



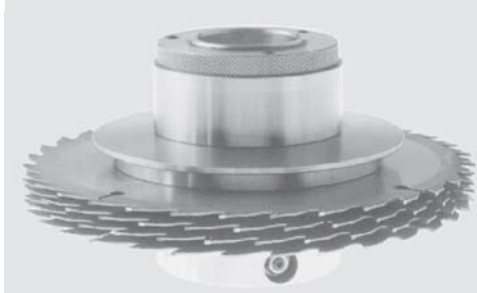
# Circular Saw Blades

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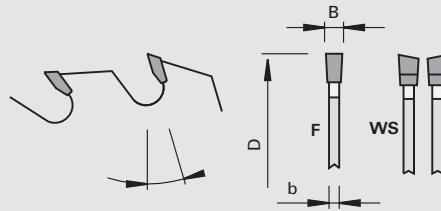
102317 / 102327

## Thin-Kerf Saw Blades HW for parquet manufacturing

product



drawing



LEUCO  
topline

LEUCO  
DUR

tungsten carbide [HW]

**Machine / Application**

- | molders
- | splitting machines
- | for precise dividing cuts in trimmed solid woods

**Design**

- | specially treated tool body with Oxytop coating
- | tooth configuration:
  - | flat „F“ for european hard woods (oak, beech, ...)
  - | alternate top bevel „WS“ for exotic woods
- | cutting material: HW HL Board 08

**Advantages**

- | optimum wood yield thanks to thin kerfs

**Notes**

- | also suitable for Hydro clamping bushing
- | bore extension to d=65 mm of edge saw blade for Schröder
- | packing unit 10 pieces

| Ø D  | B       | b    | Ø d  | Z  | hook angle | NL                   | tooth geometry |                  | Ident-No.  |
|------|---------|------|------|----|------------|----------------------|----------------|------------------|------------|
| 180  | 1,0     | 0,8  | 65   | 24 | 18         | 3/11/80              | F              | Schröder         | 80254254 o |
| 180  | 1,0     | 0,8  | 65   | 30 | 20         | 3/11/80              | WS             | Schröder         | 80254256 o |
| 220  | 1,2     | 0,9  | 60   | 27 | 18         | 3/10/74              | F              | Weinig           | 80252288 o |
| 220  | 1,2     | 0,9  | 65   | 27 | 18         | 3/11/80              | F              | Schröder         | 80252289 o |
| 220  | 1,2     | 0,9  | 60   | 30 | 20         | 3/10/74              | WS             | Weinig           | 80252290 o |
| 220  | 1,2     | 0,9  | 65   | 30 | 20         | 3/11/80              | WS             | Schröder         | 80252291 o |
| 220  | 3,8/3,5 | 3,0  | 60   | 30 | 18         | 3/10/74 +<br>3/11/80 | F              | Weinig, Schröder | 80252292 o |
| [mm] | [mm]    | [mm] | [mm] |    | [°]        |                      |                |                  |            |

| Saw Blade Adapter Weinig HSK | Ø D  | Ø d        | Ø d1 | L2   | L1   | Class-No. | Ident-No. |
|------------------------------|------|------------|------|------|------|-----------|-----------|
|                              | 105  | Weinig HSK | 60   | 68   | 148  | 997300    | 182974 o  |
|                              | [mm] | [mm]       | [mm] | [mm] | [mm] |           |           |

| spare parts | Dimension              | Class-No. | Ident-No. |
|-------------|------------------------|-----------|-----------|
| Lock Nuts   | 105x15xM58x1,5<br>[mm] | 995290    | 182993 o  |

| Hydro Clamping Bushing | Ø D  | Ø d  | Ø d1 | L2   | L1   | Class-No. | Ident-No. |
|------------------------|------|------|------|------|------|-----------|-----------|
|                        | 93   | 50   | 60   | 80   | 115  | 997300    | 182193 o  |
|                        | [mm] | [mm] | [mm] | [mm] | [mm] |           |           |

| spare parts                    | Ø D  | B    | Ø d  | Class-No. | Ident-No. |
|--------------------------------|------|------|------|-----------|-----------|
| Spacer Rings                   | 94   | 28   | 60   | 955520    | 182198 s  |
| Spacer Rings                   | 94   | 30   | 65   | 955520    | 182199 s  |
| Cover flange top with handhold | 130  | 16   | 60   | 997300    | 182194 s  |
| Cover flange top with handhold | 130  | 16   | 65   | 997300    | 182196 s  |
| Cover flange bottom            | 130  | 14   | 60   | 997300    | 182195 s  |
| Cover flange bottom            | 130  | 14   | 65   | 997300    | 182197 s  |
| Spacers                        | 130  | 4,2  | 60   | 955520    | 182200 s  |
| Spacers                        | 130  | 4,3  | 60   | 955520    | 182201 s  |
| Spacers                        | 130  | 4,4  | 60   | 955520    | 182202 s  |
| Spacers                        | 130  | 4,5  | 60   | 955520    | 182203 s  |
| Spacers                        | 130  | 4,6  | 60   | 955520    | 182204 s  |
| Spacers                        | 130  | 4,7  | 60   | 955520    | 182205 s  |
| Spacers                        | 130  | 4,8  | 60   | 955520    | 182206 s  |
| Spacers                        | 130  | 4,9  | 60   | 955520    | 182207 s  |
| Spacers                        | 130  | 5,0  | 60   | 955520    | 182208 s  |
| Spacers                        | 130  | 4,5  | 65   | 955520    | 182209 s  |
| Spacers                        | 130  | 4,6  | 65   | 955520    | 182210 s  |
| Spacers                        | 130  | 4,7  | 65   | 955520    | 182211 s  |
| Spacers                        | 130  | 4,8  | 65   | 955520    | 182212 s  |
| Spacers                        | 130  | 4,9  | 65   | 955520    | 182213 s  |
| Spacers                        | 130  | 5,0  | 65   | 955520    | 182214 s  |
|                                | [mm] | [mm] | [mm] |           |           |

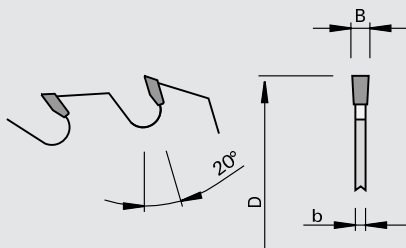
101310 / 101311

### Gang-Rip Saw Blades HW „F“

product



drawing



LEUCO  
topline

LEUCO  
DUR

tungsten carbide [HW]

Machine / Application

- l molders
- l gang-rip saws with one or two shafts
- l for precise ripping cuts in dry and planed soft woods

Design

- l tooth configuration: flat „F“
- l cutting material: HW HL Solid 15
- l staggered double keyways of type A and C

Advantages

- l staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

- l larger bore (max. Ø 100 mm) available for a surcharge
- l for cutting height > 50 mm use version with HW rakers
- l for inquiries / orders enclose specification sheet (see appendix)

| Ø D  | B    | b    | Ø d  | Z  | DKN    | NL       | Class-No. | Ident-No. |
|------|------|------|------|----|--------|----------|-----------|-----------|
| 200  | 2,0  | 1.4  | 40   | 20 |        |          | 101311    | 188029    |
| 200  | 2,4  | 1.6  | 40   | 20 |        |          | 101311    | 188148    |
| 225  | 2,4  | 1.6  | 40   | 20 |        |          | 101311    | 188150    |
| 250  | 2,4  | 1.6  | 40   | 24 |        |          | 101311    | 188151    |
| 250  | 3,2  | 2.2  | 70   | 20 | 20x5   |          | 101310    | 189300    |
| 250  | 2,8  | 1.8  | 70   | 24 | 20x5   |          | 101311    | 188030    |
| 300  | 3,2  | 2.2  | 70   | 24 | 20x5   |          | 101310    | 189301    |
| 300  | 3,2  | 2.2  | 80   | 24 | 18,5x4 | 2/13/100 | 101310    | 189302    |
| 350  | 3,5  | 2.5  | 70   | 28 | 20x5   |          | 101310    | 189303    |
| 350  | 3,5  | 2.5  | 80   | 28 | 18,5x4 | 2/13/100 | 101310    | 188027 &  |
| [mm] | [mm] | [mm] | [mm] |    | [mm]   |          |           |           |

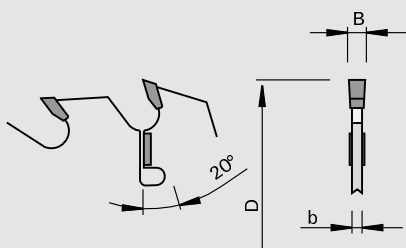
101715

### Gang-Rip Saw Blades HW with HW-rakers - solid „F“

product



drawing



LEUCO  
solid

LEUCO  
DUR

tungsten carbide [HW]

MEC

Machine / Application

- l gang-rip saws with one or two shafts
- l for longitudinal cuts in wet and dry soft woods

Design

- l tooth configuration: flat „F“
- l cutting material: HW HL Solid 15

Advantages

- l tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate

Notes

- l for inquiries / orders enclose specification sheet (see appendix)
- l for cutting height > 50 mm

| Ø D  | B    | b    | Ø d  | Ø dmax | max. flange Ø | Z  | number of rakers | Ident-No. |
|------|------|------|------|--------|---------------|----|------------------|-----------|
| 300  | 3,0  | 2.0  | 50   | 90     | 130           | 20 | 2+2              | 189270    |
| 350  | 3,5  | 2.4  | 50   | 100    | 140           | 20 | 2+2              | 189271    |
| 400  | 4,2  | 3.0  | 50   | 100    | 150           | 24 | 2+2              | 189272    |
| 450  | 4,2  | 3.0  | 50   | 100    | 160           | 24 | 2+2              | 189273    |
| 500  | 4,6  | 3.3  | 50   | 100    | 180           | 28 | 2+2+2            | 189274    |
| [mm] | [mm] | [mm] | [mm] | [mm]   | [mm]          |    | [pc.]            |           |

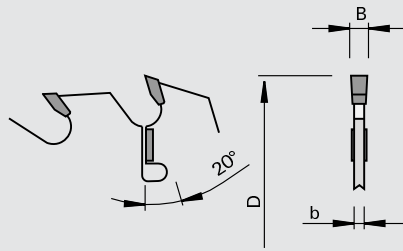
101315 / 101316

## Gang-Rip Saw Blades HW with HW-rakers „F“

product



drawing



LEUCO  
topline

LEUCO  
DUR

tungsten carbide [HW]

MEC

**Machine / Application**

- | molders
- | gang-rip saws with one or two shafts
- | for longitudinal cuts in wet and dry soft woods

**Design**

- | tooth configuration: flat „F“
- | cutting material: HW HL Solid 15
- | staggered double keyways of type A and C

**Advantages**

- | tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
- | staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

**Notes**

- | for inquiries / orders enclose specification sheet (see appendix)
- | for cutting height > 50 mm

| Ø D  | B    | b    | Ø d  | Ø dmax | max. flange Ø | Z  | number of rakers | DKN      | NL                             | Class-No. | Ident-No. |
|------|------|------|------|--------|---------------|----|------------------|----------|--------------------------------|-----------|-----------|
| 180  | 2,4  | 1,6  | 40   | 55     | 95            | 16 | 2                |          |                                | 101316    | 188096    |
| 200  | 2,0  | 1,4  | 40   | 75     | 115           | 16 | 2                |          |                                | 101316    | 188097    |
| 200  | 2,4  | 1,6  | 40   | 75     | 115           | 16 | 2                |          |                                | 101316    | 188098    |
| 225  | 2,4  | 1,6  | 40   | 80     | 120           | 16 | 2                |          |                                | 101316    | 188100    |
| 250  | 2,4  | 1,6  | 40   | 80     | 125           | 16 | 2                |          |                                | 101316    | 188101    |
| 250  | 2,8  | 1,8  | 70   |        | 125           | 24 | 2                | 20x5     |                                | 101316    | 189290    |
| 300  | 3,2  | 2,2  | 70   |        | 120           | 16 | 2+2              | 20,0x5   |                                | 101315    | 189293    |
| 300  | 3,4  | 2,2  | 80   |        | 120           | 16 | 2+2              | 12,5x4,5 |                                | 101315    | 189296    |
| 300  | 3,2  | 2,2  | 70   |        | 120           | 28 | 2+2              | 20,0x5   |                                | 101315    | 189294    |
| 300  | 3,2  | 2,2  | 80   |        | 125           | 16 | 2+2              | 18,5x4   | 2/13/100 + 4/6,6/95 + 6/5,5/91 | 101315    | 189295    |
| 350  | 3,5  | 2,5  | 70   |        | 120           | 20 | 2+2              | 20x5     |                                | 101315    | 189297    |
| 350  | 3,8  | 2,5  | 80   |        | 125           | 20 | 2+2              | 18,5x4   | 2/13/100                       | 101315    | 189299    |
| [mm] | [mm] | [mm] | [mm] | [mm]   | [mm]          |    | [pc.]            | [mm]     |                                |           |           |

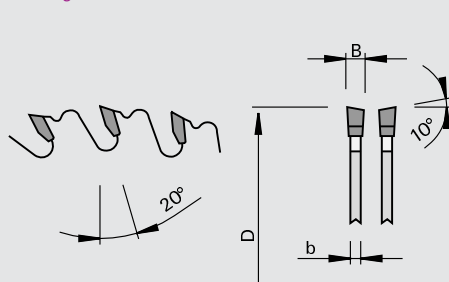
101725

### Gang-Rip Saw Blades HW with internal HW-rakers - solid „WS“

product



drawing



**LEUCO**  
solid

**LEUCO**  
DUR

tungsten carbide [HW]

MAN

**Machine / Application**

- | table saws
- | climb-cutting rip saws
- | suitable for manual feed
- | for ripping and cross cuts in wet and dry solid woods

**Design**

- | tooth configuration: alternate top bevel „WS“
- | cutting material: HW HL Solid 15
- | 4 internal spurs HW

**Advantages**

- | tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
- | chip limiter design for universal application

**Notes**

- | for inquiries / orders enclose specification sheet (see appendix)

| Ø D  | B    | b    | Ø d  | Ø dmax | max. flange Ø | Z  | number of rakers | NL                            | Ident-No. |
|------|------|------|------|--------|---------------|----|------------------|-------------------------------|-----------|
| 350  | 3,5  | 2,45 | 30   | 70     | 140           | 24 | 2+2              | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 189643    |
| 400  | 3,5  | 2,45 | 30   | 80     | 160           | 28 | 2+2              | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 189644    |
| 450  | 4,2  | 2,8  | 30   | 80     | 160           | 36 | 2+2              | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 189645    |
| [mm] | [mm] | [mm] | [mm] | [mm]   | [mm]          |    | [pc.]            |                               |           |

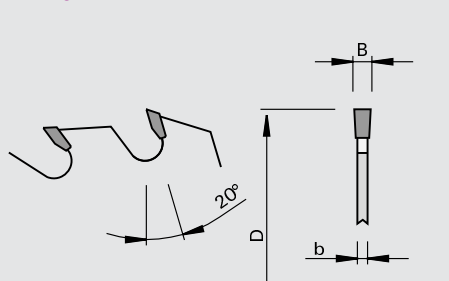
101310

### Gang-Rip Saw Blades HW with cooling slots „F“

product



drawing



**LEUCO**  
topline

**LEUCO**  
DUR

tungsten carbide [HW]

MEC

**Machine / Application**

- | molders
- | gang-rip saw with one or two shafts (e.g. Raimann, Paul, Costa, ...)
- | for precise ripping cuts in dry and planed hard woods

**Design**

- | tooth configuration: flat „F“
- | cutting material: HW HL Board 10

**Advantages**

- | special design and tungsten carbide grade for highest cutting quality and very long edge lives

**Notes**

- | for inquiries / orders enclose specification sheet (see appendix)

| Ø D  | B    | b    | Ø d  | Ø dmax | max. flange Ø | Z  | number of cooling slots | DKN      | NL                             | Ident-No. |
|------|------|------|------|--------|---------------|----|-------------------------|----------|--------------------------------|-----------|
| 250  | 3,4  | 2,2  | 30   | 80     | 120           | 24 | 3                       |          |                                | 189275    |
| 300  | 3,4  | 2,2  | 80   | 100    | 140           | 28 | 4                       | 18,5x3,5 | 6/5,5/91 + 4/6,6/95 + 2/13/100 | 189276    |
| 300  | 3,4  | 2,2  | 30   | 100    | 130           | 28 | 4                       |          |                                | 189277    |
| 350  | 3,6  | 2,4  | 30   | 100    | 140           | 32 | 4                       |          |                                | 189279    |
| 350  | 3,6  | 2,4  | 80   | 100    | 140           | 32 | 4                       | 18,5x3,5 | 6/5,5/91 + 4/6,6/95 + 2/13/100 | 189280    |
| 500  | 4,0  | 2,8  | 30   | 100    | 165           | 40 | 4                       |          |                                | 189282    |
| [mm] | [mm] | [mm] | [mm] | [mm]   | [mm]          |    | [pc.]                   | [mm]     |                                |           |

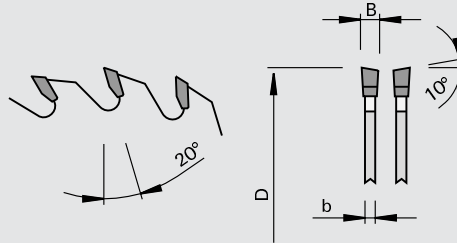
101320

### Gang-Rip Saw Blades HW „WS“

product



drawing



LEUCO  
topline

LEUCO  
DUR

tungsten carbide [HW]

Machine / Application

- l molders
- l gang-rip saws with one or two shafts
- l for precise ripping cuts in dry and planed solid woods and wood-based materials

Design

- l staggered double keyways of type A and C
- l tooth configuration: alternate top bevel „WS“
- l cutting material: HW HL Board 06 for wood-based materials
- l cutting material: HW HL Solid 15 for solid woods

Advantages

- l staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

- l larger bore (max. Ø 100 in) available for a surcharge
- l for inquiries / orders enclose specification sheet (see appendix)

| Ø D  | B    | b    | Ø d  | Z  | DKN    | NL       | LEUCODUR    | Ident-No. |
|------|------|------|------|----|--------|----------|-------------|-----------|
| 190  | 3,4  | 2.2  | 30   | 20 |        |          | HL Solid 15 | 188049    |
| 200  | 3,2  | 2.2  | 60   | 34 |        | Paul     | HL Board 06 | 188038    |
| 200  | 3,2  | 2.2  | 60   | 42 |        | Paul     | HL Board 06 | 188041    |
| 210  | 3,2  | 2.2  | 100  | 34 | 12,5x4 |          | HL Board 06 | 189283    |
| 220  | 3,4  | 2.2  | 50   | 24 |        |          | HL Solid 15 | 188051    |
| 300  | 3,2  | 2.2  | 80   | 28 | 18,5x4 | 2/13/100 | HL Solid 15 | 188054    |
| 300  | 3,2  | 2.2  | 70   | 36 | 20x5   |          | HL Solid 15 | 189285    |
| 300  | 3,2  | 2.2  | 80   | 36 | 18,5x4 | 2/13/100 | HL Solid 15 | 189286    |
| 300  | 3,2  | 2.2  | 70   | 48 | 20x5   |          | HL Solid 15 | 189287    |
| [mm] | [mm] | [mm] | [mm] |    | [mm]   |          |             |           |

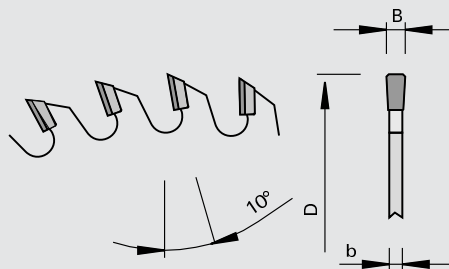
203040

### Gang-Rip Saw Blades DP „F-FA“

product



drawing



LEUCO  
DIA

polycrystalline diamond [DP]

Machine / Application

- l gang-rip machines Paul
- l for trimming cuts in raw and laminated panels and composite materials

Design

- l tooth configuration: flat with chamfer „F-FA“
- l resharpenable area 3.5 mm

Advantages

Notes

- l Ident-No. 181189 for hydro bushing Ident-No. 180455

| Ø D  | B    | b    | Ø d  | Z  | DKN      | NL             | Ident-No. |
|------|------|------|------|----|----------|----------------|-----------|
| 250  | 3,2  | 2.2  | 100  | 36 | 12,5x4,5 | Paul           | 181182    |
| 250  | 3,2  | 2.2  | 110  | 36 |          | 4/8,5/130 Paul | 181189    |
| [mm] | [mm] | [mm] | [mm] |    | [mm]     |                |           |



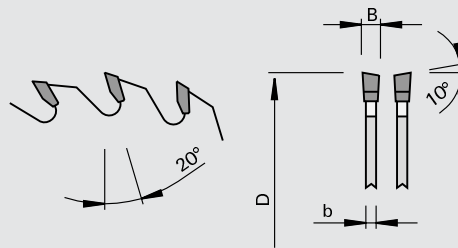
101420

## Trimming Saw Blades HW „WS“

product



drawing



LEUCO  
proline

LEUCO  
DUR

tungsten carbide [HW]

Machine / Application

- | table saws
- | for sizing cuts in solid woods

Design

- | tooth configuration: alternate top bevel „WS“
- | cutting material: HW HL Board 10

Advantages

Notes

- | larger bore (max. Ø 50 mm) available for a surcharge

| Ø D  | B    | b    | Ø d  | Z  | NL               | Ident-No. |
|------|------|------|------|----|------------------|-----------|
| 200  | 3,2  | 2.2  | 30   | 24 | 2/7/42           | 188643    |
| 250  | 3,2  | 2.2  | 30   | 24 | 2/7/42           | 188648    |
| 250  | 4,4  | 2.8  | 30   | 20 | 2/7/42           | 189696    |
| 300  | 3,2  | 2.2  | 30   | 24 | 2/10/60          | 188655    |
| 300  | 3,2  | 2.2  | 30   | 28 | 2/10/60          | 188656    |
| 300  | 3,2  | 2.2  | 30   | 36 | 2/7/42 + 2/10/60 | 189025    |
| 300  | 4,4  | 2.8  | 30   | 24 | 2/10/60          | 189697    |
| 350  | 3,5  | 2.5  | 30   | 24 | 2/10/60          | 189024    |
| 350  | 3,5  | 2.5  | 30   | 32 | 2/10/60          | 188958    |
| 350  | 3,5  | 2.5  | 30   | 36 | 2/10/60          | 189026    |
| 350  | 4,4  | 2.8  | 30   | 28 | 2/10/60          | 189698    |
| 400  | 3,5  | 2.5  | 30   | 28 | 2/10/60          | 188957    |
| 400  | 3,5  | 2.5  | 30   | 36 | 2/10/60          | 188959    |
| 450  | 3,8  | 2.8  | 30   | 40 |                  | 188960    |
| 500  | 3,8  | 2.8  | 30   | 44 |                  | 188961    |
| [mm] | [mm] | [mm] | [mm] |    |                  |           |

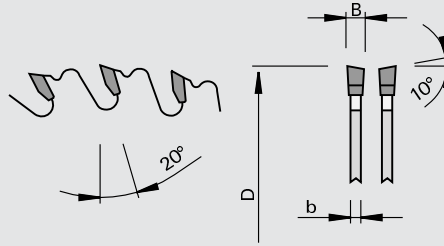
101420

## Trimming Saw Blades HW with chip limiter „WS“

product



drawing

LEUCO  
prolineLEUCO  
DUR

tungsten carbide [HW]

Notes

| larger bore (max. Ø 50 mm)  
available for a surcharge

Machine / Application

| table saws  
| special saws  
| for sizing cuts in solid woods  
| especially for knotty woods

Design

| tooth configuration: alternate  
top bevel „WS“  
| cutting material: HW HL Board  
10

Advantages

| no chipped edges from knots  
thanks to chip limiter

| Ø D  | B    | b    | Ø d  | Z  | NL                            | Ident-No. |
|------|------|------|------|----|-------------------------------|-----------|
| 250  | 3,2  | 2.2  | 30   | 24 | 2/7/42                        | 188649    |
| 300  | 3,2  | 2.2  | 30   | 28 | 2/10/60                       | 188657 \$ |
| 315  | 3,2  | 2.2  | 30   | 28 | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188985    |
| 350  | 3,5  | 2.5  | 30   | 32 | 2/10/60                       | 188986 \$ |
| 400  | 3,5  | 2.5  | 30   | 36 | 2/10/60                       | 188987 \$ |
| 450  | 3,8  | 2.8  | 30   | 40 |                               | 188988    |
| 500  | 3,8  | 2.8  | 30   | 44 |                               | 188989    |
| [mm] | [mm] | [mm] | [mm] |    |                               |           |

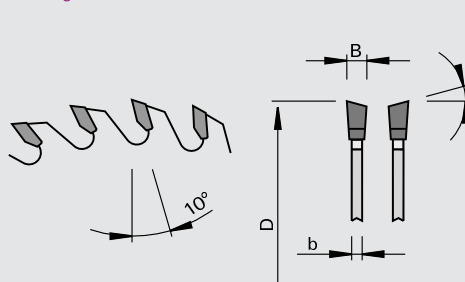
102420

## Sizing Saw Blades HW „WS“

product



drawing



LEUCO  
proline

LEUCO  
DUR

tungsten carbide [HW]

**Machine / Application**

- | table saws
- | special saws
- | for sizing cuts in wood-based panels

**Design**

- | tooth configuration: alternate top bevel „WS“
- | cutting material: HW HL Board 10

**Advantages**

- | optimal quality of cut, feed rate and adjustment for material thickness thanks to various numbers of teeth

**Notes**

- | larger bore (max. Ø 50 mm) available for a surcharge

| Ø D  | B    | b    | Ø d  | Z   | DKN  | NL                            | Ident-No. |
|------|------|------|------|-----|------|-------------------------------|-----------|
| 150  | 3,2  | 2.2  | 30   | 24  |      |                               | 188982    |
| 150  | 3,2  | 2.2  | 30   | 36  |      |                               | 188983    |
| 150  | 3,2  | 2.2  | 30   | 48  |      | 2/7/42                        | 188984    |
| 180  | 3,2  | 2.2  | 30   | 30  |      |                               | 188962    |
| 180  | 3,2  | 2.2  | 30   | 54  |      |                               | 188156    |
| 200  | 3,2  | 2.2  | 30   | 34  |      |                               | 188963    |
| 200  | 3,2  | 2.2  | 30   | 48  |      |                               | 188981    |
| 200  | 3,2  | 2.2  | 30   | 64  |      |                               | 188157    |
| 250  | 3,2  | 2.2  | 30   | 40  |      | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188650 \$ |
| 250  | 3,2  | 2.2  | 30   | 48  |      | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188651    |
| 250  | 3,2  | 2.2  | 30   | 60  |      | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188868    |
| 250  | 3,2  | 2.2  | 30   | 80  |      | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188654    |
| 300  | 3,2  | 2.2  | 30   | 48  |      | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188658 \$ |
| 300  | 3,2  | 2.2  | 30   | 60  |      | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188659 \$ |
| 300  | 3,2  | 2.2  | 30   | 72  |      | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188660 \$ |
| 300  | 3,2  | 2.2  | 30   | 96  |      | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188661 \$ |
| 315  | 3,2  | 2.2  | 30   | 48  |      | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188964    |
| 315  | 3,2  | 2.2  | 30   | 72  |      | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188977    |
| 350  | 3,5  | 2.5  | 30   | 54  |      | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188965 \$ |
| 350  | 3,5  | 2.5  | 30   | 72  |      | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188969 \$ |
| 350  | 3,5  | 2.5  | 30   | 84  |      | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188971 \$ |
| 350  | 3,5  | 2.5  | 30   | 108 |      | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188973 \$ |
| 400  | 3,5  | 2.5  | 30   | 60  |      | 2/7/42 + 2/10/60              | 188966    |
| 400  | 3,5  | 2.5  | 30   | 84  |      | 2/7/42 + 2/10/60              | 188970    |
| 400  | 3,5  | 2.5  | 30   | 96  |      | 2/7/42 + 2/10/60              | 188972    |
| 400  | 3,5  | 2.5  | 30   | 120 |      | 2/7/42 + 2/10/60              | 188974    |
| 400  | 3,5  | 2.5  | 50   | 60  |      |                               | 188167 \$ |
| 450  | 3,8  | 2.8  | 30   | 66  |      | 2/7/42 + 2/10/60              | 188967    |
| 500  | 3,8  | 2.8  | 30   | 72  |      | 2/7/42 + 2/10/60              | 188968    |
| [mm] | [mm] | [mm] | [mm] |     | [mm] |                               |           |

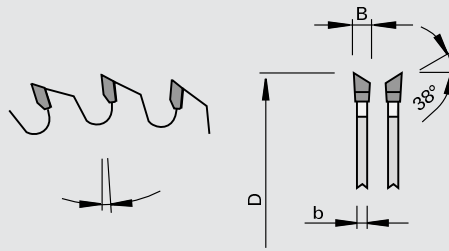
102428

## Sizing Saw Blades HW „WS“

product



drawing

LEUCO  
prolineLEUCO  
DUR

tungsten carbide [HW]

Notes

| for profiles, ledges and plastic profiles

Machine / Application

| chop and miter saws  
| table saws  
| for sizing and trimming cuts in wood-based panels

Design

| tooth configuration: alternate top bevel „WS“  
| cutting material: HW HL Board 06

Advantages

| tear-free cutting without using a scoring aggregate thanks to 38 degree ATB

| Ø D  | B    | b    | Ø d  | Z  | NL                            | hook angle | Ident-No. |
|------|------|------|------|----|-------------------------------|------------|-----------|
| 250  | 3,2  | 2.2  | 30   | 80 | 2/7/42 + 2/9,5/46,5 + 2/10/60 | -2         | 181995    |
| 300  | 3,2  | 2.2  | 30   | 96 | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 2          | 181996    |
| [mm] | [mm] | [mm] | [mm] |    |                               | [°]        |           |

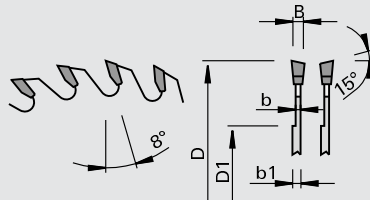
102323

## Sizing Saw Blades HW - thin rim design of the steel plate „WS“

product



drawing

LEUCO  
prolineLEUCO  
DUR

tungsten carbide [HW]

Notes

| improved stability thanks to relieved tool body

Machine / Application

| table saws  
| machines Scheer FM  
| for sizing cuts in thin-walled plastic profiles and veneers

Design

| extra thin rim design of the steel plate  
| tooth configuration: alternate top bevel „WS“  
| cutting material: HW HL Board 06

Advantages

| Ø D  | B    | b1   | b    | D1   | Ø d  | Z  | NL         | Ident-No. |
|------|------|------|------|------|------|----|------------|-----------|
| 160  | 1,8  | 2.2  | 1.0  | 80   | 16   | 48 | 2/7,5/31,5 | 188209    |
| 180  | 1,6  | 2.2  | 1.0  | 105  | 16   | 56 | 1/6/33     | 188210    |
| 250  | 1,7  | 2.2  | 1.0  | 170  | 30   | 80 |            | 188211    |
| [mm] | [mm] | [mm] | [mm] | [mm] | [mm] |    |            |           |

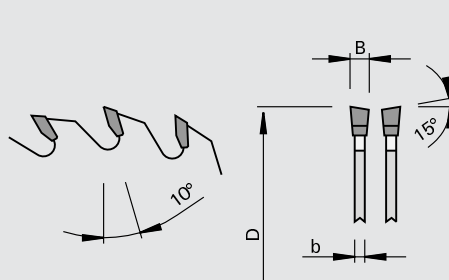
102321

### Sizing Saw Blades HW - thin „WS“ - wood-based panels

product



drawing



tungsten carbide [HW]

Machine / Application

- | chop and miter saws
- | table saws
- | for clipping and miter cuts in solid woods, mainly in MDF
- | for cross cutting of profiles (e.g. plastic profiles)

Design

- | tooth configuration: alternate top bevel „WS“
- | cutting material: HW HL Board 03

Advantages

- | long edge lives

Notes

| Ø D  | B    | b    | Ø d  | Z   | NL                            | Ident-No. |
|------|------|------|------|-----|-------------------------------|-----------|
| 150  | 2,4  | 1,8  | 30   | 48  |                               | 189699    |
| 180  | 2,4  | 1,8  | 30   | 60  |                               | 189700    |
| 200  | 2,4  | 1,8  | 30   | 64  |                               | 189701    |
| 250  | 2,4  | 1,8  | 30   | 80  | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 189702    |
| 250  | 2,6  | 2,2  | 30   | 80  | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 189703    |
| 300  | 2,4  | 1,8  | 30   | 96  | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 189704    |
| 300  | 2,6  | 2,2  | 30   | 96  | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 189705    |
| 350  | 2,6  | 2,2  | 30   | 108 | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 189706    |
| [mm] | [mm] | [mm] | [mm] |     |                               |           |

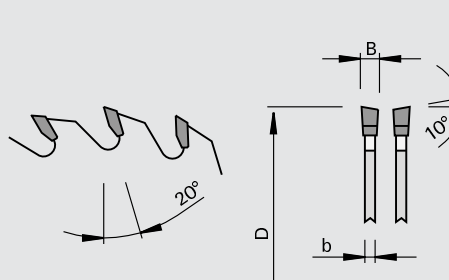
102321

### Sizing Saw Blades HW - thin „WS“ - solid woods

product



drawing



tungsten carbide [HW]

Machine / Application

- | table saws
- | sizing saws
- | cut-off saws
- | for sizing and clipping cuts in solid woods

Design

- | tooth configuration: alternate top bevel „WS“
- | cutting material: HW HL Board 06

Advantages

Notes

| Ø D  | B    | b    | Ø d  | Z  | NL               | Ident-No. |
|------|------|------|------|----|------------------|-----------|
| 180  | 2,4  | 1,8  | 30   | 30 |                  | 188064    |
| 200  | 2,4  | 1,8  | 30   | 32 |                  | 188065    |
| 250  | 2,4  | 1,8  | 30   | 40 | 2/7/42 + 2/10/60 | 188067    |
| 300  | 2,4  | 1,8  | 30   | 48 | 2/10/60          | 188068    |
| 350  | 2,6  | 2,0  | 30   | 54 | 2/10/60          | 188069    |
| [mm] | [mm] | [mm] | [mm] |    |                  |           |

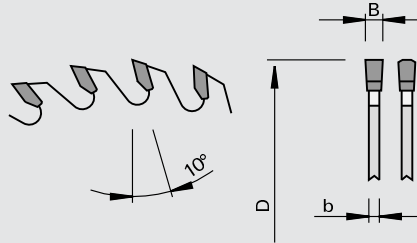
102470

## Sizing Saw Blades HW „TR-F“ - hook angle 10°

product



drawing

LEUCO  
prolineLEUCO  
DUR

tungsten carbide [HW]

Notes

- larger bore (max. Ø 50 mm) available for a surcharge

Machine / Application

- table saws
- vertical panel sizing saws
- for sizing cuts in plastic-laminated panels

Design

- tooth configuration: triple chip / flat „TR-F“
- cutting material: HW HL Board 10

Advantages

| Ø D  | B    | b    | Ø d  | Z  | NL                            | Ident-No. |
|------|------|------|------|----|-------------------------------|-----------|
| 250  | 3,2  | 2.2  | 30   | 80 | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188978 \$ |
| 300  | 3,2  | 2.2  | 30   | 72 | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188979 \$ |
| 300  | 3,2  | 2.2  | 30   | 96 | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188980 \$ |
| 350  | 3,5  | 2.5  | 30   | 96 | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188642    |
| [mm] | [mm] | [mm] | [mm] |    |                               |           |

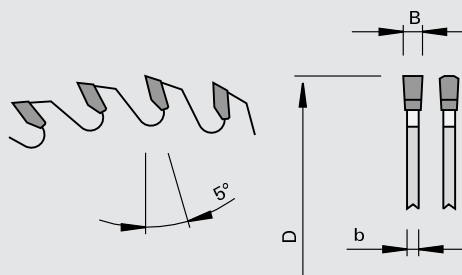
102478

## Sizing Saw Blades HW „TR-F“ - hook angle 5°

product



drawing

LEUCO  
prolineLEUCO  
DUR

tungsten carbide [HW]

LOW  
NOISE

Notes

- larger bore (max. Ø 50 mm) available for a surcharge

Machine / Application

- table saws
- vertical panel sizing saws
- for sizing cuts in plastic-laminated panels

Design

- tooth configuration: triple chip / flat „TR-F“
- cutting material: HW HL Board 06

Advantages

- improved bottom edge (without scoring sawblade) thanks to 5 degree hook angle
- noise-reduction thanks to laser ornaments

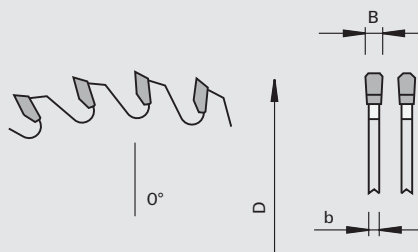
| Ø D  | B    | b    | Ø d  | Z  | NL                            | Ident-No. |
|------|------|------|------|----|-------------------------------|-----------|
| 250  | 3,2  | 2.2  | 30   | 80 | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188911    |
| 300  | 3,2  | 2.2  | 30   | 96 | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 188910 \$ |
| [mm] | [mm] | [mm] | [mm] |    |                               |           |

108380  
Sizing Saw Blades HW - Solid Surface „TR-F-FA“

product



drawing



tungsten carbide [HW]

Machine / Application

- | table saws
- | vertical panel sizing saws
- | especially for the machining of solid surface materials and hard wood-based panels such as Corian, compact boards, ...

Design

- | with laser ornaments
- | tooth configuration: triple chip / flat with chamfer „TR-FA“
- | cutting material: HW HL Board 06

Advantages

- | less vibration and noise thanks to laser ornaments

Notes

| Ø D  | B    | b    | Ø d  | Z  | NL                            | Ident-No. |
|------|------|------|------|----|-------------------------------|-----------|
| 303  | 3,2  | 2.5  | 30   | 84 | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 189531    |
| [mm] | [mm] | [mm] | [mm] |    |                               |           |

202180  
DIAREX Sizing Saw Blades DP

product



drawing



polycrystalline diamond [DP]



Machine / Application

- | table saws
- | vertical panel sizing saws
- | for finished cuts in melamine-, paper- or HPL-laminated panels and composite materials

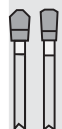
Design

- | resharpening area 2.0 mm
- | with laser ornaments

Advantages

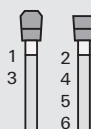
- | long edge lives thanks to tooth group with higher number of quality-forming cutting edges
- | less vibration and noise thanks to laser ornaments

Notes



TR-F-FA

for melamine- or HPL-laminated panels and composite materials in combination with scoring saw blades



G6

for melamine-laminated boards in combination with scoring saw blades for optimum cutting quality compared to TR-F-FA



HR-FA

- for fine cuts in a great variety of materials, in many cases even without scoring saw blade  
- for thin composite materials such as Cfk / Gfk projection 5-10 mm

| Ø D  | B    | b    | Ø d  | Z  | NL                        | tooth geometry | Ident-No. |
|------|------|------|------|----|---------------------------|----------------|-----------|
| 250  | 3,2  | 2.2  | 30   | 48 | 2/7/42 + 2/9/46 + 2/10/60 | TR-F-FA        | 189635    |
| 303  | 3,2  | 2.2  | 30   | 60 | 2/7/42 + 2/9/46 + 2/10/60 | TR-F-FA        | 189636    |
| 303  | 3,2  | 2.2  | 30   | 84 | 2/7/42 + 2/9/46 + 2/10/60 | TR-F-FA        | 189637    |
| 350  | 3,2  | 2.2  | 30   | 60 | 2/7/42 + 2/9/46 + 2/10/60 | TR-F-FA        | 189638    |
| 303  | 3,2  | 2.2  | 30   | 60 | 2/7/42 + 2/9/46 + 2/10/60 | G6             | 189623    |
| 303  | 3,2  | 2.2  | 30   | 60 | 2/7/42 + 2/9/46 + 2/10/60 | HR-FA          | 189624    |
| [mm] | [mm] | [mm] | [mm] |    |                           |                |           |

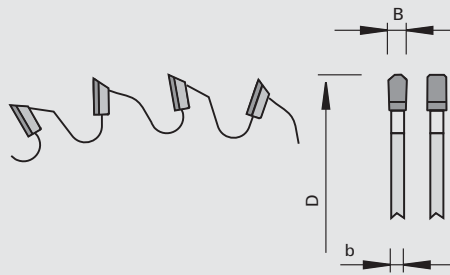
202380

## Sizing Saw Blades DP „TR-F-FA“ pos.-neg.

product



drawing

LEUCO  
toplineLEUCO  
DIA

polycrystalline diamond [DP]

## Machine / Application

- | table saws
- | vertical panel sizing saws
- | for sizing cuts in MDF and hard materials (e.g. Corian, Epoxyplatten, Cfk, Gfk,...)

## Design

- | asymmetric chip evacuation gap geometry
- | resharpening area 3.5 mm
- | tooth configuration: triple chip / flat with chamfer „TR-FA“ with alternating hook angle positive - negative

## Advantages

- | optimized chip removal
- | low cutting pressures
- | noise-reduction thanks to laser ornaments
- | improved cutting quality thanks to optimized entrance and exit angle

## Notes

| Ø D  | B    | b    | Ø d  | Z  | NL                        | Ident-No. |
|------|------|------|------|----|---------------------------|-----------|
| 303  | 3,2  | 2.2  | 30   | 56 | 2/7/42+2/9,5/46,5+2/10/60 | 189560 s  |
| 350  | 3,5  | 2.5  | 30   | 63 | 2/7/42+2/9,5/46,5+2/10/60 | 189561 s  |
| [mm] | [mm] | [mm] | [mm] |    |                           |           |



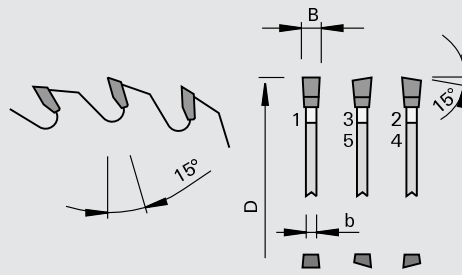
102348

## Sizing Saw Blades HW „G5“

product



drawing



LEUCO  
topLine

LEUCO  
DUR

tungsten carbide [HW]

LOW  
noise

**Machine / Application**

- | table saws
- | chop and miter saws
- | for chip-free sizing cuts as well as clipping and mitre cuts in wood-based panels, solid woods and plastics

**Design**

- | tooth configuration: G5
- | cutting material: HW HL Board 03

**Advantages**

- | excellent cutting quality for cross cuts
- | excellent cutting quality thanks to special tooth geometry
- | extremely long edge lives
- | noise-reduction thanks to laser ornaments

**Notes**

- | pay attention to nmax!!!

| Ø D  | B    | b    | Ø d  | Z   | NL                            | Ident-No.       |
|------|------|------|------|-----|-------------------------------|-----------------|
| 200  | 3,0  | 2.2  | 30   | 65  |                               | 189313          |
| 220  | 3,0  | 2.2  | 30   | 70  |                               | 189572          |
| 240  | 3,0  | 2.2  | 30   | 75  |                               | 189314          |
| 250  | 3,0  | 2.2  | 30   | 80  | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 189639          |
| 280  | 3,0  | 2.2  | 30   | 85  |                               | 189315          |
| 300  | 3,0  | 2.2  | 30   | 100 | 2/7/42 + 2/9,5/46,5 + 2/10/60 | Striebig 189640 |
| 303  | 3,2  | 2.2  | 30   | 100 | 2/7/42 + 2/10/60              | Striebig 189325 |
| 350  | 3,0  | 2.2  | 30   | 100 | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 189641          |
| 400  | 3,0  | 2.2  | 30   | 120 | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 189642          |
| 450  | 3,6  | 2.8  | 30   | 130 | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 189528          |
| 500  | 3,6  | 2.8  | 30   | 145 | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 189529          |
| [mm] | [mm] | [mm] | [mm] |     |                               |                 |

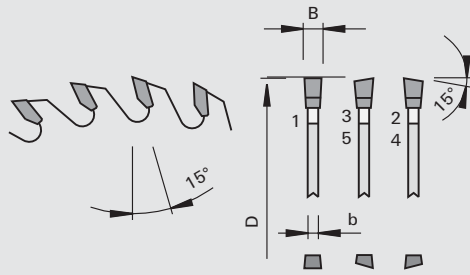
| Ø D    | B    | b    | Ø d    | Z   | NL                            | Ident-No. |
|--------|------|------|--------|-----|-------------------------------|-----------|
| 12"    | 3,0  | 2.2  | 1"     | 100 | 2/7/42 + 2/9,5/46,5 + 2/10/60 | 189224    |
| [inch] | [mm] | [mm] | [inch] |     |                               |           |

202380

## Sizing Saw Blades DP „G5“

product

drawing

LEUCO  
toplineLEUCO  
DIA

polycrystalline diamond [DP]

LOW  
noise

## Machine / Application

- | table saws
- | vertical panel sizing saws
- | for chip-free sizing cuts as well as clipping and miter cuts in wood-based panels, and plastics (e.g. plastic profiles)

## Design

- | resharpening area 3.5 mm
- | tooth configuration: G5

## Advantages

- | excellent cutting quality for cross cuts
- | excellent cutting quality thanks to special tooth geometry
- | extremely long edge lives
- | noise-reduction thanks to laser ornaments

## Notes

- | pay attention to nmax!!!

| Ø D  | B    | b    | Ø d  | Z   | NL                        | Ident-No. |
|------|------|------|------|-----|---------------------------|-----------|
| 303  | 3,2  | 2.2  | 30   | 100 | 2/7/42+2/9,5/46,5+2/10/60 | 189633 s  |
| 350  | 3,2  | 2.2  | 30   | 100 | 2/7/42+2/9,5/46,5+2/10/60 | 189634 s  |
| [mm] | [mm] | [mm] | [mm] |     |                           |           |

1023...

## Sizing Saw Blades HW - LowNoise

product



drawing



tungsten carbide [HW]



**Machine / Application**

- | table saws
- | vertical panel sizing saws
- | for sizing cuts

**Design**

- | vibration and noise damping ornaments
- | additional expansion slots
- | cutting material: HL Board 03 and HL Board 06

**Advantages**

- | extremely low-noise and smooth running thanks to vibration and noise damping ornaments as well as special expansion slot combinations
- | for each application case the correct tooth form

**Notes**

- | Ident-No. 189690: extremely straight steel plate for Striebig panel sizing saws with scoring device
- | Combi2 = 2/7/42 + 2/9.5/46.5 + 2/10/60

**WS**

- HW HL Board 03 for raw and laminated panels
- HL Board 06 for solid woods in combination with scoring saw blade
- optimum cutting quality, feed rate and adjustment for material thickness thanks to various numbers of teeth

**TR-F**

- for raw and laminated panels
- 10° hook angle in combination with scoring saw blade
- 5° hook angle improved bottom edge even without scoring saw blade

**DA-D**

- 10° hook angle for raw and laminated panels
- -6° hook angle for sizing cuts in plastic and solid wood profile ledges
- good quality of bottom edge even without scoring saw blade
- excellent cutting quality

| Ø D  | B    | b    | Ø d  | Z  | hook angle | NL      | tooth geometry | LEUCODUR    | Class-No. | Ident-No. |
|------|------|------|------|----|------------|---------|----------------|-------------|-----------|-----------|
| 220  | 3,2  | 2,2  | 30   | 36 | 10         | 2/7/42  | WS             | HL Board 06 | 102328    | 189664    |
| 250  | 3,2  | 2,2  | 30   | 40 | 10         | Combi2  | WS             | HL Board 06 | 102328    | 189665    |
| 250  | 3,2  | 2,2  | 30   | 48 | 10         | Combi2  | WS             | HL Board 06 | 102328    | 189666    |
| 250  | 3,2  | 2,2  | 60   | 40 | 10         | Combi2  | WS             | HL Board 06 | 102328    | 189667    |
| 300  | 3,2  | 2,2  | 30   | 48 | 10         | Combi2  | WS             | HL Board 06 | 102328    | 189668    |
| 300  | 3,2  | 2,2  | 30   | 60 | 10         | Combi2  | WS             | HL Board 06 | 102328    | 189669    |
| 300  | 3,2  | 2,2  | 60   | 48 | 10         |         | WS             | HL Board 06 | 102328    | 188185 &  |
| 350  | 3,5  | 2,5  | 30   | 54 | 10         | Combi2  | WS             | HL Board 06 | 102328    | 189670    |
| 350  | 3,5  | 2,5  | 30   | 72 | 10         | Combi2  | WS             | HL Board 06 | 102328    | 189671    |
| 400  | 3,5  | 2,5  | 30   | 60 | 10         | 2/10/60 | WS             | HL Board 06 | 102328    | 189672    |
| 400  | 3,5  | 2,5  | 30   | 84 | 10         | 2/10/60 | WS             | HL Board 06 | 102328    | 189673    |
| [mm] | [mm] | [mm] | [mm] |    | [°]        |         |                |             |           |           |

| Ø D  | B    | b    | Ø d  | Z   | hook angle | NL      | tooth geometry | LEUCODUR    | Class-No. | Ident-No. |
|------|------|------|------|-----|------------|---------|----------------|-------------|-----------|-----------|
| 220  | 3,2  | 2,2  | 30   | 64  | 10         | 2/7/42  | WS             | HL Board 03 | 102328    | 189674    |
| 250  | 3,2  | 2,2  | 30   | 60  | 10         | Combi2  | WS             | HL Board 03 | 102328    | 189675    |
| 250  | 3,2  | 2,2  | 30   | 80  | 10         | Combi2  | WS             | HL Board 03 | 102328    | 189676    |
| 300  | 3,2  | 2,2  | 30   | 72  | 10         | Combi2  | WS             | HL Board 03 | 102328    | 189620 \$ |
| 300  | 3,2  | 2,2  | 30   | 96  | 10         | Combi2  | WS             | HL Board 03 | 102328    | 189619 \$ |
| 350  | 3,5  | 2,5  | 30   | 84  | 10         | Combi2  | WS             | HL Board 03 | 102328    | 189677    |
| 350  | 3,5  | 2,5  | 30   | 108 | 10         | Combi2  | WS             | HL Board 03 | 102328    | 189622    |
| 350  | 3,5  | 2,5  | 35   | 84  | 10         |         | WS             | HL Board 03 | 102328    | 189678 &  |
| 400  | 3,5  | 2,5  | 30   | 96  | 10         | 2/10/60 | WS             | HL Board 03 | 102328    | 189679    |
| 400  | 3,5  | 2,5  | 30   | 120 | 10         | 2/10/60 | WS             | HL Board 03 | 102328    | 189680    |
| 450  | 4,0  | 2,8  | 30   | 132 | 10         |         | WS             | HL Board 03 | 102328    | 189681    |
| [mm] | [mm] | [mm] | [mm] |     | [°]        |         |                |             |           |           |

| Ø D  | B    | b    | Ø d  | Z   | hook angle | NL      | tooth geometry | LEUCODUR    | Class-No. | Ident-No. |
|------|------|------|------|-----|------------|---------|----------------|-------------|-----------|-----------|
| 220  | 3,2  | 2.2  | 30   | 64  | 10         | 2/7/42  | TR-F           | HL Board 03 | 102370    | 189682    |
| 250  | 3,2  | 2.2  | 30   | 60  | 10         | Combi2  | TR-F           | HL Board 03 | 102370    | 189683    |
| 250  | 3,2  | 2.2  | 30   | 80  | 10         | Combi2  | TR-F           | HL Board 03 | 102378    | 189621    |
| 300  | 3,2  | 2.2  | 30   | 72  | 10         | Combi2  | TR-F           | HL Board 03 | 102370    | 189684    |
| 300  | 3,2  | 2.2  | 30   | 96  | 5          | Combi2  | TR-F           | HL Board 03 | 102378    | 189616 \$ |
| 300  | 3,2  | 2.2  | 30   | 96  | 10         | Combi2  | TR-F           | HL Board 03 | 102378    | 189618 \$ |
| 350  | 3,5  | 2.5  | 30   | 84  | 10         | Combi2  | TR-F           | HL Board 03 | 102370    | 189685    |
| 350  | 3,5  | 2.5  | 30   | 108 | 10         | Combi2  | TR-F           | HL Board 03 | 102370    | 189686    |
| [mm] | [mm] | [mm] | [mm] |     | [°]        |         |                |             |           |           |
| Ø D  | B    | b    | Ø d  | Z   | hook angle | NL      | tooth geometry | LEUCODUR    | Class-No. | Ident-No. |
| 220  | 3,2  | 2.2  | 30   | 42  | 10         | 2/7/42  | DA-D           | HL Board 06 | 102338    | 189688    |
| 250  | 3,2  | 2.2  | 30   | 48  | 10         | Combi2  | DA-D           | HL Board 06 | 102338    | 189689 \$ |
| 303  | 3,2  | 2.2  | 30   | 60  | 10         | Combi2  | DA-D           | HL Board 06 | 102338    | 189690    |
| 303  | 3,2  | 2.2  | 30   | 60  | 10         | Combi2  | DA-D           | HL Board 06 | 102338    | 189617 \$ |
| 350  | 3,5  | 2.5  | 30   | 72  | 10         | Combi2  | DA-D           | HL Board 06 | 102338    | 189691    |
| 400  | 3,5  | 2.5  | 30   | 84  | 10         | 2/10/60 | DA-D           | HL Board 06 | 102338    | 189692    |
| [mm] | [mm] | [mm] | [mm] |     | [°]        |         |                |             |           |           |
| Ø D  | B    | b    | Ø d  | Z   | hook angle | NL      | tooth geometry | LEUCODUR    | Class-No. | Ident-No. |
| 250  | 3,2  | 2.2  | 30   | 48  | -6         | Combi2  | DA-D           | HL Board 06 | 102338    | 189693    |
| 303  | 3,2  | 2.2  | 30   | 60  | -6         | Combi2  | DA-D           | HL Board 06 | 102338    | 189694    |
| 350  | 3,5  | 2.5  | 30   | 72  | -6         | Combi2  | DA-D           | HL Board 06 | 102338    | 189695    |
| [mm] | [mm] | [mm] | [mm] |     | [°]        |         |                |             |           |           |

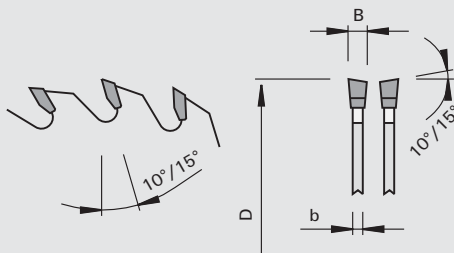
103320

## Panel Sizing Saw Blades HW - UniCut „WS“

product



drawing



LEUCO  
topline

UNICUT

tungsten carbide [HW]

**Machine / Application**

- | panel sizing saws
- | double-end tenoners
- | for sizing cuts in raw and veneered particleboard, hardboard, MDF panels and high-density plywood in single sheets and stacks

**Design**

- | up to ØD=355, 10 degree hook angle and 15 degree corner angle
- | from ØD=400, 15 degree hook angle and 10 degree corner angle
- | tooth configuration: alternate top bevel „WS“
- | cutting material: HW HL Board 06

**Advantages**

**Notes**

- | for main/scoring saw combinations see specifications (appendix)
- | on double-end tenoners in combination with large hoggers

| Ø D  | B    | b    | Ø d  | Z  | NL               | Ident-No.                                   |
|------|------|------|------|----|------------------|---|
| 305  | 4,4  | 2,8  | 30   | 48 |                  | Mayer, Panhans<br>188498                    |
| 305  | 4,4  | 2,8  | 60   | 48 |                  | 188499                                      |
| 350  | 4,4  | 3,0  | 30   | 54 |                  | SCM, Panhans, Schelling<br>188503           |
| 355  | 4,4  | 3,0  | 30   | 72 |                  | Schelling, Mayer, Irion<br>188506           |
| 355  | 4,4  | 3,0  | 60   | 54 |                  | 188504                                      |
| 355  | 4,4  | 3,0  | 60   | 72 |                  | 188507                                      |
| 355  | 4,4  | 3,0  | 80   | 54 |                  | S.M.A.<br>188505                            |
| 355  | 4,4  | 3,0  | 80   | 72 |                  | S.M.A.<br>188508                            |
| 400  | 4,6  | 3,2  | 30   | 60 | 2/7/42 + 2/10/60 | Schelling, Mayer, Irion, HOLZ-HER<br>188509 |
| 400  | 4,6  | 3,2  | 30   | 72 | 2/7/42 + 2/10/60 | Schelling, Mayer, Irion, HOLZ-HER<br>188511 |
| 400  | 4,6  | 3,2  | 80   | 60 |                  | S.M.A.<br>188510                            |
| 400  | 4,6  | 3,2  | 80   | 72 |                  | S.M.A.<br>188512                            |
| 430  | 4,6  | 3,2  | 75   | 72 | 4/15/105         | Giben Prismatic 2<br>188513                 |
| 430  | 4,6  | 3,2  | 80   | 72 |                  | S.M.A.<br>188514                            |
| 450  | 4,6  | 3,2  | 30   | 54 |                  | Panhans, Irion, Schelling<br>188515         |
| 450  | 4,6  | 3,2  | 80   | 72 |                  | S.M.A., Irion<br>188516                     |
| 500  | 4,6  | 3,2  | 30   | 60 |                  | Schelling, Irion<br>188517                  |
| 500  | 4,6  | 3,2  | 80   | 60 |                  | Teutomatic<br>188518                        |
| 550  | 5,0  | 3,5  | 80   | 60 |                  | Teutomatic<br>188521                        |
| [mm] | [mm] | [mm] | [mm] |    |                  |   |

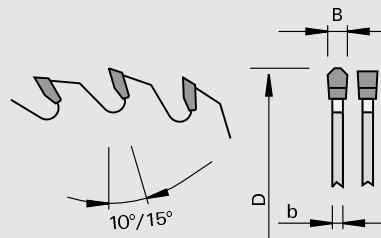
104378

## Panel Sizing Saw Blades HW - UniCut „TR-F“

product



drawing



**LEUCO**  
topLine

UNICUT

tungsten carbide [HW]

LOW VIBRATION

**Machine / Application**

panel sizing saws  
for sizing cuts in plastic-laminated panels

**Design**

up to ØD=360, 10 degree hook angle  
from ØD=380, 15 degree hook angle  
tooth configuration: triple chip / flat „TR-F“  
cutting material: HW HL Board 03

**Advantages**

improved cutting quality thanks to optimized cutting geometry  
noise-reduction thanks to laser ornaments

**Notes**

specifically for plastic-laminated panels and plywood in single sheets and stacks

| Ø D  | B    | b    | Ø d  | Z  | NL                             | Ident-No.   |
|------|------|------|------|----|--------------------------------|---|
| 300  | 4,4  | 3.0  | 75   | 72 |                                | Homag Espana 189202   |
| 305  | 3,2  | 2.2  | 30   | 60 | 2/7/42 + 2/9/46 + 2/10/60      | Scheer FM 16 189201   |
| 305  | 4,4  | 2.8  | 30   | 60 | 2/7/42 + 2/9/46 + 2/10/60      | Mayer, Panhans 189199                                       |
| 305  | 4,4  | 2.8  | 60   | 60 |                                | Hoggers 189198  |
| 320  | 4,4  | 3.2  | 65   | 60 | 2/9/110                        | Biesse, Selco EB 80 189197                                  |
| 320  | 4,4  | 3.2  | 75   | 72 | 3/13/95                        | Giben Smart 189196  |
| 350  | 4,4  | 3.0  | 75   | 60 |                                | Giben MK Gamma 189190                                       |
| 350  | 4,4  | 3.0  | 30   | 72 | 2/7/42 + 2/9/46 + 2/10/60      | SCM, Panhans, Mayer, Schelling, HOLZ-HER 189191 \$          |
| 350  | 4,4  | 3.2  | 60   | 72 | 2/14/100                       | Holzma 72, HPP 350 189192                                   |
| 355  | 4,4  | 3.0  | 75   | 60 |                                | Giben Trend, Homag CH06+10 189184                           |
| 355  | 4,4  | 3.0  | 75   | 72 | 4/15/105                       | Giben 189183  |
| 355  | 4,4  | 3.0  | 80   | 72 | 4/19/120 + 2/8,4/130           | S.M.A., hoggers 189180                                      |
| 355  | 4,4  | 3.0  | 80   | 72 | 4/8,5/100 + 2/14/110 + 2/7/110 | Gabbiani PRIMA, SCM ALPHA 189181                            |
| 360  | 4,4  | 3.2  | 65   | 72 | 2/9/110                        | Selco 189178  |
| 380  | 4,4  | 3.2  | 60   | 72 | 2/14/100 + 2/14/125            | Holzma 189173   |
| 380  | 4,8  | 3.5  | 60   | 72 | 2/14/100 + 2/14/125            | Holzma 189170 \$  |
| 400  | 4,25 | 3.2  | 30   | 72 |                                | Scheer 189168   |
| 400  | 4,4  | 3.2  | 30   | 72 | 2/7/42 + 2/10/60               | Schelling, Mayer, Irion, Scheer, HOLZ-HER 189165            |
| 400  | 4,4  | 3.2  | 60   | 72 |                                | Anthon 189164 \$  |
| 400  | 4,4  | 3.2  | 75   | 72 | 4/15/105 + 2/7/110             | Giben Prismatic 1, Giben Starmatic, Homag CH08+12 189161 \$ |
| 400  | 4,4  | 3.2  | 80   | 72 | 2/7/110 + 4/19/120 + 2/8,4/130 | Selco WN / EB, S.M.A., Irion 189158                         |
| 400  | 4,8  | 3.5  | 60   | 72 | 2/14/100 + 2/14/125            | Holzma type 01 189157                                       |
| 400  | 4,4  | 3.2  | 30   | 96 |                                | 189167  |
| 420  | 4,8  | 3.5  | 60   | 72 | 2/10/80 + 2/14/125             | Holzma 189155   |
| 430  | 4,4  | 3.2  | 30   | 72 |                                | 189154  |
| 430  | 4,4  | 3.2  | 60   | 72 | 1/11/85                        | Anthon 189153   |
| 430  | 4,4  | 3.2  | 80   | 72 | 4/19/120 + 2/8,4/130           | Selco WN 189149   |
| 430  | 4,4  | 3.2  | 75   | 96 | 4/15/105 + 2/7/110             | Giben Prismatic 2 old 189151                                |
| 450  | 4,4  | 3.2  | 30   | 72 |                                | Irion, Schelling 189148                                     |
| [mm] | [mm] | [mm] | [mm] |    |                                |   |

| Ø D  | B    | b    | Ø d  | Z  | NL                               | Ident-No.                      |
|------|------|------|------|----|----------------------------------|--------------------------------|
| 450  | 4,8  | 3.5  | 60   | 72 | 2/19/120 +<br>2/14/125           | Holzma 189141 \$               |
| 450  | 4,4  | 3.2  | 80   | 72 | 2/7/110 + 2/8,3/130S.M.A., Irion | 189145                         |
| 450  | 4,8  | 3.5  | 80   | 72 | 4/19/120 +<br>2/8,4/130          | Selco WN 189138                |
| 460  | 4,4  | 3.2  | 30   | 72 | 2/13/94                          | Schelling FL, FH 6 189137      |
| 470  | 4,4  | 3.2  | 75   | 72 | 4/15/105                         | Giben 189525                   |
| 470  | 4,4  | 3.2  | 75   | 96 | 4/15/105                         | Giben Prismatic 3 189136       |
| 480  | 4,4  | 3.2  | 30   | 72 |                                  | Schelling FL ab 211.145 189135 |
| 480  | 4,8  | 3.5  | 60   | 72 | 2/11/115 +<br>2/19/120           | Holzma 530 189242              |
| 480  | 4,8  | 3.5  | 80   | 72 | 4/19/120 +<br>2/8,4/130          | Selco WN 189134                |
| 500  | 4,4  | 3.2  | 30   | 60 |                                  | Schelling, Irion 189133        |
| 500  | 4,8  | 3.5  | 60   | 72 | 2/11/115                         | Holzma type 22 189130          |
| 520  | 4,8  | 3.5  | 30   | 72 | 2/13/94                          | Schelling FH 8 189526          |
| 520  | 4,8  | 3.5  | 60   | 72 | 2/11/115 +<br>2/19/120           | Holzma type 23 189227          |
| 550  | 5,0  | 3.5  | 100  | 72 |                                  | Giben 189126                   |
| 565  | 5,0  | 3.5  | 100  | 72 |                                  | Giben 189124                   |
| 600  | 5,8  | 4.0  | 60   | 72 | 2/11/115 +<br>2/19/120           | Holzma type 42 189121          |
| 650  | 6,2  | 4.0  | 40   | 72 |                                  | Schelling 189118               |
| [mm] | [mm] | [mm] | [mm] |    |                                  |                                |

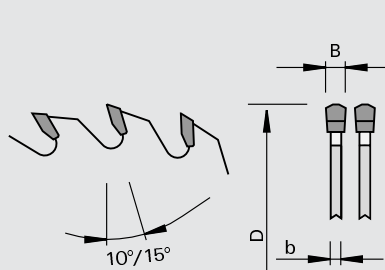
104378

### Panel Sizing Saw Blades HW - UniCut „TR-TR“

product



drawing



LEUCO topline

UNI-CUT

tungsten carbide [HW]

LOW VIBRATION

**Machine / Application**

- panel sizing saws
- for sizing cuts in plastic-laminated panels

**Design**

- up to ØD=360, 10 degree hook angle
- from ØD=380, 15 degree hook angle
- tooth configuration: triple chip / triple chip „TR-TR“
- cutting material: HW HL Board 03

**Advantages**

- improved cutting quality thanks to optimized cutting geometry
- noise-reduction thanks to laser ornaments

**Notes**

- specifically for plastic-laminated panels and plywood in single sheets and stacks

| Ø D  | B    | b    | Ø d  | Z  | NL       | Ident-No.                        |
|------|------|------|------|----|----------|----------------------------------|
| 350  | 4,4  | 3.2  | 75   | 72 |          | Homag Sawtech, Holzma 250 189186 |
| 500  | 4,8  | 3.5  | 60   | 72 | 2/11/115 | Holzma type 22 189131 &          |
| [mm] | [mm] | [mm] | [mm] |    |          |                                  |

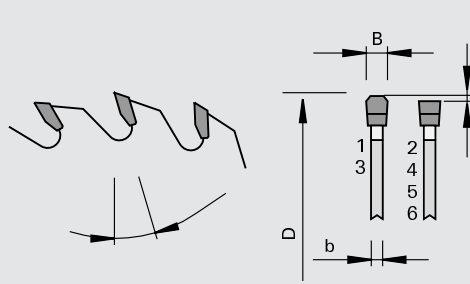
104388

## Panel Sizing Saw Blades HW - UniCut Plus „G6“

product



drawing



**LEUCO**  
topLine

UNI-CUT PLUS

tungsten carbide [HW]

LOW VIBRATION

**Machine / Application**

| horizontal panel sizing saws  
| for sizing cuts in raw and plastic-laminated panels

**Design**

| tooth configuration: G6  
| cutting material: HW HL Board 03

**Advantages**

| improved cutting quality thanks to optimized cutting geometry  
| very long edge lives thanks to uneven tooth configuration  
| less vibration and noise thanks to laser ornaments

**Notes**

| Ø D  | B    | b    | Ø d  | Z  | NL                        | Ident-No.   |          |
|------|------|------|------|----|---------------------------|---|----------|
| 350  | 4,4  | 3.0  | 30   | 72 | 2/7/42 + 2/9/46 + 2/10/60 | SCM, Panhans, Mayer, Schelling, HOLZ-HER          | 189194   |
| 350  | 4,4  | 3.2  | 60   | 72 | 2/14/100                  | Holzma 72, HPP350                                 | 189193   |
| 380  | 4,8  | 3.5  | 60   | 72 | 2/14/100 + 2/14/125       | Holzma  | 189171   |
| 400  | 4,4  | 3.2  | 30   | 72 | 2/7/42 + 2/10/60          | Schelling, Mayer, Irion, Scheer, HOLZ-HER         | 189166   |
| 400  | 4,4  | 3.2  | 75   | 72 | 4/15/105                  | Giben Prismatic 1, Giben Starmatic, Homag CH08+12 | 189162 & |
| 450  | 4,8  | 3.5  | 60   | 72 | 2/19/120 + 2/14/125       | Holzma  | 189142   |
| [mm] | [mm] | [mm] | [mm] |    |                           |   |          |



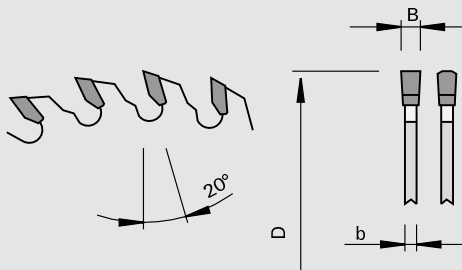
104270

## Panel Sizing Saw Blades HW - SpeedCut Plus „TR-F“

product



drawing



LEUCO  
topline



tungsten carbide [HW]

**Machine / Application**

- horizontal panel sizing saws
- for stack cuts in raw and plastic-laminated panels

**Design**

- tooth configuration: triple chip / flat „TR-F“
- cutting material: HW HL Board 03

**Advantages**

- for highest performance demands
- reduced cutting pressure and power consumption thanks to optimized cutting geometry
- improved vibration behaviour and chip removal thanks to asymmetric chip evacuation gap geometry
- highest wear-resistance

**Notes**

- stack height: Ident-No. 189210 up to max. 190 mm / Ident-No. 189209 up to max. 210 mm / Ident-No. 189208 up to max. 215 mm
- recommended projection: 20-30 mm

| Ø D  | B    | b    | Ø d  | Z  | NL                     |                    | Ident-No. |
|------|------|------|------|----|------------------------|--------------------|-----------|
| 480  | 4,8  | 3.5  | 60   | 48 | 2/11/115 +<br>2/19/120 | Holzma 530         | 189243    |
| 520  | 4,8  | 3.5  | 60   | 60 | 2/11/115 +<br>2/19/120 | Holzma             | 189228    |
| 530  | 5,0  | 3.5  | 30   | 60 |                        | Schelling          | 189128    |
| 530  | 5,8  | 4.0  | 60   | 60 | 1/11/85                | Anthon             | 189127    |
| 565  | 5,0  | 3.5  | 100  | 60 |                        | Giben              | 189125    |
| 570  | 4,8  | 3.5  | 60   | 60 | 2/11/115 +<br>2/19/120 | Holzma             | 189123    |
| 600  | 5,8  | 4.0  | 60   | 60 | 2/11/115 +<br>2/19/120 | Holzma 33 / 42     | 189226    |
| 650  | 6,2  | 4.0  | 40   | 60 |                        | Schelling          | 189119    |
| 670  | 6,0  | 4.4  | 60   | 48 | 2/11/148 +<br>2/19/120 | Holzma 66 (Tandem) | 189117    |
| 680  | 6,4  | 4.4  | 40   | 60 | 2/17/140 +<br>2/13/140 | Schelling AS       | 189210    |
| 700  | 6,4  | 4.4  | 80   | 60 | 2/17/110               | Anthon             | 189209    |
| 720  | 6,4  | 4.4  | 40   | 60 | 2/13/114 +<br>2/13/140 | Schelling          | 189208    |
| 730  | 6,4  | 4.4  | 60   | 60 | 2/19/120 +<br>2/11/148 | Holzma 66 (Tandem) | 189116    |
| 730  | 6,4  | 4.4  | 80   | 60 | 2/17/110               | Anthon LNC         | 189207    |
| [mm] | [mm] | [mm] | [mm] |    |                        |                    |           |

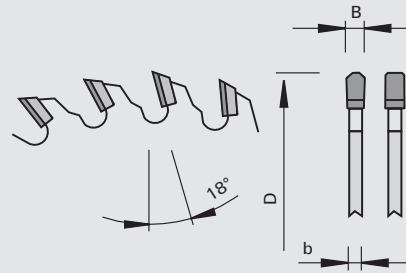
204385

## Panel Sizing Saw Blades DP - SpeedCut Plus „TR-F-FA“

product



drawing



LEUCO  
topline

WORLD  
CLASS  
SPEED-CUT

polycrystalline diamond [DP]

**Machine / Application**

- | horizontal panel sizing saws
- | for stack cuts in raw and plastic-laminated panels

**Design**

- | resharpening area 5 mm
- | tooth configuration: triple chip / flat with chamfer „TR-FA“

**Advantages**

- | for highest performance demands
- | reduced cutting pressure and power consumption thanks to optimized cutting geometry
- | improved vibration behaviour and chip removal thanks to asymmetric chip evacuation gap geometry
- | highest wear-resistance
- | extremely long teeth for better guide and improved service possibilities

**Notes**

- | recommended projection: 20-30 mm

| Ø D  | B    | b    | Ø d  | Z  | NL                     |                    | Ident-No. |
|------|------|------|------|----|------------------------|--------------------|-----------|
| 530  | 5,8  | 4.0  | 60   | 60 | 1/11/85                | Anthon             | 189550 s  |
| 570  | 4,8  | 3.5  | 60   | 60 | 2/11/115 +<br>2/19/120 | Holzma             | 189551 s  |
| 600  | 5,8  | 4.0  | 60   | 60 | 2/11/115 +<br>2/19/120 | Holzma 33 / 42     | 189552 s  |
| 650  | 6,2  | 4.0  | 40   | 60 |                        | Schelling          | 189553 s  |
| 670  | 6,0  | 4.4  | 60   | 48 | 2/11/148 +<br>2/19/120 | Holzma 66 (Tandem) | 189554 s  |
| 680  | 6,4  | 4.4  | 40   | 60 | 2/17/140 +<br>2/12/140 | Schelling AS       | 189555 s  |
| 700  | 6,4  | 4.4  | 80   | 60 | 2/17/110               | Anthon             | 189556 s  |
| 720  | 6,4  | 4.4  | 40   | 60 | 2/13/114 +<br>2/13/140 | Schelling          | 189557 s  |
| 730  | 6,4  | 4.4  | 60   | 60 | 2/19/120 +<br>2/11/148 | Holzma 66 (Tandem) | 189558 s  |
| 730  | 6,4  | 4.4  | 80   | 60 | 2/17/110               | Anthon LNC         | 189559 s  |
| [mm] | [mm] | [mm] | [mm] |    |                        |                    |           |

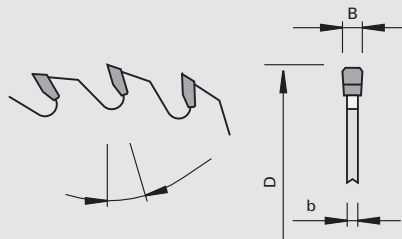
104348

## Panel Sizing Saw Blades HW - FinishCut „F-FA“

product



drawing



**LEUCO**  
topline

FINISH-CUT

tungsten carbide [HW]

LOW

**Machine / Application**

panel sizing saws  
for finish cuts in veneered, foiled or melamine-laminated panels, in single sheets or in stacks up to 100 mm cutting height

**Design**

tooth configuration: flat with chamfer „F-FA“  
cutting material: HW HL Board 03

**Advantages**

improved cutting quality thanks to optimized cutting geometry  
noise-reduction thanks to laser ornaments

**Notes**

projection: min 20 - 25 mm  
max 40 mm

| Ø D  | B    | b    | Ø d  | Z  | NL                             |   | Ident-No. |
|------|------|------|------|----|--------------------------------|---|-----------|
| 280  | 3,2  | 2.2  | 30   | 60 |                                | Panhans EURO 5                                    | 189205    |
| 300  | 4,4  | 3.0  | 65   | 60 | 2/8,4/110                      | Selco EB 70                                       | 189203    |
| 300  | 4,4  | 3.0  | 75   | 60 |                                | Homag CHO3  | 189204    |
| 305  | 4,4  | 2.8  | 30   | 60 | 2/7/42 + 2/9/46 + 2/10/60      | Mayer, Panhans                                    | 189200    |
| 330  | 4,4  | 3.2  | 50   | 60 | 8/13/80                        | Giben   | 189251    |
| 350  | 4,25 | 3.2  | 30   | 72 | 2/7/42 + 2/9/46 + 2/10/60      | Scheer  | 189195 &  |
| 350  | 4,4  | 3.2  | 30   | 72 | 2/7/42 + 2/9/46 + 2/10/60      | SCM, Panhans, Mayer, Schelling, HOLZ-HER          | 189189    |
| 350  | 4,4  | 3.2  | 50   | 72 | 8/12,5/80                      | Giben Smart                                       | 189188    |
| 350  | 4,4  | 3.2  | 60   | 72 | 2/14/100                       | Holzma 72, HPP 350                                | 189187    |
| 350  | 4,4  | 3.2  | 75   | 72 |                                | Homag Sawtech, Holzma 250                         | 189229    |
| 355  | 4,4  | 3.2  | 75   | 72 |                                | Giben   | 189185    |
| 355  | 4,4  | 3.2  | 80   | 72 | 4/8,5/100 + 2/14/110 + 2/7/110 | Gabbiani PRIMA, SCM ALPHA                         | 189182 &  |
| 355  | 4,4  | 3.2  | 80   | 72 | 4/19/120 + 2/8,4/130           | Selco EB 90                                       | 189179 &  |
| 360  | 4,4  | 3.2  | 75   | 72 | 4/15/105                       | Giben   | 189177    |
| 370  | 4,4  | 3.2  | 30   | 72 |                                | Schelling FM from 202180                          | 189176    |
| 380  | 4,4  | 3.2  | 50   | 72 | 4/12,5/80                      | Giben Onyx  | 189175    |
| 380  | 4,4  | 3.2  | 60   | 72 | 2/14/100 + 2/14/125            | Holzma  | 189174    |
| 380  | 4,8  | 3.5  | 60   | 72 | 2/14/100 + 2/14/125            | Holzma  | 189172 \$ |
| 400  | 4,25 | 3.2  | 30   | 72 |                                | Scheer  | 189169 &  |
| 400  | 4,4  | 3.2  | 30   | 72 | 2/7/42 + 2/10/60               | Scheer, HOLZ-HER                                  | 181691    |
| 400  | 4,4  | 3.2  | 75   | 72 | 4/15/105 + 2/7/110             | Giben Prismatic 1, Giben Starmatic, Homag CH08+12 | 189163    |
| 400  | 4,4  | 3.2  | 80   | 72 | 4/8,5/100 + 2/14/110 + 2/7/110 | Gabbiani CLASS, Scm DELTA                         | 189159    |
| 400  | 4,4  | 3.2  | 80   | 72 | 4/19/120 + 2/8,4/130           | Selco WN / EB                                     | 189160 &  |
| 420  | 4,8  | 3.5  | 60   | 72 | 2/10/80 + 2/14/125             | Holzma type 92                                    | 189156    |
| 430  | 4,4  | 3.2  | 75   | 72 | 4/15/105 + 2/7/110             | Giben Prismatic 2 old                             | 189152    |
| 430  | 4,4  | 3.2  | 80   | 72 | 4/19/120 + 2/8,4/130           | Selco WN  | 189150    |
| 450  | 4,4  | 3.2  | 30   | 72 |                                | Irion, Schelling                                  | 189147    |
| 450  | 4,65 | 3.5  | 30   | 72 | 2/9/60                         | Scheer  | 189144 &  |
| 450  | 4,8  | 3.5  | 30   | 72 | 2/9/60                         | Scheer  | 189143    |
| 450  | 4,8  | 3.5  | 60   | 72 | 2/19/120 + 2/14/125            | Holzma  | 189140 \$ |
| [mm] | [mm] | [mm] | [mm] |    |                                |   |           |

| Ø D  | B    | b    | Ø d  | Z  | NL                                | Ident-No.                |
|------|------|------|------|----|-----------------------------------|--------------------------|
| 450  | 4,4  | 3.2  | 75   | 72 | 2/7/110                           | Gibben 189663            |
| 450  | 4,4  | 3.2  | 80   | 72 | 4/8,5/100 +<br>2/14/110 + 2/7/110 | Gabbiani ELITE 189146    |
| 450  | 4,8  | 3.5  | 80   | 72 | 4/19/120 +<br>2/8,4/130           | Selco WN 189139          |
| 460  | 4,4  | 3.2  | 30   | 72 | 2/13/94                           | Schelling FL, FH6 189249 |
| 470  | 4,4  | 3.2  | 75   | 72 | 4/15/105                          | Gibben 189248            |
| 480  | 4,8  | 3.5  | 60   | 72 | 2/11/115 +<br>2/19/120            | Holzma 530 189241        |
| 520  | 4,8  | 3.5  | 60   | 72 | 2/11/115 +<br>2/19/120            | Holzma 23 / 550 189250   |
| [mm] | [mm] | [mm] | [mm] |    |                                   |                          |

2043..

## Panel Sizing Saw Blades DP - flexible & quick

product



drawing



polycrystalline diamond [DP]



**Machine / Application**

- | panel sizing saws
- | for sizing cuts in raw and plastic-laminated panels

**Design**

- | Saw blade body with vibration- and noise-dampening ornaments
- | diamond cutting edges with polished design
- | LEUCODIA tipping quality
- | optimized cutting geometry depending on the respective tooth form for main and scoring saw blades

**Advantages**

- | for each application case the correct tooth form
- | short delivery times
- | interesting scaled prices

**Notes**

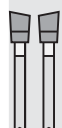
- | all flat and alternate bevel teeth with protection chamfer
- | further dimensions and tooth forms on request



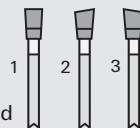
**TR-F-FA UniCut**  
Single and book cuts, focus on universality



**G6 UniCut Plus**  
Improved edge live compared to standard UniCut, reduced motor power



**WS-FA UniCut**  
Single and book cuts in uncovered or veneered panel materials and plywood



**G3 UniCut**  
Reduced cutting pressure and increased edge life

|      | B    | b    | Ø d  | Z  | NL | tooth geometry | Ident-No.   |
|------|------|------|------|----|----|----------------|---|
|      | 350  | 4,4  | 3.2  | 75 | 72 | TR-F-FA        | Homag Sawtech, Holzma 250 189380 s                    |
|      | 350  | 4,4  | 3.2  | 75 | 72 | G6             | Homag Sawtech, Holzma 250 189385 s                    |
|      | 350  | 4,4  | 3.2  | 75 | 72 | WS-FA          | Homag Sawtech, Holzma 250 189395 s                    |
|      | 350  | 4,4  | 3.2  | 75 | 72 | G3             | Homag Sawtech, Holzma 250 189390 s                    |
|      | 350  | 4,4  | 3.2  | 60 | 72 | 2/14/100       | TR-F-FA Holzma 72, HPP350 189381 s                    |
|      | 350  | 4,4  | 3.2  | 60 | 72 | 2/14/100       | G6 Holzma 72, HPP350 189386 s                         |
|      | 350  | 4,4  | 3.2  | 60 | 72 | 2/14/100       | WS-FA Holzma 72, HPP350 189396 s                      |
|      | 350  | 4,4  | 3.2  | 60 | 72 | 2/14/100       | G3 Holzma 72, HPP350 189391 s                         |
|      | 350  | 4,4  | 3.2  | 50 | 72 | 8/12,5/80      | TR-F-FA Giben Smart 189382 s                          |
|      | 350  | 4,4  | 3.2  | 50 | 72 | 8/12,5/80      | G6 Giben Smart 189387 s                               |
|      | 350  | 4,4  | 3.2  | 50 | 72 | 8/12,5/80      | WS-FA Giben Smart 189397 s                            |
|      | 350  | 4,4  | 3.2  | 50 | 72 | 8/12,5/80      | G3 Giben Smart 189392 s                               |
|      | 350  | 4,4  | 3.2  | 30 | 72 | 2/10/60        | TR-F-FA SCM, Panhans, Mayer, Schelling, Scheer 189383 |
|      | 350  | 4,4  | 3.2  | 30 | 72 | 2/10/60        | G6 SCM, Panhans, Mayer, Schelling, Scheer 189388 s    |
|      | 350  | 4,4  | 3.2  | 30 | 72 | 2/10/60        | WS-FA SCM, Panhans, Mayer, Schelling, Scheer 189398 s |
|      | 350  | 4,4  | 3.2  | 30 | 72 | 2/10/60        | G3 SCM, Panhans, Mayer, Schelling, Scheer 189393 s    |
|      | 350  | 4,25 | 3.2  | 30 | 72 | 2/10/60        | TR-F-FA Scheer 189384 s                               |
|      | 350  | 4,25 | 3.2  | 30 | 72 | 2/10/60        | G6 Scheer 189389 s                                    |
|      | 350  | 4,25 | 3.2  | 30 | 72 | 2/10/60        | WS-FA Scheer 189399 s                                 |
| [mm] | [mm] | [mm] | [mm] |    |    |                |   |

|      | B    | b    | Ø d  | Z  | NL | tooth geometry                    |         | Ident.No.                                    |          |
|------|------|------|------|----|----|-----------------------------------|---------|--|----------|
|      | 350  | 4,25 | 3.2  | 30 | 72 | 2/10/60                           | G3      | Scheer                                       | 189394 s |
|      | 355  | 4,4  | 3.2  | 80 | 72 | 4/19/120 + 2/8,4/130              | TR-F-FA | Selco EB 90                                  | 189405 s |
|      | 355  | 4,4  | 3.2  | 80 | 72 | 4/19/120 + 2/8,4/130              | G6      | Selco EB 90                                  | 189408 s |
|      | 355  | 4,4  | 3.2  | 80 | 72 | 4/19/120 + 2/8,4/130              | WS-FA   | Selco EB 90                                  | 189414 s |
|      | 355  | 4,4  | 3.2  | 80 | 72 | 4/19/120 + 2/8,4/130              | G3      | Selco EB 90                                  | 189411 s |
|      | 355  | 4,4  | 3.2  | 80 | 72 | 4/8,5/100 + 2/14/110 +<br>2/7/110 | TR-F-FA | Gabbiani PRIMA, SCM ALPHA                    | 189406 s |
|      | 355  | 4,4  | 3.2  | 80 | 72 | 4/8,5/100 + 2/14/110 +<br>2/7/110 | G6      | Gabbiani PRIMA, SCM ALPHA                    | 189409 s |
|      | 355  | 4,4  | 3.2  | 80 | 72 | 4/8,5/100 + 2/14/110 +<br>2/7/110 | WS-FA   | Gabbiani PRIMA, SCM ALPHA                    | 189415 s |
|      | 355  | 4,4  | 3.2  | 80 | 72 | 4/8,5/100 + 2/14/110 +<br>2/7/110 | G3      | Gabbiani PRIMA, SCM ALPHA                    | 189412 s |
|      | 355  | 4,4  | 3.2  | 75 | 72 | 4/15/105                          | TR-F-FA | Giben  | 189407 s |
|      | 355  | 4,4  | 3.2  | 75 | 72 | 4/15/105                          | G6      | Giben  | 189410 s |
|      | 355  | 4,4  | 3.2  | 75 | 72 | 4/15/105                          | WS-FA   | Giben  | 189416 s |
|      | 355  | 4,4  | 3.2  | 75 | 72 | 4/15/105                          | G3      | Giben  | 189413 s |
|      | 380  | 4,8  | 3.5  | 60 | 72 | 2/14/100 + 2/14/125               | TR-F-FA | Holzma                                       | 189420 s |
|      | 380  | 4,8  | 3.5  | 60 | 72 | 2/14/100 + 2/14/125               | G6      | Holzma                                       | 189421 s |
|      | 380  | 4,8  | 3.5  | 60 | 72 | 2/14/100 + 2/14/125               | WS-FA   | Holzma                                       | 189423 s |
|      | 380  | 4,8  | 3.5  | 60 | 72 | 2/14/100 + 2/14/125               | G3      | Holzma                                       | 189422 s |
|      | 400  | 4,4  | 3.2  | 80 | 72 | 2/7/110 + 4/19/120 +<br>2/8,4/130 | TR-F-FA | Selco WN / EB                                | 189425 s |
|      | 400  | 4,4  | 3.2  | 80 | 72 | 2/7/110 + 4/19/120 +<br>2/8,4/130 | G6      | Selco WN / EB                                | 189430 s |
|      | 400  | 4,4  | 3.2  | 80 | 72 | 2/7/110 + 4/19/120 +<br>2/8,4/130 | WS-FA   | Selco WN / EB                                | 189440 s |
|      | 400  | 4,4  | 3.2  | 80 | 72 | 2/7/110 + 4/19/120 +<br>2/8,4/130 | G3      | Selco WN / EB                                | 189435 s |
|      | 400  | 4,4  | 3.2  | 80 | 72 | 4/8,5/100 + 2/14/110 +<br>2/7/110 | TR-F-FA |  | 189426 s |
|      | 400  | 4,4  | 3.2  | 80 | 72 | 4/8,5/100 + 2/14/110 +<br>2/7/110 | G6      |  | 189431 s |
|      | 400  | 4,4  | 3.2  | 80 | 72 | 4/8,5/100 + 2/14/110 +<br>2/7/110 | WS-FA   |  | 189441 s |
|      | 400  | 4,4  | 3.2  | 80 | 72 | 4/8,5/100 + 2/14/110 +<br>2/7/110 | G3      |  | 189436 s |
|      | 400  | 4,4  | 3.2  | 75 | 72 | 4/15/105                          | TR-F-FA | Giben, Homag CH08+12                         | 189427 s |
|      | 400  | 4,4  | 3.2  | 75 | 72 | 4/15/105                          | G6      | Giben, Homag CH08+12                         | 189432 s |
|      | 400  | 4,4  | 3.2  | 75 | 72 | 4/15/105                          | WS-FA   | Giben, Homag CH08+12                         | 189442 s |
|      | 400  | 4,4  | 3.2  | 75 | 72 | 4/15/105                          | G3      | Giben, Homag CH08+12                         | 189437 s |
|      | 400  | 4,4  | 3.2  | 60 | 72 |                                   | TR-F-FA | Anthon                                       | 189428 s |
|      | 400  | 4,4  | 3.2  | 60 | 72 |                                   | G6      | Anthon                                       | 189433 s |
|      | 400  | 4,4  | 3.2  | 60 | 72 |                                   | WS-FA   | Anthon                                       | 189443 s |
|      | 400  | 4,4  | 3.2  | 60 | 72 |                                   | G3      | Anthon                                       | 189438 s |
|      | 400  | 4,4  | 3.2  | 30 | 72 | 2/7/42 + 2/10/60                  | TR-F-FA | Schelling, Mayer, Irion, Scheer,<br>HOLZ-HER | 189429   |
|      | 400  | 4,4  | 3.2  | 30 | 72 | 2/7/42 + 2/10/60                  | G6      | Schelling, Mayer, Irion, Scheer,<br>HOLZ-HER | 189434 s |
|      | 400  | 4,4  | 3.2  | 30 | 72 | 2/7/42 + 2/10/60                  | WS-FA   | Schelling, Mayer, Irion, Scheer,<br>HOLZ-HER | 189444 s |
|      | 400  | 4,4  | 3.2  | 30 | 72 | 2/7/42 + 2/10/60                  | G3      | Schelling, Mayer, Irion, Scheer,<br>HOLZ-HER | 189439 s |
|      | 430  | 4,4  | 3.2  | 80 | 72 | 4/19/120 + 2/8,4/130              | TR-F-FA | Selco WN                                     | 189450 s |
|      | 430  | 4,4  | 3.2  | 80 | 72 | 4/19/120 + 2/8,4/130              | G6      | Selco WN                                     | 189455 s |
|      | 430  | 4,4  | 3.2  | 80 | 72 | 4/19/120 + 8/8,4/130              | WS-FA   | Selco WN                                     | 189465 s |
|      | 430  | 4,4  | 3.2  | 80 | 72 | 4/19/120 + 2/8,4/130              | G3      | Selco WN                                     | 189460 s |
|      | 430  | 4,4  | 3.2  | 80 | 72 | 2/8,3/130                         | TR-F-FA | S.M.A., hogggers                             | 189451 s |
|      | 430  | 4,4  | 3.2  | 80 | 72 | 2/8,3/130                         | G6      | S.M.A., hogggers                             | 189456 s |
|      | 430  | 4,4  | 3.2  | 80 | 72 | 2/8,3/130                         | WS-FA   | S.M.A., hogggers                             | 189466 s |
|      | 430  | 4,4  | 3.2  | 80 | 72 | 2/8,3/130                         | G3      | S.M.A., hogggers                             | 189461 s |
|      | 430  | 4,4  | 3.2  | 75 | 72 | 4/15/105 + 2/7/110                | TR-F-FA | Giben Prismatic 2 old                        | 189452 s |
|      | 430  | 4,4  | 3.2  | 75 | 72 | 4/15/105 + 2/7/110                | G6      | Giben Prismatic 2 old                        | 189457 s |
|      | 430  | 4,4  | 3.2  | 75 | 72 | 4/15/105 + 2/7/110                | WS-FA   | Giben Prismatic 2 old                        | 189467 s |
|      | 430  | 4,4  | 3.2  | 75 | 72 | 4/15/105 + 2/7/110                | G3      | Giben Prismatic 2 old                        | 189462 s |
| [mm] | [mm] | [mm] | [mm] |    |    |                                   |         |  |          |

|      | B    | b    | Ø d  | Z  | NL                             | tooth geometry |                           | Ident-No. |
|------|------|------|------|----|--------------------------------|----------------|---------------------------|-----------|
| 430  | 4,4  | 3.2  | 60   | 72 | 1/11/85                        | TR-F-FA        | Anthon                    | 189453 s  |
| 430  | 4,4  | 3.2  | 60   | 72 | 1/11/85                        | G6             | Anthon                    | 189458 s  |
| 430  | 4,4  | 3.2  | 60   | 72 | 1/11/85                        | WS-FA          | Anthon                    | 189468 s  |
| 430  | 4,4  | 3.2  | 60   | 72 | 1/11/85                        | G3             | Anthon                    | 189463 s  |
| 430  | 4,4  | 3.2  | 30   | 72 |                                | TR-F-FA        |                           | 189454 s  |
| 430  | 4,4  | 3.2  | 30   | 72 |                                | G6             |                           | 189459 s  |
| 430  | 4,4  | 3.2  | 30   | 72 |                                | WS-FA          |                           | 189469 s  |
| 430  | 4,4  | 3.2  | 30   | 72 |                                | G3             |                           | 189464 s  |
| 450  | 4,4  | 3.2  | 80   | 72 | 2/7/110 + 2/8,3/130            | TR-F-FA        | S.M.A., Irion             | 189475 s  |
| 450  | 4,4  | 3.2  | 80   | 72 | 2/7/110 + 2/8,3/130            | G6             | S.M.A., Irion             | 189478 s  |
| 450  | 4,4  | 3.2  | 80   | 72 | 2/7/110 + 2/8,3/130            | WS-FA          | S.M.A., Irion             | 189484 s  |
| 450  | 4,4  | 3.2  | 80   | 72 | 2/7/110 + 2/8,3/130            | G3             | S.M.A., Irion             | 189481 s  |
| 450  | 4,4  | 3.2  | 80   | 72 | 4/8,5/100 + 2/14/110 + 2/7/110 | TR-F-FA        | Gabbiani ELITE            | 189476 s  |
| 450  | 4,4  | 3.2  | 80   | 72 | 4/8,5/100 + 2/14/110 + 2/7/110 | G6             | Gabbiani ELITE            | 189479 s  |
| 450  | 4,4  | 3.2  | 80   | 72 | 4/8,5/100 + 2/14/110 + 2/7/110 | WS-FA          | Gabbiani ELITE            | 189485 s  |
| 450  | 4,4  | 3.2  | 80   | 72 | 4/8,5/100 + 2/14/110 + 2/7/110 | G3             | Gabbiani ELITE            | 189482 s  |
| 450  | 4,4  | 3.2  | 30   | 72 |                                | TR-F-FA        | Irion, Schelling          | 189477    |
| 450  | 4,4  | 3.2  | 30   | 72 |                                | G6             | Irion, Schelling          | 189480 s  |
| 450  | 4,4  | 3.2  | 30   | 72 |                                | WS-FA          | Irion, Schelling          | 189486 s  |
| 450  | 4,4  | 3.2  | 30   | 72 |                                | G3             | Irion, Schelling          | 189483 s  |
| 450  | 4,8  | 3.5  | 80   | 72 | 4/19/120 + 2/8,4/130           | TR-F-FA        | Selco WN                  | 189490 s  |
| 450  | 4,8  | 3.5  | 80   | 72 | 4/19/120 + 2/8,4/130           | G6             | Selco WN                  | 189492 s  |
| 450  | 4,8  | 3.5  | 80   | 72 | 4/19/120 + 2/8,4/130           | WS-FA          | Selco WN                  | 189496 s  |
| 450  | 4,8  | 3.5  | 80   | 72 | 4/19/120 + 2/8,4/130           | G3             | Selco WN                  | 189494 s  |
| 450  | 4,8  | 3.5  | 60   | 72 | 2/14/125 + 2/19/120            | TR-F-FA        | Holzma                    | 189491    |
| 450  | 4,8  | 3.5  | 60   | 72 | 2/14/125 + 2/19/120            | G6             | Holzma                    | 189493 s  |
| 450  | 4,8  | 3.5  | 60   | 72 | 2/14/125 + 2/19/120            | WS-FA          | Holzma                    | 189497 s  |
| 450  | 4,8  | 3.5  | 60   | 72 | 2/14/125 + 2/19/120            | G3             | Holzma                    | 189495 s  |
| 460  | 4,4  | 3.2  | 30   | 72 | 2/13/94                        | TR-F-FA        | Schelling FL, FH6         | 189500 s  |
| 460  | 4,4  | 3.2  | 30   | 72 | 2/13/94                        | G6             | Schelling FL, FH6         | 189502 s  |
| 460  | 4,4  | 3.2  | 30   | 72 | 2/13/94                        | WS-FA          | Schelling FL, FH6         | 189506 s  |
| 460  | 4,4  | 3.2  | 30   | 72 | 2/13/94                        | G3             | Schelling FL, FH6         | 189504 s  |
| 460  | 4,4  | 3.2  | 75   | 72 | 4/15/105                       | TR-F-FA        | Giben Prismatic 3         | 189501 s  |
| 460  | 4,4  | 3.2  | 75   | 72 | 4/15/105                       | G6             | Giben Prismatic 3         | 189503 s  |
| 460  | 4,4  | 3.2  | 75   | 72 | 4/15/105                       | WS-FA          | Giben Prismatic 3         | 189507 s  |
| 460  | 4,4  | 3.2  | 75   | 72 | 4/15/105                       | G3             | Giben Prismatic 3         | 189505 s  |
| 480  | 4,8  | 3.5  | 80   | 72 | 4/19/120 + 2/8,4/130           | TR-F-FA        | Selco WN                  | 189510 s  |
| 480  | 4,8  | 3.5  | 80   | 72 | 4/19/120 + 2/8,4/130           | G6             | Selco WN                  | 189513 s  |
| 480  | 4,8  | 3.5  | 80   | 72 | 4/19/120 + 2/8,4/130           | WS-FA          | Selco WN                  | 189519 s  |
| 480  | 4,8  | 3.5  | 80   | 72 | 4/19/120 + 2/8,4/130           | G3             | Selco WN                  | 189516 s  |
| 480  | 4,8  | 3.5  | 60   | 72 | 2/19/120                       | TR-F-FA        | Holzma                    | 189511 s  |
| 480  | 4,8  | 3.5  | 60   | 72 | 2/19/120                       | G6             | Holzma                    | 189514 s  |
| 480  | 4,8  | 3.5  | 60   | 72 | 2/19/120                       | WS-FA          | Holzma                    | 189520 s  |
| 480  | 4,8  | 3.5  | 60   | 72 | 2/19/120                       | G3             | Holzma                    | 189517 s  |
| 480  | 4,8  | 3.5  | 30   | 72 |                                | TR-F-FA        | Schelling FL from 211,145 | 189512 s  |
| 480  | 4,8  | 3.5  | 30   | 72 |                                | G6             | Schelling FL from 211,145 | 189515 s  |
| 480  | 4,8  | 3.5  | 30   | 72 |                                | WS-FA          | Schelling FL from 211,145 | 189521 s  |
| 480  | 4,8  | 3.5  | 30   | 72 |                                | G3             | Schelling FL from 211,145 | 189518 s  |
| 500  | 4,8  | 3.5  | 60   | 72 | 2/11/115                       | TR-F-FA        | Holzma 22                 | 189569 s  |
| 500  | 4,8  | 3.5  | 60   | 72 | 2/11/115                       | G3             | Holzma 22                 | 189586 s  |
| 600  | 5,8  | 4    | 60   | 72 | 2/11/115+2/19/120              | TR-F-FA        | Holzma 42, 33             | 189570 s  |
| 600  | 5,8  | 4    | 60   | 72 | 2/11/115+2/19/120              | G3             | Holzma 42, 33             | 189587 s  |
| [mm] | [mm] | [mm] | [mm] |    |                                |                |                           |           |

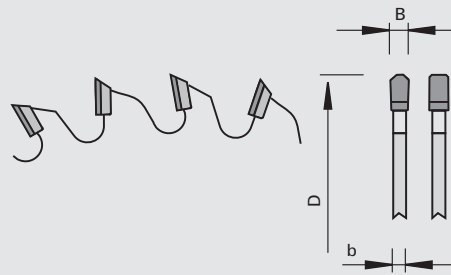
202380

### Panel Sizing Saw Blades DP „TR-F-FA“ pos.-neg.

product



drawing



**LEUCO**  
*topline*

**LEUCO**  
**DIA**

polycrystalline diamond [DP]

**Machine / Application**

- panel sizing saws
- for sizing cuts in MDF and hard materials (e.g. Cfk, Gfk,...)

**Design**

- tooth configuration: triple chip / flat with chamfer „TR-FA“
- cutting material: HW HL Board 03

**Advantages**

- optimized chip removal
- low cutting pressures
- noise-reduction thanks to laser ornaments
- improved cutting quality thanks to optimized entrance and exit angle

**Notes**

| Ø D  | B    | b    | Ø d  | Z  | NL                | Ident-No. |
|------|------|------|------|----|-------------------|-----------|
| 350  | 4,4  | 3.2  | 30   | 63 |                   | 189562 s  |
| 350  | 4,4  | 3.2  | 60   | 63 | 2/14/100          | 189563 s  |
| 380  | 4,8  | 3.5  | 60   | 70 | 2/14/100+2/14/125 | 189564 s  |
| 400  | 4,4  | 3.2  | 30   | 70 |                   | 189565 s  |
| 430  | 4,4  | 3.2  | 30   | 70 |                   | 189566 s  |
| 450  | 4,8  | 3.5  | 60   | 70 | 2/14/125+2/19/120 | 189567 s  |
| 450  | 4,4  | 3.2  | 30   | 70 |                   | 189568 s  |
| [mm] | [mm] | [mm] | [mm] |    |                   |           |



2043..

## Scoring Saw Blades DP - flexible & quick

product



drawing



polycrystalline diamond [DP]

**Machine / Application**

| Panel Sizing Saw Blades with scoring device  
| for scoring of plastic-laminated panels

**Design**




| diamond cutting edges with polished design  
| LEUCODIA tipping quality

**Advantages**

| for each application case the correct tooth form  
| short delivery times  
| interesting scaled prices

**Notes**

| application with feed

|  |   |   |
|--|---|---|
| <br><b>KO-F</b><br>Universal use in melamine and laminated panels | <br><b>KO-WS</b><br>Veneered panels, reduced motor power | <br><b>KO-HR</b><br>Perfect Cutting quality in all different panel materials |
|--|---|---|

|      | B         | b    | Ø d  | Z  | NL                    | tooth geometry |                   | Ident-No. |
|------|-----------|------|------|----|-----------------------|----------------|-------------------|-----------|
| 160  | 4,4 - 5,2 | 3.2  | 45   | 30 | 3/11/70               | KO-F           | Giben Prismatic   | 189345 s  |
| 160  | 4,4 - 5,2 | 3.2  | 45   | 30 | 3/11/70               | KO-WS          | Giben Prismatic   | 189341 s  |
| 160  | 4,4 - 5,2 | 3.2  | 45   | 30 | 3/11/70               | KO-HR          | Giben Prismatic   | 189343 s  |
| 160  | 4,4 - 5,2 | 3.2  | 55   | 30 | 3/6,5/66              | KO-F           | Gabbiani          | 189346 s  |
| 160  | 4,4 - 5,2 | 3.2  | 55   | 30 | 3/6,5/66              | KO-WS          | Gabbiani          | 189342 s  |
| 160  | 4,4 - 5,2 | 3.2  | 55   | 30 | 3/6,5/66              | KO-HR          | Gabbiani          | 189344 s  |
| 180  | 4,4 - 5,2 | 3.2  | 20   | 30 |                       | KO-F           | Schelling, Anthon | 189351 s  |
| 180  | 4,4 - 5,2 | 3.2  | 20   | 30 |                       | KO-WS          | Schelling, Anthon | 189355 s  |
| 180  | 4,4 - 5,2 | 3.2  | 20   | 30 |                       | KO-HR          | Schelling, Anthon | 189347 s  |
| 180  | 4,4 - 5,2 | 3.2  | 30   | 30 | 2/10/60               | KO-F           | Panhans           | 189352 s  |
| 180  | 4,4 - 5,2 | 3.2  | 30   | 30 | 2/10/60               | KO-WS          | Panhans           | 189356 s  |
| 180  | 4,4 - 5,2 | 3.2  | 30   | 30 | 2/10/60               | KO-HR          | Panhans           | 189348 s  |
| 180  | 4,4 - 5,2 | 3.2  | 45   | 30 |                       | KO-F           |                   | 189353    |
| 180  | 4,4 - 5,2 | 3.2  | 45   | 30 |                       | KO-WS          |                   | 189357 s  |
| 180  | 4,4 - 5,2 | 3.2  | 45   | 30 |                       | KO-HR          |                   | 189349 s  |
| 180  | 4,4 - 5,2 | 3.2  | 50   | 30 | 3/13/80               | KO-F           | Giben Smart       | 189354 s  |
| 180  | 4,4 - 5,2 | 3.2  | 50   | 30 | 3/13/80               | KO-WS          | Giben Smart       | 189358 s  |
| 180  | 4,4 - 5,2 | 3.2  | 50   | 30 | 3/13/80               | KO-HR          | Giben Smart       | 189350 s  |
| 180  | 4,8 - 5,6 | 3.5  | 45   | 30 |                       | KO-F           | Holzma            | 189360 s  |
| 180  | 4,8 - 5,6 | 3.5  | 45   | 30 |                       | KO-WS          | Holzma            | 189361 s  |
| 180  | 4,8 - 5,6 | 3.5  | 45   | 30 |                       | KO-HR          | Holzma            | 189359 s  |
| 200  | 4,4 - 5,2 | 3.2  | 30   | 30 | 2/10/60               | KO-F           | Panhans           | 189366 s  |
| 200  | 4,4 - 5,2 | 3.2  | 30   | 30 | 2/10/60               | KO-WS          | Panhans           | 189370 s  |
| 200  | 4,4 - 5,2 | 3.2  | 30   | 30 | 2/10/60               | KO-HR          | Panhans           | 189362 s  |
| 200  | 4,4 - 5,2 | 3.2  | 65   | 30 | 2/8,4/100 + 2/8,4/110 | KO-F           | Selco             | 189367    |
| 200  | 4,4 - 5,2 | 3.2  | 65   | 30 | 2/8,4/100 + 2/8,4/110 | KO-WS          | Selco             | 189371 s  |
| 200  | 4,4 - 5,2 | 3.2  | 65   | 30 | 2/8,4/100 + 2/8,4/110 | KO-HR          | Selco             | 189363 s  |
| 200  | 4,4 - 5,2 | 3.2  | 20   | 30 |                       | KO-F           |                   | 189368 s  |
| 200  | 4,4 - 5,2 | 3.2  | 20   | 30 |                       | KO-WS          |                   | 189372 s  |
| 200  | 4,4 - 5,2 | 3.2  | 20   | 30 |                       | KO-HR          |                   | 189364 s  |
| 200  | 4,4 - 5,2 | 3.2  | 50   | 30 | 3/13/80               | KO-F           | Giben Smart       | 189369 s  |
| 200  | 4,4 - 5,2 | 3.2  | 50   | 30 | 3/13/80               | KO-WS          | Giben Smart       | 189373 s  |
| 200  | 4,4 - 5,2 | 3.2  | 50   | 30 | 3/13/80               | KO-HR          | Giben Smart       | 189365 s  |
| 200  | 4,8 - 5,6 | 3.5  | 45   | 30 |                       | KO-F           | Holzma            | 189376    |
| 200  | 4,8 - 5,6 | 3.5  | 45   | 30 |                       | KO-WS          | Holzma            | 189378 s  |
| 200  | 4,8 - 5,6 | 3.5  | 45   | 30 |                       | KO-HR          | Holzma            | 189374 s  |
| [mm] | [mm]      | [mm] | [mm] |    |                       |                |                   |           |

|      | B         | b    | Ø d  | Z  | NL        | tooth geometry |       | Ident-No. |
|------|-----------|------|------|----|-----------|----------------|-------|-----------|
| 200  | 4,8 - 5,6 | 3,5  | 65   | 30 | 2/8,4/110 | KO-F           | Selco | 189377 s  |
| 200  | 4,8 - 5,6 | 3,5  | 65   | 30 | 2/8,4/110 | KO-WS          | Selco | 189379 s  |
| 200  | 4,8 - 5,6 | 3,5  | 65   | 30 | 2/8,4/110 | KO-HR          | Selco | 189375 s  |
| [mm] | [mm]      | [mm] | [mm] |    |           |                |       |           |

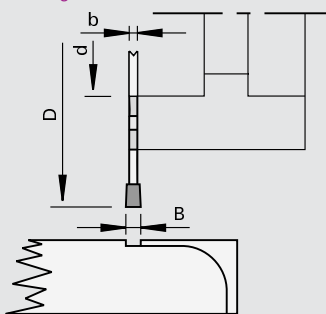
205010

## Scoring Saw Blades DP for inlay profiles „F“

product



drawing



Machine / Application

l machines Homag  
l for chip-free scoring of inlay profiles in veneered panels

Design

l resharpenable area 4.0 mm  
l n max = 24,000 min-1  
l tooth configuration: flat „F“

Advantages

Notes

l application with feed

| Ø D  | B    | b    | Ø d  | Z  | NL       | Ident-No. |
|------|------|------|------|----|----------|-----------|
| 70   | 4,0  | 3,0  | 34   | 8  | 4/5,3/42 | 168473    |
| 75   | 3,2  | 2,2  | 22   | 10 |          | 168464 s  |
| [mm] | [mm] | [mm] | [mm] |    |          |           |

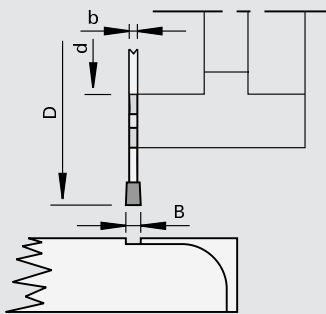
205080

## Scoring Saw Blades DP for inlay profiles „KO-F“

product



drawing



Machine / Application

l machines IMA  
l for chip-free scoring of inlay profiles in melamine-faced and plastic-laminated panels

Design

l flanks 3 degrees conical  
l resharpenable area 4.0 mm  
l n max = 24,000 min-1  
l tooth configuration: conical-flat „KO-F“

Advantages

Notes

l application with feed

| Ø D  | B    | b    | Ø d  | Z  | NL       | Ident-No. |
|------|------|------|------|----|----------|-----------|
| 70   | 4,0  | 3,0  | 34   | 8  | 4/5,3/42 | 181145    |
| 75   | 3,2  | 2,2  | 22   | 10 |          | 181146 s  |
| [mm] | [mm] | [mm] | [mm] |    |          |           |

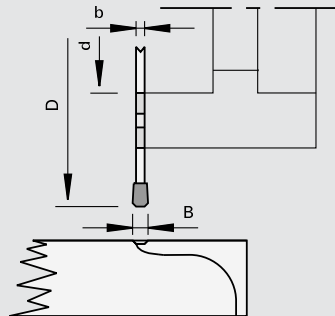
205080

### Scoring Saw Blades DP for inlay profiles „F-FA“

product



drawing



polycrystalline diamond [DP]

Machine / Application

l machines Homag  
l for chip-free scoring of softforming profiles

Design

l n max = 24,000 min-1  
l resharpenable area 3.0 mm  
l tooth configuration: flat with two-sided chamfer 1.5 x 45 degrees „F-FA“

Advantages

Notes

l for Homag flange  
l application with feed

| Ø D  | B    | b    | Ø d  | Z | NL       | Ident-No. |
|------|------|------|------|---|----------|-----------|
| 70   | 4,3  | 3.0  | 34   | 8 | 4/5,3/42 | 168474 s  |
| [mm] | [mm] | [mm] | [mm] |   |          |           |

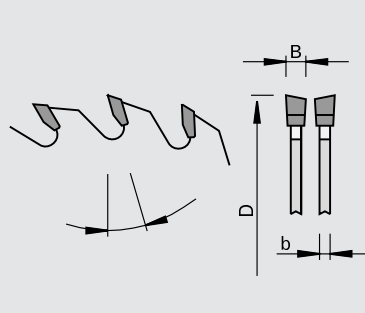
105320

### Scoring Saw Blades HW „WS“

product



drawing



tungsten carbide [HW]

Machine / Application

l panel sizing saws with controllable scoring device  
l for scoring of plastic-laminated postforming panels

Design

l tooth configuration: alternate top bevel „WS“  
l cutting material: HW HL Board 06

Advantages

Notes

l cutting width consistently .2 mm wider than the main saw kerf

| Ø D  | B    | b    | Ø d  | Z   | NL      | corner | Ident-No.              |
|------|------|------|------|-----|---------|--------|------------------------|
| 250  | 4,55 | 3.5  | 30   | 48  | 2/10/60 | 15     | HOLZ-HER Cut 85        |
| 250  | 4,55 | 3.5  | 45   | 48  |         | 15     | Holzma HVP 120         |
| 280  | 4,55 | 3.5  | 45   | 84  |         | 30     | Holzma HPP 230+Hpp 250 |
| 280  | 5,0  | 3.5  | 45   | 84  |         | 30     | Holzma type 350/380    |
| 340  | 5,0  | 3.5  | 45   | 48  |         | 20     | Holzma                 |
| 340  | 5,0  | 3.5  | 45   | 108 |         | 20     | Holzma                 |
| [mm] | [mm] | [mm] | [mm] |     |         | [°]    |                        |

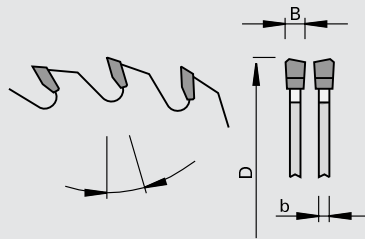
105320

## Scoring Saw Blades HW „WS-FA“

product



drawing

LEUCO  
toplineLEUCO  
DUR

tungsten carbide [HW]

Machine / Application

- panel sizing saws with controllable scoring device
- for scoring of plastic-laminated postforming panels

Design

- tooth configuration: alternate top bevel with chamfer „WS-FA“
- cutting material: HW HL Board 06

Advantages

Notes

- cutting width consistently .2 mm wider than the main saw kerf

| Ø D  | B    | b    | Ø d  | Z  | NL                     | corner | Ident-No. |
|------|------|------|------|----|------------------------|--------|-----------|
| 300  | 4,6  | 3,2  | 65   | 72 | 2/8,4/110 +<br>2/9/100 | 5      | Selco     |
| [mm] | [mm] | [mm] | [mm] |    |                        | [°]    |           |

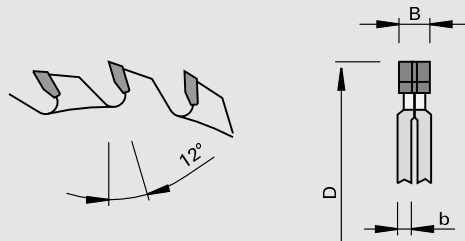
105318

## Scoring Saw Blades HW - adjustable „F“

product



drawing

LEUCO  
toplineLEUCO  
DUR

tungsten carbide [HW]

Machine / Application

- table saws
- panel sizing saws
- panel sizing saws with controllable scoring device
- for scoring of plastic-laminated panels

Design

- tooth configuration: flat „F“
- cutting material: HW HL Board 03

Advantages

- universally applicable

Notes

- split version - cutting width adjustable with spacers
- for main/scoring saw combinations see specifications (Technical Appendix)
- X = Original Striebig Scoring Saw Blades, cutting width adjustable by means of attachment screws

| Ø D  | B         | b    | Ø d  | Z    | NL       | hook angle | Ident-No.                |
|------|-----------|------|------|------|----------|------------|--------------------------|
| 80   | 2,6 - 3,6 | 2,2  | 20   | 2x10 | 2/4/34   | 10         | Striebig X 9201253       |
| 80   | 2,8 - 3,6 | 2,2  | 20   | 2x10 | 2/3,8/42 | 12         | Striebig 189707          |
| 120  | 2,8 - 3,8 | 2,2  | 20   | 2x12 | 2/3,8/42 | 12         | SCM 189307               |
| 120  | 2,8 - 3,8 | 2,2  | 22   | 2x12 | 2/3,8/42 | 12         | Altendorf, Martin 189310 |
| 125  | 2,8 - 3,8 | 2,2  | 20   | 2x12 | 2/3,8/42 | 12         | HOLZ-HER, SCM 189708     |
| [mm] | [mm]      | [mm] | [mm] |      |          | [°]        |                          |

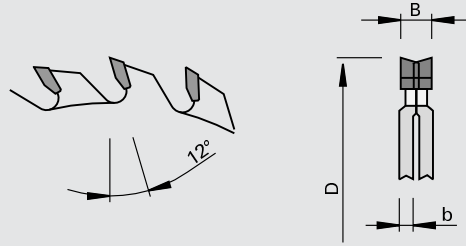
105325

## Scoring Saw Blades HW - adjustable „ES“

product



drawing



LEUCO  
topline

LEUCO  
DUR

tungsten carbide [HW]

**Machine / Application**

- | table saws
- | panel sizing saws
- | panel sizing saws with controllable scoring device
- | for scoring of plastic-laminated panels

**Design**

- | tooth configuration: top bevel „ES“
- | cutting material: HW HL Board 06

**Advantages**

- | low motor output thanks to tooth configuration „ES“

**Notes**

- | split version - cutting width adjustable with spacers
- | for main/scoring saw combinations see specifications (appendix)

| Ø D  | B         | b    | Ø d  | Z    | NL                                   | hook angle |                                      | Ident-No. |
|------|-----------|------|------|------|--------------------------------------|------------|--------------------------------------|-----------|
| 100  | 2,8 - 3,6 | 2,2  | 20   | 2x10 |                                      | 12         | Schelling                            | 188525 \$ |
| 100  | 2,8 - 3,6 | 2,2  | 22   | 2x10 |                                      | 12         | Altendorf, Martin, Panhans, Striebig | 169892    |
| 120  | 2,8 - 3,8 | 2,2  | 20   | 2x12 |                                      | 12         | SCM                                  | 188528 \$ |
| 120  | 2,8 - 3,8 | 2,2  | 22   | 2x12 | 2/3,1/42                             | 12         | Altendorf, Martin                    | 169883 \$ |
| 120  | 2,8 - 3,8 | 2,2  | 22   | 2x12 | 2/3,8/42 +<br>4/4,6/55 +<br>4/4,6/39 | 12         | Martin<br>NC-adjustment              | 181678    |
| 120  | 2,8 - 3,8 | 2,2  | 50   | 2x12 | 4/6,2/62                             | 12         | Altendorf adjustment unit Rapido     | 188398 \$ |
| 125  | 4,0 - 4,8 | 1,6  | 45   | 2x20 |                                      | 12         | Giben, Mayer                         | 188531    |
| 180  | 3,0 - 3,8 | 2,2  | 30   | 2x18 |                                      | 8          | Koelle                               | 188543    |
| 160  | 2,8 - 3,8 | 2,2  | 30   | 2x16 |                                      | 8          | Bäuerle                              | 188539    |
| 300  | 4,2 - 4,7 | 1,8  | 50   | 2x32 | 3/15/80                              | 12         | Giben Prismatic + Starmatic          | 188561    |
| 340  | 4,4 - 5,6 | 2,5  | 45   | 2x24 |                                      | 15         | Holzma                               | 188562    |
| [mm] | [mm]      | [mm] | [mm] |      |                                      | [°]        |                                      |           |

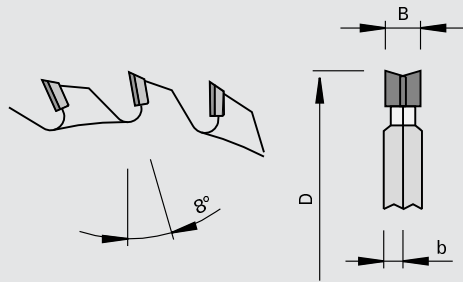
205088

## Scoring Saw Blades DP - adjustable „ES“

product



drawing

LEUCO  
DIA

polycrystalline diamond [DP]

## Machine / Application

table saws  
for chip-free scoring of  
melamine-, paper- or HPL-  
laminated panels

## Design

tooth configuration: top bevel  
„ES“

## Advantages

## Notes

application with feed  
split version - cutting width  
adjustable with spacers  
Ident-No. 189104 automatic  
kerf adjustment  
X = for Striebig „Compact“,  
„Evolution“, „Control“,  
adjustable by means of spring  
ring and attachment screw

| Ø D  | B         | b    | Ø d  | Z    | NL                |                           | Ident-No. |
|------|-----------|------|------|------|-------------------|---------------------------|-----------|
| 80   | 2,6 - 3,6 | 2.2  | 20   | 2x6  | 2/4/34            | Striebig                  | X 9201163 |
| 120  | 2,8 - 3,8 | 2.2  | 22   | 2x12 | 2/3,8/42          | Altendorf, Martin         | 189101    |
| 120  | 2,8 - 3,6 | 2.0  | 50   | 2x12 | 3/5,5/63 + 3/9/63 | for LEUCO adjustment unit | 189652 s  |
| 120  | 2,8 - 3,8 | 2.2  | 50   | 2x12 | 4/6,2/62          | Altendorf adjustment unit | 189104    |
| [mm] | [mm]      | [mm] | [mm] |      |                   |                           |           |

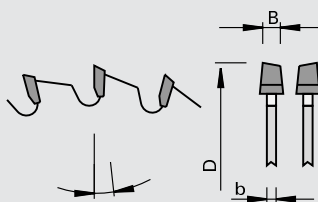
105390

## Scoring Saw Blades HW „KO-WS“

product



drawing



LEUCO  
topline

LEUCO  
DUR

tungsten carbide [HW]

**Machine / Application**

- panel sizing saws with scoring device
- for scoring of plastic-laminated panels

**Design**

- tooth configuration: conical / alternate top bevel „KO-WS“
- cutting material: HW HL Board 06

**Advantages**

- low motor output thanks to tooth configuration „KO-WS“

**Notes**

- height adjustable to kerf of main saw blade
- 1 mm scoring depth = .17 mm wider than main saw kerf
- optimum scoring depth 1.5 - 2.5 mm
- for main/scoring saw combinations see specifications (appendix)

| Ø D  | B         | b    | Ø d  | Z  | NL                       | hook angle | Ident-No.                   |           |
|------|-----------|------|------|----|--------------------------|------------|-----------------------------|-----------|
| 100  | 3,2 - 4,0 | 2.2  | 20   | 20 |                          | 8          | Schelling                   | 188527    |
| 120  | 3,1 - 3,9 | 2.2  | 20   | 24 |                          | 8          | Lasari                      | 189591    |
| 120  | 3,1 - 3,9 | 2.2  | 22   | 24 |                          | 8          | Altendorf                   | 189590    |
| 125  | 4,4 - 5,2 | 3.2  | 20   | 20 |                          | 0          | Panhans                     | 188532    |
| 125  | 4,4 - 5,2 | 3.2  | 22   | 20 |                          | 0          | Martin                      | 188533    |
| 125  | 4,4 - 5,2 | 3.2  | 45   | 20 |                          | 0          | Giben, Homag CH03           | 188534    |
| 125  | 3,0 - 3,8 | 2.2  | 20   | 24 |                          | 8          |                             | 181994    |
| 125  | 3,2 - 4,0 | 2.8  | 20   | 24 |                          | 8          | SCM, SICAR, Panhans         | 188576    |
| 125  | 4,4 - 5,2 | 3.2  | 45   | 24 |                          | 8          | Homag Espana                | 188888    |
| 150  | 4,4 - 5,2 | 3.2  | 30   | 24 |                          | 8          | Irion, Mayer                | 188538    |
| 150  | 4,4 - 5,2 | 3.2  | 45   | 24 |                          | 8          | Homag CH06,08,10,12         | 188630    |
| 150  | 4,4 - 5,2 | 3.2  | 45   | 28 |                          | 8          | Homag Espana                | 188885    |
| 160  | 4,4 - 5,2 | 3.2  | 45   | 28 | 3/11/70                  | 8          | Giben Prismatic             | 188540    |
| 160  | 4,4 - 5,2 | 3.2  | 55   | 36 | 3/6,5/66                 | 8          | Gabbiani                    | 188541    |
| 180  | 4,4 - 5,2 | 3.2  | 20   | 30 |                          | 8          | Schelling, Anthon           | 188545    |
| 180  | 5,8 - 6,6 | 4.0  | 20   | 30 |                          | 8          | Anthon                      | 188548    |
| 180  | 4,4 - 5,2 | 3.2  | 30   | 30 | 2/10/60                  | 8          | Panhans                     | 188546    |
| 180  | 5,2 - 6,0 | 3.5  | 55   | 30 |                          | 0          | Giben                       | 188547    |
| 180  | 4,4 - 5,2 | 3.2  | 45   | 36 |                          | 8          | Holzma                      | 188954 \$ |
| 180  | 4,8 - 5,6 | 3.5  | 45   | 36 |                          | 8          | Holzma type 11              | 188550 \$ |
| 180  | 4,4 - 5,3 | 3.2  | 50   | 44 | 3/13/80                  | 10         | Giben Smart                 | 189086    |
| 200  | 4,3 - 5,1 | 6.0  | 20   | 24 |                          | 8          | Schelling                   | 188552    |
| 200  | 5,0 - 5,8 | 3.5  | 20   | 34 |                          | 8          | Schelling                   | 188557    |
| 200  | 4,8 - 5,6 | 3.5  | 20   | 34 |                          | 8          | Schelling FH 8              | 189527 \$ |
| 200  | 4,4 - 5,2 | 3.5  | 20   | 36 |                          | 8          | Schelling                   | 188597 \$ |
| 200  | 4,4 - 5,2 | 3.2  | 30   | 36 | 2/10/60                  | 8          | S.M.A., Panhans, Scheer     | 188554    |
| 200  | 4,8 - 5,6 | 3.5  | 45   | 36 |                          | 8          | Holzma                      | 188555 \$ |
| 200  | 5,8 - 6,6 | 3.5  | 45   | 36 |                          | 8          | Holzma                      | 188556    |
| 200  | 4,4 - 5,2 | 3.2  | 65   | 36 | 2/9/100 +<br>2/9/110     | 8          | Selco                       | 188553 \$ |
| 200  | 4,8 - 5,6 | 3.5  | 65   | 36 | 2/9/110                  | 8          | Selco WN / EB               | 188618    |
| 200  | 4,4 - 5,2 | 3.2  | 50   | 42 | 3/13/80                  | 8          | Giben Smart                 | 188913    |
| 215  | 4,4 - 5,2 | 3.2  | 50   | 42 | 3/15/80 +<br>2/7/80      | 8          | Giben Prismatic + Starmatic | 188559    |
| 280  | 4,8 - 5,6 | 3.5  | 45   | 72 |                          | 8          | Holzma                      | 189541    |
| 300  | 4,4 - 5,4 | 3.2  | 30   | 48 |                          | 8          | Schelling FX-H 430          | 189087    |
| 300  | 4,4 - 5,2 | 3.2  | 50   | 48 | 3/15/80                  | 8          | Giben Prismatic             | 188560    |
| 300  | 4,4 - 5,2 | 3.2  | 65   | 48 | 2/8,4/100 +<br>2/8,4/110 | 8          | Selco EB                    | 188612    |
| [mm] | [mm]      | [mm] | [mm] |    |                          | [°]        |                             |           |

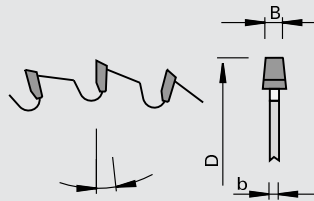
105390

## Scoring Saw Blades HW „KO-F“

product



drawing

LEUCO  
topLineLEUCO  
DUR

tungsten carbide [HW]

## Machine / Application

- panel sizing saws with scoring device
- for scoring of plastic-laminated panels

## Design

- tooth configuration: conical-flat „KO-F“
- cutting material: HW HL Board 06

## Advantages

- quick adjustment
- universally applicable

## Notes

- height adjustable to kerf of main saw blade
- 1 mm scoring depth = .17 mm wider than main saw kerf
- optimum scoring depth 1.5 - 2.5 mm
- for main/scoring saw combinations see specifications (appendix)

| Ø D  | B         | b    | Ø d  | Z  | NL                   | hook angle |                       | Ident-No. |
|------|-----------|------|------|----|----------------------|------------|-----------------------|-----------|
| 180  | 6,7 - 7,5 | 4.4  | 20   | 30 |                      | 8          | Anthon                | 189235    |
| 180  | 4,4 - 5,2 | 3.2  | 45   | 36 |                      | 8          | Holzma                | 189268    |
| 180  | 4,8 - 5,6 | 3.5  | 45   | 36 |                      | 8          | Holzma type 11        | 189264    |
| 125  | 3,1 - 4,3 | 2.2  | 20   | 24 |                      | 8          | SCM, SICAR, Panhans   | 189304    |
| 200  | 6,7 - 7,5 | 4.5  | 20   | 34 |                      | 8          | Schelling             | 189236    |
| 200  | 4,4 - 5,2 | 3.5  | 20   | 36 |                      | 8          | Schelling             | 189267    |
| 200  | 4,5 - 5,5 | 3.0  | 45   | 36 |                      | 8          | Homag Sawtech         | 189050    |
| 200  | 4,8 - 5,6 | 3.5  | 45   | 36 |                      | 8          | Holzma                | 189266    |
| 200  | 4,4 - 5,2 | 3.2  | 65   | 36 | 2/9/100 +<br>2/9/110 | 8          | Selco                 | 189265    |
| 200  | 3,2 - 4,1 | 2.2  | 30   | 60 |                      | 15         | Scheer                | 188875    |
| 220  | 6,7 - 7,5 | 4.4  | 20   | 36 |                      | 8          | Schelling FS-H / AS-H | 189237    |
| 250  | 4,4 - 5,2 | 3.5  | 30   | 42 | 2/10/60              | 8          | Panhans, HOLZ-HER     | 189646    |
| [mm] | [mm]      | [mm] | [mm] |    |                      | [°]        |                       |           |



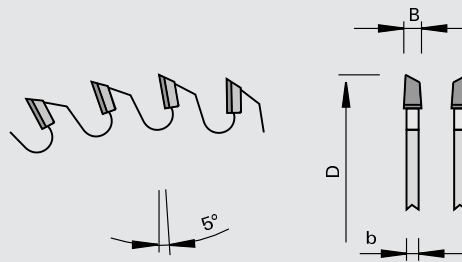
205091

### Scoring Saw Blades DP „KO-WS“

product



drawing



LEUCO  
DIA

polycrystalline diamond [DP]

Machine / Application

l table saws  
l for chip-free scoring of melamine-, paper- or HPL-laminated panels

Design

l tooth configuration: conical / alternate top bevel „KO-WS“

Advantages

Notes

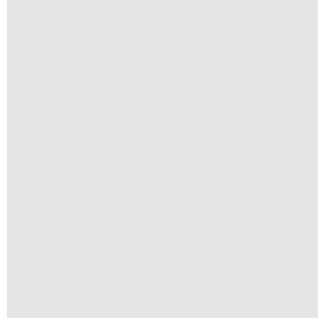
l application with feed  
l kerf „B“ = kerf of the main saw blade

| Ø D  | B         | b    | Ø d  | Z  |                   | Ident-No. |
|------|-----------|------|------|----|-------------------|-----------|
| 120  | 3,1 - 3,9 | 2.2  | 22   | 16 | Altendorf, Martin | 178766    |
| [mm] | [mm]      | [mm] | [mm] |    |                   |           |

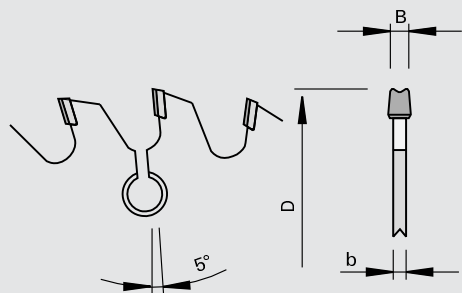
205082

### Scoring Saw Blades Holzma DP „HR-FA“

product



drawing



LEUCO  
topline

LEUCO  
DIA

polycrystalline diamond [DP]

Machine / Application

l panel sizing saws  
l table saws  
l for chip-free scoring of melamine-, paper- or HPL-laminated panels

Design

l tooth geometry: hollow back with chamfer „HR-FA“

Advantages

l long edge lives  
l excellent cutting quality

Notes

l application with feed

| Ø D  | B       | b    | Ø d  | Z  | NL                                | Ident-No. |
|------|---------|------|------|----|-----------------------------------|-----------|
| 180  | 4,8-5,6 | 3.5  | 45   | 36 | Holzma                            | 182283    |
| 180  | 4,4-5,2 | 3.2  | 45   | 36 | Holzma                            | 189234 s  |
| 200  | 4,4-5,2 | 3.2  | 20   | 36 | Schelling                         | 189232 s  |
| 200  | 4,8-5,6 | 3.5  | 45   | 36 | Holzma                            | 189231 s  |
| 200  | 4,4-5,2 | 3.2  | 65   | 36 | 2/8,4/100 +<br>2/8,4/110<br>Selco | 189230 s  |
| 200  | 4,8-5,6 | 3.5  | 65   | 36 | 2/8,4/110<br>Selco WN/EB          | 189233 s  |
| [mm] | [mm]    | [mm] | [mm] |    |                                   |           |

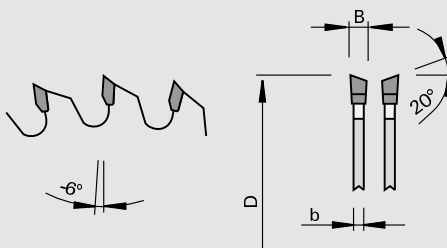
101322

### Chop Saw Blades HW „WS“

product



drawing



LEUCO  
topLine

LEUCO  
DUR

tungsten carbide [HW]

Notes

Machine / Application

- chop and cross-cutting saws
- for cross cuts in solid woods

Design

- negative hook angle
- tooth configuration: alternate top bevel „WS“
- cutting material: HW HL Solid 15

Advantages

| Ø D  | B    | b    | Ø d  | Z  | Ident-No. |
|------|------|------|------|----|-----------|
| 450  | 4,4  | 3,2  | 30   | 54 | 188045    |
| 500  | 4,4  | 3,2  | 30   | 60 | 188046    |
| [mm] | [mm] | [mm] | [mm] |    |           |

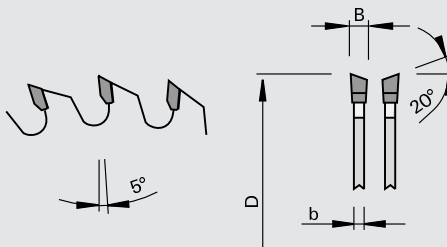
101320

### Chop Saw Blades HW for wood optimization „WS“

product



drawing



LEUCO  
topLine

LEUCO  
DUR

tungsten carbide [HW]

Notes

Machine / Application

- optimizing chop saws
- for cross cuts in solid woods

Design

- positive hook angle
- tooth configuration: alternate top bevel „WS“
- cutting material: HW HL Solid 15

Advantages

| Ø D  | B    | b    | Ø d  | Z   | NL         | Ident-No.       |
|------|------|------|------|-----|------------|-----------------|
| 400  | 4,6  | 3,5  | 30   | 120 | 2/10/60    | DIMTER 188666   |
| 450  | 4,6  | 3,5  | 30   | 132 | 2/15/63    | DIMTER 188667   |
| 500  | 4,6  | 3,5  | 30   | 144 | 2/15/63    | DIMTER 188670   |
| 550  | 4,6  | 3,5  | 120  | 156 | 6/10,2/240 | Paul 188671 #   |
| 600  | 5,2  | 3,8  | 30   | 172 | 2/15/63    | DIMTER 189263 # |
| [mm] | [mm] | [mm] | [mm] |     |            |                 |

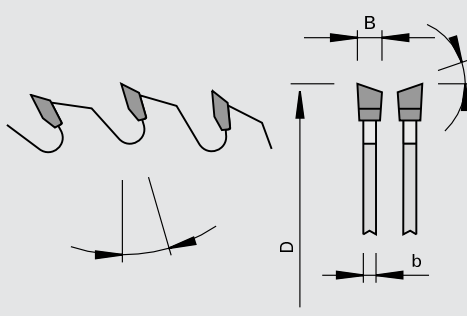
106320

### Clipping Saw Blades HW for edge trimming „WS“ - without countersink

product



drawing



**LEUCO**  
topline

**LEUCO**  
DUR

tungsten carbide [HW]

Machine / Application

- | edge banders
- | edge trimming machines
- | for trimming of plastic-, veneer- and solid wood edges

Design

- | positive or negative hook angle
- | with or without shear angle
- | tooth configuration: alternate top bevel „WS“
- | cutting material: HW HL Board 06

Advantages

Notes

| Ø D  | B    | b    | Ø d  | Z  | NL                     | hook angle | corner | shear |                  | Ident-No. |
|------|------|------|------|----|------------------------|------------|--------|-------|------------------|-----------|
| 90   | 3,0  | 2,0  | 30   | 20 |                        | 8          | 10     | 0     | Reich            | 188955    |
| 100  | 2,4  | 1,6  | 22   | 12 |                        | 15         | 10     | 5     | HOLZ-HER         | 188008    |
| 100  | 2,4  | 1,6  | 22   | 20 | 2/4/30                 | -8         | 10     | 5     | EBM              | 188181    |
| 100  | 3,6  | 2,2  | 32   | 20 |                        | 8          | 30     | 5     | Wilmsmeyer       | 169986    |
| 100  | 2,6  | 1,6  | 32   | 30 |                        | 10         | 15     | 5     | Brandt           | 188009    |
| 110  | 3,2  | 2,2  | 40   | 30 | 4/6/52                 | 10         | 45     | 0     | Homag BAZ        | 188663    |
| 110  | 3,6  | 2,5  | 22   | 20 |                        | 8          | 30     | 5     | Reich            | 169987    |
| 110  | 3,6  | 2,5  | 32   | 20 |                        | 8          | 30     | 5     | Homag            | 169988    |
| 115  | 3,2  | 2,2  | 30   | 30 | 3/7,1/68 +<br>3/7,1/68 | 15         | 15     | 0     | Biesse Akron 400 | 189632 s  |
| 120  | 3,2  | 2,2  | 32   | 20 |                        | 10         | 10     | 5     | Homag            | 188000    |
| 120  | 3,2  | 2,5  | 40   | 36 | 8/5,5/52               | 10         | 45     | 5     | Homag            | 188590    |
| 120  | 3,6  | 2,8  | 40   | 24 | 8/6/52                 | 8          | 30     | 0     | Homag            | 188633    |
| 120  | 3,6  | 2,8  | 40   | 36 | 8/6/52                 | 12         | 20     | 0     | Homag            | 189220    |
| 125  | 2,4  | 1,6  | 30   | 36 | 8/6,5/48               | 10         | 30     | 0     | Homag BAZ        | 188927    |
| 140  | 3,2  | 2,2  | 16   | 36 |                        | 10         | 15     | 5     | Ott              | 189326    |
| 140  | 3,2  | 2,2  | 22   | 36 |                        | 10         | 15     | 5     | HOLZ-HER         | 188880    |
| 150  | 3,2  | 2,2  | 22   | 48 |                        | 10         | 10     | 5     | IMA              | 188002    |
| 150  | 3,2  | 2,2  | 30   | 48 | 4/6/48 +<br>4/5,5/52   | 10         | 15     | 0     | Homag BAZ        | 188682    |
| 160  | 3,2  | 2,2  | 20   | 48 | 2/5/32                 | 10         | 10     | 5     | HOLZ-HER         | 188006    |
| 160  | 3,5  | 2,5  | 22   | 36 |                        | -5         | 15     | 5     | IMA              | 188662    |
| 160  | 3,2  | 2,2  | 22   | 48 |                        | -8         | 10     | 5     | IMA              | 188007    |
| 160  | 3,2  | 2,2  | 30   | 24 | 2/7/42                 | 15         | 10     | 5     | HOLZ-HER         | 188005    |
| 160  | 3,2  | 2,2  | 40   | 30 | 4/5,5/52               | -8         | 20     | 10    | HOLZ-HER         | 189628    |
| 170  | 3,2  | 2,2  | 30   | 36 | 4/5,5/52               | 10         | 20     | 0     | Homag            | 189063    |
| 200  | 3,2  | 2,2  | 30   | 64 | 4/6,6/60 +<br>2/6,2/42 | 10         | 15     | 0     | IMA              | 188626    |
| [mm] | [mm] | [mm] | [mm] |    |                        | [°]        | [°]    | [°]   |                  |           |

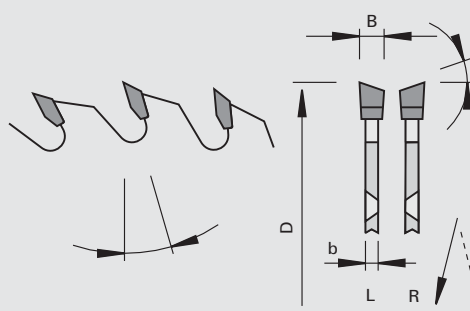
106320

## Clipping Saw Blades HW for edge trimming „WS“ - with countersink

product



drawing

LEUCO  
topLineLEUCO  
DUR

tungsten carbide [HW]

## Machine / Application

edge trimming machines  
for trimming of plastic-, veneer-  
and solid wood edges

## Design

positive hook angle  
with or without shear angle  
pin holes with countersink  
tooth configuration: alternate  
top bevel „WS“  
cutting material: HW HL Board  
06

## Advantages

## Notes

sense of rotation according to  
DIN-EN 50144

| Ø D  | B    | b    | Ø d  | Z  | NL                  | hook<br>angle | corner∟ | shear∟ |                         | Ident-No. [L] | Ident-No. [R] |
|------|------|------|------|----|---------------------|---------------|---------|--------|-------------------------|---------------|---------------|
| 110  | 3,2  | 2,5  | 40   | 20 | 4/5,5/52            | 10            | 45      | 5      | Homag                   | 188290        | 188289        |
| 140  | 3,2  | 2,2  | 30   | 36 | 4/8,6/46            | 10            | 15      | 5      | Biesse Akron 600/800    | 189549 &      | 189548 &      |
| 180  | 3,2  | 2,2  | 30   | 54 | 4/6/52              | 10            | 30      | 5      | Homag BAZ               | 188291        |               |
| 240  | 3,5  | 2,2  | 30   | 54 | 8/6,1/52            | 10            | 20      | 0      | Homag BAZ               | 189253        |               |
| 240  | 3,5  | 2,2  | 40   | 54 | 8/6,1/52            | 10            | 20      | 0      | Homag BAZ Flex 5, Weeke | 189254        |               |
| 350  | 3,6  | 2,5  | 30   | 16 | 2/10/60 +<br>8/6/90 | 20            | 10      | 0      | Homag BAZ               | 189259        |               |
| [mm] | [mm] | [mm] | [mm] |    |                     | [°]           | [°]     | [°]    |                         |               |               |

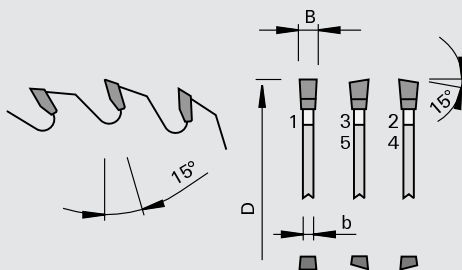
106380

### NF Chop Saw Blades HW „G5“

product



drawing



LEUCO  
topline

LEUCO  
DUR

tungsten carbide [HW]

**Machine / Application**

l CNC machining centers and aggregates  
l for chip-free sizing cuts as well as clipping and mitre cuts in wood-based panels, solid woods and plastics

**Design**

l tooth configuration: G5  
l cutting material: HW HL Board 03

**Advantages**

l excellent cutting quality for cross cuts  
l excellent cutting quality thanks to special tooth geometry  
l extremely long edge lives  
l noise reduction thanks to laser ornaments

**Notes**

l pay attention to nmax!!!

| Ø D  | B    | b    | Ø d  | Z  | NL                  |              | Ident-No. |
|------|------|------|------|----|---------------------|--------------|-----------|
| 180  | 3,0  | 2.2  | 30   | 60 | 4/6/52              | Homag, Weeke | 189323    |
| 200  | 3,0  | 2.2  | 30   | 65 | 4/6/52              | Homag        | 189316 &  |
| 200  | 3,0  | 2.2  | 30   | 65 | 2/6,2/42 + 4/6,6/60 | IMA          | 189317 &  |
| 220  | 3,0  | 2.2  | 40   | 70 | 8/6/52              | Homag, Weeke | 189573 &  |
| 240  | 3,0  | 2.2  | 30   | 75 | 8/6/52              | Homag        | 189318 &  |
| 240  | 3,0  | 2.2  | 40   | 75 | 8/6/52              | Homag, Weeke | 189319 &  |
| 240  | 3,0  | 2.2  | 30   | 75 | 2/6,2/42 + 4/6,6/60 | IMA          | 189320 &  |
| 280  | 3,0  | 2.2  | 30   | 85 | 8/5,5/52            | Homag        | 189321 &  |
| [mm] | [mm] | [mm] | [mm] |    |                     |              |           |

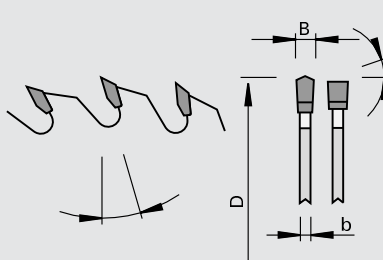
106370

### Clipping Saw Blades HW for edge trimming „DA-F“

product



drawing



LEUCO  
topline

LEUCO  
DUR

tungsten carbide [HW]

**Machine / Application**

l edge banders  
l edge trimming machines  
l for trimming of plastic-, veneer- and solid wood edges

**Design**

l without shear angle  
l positive hook angle  
l tooth configuration: inverted v-flat „DA-F“  
l cutting material: HW HL Board 06

**Advantages**

**Notes**

| Ø D  | B    | b    | Ø d  | Z  | NL     | hook angle | corner |           | Ident-No. |
|------|------|------|------|----|--------|------------|--------|-----------|-----------|
| 110  | 1,7  | 1.2  | 40   | 30 | 4/6/52 | 10         | 45     | Homag BAZ | 188858    |
| [mm] | [mm] | [mm] | [mm] |    |        | [°]        | [°]    |           |           |

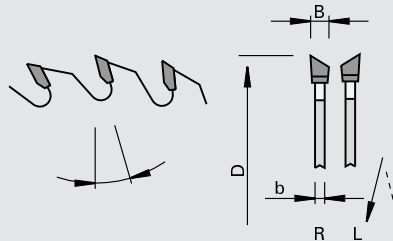
106350

### Clipping Saw Blades HW for edge trimming „ES“ - without countersink

product



drawing



LEUCO  
topLine

LEUCO  
DUR

tungsten carbide [HW]

Notes

| sense of rotation see drawing

Machine / Application

| edge banders  
| edge trimming machines  
| for trimming of thin plastic-, veneer- and solid wood edges

Design

| positive or negative hook angle  
| with and without shear angle  
| tooth configuration: top bevel „ES (right + left)”  
| cutting material: HW HL Board 06

Advantages

| Ø D  | B    | b    | Ø d  | Z  | NL       | hook angle | corner∟ | shear∟ |                 | Ident-No. [L] | Ident-No. [R] |
|------|------|------|------|----|----------|------------|---------|--------|-----------------|---------------|---------------|
| 100  | 3,2  | 2.2  | 32   | 20 |          | -6         | 30      | 5      | Homag           | 169991        | 169992        |
| 100  | 3,0  | 2.2  | 32   | 20 |          | 8          | 30      | 5      | Wilmsmeyer      | 169981        | 169984        |
| 100  | 2,6  | 2.0  | 32   | 30 |          | -10        | 15      | 0      | Brandt          | 181617        | 181616        |
| 100  | 2,6  | 1.6  | 32   | 30 |          | 10         | 10      | 0      | Brandt          | 188593        | 188594        |
| 150  | 3,5  | 2.2  | 30   | 44 | 4/5,5/52 | -12        | 45      | 10     | Homag Powerline | 188855        | 188854        |
| 160  | 3,6  | 2.5  | 40   | 18 |          | 8          | 30      | 0      | HOLZ-HER        | 189041        | 189042        |
| 170  | 3,5  | 2.2  | 30   | 48 | 4/5,5/52 | -12        | 45      | 10     | Homag Powerline | 181584        | 181583        |
| [mm] | [mm] | [mm] | [mm] |    |          | [°]        | [°]     | [°]    |                 |               |               |

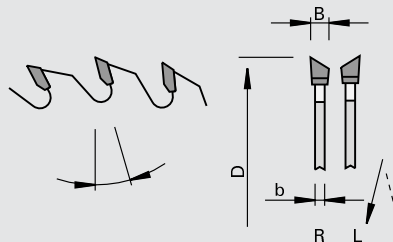
106350

### Clipping Saw Blades HW for edge trimming „ES“ - with countersink

product



drawing



LEUCO  
topLine

LEUCO  
DUR

tungsten carbide [HW]

Notes

| sense of rotation see drawing

Machine / Application

| edge banders  
| edge trimming machines  
| for trimming of thin plastic-, veneer- and solid wood edges

Design

| positive or negative hook angle  
| with and without shear angle  
| pin holes with countersink  
| tooth configuration: top bevel „ES (right + left)”  
| cutting material: HW HL Board 06

Advantages

| Ø D  | B    | b    | Ø d  | Z    | NL       | hook angle | corner∟ | shear∟ |             | Ident-No. [L] | Ident-No. [R] |
|------|------|------|------|------|----------|------------|---------|--------|-------------|---------------|---------------|
| 110  | 3,2  | 2.5  | 40   | 20   | 4/6/52   | -6         | 45      | 5      | Homag       | 188277        | 188278        |
| 120  | 3,2  | 2.5  | 40   | 20   | 4/6/52   | -6         | 45      | 5      | Homag       | 188010        | 188011        |
| 130  | 3,6  | 2.8  | 30   | 20+4 | 4/7,4/46 | 10         | 30      | 0      | Biesse      | 189545 s      | 189544 s      |
| 140  | 3,6  | 2.8  | 30   | 20+4 | 4/7,4/46 | -20        | 30      | 0      | Biesse      | 189547 s      | 189546 s      |
| 150  | 3,8  | 2.5  | 35   | 24+6 | 4/6/50   | 10         | 15      | 0      | SCM-Stefani | 189328 #      | 189327 #      |
| [mm] | [mm] | [mm] | [mm] |      |          | [°]        | [°]     | [°]    |             |               |               |

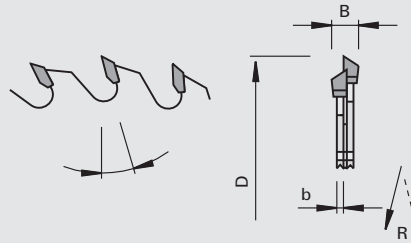
106354

## Clipping Saw Blades HW for edge trimming - adjustable „ES“

product



drawing



LEUCO  
topline<sub>HW</sub>

LEUCO  
DUR

tungsten carbide [HW]

Machine / Application

- | edge banders
- | edge trimming machines  
Homag, Brandt, Raimann,  
Reich, Ott, SCM-Stefani
- | for trimming and chamfering of  
plastic-, veneer- and solid wood  
edges

Design

- | positive hook angle
- | L - left hand bevel „ES-L“ /  
R - right hand bevel „ES-R“
- | cutting material: HW HL Board  
06

Advantages

Notes

- | LEUCODUR HW
- | sense of rotation see drawing

| Ø D  | B    | b    | Ø d  | Z    | NL       | hook<br>angle | shear∠ |             | Ident-No. [L] | Ident-No. [R] |
|------|------|------|------|------|----------|---------------|--------|-------------|---------------|---------------|
| 100  | 5,8  | 2.2  | 32   | 2x20 |          | 8             | 5      |             | 169980        | 169983        |
| 125  | 6,2  | 2.0  | 30   | 2x20 | 2/3,1/42 | 10            | 0      | SCM-Stefani | 189329        | 189332        |
| [mm] | [mm] | [mm] | [mm] |      |          | [°]           | [°]    |             |               |               |

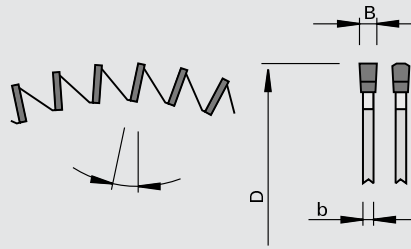
102370

## NF-Chop Saw Blades HW „TR-F“

product



drawing



LEUCO  
topline

LEUCO  
DUR

tungsten carbide [HW]

**Machine / Application**

- chop and miter saws
- for cross cuts in thin-walled plastic and aluminum profiles

**Design**

- negative hook angle
- tooth configuration: triple chip / flat „TR-F“
- cutting material: HW HL Board 10

**Advantages**

- smooth running and no chipping of edges of the workpiece thanks to the high number of teeth

**Notes**

| Ø D  | B    | b    | Ø d  | Z   | hook angle | Ident-No. |
|------|------|------|------|-----|------------|-----------|
| 200  | 2,2  | 2.0  | 30   | 100 | -6         | 188388    |
| 250  | 2,2  | 1.6  | 30   | 126 | -6         | 189709    |
| [mm] | [mm] | [mm] | [mm] |     | [°]        |           |



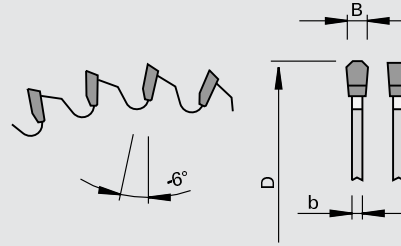
108472

NF-Circular Saw Blades HW - negative hook angle „TR-F“

product



drawing



LEUCO  
proline

LEUCO  
DUR

tungsten carbide [HW]



Machine / Application

l chop and miter saws  
l for clipping and mitre cuts in aluminum and plastic profiles

Design

l negative hook angle  
l tooth configuration: triple chip / flat „TR-F“  
l cutting material: HW HL Board 10

Advantages

l noise-reduction thanks to laser ornaments

Notes

| Ø D  | B    | b    | Ø d  | Z   | NL                         |  | Ident-No. |
|------|------|------|------|-----|----------------------------|--|-----------|
| 250  | 3,2  | 2,5  | 30   | 60  | 2/7/42                     | DeWALT, ELU, Haffner, Makita   | 188802    |
| 250  | 2,8  | 2,2  | 30   | 80  | 2/7/42                     | ELU, Mafell, Metabo, Festo, Haffner, Hitachi                             | 188805    |
| 250  | 3,2  | 2,5  | 30   | 80  | 2/7/42                     | DeWALT, ELU, Haffner, Makita   | 188803 \$ |
| 250  | 3,2  | 2,5  | 32   | 80  |                            | Kaltenbach TL 250, ELU TGS 71, 171, 172, Baier, Fezer, Ulmia, Trennjäger | 188804 &  |
| 275  | 3,2  | 2,5  | 40   | 88  | 4/12/64 + 2/9/55           | Eisele LMS I new, Graule, Trennjäger, Weidmann                           | 188811    |
| 300  | 3,2  | 2,5  | 30   | 72  | 2/7/42 + 2/10/60           | DeWALT, Fezer, Schleicher  | 188812    |
| 300  | 3,2  | 2,5  | 32   | 72  |                            | ELU MGS 73, Rapid, Trennjäger, Fezer, Berg&Schmid                        | 188813 &  |
| 300  | 2,8  | 2,2  | 30   | 96  | 2/7/42 + 2/10/60           |  | 188842    |
| 300  | 3,2  | 2,5  | 30   | 96  | 2/7/42 + 2/10/60           | DeWALT, Fezer, Schleicher  | 188814 \$ |
| 300  | 3,2  | 2,5  | 32   | 96  |                            | ELU MGS 73, Rapid, Trennjäger, Fezer, Berg&Schmid                        | 188815 &  |
| 330  | 3,2  | 2,5  | 30   | 96  |                            | ELU, Haffner   | 188816    |
| 330  | 3,2  | 2,5  | 32   | 96  |                            | ELU  | 188818 &  |
| 350  | 3,8  | 3,2  | 40   | 84  | 4/12/64 + 2/9/55           | Eisele LMS II, LMS II - P V, VA - L, Graule, Ulmia, Weidmann             | 188819    |
| 350  | 3,2  | 2,5  | 30   | 90  |                            | DeWALT, Haffner, Pfeiffer  | 188821    |
| 350  | 3,2  | 2,5  | 30   | 96  | 2/10/60                    |  | 188846    |
| 350  | 3,2  | 2,5  | 30   | 108 | 2/9/55 + 2/10/60 + 4/12/64 |  | 188822 \$ |
| 350  | 3,2  | 2,5  | 40   | 108 | 4/12/64 + 2/9/55           | Eisele LMS II, LMS II - PV, VA - L, Graule, Ulmia, Weidmann              | 188823 &  |
| 400  | 3,8  | 3,2  | 30   | 96  | 2/12/64 + 4/15/80          | DeWALT, Haffner  | 188827    |
| 400  | 3,8  | 3,2  | 50   | 96  | 4/15/80                    | Kaltenbach TL 400  | 188828 &  |
| 420  | 4,0  | 3,2  | 30   | 96  |                            | Rapid, ELU   | 188829    |
| 450  | 3,8  | 3,2  | 30   | 96  | 4/12/64 + 2/12/80          | DeWALT, Haffner  | 188831    |
| 500  | 4,0  | 3,4  | 30   | 120 | 2/10/70                    | Pfeiffer, Rapid  | 188833    |
| [mm] | [mm] | [mm] | [mm] |     |                            |  |           |

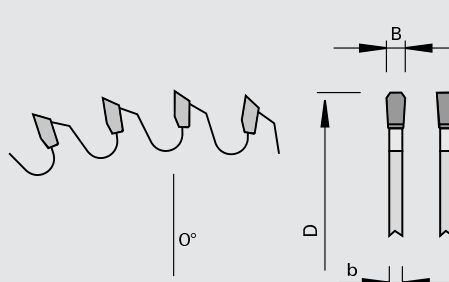
108370

### NF-Chop Saw Blades HW - neutral hook angle „TR-F“

product



drawing



**LEUCO topLine**

**LEUCO DUR**

tungsten carbide [HW]

**LOW VIBRATION**

**Machine / Application**

- chop and miter saws
- table saws
- for clipping and mitre cuts in aluminum profiles

**Design**

- neutral hook angle
- tooth configuration: triple chip / flat „TR-F“
- cutting material: HW HL Board 08

**Advantages**

- burr-free cuts in profiles with low roughness
- noise-reduction thanks to laser ornaments

**Notes**

- tight workpiece clamping required
- Kaltenbach as counter-bore type

| Ø D  | B    | b    | Ø d  | Z   | NL      |                             | Ident-No. |
|------|------|------|------|-----|---------|-----------------------------|-----------|
| 380  | 3,6  | 3.0  | 32   | 90  |         | Elumatec                    | 189111    |
| 420  | 3,8  | 3.2  | 30   | 102 | 2/10/70 | Rapid, Elumatec             | 189074    |
| 500  | 4,0  | 3.4  | 30   | 114 | 2/10/70 | Rapid, Elumatec             | 189075    |
| 500  | 4,0  | 3.4  | 32   | 114 | 2/12/64 | Eisele LMS SCA              | 189076    |
| 550  | 4,4  | 3.8  | 30   | 126 | 2/10/70 | Elumatec, Kaltenbach, Rapid | 189113    |
| [mm] | [mm] | [mm] | [mm] |     |         |                             |           |

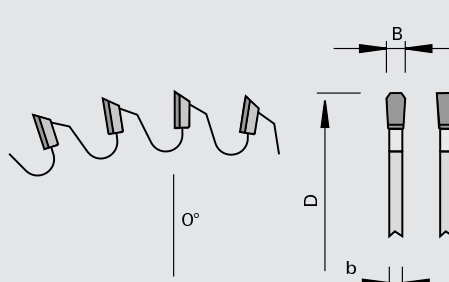
208070

### NF-Chop Saw Blades DP - profiles „TR-F“

product



drawing



**LEUCO topLine**

**LEUCO DIA**

polycrystalline diamond [DP]

**Machine / Application**

- chop and miter saws
- for clipping and mitre cuts in aluminum profiles

**Design**

- neutral hook angle
- tooth configuration: triple chip / flat „TR-F“

**Advantages**

- excellent burr-free cuts with low roughness thanks to special laser ornaments and tooth partition

**Notes**

- tight workpiece clamping required

| Ø D  | B    | b    | Ø d  | Z   | NL      |                     | Ident-No. |
|------|------|------|------|-----|---------|---------------------|-----------|
| 275  | 3,4  | 2.8  | 32   | 60  | 4/9/50  | Wagner 1994         | 189067 s  |
| 285  | 3,4  | 2.8  | 32   | 60  | 4/9/50  | Wagner              | 189068 s  |
| 380  | 3,6  | 3.0  | 32   | 84  | 4/9/50  | Elumatec            | 189337 s  |
| 400  | 3,8  | 3.2  | 40   | 90  | 2/12/80 | Eisele VA-L 350 NC1 | 189338 s  |
| 500  | 4,0  | 3.4  | 30   | 108 | 2/10/70 | Elumatec            | 189339 s  |
| 550  | 4,2  | 3.6  | 30   | 120 |         | Elumatec MGS        | 189340 s  |
| [mm] | [mm] | [mm] | [mm] |     |         |                     |           |

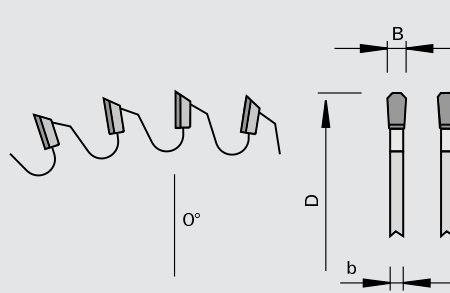
208080

### NF-Chop Saw Blades DP - solid „TR-F-FA“

product



drawing



LEUCO  
topline

LEUCO  
DIA

polycrystalline diamond [DP]

Machine / Application

l chop and miter saws  
l for miter cuts in solid aluminum materials

Design

l neutral hook angle  
l tooth configuration: inverted-v / flat with chamfer „TR-F-FA“

Advantages

l excellent burr-free cuts with low roughness thanks to special laser ornaments and tooth partition

Notes

l tight workpiece clamping required

| Ø D  | B    | b    | Ø d  | Z  | NL      |                    | Ident-No. |
|------|------|------|------|----|---------|--------------------|-----------|
| 500  | 4,0  | 3.4  | 50   | 90 | 4/15/80 | Kaltenbach RKL 550 | 189064 s  |
| 500  | 4,0  | 3.4  | 30   | 90 |         | Elumatec           | 189065 s  |
| 550  | 4,4  | 3.8  | 50   | 96 | 4/15/80 | Kaltenbach RKL 550 | 189066 s  |
| [mm] | [mm] | [mm] | [mm] |    |         |                    |           |

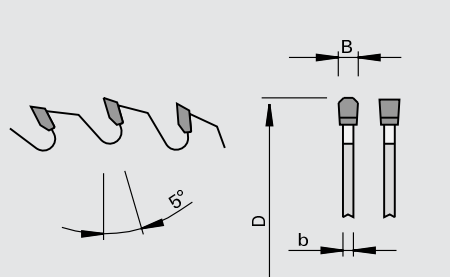
108471

### NF-Chop Saw Blades HW - positive hook angle „TR-F“

product



drawing



LEUCO  
proline

LEUCO  
DUR

tungsten carbide [HW]

LOW  
noise

Machine / Application

l table saws  
l for dividing and miter cuts in aluminum and plastic profiles as well as for wood-based panels (Corian, Noblan, Varicor and HPL)

Design

l positive hook angle  
l tooth configuration: triple chip / flat „TR-F“  
l cutting material: HW HL Board 10

Advantages

l noise-reduction thanks to laser ornaments

Notes

l tight workpiece clamping required

| Ø D  | B    | b    | Ø d  | Z   | NL                |  | Ident-No. |
|------|------|------|------|-----|-------------------|--|-----------|
| 250  | 3,2  | 2.5  | 30   | 60  |                   | Haffner, ELU, Makita                     | 188783 #  |
| 250  | 3,2  | 2.5  | 30   | 80  | 2/7/42            | Haffner, ELU, Makita                     | 188785    |
| 300  | 3,2  | 2.5  | 30   | 72  | 2/7/42 + 2/10/60  | Fezer, Rapid                             | 188787    |
| 300  | 3,2  | 2.5  | 30   | 96  | 2/7/42 + 2/10/60  | Fezer, Rapid                             | 188789    |
| 300  | 3,2  | 2.5  | 32   | 96  |                   |  | 188843 &  |
| 350  | 3,2  | 2.5  | 30   | 108 |                   | Haffner, Rapid, Pfeffer                  | 188791    |
| 400  | 3,8  | 3.2  | 30   | 96  | 4/12/64 + 2/12/80 |  | 188794    |
| 400  | 3,8  | 3.2  | 40   | 96  | 4/12/64 + 2/12/80 | Eisele LMS II, LMS III                   | 188793 &  |
| 420  | 3,8  | 3.2  | 30   | 96  |                   | ELU DG 102, 104, DLG, MGS 105, Rapid SAT | 188795    |
| 450  | 3,8  | 3.2  | 40   | 108 | 4/12/64 + 2/12/80 | Eisele                                   | 188798    |
| 500  | 4,0  | 3.4  | 30   | 120 | 2/10/70           | Pfeifer, Rapid, BKS                      | 188799    |
| [mm] | [mm] | [mm] | [mm] |     |                   |  |           |

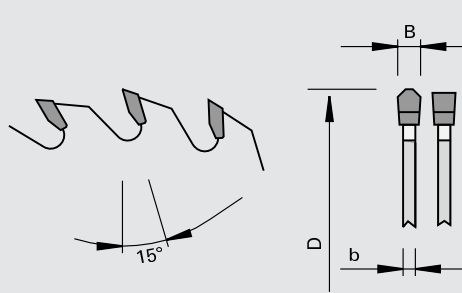
108371

## NF-Panel Sizing Saw Blades HW - positive hook angle „TR-F“

product



drawing



LEUCO  
topline

LEUCO  
DUR

tungsten carbide [HW]

LOW  
noise

**Machine / Application**

- | horizontal panel sizing saws
- | for dividing cuts in aluminum block materials

**Design**

- | tooth configuration: triple chip / flat „TR-F“
- | cutting material: HW HL Board 08

**Advantages**

- | noise-reduction thanks to laser ornaments

**Notes**

- | for stack heights up to 200 mm (for large saw diameters)

| Ø D  | B    | b    | Ø d  | Z  | NL       | H       |           | Ident-No. |
|------|------|------|------|----|----------|---------|-----------|-----------|
| 450  | 4,5  | 3.2  | 40   | 60 | 2/13/114 | -100    | Schelling | 189212 s  |
| 620  | 5,5  | 4.2  | 40   | 60 | 2/13/114 | 110-160 | Schelling | 189213 s  |
| 680  | 5,8  | 4.5  | 40   | 60 | 2/13/114 | -200    | Schelling | 189214 s  |
| 720  | 6,0  | 4.8  | 40   | 60 | 2/13/114 | 150-220 | Schelling | 189215 s  |
| [mm] | [mm] | [mm] | [mm] |    |          | [mm]    |           |           |

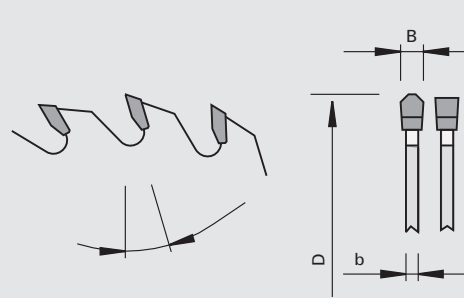
108271

NF-Thin-Kerf-Chop Saw Blades HW - positive hook angle „TR-F“

product



drawing



tungsten carbide [HW]



Machine / Application

chop saws  
for dividing and trimming of aluminum profiles (bars, tubes, ...)

Design

with laser ornaments  
tooth configuration: triple chip / flat „TR-F“  
cutting material: HW HL Board O8

Advantages

less vibration and noise thanks to laser ornaments

Notes

| Ø D  | B    | b    | Ø d  | Z  | hook angle | NL                  | Ident-No.  |          |
|------|------|------|------|----|------------|---------------------|--|----------|
| 285  | 2,0  | 1,6  | 32   | 60 | 5          | 4/9/50 +<br>4/11/63 | Kasto Speed C9,<br>Kasto WAC-70, Tsune, Nishijima, Rhobi,<br>Everising, I.T.E.C                          | 189655 s |
| 360  | 3,4  | 2,6  | 50   | 60 | 5          | 4/16/80             | Kasto Speed C14/C15, Kasto Variospeed<br>C14/C15, Kaltenbach KMR-100AP<br>Tsune, Nishijima, Sinico, Endo | 189657 s |
| 360  | 3,4  | 2,6  | 50   | 80 | 5          | 4/16/80             | Kasto Speed C14/C15, Kasto Variospeed<br>C14/C15, Kaltenbach KMR-100AP<br>Tsune, Nishijima, Sinico, Endo | 189656 s |
| 425  | 3,4  | 2,6  | 50   | 50 | 5          | 4/16/80             | Kasto Speed C14/C15,<br>Kasto Variospeed C14/C15   | 189658 s |
| 425  | 3,4  | 2,6  | 50   | 60 | 5          | 4/16/80             | Kasto Speed C14/C15,<br>Kasto Variospeed C14/C15   | 189659 s |
| 460  | 3,4  | 2,6  | 50   | 50 | 8          | 4/16/80             | Kasto Speed C14/C15,<br>Kasto Variospeed C14/C15,<br>Everising, Noritake                                 | 189660 s |
| 460  | 3,4  | 2,6  | 50   | 60 | 8          | 4/16/80             | Kasto Speed C14/C15,<br>Kasto Variospeed C14/C15,<br>Everising, Noritake                                 | 189662 s |
| 460  | 3,4  | 2,6  | 50   | 80 | 8          | 4/16/80             | Kasto Speed C14/C15,<br>Kasto Variospeed C14/C15,<br>Everising, Noritake                                 | 189661 s |
| [mm] | [mm] | [mm] | [mm] |    | [°]        |                     |  |          |

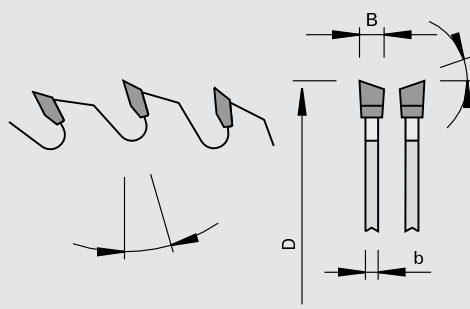
107520

## Portable Saw Blades HW „WS“

product



drawing



LEUCO  
euroline

LEUCO  
DUR

tungsten carbide [HW]

**Machine / Application**

- | Portable Saws
- | chop and miter saws
- | for ripping and cross cuts in solid woods and wood-based panels

**Design**

- | tooth configuration: alternate top bevel „WS“
- | cutting material: HW HL Board
- 10

**Advantages**

**Notes**

- | lower numbers of teeth for solid woods
- | higher numbers of teeth for wood-based panels

| Ø D  | B    | b    | Ø d  | Z  | NL       | hook angle | Ident-No. |
|------|------|------|------|----|----------|------------|-----------|
| 100  | 2,4  | 1,4  | 12   | 30 |          | 10         | 50110001  |
| 100  | 3,97 | 2,8  | 22   | 12 |          | 20         | 50110178  |
| 100  | 2,4  | 1,4  | 22   | 30 |          | 10         | 50110003  |
| 105  | 2,4  | 1,4  | 22   | 30 |          | 10         | 50110006  |
| 120  | 1,8  | 1,3  | 20   | 24 |          | 15         | 50104061  |
| 125  | 2,4  | 1,6  | 20   | 20 | 2/5,5/30 | 15         | 50110011  |
| 125  | 2,4  | 1,6  | 20   | 36 | 2/6/32,5 | 10         | 50110012  |
| 130  | 2,4  | 1,6  | 20   | 20 | 2/6/32,5 | 15         | 50110017  |
| 130  | 2,4  | 1,6  | 20   | 36 | 2/6/32,5 | 10         | 50110018  |
| 140  | 2,4  | 1,6  | 20   | 12 | 2/6/32,5 | 20         | 50110242  |
| 140  | 2,4  | 1,6  | 20   | 20 | 2/6/32,5 | 15         | 50110028  |
| 140  | 2,4  | 1,6  | 20   | 36 | 2/6/32,5 | 10         | 50110029  |
| 150  | 2,6  | 1,6  | 20   | 12 | 2/6/32,5 | 20         | 50110243  |
| 150  | 2,6  | 1,6  | 20   | 24 | 2/6/32,5 | 15         | 50110039  |
| 150  | 2,6  | 1,6  | 20   | 36 | 2/6/32,5 | 15         | 50110040  |
| 150  | 2,6  | 1,6  | 20   | 48 | 2/6/32,5 | 10         | 50110041  |
| 150  | 2,6  | 1,6  | 30   | 24 | 2/7/42   | 15         | 50110042  |
| 160  | 2,6  | 1,6  | 16   | 24 | 2/6/32,5 | 15         | 50110051  |
| 160  | 2,6  | 1,6  | 16   | 48 | 2/6/32,5 | 10         | 50110053  |
| 160  | 2,2  | 1,6  | 20   | 12 | 2/6/32,5 | 20         | 50110244  |
| 160  | 2,2  | 1,6  | 20   | 24 | 2/6/32,5 | 15         | 50110054  |
| 160  | 2,2  | 1,6  | 20   | 36 | 2/6/32,5 | 15         | 50110055  |
| 160  | 2,2  | 1,6  | 20   | 48 | 2/6/32,5 | 10         | 50110056  |
| 160  | 2,6  | 1,6  | 30   | 24 | 2/7/42   | 15         | 50110057  |
| 160  | 2,6  | 1,6  | 30   | 36 | 2/7/42   | 15         | 50110058  |
| 160  | 2,6  | 1,6  | 30   | 48 | 2/7/42   | 10         | 50110059  |
| 165  | 2,6  | 1,6  | 20   | 24 | 2/6/32,5 | 15         | 50110060  |
| 165  | 2,6  | 1,6  | 20   | 36 | 2/6/32,5 | 15         | 50110061  |
| 165  | 2,6  | 1,6  | 20   | 48 | 2/6/32,5 | 10         | 50110062  |
| 165  | 2,6  | 1,6  | 30   | 24 | 2/7/42   | 15         | 50110130  |
| 170  | 2,6  | 1,6  | 30   | 24 | 2/7/42   | 20         | 50110069  |
| 170  | 2,6  | 1,6  | 30   | 36 | 2/7/42   | 15         | 50110070  |
| 170  | 2,6  | 1,6  | 30   | 48 | 2/7/42   | 10         | 50110071  |
| 180  | 2,6  | 1,6  | 16   | 24 | 2/6/32,5 | 15         | 50110081  |
| 180  | 2,6  | 1,6  | 16   | 48 | 2/6/32,5 | 10         | 50110183  |
| 180  | 2,6  | 1,6  | 20   | 14 | 2/6/32,5 | 20         | 50110247  |
| 180  | 2,6  | 1,6  | 20   | 24 | 2/6/32,5 | 20         | 50110075  |
| 180  | 2,6  | 1,6  | 20   | 40 | 2/6/32,5 | 15         | 50110076  |
| 180  | 2,6  | 1,6  | 30   | 14 | 2/7/42   | 20         | 50110248  |
| 180  | 2,6  | 1,6  | 30   | 24 | 2/7/42   | 20         | 50110078  |
| 180  | 2,6  | 1,6  | 30   | 40 | 2/7/42   | 15         | 50110079  |
| 180  | 2,6  | 1,6  | 30   | 54 | 2/7/42   | 10         | 50110080  |
| [mm] | [mm] | [mm] | [mm] |    |          | [°]        |           |

| Ø D  | B    | b    | Ø d  | Z  | NL                               | hook angle | Ident-No. |
|------|------|------|------|----|----------------------------------|------------|-----------|
| 190  | 2,6  | 1.6  | 16   | 24 | 2/6/32,5                         | 15         | 50110153  |
| 190  | 2,6  | 1.6  | 16   | 30 | 2/6/32,5                         | 15         | 50110083  |
| 190  | 2,6  | 1.6  | 16   | 42 | 2/6/32,5                         | 10         | 50110084  |
| 190  | 2,6  | 1.6  | 20   | 24 | 2/6/32,5                         | 15         | 50110154  |
| 190  | 2,6  | 1.6  | 20   | 30 | 2/6/32,5                         | 15         | 50110086  |
| 190  | 2,6  | 1.6  | 20   | 48 | 2/6/32,5                         | 10         | 50110087  |
| 190  | 2,6  | 1.6  | 30   | 16 | 2/7/42                           | 20         | 50110251  |
| 190  | 2,6  | 1.6  | 30   | 24 | 2/7/42                           | 20         | 50110155  |
| 190  | 2,6  | 1.6  | 30   | 30 | 2/7/42                           | 15         | 50110089  |
| 190  | 2,6  | 1.6  | 30   | 48 | 2/7/42                           | 10         | 50110090  |
| 190  | 2,6  | 1.6  | 30   | 60 | 2/7/42                           | 10         | 50110091  |
| 200  | 2,8  | 1.8  | 30   | 18 | 2/7/42                           | 20         | 50110252  |
| 200  | 2,8  | 1.8  | 30   | 30 | 2/7/42                           | 15         | 50110095  |
| 200  | 2,8  | 1.8  | 30   | 48 | 2/7/42                           | 15         | 50110096  |
| 200  | 2,8  | 1.8  | 30   | 60 | 2/7/42                           | 10         | 50110097  |
| 205  | 2,6  | 1.8  | 18   | 30 |                                  | 15         | 50110286  |
| 210  | 2,8  | 1.8  | 30   | 18 | 2/7/42                           | 20         | 50110253  |
| 210  | 2,8  | 1.8  | 30   | 30 | 2/7/42                           | 15         | 50110104  |
| 210  | 2,8  | 1.8  | 30   | 48 | 2/7/42                           | 15         | 50110105  |
| 210  | 2,8  | 1.8  | 30   | 60 | 2/7/42                           | 10         | 50110106  |
| 216  | 2,8  | 1.8  | 30   | 30 | 2/7/42                           | 20         | 50110107  |
| 216  | 2,8  | 1.8  | 30   | 48 | 2/7/42                           | 15         | 50110108  |
| 216  | 2,8  | 1.8  | 30   | 60 | 2/7/42                           | 10         | 50110109  |
| 220  | 2,8  | 1.8  | 30   | 24 | 2/7/42                           | 15         | 50110164  |
| 220  | 2,8  | 1.8  | 30   | 36 | 2/7/42                           | 15         | 50110110  |
| 220  | 2,8  | 1.8  | 30   | 48 | 2/7/42                           | 15         | 50110111  |
| 220  | 2,8  | 1.8  | 30   | 64 | 2/7/42                           | 10         | 50110112  |
| 225  | 2,8  | 1.8  | 30   | 24 | 2/7/42                           | 15         | 50110165  |
| 225  | 2,8  | 1.8  | 30   | 34 | 2/7/42                           | 15         | 50110228  |
| 225  | 2,8  | 1.8  | 30   | 48 | 2/7/42                           | 10         | 50110237  |
| 230  | 2,8  | 1.8  | 30   | 18 | 2/7/42                           | 20         | 50110255  |
| 230  | 2,8  | 1.8  | 30   | 24 | 2/7/42                           | 15         | 50110168  |
| 230  | 2,8  | 1.8  | 30   | 36 | 2/7/42                           | 15         | 50110113  |
| 230  | 2,8  | 1.8  | 30   | 48 | 2/7/42                           | 15         | 50110114  |
| 230  | 2,8  | 1.8  | 30   | 64 | 2/7/42                           | 10         | 50110115  |
| 235  | 2,8  | 1.8  | 30   | 18 | 2/7/42                           | 20         | 50110256  |
| 235  | 2,8  | 1.8  | 30   | 24 | 2/7/42                           | 15         | 50110170  |
| 235  | 2,8  | 1.8  | 30   | 36 | 2/7/42                           | 15         | 50110117  |
| 240  | 2,8  | 1.8  | 30   | 24 | 2/7/42                           | 20         | 50110174  |
| 240  | 2,8  | 1.8  | 30   | 36 | 2/7/42                           | 20         | 50110123  |
| 240  | 2,8  | 1.8  | 30   | 48 | 2/7/42                           | 15         | 50110124  |
| 235  | 2,8  | 1.8  | 30   | 48 | 2/7/42                           | 15         | 58110121  |
| 235  | 2,8  | 1.8  | 30   | 64 | 2/7/42                           | 10         | 58110118  |
| 250  | 3,2  | 2.2  | 30   | 24 | 2/7/42 + 2/9,5/46,5<br>+ 2/10/60 | 20         | 58120060  |
| 250  | 3,2  | 2.2  | 30   | 30 | 2/7/42 + 2/9,5/46,5<br>+ 2/10/60 | 20         | 58120061  |
| 250  | 3,2  | 2.2  | 30   | 40 | 2/7/42 + 2/9,5/46,5<br>+ 2/10/60 | 10         | 58100018  |
| 250  | 3,2  | 2.2  | 30   | 48 | 2/7/42 + 2/9,5/46,5<br>+ 2/10/60 | 10         | 58100026  |
| 250  | 3,2  | 2.2  | 30   | 60 | 2/7/42 + 2/9,5/46,5<br>+ 2/10/60 | 10         | 58100031  |
| 250  | 3,2  | 2.2  | 30   | 80 | 2/7/42 + 2/9,5/46,5<br>+ 2/10/60 | 10         | 58100038  |
| 254  | 3,2  | 2.2  | 30   | 40 | 2/7/42 + 2/9,5/46,5<br>+ 2/10/60 | 10         | 58120067  |
| 254  | 3,2  | 2.2  | 30   | 60 | 2/7/42 + 2/9,5/46,5<br>+ 2/10/60 | 10         | 58120068  |
| 260  | 3,2  | 2.2  | 30   | 32 | 2/7/42 + 2/9,5/46,5<br>+ 2/10/60 | 20         | 58110185  |
| 260  | 3,2  | 2.2  | 30   | 40 | 2/7/42 + 2/9,5/46,5<br>+ 2/10/60 | 10         | 58110175  |
| 260  | 3,2  | 2.2  | 30   | 60 | 2/7/42 + 2/9,5/46,5<br>+ 2/10/60 | 10         | 58100254  |
| [mm] | [mm] | [mm] | [mm] |    |                                  | [°]        |           |

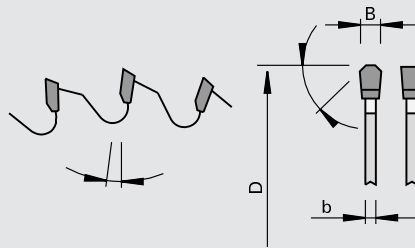
| Ø D  | B    | b    | Ø d  | Z  | NL                               | hook angle | Ident-No. |
|------|------|------|------|----|----------------------------------|------------|-----------|
| 270  | 3,2  | 2.2  | 30   | 24 | 2/7/42 + 2/9,5/46,5<br>+ 2/10/60 | 20         | 58110176  |
| 270  | 3,2  | 2.2  | 30   | 60 | 2/7/42 + 2/9,5/46,5<br>+ 2/10/60 | 10         | 58110182  |
| 280  | 3,2  | 2.2  | 30   | 48 | 2/7/42 + 2/9,5/46,5<br>+ 2/10/60 | 10         | 58110136  |
| [mm] | [mm] | [mm] | [mm] |    |                                  | [°]        |           |

108472

### Portable Saw Blades HW „WS“

product

drawing



LEUCO  
proline

LEUCO  
DUR

tungsten carbide [HW]

Machine / Application

portable saws  
for ripping and cross cuts in  
wood-based panels, NF-metals  
and solid woods

Design

negative hook angle  
tooth configuration: triple chip  
/ flat „TR-F“  
cutting material: HW HL Board  
10

Advantages

Notes

| Ø D  | B    | b    | Ø d  | Z  | NL       | hook angle | Ident-No. |
|------|------|------|------|----|----------|------------|-----------|
| 150  | 2,8  | 2.2  | 20   | 42 | 2/6/32,5 | -6         | 58115002  |
| 160  | 2,2  | 1.6  | 20   | 42 | 2/6/32,5 | -6         | 58115004  |
| 160  | 2,2  | 1.6  | 20   | 56 | 2/6/32,5 | -6         | 58115042  |
| 160  | 2,8  | 2.2  | 30   | 42 | 2/7/42   | -6         | 58115026  |
| 180  | 2,8  | 2.2  | 20   | 48 | 2/6/32,5 | -6         | 58115007  |
| 180  | 2,8  | 2.2  | 30   | 48 | 2/7/42   | -6         | 58115008  |
| 190  | 2,8  | 2.2  | 20   | 54 | 2/6/32,5 | -6         | 58115009  |
| 190  | 2,8  | 2.2  | 30   | 54 | 2/7/42   | -6         | 58115010  |
| 200  | 2,8  | 2.2  | 30   | 54 | 2/7/42   | -6         | 58115011  |
| 210  | 2,8  | 2.2  | 30   | 54 | 2/7/42   | -6         | 58115012  |
| 216  | 2,8  | 2.2  | 30   | 60 | 2/7/42   | -6         | 58115024  |
| 216  | 2,8  | 2.2  | 30   | 80 | 2/7/42   | -6         | 58115034  |
| 220  | 2,8  | 2.2  | 30   | 54 | 2/7/42   | -6         | 58115021  |
| 230  | 2,8  | 2.2  | 30   | 64 | 2/7/42   | -6         | 58115014  |
| 235  | 2,8  | 2.2  | 30   | 64 | 2/7/42   | -6         | 58115018  |
| [mm] | [mm] | [mm] | [mm] |    |          | [°]        |           |



## Tooth configuration

The tooth design has a big influence on the edge quality and is depending on the following factors:

- | workpiece material
- | mode of application (with and across the grain)
- | direction of cut (along / across the grain)

|  |         |                                  |  |         |   |  |          |                                      |
|--|---------|----------------------------------|--|---------|---|--|----------|--------------------------------------|
|  | F       | flat                             |  | DA      | inverted-v                              |  | KO-WS    | conical-alternate bevel              |
|  | F-FA    | flat with chamfers on both sides |  | DA-F    | inverted-v + flat                       |  | KO-HR-FA | conical hollow back with chamfer     |
|  | F-WFA   | flat with alternating chamfer    |  | DA-F-FA | inverted-v + flat with chamfer          |  | D        | hollow-ground                        |
|  | WS      | alternate top bevel              |  | DA-D    | inverted-v + hollow-ground              |  | D-FA     | hollow-ground with two-sided chamfer |
|  | WS-FA   | alternate top bevel with chamfer |  | DA-D-FA | inverted-v + hollow-ground with chamfer |  | HR       | hollow back                          |
|  | TR      | triple-chip                      |  | ES      | top bevel                               |  | HR-FA    | hollow back with chamfer             |
|  | TR-F    | triple-chip + flat               |  | ES-L    | top bevel, left                         |  | G3       | G3                                   |
|  | TR-F-FA | triple-chip + flat with chamfer  |  | ES-R    | top bevel, right                        |  | G5       | G5                                   |
|  | TR-TR   | triple-chip + triple-chip        |  | KO-F    | conical-flat                            |  | G6       | G6                                   |

## Number of teeth

The number of cutting edges subject to feed rate is to be found in section tool description on the respective pages. It is depending on the following criteria:

- | feed
- | RPM of the spindle
- | diameter of the circular saw blade
- | workpiece material
- | cutting quality (sizing cut / finish cut)
- | cutting height (single boards / stack)
- | stack height (no. of single boards)
- | pass

## Cutting speed (standard values)

### HW Saw Blades

| workpiece material                      | cutting speed<br>vc [m/s] |
|---|---------------------------|
| Al-Mg-Cu                                | 40 - 60                   |
| Al-Si alloys                            | 15 - 40                   |
| panels veneered both sides              | 60 - 90                   |
| thermosets (Pertinax®, Restitex®, etc.) | 15 - 50                   |
| exotic woods                            | 50 - 85                   |
| veneers                                 | 70 - 100                  |
| gypsum plaster boards                   | 40 - 65                   |
| hardboards                              | 50 - 80                   |
| hard woods                              | 60 - 100                  |
| plastic laminated particle boards       | 60 - 80                   |
| plastic profiles without filling        | 30 - 70                   |
| pressed laminated woods                 | 40 - 65                   |
| pure aluminum                           | 60 - 80                   |
| raw particle boards                     | 50 - 80                   |
| laminated boards                        | 60 - 80                   |
| laminates, hard paper, fabric           | 50 - 70                   |
| particle boards                         | 60 - 80                   |
| plywood boards                          | 50 - 80                   |
| thermoplastic (PA, PE, PMMA etc.)       | 30 - 70                   |
| wood core plywood                       | 50 - 90                   |
| condensed woods                         | 40 - 65                   |
| soft fiber boards                       | 60 - 100                  |
| soft woods                              | 60 - 100                  |
| cement bonded boards                    | 40 - 60                   |

### DP Saw Blades

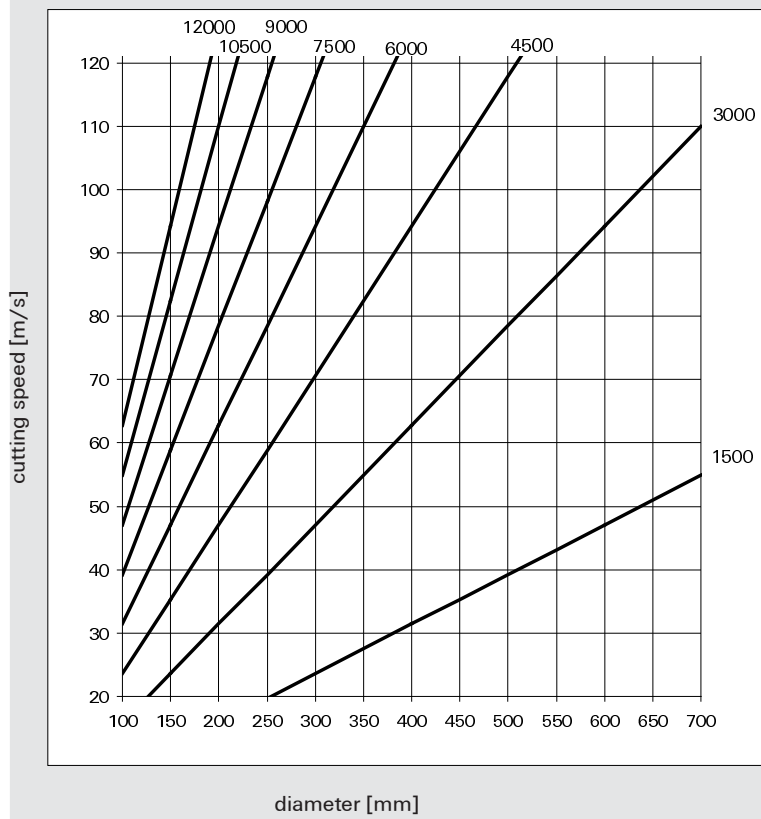
| workpiece material                         | cutting speed<br>vc [m/s] |
|--|---------------------------|
| CFRP, GRP                                  | 40 - 60                   |
| thermosets (Pertinax®, Restitex®, etc.)    | 50 - 80                   |
| polymer bound boards (Corian®, Varicor®)   | 60 - 90                   |
| pressed laminated woods                    | 40 - 60                   |
| laminated particle boards and MDF boards   | 50 - 80                   |
| foil-coated particle boards and MDF boards | 64 - 100                  |
| veneered particle boards and MDF boards    | 65 - 100                  |
| raw particle boards and MDF boards         | 65 - 100                  |
| plywood boards                             | 65 - 100                  |
| thermoplastic (PA, PE, PMMA etc.)          | 60 - 90                   |
| wood core plywood                          | 60 - 80                   |
| condensed woods                            | 70 - 100                  |
|  | 50 - 80                   |

## Feed rate per tooth

### HW Saw Blades

| workpiece material                       | feed rate per tooth<br>fz [mm] |
|--|--------------------------------|
| Al-Mg-Cu                                 | 0,05 - 0,12                    |
| Al-Si alloys                             | 0,03 - 0,08                    |
| panels veneered both sides               | 0,03 - 0,10                    |
| thermosets (Pertinax®, Restitex®, etc.)  | 0,02 - 0,05                    |
| hardboards                               | 0,03 - 0,08                    |
| plastic laminated particle boards        | 0,03 - 0,15                    |
| plastic profiles without filling         | 0,03 - 0,15                    |
| solid wood with the grain                | 0,10 - 0,50                    |
| solid wood across the grain              | 0,02 - 0,20                    |
| polymer bound boards (Corian®, Varicor®) | 0,05 - 0,15                    |
| pure aluminum                            | 0,05 - 0,12                    |
| particle boards, MDF boards              | 0,05 - 0,25                    |
| plywood boards                           | 0,05 - 0,25                    |
| thermoplastic (PA, PE, PMMA etc.)        | 0,05 - 0,08                    |

### Determination of RPM [min-1]



## Order / Inquiry for Special Tools: Circular Saw Blades

Please copy and send the completed form to one of the LEUCO sales offices. (Only one tool description per form)

|                  |       |                      |                       |
|------------------|-------|----------------------|-----------------------|
| customer-no.:    | _____ | order:               | <input type="radio"/> |
| company:         | _____ | inquiry:             | <input type="radio"/> |
| plant:           | _____ |                      |                       |
| street:          | _____ | delivery (week no.): | _____                 |
| zip / city:      | _____ | (not binding)        |                       |
| country:         | _____ | no. of pieces:       | _____                 |
| contact partner: | _____ |                      |                       |
| phone:           | _____ | fax:                 | _____                 |
| city and date:   | _____ | signature:           | _____                 |

### machine

make: \_\_\_\_\_

model: \_\_\_\_\_

type: \_\_\_\_\_

operating RPM [min-1]: \_\_\_\_\_

feed rate [m/min]: \_\_\_\_\_

flange diameter [mm]: \_\_\_\_\_

motor output [kW]: \_\_\_\_\_

type of machine:

|            |                       |
|------------|-----------------------|
| one shaft  | <input type="radio"/> |
| two shafts | <input type="radio"/> |

mode of application:

against feed:

|             |                       |
|-------------|-----------------------|
| from top    | <input type="radio"/> |
| from bottom | <input type="radio"/> |

with feed:

|             |                       |
|-------------|-----------------------|
| from top    | <input type="radio"/> |
| from bottom | <input type="radio"/> |

### workpiece

description: \_\_\_\_\_

cut height [mm]: \_\_\_\_\_

type of cut:

|        |                       |
|--------|-----------------------|
| single | <input type="radio"/> |
| stack  | <input type="radio"/> |

cutting quality:

|              |                       |
|--------------|-----------------------|
| coarse       | <input type="radio"/> |
| trimming cut | <input type="radio"/> |
| finish cut   | <input type="radio"/> |

for solid wood:

|              |                       |
|--------------|-----------------------|
| with grain   | <input type="radio"/> |
| across grain | <input type="radio"/> |

for wood-based panels:

|          |                       |
|----------|-----------------------|
| sizing   | <input type="radio"/> |
| trimming | <input type="radio"/> |

### tool

cutting diameter D [mm]: \_\_\_\_\_

cutting width B [mm]: \_\_\_\_\_

saw plate thickness b [mm]: \_\_\_\_\_

bore diameter d [mm]: \_\_\_\_\_

### countersinks and recesses

no. of countersinks: \_\_\_\_\_

bore diameter db [mm]: \_\_\_\_\_

countersink diameter ds [mm]: \_\_\_\_\_

position angle  $\alpha$  [°]: \_\_\_\_\_

boring circle diameter Dt [mm]: \_\_\_\_\_

no. of recesses:

|                |     |                  |                  |
|----------------|-----|------------------|------------------|
| double keyway: |     | width bk         | height hk        |
| keyway:        |     | width bk         | height hk        |
| pin holes:     | no. | $\varnothing$ NL | $\varnothing$ TK |

countersinks (per drawing):

cut-outs for hoppers (per drawing):

no. of teeth [pcs.]: \_\_\_\_\_

rakers:

tooth configuration:

|                         |                       |
|-------------------------|-----------------------|
| flat                    | <input type="radio"/> |
| alternate top bevel     | <input type="radio"/> |
| top bevel               | <input type="radio"/> |
| hollow-ground           | <input type="radio"/> |
| triple-chip             | <input type="radio"/> |
| inverted-v              | <input type="radio"/> |
| conical-alternate bevel | <input type="radio"/> |
| hollow-ground / chamfer | <input type="radio"/> |
| triple chip / flat      | <input type="radio"/> |
| ATB / flat              | <input type="radio"/> |

with relieved tool body:

hub location (per drawing):

|   |                       |   |                       |
|---|-----------------------|---|-----------------------|
| A | <input type="radio"/> | B | <input type="radio"/> |
|---|-----------------------|---|-----------------------|

hub diameter D1 [mm]: \_\_\_\_\_

hub width b1 [mm]: \_\_\_\_\_

sense of rotation:

|        |                       |      |                       |
|--------|-----------------------|------|-----------------------|
| right  | <input type="radio"/> | left | <input type="radio"/> |
| single | <input type="radio"/> | set  | <input type="radio"/> |

Check if applicable

## Order / Inquiry for Special Tools: Circular Saw Blades

name: \_\_\_\_\_ city and date: \_\_\_\_\_

### product line

Topline

Proline

Euroline (only portable saw blades)

### cutting material

carbide

Diamond

ST

HS

Please indicate additional dimension and markings in the schematic drawing.

#### tool body

3 double keyway

6 pin hole

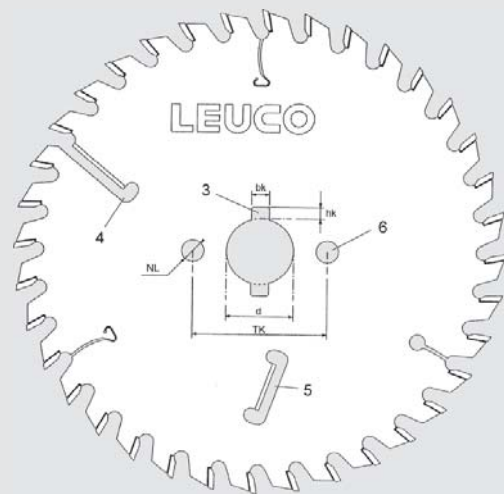
d bore diameter

bk width of keyway

hk height of keyway

TK reference diameter

NL pin hole diameter



#### additional tool body elements:

4 raker with carbide cutting edge enclosed

5 raker with carbide cutting edge open

#### countersink and cut-out for hoppers

1 countersink for countersunk flat headed screw

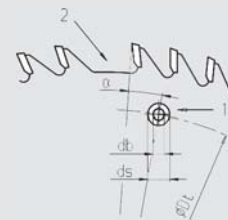
2 cut-out for hoppers

db bore diameter

ds countersink diameter

$\alpha$  position angle

Dt boring circle diameter



#### tool body

D cutting diameter

b saw plate thickness

d bore

D1 hub diameter

b1 hub width

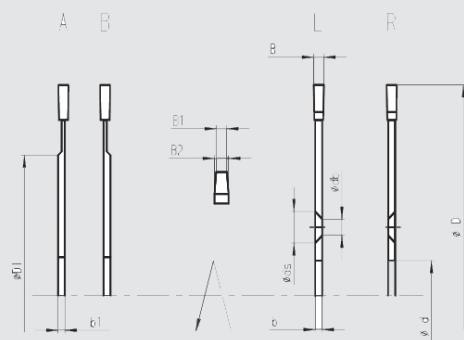
B1 cutting width

B2 cutting width

A/B hub location

db bore diameter

ds countersink diameter



#### sense of rotation

L left

R right

## Checklist for NF customers

|               |       |                  |       |
|---------------|-------|------------------|-------|
| customer-no.: | _____ | contact partner: | _____ |
| company:      | _____ | function:        | _____ |
| plant:        | _____ | phone:           | _____ |
| street:       | _____ | fax:             | _____ |
| zip / city:   | _____ | e-mail:          | _____ |
| country:      | _____ |                  | _____ |

### machine data

make: \_\_\_\_\_

model: \_\_\_\_\_

year of manufacture: \_\_\_\_\_

driving power [kW]: \_\_\_\_\_

RPM [min-1]: min \_\_\_\_\_ max \_\_\_\_\_

type of feed: man  mec

cutting speed vc [m/min] max: \_\_\_\_\_

type of machine:

panel sizing saw: panel height [mm]: \_\_\_\_\_

chop saw: saw blade from top \_\_\_\_\_

from bottom \_\_\_\_\_

other \_\_\_\_\_

### workpiece

workpiece material: \_\_\_\_\_

workpiece material No.: \_\_\_\_\_

workpiece clamping: \_\_\_\_\_

workpiece form: \_\_\_\_\_

(e.g. round, tube, profile, block, etc.)

dimension: \_\_\_\_\_

for profiles, wall thickness [mm]: \_\_\_\_\_

### application data

feed rate vf [m/min]: \_\_\_\_\_

cooling (spraying, dry, etc.): \_\_\_\_\_

cutting speed vc [m/min]: \_\_\_\_\_

rotations per minute (RPM) [min-1]: \_\_\_\_\_

### saw blade in current application

make: \_\_\_\_\_

diameter [mm]: \_\_\_\_\_

bore [mm]: \_\_\_\_\_

cutting height [mm]: \_\_\_\_\_

no. of teeth [pcs.]: \_\_\_\_\_

hook angle [°]: \_\_\_\_\_

cutting material: \_\_\_\_\_

flange diameter [mm]: \_\_\_\_\_

pin holes: \_\_\_\_\_

saw plate thickness b [mm]: \_\_\_\_\_

tooth configuration: \_\_\_\_\_

uneven pitch: yes  no

low-noise design: yes  no

### requirements with regards to cutting quality

cutting time [sec]: \_\_\_\_\_

surface quality: \_\_\_\_\_

tool life (no. of cuts): \_\_\_\_\_

misc.: \_\_\_\_\_

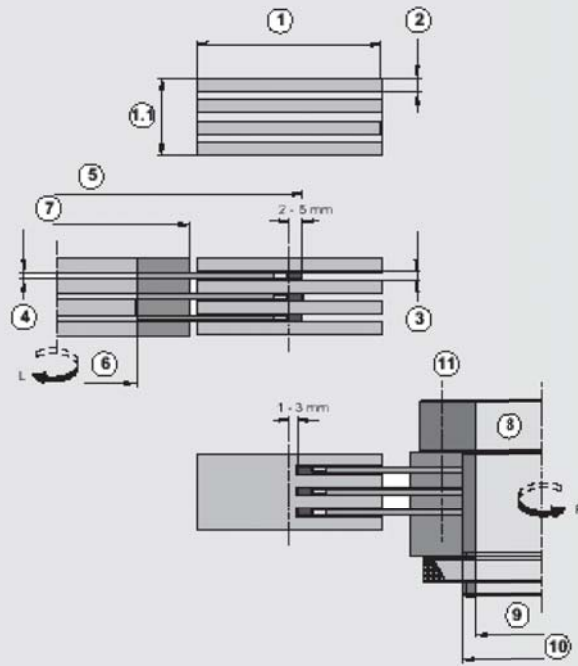
### notes

503-01.0106

## Thin-Kerf Saw Blades on splitting machines

customer-no.: \_\_\_\_\_  
 company: \_\_\_\_\_  
 plant: \_\_\_\_\_  
 street: \_\_\_\_\_  
 zip / city: \_\_\_\_\_  
 country: \_\_\_\_\_

contact partner: \_\_\_\_\_  
 function: \_\_\_\_\_  
 phone: \_\_\_\_\_  
 fax: \_\_\_\_\_  
 e-mail: \_\_\_\_\_



1.1 wood type: \_\_\_\_\_ humidity [%]: \_\_\_\_\_  
 Oslat dimension: thickness \_\_\_\_\_ length [mm]: \_\_\_\_\_  
 1 lamella width [mm]: \_\_\_\_\_  
 2 lamella thickness [mm]: \_\_\_\_\_  
 3 cutting width [mm]: \_\_\_\_\_  
 4 saw plate thickness b [mm]: \_\_\_\_\_  
 5 saw blade diameter [mm]: \_\_\_\_\_  
 6 bore diameter [mm]: \_\_\_\_\_  
 7 flange diameter [mm]: \_\_\_\_\_  
 8 bushing: hydro      yes       no   
 9 bushing inside diameter [mm]: \_\_\_\_\_  
 10 bushing outside diameter [mm]: \_\_\_\_\_  
 11 pin holes: \_\_\_\_\_      DKN: \_\_\_\_\_

no. of saw blades per spindle [pcs.]: \_\_\_\_\_  
 edge saw blade:      yes       no   
 current dimension: \_\_\_\_\_  
 saw blades in current application (dimension): \_\_\_\_\_  
 RPM [min-1]: \_\_\_\_\_  
 feed rate [m/min]: \_\_\_\_\_  
 spindle diameter [mm]: \_\_\_\_\_  
 spindle length [mm]: \_\_\_\_\_  
 driving pin: \_\_\_\_\_  
 spindle / bushing:      top       bottom   
 diameter [mm]: \_\_\_\_\_  
 pitch circle diameter [mm]: \_\_\_\_\_

508-01.1006