

The background of the cover is a high-speed photograph of a CNC machine's end mill cutting into a piece of wood. The end mill is a long, silver-colored metal tool with a fluted design. As it rotates and moves down, it creates a large cloud of fine wood chips and dust that fills the lower half of the frame. The lighting is dramatic, with a strong light source from the side, creating highlights on the metal tool and the edges of the wood chips. The overall color palette is dominated by the metallic silver of the tool, the natural tan of the wood, and the vibrant red of the text overlay.

OERTLI 
Excellence in solid wood

**CNC tool
catalogue**

Abbreviation I: technical drawings

alpha	Angle
A	A-dimension
B	cutting width
D	diameter
d	bore
D1	body diameter
d1	shank diameter
Dmax	maximum diameter
DR	direction of rotation
DW	helix angle
h	Knife height
L	overall length
L1	clamping length shank
L2	clamping length arbor
L3	chamfer width
L4	alternating axial angle
L5	tip length
li.	left-hand rotation
MAN	manual feed
MEC	mechanical feed
M	Metric thread
n max	maximum speed
NEG	negative helix angle
NUL	cutting length
POS	positive helix angle
R	radius
re.	right-hand rotation
SL	cutting length
T	Depth
Tmax	maximum depth
WB	workpiece width
WB max	maximum workpiece width
WB min	minimum workpiece width
Z	number of teeth
ZH	Tooth height



OERTLI Werkzeuge AG

A traditional company of Swiss origin with an international presence.

What began over 100 years ago in the Zurich lowlands with the mechanic Jean Oertli is today an internationally respected manufacturer of tooling solutions for a wide range of woodworking applications. One thing has not changed: the company’s headquarters, as well as development and production, are still located in the heart of Switzerland.

Excellence in Solid Wood

More than a guiding principle

OERTLI has grown with the machining of solid wood and has always remained true to its core competence. The company benefits from many years of experience in various business sectors such as interior finishing, the production of windows and doors, as well as timber construction – always to the advantage of its customers. Today, OERTLI is known and valued as a technology leader in the field of solid wood machining. The company has earned this reputation not only through its high-performance tools, but also through optimized application concepts aimed at increasing customer profitability



CNC Tools

Ensuring the full performance of your CNC machine

Even the best CNC machine depends on the quality and performance of the tools used. Optimal tool selection and coordination are therefore among the most important factors for successful CNC production. On the following pages, you will find a range of tools of the highest quality, clearly structured by product groups. Together with practical application recommendations from our experts, this catalogue serves as a practical handbook for every CNC user.

OERTLI Engineering

Guidance for sustainable efficiency

Alongside its traditional tool manufacturing, OERTLI is highly regarded and sought after by many successful woodworking companies as an engineering partner. From consulting and machining concepts to 3D visualisations and programming data, OERTLI supports the entire project process. The objective of every consultation is to achieve high and sustainable cost-effectiveness for the customer.

Abbreviations II:
Materials + Components

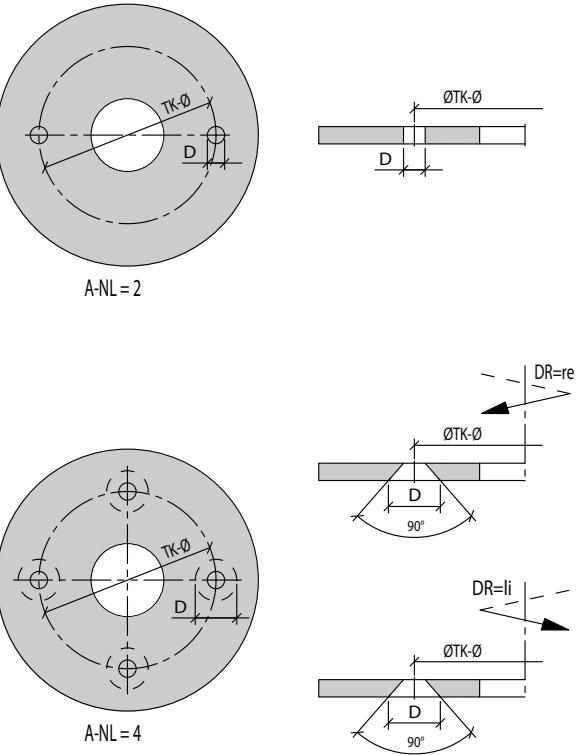
DP	Diamond
HS	High-speed steel (HSS)
HW	Carbide
PS	Profile cutting edge
VHW	Solid carbide
WS	Indexable insert
WS-PS	Profile indexable insert

Abbreviations III:
Circular saws + Specials

A-NL	Number of pin holes
b	Blade body thickness
DKN B	Double keyway width
DKN L	Double keyway length
NL	Pin holes
NLK	"Secondary hole combination 2/7/42 + 2/9/46.5 + 2/10/60"
TK	Pitch circle diameter
Typ	Miscellaneous information
ZF	Tooth geometry



Arrangement of pin holes



A-NL	D	TK	DR
2/10/60			

A-NL	D	TK	DR
4/10.2/65/re.			

A-NL	D	TK	DR
4/10.2/65/li.			

BASE | PRO | MAX -
The OERTLI product lines

With BASE, PRO and MAX, we offer three clearly defined performance levels: cost-effective for entry-level applications, productive for demanding operations, and maximum performance for continuous industrial use. This allows you to choose exactly the tool that fits your process and your objectives.

Price attractiveness

Cost efficiency of the tool in terms of purchase

BASE		8
PRO		6
MAX		4

Performance

Process speed + productivity

BASE		4
PRO		7
MAX		10

Surface quality

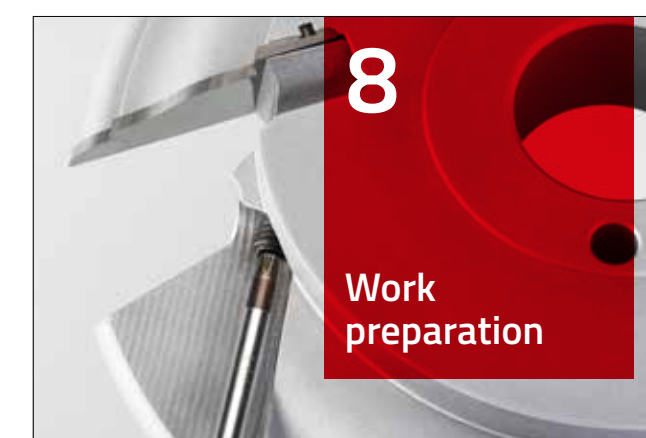
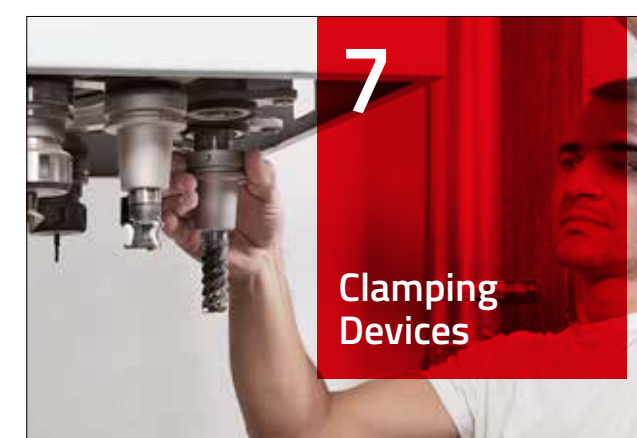
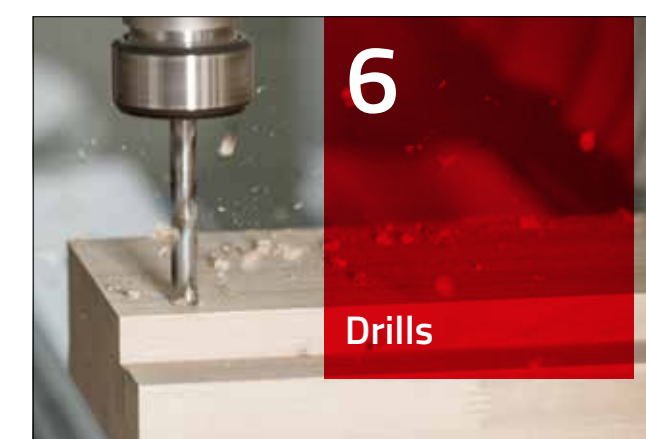
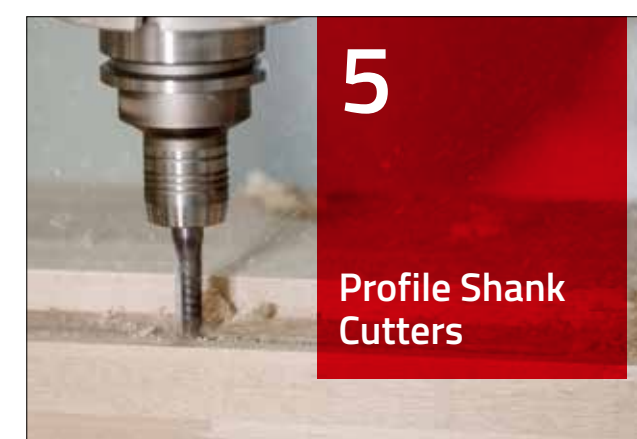
High quality of the machined surface

BASE		5
PRO		7
MAX		8

Tool life

Service life of the tool

BASE		5
PRO		7
MAX		9



A close-up photograph of a solid carbide shank cutter in operation. The cutter is a long, cylindrical tool with a threaded shank and a wider, polished cutting edge. It is positioned vertically, cutting into a workpiece. A large, bright red semi-transparent overlay covers the upper right portion of the image, containing the number '1' and the text 'Solid carbide shank cutter'. The background is dark and out of focus, showing some sparks or debris from the cutting process.

1

**Solid carbide
shank cutter**

TURBEX Sprint Spiral Cutter BASE

Application

- For grooving, sizing and cutting
- Suitable for ramping (angled plunging)
- For surfaces with roughing–finishing quality
- Enables higher feed rates compared to conventional roughing cutters

Materials

- Solid wood
- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated
- Mineral materials (Corian, Varicor, etc.)
- Melamine- and paper-faced, HPL- and foil-laminated, veneered wood-based materials
- Various plastics

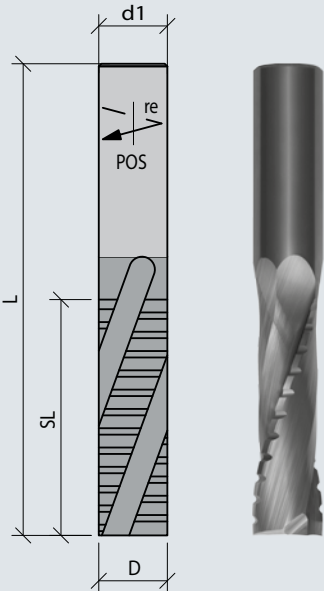
Machines

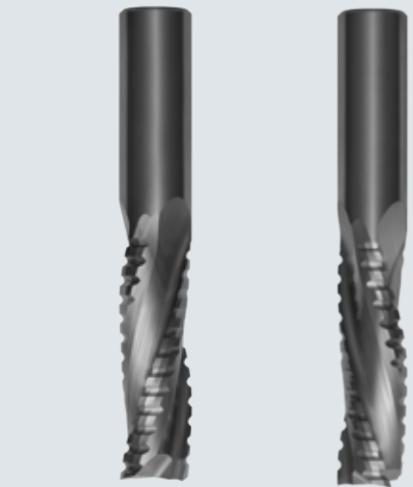
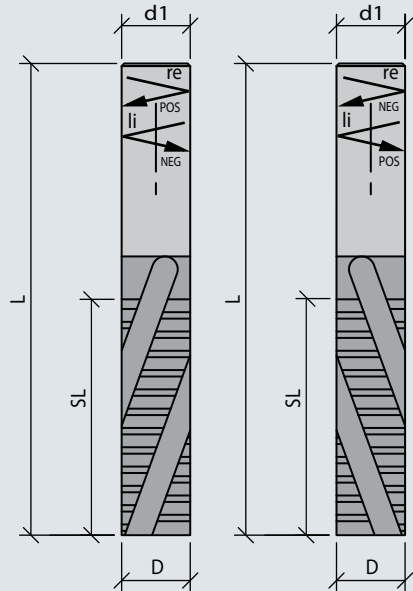
- Hand routers with or without CNC control
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Technical Information

- Solid carbide
- Sprint tooth geometry for reduced cutting forces
- Improved chip evacuation due to optimized flutes
- With end grinding
- Limited resharpening zone
- MAN up to diameter 12 mm
- MEC from diameter 12 mm

Art. No.	D	SL	L	d1	Z	DW	DR	n max
TB682030	8	30	75	8	2	pos.	re.	30000
TB682031	10	30	75	10	2	pos.	re.	30000
TB682032	12	45	90	12	2	pos.	re.	30000
TB682033	16	55	110	16	2	pos.	re.	30000
TB682034	20	75	135	20	2	pos.	re.	30000





TURBEX Sprint Spiral Cutter PRO

Application

- For grooving, sizing and cutting
- Suitable for ramping (angled plunging)
- For surfaces with roughing–finishing quality
- For maximum feed rates

Materials

- Solid wood
- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated
- Mineral materials (Corian, Varicor, etc.)
- Melamine- and paper-faced, HPL- and foil-la-minated, veneered wood-based materials
- Various plastics

Machines

- Hand routers with or without CNC control
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Technical Information

- Solid carbide
- Sprint tooth geometry for reduced cutting forces
- Improved chip evacuation due to optimized flutes
- Peripheral and end cutting
- Resharpenable several times
- MAN up to diameter 12 mm
- MEC from diameter 12 mm

Art. No.	D	SL	L	d1	Z	DW	DR	n max
TB682000	8	30	75	8	2	pos.	re.	30000
TB682001	10	30	75	10	2	pos.	re.	30000
TB682028	10	30	75	10	2	pos.	li.	30000
TB682002	10	30	75	10	2	neg.	re.	30000
TB682003	10	30	75	10	2	neg.	li.	30000
TB682004	10	45	90	10	2	pos.	re.	30000
TB682005	10	40	110	10	2	neg.	re.	30000
TB682006	10	70	120	12	2	pos.	re.	30000
TB682007	11	40	90	12	2	pos.	re.	30000
TB682008	11	60	110	12	2	pos.	re.	30000
TB682009	12	35	80	12	3	pos.	re.	30000
TB682010	12	45	90	12	3	pos.	re.	30000
TB682012	12	45	90	12	3	pos.	li.	30000
TB682011	12	45	90	12	3	neg.	re.	30000
TB682013	12	60	110	12	3	pos.	re.	30000
TB682029	14	35	95	14	3	neg.	re.	30000
TB682014	14	55	110	14	3	pos.	re.	30000
TB682015	16	35	90	16	3	pos.	re.	30000
TB682016	16	55	110	16	3	pos.	re.	30000
TB682017	16	55	110	16	3	pos.	li.	30000
TB682051	16	55	110	16	3	neg.	li.	30000
TB682050	16	55	110	16	3	neg.	re.	30000
TB682019	16	75	130	16	3	pos.	re.	30000
TB682018	16	65	130	16	3	neg.	re.	30000
TB682020	20	55	115	20	3	pos.	re.	30000
TB682021	20	55	115	20	3	neg.	re.	30000
TB682022	20	75	135	20	3	pos.	re.	30000
TB682024	20	75	135	20	3	pos.	li.	30000

Art. No.	D	SL	L	d1	Z	DW	DR	n max
TB682023	20	75	135	20	3	neg.	re.	30000
TB682025	20	95	150	20	3	pos.	re.	30000
TB680125	20	125	180	20	3	pos.	re.	24000
TB682026	25	50	125	25	3	neg.	re.	24000
TB682027	25	100	165	25	3	pos.	re.	24000
TB680075	25	130	190	25	3	pos.	re.	24000

TURBEX Sprint Spiral Cutter MAX

Application

- For grooving, sizing and cutting
- Suitable for ramping (angled plunging)
- For surfaces with roughing–finishing quality
- For maximum feed rates
- Conditionally suitable for plunge cutting

Materials

- Solid wood
- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated
- Mineral materials (Corian, Varicor, etc.)
- Melamine- and paper-faced, HPL- and foil-la-minated, veneered wood-based materials
- Various plastics

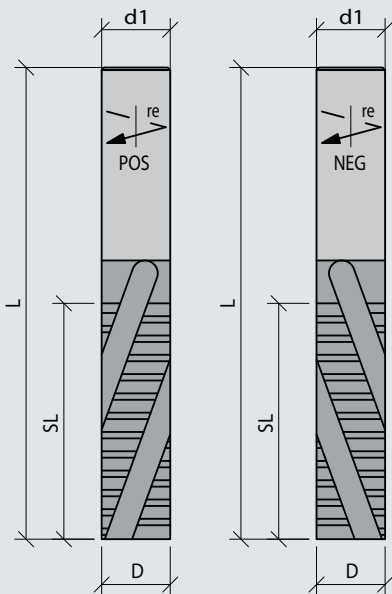
Machines

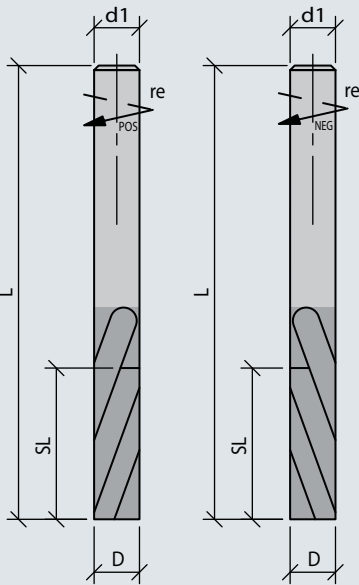
- Hand routers with or without CNC control
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Technical Information

- Solid carbide
- Sprint tooth geometry for reduced cutting forces
- Improved chip evacuation due to optimized flutes
- With centre cutting geometry
- Extended resharpening zone
- MAN up to diameter 12 mm
- MEC from diameter 12 mm
- With coating for extended tool life

Art. No.	D	SL	L	d1	Z	DW	DR	n max
TB682040	12	45	90	12	3	pos.	re.	30000
TB682041	16	35	90	16	3	pos.	re.	30000
TB682042	16	55	110	16	3	pos.	re.	30000
TB682043	16	65	130	16	3	neg.	re.	30000
TB682044	20	55	115	20	3	pos.	re.	30000
TB682045	20	75	135	20	3	pos.	re.	30000





TURBEX Finishing Spiral Cutter BASE

Application

- For grooving, sizing and cutting
- Suitable for ramping (angled plunging)
- For maximum surface quality requirements
- Typically used after roughing operations
- For low material removal volumes at medium feed rates

Materials

- Solid wood
- Wood-based materials and panels
- Various plastics

Machines

- Hand routers with CNC control
- CNC machining centres
- Special milling machines with milling spindles for shank-type tools

Technical Information

- Solid carbide
- Improved chip evacuation due to optimized flutes
- With end grinding
- Disposable tool
- Positive and negative helix angle for optimal chip evacuation
- MAN

Art. No.	D	SL	L	d1	Z	DW	DR	n max
TB682190	3	15	60	3	2	pos.	re.	30000
TB682191	4	15	60	4	2	pos.	re.	30000
TB682192	4	15	60	4	2	neg.	re.	30000
TB682193	6	20	60	6	2	pos.	re.	30000
TB682194	6	20	60	6	2	neg.	re.	30000

TURBEX Finishing Cutter PRO

Application

- For grooving, sizing and cutting
- Suitable for ramping (angled plunging)
- For maximum surface quality requirements
- For low material removal volumes at medium feed rates

Materials

- Solid wood, wood-based materials and panels
- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated
- Mineral materials (Corian, Varicor, etc.)
- Various plastics

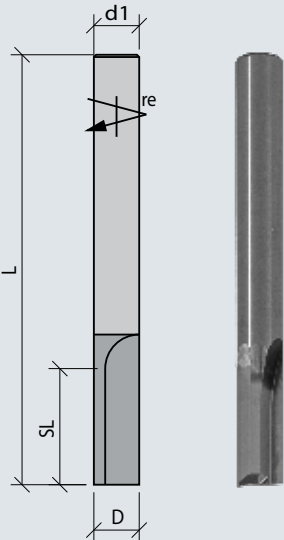
Machines

- Hand routers with or without CNC control
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Technical Information

- Solid carbide
- Cutting edges parallel to the tool axis
- Peripheral and end cutting
- MAN

Art. No.	D	SL	L	d1	Z	DW	DR	n max
TB682180	4	13	60	4	2	0°	re.	30000
TB682181	5	13	60	5	2	0°	re.	30000
TB682182	6	16	60	6	2	0°	re.	30000
TB682183	8	25	75	8	2	0°	re.	30000



TURBEX Finishing Spiral Cutter MAX

Application

- For grooving, sizing and cutting
- Suitable for ramping (angled plunging)
- For maximum surface quality requirements
- Typically used after roughing operations

Materials

- Solid wood
- Particleboard and fibreboard materials (chipboard, MDF, HDF, etc.), uncoated
- Mineral materials (Corian, Varicor, etc.)
- Melamine- and paper-faced, HPL- and foil-laminated, veneered wood-based materials
- Various plastics

Machines

- Hand routers with or without CNC control
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Technical Information

- Solid carbide
- Improved chip evacuation due to optimized flutes
- With end grinding
- Extended resharpening zone
- MAN up to diameter 12 mm
- MEC from diameter 12 mm
- Cutting allowance approx. 1–2 mm

Art. No.	D	SL	L	d1	Z	DW	DR	n max
TB682157	6	15	60	6	2	pos.	re.	30000
TB682150	8	30	75	8	2	pos.	re.	30000
TB682152	8	30	75	8	2	pos.	li.	30000
TB682151	8	30	75	8	2	neg.	re.	30000
TB682158	8	30	75	8	2	neg.	li.	30000
TB682153	10	30	75	10	2	pos.	re.	30000
TB682159	10	30	75	10	2	pos.	li.	30000
TB682154	12	45	90	12	3	pos.	re.	30000
TB682160	12	45	90	12	3	pos.	li.	30000
TB682155	16	55	110	16	3	pos.	re.	30000
TB682164	16	55	110	16	2	pos.	re.	30000
TB682161	16	55	110	16	3	pos.	li.	30000
TB682156	20	75	135	20	3	pos.	re.	30000
TB682162	20	75	135	20	3	pos.	li.	30000
TB682163	20	95	150	20	3	pos.	re.	30000

Finishing Spiral Cutter MAX

Application

- For grooving, sizing and cutting
- Suitable for ramping (angled plunging)
- For maximum surface quality requirements
- For low material removal volumes at medium feed rates

Materials

- Solid wood
- Particleboard and fibreboard materials (chipboard, MDF, HDF, etc.), uncoated
- Mineral materials (Corian, Varicor, etc.)
- Melamine- and paper-faced, HPL- and foil-laminated, veneered wood-based materials
- Various plastics
- Aluminium

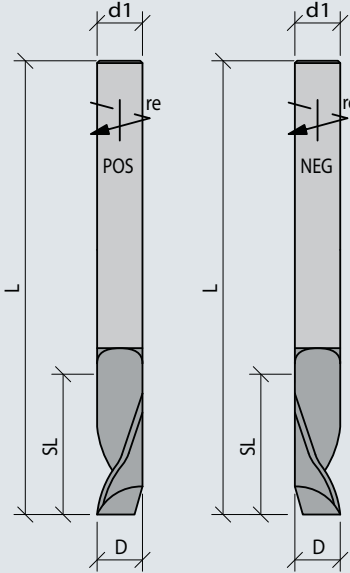
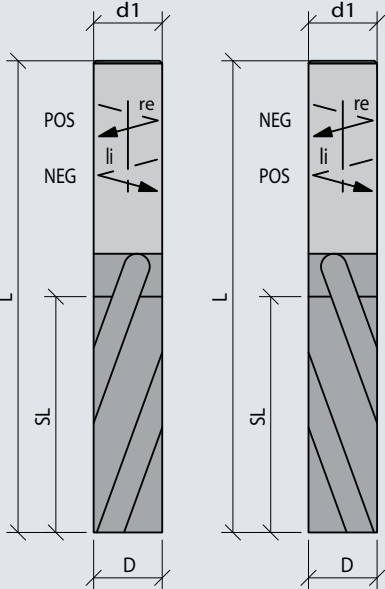
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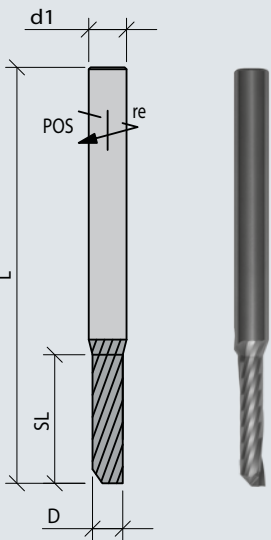
- Hand routers with or without CNC control
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Technical Information

- Solid carbide
- Improved chip evacuation due to polished flutes
- MAN

Art. No.	D	SL	L	d1	Z	DW	DR	n max
TA680159	1	5	40	3	1	pos.	re.	30000
TA680160	2	8	40	3	1	pos.	re.	30000
TA680161	3	10	40	3	1	pos.	re.	30000
TA680166	4	12	50	6	1	neg.	re.	30000
TA680162	4	14	50	4	1	pos.	re.	30000
TA680163	5	16	60	5	1	pos.	re.	30000
TA680167	6	14	50	6	1	neg.	re.	30000
TA680164	6	20	60	6	1	pos.	re.	30000
TA680168	6	14	50	6	2	pos.	re.	30000
TA680169	6	22	60	6	2	pos.	re.	30000
TA680165	8	25	75	8	1	pos.	re.	30000





TURBEX Finishing Spiral Cutter – Glazing Bead Removal

Application

- For grooving, sizing and cutting
- Suitable for ramping (angled plunging)
- Specially designed for separation cuts in window manufacturing (glazing bead removal)
- For low material removal volumes at medium feed rates

Materials

- Solid wood, wood-based and panel materials
- Particleboard and fibreboard materials (chipboard, MDF, HDF, etc.), uncoated
- Mineral materials (Corian, Varicor, etc.)
- For melamine-resin and paper-faced, HPL- and foil-coated, veneered wood-based materials
- Various plastics

Machines

- Hand routers with or without CNC control
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Technical Information

- Solid carbide
- MAN

Art. No.	D	SL	L	d1	Z	DW	DR	n max
TB682130	6	30	70	8	1	pos.	re.	30000
TB682131	6	30	90	8	1	pos.	re.	30000
TB682132	8	35	80	8	1	pos.	re.	30000
TB682133	8	35	110	10	1	pos.	re.	30000
TB682134	10	35	120	12	1	pos.	re.	30000

Kanefusa Finishing Spiral Cutter Up & Down

Application

- For grooving, sizing and cutting
- Suitable for ramping (angled plunging)
- For maximum surface quality requirements
- For low material removal volumes at medium feed rates

Materials

- Solid wood
- Mineral materials (Corian, Varicor, etc.)
- Various plastics
- Aluminium
- Acrylic (Plexiglas)

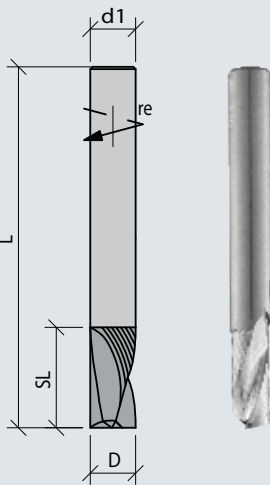
Machines

- Hand routers with or without CNC control
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Technical Information

- Solid carbide
- Improved chip evacuation due to polished flutes
- Smooth cutting action due to alternating helix angle (up- & down-cut)
- MAN

Art. No.	D	SL	L	d1	Z	DW	DR	n max
TB680703	4	10	60	4	2	pos./neg.	re.	30000
TB680704	6	15	70	6	2	pos./neg.	re.	30000
TB680705	10	20	80	10	2	pos./neg.	re.	30000
TB680706	12	30	85	12	2	pos./neg.	re.	30000



TURBEX Sprint Spiral Cutter MAX – Lock Case Milling

Application

- For grooving, sizing and cutting
- Suitable for ramping (angled plunging)
- For lock case and faceplate milling

Materials

- Solid wood
- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated
- Melamine- and paper-faced, HPL- and foil-laminated, veneered wood-based panels

Machines

- Machining centres
- Special milling machines with milling spindles for shank-type tools

Technical Information

- Solid carbide
- Sprint tooth geometry for reduced cutting forces
- Improved chip evacuation due to optimized flutes
- Peripheral and end cutting
- Extended resharpening zone
- Design with negative helix angle for maximum stability
- MEC

Art. No.	D	SL	NUL	L	d1	Z	DW	DR	n max
TB682100	12	25	115	155	12	3	pos.	re.	24000
TB682101	14,5	25	105	150	16	3	pos.	re.	24000
TB682102	14,5	25	105	150	16	3	neg.	re.	24000
TB682103	14,5	25	125	175	16	3	pos.	re.	24000
TB682104*	14,5	25	125	175	16	3	pos.	re.	24000
TB682105	14,5	25	125	175	16	3	neg.	re.	24000
TB682106	14,5	25	140	190	16	3	pos.	re.	24000
TB682107	14,5	25	140	190	16	3	neg.	re.	24000
TB682108	16	25	105	150	16	3	pos.	re.	24000
TB682109	16	25	105	150	16	3	neg.	re.	24000
TB682110	16	25	125	175	16	3	pos.	re.	24000
TB682111	16	25	125	175	16	3	neg.	re.	24000

* with clamping surface for Homag and Weeke milling unit

TURBEX Profile Spiral Cutter – Interchangeable Rebate

Application

- For secondary trimming in interchangeable rebate milling operations in window manufacturing

Materials

- Solid wood, wood-based materials and panels

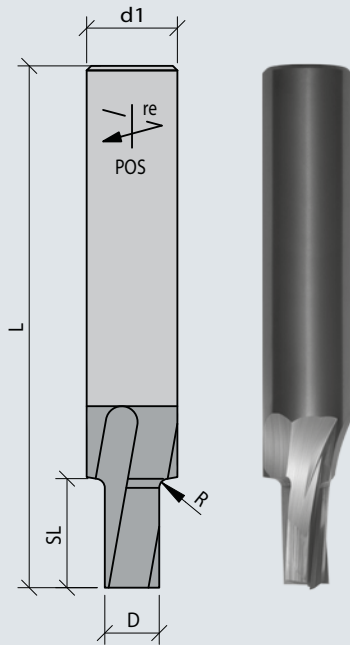
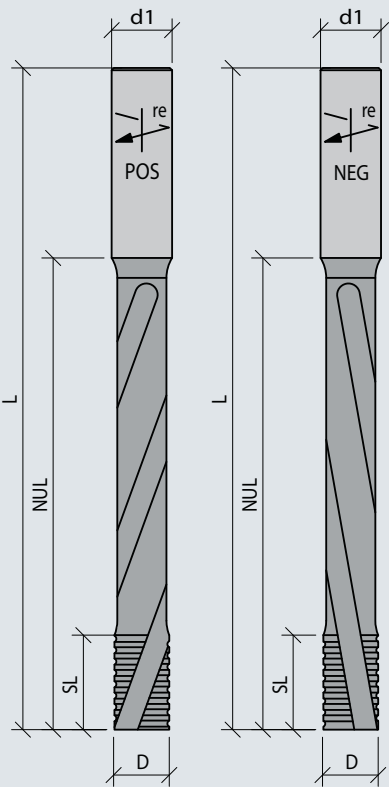
Machines

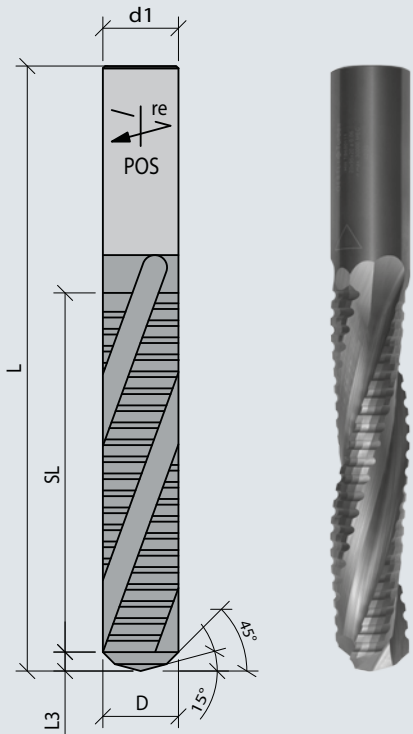
- Hand routers with or without CNC control
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Technical Information

- Solid carbide
- Positive helix angle for improved surface quality and extended tool life
- With end grinding
- MEC

Art. No.	D	R	SL	L	d1	Z	DW	DR	n max
TB682140	12	2	16,5	115	20	3	pos.	re.	30000
TB682141	12	2,5	16,5	115	20	3	pos.	re.	30000
TB682142	12	1,5	24	115	20	3	pos.	re.	30000
TB682143	12	2	24	115	20	3	pos.	re.	30000
TB682144	12	1,5	30	115	20	3	pos.	re.	30000
TB682145	12	2	30	115	20	3	pos.	re.	30000





TURBEX Drilling Spiral Cutter

Application

- For circular milling of handle holes
- For milling lock cylinders
- For milling light cut-outs

Materials

- Solid wood, wood-based materials and panels

Machines

- Gantry CNC router
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Technical Information

- Solid carbide
- Sprint tooth geometry for reduced cutting forces
- Flat drill point for circular plunging
- Positive upcut helix
- MEC

Art. No.	D	SL	L3	L	d1	Z	DW	DR	n max
TB680121	12	70	2	120	12	3	pos.	re.	30000
TB680122	16	80	4	140	16	3	pos.	re.	30000
TB680111	20	95	5	160	20	3	pos.	re.	30000

TURBEX Drilling Spiral Cutter MAX

Application

- For circular milling of peephole openings
- For circular milling of handle holes
- For milling lock cylinders
- For milling light cut-outs
- For large material removal volumes at maximum feed rates

Materials

- Solid wood
- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated
- Melamine- and paper-faced, HPL- and foil-laminated, veneered wood-based materials

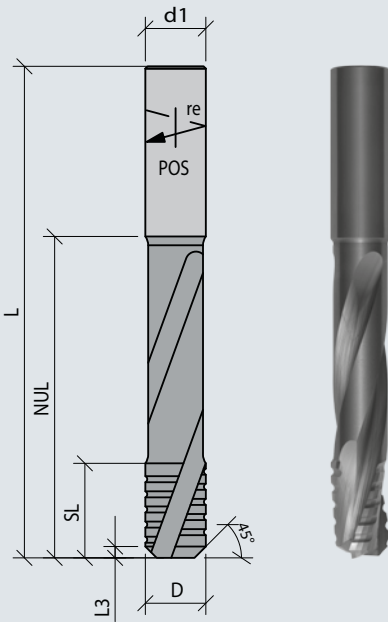
Machines

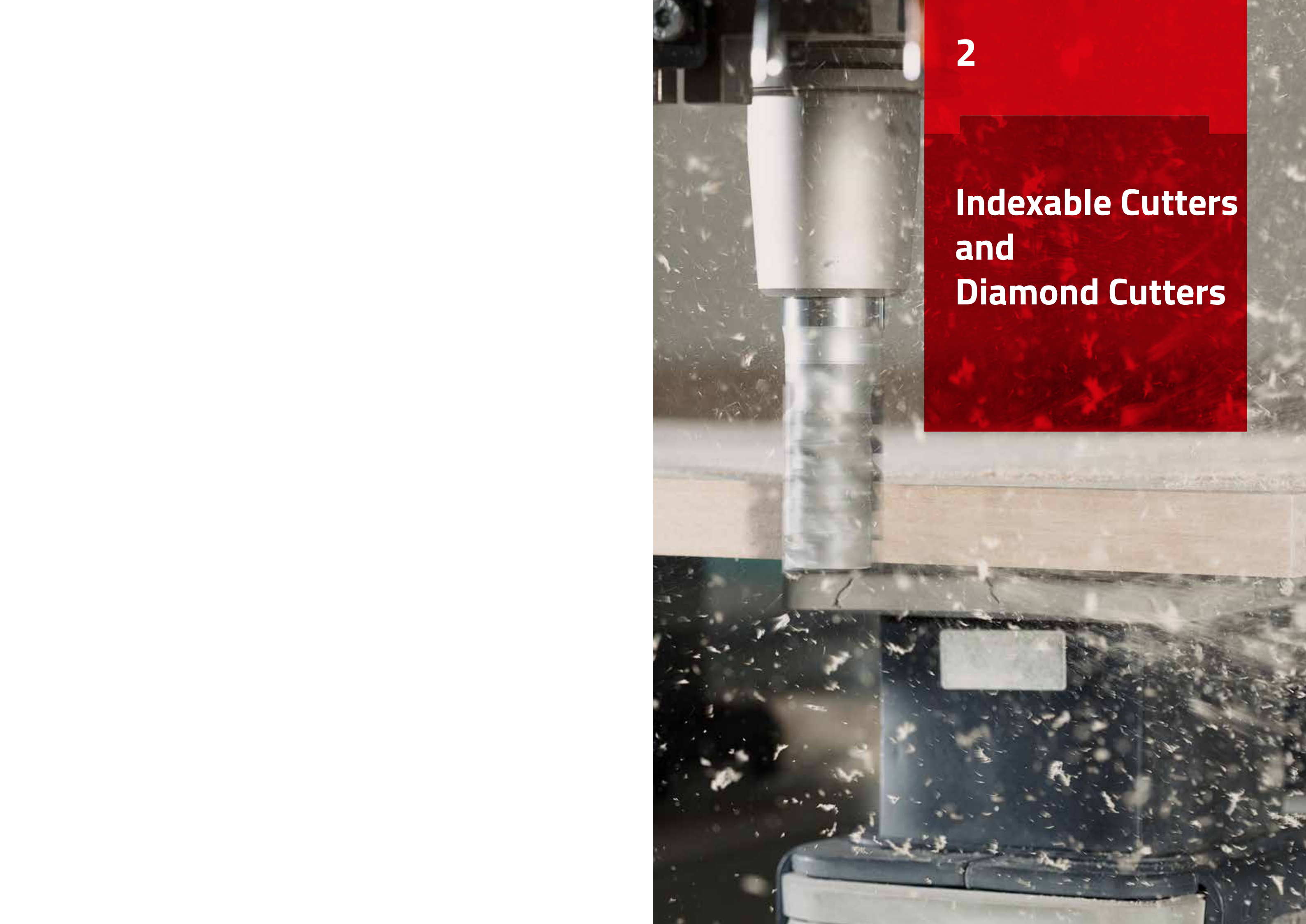
- Gantry CNC router
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Technical Information

- Solid carbide
- Sprint tooth geometry for reduced cutting forces
- Flat drill point for circular plunging
- Positive upcut helix
- MEC

Art. No.	D	SL	NUL	L3	L	d1	Z	DW	DR	n max
TB680112	7,5	15	75	1	110	8	2	pos.	re.	24000
TB680113	10	20	75	1	110	10	2	pos.	re.	24000
TB680114	12	25	75	1	120	12	3	pos.	re.	24000
TB680115	12	25	95	1	140	12	3	pos.	re.	24000
TB680116	14	25	75	3	120	14	3	pos.	re.	24000
TB680117	14	25	95	3	140	14	3	pos.	re.	24000
TB680118	16	25	85	3	130	16	3	pos.	re.	24000
TB680119	16	25	105	3	150	16	3	pos.	re.	24000





2

Indexable Cutters and Diamond Cutters

WS Straight Grooving Cutter

Application

- For sizing and grooving with step-free cutting
- For low material removal volumes at medium feed rates
- Suitable for ramping (angled plunging)

Materials

- Wood-based materials and panels

Machines

- Gantry CNC router
- Machining centres
- Special milling machines with milling spindles for shank-type tools

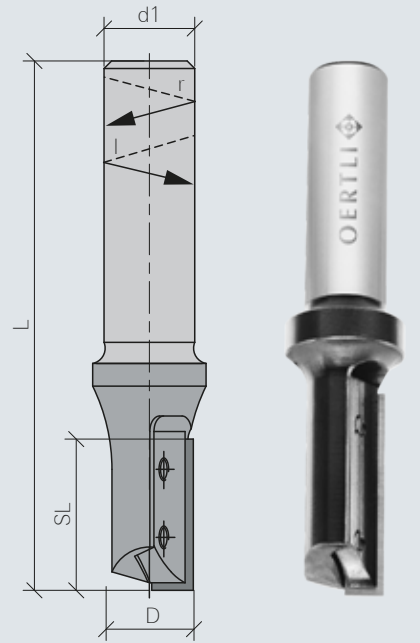
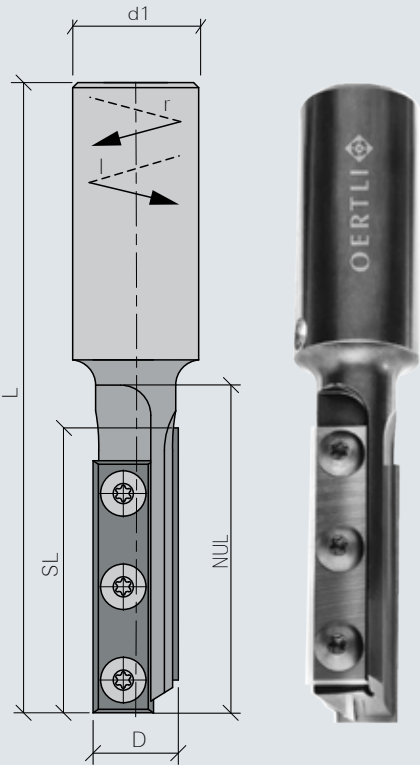
Technical Information

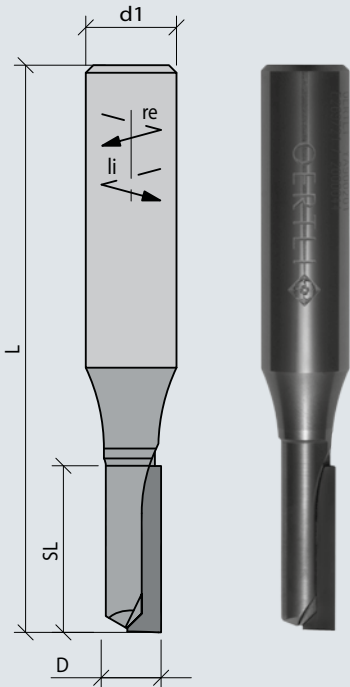
- Indexable carbide insert
- Steel tool body
- Carbide-tipped drilling insert from Ø18 mm
- Straight axial cutting edge arrangement
- Without adjustment screw
- MEC

Art. No.	D	SL	NUL	L	d1	Z	DR	n max	Index
TA670530	8	20		70	12	1	re.	24000	1
TA670531	10	25		75	12	1	re.	24000	2
TA670532	12	30		80	12	1	re.	24000	3
TA670534	12	30		80	12	1	li.	24000	4
TA670644	16	50		116	25	1	re.	24000	5
TB860604	18	55	75	130	25	2	re.	18000	6
TB860603	18	55	75	130	25	2	li.	18000	7
TA680022	20	55	65	125	25	2	re.	18000	8

Spare parts

Art. No.	Detail	Index
TA217700	Replaceable carbide knife, B=20 h=4.1	1
TA217704	Replaceable carbide knife, B=25 h=5.5	2
TA217702	Replaceable carbide knife, B=30 h=5.5	3,4
TA217703	Replaceable carbide knife, B=50 h=5.5	5
TA217707	Replaceable carbide knife, B=50 h=12	6,7,8
TA219742	Replaceable carbide knife, B=12 h=12	5
TA851601	Screw M2.5x3.0 T8 for B=20	1
TA851602	Screw M2.5x4.0 T8 for B=25	2
TA851603	Screw M3.0x7.0 T8 for B=30	3,4
TA851604	Screw M3.5x5.5 T15 for B=50	5
TA851606	Screw M4x6 T15	5,6,7,8





DP Cutting Cutter-L BASE

Application

- For sizing and grooving with step-free cutting
- Suitable for ramping (angled plunging)

Machines

- Gantry CNC router
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Materials

- Particleboard and fibreboard materials (chipboard, MDF, etc.), uncoated
- Melamine- and paper-faced, HPL- and foil-laminated, veneered wood-based materials
- Various plastics and aluminium
- Solid wood

Technical Information

- Diamond-tipped
- Tool body made of solid carbide (VHW)
- Peripheral cutting edges and drilling cutting edge made of DP
- Straight axial cutting edge arrangement
- Without adjustment screw
- MEC

Art.No.	D	SL	L	d1	Z	ZH	DR	n max
TB681050	4	12	70	8	1	1,6	re.	24000
TB680540	5	12	70	10	1	1,9	re.	24000
TB681051	6	7	50	6	1	2	re.	24000
TA680247	6	12	70	12	1	2	re.	24000
TB681052	6	12	70	12	1	2	li.	24000
TA680248	8	12	70	12	1	2,5	re.	24000
TB681053	8	22	75	12	1	2,5	re.	24000
TB681054	8	22	75	12	2	2,5	re.	24000
TB681055	10	22	75	12	1	2,8	re.	24000
TB681056	10	22	75	12	2	2,8	re.	24000
TB681057	10	22	75	12	2	2,8	li.	24000

DP Cutting Cutter-S BASE

Application

- For sizing and grooving with extended tool life
- For tear-free cutting edges on both sides
- Suitable for axial and ramping (angled plunging)
- Z 2+2 for increased feed rates
- For small and medium batch sizes
- For paint-ready cuts in MDF; post-processing with tools featuring continuous cutting edges required

Machines

- Gantry CNC router
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Werkstoff

- Particleboard and fibreboard materials (chipboard, MDF, etc.), uncoated
- Melamine- and paper-faced, HPL- and foil-laminated, veneered wood-based materials

Technical Information

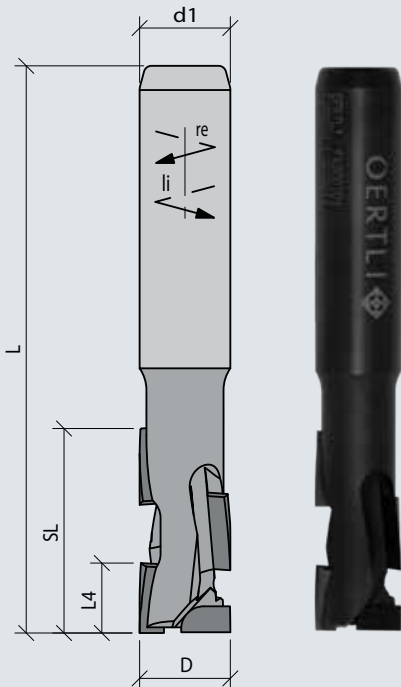
- Diamond-tipped
- Steel tool body
- Blackened tool body
- Peripheral cutting edges and drilling cutting edge made of DP
- Inward-pulling cutting action
- Resharpenable several times
- Without adjustment screw
- MEC

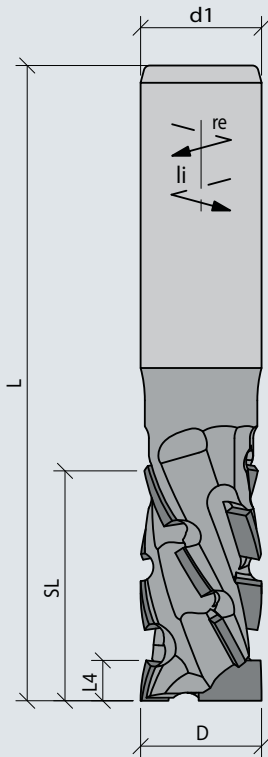
Z=1

Art. No.	D	SL	L4	L	d1	Z	ZH	DR	n max
TB681032	8	27	9	70	12	1	2,4	re.	24000
TB681033	8	27	9	70	12	1	2,4	li.	24000
TB681034	10	26	9,4	70	12	1	2,6	re.	24000
TB681035	12	26	9,2	75	12	1	2,6	re.	24000
TB681036	12	26	9,2	75	12	1	2,6	li.	24000
TB681037	16	26	9,2	80	16	1	2,6	re.	24000
TB681038	16	26	9,2	80	16	1	2,6	li.	24000
TB681039	16	35	9,2	90	16	1	2,6	re.	24000
TB681040	16	35	9,2	90	16	1	2,6	li.	24000
TB681041	18	26	9,2	90	20	1	2,6	re.	24000
TB681042	18	26	9,2	90	20	1	2,6	li.	24000
TB681043	18	35	9,2	100	20	1	2,6	re.	24000
TB681044	18	35	9,2	100	20	1	2,6	li.	24000
TB681045	18	43	9,2	115	25	1	2,6	re.	24000
TB681046	18	43	9,2	115	25	1	2,6	li.	24000
TB681047	20	26	9,2	95	25	1	2,6	re.	24000
TB681048	20	52	9,2	120	25	1	2,6	re.	24000
TB681049	20	52	9,2	120	25	1	2,6	li.	24000

Z=2

Art. No.	D	SL	L4	L	d1	Z	ZH	DR	n max
TB681058	16	31	6,4	90	16	2	2,6	re.	24000
TB681059	16	31	6,4	90	16	2	2,6	li.	24000
TB681060	20	39	8	95	20	2	2,6	re.	24000
TB681061	20	39	8	95	20	2	2,6	li.	24000
TB681062	20	54	8	115	20	2	2,6	re.	24000
TB681063	20	54	8	115	20	2	2,6	li.	24000
TB681064	25	66	7,4	130	25	2	2,6	re.	24000
TB681065	25	66	7,4	130	25	2	2,6	li.	24000





DP Cutting Cutter-S PRO

Application

- For sizing and grooving with extended tool life
- For tear-free cutting edges on both sides
- Suitable for axial and ramping (angled plunging)
- For large material removal volumes at high feed rates
- For paint-ready cuts in MDF; post-processing with tools featuring continuous cutting edges required

Machines

- Gantry CNC router
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Materials

- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated
- Melamine- and paper-faced, HPL- and foil-laminated, veneered wood-based materials
- Laminated wood materials (plywood, multi-plex, etc.)

Technical Information

- Diamond-tipped
- Steel body, nickel-plated
- Peripheral cutting edges and drilling cutting edge made of DP
- Smooth cutting action due to 4-flute cutting edge arrangement
- Optimal cutting quality due to helix angle with upcut and downcut action
- Continuous full diamond coating for maximum sharpening zone
- Without adjustment screw
- MEC

Art.No.	D	SL	L4	L	d1	Z	ZH	DR	n max
TB681073	16	31	6,6	95	20	2	4,4	re.	24000
TB681074	16	31	6,6	95	20	2	4,4	li.	24000
TB681075	20	38	6,6	105	20	2	4,4	re.	24000
TB681076	20	38	6,6	105	20	2	4,4	li.	24000
TB681077	25	49	6,8	120	25	2	4,5	re.	24000
TB681078	25	49	6,8	120	25	2	4,5	li.	24000

DP Cutting Cutter-S MAX

Application

- For sizing and grooving with extended tool life
- For tear-free cutting edges on both sides
- Suitable for axial and ramping (angled plunging)
- For large material removal volumes at maximum feed rates
- For paint-ready cuts in MDF; post-processing with tools featuring continuous cutting edges required

Machines

- Gantry CNC router
- Machining centres
- Special milling machines with milling spindles for shank-type tools

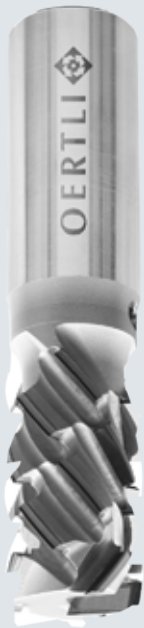
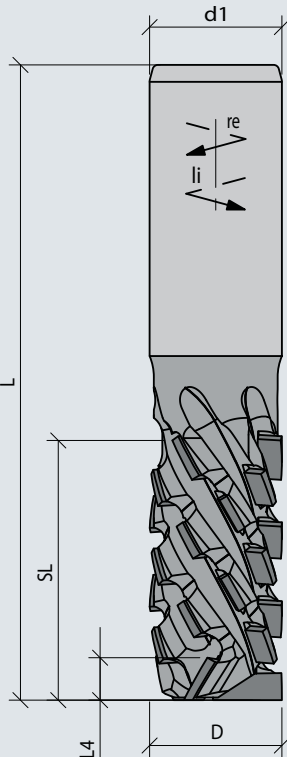
Materials

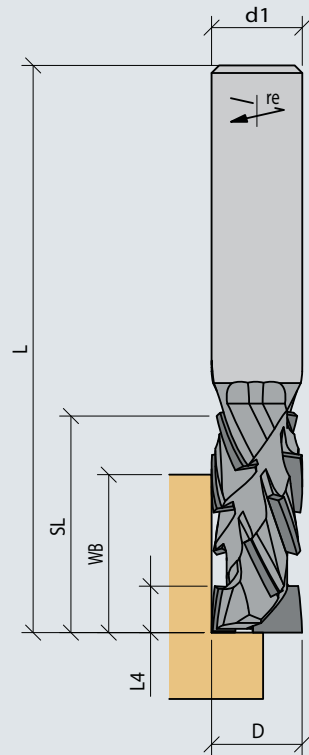
- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated
- Melamine- and paper-faced, HPL- and foil-laminated, veneered wood-based materials
- Laminated wood materials (plywood, multi-plex, etc.)
- Solid wood

Technical Information

- Diamond-tipped
- Heavy-metal tool body
- Peripheral cutting edges and drilling cutting edge made of DP
- Smooth cutting action due to 4-flute cutting edge arrangement
- Optimal cutting quality due to helix angle with upcut and downcut action
- Continuous full diamond coating for maximum sharpening zone
- Without adjustment screw
- MEC

Art. No.	D	SL	L4	L	d1	Z	ZH	DR	n max
TB681066	12	23	6,1	75	16	2	3	re.	24000
TB681067	12	28	6,1	75	16	2	3	re.	24000
TB681068	16	31	6,6	95	20	2	4,4	re.	24000
TB681069	16	31	6,6	95	20	2	4,4	li.	24000
TB681070	20	38	6,6	100	20	2	4,4	re.	24000
TB681071	20	38	6,6	100	20	2	4,4	li.	24000
TB680535	25	49	8	120	25	3	4,5	re.	24000
TB681072	25	49	8	120	25	3	4,5	li.	24000





DP Cutting Cutter-S BASE Nesting

Application

- For panel cutting in nesting processes
- Grooving, sizing, cutting (nesting) and rebating
- For tear-free cutting edges on both sides
- Suitable for axial and ramping (angled plunging)
- For increased feed rates
- Z = 2 with large chip spaces for improved chip evacuation (MDF) and reduced heat build-up, especially when machining multiplex
- Particularly suitable for small or narrow workpieces

Machines

- Gantry CNC router
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Materials

- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated
- Melamine- and paper-faced, HPL- and foil-laminated, veneered wood-based materials
- Especially suitable for laminated wood materials (plywood, multiplex, etc.)

Technical Information

- Diamond-tipped
- Solid carbide tool body (VHW)
- Peripheral cutting edges and drilling cutting edge made of DP
- Improved chip evacuation due to optimized chip spaces
- Optimal cutting quality due to helix angle with upcut and downcut action
- Without adjustment screw
- MEC

Art. No.	D	SL	L4	L	d1	WBmin	WBmax	Z	ZH	DR	n max
TB681112	12	23	6,1	75	12	8	20	2	3	re.	24000
TB681113	12	28	6,1	75	12	8	25	2	3	re.	24000

DP Cutting Cutter-S PRO Nesting

Application

- For panel cutting in nesting processes
- Grooving, sizing, cutting (nesting) and rebating
- For tear-free cutting edges on both sides
- Suitable for axial and ramping (angled plunging)
- For increased feed rates
- Z = 2 with large chip spaces for improved chip evacuation (MDF) and reduced heat build-up, especially when machining multiplex
- Particularly suitable for small or narrow workpieces

Machines

- Gantry CNC router
- Machining centres
- Special milling machines with milling spindles for shank-type tools

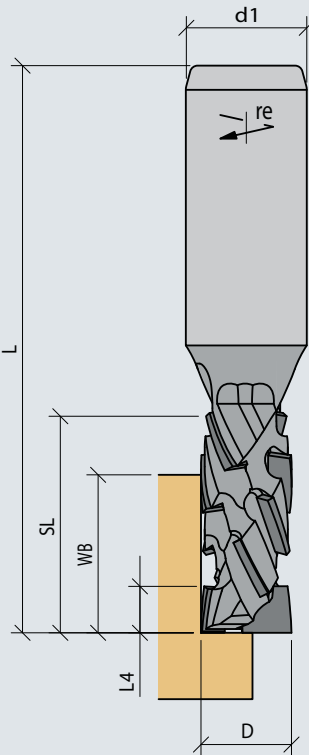
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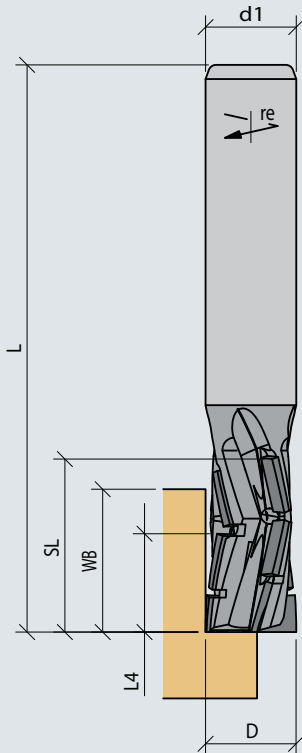
- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated
- Melamine- and paper-faced, HPL- and foil-laminated, veneered wood-based materials
- Especially suitable for laminated wood materials (plywood, multiplex, etc.)

Technical Information

- Diamond-tipped
- Heavy-metal tool body
- Optimized smooth running due to heavy-metal body
- Peripheral cutting edges and drilling cutting edge made of DP
- Improved chip evacuation due to optimized chip spaces
- Optimal cutting quality due to helix angle with upcut and downcut action
- Without adjustment screw
- MEC

Art. No.	D	SL	L4	L	d1	WBmin	WBmax	Z	ZH	DR	n max
TB681110	12	23	6,1	75	16	8	20	2	3	re.	24000
TB681111	12	28	6,1	75	16	8	25	2	3	re.	24000





DP Cutting Cutter-S MAX Nesting

Application

- For panel cutting in nesting processes
- Grooving, sizing, cutting (nesting) and rebating
- For tear-free cutting edges on both sides
- Suitable for axial and ramping (angled plunging)
- Particularly suitable for small or narrow workpieces
- Z = 4 and Z = 3 for maximum feed rates

Materials

- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated
- Melamine- and paper-faced, HPL- and foil-laminated, veneered wood-based materials

Machines

- Gantry CNC router
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Technical Information

- Diamond-tipped
- Heavy-metal tool body
- Optimized smooth running due to heavy-metal body
- Peripheral cutting edges and drilling cutting edge made of DP
- Improved chip evacuation due to optimized chip spaces
- Optimal cutting quality due to helix angle with upcut and downcut action
- Without adjustment screw
- MEC

Art. No.	D	SL	L4	L	d1	WBmin	WBmax	Z	ZH	DR	n max
TB681114	12	23	14,8	75	12	16	19	4	3	re.	24000
TB681296	12	23,5	6,5	70	12	8	20	3	2,7	re.	24000
TB681297	12	23,5	6,5	75	16	8	20	3	2,7	re.	24000
TB681294	12	30	6,5	80	12	8	28	3	2,7	re.	24000
TB681295	12	30	6,5	80	16	8	28	3	2,7	re.	24000
TB681298	14	30	6,5	80	16	8	28	3	2,7	re.	24000

DP Cutting Cutter-S PRO Nesting Fibre Cement

Application

- For panel cutting in nesting processes
- Grooving, sizing, cutting (nesting) and rebating
- For tear-free cutting edges on both sides
- Suitable for axial and ramping (angled plunging)
- Particularly suitable for small or narrow workpieces
- For maximum feed rates

Materials

- Fibre-cement panels
- Eternit

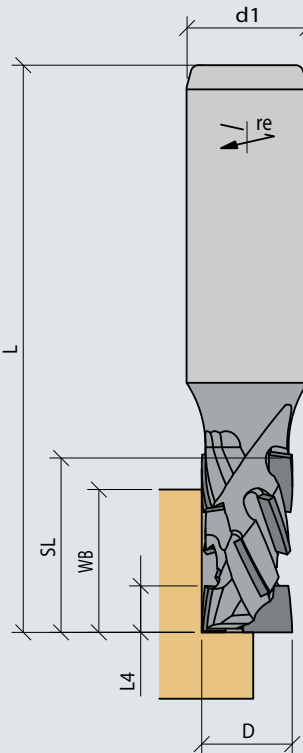
Machines

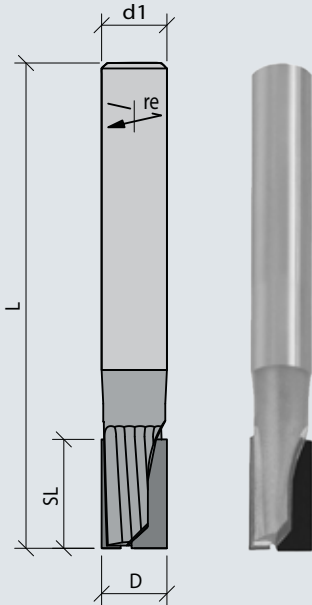
- Gantry CNC router
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Technical Information

- Diamond-tipped
- Heavy-metal tool body
- Optimized smooth running due to heavy-metal body
- Peripheral cutting edges and drilling cutting edge made of DP
- Optimal cutting quality due to helix angle with upcut and downcut action
- Without adjustment screw
- MEC

Art. No.	D	SL	L4	L	d1	WBmin	WBmax	Z	ZH	DR	n max
TB680500	12	15	4,6	70	16	6	12	3	3	re.	24000





DP Cutting Cutter-L PRO

Application

- For sizing and grooving with step-free cutting
- Suitable for ramping (angled plunging)
- Finishing, grooving, sizing, cutting (nesting) and rebating
- Z=3 For maximum feed rates

Machines

- Gantry CNC router
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Materials

- For wood-based materials, solid wood and plastics
- Especially for machining plastic solid-core panels (e.g. Trespa®, Corian®, Varicor®, LG-Hi-Macs®, etc.)
- Particularly abrasive workpiece materials

Technical Information

- Diamond-tipped
- Tool body made of solid carbide (VHW)
- Peripheral cutting edges and drilling cutting edge made of DP
- Smooth cutting action due to alternating helix angles
- Continuous full diamond coating for maximum resharpening zone
- Without adjustment screw
- MEC

Art. No.	D	SL	L	d1	Z	ZH	DR	n max
TB680646	6	15	65	6	2	2	re.	24000
TB685187	8	15	65	8	2	2,8	re.	24000
TB685188	10	15	75	10	2	2,8	re.	24000
TB680647	12	15	70	12	3	3,2	re.	24000
TB685189	12	20	75	12	2	3,2	re.	24000
TB680648	12	25	80	12	3	3,2	re.	24000
TB680649	16	20	80	16	3	4,3	re.	24000
TB685186	16	25	80	16	2	4,3	re.	24000
TB680650	16	30	85	16	3	4,3	re.	24000

DP Roughing Cutter-L PRO

Application

- For pre-sizing and grooving in roughing quality
- Suitable for ramping (angled plunging)
- Grooving, sizing, cutting (nesting) and rebating

Machines

- Gantry CNC router
- Machining centres
- Special milling machines with milling spindles for shank-type tools

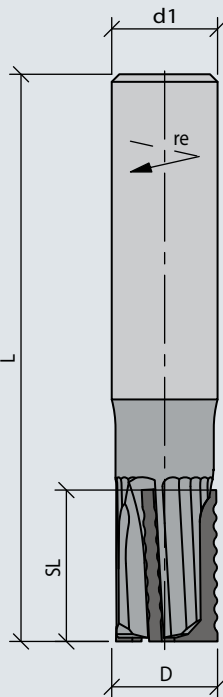
Materials

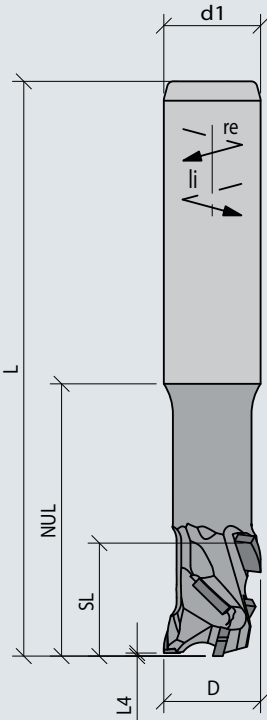
- For wood-based materials, solid wood and plastics
- Especially for machining plastic solid-core panels (e.g. Trespa®, Corian®, Varicor®, LG-Hi-Macs®, etc.)
- Particularly abrasive workpiece materials

Technical Information

- Diamond-tipped
- Tool body made of solid carbide (VHW)
- Peripheral cutting edges and drilling cutting edge made of DP
- Smooth cutting action due to alternating helix angles
- Roughing tooth geometry for increased chip volume and reduced cutting forces
- Continuous full diamond coating for maximum resharpening zone
- Without adjustment screw
- MEC

Art. No.	D	SL	L	d1	Z	ZH	DR	n max
TB680651	14	20	75	14	3	4	re.	24000
TB680652	16	30	85	16	3	4,3	re.	24000





DP Pocket Cutter-S BASE

Application

- For tear-free machining of grooves, recesses and pockets
- Suitable as a faceplate slave sash cutter
- Suitable for ramping or circular plunging

Machines

- Gantry CNC router
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Materials

- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated
- Melamine- and paper-faced, HPL- and foil-laminated, veneered wood-based panels
- Laminated wood (plywood, multiplex, etc.)
- Solid wood

Technical Information

- Diamond-tipped
- Steel tool body
- Nickel-plated tool body
- Peripheral cutting edges and drilling cutting edge made of DP
- Minimum groove depth 0.6 mm
- Optimum edge quality due to extreme axial angle, cutting from top (up-cut)
- Without adjustment screw
- MEC

Art. No.	D	SL	NUL	L4	L	d1	Z	ZH	DR	n max
TB681079	12	11,5	26,5	0,5	70	16	1	2,5	re.	24000
TB681080	12	11,5	26,5	0,5	70	16	1	2,5	li.	24000
TB681081	16	18	45	0,5	95	16	1	3	re.	24000
TB681082	16	18	45	0,5	95	16	1	3	li.	24000
TB681083	18	22,2	58	0,5	110	20	1	3	re.	24000
TB681084	18	22,2	58	0,5	110	20	1	3	li.	24000

DP Pocket Cutter-L PRO

Application

- For tear-free machining of grooves, recesses and pockets
- Suitable as a faceplate (stulp) cutter
- Suitable for ramping or circular plunging
- Especially for ABS edging

Machines

- Gantry CNC router
- Machining centres
- Special milling machines with milling spindles for shank-type tools

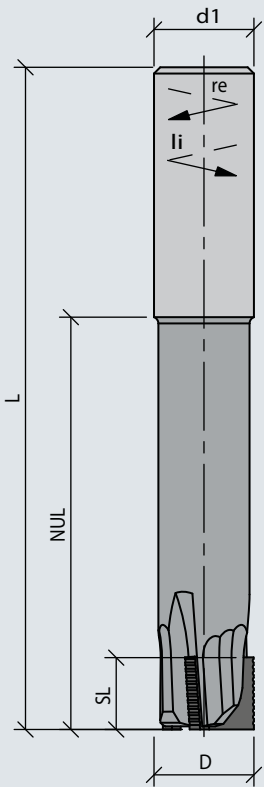
Materials

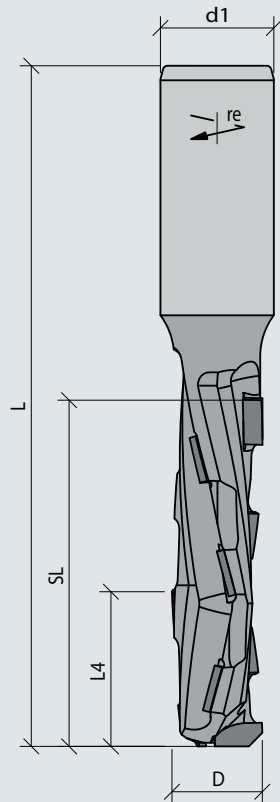
- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated
- Melamine- and paper-faced, HPL- and foil-laminated, veneered wood-based panels
- Laminated wood (plywood, multiplex, etc.)
- Solid wood
- Especially for ABS edging

Technical Information

- Diamond-tipped
- Tool body made of solid carbide (VHW)
- Peripheral cutting edges and drilling cutting edge made of DP
- Smooth cutting action due to alternating axial angles
- Continuous full diamond tipping for maximum resharpening zone
- Special roughing geometry
- Without adjustment screw
- MEC

Art. No.	D	SL	NUL	L	d1	Z	ZH	DR	n max
TB681299	10	22,5	35	77	12	3	3	re.	24000
TB681300	12	11,5	35	76	12	3	3,5	re.	24000
TB681301	12	11,5	35	76	12	3	3,5	li.	24000
TB681302	12	11,5	35	78	16	3	3,5	re.	24000
TB681303	12	11,5	35	78	16	3	3,5	li.	24000
TB681304	12	22,2	55	96	12	3	3,5	re.	24000
TB681305	16	11,5	65	106	16	3	3,5	re.	24000
TB681306	16	11,5	65	106	16	3	3,5	li.	24000
TB681307	16	22,2	55	96	16	3	3,5	re.	24000
TB681308	16	22,2	55	96	16	3	3,5	li.	24000





DP Drill / Cutting Cutter-S MAX Z1

Application

- For drilling and circular milling of handle holes
- For milling out lock cylinders
- For milling light cut-outs
- Suitable for angled or circular plunging

Materials

- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated
- Melamine- and paper-faced, HPL- and foil-la-minated, veneered wood-based panels
- Laminated wood (plywood, multiplex, etc.)
- For various door blank constructions

Machines

- Gantry CNC router
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Technical Information

- Diamond-tipped
- Tool body made of heavy metal
- Peripheral cutting edges and drilling cutting edge made of DP
- Optimized smooth running due to heavy metal tool body
- Improved chip evacuation due to optimized flutes
- Without adjustment screw
- MEC

Art. No.	D	SL	L4	L	d1	Z	ZH	DR	n max
TB680523	20	85	34,5	150	25	1	4,2	re.	24000
TB680522	22	85	34,5	150	25	1	4,2	re.	24000

DP Drill / Cutting Cutter-S MAX Z2

Application

- For circular milling of handle holes
- For milling out lock cylinders
- For milling light cut-outs
- Suitable as a faceplate (stulp) cutter
- Suitable for angled or circular plunging

Materials

- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated
- Melamine- and paper-faced, HPL- and foil-la-minated, veneered wood-based panels
- Laminated wood (plywood, multiplex, etc.)
- For various door blank constructions

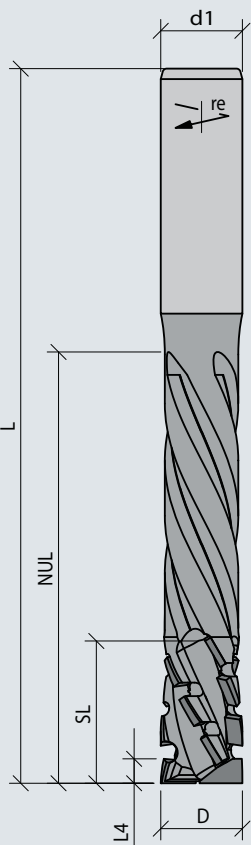
Machines

- Gantry CNC router
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Technical Information

- Diamond-tipped
- Tool body made of heavy metal
- Peripheral cutting edges and drilling cutting edge made of DP
- Optimized smooth running due to heavy metal tool body
- Improved chip evacuation due to optimized flutes
- Without adjustment screw
- MEC

Art.No.	D	SL	NUL	L4	L	d1	Z	ZH	DR	n max
TB681086	16	24,6	45	6,6	110	20	2	4,4	re.	24000
TB681087	18	35	80	6	130	20	2	4,4	re.	24000
TB681088	20	35	105	6	160	20	2	4,4	re.	24000



CASTOR Optimo Jointing and Rebating Cutter

Application

- For pre-milling, jointing and sizing
- For rebating and grooving
- For large material removal volumes at maximum feed rates

Materials

- Solid wood, cross-grain and longitudinal
- Wood-based and panel materials

Machines

- CNC machining centres
- Gantry CNC router
- Special milling machines with milling spindles for shank-type tools

Technical Information

- Indexable carbide insert
- Tool body made of aluminium
- Simple knife clamping system
- Face-mounted with bottom scoring cutter
- Straight axial cutting edge arrangement
- Carbide grade H8, optionally available in H6 (harder)
- Arbor, cover and spacer ring not included in the scope of delivery
- MEC

Art. No.	D	B	d	DKN_B	DKN_L	Z	DW	n max	Index
TB860357	80	80	25	8	31,6	2	0°	18000	1
TB860358	80	100	25	8	31,6	2	0°	18000	2

Spare parts

Art. No.	Detail	Index
KF220017	Indexable carbide insert, H8, B=14 h=14	1 - 2
KF220017H6	Indexable carbide insert, H6, B=14 h=14	1 - 2
TA851040	Shoulder screw M5x15.5 T15 for peripheral cutting edge	1 - 2
TB851037	Shoulder screw M5x10.5 T15 for scoring cutter	1 - 2

CASTOR Sprint Drill / Universal Cutter

Application

- For pre-milling, jointing and sizing
- For rebating and grooving
- Suitable for angled or circular plunging
- For large material removal volumes at maximum feed rates

Materials

- Solid wood, cross-grain and longitudinal
- Wood-based and panel materials

Machines

- CNC machining centres
- Gantry CNC router
- Special milling machines with milling spindles for shank-type tools

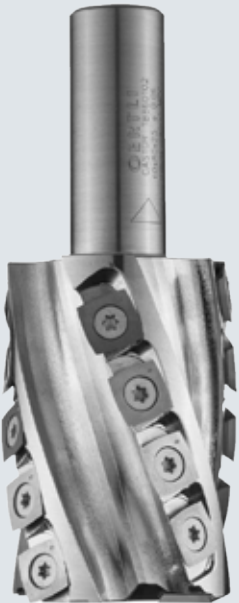
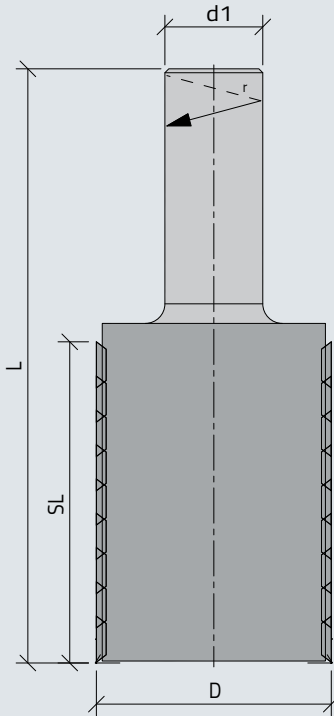
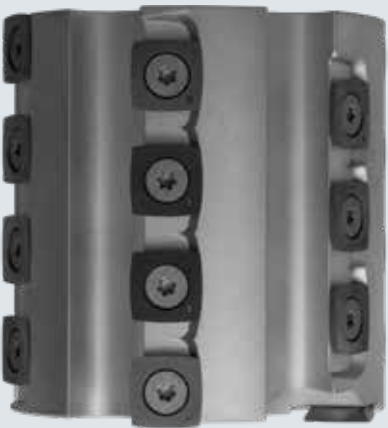
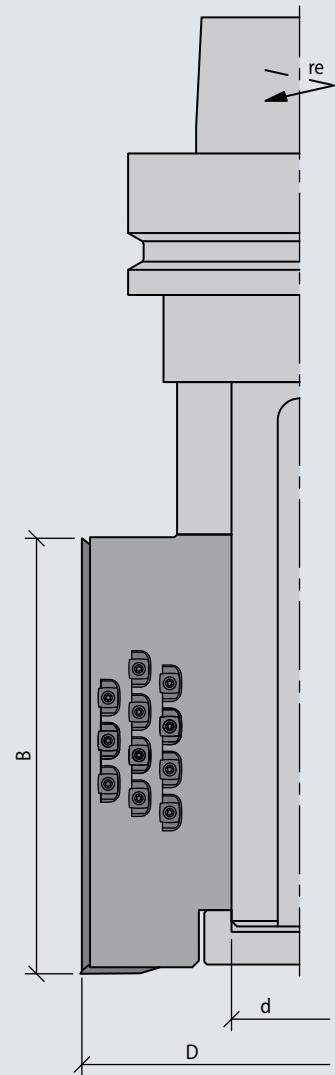
Technical Information

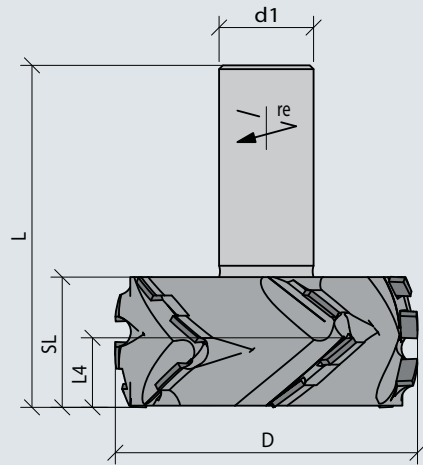
- Indexable carbide insert
- Tool body made of steel
- Simple knife clamping system
- Face-mounted with bottom scoring cutter
- Spiral cutting edge arrangement
- Carbide grade H8, optionally available in H6 (harder)
- With segmented cutting edges to reduce cutting forces
- MEC

Art. No.	D	SL	L	d1	Z	DW	DR	n max	Index
TB860114	45	80	150	20	2	pos.	re.	22500	1
TB860116	50	80	150	20	2	pos.	re.	20000	2
TB860164	61	55	116	25	2	0°	re.	22000	3

Spare parts

Art. No.	Detail	Index
KF220017	Peripheral and face cutting edge, carbide, B=14 h=14	1 - 3
KF216009	Face cutting edge, carbide, B=14 h=14	1
KF216672	Face cutting edge, carbide, B=15 h=15	2
KF216013	Face cutting edge, carbide, B=16 h=16	3
TA851040	Shoulder screw M5x15.5 T15 for peripheral cutting edge KF220017	1 - 3
TA851038	Screw M5x6.3 T15 for face cutting edge KF216009	1
TB851037	Shoulder screw M5x10.5 T15 for face cutting edge KF216672 & KF220017	2,3
TA851032	Shoulder screw M5x11.0 T15 for face cutting edge KF216013	3





DP Jointing Cutter MAX

Application

- For sizing with extended tool life
- For tear-free cutting edges on both sides
- For large material removal volumes at maximum feed rates
- Particularly high performance on veneered wood-based panels
- For maximum feed rate

Machines

- Gantry CNC router
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Materials

- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated
- Melamine- and paper-faced, HPL- and foil-laminated, veneered wood-based panels
- Laminated wood (plywood, multiplex, etc.)
- Solid wood, wood-based and panel materials

Technical Information

- Diamond-tipped
- Tool body made of steel
- Nickel-plated tool body
- Optimum cutting quality due to extreme axial angle, cutting from top and bottom
- Without adjustment screw
- MEC

Art. No.	D	SL	L4	L	d1	Z	ZH	DR	n max
TB300135	80	32	16	90	25	3	4,3	re.	17000
TB300150	80	81,5	39	145	25	3	4,4	re.	17000

DP Jointing and Rebating Cutter MAX

Application

- For sizing and rebating with extended tool life
- For tear-free cutting edges on both sides
- For large material removal volumes at high feed rates

Machines

- Gantry CNC router
- Machining centres
- Special milling machines with milling spindles for shank-type tools

Materials

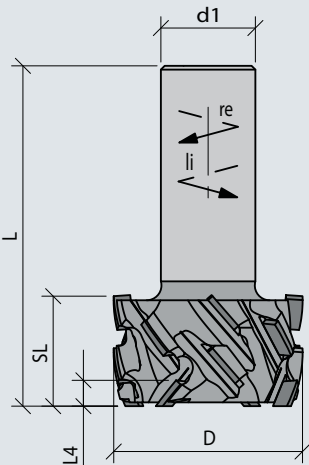
- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated
- Melamine- and paper-faced, HPL- and foil-laminated, veneered wood-based panels
- Laminated wood (plywood, multiplex, etc.)

Technical Information

- Diamond-tipped
- Tool body made of steel
- Nickel-plated tool body
- Peripheral cutting edges and plunge cutting edge made of DP
- High feed rates with good edge quality due to tooth count Z=4 in the top layer
- Optimum cutting quality due to axial angle, cutting from top and bottom
- Without adjustment screw
- MEC

Art. No.	D	SL	L4	L	d1	Z	ZH	DR	n max
TB681026*	50	28	6,8	90	25	4	4,4	li.	24000
TB681027*	50	28	6,8	90	25	4	4,4	re.	24000
TB680602**	50	48	24,8	110	25	4	4,5	re.	24000

*Specially for rabbeting drawer bottoms for Legrabox
** Reduced dust generation due to tooth number Z=2 in the centre position



DP Rebating Cutter Legrabox with HSK63F

Application

- For sizing and tear-free rebating
- Specially designed for Legrabox fittings

Machines

- Gantry CNC router
- CNC machining centres
- Special milling machines with milling spindles for shank-type tools

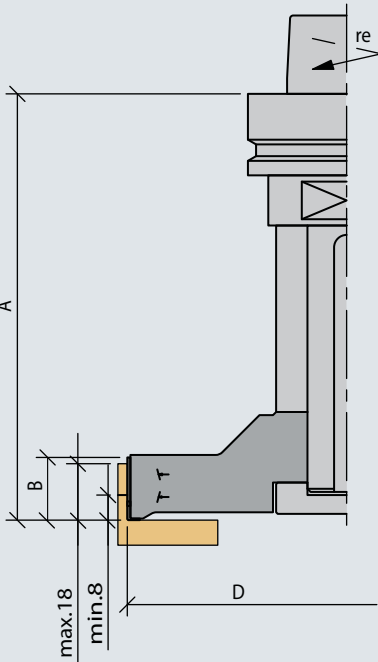
Materials

- Melamine- and paper-faced, HPL- and foil-la-minated, veneered wood-based panels
- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated

Technical Information

- Diamond-tipped
- Tool body made of steel
- Peripheral and end cutting edges
- Optimum edge quality due to extreme axial angle with upward cutting action
- Mounted on HSK63F arbor
- Design in SP technology – bonded
- MEC

Art. No.	D	B	Z	ZH	A	DR	n max
TB681031	140	20	3	3,5	136	re.	12700



DP-WS Plan Shank Cutter

Application

- For face milling of large-area workpieces
- For milling large rebate depths in a single operation
- Negative design, especially suitable for face milling of nesting spoil boards (MDF)

Machines

- Gantry CNC router
- Machining centres

Materials

- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated
- Melamine- and paper-faced, HPL- and foil-la-minated, veneered wood-based panels
- Laminated woods (plywood, multiplex, etc.)
- Solid wood
- Mineral materials (Corian®, Varicor®, etc.)
- Various plastics

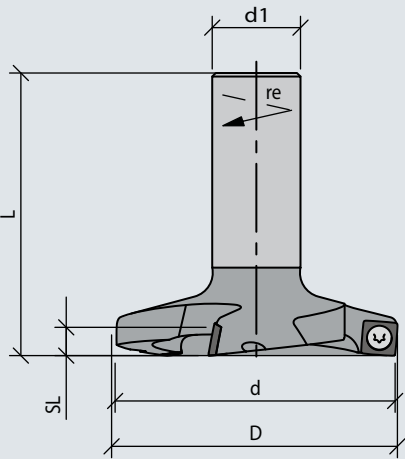
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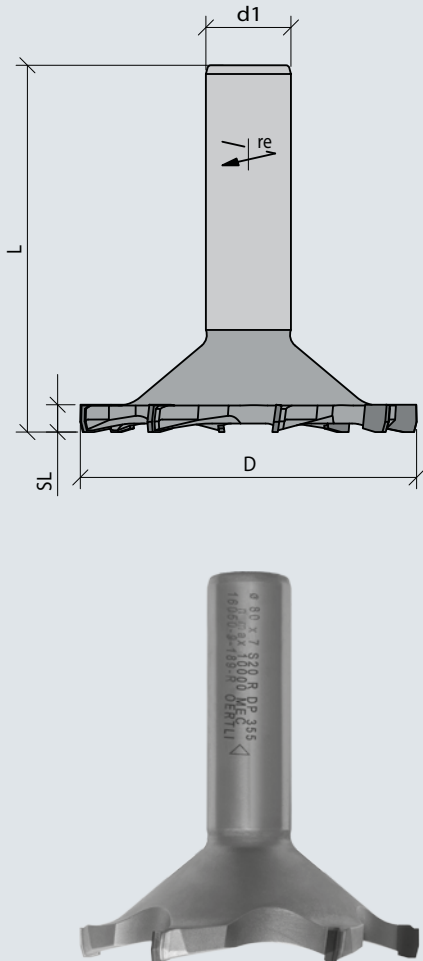
- Diamond-tipped
- Tool body made of steel
- Tool body blackened
- Replaceable DP indexable inserts
- Without adjustment screw
- MEC

Art. No.	D	d	SL	L	d1	Z	DW	DR	n max	Index
TB681096	82	80	8	80	25	3	pos.	re.	12000	1
TB681097	150	150	8	90	25	6	neg.	re.	9000	2

Spare parts

Art. No.	Detail	Index
TB219090	Indexable insert, diamond (DP), B=9.8 h=9.8 a=2	1, 2
TB851070	Screw M4x7.0 Torx 15	1, 2





DP Plan Shank Cutter

Application

- For face milling of large-area workpieces
- For milling large rebate depths in a single operationg

Materials

- Particleboard and fibreboard materials (chip-board, MDF, HDF, etc.), uncoated
- Melamine- and paper-faced, HPL- and foil-laminated, veneered wood-based panels
- Laminated woods (plywood, multiplex, etc.)
- Solid wood
- Mineral materials (Corian®, Varicor®, etc.)
- Various plastics

Machines

- Gantry CNC router
- Machining centres

Technical Information

- Diamond-tipped
- Tool body made of steel
- Tool body nickel-plated
- Without adjustment screw
- MEC

Art. No.	D	SL	L	d1	Z	ZH	DW	DR	n max
TB681098	100	8	90	25	8	6	pos.	re.	10000

WS-PS Chamfer and Rounding Joint Shank Cutter

Application

- For flexible jointing, rounding or chamfering
- Universal use on the top and bottom of the workpiece
- Suitable for milling along tight internal radii on the workpiece
- For optimum surface quality

Materials

- Solid wood, wood-based panels and plastics
- Laminated woods (plywood, multiplex, etc.)

Machines

- Gantry CNC router
- Machining centres

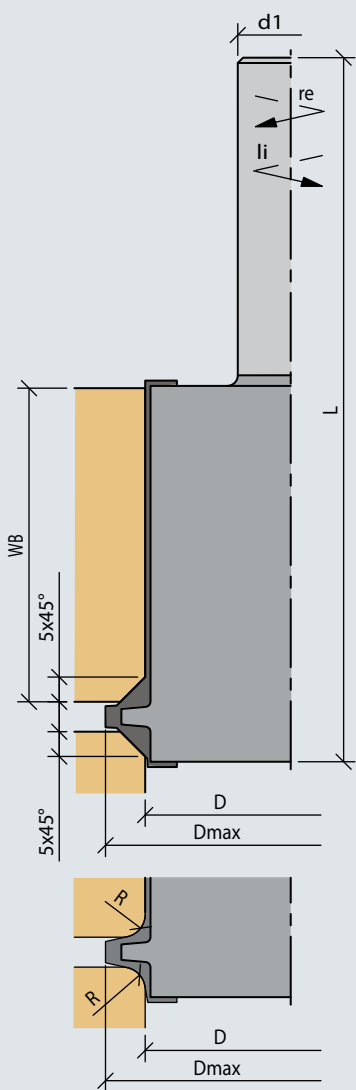
Technical Information

- Carbide profile cutting edges
- Steel body, nickel-plated
- Axial cutting edge arrangement
- A carrier body for radii from R1.5 to R6mm as well as for a 5x45° chamfer
- High spindle speeds for excellent surface finish
- High spindle speeds for maximum feed rates
- Tool is always supplied with 5x45° cutting edge
- MEC

Art. No.	D	Dmax	WBmax	d1	L	Z	DR	n max	Index
TB860175	55	70	60	20	133	2	li.	22000	1
TB860176	55	70	60	20	133	2	re.	22000	2

Spare parts

Art Nr	Detail	Index
KG217060	Indexable insert, carbide H8, B=60 H=8	1,2
KC130446S8	Profile insert CAT, carbide H8, B=20 H=28, 5x45°	1,2
KC130447S8	Profile insert CAT, carbide H8, B=20 H=28, R6	1,2
KC130448S8	Profile insert CAT, carbide H8, B=20 H=28, R5	1,2
LC130449S8	Profile insert CAT, carbide H8, B=20 H=28, R4	1,2
KC130450S8	Profile insert CAT, carbide H8, B=20 H=28, R3	1,2
KC130451S8	Profile insert CAT, carbide H8, B=20 H=28, R2.5	1,2
KC130452S8	Profile insert CAT, carbide H8, B=20 H=28, R2	1,2
KC130453S8	Profile insert CAT, carbide H8, B=20 H=28, R1.5	1,2
TB851272	Clamping jaw CAT, b=17	1,2
TB851407	Clamping jaw CAT reamer, b=60	1,2
TB851016	Set screw M6x16.25, type Torx 15	1,2



WS-PS Rounding and Chamfer Cutter

Application

- For flexible rounding and chamfering
- Universal use
- For optimum surface quality

Materials

- Solid wood, wood-based panels and plastics
- Laminated woods (plywood, multiplex, etc.)
- Plastics

Machines

- Gantry CNC router
- Machining centres

Technical Information

- Carbide profile cutting edges
- Tool body made of steel
- Tool body nickel-plated
- Axial cutting edge arrangement
- A carrier body for radii from R1.5 to R6mm as well as for a 5x45° chamfer
- Flexibly combinable
- Jointing cutter, arbor, cover and spacer rings not included in delivery
- MEC

Art. No.	D	Dmax	d	DKN_L	DKN_B	R	alpha	Z	DR	n max	Index
TB300200	90	105	25	8	31,6		45°	2	re./li.	15400	1
TB300201	90	105	25	8	31,6	6		2	re./li.	15400	2
TB300202	90	105	25	8	31,6	5		2	re./li.	15400	3
TB300203	90	105	25	8	31,6	4		2	re./li.	15400	4
TB300204	90	105	25	8	31,6	3		2	re./li.	15400	5
TB300205	90	105	25	8	31,6	2,5		2	re./li.	15400	6
TB300206	90	105	25	8	31,6	2		2	re./li.	15400	7
TB300207	90	105	25	8	31,6	1,5		2	re./li.	15400	8

Spare parts

Art. No.	Detail	Index
KC130446S8	Profile insert CAT, carbide H8, B=20 H=28, 5x45°	1
KC130447S8	Profile insert CAT, carbide H8, B=20 H=28, R6	2
KC130448S8	Profile insert CAT, carbide H8, B=20 H=28, R5	3
LC130449S8	Profile insert CAT, carbide H8, B=20 H=28, R4	4
KC130450S8	Profile insert CAT, carbide H8, B=20 H=28, R3	5
KC130451S8	Profile insert CAT, carbide H8, B=20 H=28, R2.5	6
KC130452S8	Profile insert CAT, carbide H8, B=20 H=28, R2	7
KC130453S8	Profile insert CAT, carbide H8, B=20 H=28, R1.5	8
TB851272	Clamping jaw CAT, b=17	1-8
TB851016	Set screw M6x16.25, type Torx 15	1-8

WS Jointing Cutter

Application

- For jointing
- Universal use
- For optimum surface quality

Materials

- Solid wood, wood-based panels and plastics
- Laminated woods (plywood, multiplex, etc.)

Machines

- Gantry CNC router
- Machining centres

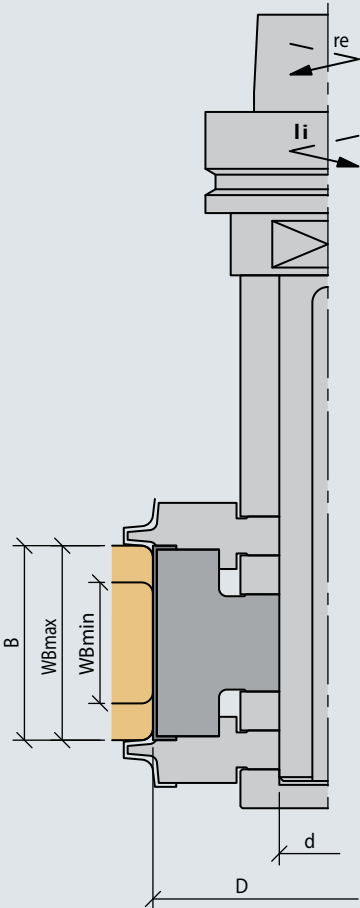
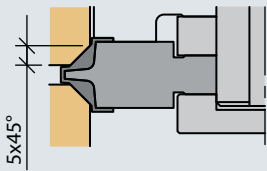
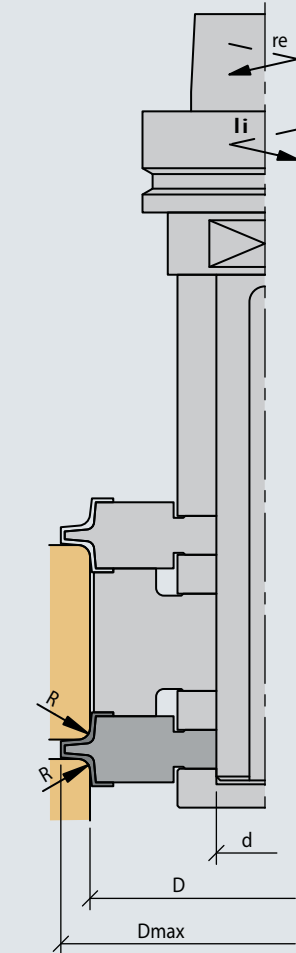
Technical Information

- Indexable carbide inserts
- Tool body made of steel
- Tool body nickel-plated
- Axial cutting edge arrangement
- Flexibly combinable
- Rounding cutter, arbor, cover and spacer rings not included in delivery
- MEC

Art. No.	D	B	d	DKN_L	DKN_B	WBmin	WBmax	Z	DR	n max	Index
TB300215	90	32	25	8	31,6	18	32	2	re./li.	18000	1
TB300216	90	50	25	8	31,6	30	50	2	re./li.	18000	2
TB300217	90	80	25	8	31,6	44	80	2	re./li.	18000	3

Spare parts

Art. No.	Detail	Index
KG217030	Indexable insert, carbide H8, B=32 H=8	1
KG217050	Indexable insert, carbide H8, B=50 H=8	2
KG217080	Indexable insert, carbide H8, B=80 H=8	3
TB851404	Clamping jaw CAT reamer, b=30	1
TB851406	Clamping jaw CAT reamer, b=50	2
TB851409	Clamping jaw CAT reamer, b=80	3
TB851016	Set screw M6x16.25, type Torx 15	1-3



WS Double Chamfer / Rounding Cutter with HSK63F

Application

- For rounding and chamfering
- Universal use on the top and bottom of the workpiece

Materials

- Solid wood, wood-based panels and plastics
- Laminated woods (plywood, multiplex, etc.)

Machines

- Gantry CNC router
- Machining centres

Technical Information

- Indexable carbide inserts
- Steel body
- Cutting edges with axial angle
- Basic configuration with chamfer 3.5x45°
- Optional with rounding knives R1.5 to R6mm
- Constant cutting circle diameter
- Mounted on HSK63F arbor
- Version in SP technology – bonded
- MEC

Art. No.	D	Dmax	Z	A	DR	n max
TB860602	130	144	2	149	re.	12400

Spare parts

Art. No.	Detail
KF216150	Indexable insert, carbide, B=6.0 R1.5 / top
KF216152	Indexable insert, carbide, B=6.0 R1.5 / bottom
KF216579	Indexable insert, carbide, B=6.0 R2.0 / top
KF216580	Indexable insert, carbide, B=6.0 R2.0 / bottom
KF216140	Indexable insert, carbide, B=6.0 R2.5 / top
KF216142	Indexable insert, carbide, B=6.0 R2.5 / bottom
KF216637	Indexable insert, carbide, B=6.0 R3.0 / top
KF216638	Indexable insert, carbide, B=6.0 R3.0 / bottom
KF216682	Indexable insert, carbide, B=9.5 R4.0 / top
KF216685	Indexable insert, carbide, B=9.5 R4.0 / bottom
KF216683	Indexable insert, carbide, B=9.5 R5.0 / top
KF216686	Indexable insert, carbide, B=9.5 R5.0 / bottom
KF216684	Indexable insert, carbide, B=9.5 R6.0 / top
KF216687	Indexable insert, carbide, B=9.5 R6.0 / bottom
KF216629	Indexable insert, carbide, B=6.0 45° / top
KF216630	Indexable insert, carbide, B=6.0 45° / bottom
TA851074	Screw M4x10 T15 for indexable insert B=6.0
TA851077	Screw M4x16 T15 for indexable insert B=9.5

WS Double Chamfer Cutter with HSK63F

Application

- For chamfering
- Universal use on the top and bottom of the workpiece

Materials

- Solid wood, wood-based panels and plastics
- Laminated woods (plywood, multiplex, etc.)

Machines

- Gantry CNC router
- Machining centres

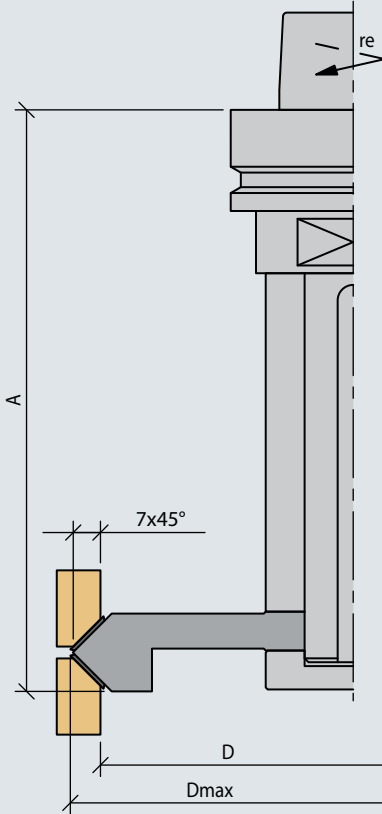
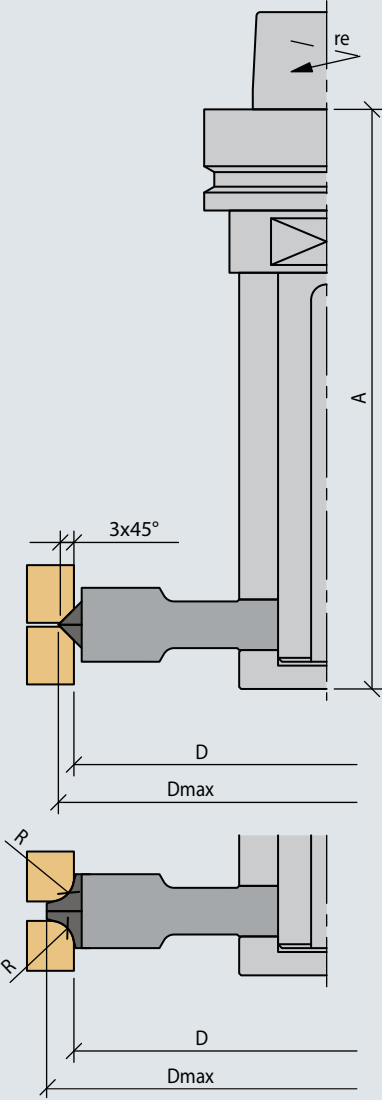
Technical Information

- Indexable carbide inserts
- Tool body made of steel
- 2 cutting edges on the top and 2 cutting edges on the bottom for selective edge change
- Cutting edges with 4 cutting edges per insert
- Constant cutting circle diameter
- Mounted on HSK63F arbor
- Version in SP technology – bonded
- MEC

Art. No.	D	Dmax	Z	A	DR	n max
TB860600	130	145,5	2	150	re.	12400

Spare parts

Art. No.	Detail
KF216009	Indexable insert, carbide, B=14 h=14
TA851038	Screw M5x6.3 T15



3

Door Processing



DP Chamfering / Pre-Milling Cutter for Doors with HSK63F

Application

- For pre-milling and chamfering abrasive top layers of door blanks on the top and bottom sides
- For large material removal volumes at maximum feed speed

Machines

- Gantry CNC router
- CNC machining centres

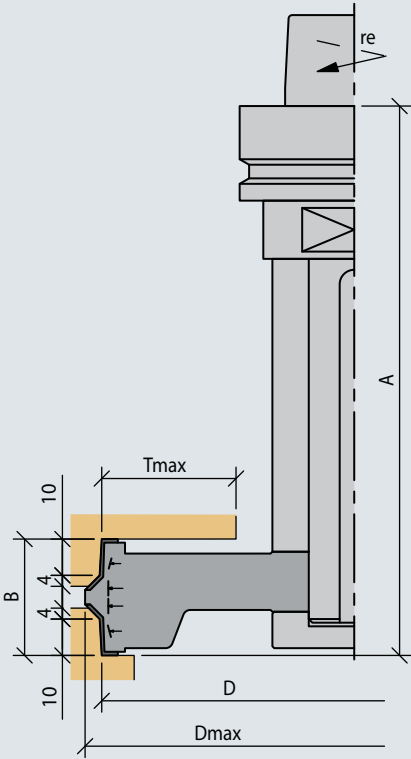
Materials

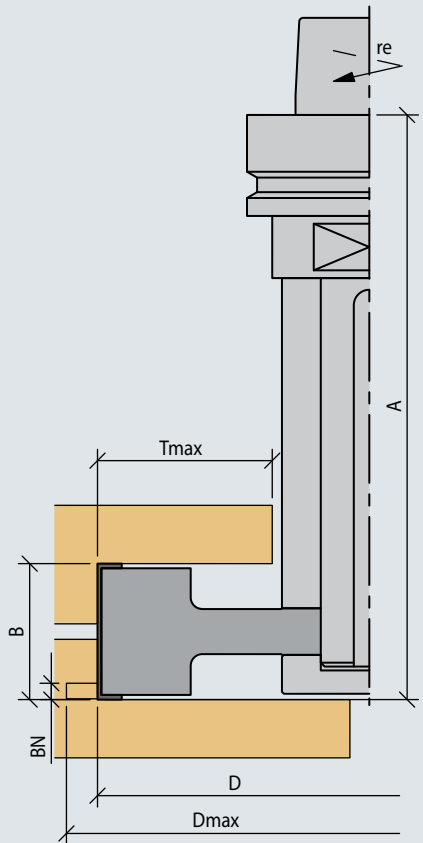
- For various door blank constructions
- Top layers made of MDF, HDF, veneer, with or without aluminium inlay
- Wood and wood-based panels

Technical Information

- Diamond-tipped
- Smooth cutting behaviour due to alternating axial angle
- Optimal cutting quality due to axial angle pulling from top and bottom
- Very good chip evacuation thanks to large chip flutes
- Can be resharpened multiple times
- For mounting on HSK63F arbor
- SP technology version – bonded
- MEC

Art. No.	D	Dmax	B	Z	ZH	Tmax	A	DR	n max
TB680516	140	148	32	3	5	46	151	re.	12200





WS Universal Rebating Cutter with HSK63F

Application

- Universal application
- Grooving and rebating
- Jointing
- Chamfering
- Face milling

Materials

- Wood and wood-based panels
- Cross and longitudinal cutting in solid wood, laminated wood, thermo wood

Machines

- Gantry CNC router
- CNC machining centres

Technical Information

- Solid carbide indexable insert
- Double-sided with sharp planer pre-cutter (KF216013)
- Basic configuration without grooving cutter
- With alternating axial angle
- Carrier body width 35 in steel
- Carrier body width 62 in aluminium
- For mounting on HSK63F arbor
- SP technology version – bonded
- MEC

Art. No.	D	Dmax	B	Tmax	A	Z	DR	n max	Index
TB860655	140	156	35	45	150,5	2	re.	11700	1
TB860656	140	156	62	45	154	2	re.	11700	2

Spare parts

Art. No.	Detail	Index
KG217030	Indexable insert, carbide H8, B=32 H=8	1
KG217060	Indexable insert, carbide H8, B=60 H=8	2
KF216013	Scoring cutter, carbide, BN=16 h=16	1 - 2
KF220024	Square grooving knife, BN=3 T=8	1 - 2
KF220026	Square grooving knife, BN=4 T=8	1 - 2
KF220034	Square grooving knife, BN=4.5 T=8	1 - 2
KF220028	Square grooving knife, BN=5 T=8	1 - 2
TB851404	Clamping jaw CAT reamer, b=30	1
TB851407	Clamping jaw CAT reamer, b=60	2
TB851016	Set screw M6x16.25, type Torx 15	1 - 2
TA851039	Countersunk screw M5x12, type Torx 15	1 - 2
TA851075	Special screw M4x12, type Torx 15	1 - 2

WS Universal Hybrid Rebating Cutter with HSK63F

Application

- Universal application
- Grooving and rebating
- Jointing
- Chamfering
- Face milling

Materials

- Wood and wood-based panels
- Cross and longitudinal cutting in solid wood, laminated wood, thermo wood

Machines

- Gantry CNC router
- CNC machining centres

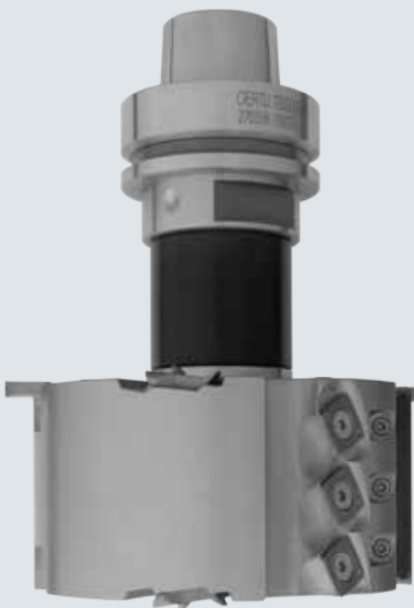
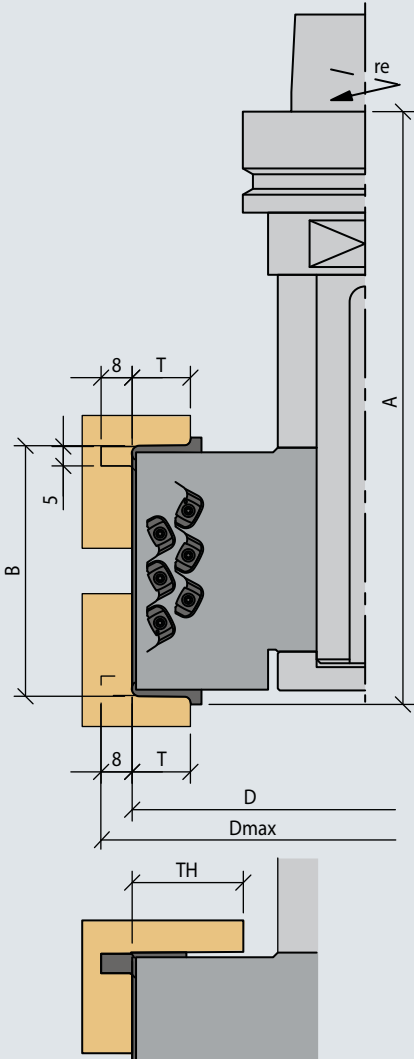
Technical Information

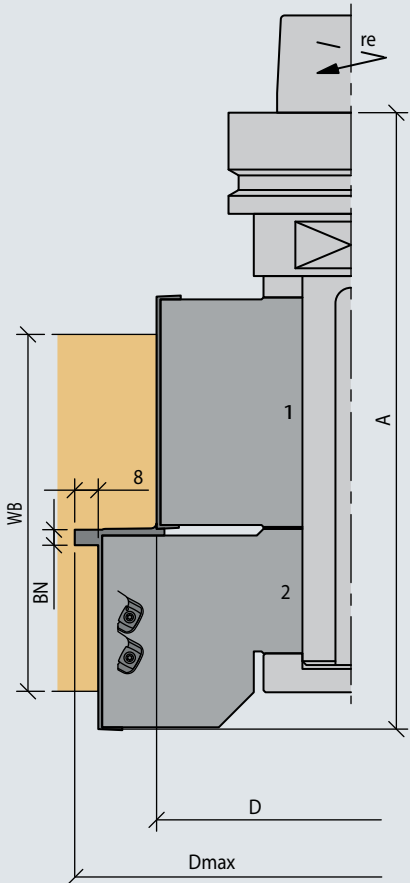
- Solid carbide indexable insert
- Cutter body made of aluminium
- Basic configuration with rounding pre-cutter T=15
- Optional with rounding pre-cutter T=8, 9, 10, 11, 12, 13 and 14 mm
- Optional with sharp pre-cutter (KF216013)
- Basic configuration without bottom grooving cutter
- Hybrid technology
- For mounting on HSK63F arbor
- SP technology version – bonded
- MEC

Art. No.	D	Dmax	B	Z	A	DR	n max	Index
TB860182	120	136	84,5	2	153	re.	13000	1
TB860183	120	136	64,5	2	153	re.	13000	2

Spare parts

Art. No.	Detail	Index
KG217080H6	Indexable insert, carbide H6, B=80 h=8	1
KG217060H6	Indexable insert, carbide H6, B=60 h=8	2
KF220017H6	CASTOR insert, carbide H6, B=14 h=14	1 - 2
KF216398	Radius scoring cutter R2/R1.5 T=15, top	1 - 2
KF216396	Radius scoring cutter R2/R1.5 T=15, bottom	1 - 2
KF216394	Radius scoring cutter R2/R1.5 T=14, top	1 - 2
KF216392	Radius scoring cutter R2/R1.5 T=14, bottom	1 - 2
KF216655	Radius scoring cutter R2/R1.5 T=13, top	1 - 2
KF216822	Radius scoring cutter R2/R1.5 T=13, bottom	1 - 2
KF216390	Radius scoring cutter R2/R1.5 T=12, top	1 - 2
KF216388	Radius scoring cutter R2/R1.5 T=12, bottom	1 - 2
KF216573	Radius scoring cutter R2/R1.5 T=11, top	1 - 2
KF216572	Radius scoring cutter R2/R1.5 T=11, bottom	1 - 2
KF216570	Radius scoring cutter R2/R1.5 T=9, top	1 - 2
KF216569	Radius scoring cutter R2/R1.5 T=9, bottom	1 - 2
KF216512	Radius scoring cutter R2/R1.5 T=8, top	1 - 2
KF216510	Radius scoring cutter R2/R1.5 T=8, bottom	1 - 2
KF216013	Scoring cutter, carbide, B=16 h=16, top and bottom	1 - 2
KF216733	Square grooving knife, B=5 T=8, top	1 - 2
KF216732	Square grooving knife, B=5 T=8, bottom	1 - 2
TB851409	Clamping jaw CAT for indexable insert B=80	1





Art. No.	Detail	Index
TB851407	Clamping jaw CAT for indexable insert B=60	2
TB851016	Set screw M6x16.25 T15 for clamping jaw CAT reamer	1 - 2
TA851040	Screw M5x15.5 T15 for CASTOR insert	1 - 2
TA851045	Screw M5x15 T15 for radius scoring cutter	1 - 2
TA851046	Screw M5x15 T15 for scoring cutter KF216013	1 - 2
TA851077	Screw M4x16 T15 for square grooving knife	1 - 2

WS Profile Cutter Set for Doors with HSK63F

Application

- For rebating doors

Materials

- CNC machining centres

Machines

- Gantry CNC router
- CNC machining centres

Technical Information

- Solid wood, wood and wood-based panels
- Technical Information
- Indexable carbide inserts
- Nickel-plated aluminium body
- Optimal cutting quality due to axial angle pulling from top and bottom
- Groove width BN 3, 4, 4.5 and 5 mm, groove depth 8 mm
- High speeds for very good surface finishes + maximum feed rates
- With hybrid technology in the rebate
- For mounting on HSK63F arbor
- SP technology version – bonded
- MEC

Art. No.	D	Dmax	B	Wbmax	A	Z	DR	n max	Index
TB860660	100	146		108	159	2	re.	13900	
TB300220			60			2	re.		1
TB300221			50			2	re.		2

Spare parts

Art. No.	Detail	Index
KG217060	Indexable insert, carbide H8, B=60 H=8	1
KG217050	Indexable insert, carbide H8, B=50 H=8	2
KF216398	Radius scoring cutter R2/R1.5 T=15	2
KF220017	Indexable insert, carbide H8, 13.8x13.8x2.5 R=40	2
KF220029	Square grooving knife, BN=5 T=8	2
TB851407	Clamping jaw CAT reamer, b=60	1
TB851406	Clamping jaw CAT reamer, b=50	2
TB851016	Set screw M6x16.25, type Torx 15	1,2
TA851045	Special screw M5x15, type Torx 15	2
TA851040	Special screw M5x15.5, type Torx 15	2
TA851075	Special screw M4x12, type Torx 15	2

WS Profile Cutter Set for Door Frames with HSK63F

Application

- Milling of the sealing profile
- Milling of the cladding profile

Materials

- Solid wood, wood and wood-based panels

Machines

- Gantry CNC router
- CNC machining centres

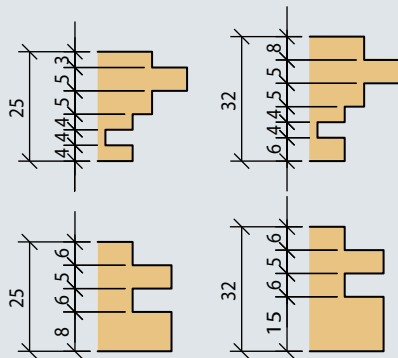
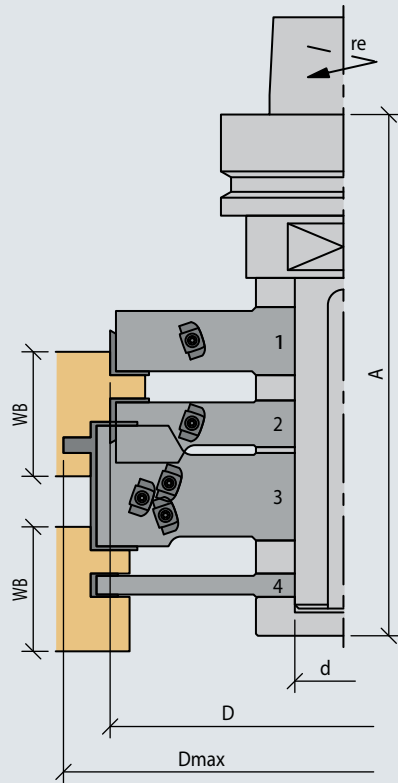
Technical Information

- Indexable carbide inserts
- Cutter body nickel-plated
- Optimal cutting quality due to axial angle pulling from top and bottom
- Seals 12 mm and 14 mm possible
- High spindle speeds for very good surface finish
- High spindle speeds for maximum feed rates
- For mounting on HSK63F arbor
- MEC

Art. No.	D	Dmax	d	DKN_B	DKN_L	B	Wbmin	Wbmax	A	Z	DR	n max	Index
TB860665	120	144	25				25	32	134	2	re.	11200	
TB300222			25	8	31,6	11				2	re.		1
TB300223			25	8	31,6	11				2	re.		2
TB300224			25	8	31,6	33				2	re.		3
TB300225			25	8	31,6	6				2	re.		4

Spare parts

Art. No.	Detail	Index
KF220017	Indexable insert, carbide H8, 13.8x13.8x2.5 R=40	1-3
KF216731	Square grooving knife, BN=4 T=8	3
KF216302	Indexable insert, carbide H8, B=5	4
KF216304	Indexable insert, carbide H8, B=5	4
TA851179	Eccentric D=14	4
TA851182	Tongue for eccentric	4
TA851040	Special screw M5x15.5, type Torx 15	1-3
TA851077	Special screw M4x16, type Torx 15	3



WS-PS Groove Cutter with HSK63F

Application

- For gearbox groove milling multipoint locks (Treplan or Tribloc)

Machines

- Gantry CNC router
- CNC machining centres

Materials

- Solid wood
- Wood and wood-based panels

Technical Information

- Solid carbide profile cutters
- Steel body, nickel-plated
- Constant dimensions
- Simple knife clamping system
- Reversible knives for Treplan and Tribloc usable in the same cutter body
- For mounting on HSK63F arbor
- MEC

Art. No.	Type	D	Dmax	d	DKN_B	DKN_L	Z	A	DR	n max	Index
TB860606	Treplan	101	120	25	8	31,6	2	149	re.	10000	1
TB860605	Tribloc	101	120	25	8	31,6	2	149	re.	10000	2

Spare parts

Art. No.	Detail	Index
KP223901	Profile insert, carbide, B=25, type Treplan	1
KP223902	Profile insert, carbide, B=25, type Tribloc	2
TA950385	Clamping jaw for profile insert B=25	1 - 2
TA950379	Clamping element for clamping jaw	1 - 2
TA851341	Set screw M6x18 T15 for clamping element	1 - 2

WS-PS Hardware Cutter Glutz

Application

- For Glutz hardware milling type 1160 and 1150
- Left-hand and right-hand versions for tear-free production

Machines

- Gantry CNC router
- CNC machining centres

Materials

- Solid wood
- Particleboard and fibreboard materials (particleboard, MDF, HDF, etc.) raw
- For melamine-faced, paper-laminated, HPL- and foil-coated, veneered wood-based panels
- For various door blank constructions

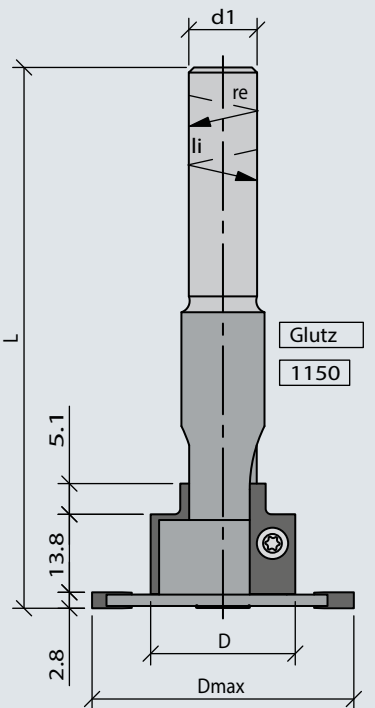
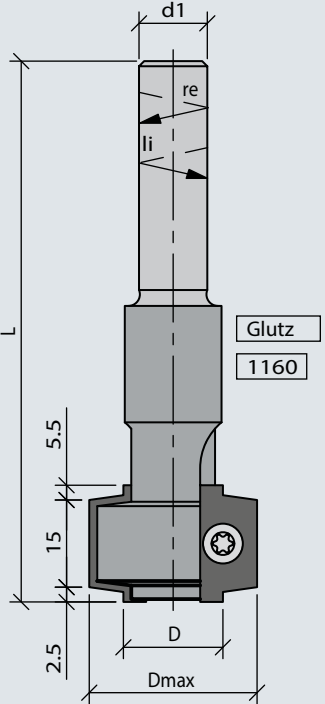
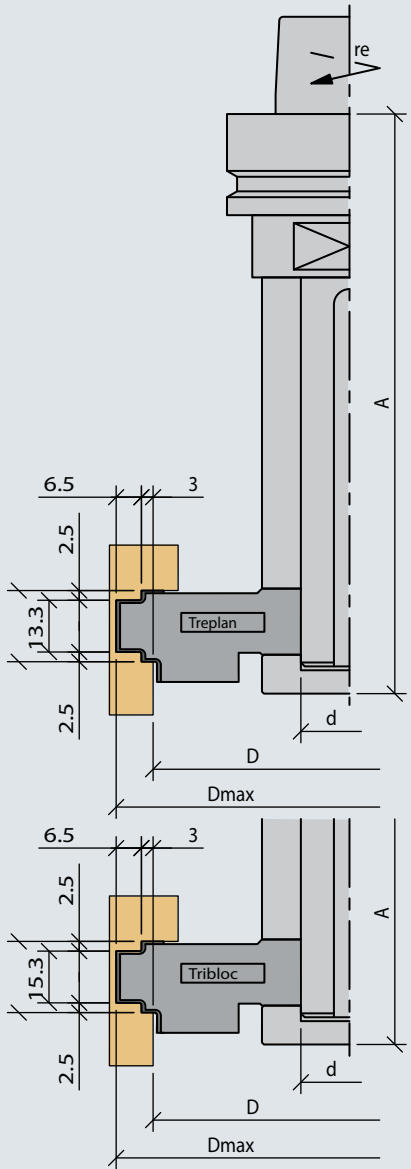
Technical Information

- Solid carbide profile cutters
- Cutter body made of steel
- Cutter body nickel-plated
- Axially straight cutter arrangement
- For type 1150, the grooving tool is replaceable
- MEC

Art. No.	Type	D	Dmax	d1	L	Z	DR	n max	Index
TB681141	1150	26	46	12	95	2	re.	18000	1
TB681142	1160	18,5	30	12	95	2	re.	18000	2
TB681143	1150	26	46	12	95	2	li.	18000	3
TB681144	1160	18,5	30	12	95	2	li.	18000	4
TB681145	1150	26	46	16	120	2	li.	18000	5
TB681146	1150	26	46	16	120	2	re.	18000	6

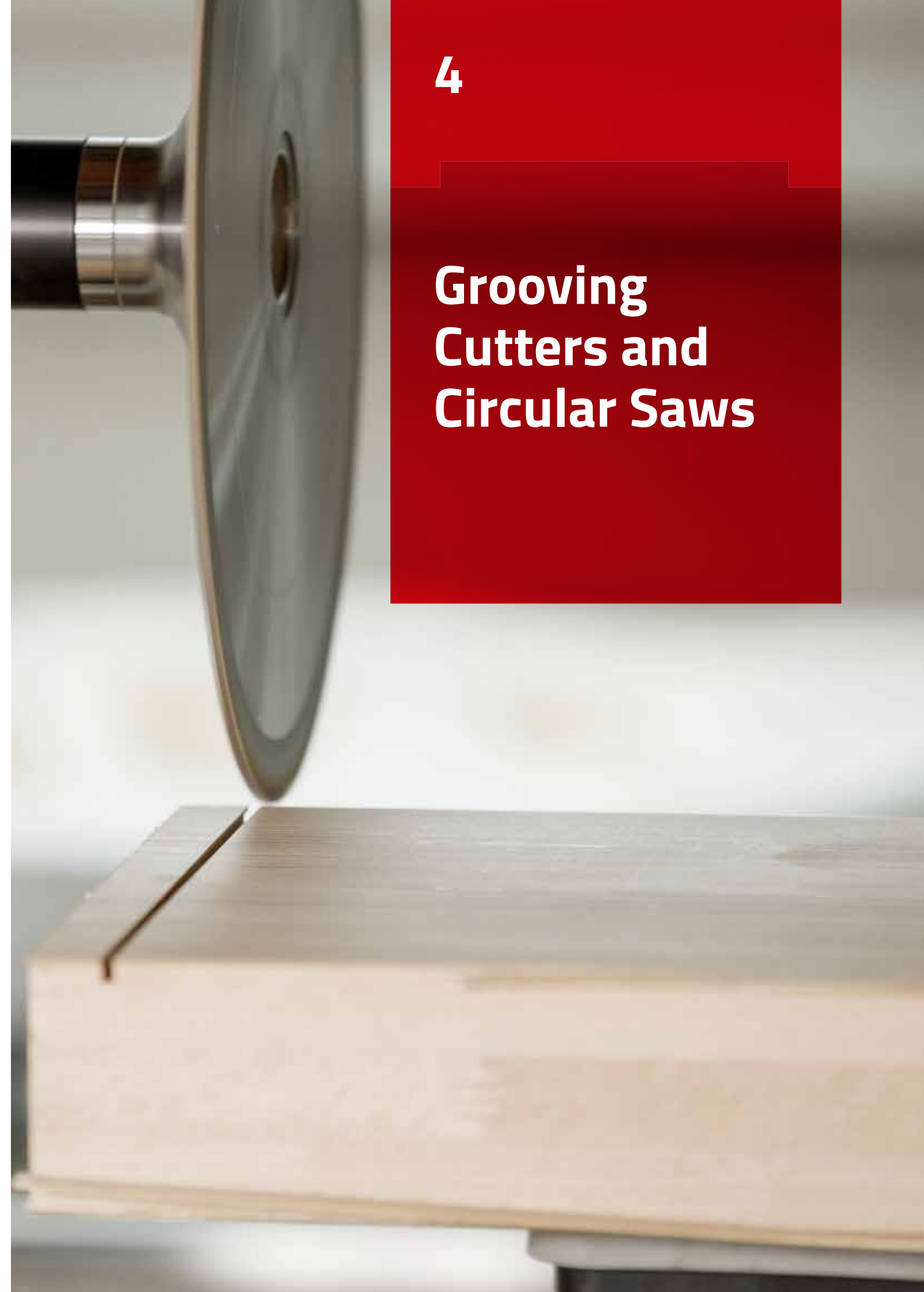
Spare parts

Art Nr	Detail	Index
TB219124	Profile insert, carbide, Glutz 1150, B=19.4 h=8 a=1.5, cutting direction right	1, 6
TB219123	Profile insert, carbide, Glutz 1150, B=19.4 h=8 a=1.5, cutting direction left	3, 5
TB219122	Profile insert, carbide, Glutz 1160, B=20.5 h=10 a=1.5, cutting direction left/right	4
TC108658	Grooving saw, carbide, Glutz 1150, D=46 B=2.8 b=2.2, bore 6, NL2/6/16, Z=2 FZ, cutting direction right	1, 6
TC108657	Grooving saw, carbide, Glutz 1150, D=46 B=2.8 b=2.2, bore 6, NL2/6/16, Z=2 FZ, cutting direction left	3, 5
TA851309	Pan head screw M3x4 Torx 9	1, 3, 5, 6
TB851078	Countersunk screw M5x12 Torx 20	1, 3, 5, 6
TB851077	Pan head screw M4x5 Torx 15	2, 4



4

Grooving Cutters and Circular Saws



WS Grooving Cutter with Cylindrical Shank

Application

- For grooving in climb cutting

Materials

- Solid wood, wood-based and panel materials
- Melamine-faced, paper-laminated, veneered wood-based panels

Machines

- Gantry CNC router
- CNC machining centres
- Specially for Holzher Evolution

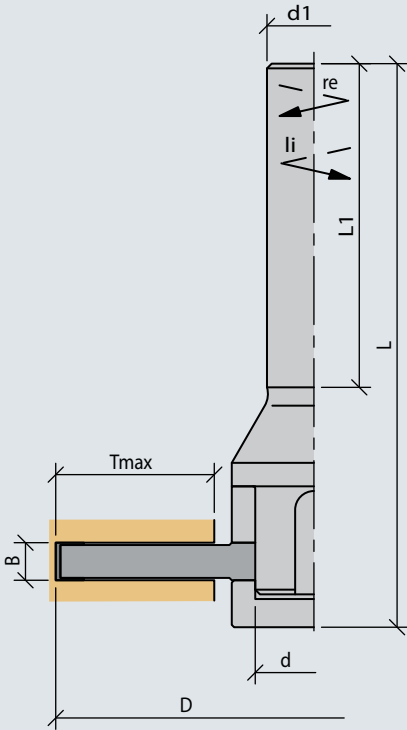
Technical Information

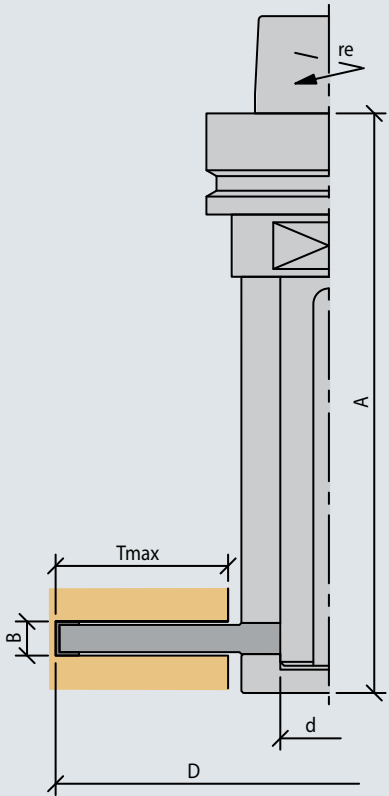
- Indexable carbide inserts
- Cutter body made of steel
- Cutter body nickel-plated
- Constant dimensions
- Simple knife clamping
- Fitted and screwed onto cylindrical shank d1=20
- MEC

Art. No.	D	B	d1	L1	d	DKN_B	DKN_L	Tmax	L	Z	DR	n max	Index
TB860650	110	8	20	70	25	8	31,6	37	120	2	re.	14600	1
TB860651	110	8	20	70	25	8	31,6	37	120	2	li.	14600	2

Spare parts

Art. No.	Detail	Index
KW199001	WIN insert, carbide, B=7 h=16.7	1 - 2
KW199002	WIN insert, carbide, B=7 h=16.7	1 - 2
KF216009	Indexable insert, carbide, B=14 h=14	1 - 2
TB850940	Clamping jaw for WIN insert B=7	1 - 2
TA851340	Set screw M5x18, type Torx 10	1 - 2
TA851038	Screw M5x6.3, type Torx 15	1 - 2





WS Grooving Cutter with HSK63F

Application

- For grooving in climb cutting

Materials

- Solid wood, wood-based and panel materials
- Melamine-faced, paper-laminated, veneered wood-based panels

Machines

- Gantry CNC router
- CNC machining centres
- Specially for Holzher Evolution

Technical Information

- Indexable carbide inserts
- Cutter body made of steel
- Cutter body nickel-plated
- Constant dimensions
- Simple knife clamping
- Keyed and bolted onto an HSK63F mounting arbor
- MEC

Art. No.	D	B	d	DKN_B	DKN_L	Tmax	A	Z	DR	n max	Index
TB860652	125	4	25	8	31,6	39,5	149	2	re.	12800	1
TB860653	160	4	25	8	31,6	57	149	2	re.	10000	2
TB860654	160	8	25	8	31,6	57	149	2	re.	10000	3

Spare parts

Art. No.	Detail	Index
KF216172	Indexable insert, carbide, B=4 h=13	1 - 2
KF216027	Indexable insert, carbide, B=3.7 h=14.9	1 - 2
KW199001	WIN insert, carbide, B=7 h=16.7	3
KW199002	WIN insert, carbide, B=7 h=16.7	3
KF216009	Indexable insert, carbide, B=14 h=14	3
TA851179	Eccentric D=14	1 - 2
TA851182	Tongue for eccentric	1 - 2
TB850940	Clamping jaw for WIN insert B=7	3
TA851340	Set screw M5x18, type Torx 10	3
TA851038	Screw M5x6.3, type Torx 15	3

HW/DP Profile Cutter Clamex P with Cylindrical Shank

Application

- For grooving for Clamex P connections

Materials

- Solid wood
- Wood-based and panel materials

Machines

- Gantry CNC router
- CNC machining centres

Technical Information

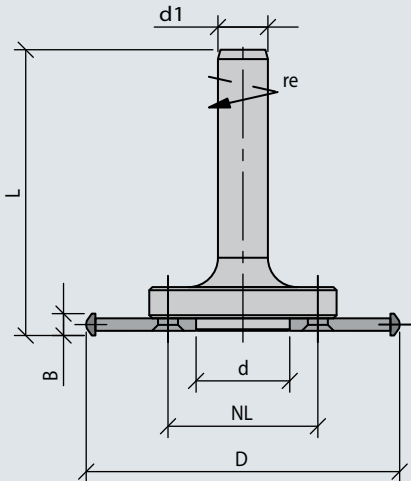
- Equipped with diamond or carbide
- Cutter body made of steel
- Cutter body nickel-plated
- Disposable tool
- Special cutting geometry
- MEC

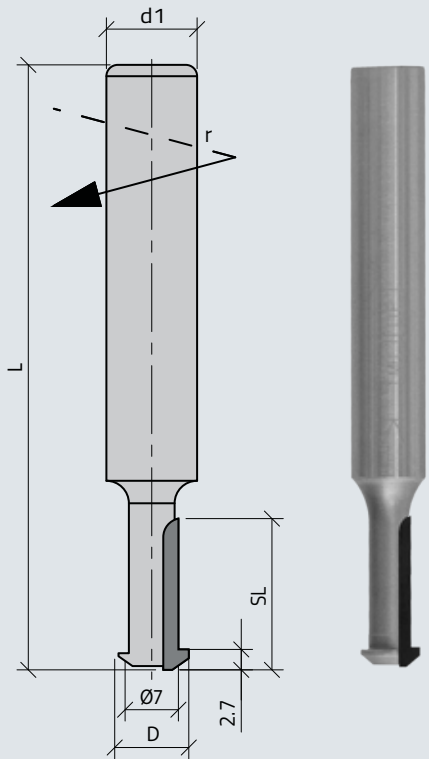
Art. No.	Type	D	B	d1	L	Z	DR	n max	Index
TB860609	DP	100,4	7	16	92	3	re.	13300	1
TB860610	DP	100,4	7	25	92	3	re.	13300	1
TB860611	HW	100,9	7	16	92	3	re.	16000	2
TB860612	HW	100,9	7	25	92	3	re.	16000	2

Arrangement of auxiliary holes NL, see legend III: circular saw blades + special

Spare parts

Art. No.	Detail	Index
TB681090	Profile cutter, diamond (DP), Clamex P, D=100.4 B=7 d=30 Z=3, cutting direction right, NL=4/12.5/48/right	1
TA176612	Profile cutter, carbide (HW), Clamex P, D=100.9 B=7 d=22 Z=3, cutting direction right, NL=4/10.2/36/right	2





DP Profile Shank Cutter Clamex P

Application

- For grooving for Clamex P connections
- Especially suitable for milling operations located further inside the panel surface
- Problem-solving solution where space is limited when using angle aggregates

Materials

- Solid wood
- Wood-based and panel materials

Machines

- Gantry CNC router
- CNC machining centres
- Only in combination with 5-axis motors

Technical Information

- Diamond-tipped
- Tool body made of solid carbide
- Disposable tool
- Special cutting geometry
- MEC

Art. No.	D	SL	d1	L	Z	DR	n max
TB681089	9,8	23	12	80	1	re.	24000

VHM Through-Hole Drill PRO for Clamex P

Application

- Drilling through-holes
- For high feed rates
- Long-lasting, consistent hole quality
- Significantly longer tool life compared to conventional through-hole drills

Materials

- Wood-based and panel materials
- Melamine resin- and paper-coated, veneered wood-based panels

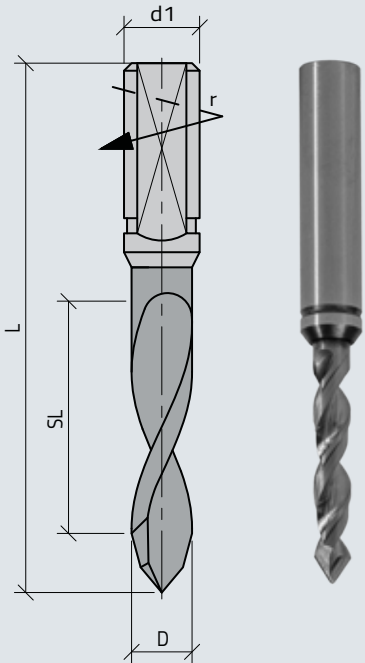
Machines

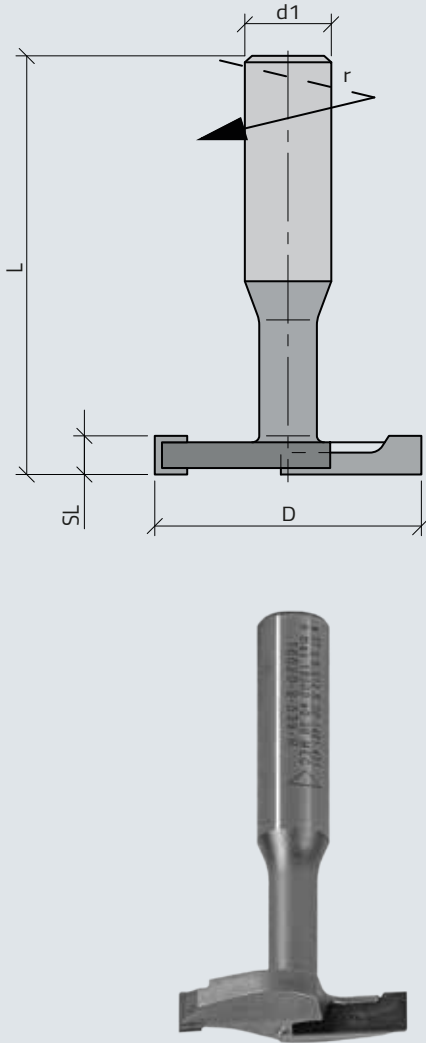
- CNC machining centres
- Drilling machines

Technical Information

- Solid carbide
- Special cutting geometry
- Cylindrical shank with clamping flat
- With adjusting screw
- MAN

Art. No.	D	SL	L	d1	Z	DR
TB700062	6	35	100	10	2	re.





DP Profile Shank Cutter FixChip

Application

- For FixChip connecting elements on nesting machines

Materials

- Raw particleboard and fibre-based materials(Chipboard, MDF, HDF, etc.)
- Melamine resin- and paper-coated, HPL- and foil-coated, veneered wood-based panels
- Plywood and laminated panels(Plywood, Multiplex, etc.)

Machines

- CNC machining centres
- Gantry CNC router

Technical Information

- Diamond-tipped
- Steel tool body
- Nickel-plated tool body
- Without adjusting screw
- MEC

Art. No.	D	SL	L	d1	Z	DR	n max
TB681030	37	6	65	12	2	re.	18000

TURBEX Finishing Spiral Cutter MAX FixChip

Application

- For FixChip connecting elements
- For grooving, formatting and separating
- Suitable for ramping

Materials

- Solid wood
- Raw particleboard and fibre-based materials(Chipboard, MDF, HDF, etc.)
- Mineral materials(Corian, Varicor, etc.)
- Melamine resin- and paper-coated, HPL- and foil-coated, veneered wood-based panels
- Various plastics

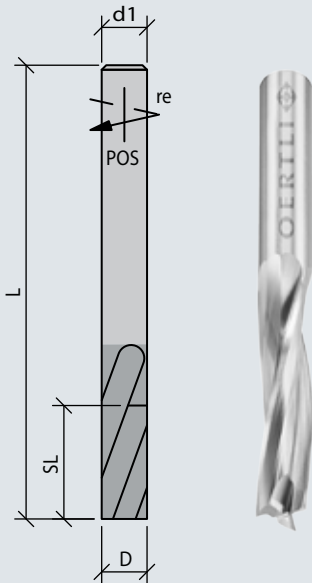
Machines

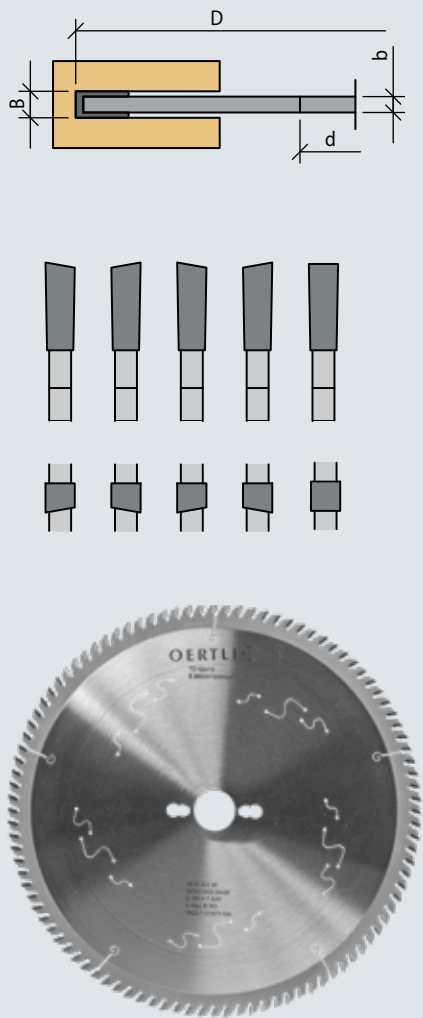
- CNC machining centres
- Nesting machines

Technical Information

- Solid carbide
- Improved chip evacuation due to optimized chip flutes
- With end grinding
- Extended resharpening zone
- Cutting allowance approx. 1–2mm
- MAN

Art. No.	D	SL	L	d1	Z	DW	DR	n max
TB682157	6	15	60	6	2	pos.	re.	30000





HW Format Circular Saw SPRINT

Application range

- Universal saw for rip and cross cuts in solid wood and wood-based panels

Design

- Carbide-tipped
- Top version for high demands
- Positive alternate tooth with scoring tooth

Art. No.	D	B	b	d	Z	NL
TC102400	100	4,0	2,8	30	30	
TC102401	100	5,0	4,0	30	30	
TC102402	120	4,0	2,8	20	35	
TC102403	120	5,0	4,0	20	35	
TC106234	120	4,0	2,8	35	35	2x 4/M5/50
TC106235	120	5,0	4,0	35	35	2x 4/M5/50
TC102404	125	4,0	2,8	30	35	2x 4/M5/48
TC102405	125	5,0	4,0	30	35	2x 4/M5/48
TC102406	180	3,0	2,2	30	60	NLK
TC102407	200	3,0	2,2	30	65	NLK
TC102408	220	3,0	2,2	30	70	NLK
TC102409	240	3,0	2,2	30	75	2x 4/M5/52
TC102410	240	3,0	2,2	40	75	8/M5/52
TC102411	250	3,0	2,2	30	80	NLK
TC102412	255	3,0	2,2	30	80	NLK
TC102413	303	3,0	2,2	30	100	NLK
TC102414	355	3,0	2,2	30	100	NLK

Arrangement of pin holes NL, see legend III: circular saw blades + special

Application recommendation

Material	Cutting speed vc	Feed per tooth fz
Chipboard	60 - 90 m/s	0.2 - 0.3
MDF	50 - 70 m/s	0.1 - 0.2
Solid wood, longitudinal	55 - 80 m/s	0.2 - 0.4
Solid wood, cross-grain	60 - 90 m/s	0.1 - 0.2
Thermoplastic	30 - 50 m/s	0.05 - 0.1
Thermoset	20 - 50 m/s	0.05 - 0.1

HW Circular Saw DUO-BFF

Application range

- Universal saw for rip and cross cuts in solid wood and wood-based panels

Design

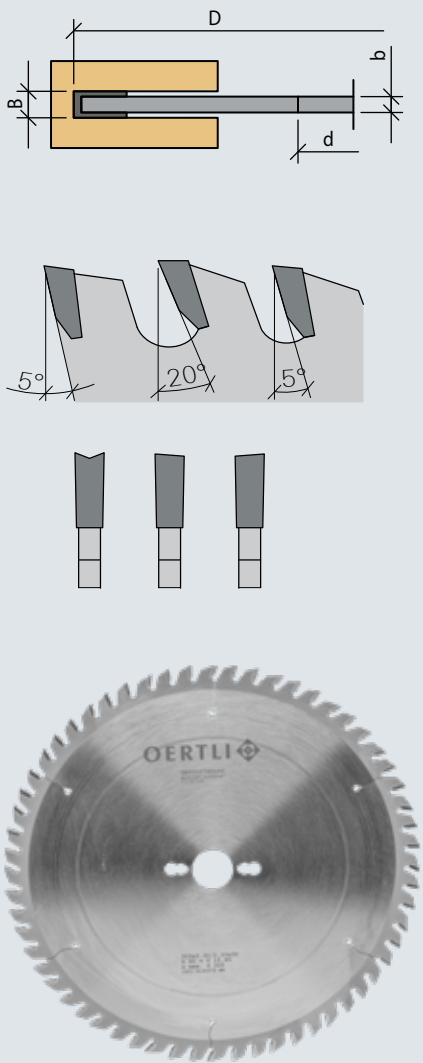
- Carbide-tipped
- Top version for high demands
- Positive alternate tooth with scoring tooth

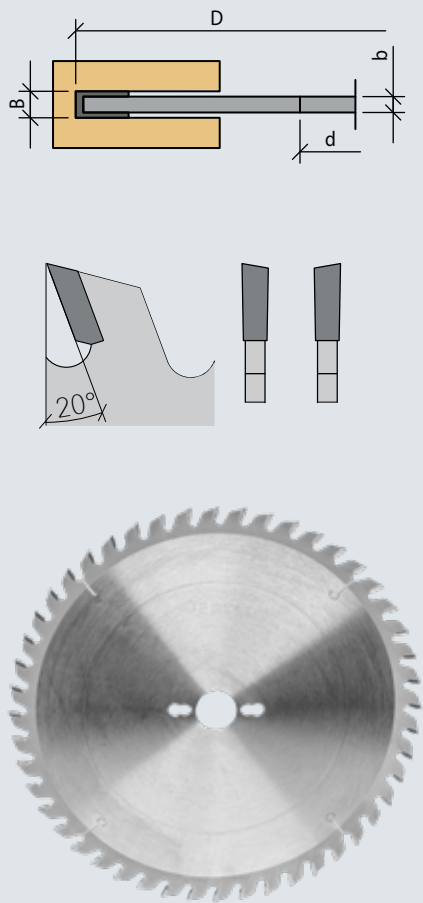
Art. No.	D	B	b	d	Z	NL
TA760035	200	3,1	2,0	30	48	
TA760069	250	3,1	2,0	30	60	NLK
TA760100	303	3,3	2,2	30	60	NLK
TA760109	303	3,3	2,2	30	72	NLK
TA760136	350	3,6	2,5	30	72	NLK

Arrangement of pin holes NL, see legend III: circular saw blades + special

Application recommendation

Material	Cutting speed vc	Feed per tooth fz
Chipboard	60 - 90 m/s	0.2 - 0.3
MDF	50 - 70 m/s	0.1 - 0.2
Solid wood, longitudinal	55 - 80 m/s	0.2 - 0.4
Solid wood, cross-grain	60 - 90 m/s	0.1 - 0.2
Thermoplastic	30 - 50 m/s	0.05 - 0.1
Thermoset	20 - 50 m/s	0.05 - 0.1





Carbide circular saw blade, universal, for rip and cross cutting

Application range

- Universal saw for rip and cross cuts in solid wood and wood-based panels

Design

- Carbide-tipped
- Positive alternate tooth

Art. No.	D	B	b	d	Z	NL
TC102000	150	3,2	2,2	30	24	
TC102002	180	3,2	2,2	30	30	
TC102005	200	3,2	2,2	30	48	
TC102006	220	3,2	2,2	30	36	NLK
TC102008	250	3,2	2,2	30	48	NLK
TC102013	300	3,2	2,2	30	48	NLK
TC102015	300	3,2	2,2	30	72	NLK
TC102019	350	3,5	2,5	30	54	NLK
TC102020	350	3,5	2,5	30	72	NLK

Arrangement of pin holes NL, see legend III: circular saw blades + special

Application recommendation		
Material	Cutting speed vc	Feed per tooth fz
Chipboard	60 - 90 m/s	0.2 - 0.3
MDF	50 - 70 m/s	0.1 - 0.2
Solid wood, longitudinal	55 - 80 m/s	0.2 - 0.4
Solid wood, cross-grain	60 - 90 m/s	0.1 - 0.2
Thermoplastic	30 - 50 m/s	0.05 - 0.1
Thermoset	20 - 50 m/s	0.05 - 0.1

Carbide circular saw blade for solid wood

Application range

- Universal saw for rip and cross cuts in solid wood and wood-based panels

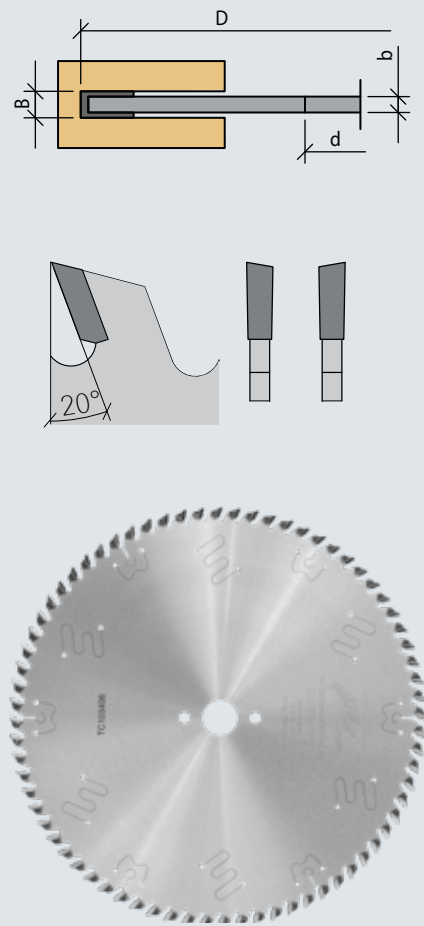
Design

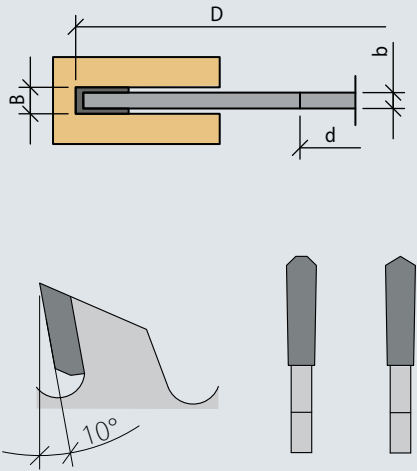
- Carbide-tipped
- Positive alternate tooth
- Precision version: finish cut quality

Art. No.	D	B	b	d	Z	NL
TC103402	300	3,2	2,2	30	60	2/10/60
TC103403	300	3,2	2,2	30	72	2/10/60
TC103406	350	3,2	2,2	30	72	2/10/60
TC103405	350	3,5	2,5	30	54	2/10/60

Arrangement of pin holes NL, see legend III: circular saw blades + special

Application recommendation		
Material	Cutting speed vc	Feed per tooth fz
Chipboard	60 - 90 m/s	0.2 - 0.3
MDF	50 - 70 m/s	0.1 - 0.2
Solid wood, longitudinal	55 - 80 m/s	0.2 - 0.4
Solid wood, cross-grain	60 - 90 m/s	0.1 - 0.2
Thermoplastic	30 - 50 m/s	0.05 - 0.1
Thermoset	20 - 50 m/s	0.05 - 0.1





Carbide circular saw blade for HDF

Application range

- Universal saw for machining plastic-coated and laminated wood-based panels

Design

- Carbide-tipped
- Hollow tooth roof-flat with positive chamfer
- Precision version: finish cut quality

Art. No.	D	B	b	d	Z	NL
TB750101	220	3,2	2,2	30	48	2/7/42 + 2/10/60
TA768068	250	3,2	2,2	30	48	2/7/42 + 2/10/60
TA768069	303	3,2	2,2	30	60	2/7/42 + 2/10/60
TA768071	350	3,2	2,2	30	72	2/7/42 + 2/10/60

Arrangement of pin holes NL, see legend III: circular saw blades + special

Application recommendation

Material	Cutting speed vc	Feed per tooth fz
Chipboard	60 - 90 m/s	0.2 - 0.3
MDF	50 - 70 m/s	0.1 - 0.2
Solid wood, longitudinal	55 - 80 m/s	0.2 - 0.4
Solid wood, cross-grain	60 - 90 m/s	0.1 - 0.2
Thermoplastic	30 - 50 m/s	0.05 - 0.1
Thermoset	20 - 50 m/s	0.05 - 0.1

DP Panel Sizing Circular Saw Blade PRO

Application

- For precise cutting and mitre cuts
- Universally applicable
- Disposable tool

Materials

- Raw particleboard and fibreboards(MDF, HDF, etc.)
- Melamine-resin and paper-coated, HPL- and foil-laminated, veneered wood-based panels
- Plywood and laminated panels
- Solid-core plastic panels(e.g. Trespa®, Corian®, Varicor®, LG-HiMacs)
- Fibre cement panels
- Eternit
- Rip and cross cuts in solid wood and thermo wood

Machines

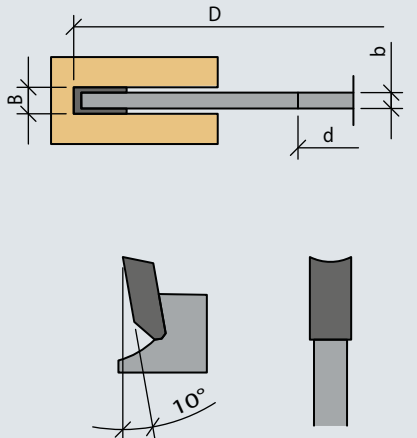
- Panel sizing and table saws
- Vertical panel dividing saws
- CNC machining centres

Technical Information

- Diamond-tipped
- Smallest chip gullets for maximum noise reduction
- Hollow-back tooth for minimal cutting pressure
- Long tool life
- Disposable tool

Art. No.	D	B	b	d	Z	DR	NL	n max
TC100800	303	2,5	2	30	60	re.	2/7/42 + 2/9/46 + 2/10/60 + 8/10.2/90/re	4900
TC100801	303	2,5	2	30	60	li.	8/10.2/65/li	4900
TC100802	303	2,5	2	30	60	re.	8/10.2/65/re	4900
TC100803	350	2,5	2	30	72	li.	2/7/42 + 2/9/46 + 2/10/60 + 8/10.2/90/li	4200
TC100804	350	2,5	2	30	72	re.	2/7/42 + 2/9/46 + 2/10/60 + 8/10.2/90/re	4200
TC100805	350	2,5	2	30	72	li.	8/10.2/65/li	4200
TC100806	350	2,5	2	30	72	re.	8/10.2/65/re	4200

Arrangement of pin holes NL, see legend III: circular saw blades + special



5

Profile Shank Cutters



WS V-Groove Shank Cutter

Application

- For milling V-grooves, decorative grooves or lettering
- For pointing profiles and corners

Materials

- Solid wood
- Raw particleboard and fibreboards(MDF, HDF, etc.)
- Melamine-resin and paper-coated, HPL- and foil-laminated, veneered wood-based panels

Machines

- Gantry CNC router
- CNC machining centres
- Special milling machines with milling spindles for shank tools

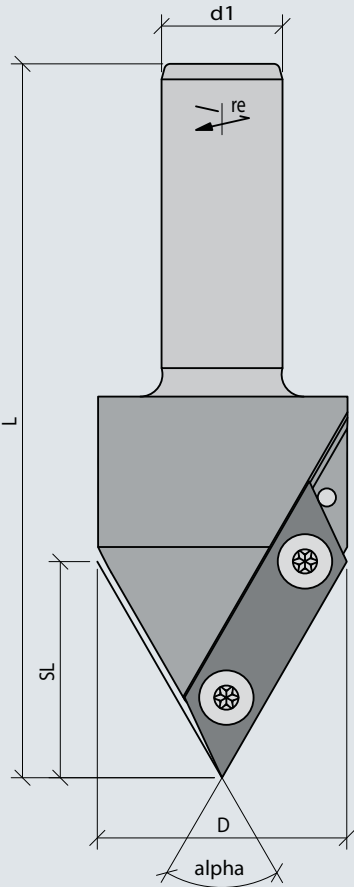
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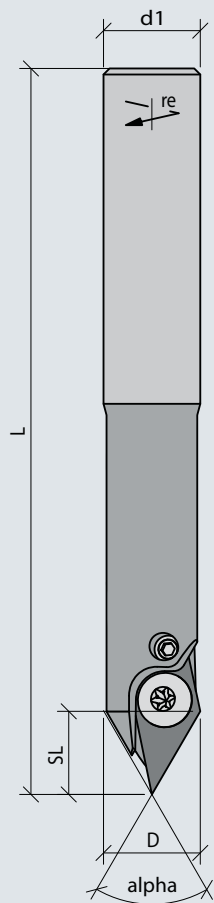
- Carbide-tipped indexable insert
- Steel tool body
- Black-oxide finished tool body
- Profile with sharp pointed tip
- MEC

Art. No.	D	alpha	SL	d1	L	Z	DR	n max	Index
TA112171	41,5	60°	35	20	118	1	re.	18000	1
TB681109	50	91°	25	25	93	1	re.	18000	2

Spare parts

Art. No.	Detail	Index
TA219850	Indexable insert, carbide, B=50 h=12 a=1.5	1
TB219137	Indexable insert, carbide, B=40 h=12 a=1.5	2
TA851606	Large head screw M4x5.9 Torx 15	1, 2





WS Pointing Shank Cutter

- Application**

 - For milling V-grooves, decorative grooves or lettering
 - For pointing profiles and corners
- Materials**

 - Solid wood
 - Wood and panel materials
- Machines**

 - Gantry CNC router
 - CNC machining centres
 - Special milling machines with milling spindles for shank tools
- Technical Information**

 - Carbide-tipped indexable insert
 - Steel tool body
 - Black-oxide finished tool body
 - Profile with sharp pointed tip
 - MEC

Art. No.	D	alpha	SL	d1	L	Z	DR	n max
TB681118	16	60°	13,7	16	120	1	re.	24000

Spare parts	
Art Nr	Detail
TB219121	Indexable insert, carbide, B=12 h=10.63 a=1.5
TB851030	Clamping screw, large head M4x4 Torx 15
TB851075	Set screw M4x4 ISO 4026

VHM Pointing Shank Cutter

- Application**

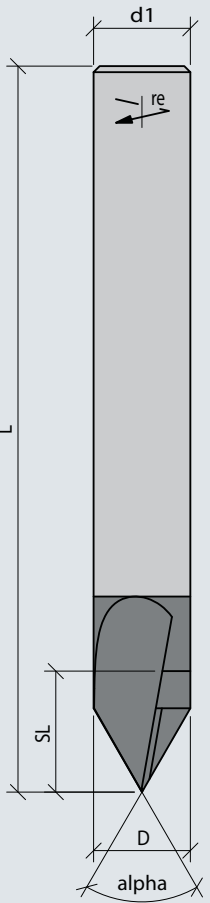
 - For milling V-grooves, decorative grooves or lettering
 - For pointing profiles and corners
- Materials**

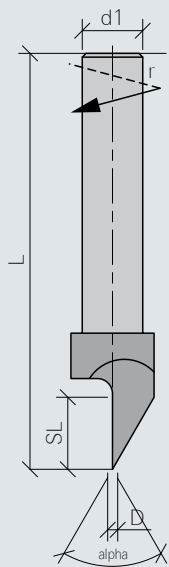
 - Solid wood
 - Wood and panel materials
- Machines**

 - Gantry CNC router
 - CNC machining centres
 - Special milling machines with milling spindles for shank tools
- Technical Information**

 - Solid carbide
 - Profile with sharp pointed tip
 - MEC

Art. No.	D	alpha	SL	d1	L	Z	DR	n max
TB681119	16	60°	14	16	120	2	re.	24000





HW Grooving / Lettering Cutter

Application

- For milling lettering

Materials

- Solid wood
- Wood-based panels

Machines

- Gantry CNC router
- CNC machining centres

Technical Information

- Solid carbide
- MEC

Art. No.	D	alpha	SL	d1	L	Z	DR	n max
TA689100	0,3	60°	9,5	8	55	1	re.	24000

WS-PS Decorative Grooving Cutter

Application

- For milling lettering
- Flexible profile design

Materials

- Solid wood
- Wood-based panels

Machines

- Gantry CNC router
- CNC machining centres

Technical Information

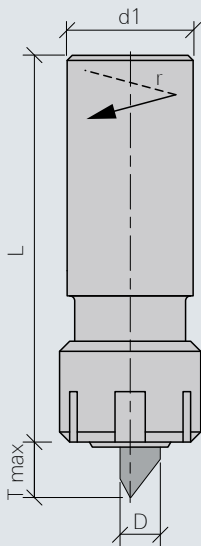
- Carbide profile cutters
- Steel tool body
- Constant dimensions
- Cutters with axial angle
- Large standard profile range
- MEC

Art. No.	D	Tmax	d1	L	Z	DR	n max
TA689107	12	8	25	85	1	re.	18000

Profile types see next page

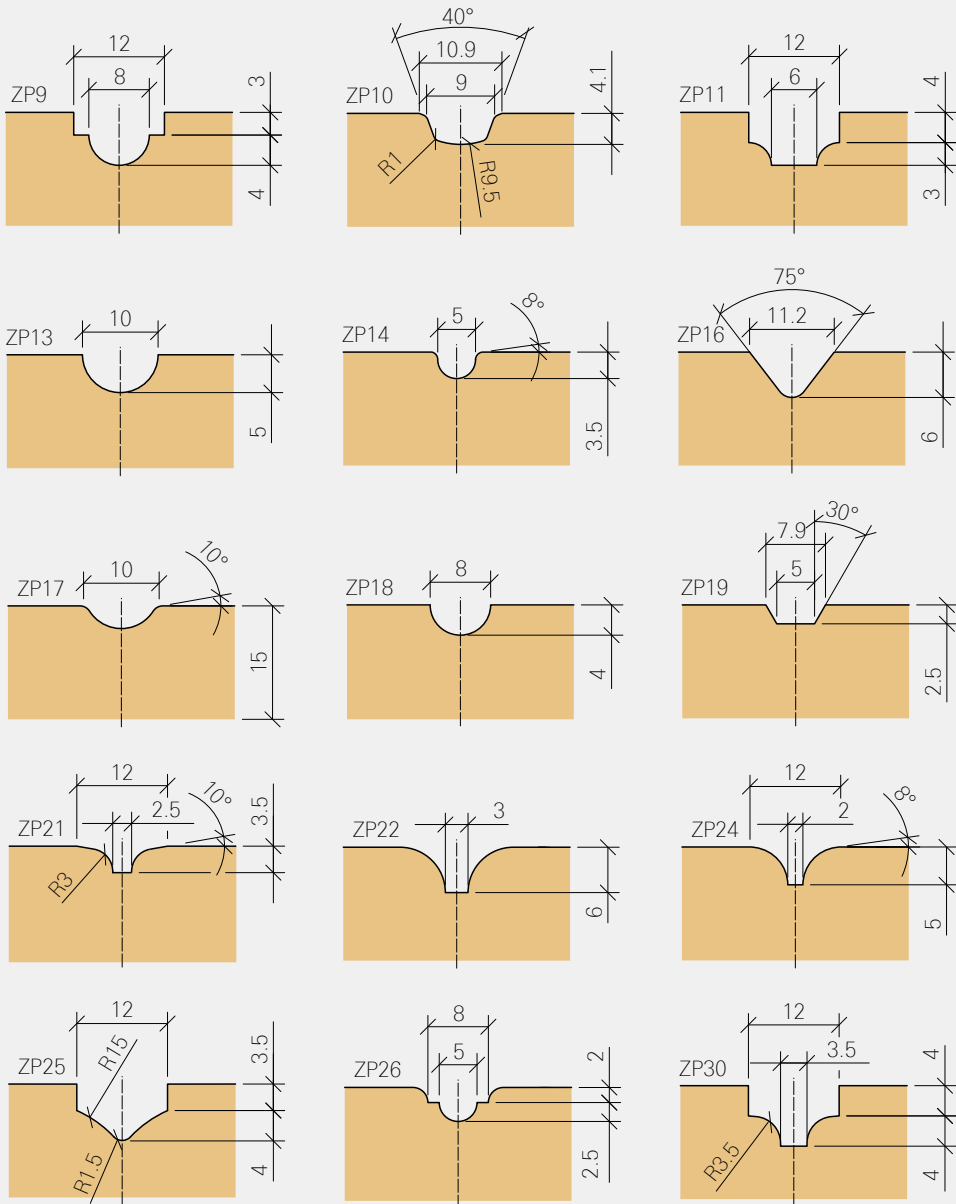
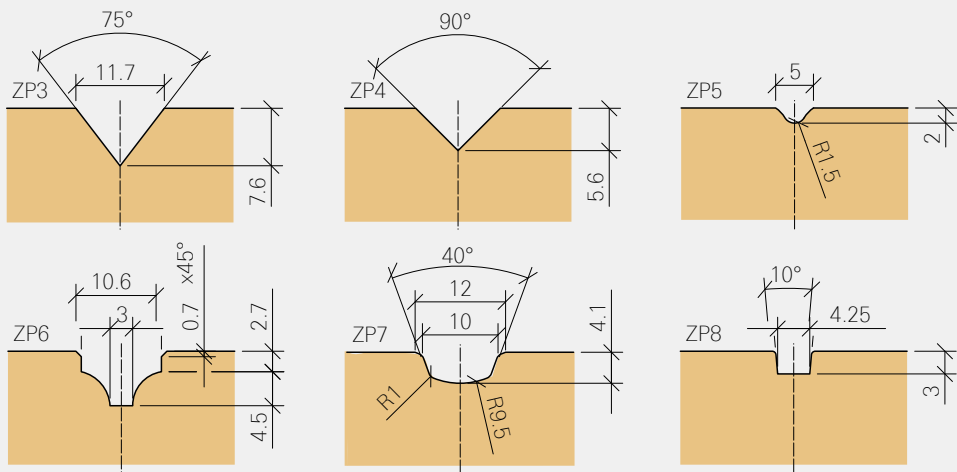
Spare parts

Art. No.	Detail
TA689109	Clamping nut
TA689110	Hook spanner



Decorative Grooving Profile Cutters

Art. No.	Type	Art. No.	Type
TA689202	ZP03	TA689222	ZP16
TA689203	ZP04	TA689227	ZP17
TA689205	ZP05	TA689224	ZP18
TA689208	ZP06	TA689225	ZP19
TA689210	ZP07	TA689228	ZP21
TA689212	ZP08	TA689229	ZP22
TA689213	ZP09	TA689231	ZP24
TA689216	ZP10	TA689232	ZP25
TA689217	ZP11	TA689233	ZP26
TA689219	ZP13	TA689240	ZP30
TA689220	ZP14		





Solid Carbide Engraving Cutter

Application

- For engraving and scribing

Materials

- Melamine- and paper-laminated, veneered wood-based panels
- Panel materials with sensitive, thin surface coatings

Machines

- CNC machining centres
- Special milling machines with milling spindles for shank tools

Technical Information

- Solid carbide
- MEC

Art. No.	D	alpha	SL	d1	L	Z	DR	n max
TA689300*	0,3	15°	5	3	40	1	re.	24000
TA689301*	0,3	36°	5	3	40	1	re.	24000
TB680000	0,3	36°	11	8	75	2	re.	30000

* with stop ring

DP V-Groove Shank Cutter Z2

Application

- For milling V-grooves, decorative grooves or lettering
- For chamfering HPL and wood-based materials
- Suitable for machining aluminium composite panels

Materials

- Composite panels with aluminium facings on both sides and plastic core (e.g. Alucobond®, Dibond®)
- Solid wood, wood-based panels

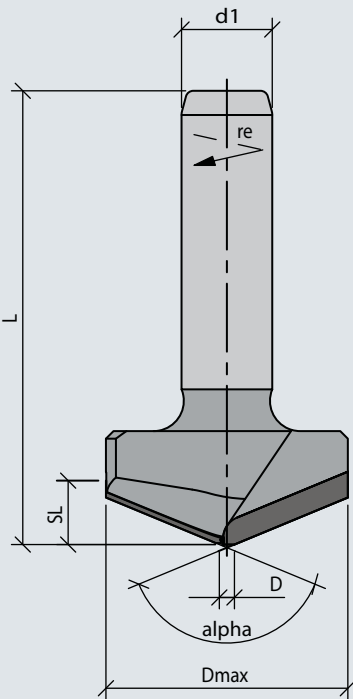
Machines

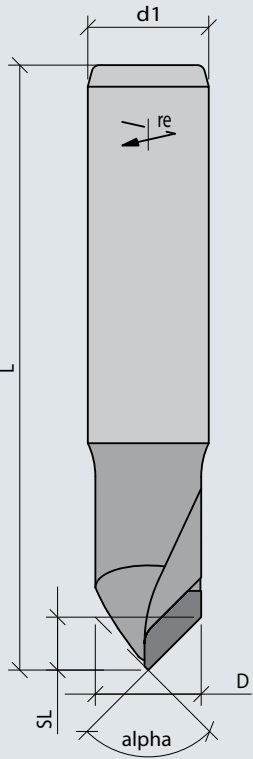
- Gantry CNC router
- CNC machining centres
- Special milling machines with milling spindles for shank tools

Technical Information

- Diamond-tipped
- Steel body
- Nickel-plated body
- MEC

Art. No.	D	Dmax	alpha	SL	L	d1	Z	ZH	DR	n max
TB681093	3	48	90°	7,5	60	12	2	3,7	re.	24000
TB681094	2	32	135°	6,2	60	12	2	3,1	re.	24000





DP V-Groove Shank Cutter Z1

Application

- For milling V-grooves, decorative grooves or lettering
- For chamfering HPL and wood-based materials
- Relief milling

Materials

- Solid wood, wood-based panels

Machines

- Gantry CNC router
- CNC machining centres
- Special milling machines with milling spindles for shank tools

Technical Information

- Diamond-tipped
- Steel body
- Nickel-plated body
- MEC

Art. No.	D	alpha	SL	d1	L	Z	ZH	DR	n max
TB681095	14	90°	7	16	80	1	3,7	re.	24000

HW Ball Nose Shank Cutter

Application

- For contour milling and copy milling
- For 3D machining, 3D models, curved parts
- Ideal for mold making

Materials

- For wood-based materials, solid wood and plastics

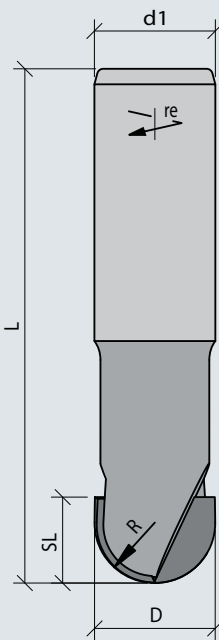
Machines

- Gantry CNC router
- CNC machining centres

Technical Information

- Carbide-tipped
- Steel body
- Black-oxidized body
- Without adjustment screw
- MEC

Art. No.	D	R	SL	d1	L	Z	DR	n max
TB681102	20	10	14	20	85	2	re.	18000
TB681103	30	15	19	20	85	2	re.	18000
TB681104	40	20	24	20	85	2	re.	18000



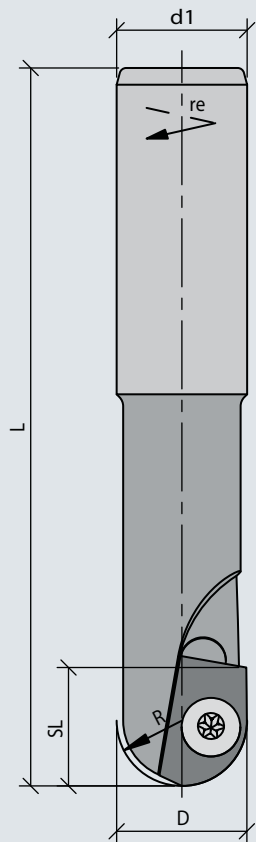


Fig. 1

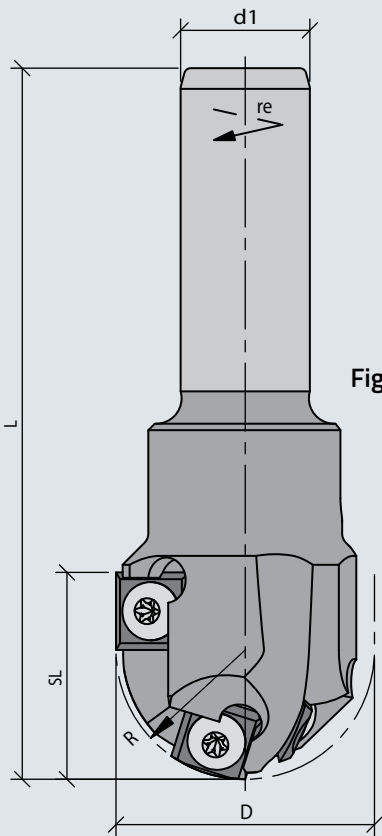


Fig. 2

WS-PS Ball Nose Shank Cutter

Application

- For contour milling and copy milling
- For 3D machining, 3D models, curved parts
- Ideal for mold making

Materials

- For wood-based materials, solid wood and plastics

Machines

- Gantry CNC router
- CNC machining centres

Technical Information

- Carbide profile cutters
- Steel body
- Black-oxidized body
- Without adjustment screw
- MEC

Art. No.	D	R	SL	d1	L	Z	DR	n max	Fig	Index
TB681105	20	10	17	20	110	1	re.	18000	1	1
TB681106	30	15	20	20	110	2	re.	18000	1	2
TB681107	40	20	27	20	110	2	re.	18000	1	3
TB681108	40	20	31,8	20	110	1	re.	18000	2	4

Spare parts

Art Nr	Detail	Index
TB219126	Profile insert, carbide, R=10	1
TB219133	Profile insert, carbide, R=15	2
TB219125	Profile insert, carbide, R=20	3
TB219134	Indexable insert, carbide, 12x12	4
TB219120	Profile insert, carbide, 12x12 R=20	4
TA851606	Screw M4x5.9 Torx T15	1, 2, 4
TA851309	Screw M3x4.0 Torx T9	3

DP Ball Nose Shank Cutter

Application

- For contour milling and copy milling
- For 3D machining, 3D models, curved parts
- Ideal for mold making

Materials

- Solid wood
- Particleboard and fibreboards (particleboard, MDF, HDF, etc.) raw
- For melamine resin- and paper-coated, HPL- and foil-coated, veneered wood-based panels
- Various plastics

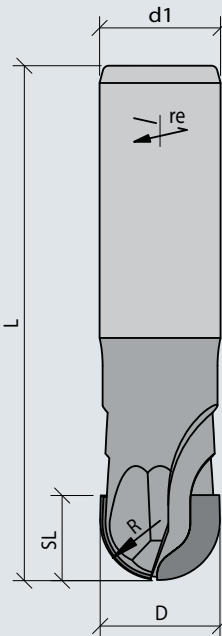
Machines

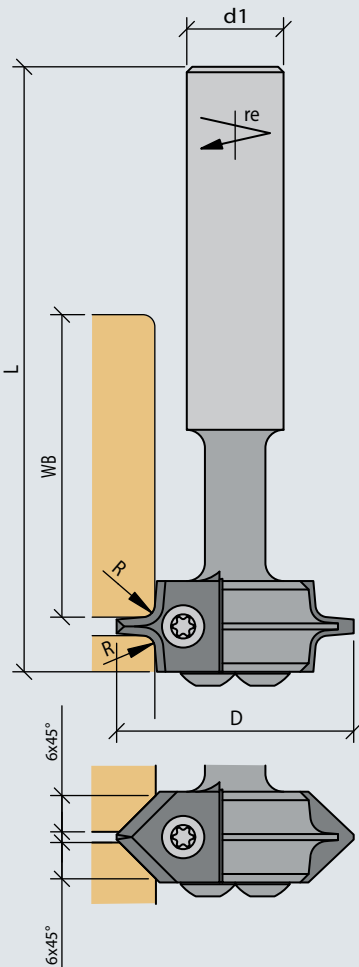
- Gantry CNC router
- CNC machining centres

Technical Information

- Diamond-tipped
- Steel body
- Nickel-plated body
- Polished DP cutting edge
- Fine-eroded clearance face
- Without adjustment screw
- MEC

Art. No.	D	R	SL	d1	L	Z	ZH	DR	n max
TB681099	20	10	14	20	85	2	4,5	re.	24000
TB681100	30	15	19	20	85	2	4,5	re.	22000
TB681101	40	20	24	20	85	2	4,5	re.	20000





WS-PS Rounding / Chamfering Shank Cutter

Application

- For rounding and chamfering
- Universal use on the top and bottom of the workpiece
- Suitable for milling along very tight internal radii on the workpiece

Machines

- Gantry CNC router
- CNC machining centres
- Special milling machines with milling spindles for shank tools

Materials

- Solid wood
- Particleboard and fibreboards (particleboard, MDF, HDF, etc.) raw
- For melamine resin- and paper-coated, HPL- and foil-coated, veneered wood-based panels

Technical Information

- Carbide profile cutting edge
- Steel body
- Black-oxidized body
- A carrier body for radii R2 to R5 mm as well as for a 6x45° chamfer
- TB681120 equipped with radius cutter R2
- MEC

Art. No.	D	R	L	d1	WBmax	Z	DR	n max
TB681120	40	2	100	16	50	2	re.	18000

Spare parts

Art. No.	Detail
TB219091	Profile insert, carbide, B=18 h=15 a=2 R=2
TB219092	Profile insert, carbide, B=18 h=15 a=2 R=3
TB219093	Profile insert, carbide, B=18 h=15 a=2 R=4
TB219094	Profile insert, carbide, B=18 h=15 a=2 R=5
TB219095	Profile insert, carbide, B=18 h=15 a=2, chamfer 6x45°
TB851076	Large head screw M3.5x4 Torx 15
TB851077	Pan head screw M4x5 Torx 15
TB681121	Body without knives, with screws

WS-PS Universal Shank Cutter CAT Flex 45°

Application

- Universal tool for profiling
- Flexible profile design

Machines

- Gantry CNC router
- CNC machining centres

Materials

- Solid wood
- Wood-based panels

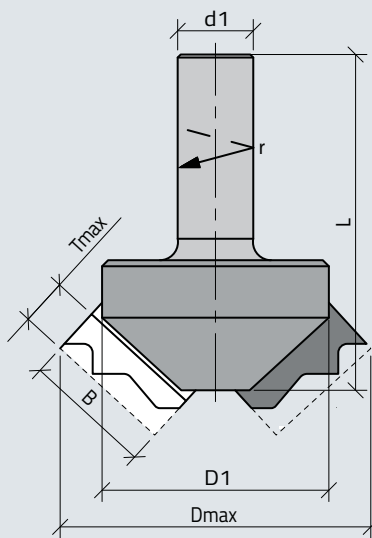
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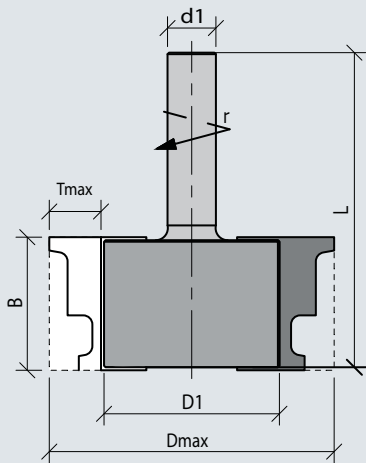
- Carbide profile cutters
- Steel body
- Nickel-plated body
- Constant dimensions
- Simple knife clamping
- Custom profile within the white knife blank area
- MEC

Art. No.	D1	Dmax	B	Tmax	d1	L	Z	DR	n max
TB860508	75	104	45	15,8	25	111	2	re.	15600

Spare parts

Art. No.	Detail
TB851210	Clamping jaw, b=42
TB851016	Set screw M6x16.5 T15





WS-PS Universal Shank Cutter CAT Flex Straight

Application

- Universal tool for profiling
- Flexible profile design

Materials

- Solid wood
- Wood-based panels

Machines

- Gantry CNC router
- CNC machining centres

Technical Information

- Carbide profile cutters
- Steel body
- Nickel-plated body
- Constant dimensions
- Simple knife clamping
- Custom profile within the white knife blank area
- MEC

Art. No.	D1	D max	B	T max	d1	L	Z	DR	n max	Index
TB860530	51	77	25	13	16	91	2	re.	20000	1
TB860502	58	92	25	16	16	84	2	re.	17400	2
TB860503	58	104	45	22	16	104	2	re.	15400	3
TB860505	65	99	25	16	25	90	2	re.	16200	4
TB860506	65	111	45	22	25	110	2	re.	14600	5
TB860507	65	99	65	16	25	130	2	re.	16200	6

Spare parts

Art. No.	Detail	Index
TB851274	Clamping jaw, b=22	1,2,4
TB851210	Clamping jaw, b=42	3,5
TB851214	Clamping jaw, b=62	6
TB851016	Set screw M6x16.5 T15	1 – 6

WS-PS Universal Shank Cutter CAT Flex End-Cutting

Application

- Universal profiling tool
- Flexible in profile design

Materials

- Solid wood
- Wood-based panels

Machines

- Gantry CNC router
- CNC machining centres

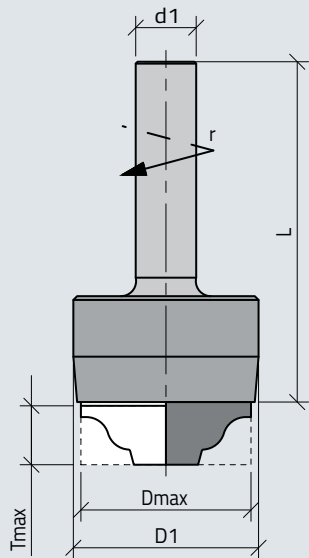
Technical Information

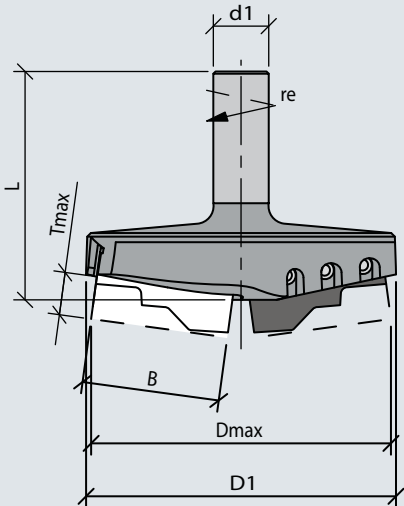
- Carbide profile knives
- Steel tool body
- Nickel-plated tool body
- Constant dimensions
- Simple knife clamping system
- Custom profile within the white knife blank area
- MEC

Art. No.	D1	Dmax	Tmax	d1	L	Z	DR	n max	Index
TB860500	49	45	15	16	90	2	re.	18000	1
TB860501	73	65	17	25	96	2	re.	18000	2

Spare parts

Art. No.	Detail	Index
TB851204	Clamping jaw, b=22	1
TB851208	Clamping jaw, b=32	2
TB851016	Set screw M6x16.5 T15	1 – 2





WS-PS Universal Shank Cutter CAT Flex Flat

Application

- Universal profiling tool
- Flexible in profile design

Materials

- Solid wood
- Wood-based panels

Machines

- Gantry CNC router
- CNC machining centres

Technical Information

- Carbide profile knives
- Steel tool body
- Nickel-plated tool body
- Constant dimensions
- Simple knife clamping system
- Custom profile within the white knife blank area
- MEC

Art. No.	D1	D max	B	T max	d1	L	Z	DR	n max	Index
TB860509	140	140	50	14	25	103	2	re.	10000	1

Spare parts

Art. No.	Detail	Index
TB851284	Clamping jaw, b=62	1
TB851016	Set screw M6x16.5 T15	1

HW Profile Shank Cutter Handle Recess

Application

- For milling different handle profiles
- Left-hand and right-hand versions for chip-free machining

Materials

- Solid wood
- Particleboard and fibreboard materials (particleboard, MDF, HDF etc.) raw
- Melamine- and paper-coated, HPL- and foil-laminated, veneered wood-based panels
- Plywood (plywood, multiplex etc.)

Machines

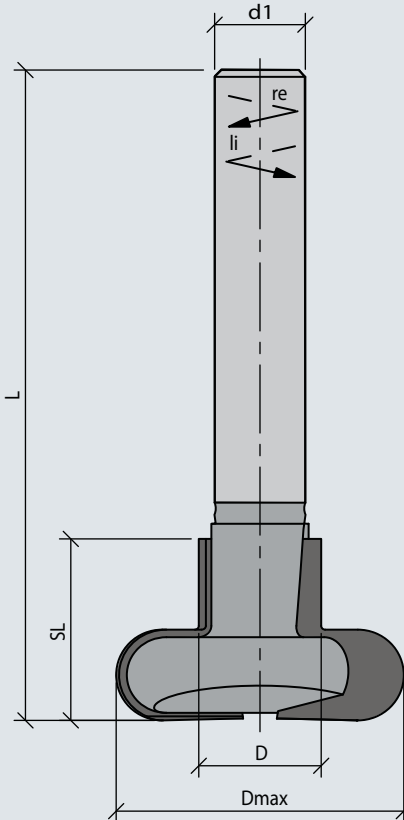
- Gantry CNC router
- CNC machining centres

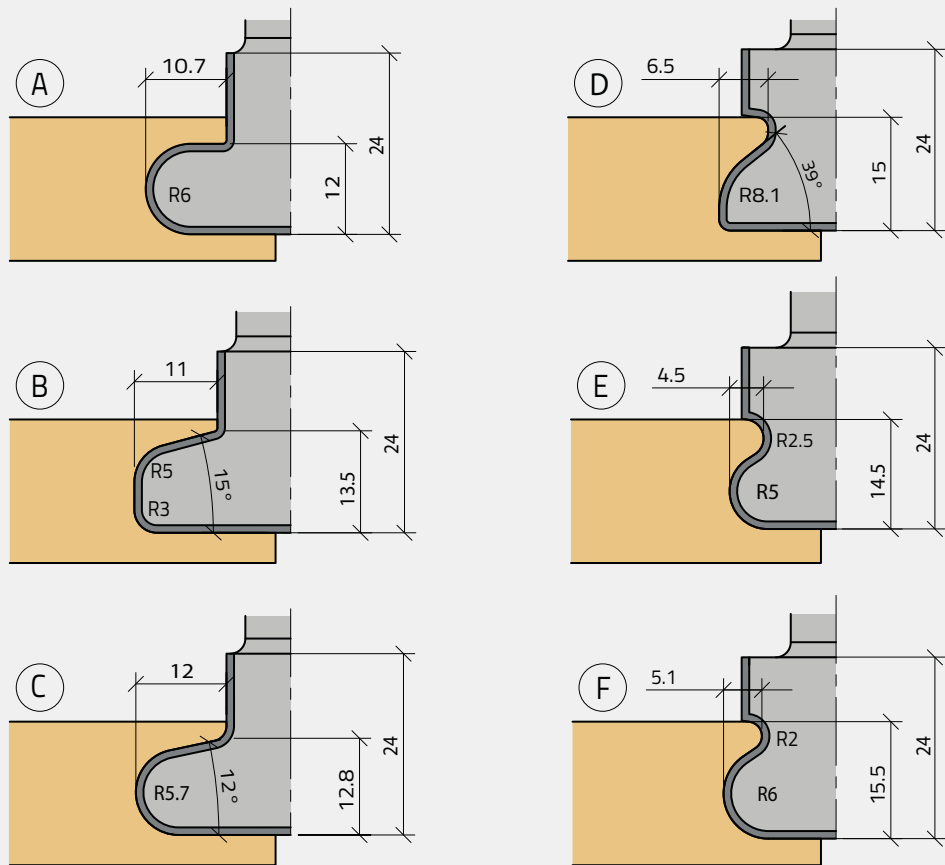
Technical Information

- Carbide-tipped
- Steel tool body
- Black-oxide finished tool body
- Axial straight cutting edge arrangement
- Profile types A to C compatible with the profile knife version
- MAN

Art. No.	Type	D	D max	SL	d1	L	Z	DR	n max
TB681123	A	17	38,4	24	12	86	2	re.	24000
TB681124	A	17	38,4	24	12	86	2	li.	24000
TB681125	B	17	39	24	12	86	2	re.	24000
TB681126	B	17	39	24	12	86	2	li.	24000
TB681127	C	17	41	24	12	86	2	re.	24000
TB681128	C	17	41	24	12	86	2	li.	24000
TB681129	D	18	31	24	12	86	2	re.	24000
TB681130	D	18	31	24	12	86	2	li.	24000
TB681131	E	19,2	28,2	24	12	86	2	re.	24000
TB681132	E	19,2	28,2	24	12	86	2	li.	24000
TB681133	F	19,6	29,8	24	12	86	2	re.	24000
TB681134	F	19,6	29,8	24	12	86	2	li.	24000

Profile types A-F see next page





WS-PS Profile Shank Cutter Handle Recess

- Application**

 - For milling different handle profiles
 - Left-hand and right-hand versions for chip-free machining
- Materials**

 - Solid wood
 - Particleboard and fibreboard materials (particleboard, MDF, HDF etc.) raw
 - Melamine- and paper-coated, HPL- and foil-laminated, veneered wood-based panels
 - Plywood (plywood, multiplex etc.)
- Machines**

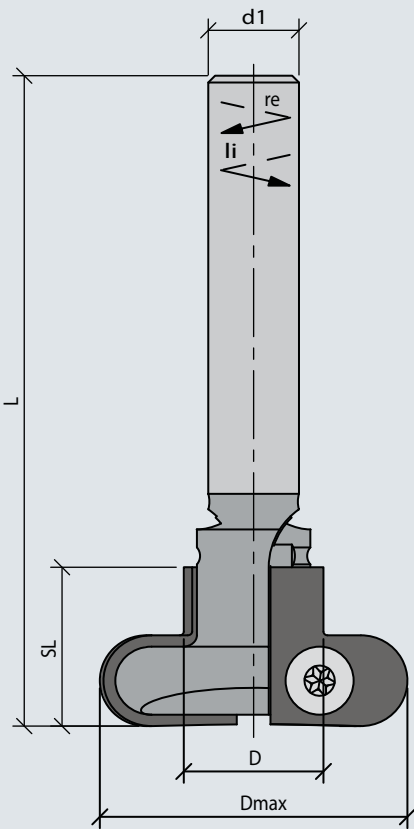
 - Gantry CNC router
 - CNC machining centres
- Technical Information**

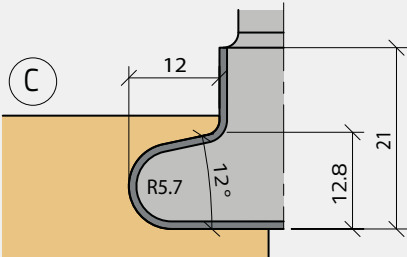
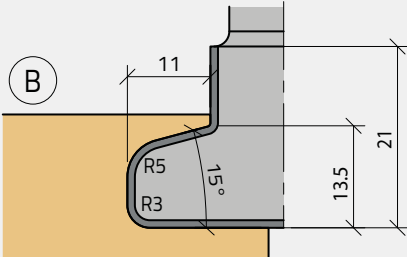
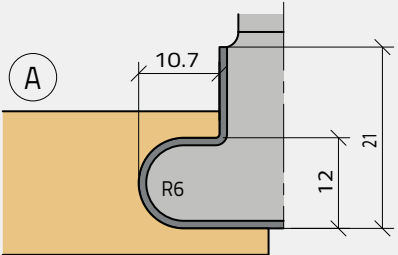
 - Carbide profile knives
 - Steel tool body
 - Nickel-plated tool body
 - Axial straight cutting edge arrangement
 - Profile types A to C compatible with the carbide-tipped version
 - MEC

Art. No.	Type	D	Dmax	SL	d1	L	Z	DR	n max	Index
TB681135	A	20	41,4	21	12	86	2	re.	24000	1
TB681136	A	20	41,4	21	12	86	2	li.	24000	2
TB681137	B	20	42	21	12	86	2	re.	24000	3
TB681138	B	20	42	21	12	86	2	li.	24000	4
TB681139	C	20	44	21	12	86	2	re.	24000	5
TB681140	C	20	44	21	12	86	2	li.	24000	6

Spare parts			
Art. No.	Detail		Index
TB219127	Profile insert, carbide, type A, cutting direction right		1
TB219128	Profile insert, carbide, type A, cutting direction left		2
TB219129	Profile insert, carbide, type B, cutting direction right		3
TB219130	Profile insert, carbide, type B, cutting direction left		4
TB219131	Profile insert, carbide, type C, cutting direction right		5
TB219132	Profile insert, carbide, type C, cutting direction left		6
TA851606	Screw M4x5,9 Torx T15		1 - 6

Profile types A–C see next page





6

Drills



HS Dowel Drill Cylindrical

Application

- Drilling precise blind holes

Machines

- Hand drills
- Bench drilling machines
- CNC machining centres

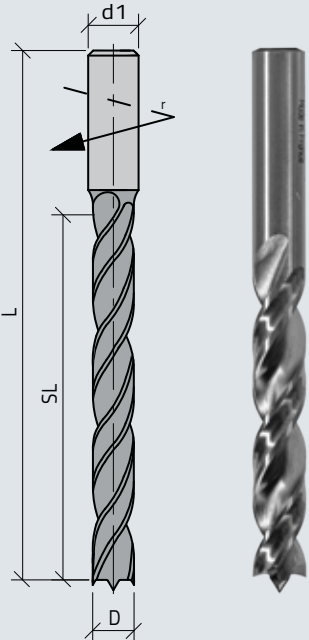
Materials

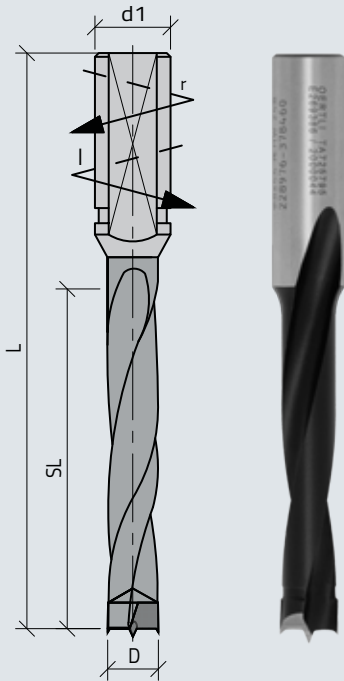
- Solid wood

Technical Information

- High-speed steel (HS)
- Cylindrical shank
- Large chip flute for efficient chip evacuation
- Coated
- MAN

Art. No.	D	SL	d1	L	Z	DR
TA720002	3	33	3	60	2	re.
TA720004	4	43	4	75	2	re.
TB700343	4	100	4	150	2	re.
TA720006	5	52	5	85	2	re.
TB700344	5	100	5	150	2	re.
TA720008	6	57	6	92	2	re.
TB700345	6	100	6	150	2	re.
TA720013	8	75	8	115	2	re.
TB700042	8	100	8	150	2	re.
TA720017	10	87	10	130	2	re.
TB700346	10	100	10	150	2	re.





HW Dowel Drill BASE

Application

- Drilling blind holes

Machines

- CNC machining centres
- Drilling machines
- Hand drills

Materials

- Solid wood
- Wood and wood-based panels
- Melamine- and paper-coated, veneered wood-based panels

Technical Information

- Carbide-tipped
- Steel tool body
- 2 negative scoring cutters
- Cylindrical shank with clamping flat
- Plastic-coated spiral section
- Reduced friction due to offset spiral
- With adjusting screw
- MAN

L=57,5

Art. No.	D	SL	d1	L	Z	DR
TB700130	4,5	27	10	57,5	2	re.
TA725632	5	30	10	57,5	2	re.
TA725633	5	30	10	57,5	2	li.
TA725628	5,1	30	10	57,5	2	re.
TA725629	5,1	30	10	57,5	2	li.
TB700088	5,2	30	10	57,5	2	re.
TB700089	5,2	30	10	57,5	2	li.
TB700132	8,2	30	10	57,5	2	re.
TB700131	8,2	30	10	57,5	2	li.
TB700134	10,5	30	10	57,5	2	re.
TB700133	10,5	30	10	57,5	2	li.
TA725642	12	30	10	57,5	2	re.

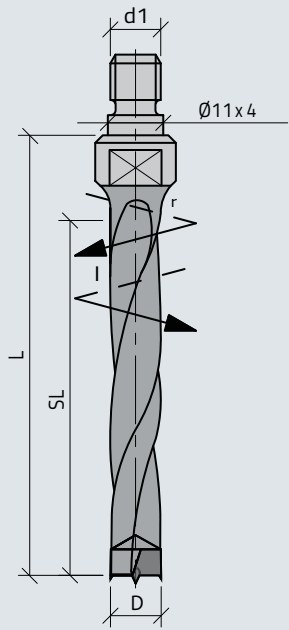
L=70

Art. No.	D	SL	d1	L	Z	DR
TB700136	4	40	10	70	2	re.
TB700135	4	40	10	70	2	li.
TB700094	4,5	40	10	70	2	re.
TB700093	4,5	40	10	70	2	li.
TA725646	5	43	10	70	2	re.
TA725647	5	43	10	70	2	li.
TA725664	5,1	43	10	70	2	re.
TA725665	5,1	43	10	70	2	li.
TB700092	5,2	43	10	70	2	re.
TA725600	5,5	43	10	70	2	re.
TA725648	6	43	10	70	2	re.
TA725649	6	43	10	70	2	li.
TB700137	6,2	43	10	70	2	re.

Art. No.	D	SL	d1	L	Z	DR
TB700139	6,5	43	10	70	2	re.
TB700138	6,5	43	10	70	2	li.
TB700004	7	43	10	70	2	re.
TB700003	7	43	10	70	2	li.
TB700141	7,5	43	10	70	2	re.
TB700140	7,5	43	10	70	2	li.
TA725650	8	43	10	70	2	re.
TA725651	8	43	10	70	2	li.
TB700143	8,1	43	10	70	2	re.
TB700142	8,1	43	10	70	2	li.
TB700145	8,2	43	10	70	2	re.
TB700144	8,2	43	10	70	2	li.
TB700147	8,5	43	10	70	2	re.
TB700146	8,5	43	10	70	2	li.
TA725652	10	43	10	70	2	re.
TA725653	10	43	10	70	2	li.
TB700149	10,2	43	10	70	2	re.
TB700148	10,2	43	10	70	2	li.
TB700150	10,5	43	10	70	2	re.
TA725654	12	43	10	70	2	re.
TA725655	12	43	10	70	2	li.

L=77

Art. No.	D	SL	d1	L	Z	DR
TA725791	5	44	10	77	2	re.
TA725789	5	44	10	77	2	li.
TA725793	6	44	10	77	2	re.
TA725794	6	44	10	77	2	li.
TA725795	8	44	10	77	2	re.
TA725796	8	44	10	77	2	li.
TA725797	10	44	10	77	2	re.
TA725798	10	44	10	77	2	li.
TA725799	12	44	10	77	2	re.
TA725800	12	44	10	77	2	li.



HW Dowel Drill BASE with Threaded Shank M10

Application

- Drilling blind holes

Materials

- Solid wood
- Wood and wood-based panels
- Melamine- and paper-coated, veneered wood-based panels

Machines

- CNC machining centres
- Drilling machines
- Hand drills

Technical Information

- Carbide-tipped
- Steel tool body
- 2 negative scoring cutters
- Plastic-coated spiral section
- Shank with M10 external thread and Ø11 x 4.0 locating fit
- Reduced friction due to offset spiral
- MAN

L=65

Art. No.	D	SL	d1	L	Z	DR
TA725132	6	50	M10	65	2	re.
TA725133	6	50	M10	65	2	li.
TA725134	8	50	M10	65	2	re.
TA725135	8	50	M10	65	2	li.
TA725136	10	50	M10	65	2	re.
TA725137	10	50	M10	65	2	li.
TA725138	12	50	M10	65	2	re.
TA725139	12	50	M10	65	2	li.

VHW Dowel Drill PRO

Application

- Drilling precise blind holes
- For high feed rates
- Long, consistent drilling quality
- Significantly longer tool life compared to conventional dowel drills

Materials

- Solid wood
- Wood and wood-based panels
- Melamine- and paper-coated, veneered wood-based panels

Machines

- CNC machining centres
- Drilling machines

Technical Information

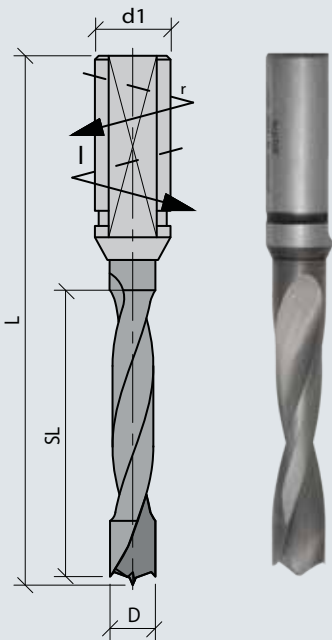
- Solid carbide
- Special cutting geometry
- Centering point
- 2 negative scoring cutters
- Cylindrical shank with clamping flat
- With adjusting screw
- MAN

L=57,5

Art. No.	D	SL	d1	L	Z	DR
TA725450	2,5	16	10	57,5	2	re.
TA725451	2,5	16	10	57,5	2	li.
TA725452	3	16	10	57,5	2	re.
TA725453	3	16	10	57,5	2	li.
TA725456	4	22	10	57,5	2	re.
TA725457	4	22	10	57,5	2	li.
TA725458	5	27	10	57,5	2	re.
TA725459	5	27	10	57,5	2	li.
TA725460	6	27	10	57,5	2	re.
TA725461	6	27	10	57,5	2	li.
TB700251	8	27	10	57,5	2	re.
TB700252	8	27	10	57,5	2	li.
TB700253	10	27	10	57,5	2	re.
TB700254	10	27	10	57,5	2	li.

L=70

Art. No.	D	SL	d1	L	Z	DR
TA725462	3	27	10	70	2	re.
TA725463	3	27	10	70	2	li.
TA725464	3,5	30	10	70	2	re.
TA725465	3,5	30	10	70	2	li.
TA725466	4	32	10	70	2	re.
TA725467	4	32	10	70	2	li.
TA725468	5	35	10	70	2	re.



Art. No.	D	SL	d1	L	Z	DR
TA725469	5	35	10	70	2	li.
TA725470	6	35	10	70	2	re.
TA725471	6	35	10	70	2	li.
TB700255	8	35	10	70	2	re.
TB700256	8	35	10	70	2	li.
TB700257	10	35	10	70	2	re.
TB700258	10	35	10	70	2	li.

VHW Dowel Drill MAX

Application

- For high feed rates
- Long, consistent drilling quality
- Significantly longer tool life compared to conventional dowel drills
- Chip-free hole edges due to special grinding

Materials

- Wood and wood-based panels
- Melamine- and paper-coated, veneered wood-based panels

Machines

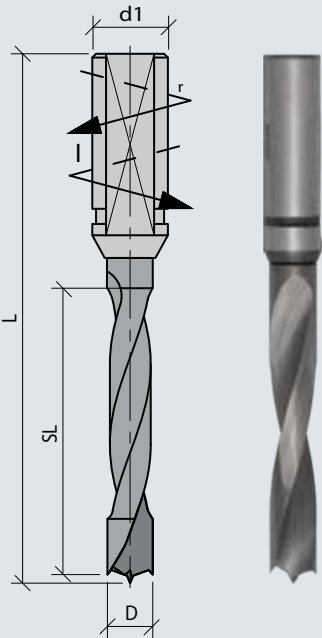
- CNC machining centres
- Drilling machines

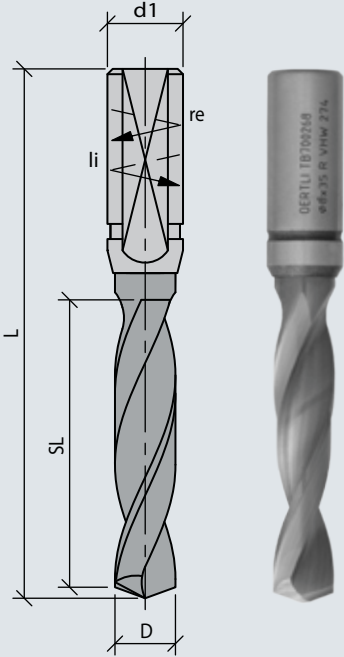
Technical Information

- Solid carbide
- Reduced friction due to offset spiral
- Special cutting geometry
- Centering point
- 2 negative scoring cutters
- Cylindrical shank with clamping flat
- With adjusting screw
- MAN

L=70

Art. No.	D	SL	d1	L	Z	DR
TB700303	4	32	10	70	2	re.
TB700304	4	32	10	70	2	li.
TB700305	5	35	10	70	2	re.
TB700306	5	35	10	70	2	li.
TB700307	6	35	10	70	2	re.
TB700308	6	35	10	70	2	li.
TB700309	8	35	10	70	2	re.
TB700310	8	35	10	70	2	li.
TB700311	10	35	10	70	2	re.
TB700312	10	35	10	70	2	li.





VHW Dowel Drill MAX for Composite Materials

Application

- Drilling blind holes and through holes
- For high feed rates
- Long, consistent drilling quality

Materials

- Wood and wood-based panels
- Melamine- and paper-coated, veneered wood-based panels
- Solid core plastic panels (e.g. Trespa®, Corian®, Varicor®, LG-HiMacs®, etc.)
- Composite materials
- Fiber cement boards

Machines

- CNC machining centres
- Drilling machines

Technical Information

- Solid carbide
- Special cutting geometry
- Cylindrical shank with clamping flat
- With adjusting screw
- MAN

L=70

Art. No.	D	SL	d1	L	Z	DR
TB700259	5	35	10	70	2	re.
TB700260	5	35	10	70	2	li.
TB700261	5,1	35	10	70	2	re.
TB700262	5,2	35	10	70	2	re.
TB700263	5,5	35	10	70	2	re.
TB700264	6	35	10	70	2	re.
TB700265	6	35	10	70	2	li.
TB700266	7	35	10	70	2	re.
TB700267	7	35	10	70	2	li.
TB700268	8	35	10	70	2	re.
TB700269	8	35	10	70	2	li.
TB700270	8,5	35	10	70	2	re.
TB700271	8,5	35	10	70	2	li.
TB700272	9	35	10	70	2	re.
TB700273	9	35	10	70	2	li.
TB700274	9,3	35	10	70	2	re.
TB700275	9,5	35	10	70	2	re.
TB700276	10	35	10	70	2	re.
TB700277	10	35	10	70	2	li.

VHW Dowel Drill SPRINT

Application

- Drilling precise blind holes in solid wood
- Suitable for deep dowel holes in end grain (counter/dowel joints)
- For maximum feed rates
- Significantly longer tool life compared to conventional dowel drills
- Long, consistent drilling quality

Materials

- Solid wood, cross and longitudinal grain
- Plywood (plywood, multiplex etc.)

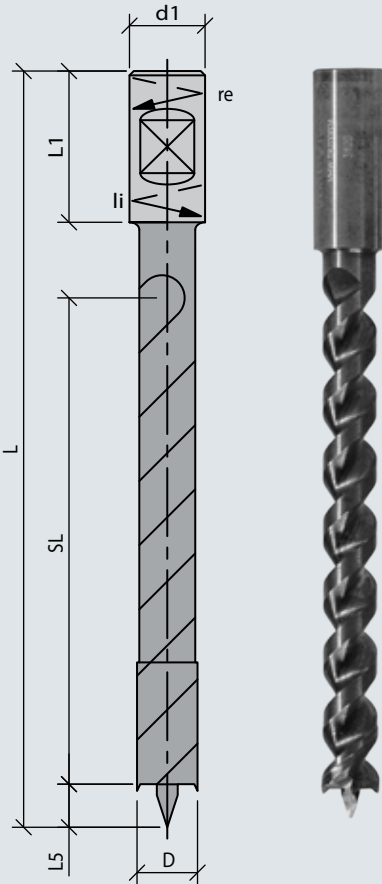
Machines

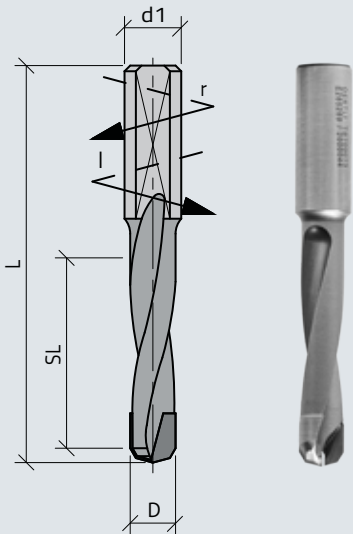
- Drilling machines
- CNC machining centres
- Window machining centres

Technical Information

- Solid carbide
- Very good chip evacuation thanks to large chip flutes
- Reduced friction due to offset spiral
- Special cutting geometry
- Cylindrical shank with clamping flat
- MAN

Art. No.	D	SL	L5	d1	L1	L	Z	DR
TB700424	6	65	4,3	10	30	105	2	re.
TB700065	6	85	4,3	10	30	125	2	re.
TB700425	6	85	4,3	10	30	125	2	li.
TB700022	8	65	5,7	10	30	105	2	li.
TB700023	8	65	5,7	10	30	105	2	re.
TB700053	8	70	5,7	10	20	100	2	re.
TB700054	8	70	5,7	10	20	100	2	li.
TB700000	8	75	5,7	10	30	115	2	li.
TB700001	8	75	5,7	10	30	115	2	re.
TB700024	8	85	5,7	10	30	125	2	re.
TB700025	8	85	5,7	10	30	125	2	li.
TB700426	8	95	5,7	10	30	135	2	re.
TB700427	8	95	5,7	10	30	135	2	li.
TB700026	10	70	7,1	10	30	110	2	re.
TB700428	10	70	7,1	10	30	110	2	li.
TB700429	10	95	7,1	10	30	135	2	re.
TB700430	10	95	7,1	10	30	135	2	li.
TB700431	12	72	8,5	10	30	115	2	re.
TB700432	12	72	8,5	10	30	115	2	li.
TB700433	12	92	8,5	10	30	135	2	re.
TB700434	12	92	8,5	10	30	135	2	li.





DP Dowel Drill

Application

- Drilling blind holes in abrasive materials
- Multiple tool life compared to carbide version

Materials

- Highly abrasive workpiece materials
- Fire-retardant panel materials
- Particleboard and fibreboard materials (particleboard, MDF, HDF etc.) raw
- Gypsum boards
- Not suitable for dense materials such as Corian

Machines

- CNC machining centres
- Drilling machines

Technical Information

- Diamond-tipped
- Special cutting geometry
- 2 DP reaming cutters, designed as double chamfer
- Cylindrical shank with clamping flat
- With adjusting screw
- MAN

L=70

Art. No.	D	SL	d1	L	Z	DR
TB700073	8	35	10	70	2	re.
TB700072	8	35	10	70	2	li.

HW Through-Hole Drill BASE

Application

- Drilling through holes

Materials

- Solid wood
- Wood-based panels

Machines

- CNC machining centres
- Drilling machines
- Hand drilling machines

Technical Information

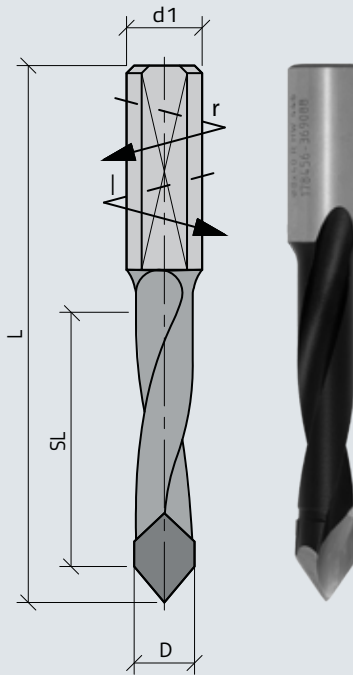
- Carbide-tipped
- Steel tool body
- Point 60°
- Cylindrical shank with clamping flat
- Plastic-coated spiral section
- Reduced friction due to offset spiral
- With adjusting screw
- MAN

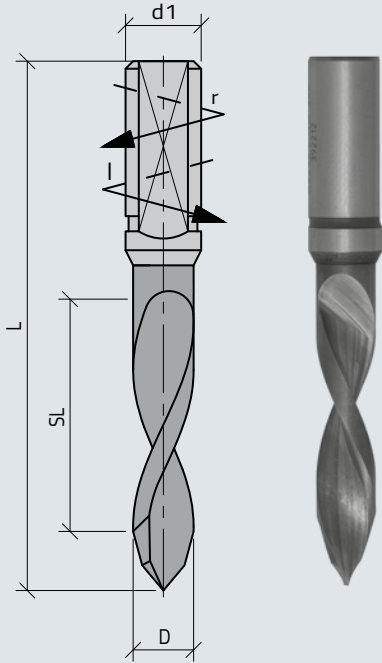
L=70

Art. No.	D	SL	d1	L	Z	DR
TA726022	4,5	40	10	70	2	re.
TA726023	4,5	40	10	70	2	li.
TA726010	5	40	10	70	2	re.
TA726011	5	40	10	70	2	li.
TB700153	5,5	40	10	70	2	re.
TB700160	5,5	40	10	70	2	li.
TB700103	6,5	40	10	70	2	re.
TB700104	6,5	40	10	70	2	li.
TA726024	7	40	10	70	2	re.
TA726025	7	40	10	70	2	li.
TB700154	7,5	40	10	70	2	re.
TB700156	8,5	40	10	70	2	re.
TB700155	8,5	40	10	70	2	li.
TA726028	12	40	10	70	2	re.
TA726029	12	40	10	70	2	li.

L=77

Art. No.	D	SL	d1	L	Z	DR
TA726030	5	40	10	77	2	re.
TA726031	5	40	10	77	2	li.
TA726032	6	40	10	77	2	re.
TA726033	6	40	10	77	2	li.
TA726040	7	40	10	77	2	re.
TA726041	7	40	10	77	2	li.
TA726034	8	40	10	77	2	re.
TA726035	8	40	10	77	2	li.
TA726036	10	40	10	77	2	re.
TA726037	10	40	10	77	2	li.
TA726038	12	40	10	77	2	re.
TA726039	12	40	10	77	2	li.





VHW Through-Hole Drill PRO

Application

- Drilling through holes
- For high feed rates
- Long, consistent drilling quality
- Significantly longer tool life compared to conventional through-hole drills

Materials

- Wood-based panels
- Melamine-coated and paper-coated, veneered wood-based panels

Machines

- CNC machining centres
- Drilling machines
- Hand drilling machines

Technical Information

- Carbide-tipped
- Steel tool body
- Point 60°
- Cylindrical shank with clamping flat
- Plastic-coated spiral section
- Reduced friction due to offset spiral
- With adjusting screw
- MAN

L=57,5

Art. No.	D	SL	d1	L	Z	DR
TB700278	3	16	10	57,5	2	re.
TB700279	3	16	10	57,5	2	li.
TB700280	5	24	10	57,5	2	re.
TB700281	5	24	10	57,5	2	li.
TB700282	8	24	10	57,5	2	re.
TB700283	8	24	10	57,5	2	li.

L=70

Art. No.	D	SL	d1	L	Z	DR
TB700284	3	25	10	70	2	re.
TB700285	3	25	10	70	2	li.
TB700286	3,5	25	10	70	2	re.
TB700287	3,5	25	10	70	2	li.
TB700288	4	29	10	70	2	re.
TB700289	4	29	10	70	2	li.
TB700290	5	35	10	70	2	re.
TB700291	5	35	10	70	2	li.
TB700292	6	35	10	70	2	re.
TB700293	6	35	10	70	2	li.
TB700294	8	33	10	70	2	re.
TB700295	8	33	10	70	2	li.
TB700296	10	33	10	70	2	re.
TB700297	10	33	10	70	2	li.

VHW Through-Hole Drill MAX

Application

- For high feed rates
- Long, consistent drilling quality
- Significantly longer tool life compared to conventional through-hole drills
- Tear-free hole edges thanks to special grinding

Materials

- Wood and wood-based panels
- Melamine-coated and paper-coated, veneered wood-based panels

Machines

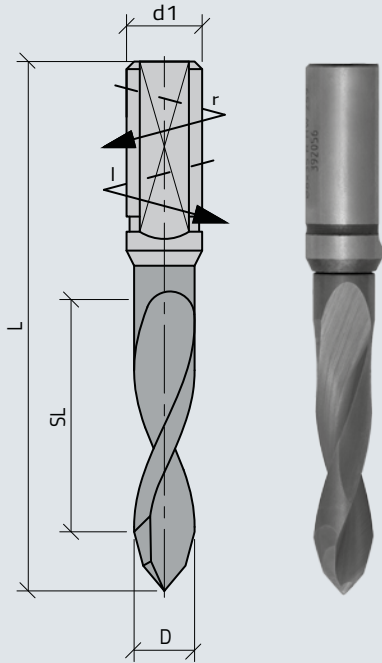
- CNC machining centres
- Drilling machines

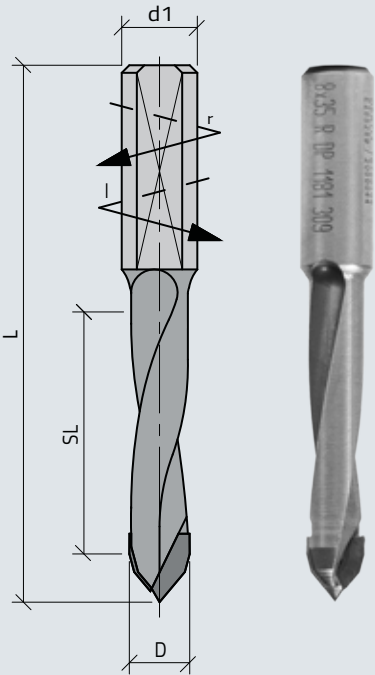
Technical Information

- Solid carbide
- Reduced friction due to offset spiral
- Special cutting geometry
- Cylindrical shank with clamping flat
- With adjusting screw
- MAN

L=70

Art. No.	D	SL	d1	L	Z	DR
TB700313	5	35	10	70	2	re.
TB700314	5	35	10	70	2	li.
TB700315	8	33	10	70	2	re.
TB700316	8	33	10	70	2	li.





DP Through-Hole Drill

Application

- Drilling through holes in abrasive materials
- Multiple tool life compared to carbide version

Materials

- Highly abrasive workpiece materials
- Fire-retardant panel materials
- Particleboard and fibreboard materials (particleboard, MDF, HDF etc.) raw
- Gypsum boards
- Not suitable for dense materials such as Corian

Machines

- CNC machining centres
- Drilling machines

Technical Information

- Diamond-tipped
- Special cutting geometry
- Flat point designed as double chamfer
- Cylindrical shank with clamping flat
- With adjusting screw
- MAN

L=70

Art. No.	D	SL	d1	L	Z	DR
TB700108	8	35	10	70	2	re.
TB700107	8	35	10	70	2	li.

HW Cylindrical Head Drill BASE

Application

- Drilling blind holes

Materials

- Solid wood
- Wood-based panels

Machines

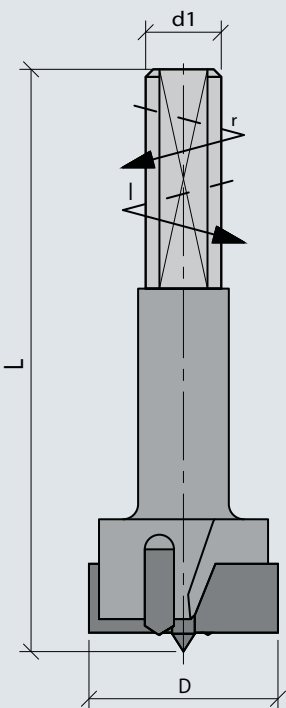
- Hardware drilling machines
- CNC machining centres
- Drilling machines
- Hand drilling machines

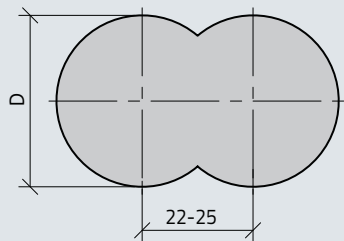
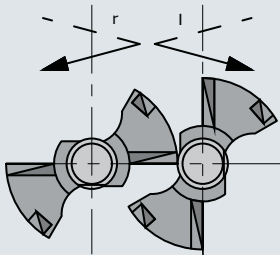
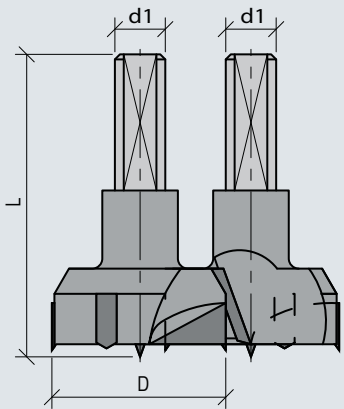
Technical Information

- Carbide-tipped
- Steel tool body
- 2 negative spurs
- Centering point
- Cylindrical shank with clamping flat
- With adjusting screw
- MAN

L=70

Art. No.	D	d1	L	Z	DR
TA725821	15	10	70	2	re.
TA725822	15	10	70	2	li.
TA725823	20	10	70	2	re.
TA725824	20	10	70	2	li.
TA725825	25	10	70	2	re.
TA725826	25	10	70	2	li.
TA725827	30	10	70	2	re.
TA725828	30	10	70	2	li.
TB700005	34	10	70	2	re.
TB700076	34	10	70	2	li.
TA725829	35	10	70	2	re.
TA725830	35	10	70	2	li.





HW Cylindrical Head Drill BASE for Concealed Hinges

Application

- Drilling blind holes
- Tear-free hole edges also for edge drilling

Materials

- Solid wood
- Wood-based panels

Machines

- Hardware drilling machines
- CNC machining centres
- Drilling machines

Technical Information

- Carbide-tipped
- Steel tool body
- Special spur geometry
- Centering point
- Very good chip evacuation thanks to large chip flutes
- Cylindrical shank with clamping flat
- With adjusting screw
- MAN

Bohrer-Set

Art. No.	D	d1	L	Z	DR
TB700066	30	10	57,5	2	re./li.
TB700067	34	10	57,5	2	re./li.

Einzelbohrer

Art. No.	D	d1	L	Z	DR
TB700064	30	10	57,5	2	re.
TB700063	30	10	57,5	2	li.
TB700006	34	10	57,5	2	re.
TB700060	34	10	57,5	2	li.

HW Cylindrical Head Drill PRO

Application

- Drilling blind holes
- Tear-free hole edges also for edge drilling

Materials

- Solid wood
- Wood-based panels

Machines

- Hardware drilling machines
- CNC machining centres
- Drilling machines
- Hand drilling machines

Technical Information

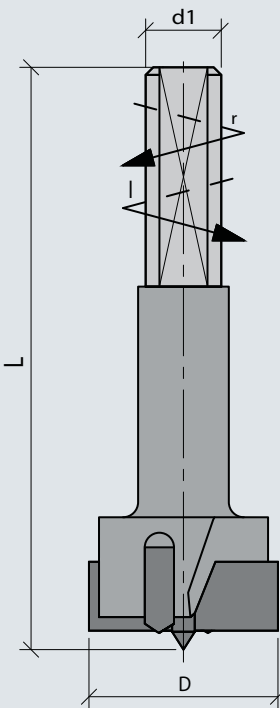
- Carbide-tipped
- Steel tool body
- Special spur geometry
- Centering point
- Very good chip evacuation thanks to large chip flutes
- Cylindrical shank with clamping flat
- With adjusting screw
- MAN

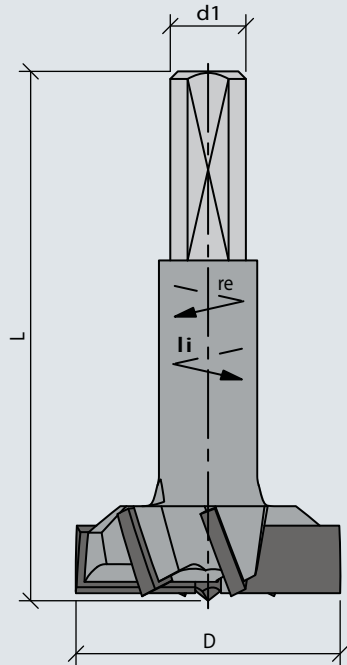
L=57,5

Art. No.	D	d1	L	Z	DR
TB700317	15	10	57,5	2	re.
TB700318	15	10	57,5	2	li.
TB700319	20	10	57,5	2	re.
TB700320	20	10	57,5	2	li.
TB700321	25	10	57,5	2	re.
TB700322	25	10	57,5	2	li.
TB700323	30	10	57,5	2	re.
TB700324	30	10	57,5	2	li.
TB700325	35	10	57,5	2	re.
TB700326	35	10	57,5	2	li.

L=70

Art. No.	D	d1	L	Z	DR
TB700327	15	10	70	2	re.
TB700328	15	10	70	2	li.
TB700329	20	10	70	2	re.
TB700330	20	10	70	2	li.
TB700331	25	10	70	2	re.
TB700332	25	10	70	2	li.
TB700333	30	10	70	2	re.
TB700334	30	10	70	2	li.
TB700335	35	10	70	2	re.
TB700336	35	10	70	2	li.





HW Cylindrical Head Drill MAX

Application

- Tear-free drilling of blind holes at high feed rates
- Tear-free hole edges for concealed hinges

Machines

- Hardware drilling machines
- CNC machining centres
- Drilling machines

Materials

- Particleboard and fibreboard materials (particleboard, MDF, HDF etc.) raw
- Melamine-coated and paper-coated, HPL- and foil-coated, veneered wood-based panels
- Solid wood, wood-based panels

Technical Information

- Carbide-tipped
- Z = 2+4 design for long tool life and high feed rates
- Tear-free hole edges thanks to the special geometry of the 4 pre-cutting edges
- Very good chip evacuation thanks to large chip flutes
- Cylindrical shank with clamping flat
- With adjusting screw
- MAN

Art. No.	D	d1	L	Z	DR
TB700337	25	10	70	2	re.
TB700338	25	10	70	2	li.
TB700339	30	10	70	2	re.
TB700340	30	10	70	2	li.
TB700341	35	10	70	2	re.
TB700342	35	10	70	2	li.

VHW Spiral Drill

Application

- Drilling blind and through holes

Machines

- Hand drilling machines
- Bench drilling machines
- CNC machining centres

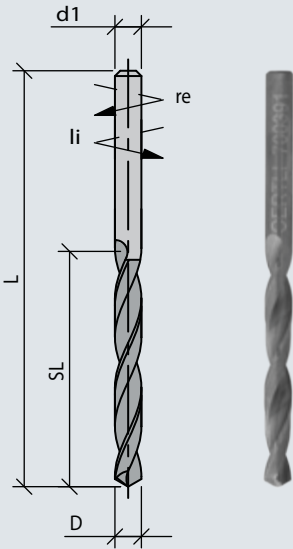
Materials

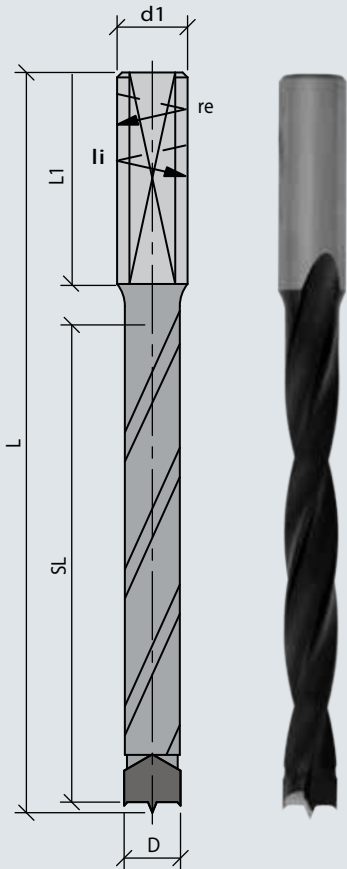
- Solid wood, wood-based panels
- Solid core plastic panels (e.g. Trespa®, Corian®, Varicor®, LG-HiMacs, etc.)

Technical Information

- Solid carbide
- Cylindrical shank
- Point 120°
- MAN

Art. No.	D	SL	d1	L	Z	DR
TB700384	2	12	2	38	2	li.
TB700385	2	12	2	38	2	re.
TB700386	3	30	3	55	2	li.
TB700387	3	30	3	55	2	re.
TB700388	3.2	36	3.2	65	2	li.
TB700389	3.2	36	3.2	65	2	re.
TB700390	3.5	30	3.5	55	2	li.
TB700391	3.5	30	3.5	55	2	re.
TB700392	4	30	4	55	2	li.
TB700393	4	30	4	55	2	re.
TB700394	5	35	5	60	2	li.
TB700395	5	35	5	60	2	re.





HW Dowel Drill with Back Guide

Application

- Drilling blind holes

Materials

- Solid wood, wood-based panels

Machines

- Hand drilling machines
- Bench drilling machines
- CNC machining centres

Technical Information

- Carbide-tipped
- Steel tool body
- Cylindrical shank with clamping flat
- 2 negative spurs
- Back guide improves centering during retraction
- Stepless attachment of the countersink on the drill shank possible
- MAN

Art. No.	D	SL	d1	L1	L	Z	DR
TB700360	5	65	10	30	105	2	re.
TB700361	5	65	10	30	105	2	li.
TB700362	6	65	10	30	105	2	re.
TB700363	6	65	10	30	105	2	li.
TB700364	7	65	10	30	105	2	re.
TB700365	7	65	10	30	105	2	li.
TB700366	8	65	10	30	105	2	re.
TB700367	8	65	10	30	105	2	li.
TB700368	10	65	10	30	105	2	re.
TB700369	10	65	10	30	105	2	li.
TB700370	12	65	10	30	105	2	re.
TB700371	12	65	10	30	105	2	li.
TB700372	5	50	10	27	85	2	re.
TB700373	5	50	10	27	85	2	li.
TB700374	6	50	10	27	85	2	re.
TB700375	6	50	10	27	85	2	li.
TB700376	7	55	10	27	85	2	re.
TB700377	7	55	10	27	85	2	li.
TB700378	8	50	10	27	85	2	re.
TB700379	8	50	10	27	85	2	li.
TB700380	10	50	10	27	85	2	re.
TB700381	10	50	10	27	85	2	li.
TB700382	12	50	10	27	85	2	re.
TB700383	12	50	10	27	85	2	li.

HW Cylindrical Dowel Drill with Back Guide

Application

- Drilling precise blind holes

Materials

- Solid wood, wood-based panels

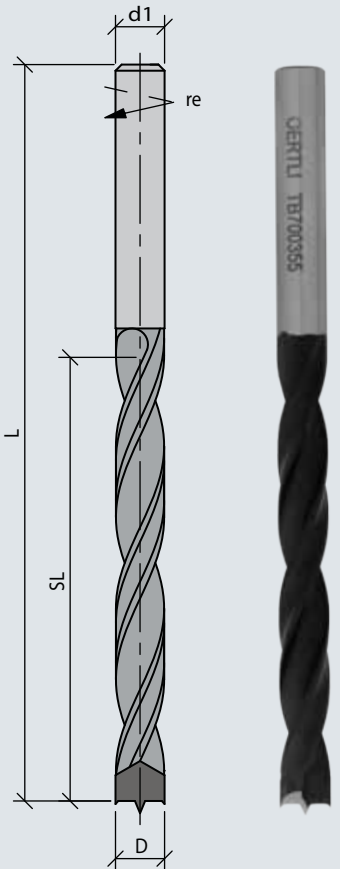
Machines

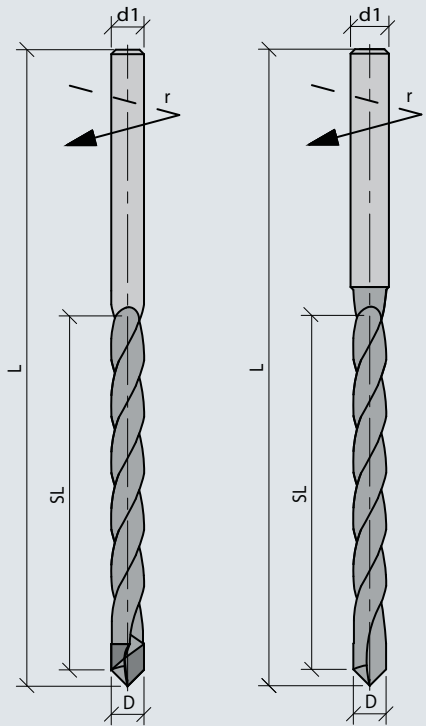
- Hand drilling machines
- Bench drilling machines
- CNC machining centres

Technical Information

- Carbide-tipped
- Steel tool body
- Cylindrical shank
- 2 negative spurs
- Back guide improves centering during retraction
- Stepless attachment of the countersink on the drill shank possible
- MAN

Art. No.	D	SL	d1	L	Z	DR
TB700347	4	55	4	80	2	re.
TB700348	4.5	60	4.5	85	2	re.
TB700349	5	60	5	90	2	re.
TB700350	5.5	65	5.5	100	2	re.
TB700351	6	35	10	100	2	re.
TB700352	6	65	6	100	2	re.
TB700353	6.5	70	6.5	110	2	re.
TB700354	7	70	7	110	2	re.
TB700355	8	75	8	120	2	re.
TB700356	8.5	80	8.5	130	2	re.
TB700357	10	90	10	140	2	re.
TB700358	11	95	11	150	2	re.
TB700359	12	100	12	155	2	re.





HW/VHW Through-Hole Drill

Application range

- For drilling blind holes in solid wood, wood-based panels

Design

- Carbide solid cutting head or solid carbide (VHW)
- Cylindrical shank
- MAN

Art. No.	Type	D	SL	d1	L	Z	DR
TA720080	HW	7	80	7	137	2	re.
TA720081	HW	8,5	80	8,5	137	2	re.
TB700113	VHW	8,5	80	8,8	137	2	re.

VHW Drill Pin

Application

- Especially suitable for blind holes in abrasive materials
- Suitable for blind holes in dry solid wood
- Not suitable for HPL

Materials

- Solid wood, wood-based panels
- Highly abrasive workpiece materials
- Panel materials with delicate, thin coatings

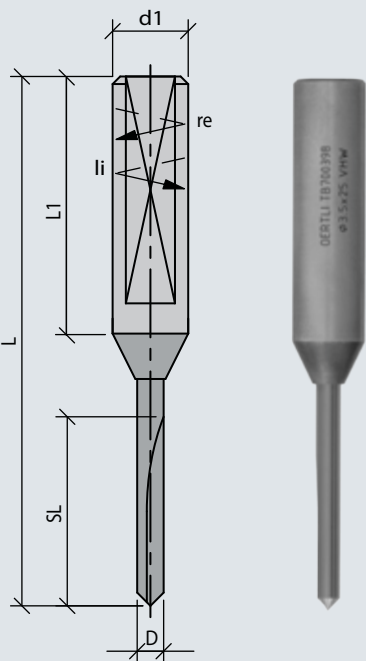
Machines

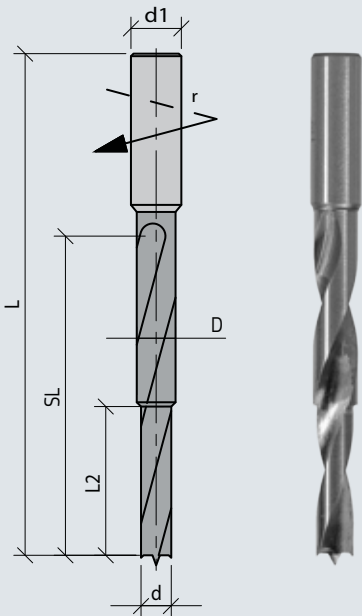
- Drilling machines
- CNC machining centres
- Hardware drilling machines

Technical Information

- Solid carbide
- Axially parallel chip flutes
- Conical point
- Cylindrical shank with clamping flat
- Suitable for clockwise and counter-clockwise rotation
- MAN

Art. No.	D	SL	d1	L1	L	Z	DR
TB700396	2.5	16	10	34	70	2	li./re.
TB700397	3.0	25	10	34	70	2	li./re.
TB700398	3.5	25	10	34	70	2	li./re.
TB700399	4.0	32	10	27	70	2	li./re.
TB700400	5.0	35	10	24	70	2	li./re.





HS Step Drill

Application

- For hinge drilling ANUBA, Simonswerk and others

Machines

- CNC machining centres
- Hardware drilling machines
- Hand drilling machines

Materials

- Solid wood, wood-based panels

Technical Information

- High-speed steel (HS)
- Cylindrical shank or M10 threaded shank
- 1st step with countersink 45°
- 2 negative spurs
- MAN

d1=10

Art. No.	d	D	L2	SL	d1	L	Z	DR
TA725430	5,8	7,2	30	65	10	100	2	re.
TB700046	6	6,8	15	65	10	105	2	re.
TA725431	6	7,7	30	65	10	100	2	re.
TB700047	6,3	7,2	24	64	10	105	2	re.
TB700048	6,7	7,7	30	65	10	105	2	re.
TA725432	7,3	8,7	30	65	10	100	2	re.
TB700049	7,7	8,7	30	65	10	105	2	re.
TA725433	8,1	9,8	30	65	10	100	2	re.
TB700050	8,8	9,8	30	65	10	105	2	re.

d1=M10

Art. No.	d	D	L2	SL	d1	L	Z	DR
TA725435	6	7,7	30	70	M10	105	2	re.
TA725436	7,3	8,7	30	70	M10	105	2	re.
TA725437	8,4	9,8	30	70	M10	105	2	re.

HS Countersink

Application

- Countersinking pre-drilled holes

Machines

- CNC machining centres
- Bench drilling machines
- Hand drilling machines

Materials

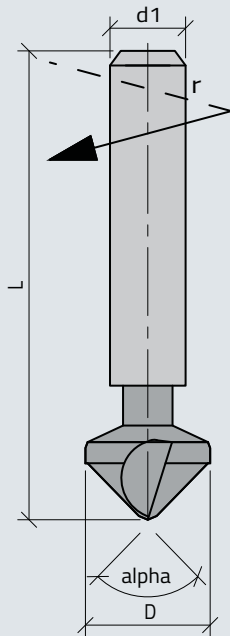
- Solid wood
- Wood-based panel

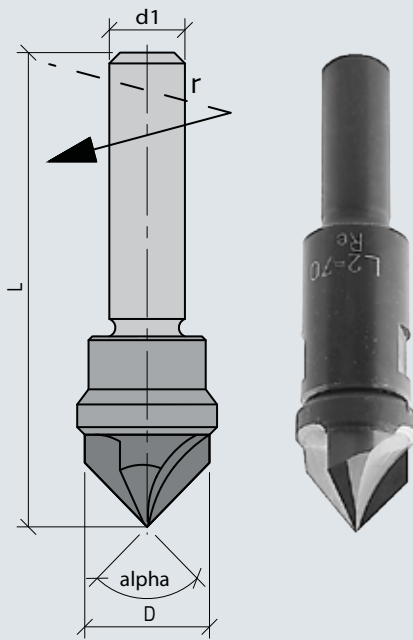
Technical Information

- High-speed steel (HS)
- Cylindrical shank
- MAN

Art. No.	D	d1	L	alpha	Z	DR
TA724002	10,4	6	47	90°	3	re.
TA724003	12,4	8	58	90°	3	re.
TA724005	16,5	10	62	90°	3	re.
TA724014*	20,5	10	35	90°	3	re.
TA724010	20,5	10	65	90°	3	re.
TA724012	25	10	67	90°	3	re.

* with clamping flat, in combination with drill chuck TA725550





VHW Countersink

Application

- Countersinking pre-drilled holes

Machines

- CNC machining centres
- Bench drilling machines
- Hand drilling machines

Materials

- Solid wood
- Wood-based panels

Technical Information

- Solid carbide
- Cylindrical shank with clamping flat
- With adjusting screw
- MAN

Art. No.	D	d1	L	alpha	Z	DR
TA724006	14	10	56	90°	3	re.
TA724009	14	10	70	90°	3	re.

HW Countersink with Shank

Application

- For stepless countersinking of drilled holes

Machines

- Bench drilling machines
- Drilling machines
- CNC machining centres

Materials

- Solid wood
- Wood-based panels
- Laminated wood (plywood, multiplex etc.)

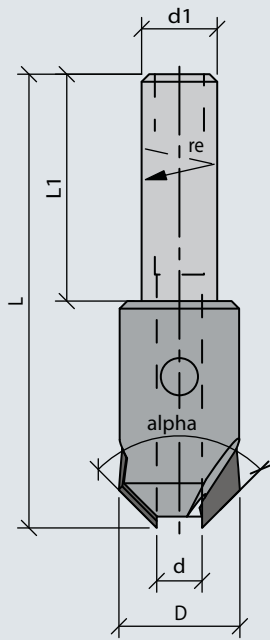
Technical Information

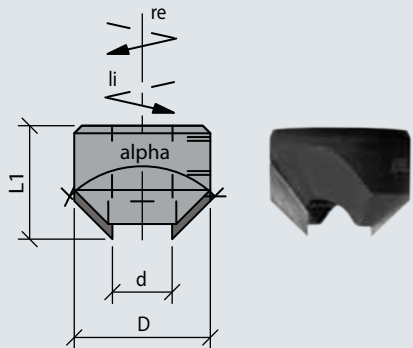
- Carbide-tipped
- Steel tool body
- Cylindrical shank
- MAN

Art. No.	d	D	d1	L1	L	alpha	Z	DR	Index
TB700401	3	16	10	30	60	90°	2	re.	1
TB700405	3,5	16	10	30	60	90°	2	re.	2
TB700402	4	16	10	30	60	90°	2	re.	3
TB700406	4,5	16	10	30	60	90°	2	re.	4
TB700403	5	16	10	30	60	90°	2	re.	5
TB700407	5,5	16	10	30	60	90°	2	re.	6
TB700404	6	16	10	30	60	90°	2	re.	7

Spare parts

Art. No.	Detail	Index
TA851199	Set screw M6x6, hex socket (3 mm)	1 - 7





HW Countersink

Application

- For stepless countersinking of drilled holes

Machines

- Bench drilling machines
- Drilling machines
- CNC machining centres

Materials

- Solid wood
- Wood-based panels
- Laminated wood (plywood, multiplex etc.)

Technical Information

- Carbide-tipped
- Steel tool body
- Suitable for spiral drills and dowel drills with back guide
- Mounted on the drill spiral by means of a set screw
- Stepless adjustment of the countersink diameter and drilling depth possible
- MAN

Art. No.	d	D	L1	alpha	Z	DR	Index
TB700408	4	14	15	90°	2	li.	1
TB700409	4	14	15	90°	2	re.	2
TB700410	5	16	15	90°	2	li.	3
TB700411	5	16	15	90°	2	re.	4
TB700412	6	16	15	90°	2	li.	5
TB700413	6	16	15	90°	2	re.	6
TB700414	7	18	15	90°	2	li.	7
TB700415	7	18	15	90°	2	re.	8
TB700416	8	18	15	90°	2	li.	9
TB700417	8	18	15	90°	2	re.	10
TB700418	9	20	15	90°	2	li.	11
TB700419	9	20	15	90°	2	re.	12
TB700420	10	20	15	90°	2	li.	13
TB700421	10	20	15	90°	2	re.	14
TB700422	12	22	15	90°	2	li.	15
TB700423	12	22	15	90°	2	re.	16

Spare parts

Art. No.	Detail	Index
TA851447	Set screw M5x6	1 - 16

Drill Chuck

Application range

- Drill chuck for holding drills with cylindrical shank Ø10 mm and clamping flat

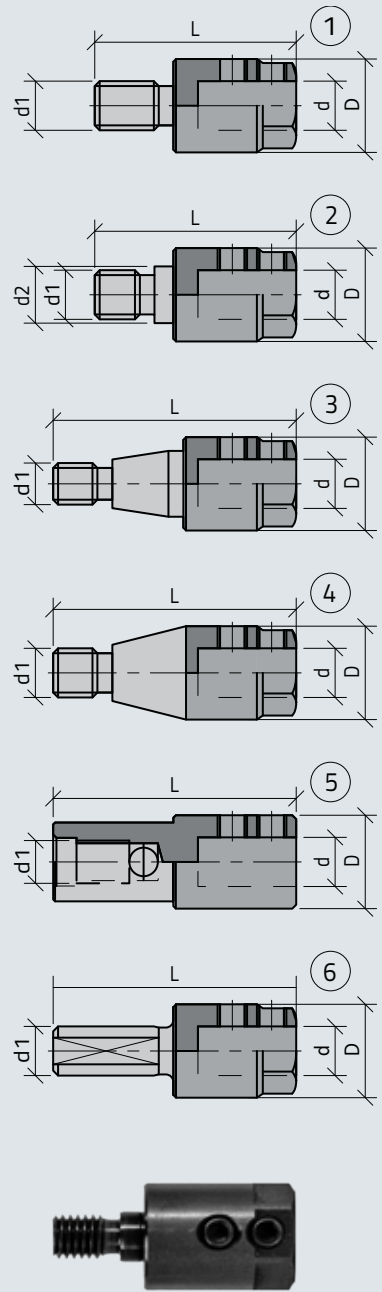
Design

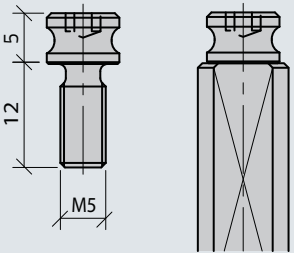
- Two clamping screws

Art. No.	Machines	d	D	d1	L	DR	Index
Fig. No. 1 shank M8 external thread							
TA725563	Nottmeyer	10	19	M8	40	re.	1
TA725564	Nottmeyer	10	19	M8	40	li.	2
Fig. No. 1 shank M10 external thread							
TA725553	Ayen/Mayer/Holma	10	19	M10	40	re.	3
TA725554	Ayen/Mayer/Holma	10	19	M10	40	li.	4
Fig. No. 2 shank M8 external thread, fitted seat d2=Ø9 mm							
TA725573	Nottmeyer	10	19	M8	40	re.	5
TA725574	Nottmeyer	10	19	M8	40	li.	6
TA725577	Nottmeyer	10	19	M8	52	re.	7
TA725578	Nottmeyer	10	19	M8	52	li.	8
Fig. No. 2 shank M10 external thread, fitted seat d2=Ø11 mm							
TA725543	Torwegge/Weeke	10	19	M10	41	re.	9
TA725544	Torwegge/Weeke	10	19	M10	41	li.	10
Fig. No. 3 shank M8 external thread, centering cone							
TA725523	Bilek, Type K+N	10	19	M8	51	re.	11
TA725524	Bilek, Type K+N	10	19	M8	51	li.	12
Fig. No. 4 shank M10 external thread, centering cone							
TA725533	Bilek/Schleicher	10	19	M10	47	re.	13
TA725534	Bilek/Schleicher	10	19	M10	47	li.	14
Fig. No. 5 shank M10 internal thread							
TA725583	Scheer	10	19	M10	46	re.	15
TA725584	Scheer	10	19	M10	46	li.	16
Fig. No. 6 shank Ø10 with clamping surface							
TA725550		10	19	10	55	re./li.	17

Spare parts

Art. No.	Detail	Index
TA851199	Set screw M6x6, hex socket (3 mm)	1 - 17



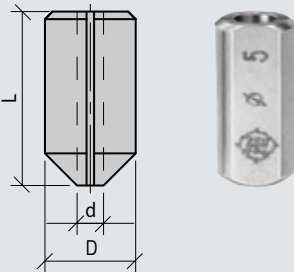


Length Adjustment Screw

Application range

- Adjustment screw for drills with cylindrical shank Ø10 mm and clamping flat
- For use with quick-change chuck

Art. No.	Type
TA851270	M5x17



Clamping Sleeves

Application range

- In combination with solid carbide (VHW) drill

Art. No.	d	D	L
TA725766	2	10	23
TA725767	3	10	23
TA725769	3,5	10	23
TA725770	4	10	23
TA725780	5	10	23

Adapter with Cylindrical Shank

Application range

- Suitable for solid carbide (VHW) drills

Art. No.	d	D	d1	L2	L	Index
TA721030	2	15	10	19	40	1
TA721031	3	15	10	19	40	2
TA721032	3,5	15	10	19	40	3
TA721033	4	15	10	19	40	4
TA721034	5	15	10	19	40	5

Spare parts

Art. No.	Detail	Index
TA851199	Set screw M6x6, hex socket (3 mm)	1 – 5

Extension with Clamping Screw

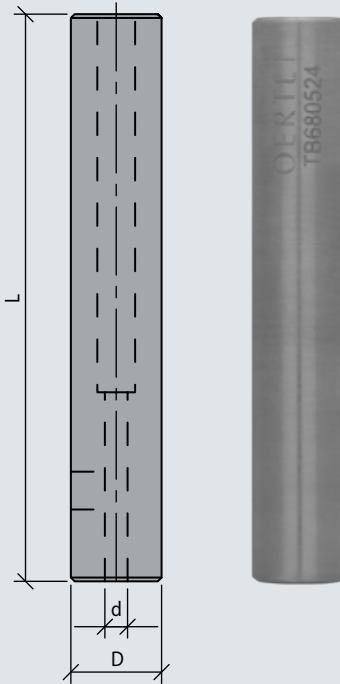
Application range

- In combination with Ø3 drills
- For pre-drilling, e.g. for rebated doors and rebated gear units

Art. No.	d	D	L
TB680524	3	12	75

Spare parts

Art. No.	Detail
TA851447	Set screw M5x6



Clamping Devices



Collet Chuck HSK

Application

- For high-precision clamping of shank tools with cylindrical shank

Machines

- CNC machining centres
- Machines with HSK interfaces

Technical Information

- Hardened and ground precision design
- Rotation-direction independent
- Increased clamping force thanks to ball-bearing precision clamping nut
- Finely balanced for speeds up to 24,000 rpm

HSK 63F

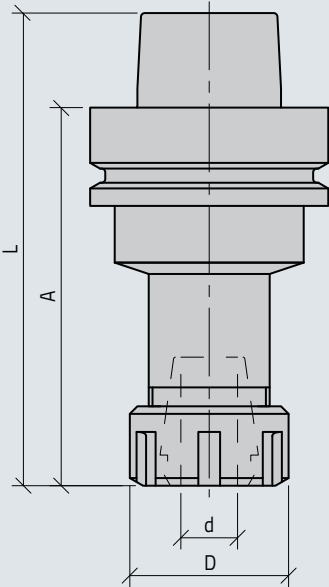
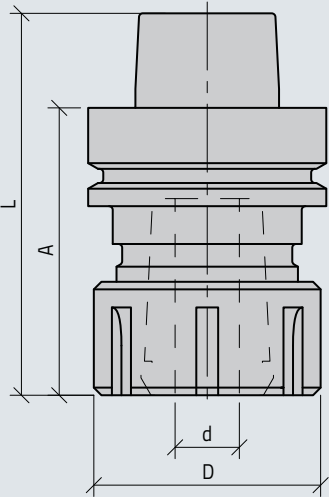
Art. No.	Type	d	D	A	L	n max	Index
TA676996	HSK 63F / ER 25	3 - 16	42	100	125	24000	1
TA676909	HSK 63F / E 462	3 - 25	60	76	101	24000	2
TB676900	HSK 63F / ER 40	2 - 30	63	95	120	24000	3

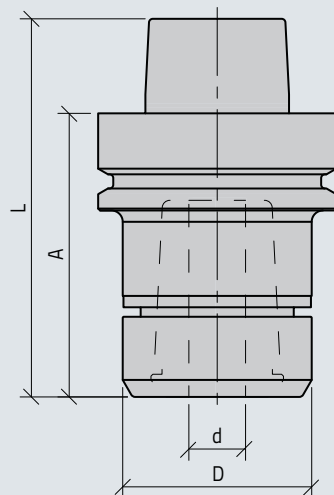
HSK 63E

Art. No.	Type	d	D	A	L	n max	Index
TB676903	HSK 63E / ER 40	2 - 30	63	78	110	24000	4

Spare parts

Art. No.	Detail	Index
TA676933	Clamping nut M32x1.5, type ER 25	1
TA676954	Clamping nut M48x2.0, type E 462	2
TB851029	Clamping nut M50x1.5, type ER 40	3,4
TA850115	Hook spanner, type ER 25	1
TA850125	Hook spanner, type E 462 + ER 40	2,3,4





Collet Chuck PREZISO

Application

- For high-precision clamping of shank tools with cylindrical shank

Machines

- CNC machining centres
- Machines with HSK interfaces

Technical Information

- Hardened and ground precision design
- Rotation-direction independent
- Increased clamping force thanks to ball-bearing precision clamping nut
- Maximum run-out accuracy

HSK 63F

Art. No.	Type	d	D	A	L	n max
TB676902	HSK 63F / E 462	3 - 25	50	75	100	30000

Spare parts

Art. No.	Detail
TB100530	PREZISO clamping wrench for tool Ø > 50 mm
TB862008	Torque wrench without insert for 40–200 Nm
TB862007	Insert wrench, C-form TP 40x1.5

Extraction Turbine PREZISO

Application

- For grooving and rebating during pocket milling and separation cuts
- Optimization of the manufacturing process, e.g. for nesting applications

Machines

- Nesting machines
- CNC machining centres
- Special milling machines with milling spindles for shank tools

Materials

- Solid wood
- Particleboard and fibreboard materials (particleboard, MDF, HDF etc.) raw
- Melamine-coated and paper-coated, HPL- and foil-coated, veneered wood-based panels

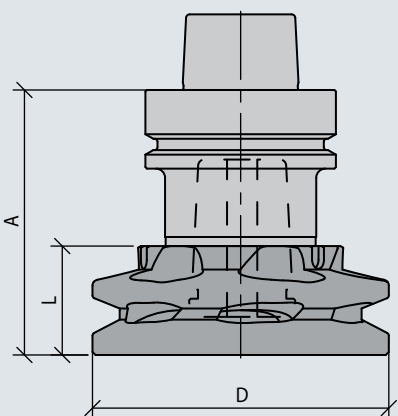
Technical Information

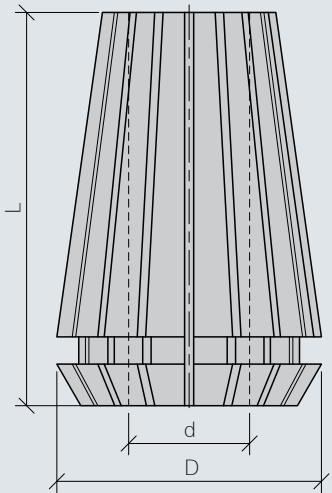
- Aluminium design for reduced spindle load
- Antistatic surface coating for wear and corrosion protection
- Easy mounting onto existing PREZISO collet chuck (instead of the clamping nut)
- Drastic reduction of dust and chip emissions
- Increased tool life
- Particularly low noise level
- Easy operation, assembly and disassembly
- Only dust and chips can be extracted
- Part size < 4 cm must be machined

Art. No.	D	L	A	DR
TB100533	98	36,5	88	re.

Spare parts

Art. No.	Detail
TB862008	Torque wrench without insert for 40–200 Nm
TB100532	Roller wrench attachment





Collets PREZISO ER462

Art. No.	d	D	L
TB677050	2.5 - 3.0	35	52
TB677051	3.5 - 4.0	35	52
TB677052	5.5 - 6.0	35	52
TB677053	7.5 - 8.0	35	52
TB677054	9.5 - 10.0	35	52
TB677055	11.5 - 12.0	35	52
TB677056	13.5 - 14.0	35	52
TB677057	15.5 - 16.0	35	52
TB677058	17.5 - 18.0	35	52
TB677059	19.5 - 20.0	35	52
TB677060	24.5 - 25.0	35	52

Collets ER462

Art. No.	d	D	L
TA676962	3,0	35	52
TA676964	4,0	35	52
TA676965	5,0	35	52
TA676966	6,0	35	52
TA676991	6,35	35	52
TA676967	7,0	35	52
TA676968	8,0	35	52
TB677011	8,5	35	52
TA676969	9,0	35	52
TA676970	10,0	35	52
TA676972	12,0	35	52
TA676973	13,0	35	52
TA676974	14,0	35	52
TA676975	15,0	35	52
TA676976	16,0	35	52
TA676978	18,0	35	52
TA676980	20,0	35	52
TA676985	25,0	35	52

Collets ER16

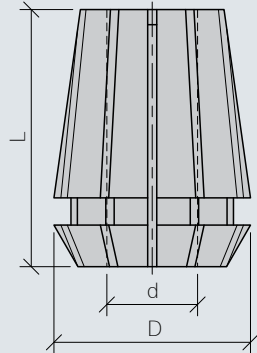
Art. No.	d	D	L
TA676820	6,0	17	27,5
TA676821	8,0	17	27,5
TA676822	10,0	17	27,5

Collets ER20

Art. No.	d	D	L
TA676833	6,0	21	31,5
TA676834	8,0	21	31,5
TA676835	10,0	21	31,5
TA676836	12,0	21	31,5

Collets ER25

Art. No.	d	D	L
TA676823	3,0	26	34
TB677003	4,0	26	34
TB677004	4,5	26	34
TB677005	5,0	26	34
TA676824	6,0	26	34
TB677010	6,5	26	34
TB677006	7,0	26	34
TA676825	8,0	26	34
TB677001	9,0	26	34
TA676826	10,0	26	34
TA676827	12,0	26	34
TB677002	13,0	26	34
TA676828	14,0	26	34
TA676829	16,0	26	34



Collets ER32

Art. No.	d	D	L
TA676170	3,0	33	40
TA676171	4,0	33	40
TA676172	5,0	33	40
TA676173	6,0	33	40
TA676169	6,35	33	40
TB677007	7,0	33	40
TA676175	8,0	33	40
TA676177	10,0	33	40
TA676179	12,0	33	40
TA676180	13,0	33	40
TA676181	14,0	33	40
TA676183	16,0	33	40
TA676185	18,0	33	40
TA676187	20,0	33	40

Collets ER40

Art. No.	d	D	L
TA676995	3,0	41	46
TA676910	4,0	41	46
TB677013	5,0	41	46
TA676912	6,0	41	46
TA676936	7,0	41	46
TB677014	8,0	41	46
TB677015	9,0	41	46
TA676916	10,0	41	46
TB677016	11,0	41	46
TA676918	12,0	41	46
TB677012	13,0	41	46
TA676923	14,0	41	46
TA676920	16,0	41	46
TA676924	18,0	41	46
TA676921	20,0	41	46
TA676922	25,0	41	46
TB677008	28,0	41	46
TB677009	30,0	41	46

Thermal Shrink Chuck HSK

Application

- For high-precision clamping of shank tools with cylindrical solid carbide or steel shank

Machines

- CNC machining centres
- Machines with HSK interfaces

Technical Information

- Hardened and ground precision design
- Slim design
- Rotation-direction independent
- Clamping by thermal shrink technology
- Finely balanced for speeds up to 24,000 rpm
- High run-out accuracy

Art. No.	Type	d	D	A	L1	L	n max
TB676502	HSK 63F	6	27	75	30	100	24000
TB676503	HSK 63F	8	27	75	40	100	24000
TB676504	HSK 63F	10	32	75	40	100	24000
TA676790	HSK 63F	12	34	75	47	100	24000
TB676501	HSK 63F	14	34	75	47	100	24000
TA676791	HSK 63F	16	34	75	50	100	24000
TA676792	HSK 63F	20	42	75	50	100	24000
TA207620	HSK 63F	20	51	160	52	185	24000
TA676793	HSK 63F	25	42	75	50	100	24000

Art. No.	Type	d	D	A	L1	L	n max
TB676510	HSK 63E	6	27	80	36	112	24000
TB676511	HSK 63E	8	27	80	36	112	24000
TB676512	HSK 63E	10	32	85	42	117	24000
TB676513	HSK 63E	12	32	90	47	122	24000
TB676514	HSK 63E	16	34	95	50	127	24000
TB676539	HSK 63E	20	42	80	52	112	24000
TB676515	HSK 63E	20	42	100	52	132	24000
TB676516	HSK 63E	25	53	115	58	147	24000

Hydraulic Chuck HSK

Application

- For high-precision clamping of shank tools with cylindrical solid carbide or steel shank

Machines

- CNC machining centres
- Machines with HSK interfaces

Technical Information

- Hardened and ground precision design
- Rigid design
- Rotation-direction independent
- Clamping by hydraulic technology
- Easy handling
- Balanced for speeds up to 24,000 rpm
- High run-out accuracy

HSK 63F

Art. No.	Type	d	D	A	L1	L	n max
TB676009	HSK 63F	8	50	80	37	105	24000
TB676010	HSK 63F	10	50	80	42	105	24000
TA676795	HSK 63F	12	50	80	47	105	24000
TB676011	HSK 63F	14	50	80	47	105	24000
TA676796	HSK 63F	16	50	80	52	105	24000
TA676797	HSK 63F	20	50	80	52	105	24000
TA676798	HSK 63F	25	53	80	52	105	24000

HSK 63E

Art. No.	Type	d	D	A	L1	L	n max
TB676003	HSK 63E	12	50	90	47	122	24000
TB676005	HSK 63E	16	50	95	52	127	24000
TB676006	HSK 63E	18	50	95	52	127	24000
TB676007	HSK 63E	20	50	100	52	132	24000
TB676008	HSK 63E	25	50	120	58	152	24000

Adapter

Application

- As a reducing adapter between tool holders or collets Ø25 mm and smaller tool shanks

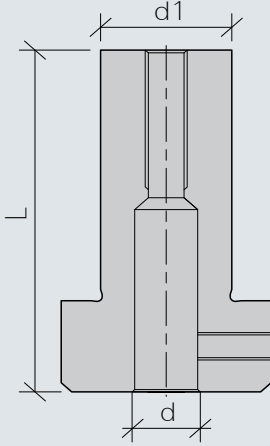
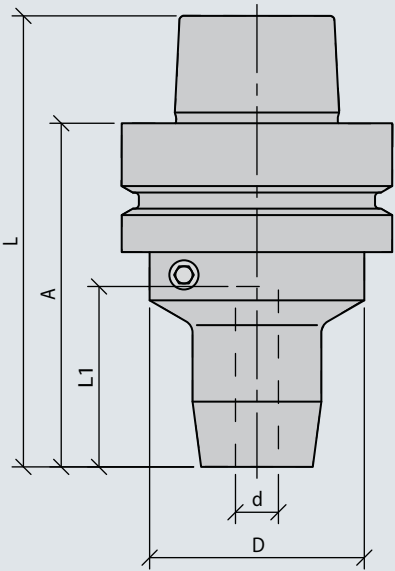
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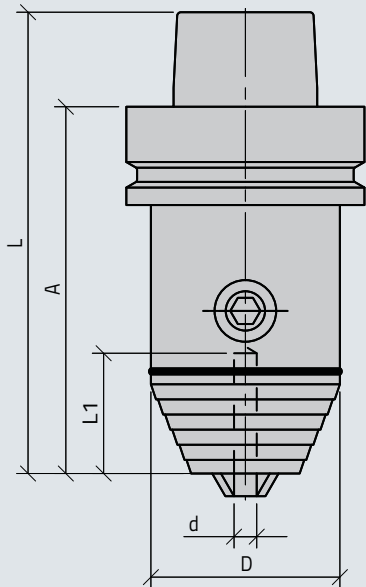
- Rotation-direction independent
- Balanced for speeds up to 24,000 rpm

Art. No.	d	d1	L	n max	Index
TA680284	6,0	25	75	24000	1
TA680285	6,35	25	75	24000	2
TA680286	8,0	25	75	24000	3
TA680288	12,0	25	75	24000	4

Spare parts

Art. No.	Detail	Index
TA851414	Set screw M6x12, hex socket (3 mm)	1 – 4





Universal Drill Chuck HSK

Application

- For clamping drills with cylindrical shank

Machines

- Machining centres
- Machines with HSK interfaces

Technical Information

- Rotation direction independent
- Easy handling
- High run-out accuracy
- Infinitely adjustable clamping range

HSK 63F

Art. No.	Type	d	D	A	L1	L	n max
TB677502	HSK 63F	1 - 16	50	98	28	123	30000

Mounting Arbor HSK

Application

- Mounting arbor for holding tools with bore
- On CNC machining centres

Machines

- Machining centres
- Machines with HSK interfaces

Technical Information

- Hardened and ground version
- Rotation direction independent
- Clamping by central screw
- Anti-rotation protection of tools and clamping cover by double keyway (DKN)
- Balanced for speeds up to 18,000 rpm
- High run-out accuracy
- Supplied without clamping cover
- Supplied without spacer rings

HSK 63F

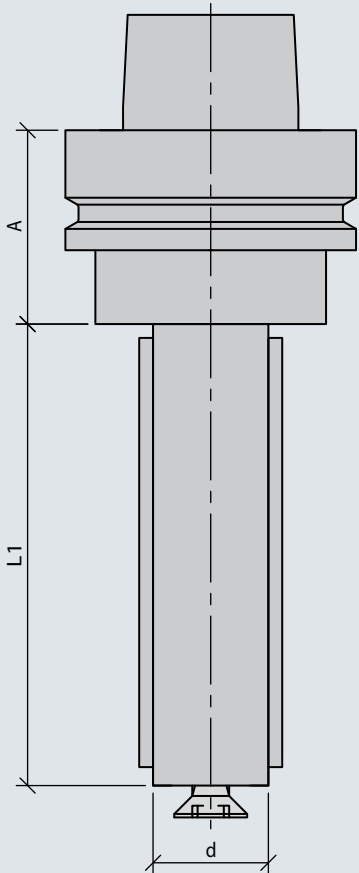
Art. No.	Type	d	A	L1	n max	Index
TB200080	HSK 63F	25	42	85	18000	1
TB200081	HSK 63F	25	42	100	18000	2
TB200082	HSK 63F	25	42	130	18000	3
TB200083	HSK 63F	25	42	150	18000	4

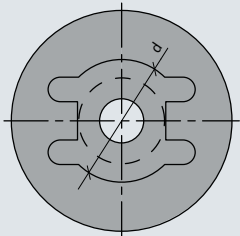
HSK 63E

Art. No.	Type	d	A	L1	n max	Index
TB200084	HSK 63E	25	42	100	18000	5

Spare parts

Art. No.	Detail	Index
TB851031	Clamping screw M8x50 T45	1 - 5





Cover for arbor shaft

Art. No.	d	D	B
TA207451	25	45	10
TA207452	25	35	10

Spacer rings with double keyway

Art. No.	d	D	B
TA207470	25	45	0,05
TA207471	25	45	0,1
TA207472	25	45	0,2
TA207473	25	45	0,5
TA207474	25	45	1,0
TA207493	25	45	3,0
TA207475	25	45	4,0
TA207476	25	45	5,0
TA207666	25	45	8,0
TA207477	25	45	10,0
TA207667	25	45	15,0
TA207485	25	45	20,0
TA207512	25	45	38,0
TA207484	25	45	40,0
TA207483	25	45	60,0

Milling arbor with cylindrical shank

- Application**

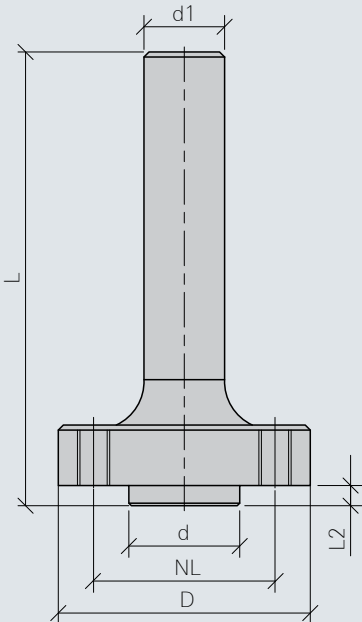
 - Mounting arbor for holding tools with bore
- Technical Information**

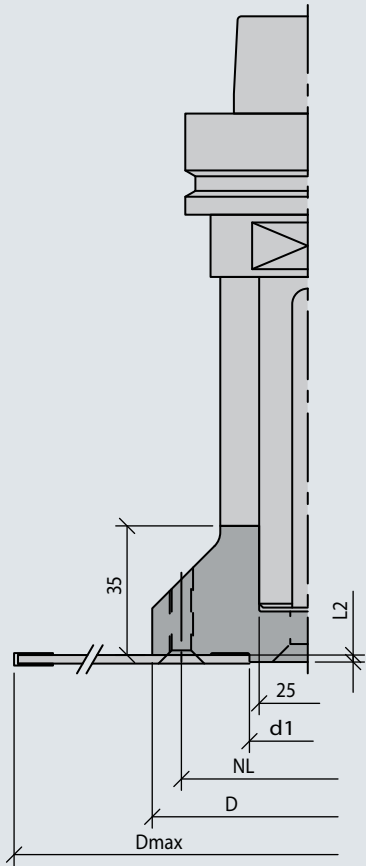
 - Hardened and ground version
 - Rotation direction independent
 - Clamping with 4 countersunk screws
 - Screws included in the scope of delivery
 - Wrench for screws not included in the scope of delivery
 - Max. tool diameter = 200 mm

Art. No.	d	D	d1	NL	L2	L	Index
TA680024	22	50	16	4/M6/36	4	90	1
TB100200	22	50	16	4/M6/38	20	90	2
TB100201	22	50	20	4/M6/38	20	90	3
TB100202	22	50	25	4/M6/36	4	90	4
TA680025	30	60	16	4/M6/48	4	90	5
TB100209	30	60	25	4/M6/48	4	90	6

Arrangement of auxiliary holes NL, see legend III: circular saw blades + special

Art. No.	Detail	Index
TA851060	Countersunk screw M6x13 T15	1 – 6
TB200541	Spacer ring d=22 D=50 b=2	1,4
TB200540	Spacer ring d=30 D=60 b=2	5,6





Saw flange adapter on arbor

Application

- For adapting circular saw blades on mounting arbor's

Machines

- Hand routers with CNC control
- Machining centres
- Special milling machines with milling spindles for holding shank tools

Technical Information

- Min. blade body thickness 2 mm
- Max. cutting width 4.6 mm
- Independent of rotation direction
- Anti-rotation locking via DKN and clamping screw
- Screws, spacers and mounting arbor not included in the scope of delivery

Art. No.	D	DKN_B	DKN_L	d1	L2	NL	D max
TB100230	80	8	31,5	30	1,8	8/M6/65	380

Spare parts

Art. No.	Detail
TA851060	Countersunk screw M6x13 T15

Saw flange monoblock HSK63F

Application

- For precise mounting of circular saw blades

Machines

- Hand routers with CNC control
- Machining centres
- Special milling machines with milling spindles for holding shank tools

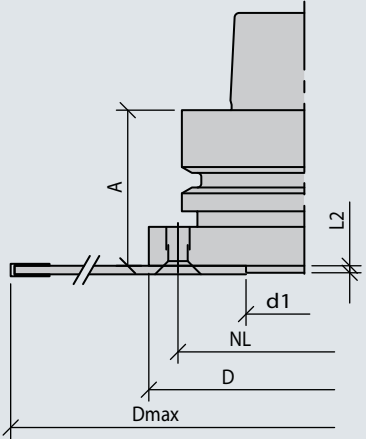
Technical Information

- Minimum base blade width 2 mm
- Max. cutting width 4.6 mm
- Max. KSB diameter 380 mm
- Nickel-plated
- Independent of rotation direction
- Mounting of the circular saw blade by countersunk screws
- Screws not included in the scope of delivery

Art. No.	Type	D	d1	A	L2	NL	D max
TB100231	HSK63F	80	30	40	1,8	8/M6/65	380
TB100232	HSK63F	80	30	50	1,8	8/M6/65	380
TB100233	HSK63F	80	30	57	1,8	8/M6/65	380
TB100234	HSK63F	80	30	100	1,8	8/M6/65	380

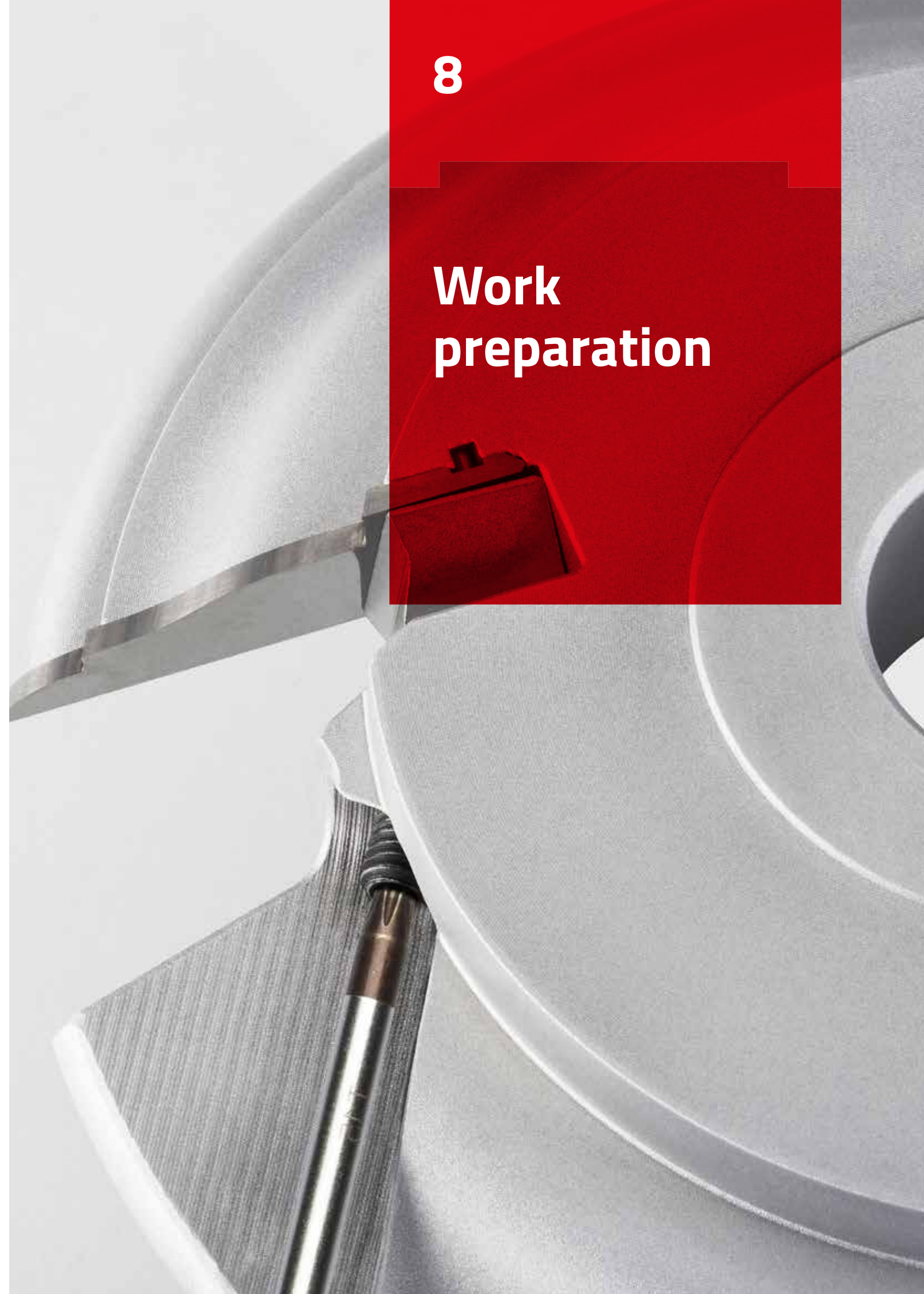
Spare parts

Art. No.	Detail
TA851060	Countersunk screw M6x13 T15



8

Work preparation



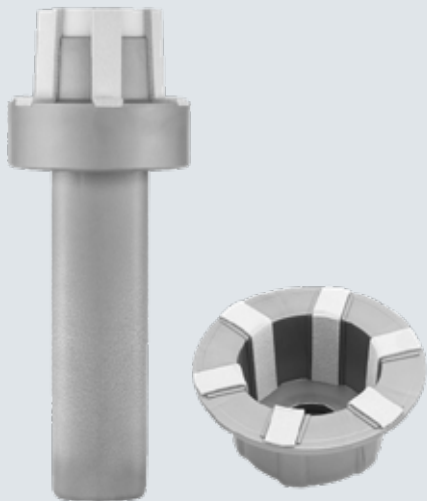
Taper cleaner

- Application**

 - For gentle and efficient cleaning of HSK inter-
faces
 - Machine interface and tool interface
- Technical Information**

 - Plastic body
 - Fully coated for best oil and grease resistance

Art. No.	Type
TB630001	Machine spindle HSK 63E / HSK 85P
TA635115	Machine spindle HSK 63F
TB630004	Tool HSK 63E / HSK 85P
TB630003	Tool HSK 63F



Cleaning agent

- Application**
- Brunox: multi-component lubricating oil for
lubricating, loosening, cleaning and protecting
 - Unipol: universal polishing paste for metals

Art. No.	Type
TB630020	Unipol, 125 ml
TB630021	BRUNOX, 120 ml



Length measuring device HSK63F

- Application**

 - For length reference measurement
- Technical Informationen**

 - Measuring plate with mounting bore for digital measuring scale
 - Measuring scale with digital display

Art. No.	Type
TA676839	Measuring plate HSK 63F, D=195 H=50
TA676051	Digital measuring ruler L=365



Universal length measuring device

- Application**

 - For individual length reference measurement
- Technical Informationen**

 - With digital display
 - Adjustment via handwheel

Art. No.	Type
TA676052	Digital length measuring device L=300
TB100084	Digital length measuring device L=600

Clamping force tester mechanical

- Application**

 - For checking the draw-in force of clamping systems in machine spindles
- Technical Informationen**

 - Analog display
 - Display in kN

Art. No.	Type
TB100077	Measuring device for HSK 63E
TB100078	Measuring device for HSK 63F



Assembly device basic

- Application**

 - As an aid for tool assembly
 - As an aid for insert change
- Technical Informationen**

 - Not swivelling
 - Only for one interface each
 - No interchangeable inserts as with easyAssembler

Art. No.	Type	Fig
TA676838	For HSK 63F, Weeke/Homag aggregates	1
TA676842	For HSK 63F and HSK 63E	1
TA676997	For HSK P	1



Fig. 1



Fig. 1

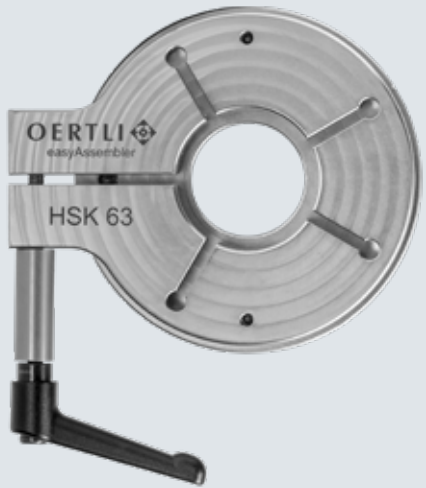


Fig. 2

Assembly device easyAssembler

- Application**

 - As an aid for tool assembly
 - As an aid for insert change
 - Minimizes the risk of injury during maintenance work on the tool
 - For assembly and disassembly of the PREZISO turbine
 - Mobile and stationary use
- Technical Informationen**

 - Tool alignment fixed vertically
 - Stable base holder
 - With quick-change inserts
 - Robust clamping lever with locking function
 - Existing mounting holes for stationary fastening

Art. No.	Type	Fig
TB100540	Base holder, compatible with all interchangeable inserts	1
TB100550	Interchangeable insert, HSK 63	2
TB100560	Interchangeable insert, HSK 80	2
TB100570	Interchangeable insert, HSK 85	2
TB100580	Interchangeable insert, HSK 100	2
TB100590	Interchangeable insert, HSK 63 + PREZISO turbine	2
TA850052	Hex key, compatible with all interchangeable inserts	

Assembly device easyAssembler Flex

- Application**

 - As an aid for tool assembly
 - As an aid for insert change
 - Minimizes the risk of injury during maintenance work on the tool
 - For assembly and disassembly of the PREZISO turbine
 - Mobile and stationary use
- Technical Informationen**

 - Flexible tool alignment in 45° steps
 - Stable base holder
 - With quick-change inserts
 - Robust clamping lever with locking function
 - Existing mounting holes for stationary fastening

Art. No.	Type	Fig
TB100541	Base holder, compatible with all interchangeable inserts	1
TB100550	Interchangeable insert, HSK 63	2
TB100560	Interchangeable insert, HSK 80	2
TB100570	Interchangeable insert, HSK 85, Powerlock	2
TB100580	Interchangeable insert, HSK 100	2
TB100590	Interchangeable insert, HSK 63 + PREZISO turbine	2
TA850052	Hex key, compatible with all interchangeable inserts	

Code carrier

- Application**
- For CNC machining centres with automatic tool change

Art. No.	Type
TA851431	Balluff BIS C- 105-05/A, D=12 h=6



Fig. 1

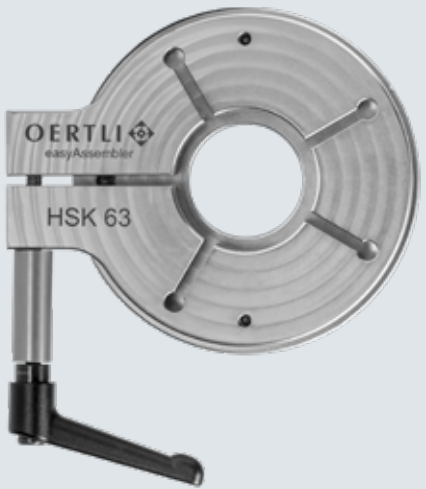


Fig. 2





Maintenance set HSK63E

- Application
- For professional cleaning of HSK63E interfaces

Art. No.	Type
TB100501	HSK 63E

Inhalt / Spare parts

Art. No.	Type
TB630001	Taper cleaner, machine spindle HSK 63E
TA630004	Taper cleaner, tool HSK 63E
TB630020	Metal polishing paste
TB630021	Corrosion protection BRUNOX
TA0002990410	Cut-resistant gloves
TA0002990401	Case

Maintenance set HSK63F

- Application
- For professional cleaning of HSK63F interfaces

Art. No.	Type
TB100502	HSK 63F

Inhalt / Spare parts

Art. No.	Type
TA635115	Taper cleaner, machine spindle HSK 63F
TB630003	Taper cleaner, tool HSK 63F
TB630020	Metal polishing paste
TB630021	Corrosion protection BRUNOX
TA0002990410	Cut-resistant gloves
TA0002990401	Case

Torque wrench set

- Application
- For correct and safe insert change

Art. No.	Type
TB100050	Set, 17-piece

Inhalt / Spare parts

Art. No.	Type	Fig
TA851290	Setting gauge for reamer cutting edges	
TB100030	Torque wrench handle, straight, 1–5 Nm	1
TB100031	Interchangeable blade for straight handle, hex socket 5 mm	2
TB100032	Interchangeable blade for straight handle, T15	2
TB100033	Interchangeable blade for straight handle, T20	2
TB100034	Interchangeable blade for straight handle, T25	2
TB100035	Interchangeable blade for straight handle, hex socket 2.5 mm	2
TB100036	Interchangeable blade for straight handle, hex socket 3 mm	2
TB100037	Interchangeable blade for straight handle, hex socket 4 mm	2
TB100038	Magnetic interchangeable blade, bit holder for straight handle	3
TB100039	Bit for bit holder, T10	4
TB100040	Torque wrench handle, T-handle, 3.2–16 Nm	5
TB100041	Interchangeable blade for T-handle, T15	6
TB100042	Interchangeable blade for T-handle, T20	6
TB100043	Interchangeable blade for T-handle, T25	6
TB100045	Interchangeable blade for T-handle, hex socket 4 mm	6
TB100046	Interchangeable blade for T-handle, hex socket 5 mm	6
TA0002990400	Case	





Fig. 1



Fig. 2

Torque wrench for collet chuck

Application		Technical Informationen
▪ For safe and precise clamping of shank tools in collet chucks		▪ Torque adjustment via handle
		▪ Various wrench inserts
Art. No.	Type	Fig
TB862008	Torque wrench 40–200 Nm	1
TB862002	Insert wrench for collet ER 25	2
TB862003	Insert wrench for collet ER 32	2
TB862005	Insert wrench for collet OZ 25 / ER 40 / E 462	2
TB862006	Insert wrench for collet OZ 16 / 415 E	2
TB862007	Insert wrench for collet PREZISO	2
TB100532	Roller wrench attachment for PREZISO turbine	o.A.

Washing machine

Application		Technical Informationen
▪ For economical tool cleaning		▪ Made of stainless steel
▪ Suitable for removing oil, grease, resin, chips, etc.		▪ Fully automatic operation
		▪ Integrated timer
		▪ Fast drying
Art. No.	Type	Index
TA635120	Mini / basket diameter 400 mm, usable height 180 mm	1
TA635128	Mini with lid extension / basket diameter 400 mm, usable height 310 mm	2
TA635121	Standard / basket diameter 600 mm, usable height 400 mm	3
Spare parts		
Art. No.	Type	Index
TA635080	Saxin cleaning agent, 5 L	1 – 3
TB630022	Detergent EM40, 10 kg	1 – 3
TA635124	Preservative EM200, 10 kg	1 – 3
TA635126	Defoamer EM902, 1 L	1 – 3
TA635130	Tool holder for HSK 63F	1 – 3
TA635131	Tool holder for HSKP Powerlock & HSK 80F	1 – 3
TB630005	Tool holder for HSK 63E	1 – 3
TB630012	Small parts basket with hinged lid, 350 x 200 x 175 mm	1 – 3
TB630013	Transport frame for washing unit, type Mini	1 – 2



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