Notes

- along and across the grain, from below sense of rotation according to VDMA 8849

Product features

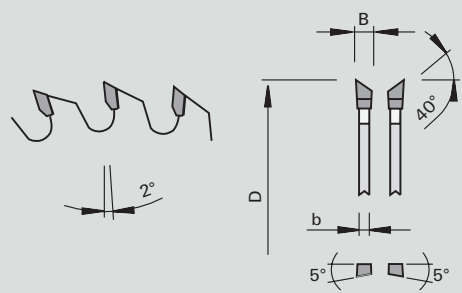
Order information

Ø D [mm]	b [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	Hook angle [°]	NL			PU [pc.]	L	Order-No. [L]
200	43		40	48+48	▲▲▲			Grecon Ultra / Profi Joint		1	O	189536

HW

OKW

Optimizing Chop Saw Blades HW - alternate top bevel / shear angle

Product	Drawing	Machine	Application	Design
		 		3-0-1  HW TC06 WSA

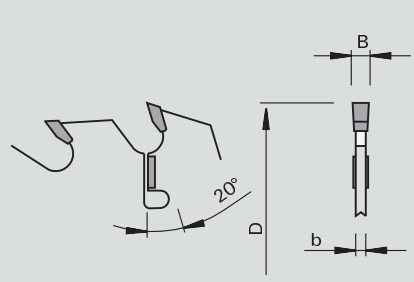
Machine / Application	Design	Advantages	Notes
- optimizing chop saws - undertable cross-cut saws - push-feed saws - through-feed saws - for cross cuts in solid woods	- positive hook angle - tooth configuration: alternate top bevel with shear angle "WSA" - cutting material: HW TC 06 - extremely high bending strength and hardness of the teeth	reduced cutting pressure thanks to alternating shear angle long edge lives provide for the necessary productivity and economic efficiency	other dimensions on request

Product features								Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
400	3,4	2,8	30	120	▲▲▲	2/10/60 + 2/12/90 + 2/12/150	2		1	L	58807839
400	4,6	3,5	30	120	▲▲▲	2/10/60	2		1	L	189833
450	4,6	3,5	30	132	▲▲▲	2/15/63	2		1	L	189834
500	4,6	3,5	30	144	▲▲▲	2/15/63	2		1	L	58807842

HW

LWR

Gang-Rip Saw Blades HW with HW-rakers - flat tooth

Product	Drawing	Machine	Application	Design
		  		3-0-1 HW TC20 F

Machine / Application	Design	Advantages	Notes
- gang-rip saws with one or two shafts - for longitudinal cuts in wet and dry soft woods	- tooth configuration: flat "F" - cutting material: HW TC20	tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate	for cutting height > 50 mm

Product features								Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	Max. flange Ø [mm]	Hook angle [°]		PU [pc.]	L	Order-No.
250	3,2	2,2	70	20	▲	120			1	L	50457841
300	3,4	2,2	70	22	▲	130			1	L	50100525
350	3,6	2,5	70	20	▲	140			1	L	50100528
350	3,6	2,4	70	28	▲	140			1	L	50457843
450	4,2	3,0	50	24	▲	160	20		1	L	189273

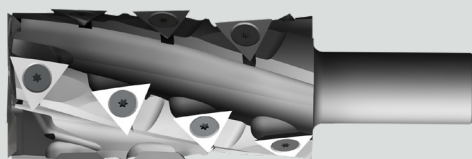
* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 + 2/7/42 Combi2 matches 2/7/42 + 2/9/46 + 2/10/60 Combi3 matches 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 Combi5 matches 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 Combi7 matches 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

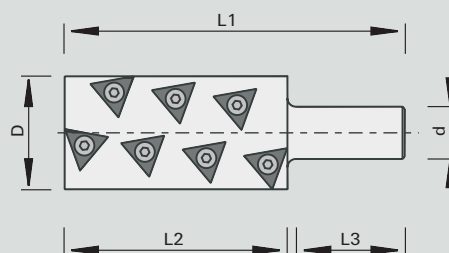
For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW 3520 Shank-Type Cutters with HW Turnover Knives - t3-System

Product



Drawing



Machine



Application



Design

MEC

Machine / Application

- CNC and joinery machines
- For offset- and chip-free jointing, rabbeting and sizing of solid wood

Design

- Rounded triangular turnover knives with cutting edges drawing from bottom to top and from top to bottom

Advantages

- absolutely chip-free jointing and rabbeting
- Thanks to the rounded turnover knives the machined surface is offset-free
- excellent edge and surface quality
- very high milling performance
- spiral plunge-cutting for free form milling
- Triangular turnover knives with rounded edges 3 edge lives

Notes

- spiral plunge-cutting, pockets larger than Ø 60
- feed rate per tooth $f_z = 0.2 - 0.5$ mm

Product features

Order information

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z	Number of cutting edges [pc.]		PU [pc.]	L	Order-No.
54	63	25	52	120	2+2	12		1	L	58187299
54	78	25	52	133.5	2+2	14		1	L	58187300
54	106,5	25	52	162.5	2+2	18		1	L	58187113

Turnover Knives

			B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
			20,88	18.3	3.0	TCw20		10	L	187251
			20,88	18.3	3.0	TC06		10	L	187692
			20,88	18.3	3.0	HL Solid 20 topcoat		10	L	187694
			20,38	17.9	3.0	TCw20		10	L	9209773

Accessories

Dimension [mm]

	Dimension [mm]		PU [pc.]	L	Order-No.
Screwdrivers	T15x80		1	L	171188
Countersunk Screws	M5x9 T15		10	L	80492032

Clamping System

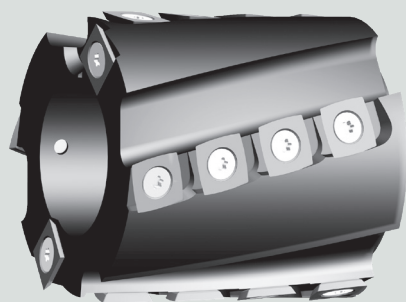
Order information

Ø d1 [mm]	Ø d [mm]	L2 [mm]	Ø D [mm]	L1 [mm]	a [mm]	x [mm]			PU [pc.]	L	Order-No.
25	HSK 63F	57	52.5	109	84	18			1	L	184309
25	HSK 63F	55	35	100	75	18			1	L	180710
25	HSK 63F	51	30	100	75	18			1	L	183087

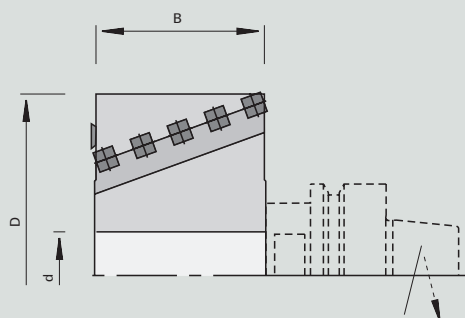
HW 5575 Spiral Cutterheads

with HW turnover knife

Product



Drawing



Machine



Application



Design



HW
TCw25

MEC

Machine / Application

- stationary milling centers
- for dressing, rough-planing, jointing, rabbeting, copying of solid woods and laminated timber

Design

- with four-sided turnover knives, with rounded edges
- 2 front spurs HW
- spiral cutting layout of turnover knives and cut division
- high-tensile aluminum body

Advantages

- easy hogging, low cutting pressure and low noise level
- high hogging volume

Notes

- for HSK mounting arbors with double key without spacer
- for Ident-No. 58665105 clamping length 50 mm with HSK63 mounting arbor 183748 + screw 173592
- for Ident-No. 58665106 clamping length 80 mm with HSK63 mounting arbor 183749 + screw 173592

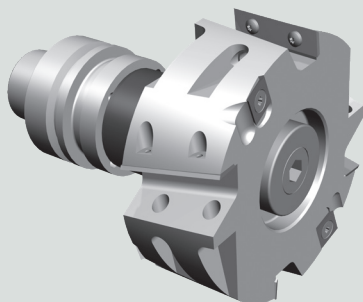
Product features

Ø D [mm]	B [mm]	Ø d [mm]	Z	nmax [min-1]						PU [pc.]	L	Order-No.
80	80	30	2+2+v2	18000						1	L	58665105
80	100	30	2+2+v2	18000						1	L	58665106
Turnover Knives					B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Spurs					14	14	2.0	TCw30		10	L	003079
Turnover Knives (with rounded edges R=50 mm)					15	15	2.5	TCw20		10	L	180454
Accessories			Dimension [mm]							PU [pc.]	L	Order-No.
Mounting arbors with HSK shank			Ø30x50xHSK 63F							1	L	183748
Mounting arbors with HSK shank			Ø30x80xHSK 63F							1	L	183749
Spare parts			Dimension [mm]							PU [pc.]	L	Order-No.
Countersunk Screws with collar 6 mm			M5x15,5 T20 D=Ø8,5							10	L	182112
Screwdrivers			T20x100							1	L	166092
Countersunk Screws			M5x6 T20 D=Ø9,3							10	L	176199

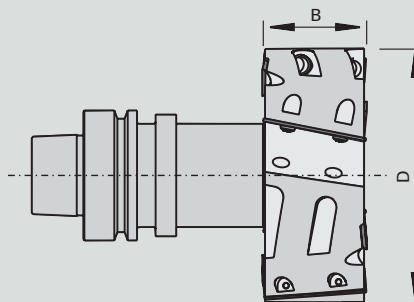
HW 5576 Jointing and rabbeting cutterheads

mounted on mounting arbor HSK63F

Product



Drawing



Machine



Application



Design



HW
TC06

MEC

Machine / Application

- CNC milling machines
- for chip-free grooving and rabbeting in solid wood and wood-based materials
- for laminated, uncoated and glued solid wood and strongly wearing wood

Design

- with alternating shear angles for pulling cut
- cutting material: HW TC06
- Body made of high-tensile aluminum
- with 2 upper and 2 lower spurs each

Advantages

- optimum cutting quality

Notes

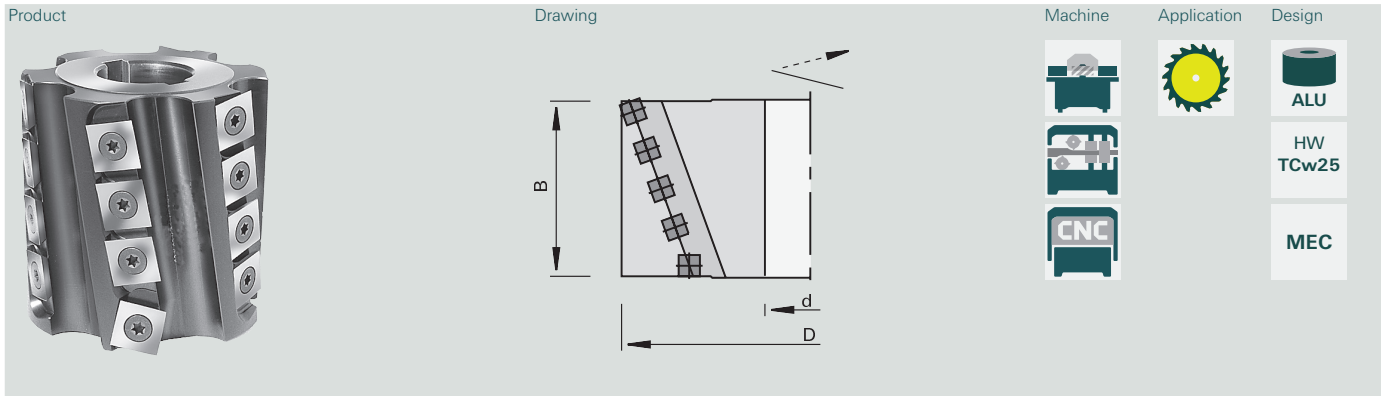
- mounted on mounting arbor HSK63F including spacer

Product features

Order information

Ø D [mm]	B [mm]	Ø d [mm]	Z	DKN [mm]	nmin-nmax [min-1]					PU [pc.]	L	Order-No. [L]
125	50	30	2+2 V2+2	8x3,3	10600					1	L	58665108
Turnover Knives					B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Spurs					14	14	2.0	TCw30		10	L	003079
Spare parts			Dimension [mm]							PU [pc.]	L	Order-No.
Screwdrivers			T20x100							1	L	166092
Screwdrivers			T15x80							1	L	171188
Spare parts			Dimension [mm]							PU [pc.]	L	Order-No.
5576 Jointing and rabbeting cutterhead			125x50x30 Z2+2 V2+2 DKN8x3							1	S	58665107
Mounting arbors with HSK shank			Ø30x80xHSK 63F							1	L	183749
Countersunk Screws			M5x6 T20 D=Ø9,3							10	L	176199
Round Head Screws			M3,5x12 T15							10	L	171067

HW 5570 Spiral Cutterheads with HW turnover knife



Machine / Application	Design	Advantages	Notes
• molders • stationary milling centers • for milling, rough-planing and finish-planing in solid woods	• with four-sided turnover knives, with rounded edges • spiral cutting layout of turnover knives and cut division • high-tensile aluminum body	• easy hogging, low cutting pressure and low noise level	• For finish cut • Other dimensions on request • 180454 R=50 mm for Cutterheads < 2022 • 187323 R=150 mm for Cutterheads > 2023 • HSK mounting arbor (183748 + screw 173592) • HSK mounting arbor (183749 + screw 173592)

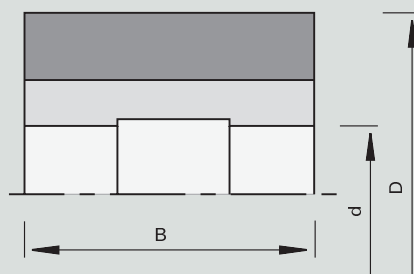
Product features										Order information		
Ø D [mm]	B [mm]	Ø d [mm]	Z	nmax [min-1]						PU [pc.]	L	Order-No.
125	100	40	2+2	12000						1	S	50665050
125	130	40	2+2	12000						1	S	50665101
125	170	40	2+2	12000						1	S	50665102
125	230	40	2+2	12000						1	S	50665103
125	240	40	2+2	12000						1	S	50665104
Turnover Knives					B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Turnover Knives (with rounded edges R=50 mm)					15	15	2.5	TCw20		10	L	180454
Turnover knives with rounded edges (rounded R=150 mm)					15	15	2.5	TCw20		10	L	187323
Spare parts			Dimension [mm]							PU [pc.]	L	Order-No.
Screwdrivers			T20x100							1	L	166092
Countersunk Screws with collar 6 mm			M5x13 T20							10	L	80306012
Countersunk Screws with collar 6 mm			M5x15,5 T20 D=Ø8,5							10	L	182112

HS 556-1 Planing Cutterheads

Product



Drawing



Machine



Application



Design



HS

HW

MEC

Machine / Application

- multi spindle planing machines
- for planing of solid woods

Design

- n max = 9,000 min-1

Advantages

Notes

- tipped with HS knives (18%) 30x3 mm
- alternative cutting material: ST for soft and hard woods; HW for hard and exotic woods

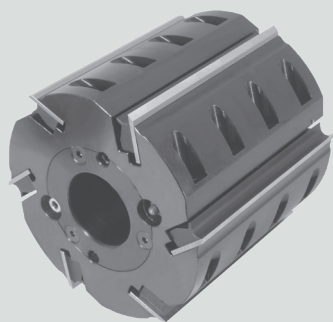
Product features

Order information

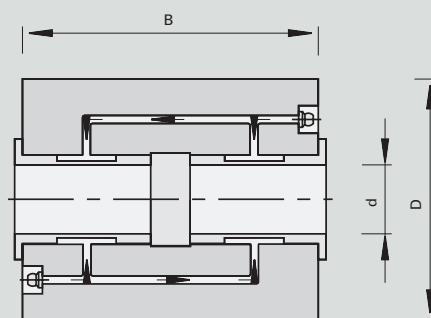
Ø D [mm]	B [mm]	Ø d [mm]	Z							PU [pc.]	L	Order-No.
125	80	40	4							1	S	50561046
125	100	40	4							1	S	50561038
125	130	40	4							1	S	50561035
125	150	40	4							1	S	50561036
125	180	40	4							1	S	50561037
125	240	40	4							1	S	50561054
Spare parts			Dimension [mm]							PU [pc.]	L	Order-No.
Pressure Bars			B=80							2	S	179205
Pressure Bars			B=100							2	S	181191
Pressure Bars			B=130							2	S	179198
Pressure Bars			B=150							2	S	179199
Pressure Bars			B=180							2	S	179200
Clamping Bars			B=240							2	S	50562677
Set Screws			M10x25 DIN EN ISO 4028							10	L	168108
Cranked Wrench Keys			SW5 DIN ISO 2936							1	L	009674

HS 520-1 Hydro Planing Cutterheads

Product



Drawing



Machine



Application



Design



HS

MEC

Machine / Application

- hydro profile molders
- for planing of solid woods

Design

Advantages

- high concentric accuracy and precise tool balancing thanks to Hydro clamping (system Weinig) for precise concentricity tolerance
- high feed rates and optimum cutting quality

Notes

- HS-tipped knives 30 x 3 mm
- alternative cutting material: ST for soft and hard woods; HW for hard and exotic woods
- peripheral application of pressure on request

Product features

Order information

Ø D [mm]	B [mm]	Ø d [mm]	Z	nmax [min ⁻¹]	PU [pc.]	L	Order-No.
143	60	40	4	8500	1	S	58562686
143	130	40	4	8500	1	S	58562689
143	230	40	4	8500	1	S	58562990
163	60	50	4	6000	1	S	58562687
163	100	50	4	6000	1	S	58562691
163	130	50	4	6000	1	S	58562741
163	130	50	4	6000	1	S	58562693
163	180	50	4	6000	1	S	58562700
163	230	50	4	6000	1	S	58562695
163	260	50	4	6000	1	S	58562697
163	310	50	4	6000	1	S	58562701
163	60	50	6	6000	1	S	58562688
163	100	50	6	6000	1	S	58562692
163	130	50	6	6000	1	S	58562742
163	150	50	6	6000	1	S	58562694
163	180	50	6	6000	1	S	58562702
163	230	50	6	6000	1	S	58562696
163	260	50	6	6000	1	S	58562698
163	310	50	6	6000	1	S	58562703
163	60	50	8	6000	1	S	58562738
163	100	50	8	6000	1	S	58562740
163	130	50	8	6000	1	S	58562739
163	150	50	8	6000	1	S	58562743
163	180	50	8	6000	1	S	58562750
163	230	50	8	6000	1	S	58562744
163	260	50	8	6000	1	S	58562745
163	310	50	8	6000	1	S	58562751
203	100	50	12	6000	1	S	58562752
203	150	50	12	6000	1	S	58562753
203	230	50	12	6000	1	S	58562754
203	260	50	12	6000	1	S	58562755
203	310	50	12	6000	1	S	58562756
203	330	50	12	6000	1	S	58562757

Spare parts

Dimension
[mm]PU
[pc.]

L

Order-No.

Set Screws M12x25 DIN EN ISO 4028 10 L 181466

Screwdrivers SW6x200 1 L 167817

Grease presses 1 L 163706

Grease Cartridges 1 L 163707

HS 569 Planing Knives HS - Plus

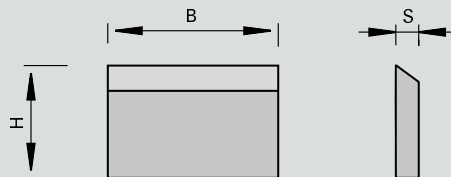
Product

Drawing

Machine

Application

Design



3-0-1

HS
18 %

Machine / Application

- for use in planing cutterheads
- also suitable for thermoplastic such as PE, PP, PVC

Design

- cutting material: high speed steel
- for the machining of soft woods
- wedge angle 40°

Advantages

- HSPlus quality for long edge lives

Notes

- for safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other
- packing unit 2 pieces

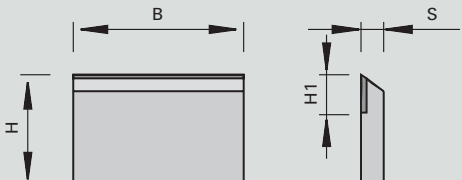
Product features

Order information

B [mm]	H [mm]	S [mm]								PU [pc.]	L	Order-No.
60	30	3								2	S	58400131
80	30	3								2	S	58400132
100	30	3								2	S	58400133
120	30	3								2	S	58400134
130	30	3								2	L	58400135
150	30	3								2	S	58400136
160	30	3								2	S	58400137
170	30	3								2	S	58400161
180	30	3								2	S	58400138
180	35	3								2	S	58400201
210	30	3								2	S	58400162
230	30	3								2	L	58400139
240	30	3								2	S	58400206
300	30	3								2	S	58400140
300	35	3								2	S	58400202
310	30	3								2	L	58400147
310	35	3								2	S	58400187
320	30	3								2	S	58400205
330	30	3								2	S	58400141
350	30	3								2	L	58400198
350	35	3								2	S	58400188
400	30	3								2	S	58400170
400	35	3								2	S	58400171
410	30	3								2	L	58400149
410	35	3								2	S	58400158
420	30	3								2	S	58400142
420	35	3								2	S	58400190
450	30	3								2	S	58400150
460	30	3								2	S	58400151
460	35	3								2	S	58400192
500	30	3								2	L	58400143
500	35	3								2	S	58400196
510	30	3								2	L	58400152
510	35	3								2	L	58400159
520	30	3								2	L	58400184
530	30	3								2	S	58400144
530	35	3								2	L	58400166
600	30	3								2	S	58400165
600	35	3								2	S	58400193
610	30	3								2	L	58400153
610	35	3								2	L	58400160
630	30	3								2	L	58400145

Product features										Order information		
B [mm]	H [mm]	S [mm]								PU [pc.]	L	Order-No.
630	35	3								2	L	58400194
635	35	3								2	S	58400195
640	30	3								2	L	58400154
640	35	3								2	L	58400167
710	30	3								2	S	58400155
710	35	3								2	S	58400179
810	30	3								2	S	58400156
810	35	3								2	S	58400164
840	30	3								2	S	58400157
1000	30	3								2	S	58400185
1000	35	3								2	S	58400168
1040	25	3								2	S	58400183
1050	30	3								2	S	58400174
1050	35	3								2	S	58400175

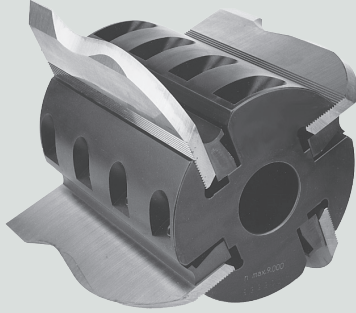
HW 569 Planing Knives HW

Product	Drawing	Machine	Application	Design
				  HW
Machine / Application	Design	Advantages	Notes	
• for use in planing cutterheads	• cutting material: HW-tipped for hard woods		• packing unit: 2 pieces	

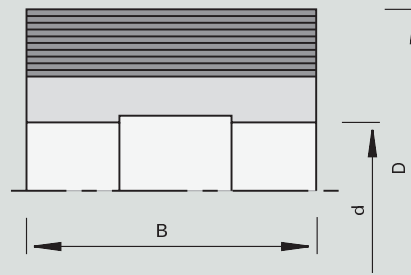
Product features										Order information		
B [mm]	H [mm]	S [mm]	H1 [mm]							PU [pc.]	L	Order-No.
60	30	3.0	11							2	S	50400021
100	30	3.0	11							2	S	50400023
120	30	3.0	11							2	S	50400024
130	30	3.0	11							2	S	50400025
150	30	3.0	11							2	S	50400026
160	30	3.0	11							2	S	50400036
170	30	3.0	11							2	S	50400027
180	30	3.0	11							2	S	50400028
210	30	3.0	11							2	S	50400029
230	30	3.0	11							2	S	50400030
260	30	3.0	11							2	S	50400031
310	30	3.0	11							2	S	50400032
310	35	3.0	11							2	S	50400073
400	35	3.0	11							2	S	50400077
410	30	3.0	11							2	S	50400033
410	35	3.0	11							2	S	50400074
460	30	3.0	11							2	S	50400078
500	30	3.0	11							2	S	50400079
510	30	3.0	11							2	S	50400034
510	35	3.0	11							2	S	50400075
600	30	3.0	11							2	S	50400080
610	30	3.0	11							2	S	50400035
640	30	3.0	11							2	O	50400083
810	30	3.0	11							2	S	50400063

HS 525 Profile Cutterheads

Product



Drawing



Machine



Application



Design



STAHL

HS

MEC

Machine / Application

- molders
- for profiling of solid woods

Design

- hook angle 25 degrees

Advantages

- high profile accuracy and surface quality thanks to knives sharpened in the cutterhead

Notes

- fixed-shape knife clamping by highly precise serration 60 degrees, partition 1.6mm
- adjustable knives
- profile depth and cutting circle diameter see table
- for back-serrated blanks
S = 5, 8, 10 mm
- included in delivery: cutterhead with clamping bar

Product features

Order information

Ø D [mm]	B [mm]	Ø d [mm]	Z							PU [pc.]	L	Order-No.
122	40	40	4							1	S	50822780
122	60	40	4							1	S	50822781
122	80	40	4							1	S	50822782
122	100	40	4							1	S	50822783
122	130	40	4							1	S	50822784
122	150	40	4							1	S	50822785
122	180	40	4							1	S	50822786
122	230	40	4							1	S	50822787
137	60	50	4							1	S	50822790
137	80	50	4							1	S	50822791
137	100	50	4							1	S	50822792
137	130	50	4							1	S	50822793
137	150	50	4							1	S	50822794
137	180	50	4							1	S	50822795
137	230	50	4							1	S	50822798

Spare parts	Dimension [mm]				PU [pc.]	L	Order-No.
Pressure Bars	B=40				2	S	179221
Pressure Bars	B=180				2	S	179227
Pressure Bars	B=150				2	S	179226
Pressure Bars	B=100				2	S	179224
Pressure Bars	B=80				2	S	179223
Pressure Bars	B=60				2	S	179222
Pressure Bars	B=230				2	S	179228
Pressure Bars	B=130				2	S	179225
Dummy Pieces	40x20x8				2	S	179229
Dummy Pieces	180x20x8				2	S	179235
Dummy Pieces	150x20x8				2	S	179234
Dummy Pieces	100x20x8				2	S	179232
Dummy Pieces	80x20x8				2	S	179231
Dummy Pieces	60x20x8				2	S	179230
Dummy Pieces	230x20x8				2	S	179236
Dummy Pieces	130x20x8				2	S	179233
Screwdrivers	SW5x150				1	L	168703
Set Screws	M10x20 DIN EN ISO 4028				10	L	815807

Maximum cutting circle diameter

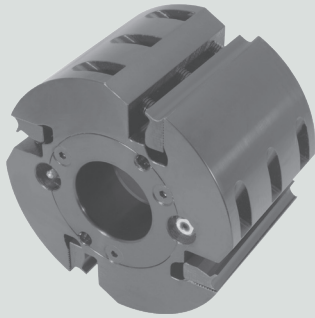
	HS	HW	ST	HS	HW	HS	ST
Knife height H [mm]	50	50	55	60	60	70	70
Knife thickness S [mm]	8	10	10	8	10	8	10
Profile depth T [mm]	12	10	15	20	18	30	27
Dmax at D=122	161	161	171	181	181	201	201
Dmax at D=137	176	176	186	196	196	216	216

Maximum RPM

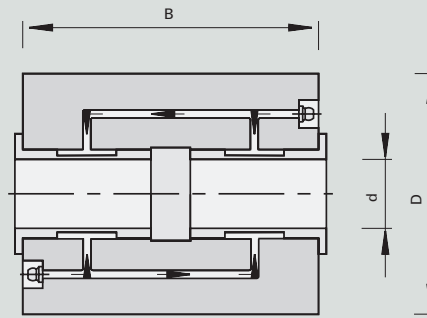
Knife height H [mm]	50	55	60	70			
Dmax at D=122	161	171	181	201			
Max.RPM (min-1):	9000	8400	8000	7200			
Dmax at D=137	176	186	196	216			
Max.RPM (min-1):	8200	7700	7300	6600			

HS 521-1 Hydro Profile Cutterheads

Product



Drawing



Machine



Application



Design



HS

MEC

Machine / Application

- hydro profile molders
- for profiling of solid woods

Design

- body made from steel

Advantages

- best cutting quality without knife marks at high feed rates
- precise concentricity tolerance (system Weinig) thanks to dual-chamber Hydro clamping
- high concentric accuracy and low operating vibration
- tight clamping thanks to precise serration (60 degrees, 1.6 mm pitch)

Notes

- adjustable knives
- profile depth and cutting circle diameter see table
- for back-serrated blanks S = 5, 8, 10 mm
- included in delivery: cutterhead with clamping bar

Product features

Order information

Ø D [mm]	B [mm]	Ø d [mm]	Z							PU [pc.]	L	Order-No.
137	60	40	4							1	S	58562920
137	100	40	4							1	S	58562921
137	130	40	4							1	S	58562922
137	150	40	4							1	S	58562923
137	180	40	4							1	S	58562924
137	230	40	4							1	S	58562925
150	60	50	4							1	S	58562926
150	60	50	6							1	S	58562934
150	100	50	4							1	S	58562927
150	100	50	6							1	S	58562935
150	130	50	4							1	S	58562928
150	130	50	6							1	S	58562936
150	150	50	4							1	S	58562929
150	150	50	6							1	S	58562937
150	180	50	4							1	S	58562930
150	180	50	6							1	S	58562938
150	230	50	4							1	S	58562931
150	230	50	6							1	S	58562939
150	260	50	4							1	S	58562932
150	260	50	6							1	S	58562940
150	310	50	4							1	S	58562933
150	310	50	6							1	S	58562941
163	60	50	8							1	S	58562942
163	100	50	8							1	S	58562943
163	130	50	8							1	S	58562944
163	150	50	8							1	S	58562945
163	180	50	8							1	S	58562946
163	230	50	8							1	S	58562947
163	260	50	8							1	S	58562948
163	310	50	8							1	S	58562949

Spare parts

Dimension [mm]

		PU [pc.]	L	Order-No.
Set Screws	M12x25 DIN EN ISO 4028	10	L	181466
Screwdrivers	SW6x200	1	L	167817
Grease presses		1	L	163706
Grease Cartridges		1	L	163707

Maximum cutting circle diameter

	HS	HW	ST	HS	HW	HS	ST
Knife height H [mm]	50	50	55	60	60	70	70
Knife thickness S [mm]	8	10	10	8	10	8	10
Profile depth T [mm]	12	10	15	20	18	30	27
Dmax at D=137	174	174	184	194	194	214	214
Dmax at D=150	189	189	199	209	209	229	229
Dmax at D=163	202	202	212	222	222	242	242

Maximum RPM

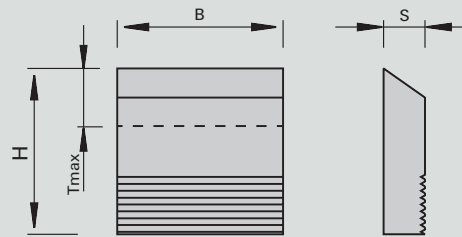
Knife height H [mm]	50	55	60	70			
Dmax at D=137	174	184	194	214			
Max.RPM (min-1):	8300	7800	7400	6700			
Dmax at D=150	189	199	209	229			
Max.RPM (min-1):	7700	7300	6900	6300			
Dmax at D=163	202	212	222	242			
Max.RPM (min-1):	7200	6800	6500	6000			
Dmax for D=215	254	264	274	294			
Max.RPM (min-1):	5700	5400	5200	4900			

HS 525 Blanks with serrated back HS

Product



Drawing



Machine



Application



Design



HS



Machine / Application

- for use in profile cutterheads with serration

Design

- cutting material: HS for soft woods

Advantages

Notes

- Tmax = maximum profile depth
- packing unit 2 pieces

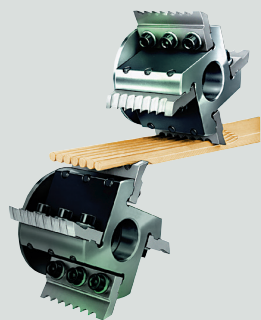
Product features

Order information

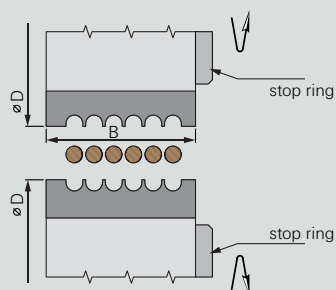
B [mm]	H [mm]	S [mm]	Tmax [mm]							PU [pc.]	L	Order-No.
40	50	8.0	12							2	L	50822712
80	50	8.0	12							2	L	50822716
100	40	8.0	-							2	o	50822705
130	40	8.0	-							2	o	50822706
650	70	8.0	30							2	L	50822754
650	50	8.0	12							1	L	176318
650	60	8.0	20							1	L	176319
40	70	8.0	30							2	L	163387
60	70	8.0	30							2	L	163390
80	60	8.0	20							2	L	163392
80	70	8.0	30							2	L	163393
100	50	8.0	12							2	L	163394
100	60	8.0	20							2	L	163395
100	70	8.0	30							2	L	163396
130	50	8.0	12							2	L	163397
130	60	8.0	20							2	L	163398
130	70	8.0	30							2	S	163399
150	50	8.0	12							2	L	163400
150	60	8.0	20							2	L	163401
150	70	8.0	30							2	L	163402
180	50	8.0	12							2	S	163403
180	60	8.0	20							2	S	163404
180	70	8.0	30							2	S	163405
230	50	8.0	12							2	L	164495
230	60	8.0	20							2	S	164496
50	50	8.0	12							2	S	180533
40	60	8.0	20							2	L	163386
60	50	8.0	12							2	L	163388
60	60	8.0	20							2	L	163389

HS 464 Multi Dowel Cutterheads

Product



Drawing



Machine



Application



Design



HS

MEC

Machine / Application

- multi spindle milling machines
- for the production of smooth round bars of 2 to 16 mm and of corrugated dowels of 6.1 to 16.1 mm in solid woods

Design

- body made from steel
- 2 or 4 knife holders

Advantages

- quick knife change
- self-centering knife seat

Notes

- guide-plate for axial adjustment of knives
- further profiles on request

Product features

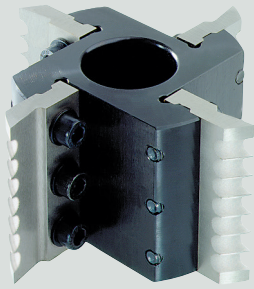
Order information

$\varnothing D$ [mm]	B [mm]	$\varnothing d$ [mm]	$\varnothing d_{max}$ [mm]	Z	n_{max} [min-1]					PU [pc.]	L	Order-No.
102	50	35	40	2	6000					1	S	50389261
102	75	35	40	2	6000					1	S	50389262
102	100	35	40	2	6000					1	S	50389263
102	50	40	40	2	6000					1	S	50389264
102	75	40	40	2	6000					1	S	50389265
102	100	40	40	2	6000					1	S	50389266
102	125	40	40	2	6000					1	S	50389267
102	150	40	40	2	6000					1	S	50389268
102	50	35	40	4	6000					1	S	50389269
102	75	35	40	4	6000					1	S	50389270
102	100	35	40	4	6000					1	S	50389271
102	50	40	40	4	6000					1	S	50389272
102	75	40	40	4	6000					1	S	50389273
102	100	40	40	4	6000					1	S	50389274
102	125	40	40	4	6000					1	S	50389275
102	150	40	40	4	6000					1	S	50389276
Spare parts			Dimension [mm]							PU [pc.]	L	Order-No.
Head Cap Screws			M8x30-8.8 DIN 7984							10	L	180005
Cranked Wrench Keys			SW6x100							1	S	180383

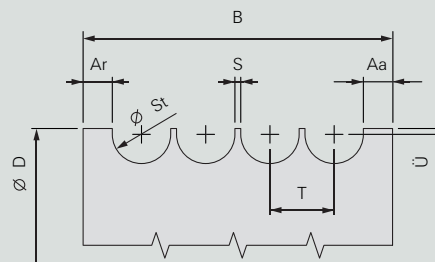
HS**464 HS Knives smooth round bars**

for smooth round dowels

Product



Drawing



Machine



Application



Design

**HS**

Machine / Application

Design

Advantages

Notes

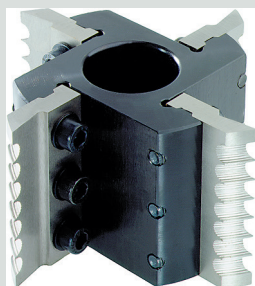
- small quantities: surcharge of 50%
- intermediate dimensions: surcharge of 25% on the next lower dimension
- indicate machine type when placing an order
- price per piece when ordering 8 identical knives

KNIVES

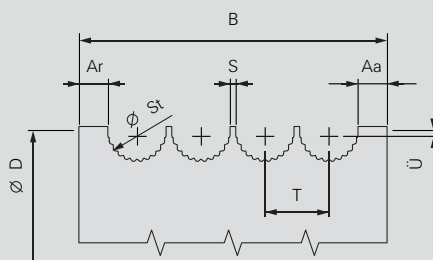
St= bar Ø	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16
S = bridge	1	1	1	1	1	1	1	1	1	1,5	1,5	1,5	1,5	1,5	1,5
T= pitch	3	4	5	6	7	8	9	10	11	12,5	13,5	14,5	15,5	16,5	17,5
D= diameter	127	127	127	127	127	127	135	135	135	135	135	135	135	135	135
B=50 No. of bars	12	9	8	7	6	5	4	4	3	3	3	3	2	2	2
Order-No. 50...	389200	389201	389202	389203	389204	389205	389206	389207	389208	389209	389210	389211	389212	389213	389214
B=75 No. of bars		16	13	11	9	8	7	6	6	5	5	4	4	4	4
Order-No. 50...		389215	389216	389217	389218	389219	389220	389221	389222	389223	389224	389225	389226	389227	389228
B=100 No. of bars			18	15	13	11	10	9	8	7	6	6	6	5	5
Order-No. 50...			389229	389230	389231	389232	389233	389234	389235	389236	389237	389238	389239	389240	389241
B=125 No. of bars					16	14	13	11	10	9	8	8	7	7	7
Order-No. 50...					389242	389243	389244	389245	389246	389247	389248	389249	389250	389251	389252
B=150 No. of bars								14	13	11	10	9	9	8	8
Order-No. 50...								389253	389254	389255	389256	389257	389258	389259	389260

HS 464 HS Knives ripple bars for fine serration dowels

Product



Drawing



Machine



Application



Design



Machine / Application

Design

Advantages

Notes

- small quantities: surcharge of 50%
- intermediate dimensions: surcharge of 25% on the next lower dimension
- indicate machine type when placing an order
- price per piece when ordering 8 identical knives

KNIVES

St= bar Ø	6,1	7,1	8,1	10,1	11,1	12,1	13,1	14,1	15,1	16,1
No. of serrations	16	16	20	22	22	22	22	22	22	22
S = bridge	1	1	1	1	1,5	1,5	1,5	1,5	1,5	1,5
T= pitch	7,1	8,1	9,1	11,1	12,6	13,6	14,6	15,6	16,6	17,6
D= diameter	127	127	135	135	135	135	135	135	135	135
B=50 No. of bars	6	5	4	3	3	3	3	2	2	2
Order-No. 50...	389300	389301	389302	389303	389304	389305	389306	389307	389308	389309
B=75 No. of bars	9	8	7	6	5	5	4	4	4	3
Order-No. 50...	389310	389311	389312	389313	389314	389315	389316	389317	389318	389319
B=100 No. of bars	12	11	10	8	7	6	6	5	5	5
Order-No. 50...	389320	389321	389322	389323	389324	389325	389326	389327	389328	389329
B=125 No. of bars	16	14	13	10	9	8	8	7	7	6
Order-No. 50...	389330	389331	389332	389333	389334	389335	389336	389337	389338	389339
B=150 No. of bars				12	11	10	9	9	8	8
Order-No. 50...				389340	389341	389342	389343	389344	389345	389346

HS 4000 Tongue and Groove Tools

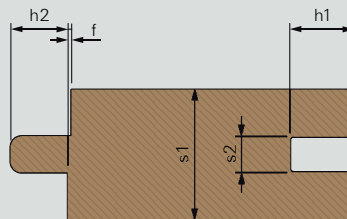
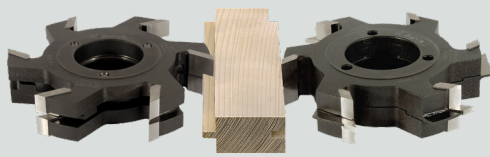
Product

Drawing

Machine

Application

Design



HS

MEC

Machine / Application

- molders
- double end tenoners
- for tongue and groove board with or without space allowance in material (=open joint) or chamfer in soft and hard woods

Design

- body made from steel
- adjustable by means of spacers
- highest precision thanks to plane parallelism of all parts
- secured against rotation by means of 3 driving pins on minor diameter 75 mm

Advantages

Notes

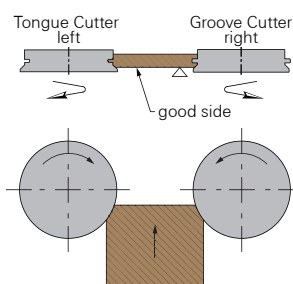
- indicate sense of rotation, direction of feed and face side according to diagram I, II, III or IV when placing an order
- without indications we will deliver according to diagram I
- delivery with HW-tipping possible with surcharge

Product features

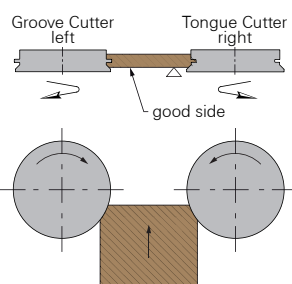
Order information

Profile	Ø D [mm]	B [mm]	Ø d [mm]	nmax [min-1]	s1 [mm]	s2 [mm]	f [mm]	Z	PU [pc.]	L	Order-No.
501/502	180	35	40	8000	12-36	4,5-7,5	0,5	6	1	S	58532354
505/506	180	35	40	8000	15-27	4,5-7,5	0,5	6	1	S	58532358
512/513	180	35	40	8000	12-27	4,5-7,5		6+3	1	S	58532361
503/502	180	35	40	8000	12-36	4,5-7,5		6	1	S	58532382
529/530	180	35	40	8000	15-27	4,5-7,5	0,5	6	1	S	58532384
507/508	180	35	40	8000	15-27	4,5-7,5		6	1	S	58532387
525/526	180	35	40	8000	12-27	4,5-7,5		6+3	1	S	58532390
541/540	180	35	40	8000	14-19	4,5-7,5		6+3	1	S	58532391

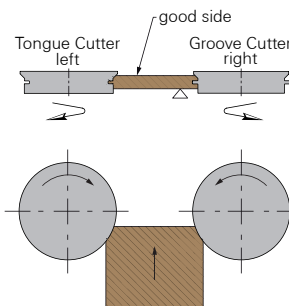
Example I



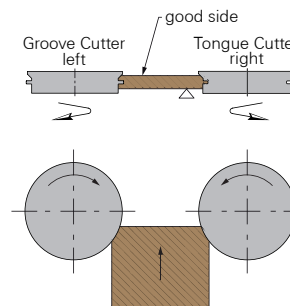
Example II



Example III



Example IV

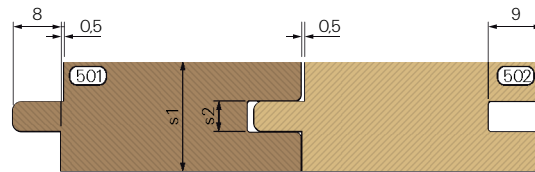


4000 Tongue and Groove Tools

Diagram I

Tongue Cutters

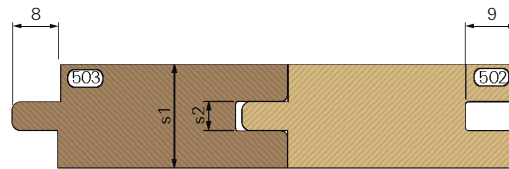
Profile 501



Grooving Cutters

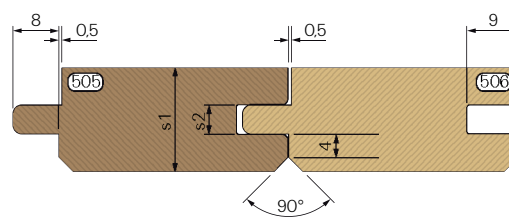
Profile 502

Profile 503



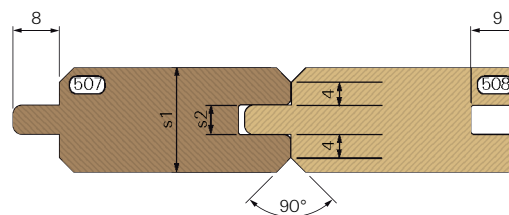
Profile 502

Profile 505



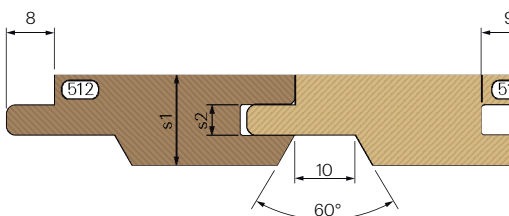
Profile 506

Profile 507



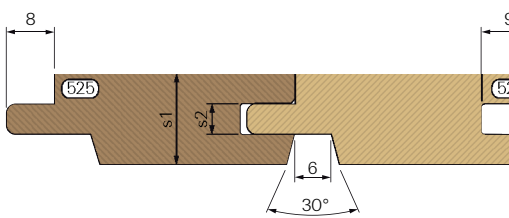
Profile 508

Profile 512



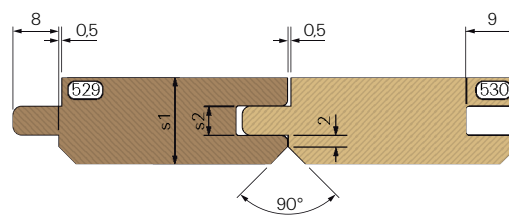
Profile 513

Profile 525



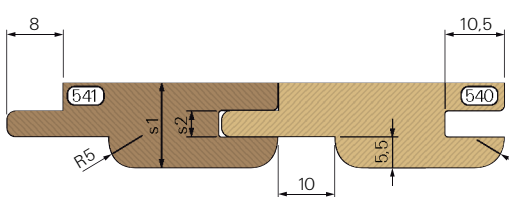
Profile 526

Profile 529



Profile 530

Profile 541



Profile 540

Tool-checklist

Request for a special tool

Date: _____

Basic Data

Company / Customer (Com.), Address, Contact, Position, E-Mail, Mobile, responsible Stehle Distribution Partner

Machine

Tact machine ☐Through-Feed ☐

Type of plant (Tact-, Through-Feed), Spindle (1 or 2), Hogger, Scoring (above/below), Parameters (RPM, Infeed).

Brand - Type _____ Infeed _____ RPM _____

Spindles 1 ☐ 2 ☐ 3 ☐Hogger YES ☐ NO ☐ Scoring: Above ☐ Below ☐

Product

Window scantlings, BSH, KVH-/Glued-Timber, Solid Wood Panels, Wood-Dimensions (l x b x h).

W.-Scantlings ☐ BSH ☐ KVH ☐ Solid Wood Panels ☐

b x h x l in mm



Vertikal



Horizontal



Wood Type

Spruce, larch, pine, oak, ash, beech,... Qty. in %, Humidity in %.

Spruce ☐ % Larch ☐ % Pine ☐ % Fir ☐ %Oak ☐ % Ash ☐ % Beech ☐ % Birch ☐ %

Humidity _____% other _____%

Glue Type

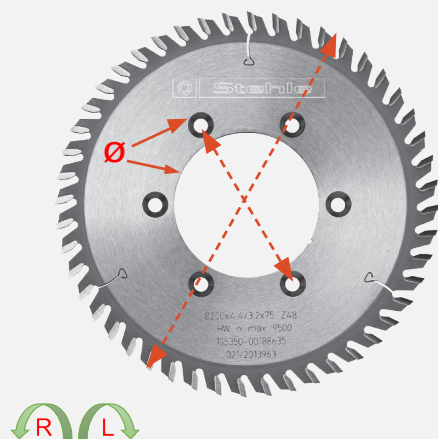
Melamine, PU, PU with fibers, Specification (Name)

PUR ☐ PUR with fibers ☐ Melamine ☐ Specification (Name): _____

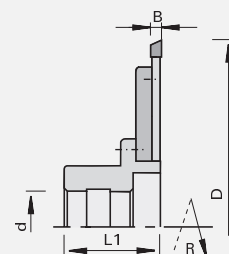
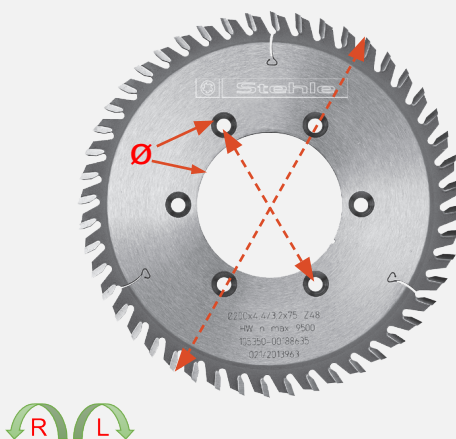
Tools-Data

Hogger, Scoring-Sawlade, Dimensions: D x d1 x b, PH, teeth, tooth-form, rotation - direction, (sketch).

Scoring Sawblade



Hogger



Jointing Cutters

Block- Micro- or Disc-Jointing-Cutters (sketch)

Jointing high, diameter, bore, teeth (wings), jointing length; Configuration (edges): e.g. HS, HS3-Plus, Coating.

Block-Cutters ☐

Disc-Cutters ☐

Type HS ☐ HS-3+ ☐ HW ☐ Special _____

Jointing Length

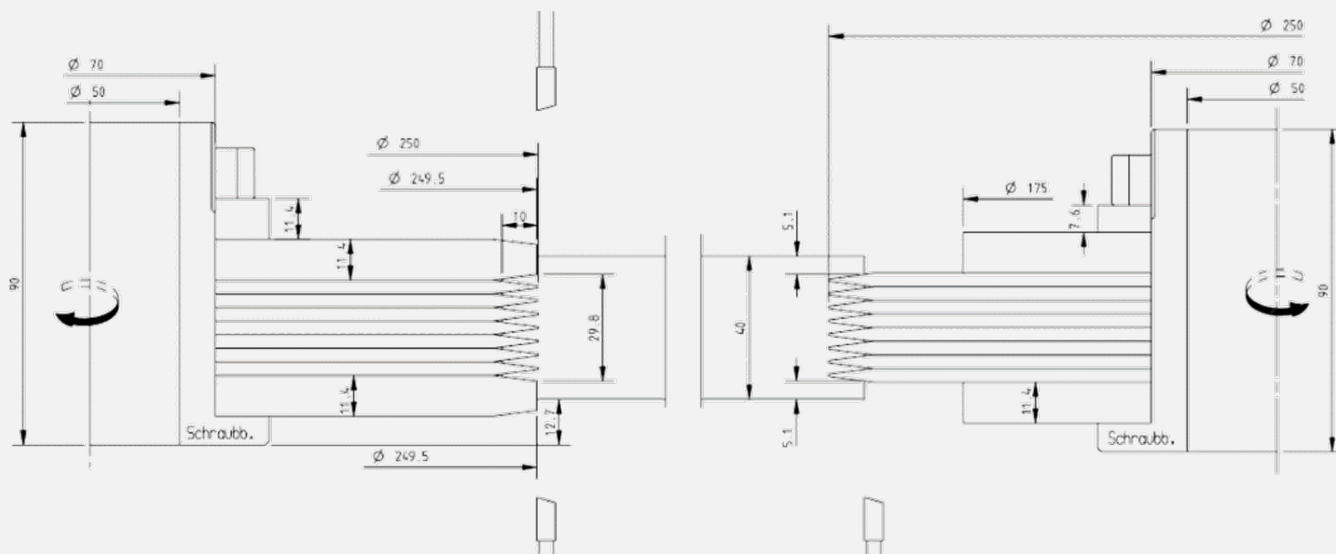
Partitionz _____

4/4 - 4/4,5 6/6 - 6/7 10/10 - 10/11 15/15 - 15/16,5 20/20 - 20/22

Tooth-wings 1,6 - 2,8 - 3,8 - 5,0 - 6,2

Bore (d) ☐ $\varnothing$ 50mm _____ mm

D ø 160 ☐ 170 ☐ 180 ☐ 200 ☐ 242 ☐ 250 ☐ 260 ☐ 350 ☐



(Disc-Jointing Cutters – Sample-Set)

Order No: Index

Order-No.	Page	
001625	L	23
003079	L	33, 34
009674	L	36
056378	L	27, 28
163386	L	44
163387	L	44
163388	L	44
163389	L	44
163390	L	44
163392	L	44
163393	L	44
163394	L	44
163395	L	44
163396	L	44
163397	L	44
163398	L	44
163399	S	44
163400	L	44
163401	L	44
163402	L	44
163403	S	44
163404	S	44
163405	S	44
163706	L	37, 42
163707	L	37, 42
164495	L	44
164496	S	44
166091	L	23, 26
166092	L	27, 28, 33, 34, 35
166709	L	27, 28
167817	L	37, 42
168108	L	36
168703	L	40
171067	L	34
171188	L	32, 34
176199	L	33, 34
176318	L	44
176319	L	44
177102	L	26
177103	L	26
177104	L	26
178171	L	26
178172	L	26
178173	C	26
178174	C	26
178188	L	26
178294	L	27
178787	C	26
179198	S	36
179199	S	36
179200	S	36
179205	S	36
179221	S	40
179222	S	40
179223	S	40
179224	S	40
179225	S	40
179226	S	40
179227	S	40
179228	S	40
179229	S	40
179230	S	40
179231	S	40
179232	S	40
179233	S	40
179234	S	40
179235	S	40
179236	S	40
180005	L	45
180383	S	45
180454	L	33, 35
180533	S	44
180710	L	32
180940	L	26
180941	L	26
181034	L	26
181035	L	26
181191	S	36
181466	L	37, 42

Order-No.	Page	
182112	L	33, 35
182377	L	27, 28
182378	O	27
182379	O	27
182599	O	28
182600	O	28
182611	O	28
182612	O	28
183087	L	32
183748	L	33
183749	L	33, 34
184309	L	32
186163	S	26
187251	L	32
187323	L	35
187692	L	32
187694	L	32
188947	L	29
188948	L	29
189032	L	27, 28
189033	L	27, 28
189034	L	29
189035	L	29
189100	L	27, 28
189222	L	27, 28
189223	L	27, 28
189246	L	28
189247	L	28
189273	L	31
189536	O	30
189539	L	29
189540	L	29
189833	L	31
189834	L	31
192187	L	23
815807	L	40
9209773	L	32
50100525	L	31
50100528	L	31
50389261	S	45
50389262	S	45
50389263	S	45
50389264	S	45
50389265	S	45
50389266	S	45
50389267	S	45
50389268	S	45
50389269	S	45
50389270	S	45
50389271	S	45
50389272	S	45
50389273	S	45
50389274	S	45
50389275	S	45
50389276	S	45
50400021	S	39
50400023	S	39
50400024	S	39
50400025	S	39
50400026	S	39
50400027	S	39
50400028	S	39
50400029	S	39
50400030	S	39
50400031	S	39
50400032	S	39
50400033	S	39
50400034	S	39
50400035	S	39
50400036	S	39
50400063	S	39
50400073	S	39
50400074	S	39
50400075	S	39
50400077	S	39
50400078	S	39
50400079	S	39
50400080	S	39
50400083	O	39

Order-No.	Page	
50457841	L	31
50457843	L	31
50561035	S	36
50561036	S	36
50561037	S	36
50561038	S	36
50561046	S	36
50561054	S	36
50562677	S	36
50570980	L	23
50570981	L	23
50570982	S	23
50570983	S	23
50571101	S	23
50571102	S	23
50571103	S	23
50571104	S	23
50571105	S	23
50572490	S	8
50572550	S	22
50572551	S	22
50573681	S	9
50573682	S	9
50573683	S	9
50573700	S	8
50576700	S	17
50576991	S	23
50576993	S	23
50576997	S	23
50577681	L	18
50577682	L	18
50577683	L	18
50665050	S	35
50665101	S	35
50665102	S	35
50665103	S	35
50665104	S	35
50822705	o	44
50822706	o	44
50822712	L	44
50822716	L	44
50822754	L	44
50822780	S	40
50822781	S	40
50822782	S	40
50822783	S	40
50822784	S	40
50822785	S	40
50822786	S	40
50822787	S	40
50822790	S	40
50822791	S	40
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50822793	S	40
50822794	S	40
50822795	S	40
50822798	S	40
50930320	L	22
50949533	S	22
58187113	L	32
58187299	L	32
58187300	L	32
58400131	S	38
58400132	S	38
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58400134	S	38
58400135	L	38
58400136	S	38
58400137	S	38
58400138	S	38
58400139	L	38
58400140	S	38
58400141	S	38
58400142	S	38
58400143	L	38
58400144	S	38
58400145	L	38
58400147	L	38
58400149	L	38

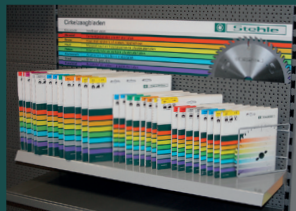
Order-No.	Page	
58400150	S	38
58400151	S	38
58400152	L	38
58400153	L	38
58400154	L	39
58400155	S	39
58400156	S	39
58400157	S	39
58400158	S	38
58400159	L	38
58400160	L	38
58400161	S	38
58400162	S	38
58400164	S	39
58400165	S	38
58400166	L	38
58400167	L	39
58400168	S	39
58400170	S	38
58400171	S	38
58400174	S	39
58400175	S	39
58400179	S	39
58400183	S	39
58400184	L	38
58400185	S	39
58400187	S	38
58400188	S	38
58400190	S	38
58400192	S	38
58400193	S	38
58400194	L	39
58400195	S	39
58400196	S	38
58400198	L	38
58400201	S	38
58400202	S	38
58400205	S	38
58400206	S	38
58532354	S	48
58532358	S	48
58532361	S	48
58532382	S	48
58532384	S	48
58532387	S	48
58532390	S	48
58532391	S	48
58562686	S	37
58562687	S	37
58562688	S	37
58562689	S	37
58562691	S	37
58562692	S	37
58562693	S	37
58562694	S	37
58562695	S	37
58562696	S	37
58562697	S	37
58562698	S	37
58562700	S	37
58562701	S	37
58562702	S	37
58562703	S	37
58562738	S	37
58562739	S	37
58562740	S	37
58562741	S	37
58562742	S	37
58562743	S	37
58562744	S	37
58562745	S	37
58562750	S	37
58562751	S	37
58562752	S	37
58562753	S	37
58562754	S	37
58562755	S	37
58562756	S	37
58562757	S	37

Order-No: Index

Order-No.	Page		Order-No.	Page		Order-No.	Page	
58562920	S	42	58572686	C	7	58577693	C	7
58562921	S	42	58572687	C	7	58578666	C	12
58562922	S	42	58572688	C	7	58578667	C	12
58562923	S	42	58572690	C	4	58578668	C	12
58562924	S	42	58574497	C	10	58578684	C	12
58562925	S	42	58574501	C	10	58578685	C	12
58562926	S	42	58574507	L	10	58578686	C	12
58562927	S	42	58574510	C	10	58578687	C	12
58562928	S	42	58574512	C	10	58578688	C	12
58562929	S	42	58574514	C	10	58578689	C	12
58562930	S	42	58574516	C	10	58578691	C	13
58562931	S	42	58574519	C	10	58578692	C	13
58562932	S	42	58574520	C	10	58578693	C	13
58562933	S	42	58574521	C	10	58640100	C	19
58562934	S	42	58574571	C	11	58640101	L	19
58562935	S	42	58574572	C	11	58640102	C	19
58562936	S	42	58574661	C	11	58640103	C	19
58562937	S	42	58574666	C	12	58640105	C	19
58562938	S	42	58574667	C	12	58640106	C	19
58562939	S	42	58574668	C	12	58640107	C	19
58562940	S	42	58574669	C	12	58640108	C	19
58562941	S	42	58574670	C	12	58640109	C	19
58562942	S	42	58574671	C	12	58640110	C	19
58562943	S	42	58574672	C	12	58640111	C	19
58562944	S	42	58574673	C	12	58640113	C	22
58562945	S	42	58574674	C	12	58640114	C	22
58562946	S	42	58574675	C	11	58640115	C	22
58562947	S	42	58574676	C	11	58640116	C	22
58562948	S	42	58574680	C	12	58640117	C	22
58562949	S	42	58574681	C	12	58640118	C	22
58562990	S	37	58574682	C	12	58640121	C	19
58571984	S	20	58574683	C	12	58640122	C	19
58572497	C	4	58574684	C	12	58640123	C	19
58572501	L	4	58574685	C	12	58640124	C	19
58572503	L	4	58574686	C	13	58640173	L	24
58572507	L	4	58574687	C	13	58640178	S	24
58572508	C	4	58574688	C	13	58640184	L	24
58572509	C	4	58576497	C	14	58640185	S	24
58572510	L	4	58576501	C	14	58640210	S	22
58572512	L	5	58576507	C	14	58640211	S	22
58572514	L	5	58576510	C	14	58665105	L	33
58572516	L	4	58576512	C	14	58665106	L	33
58572518	L	5	58576514	C	14	58665107	S	34
58572519	C	4	58576516	C	14	58665108	L	34
58572520	C	4	58576519	C	14	58671984	S	20
58572521	L	4	58576520	C	14	58671985	S	20
58572522	C	5	58576521	C	14	58807839	L	31
58572528	S	22	58576571	C	15	58807842	L	31
58572529	S	22	58576572	C	15	80306012	L	35
58572530	C	22	58576661	L	15	80425335	S	18
58572531	C	22	58576666	C	16	80425336	S	18
58572532	C	22	58576667	C	16	80425337	S	18
58572533	C	22	58576668	C	16	80478289	L	24
58572534	C	22	58576669	C	16	80478292	L	24
58572535	C	22	58576670	C	16	80478293	L	24
58572546	C	4	58576671	C	16	80492032	L	32
58572547	C	4	58576672	C	16			
58572548	C	4	58576673	C	16			
58572570	C	5	58576674	C	16			
58572571	C	5	58576675	L	15			
58572572	C	5	58576676	L	15			
58572661	C	6	58577100	C	5			
58572666	C	6	58577101	C	5			
58572667	C	6	58577103	C	5			
58572668	C	6	58577104	C	5			
58572669	C	6	58577675	C	7			
58572670	C	6	58577676	C	7			
58572671	C	6	58577677	C	7			
58572672	C	7	58577678	L	16			
58572673	C	7	58577679	C	16			
58572674	C	7	58577680	C	16			
58572675	C	6	58577684	C	7			
58572676	C	6	58577685	C	7			
58572680	C	7	58577686	C	7			
58572681	C	7	58577687	C	7			
58572682	C	7	58577688	C	7			
58572683	C	7	58577689	C	7			
58572684	C	7	58577691	C	7			
58572685	C	7	58577692	C	7			

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