

Sawing

Leitz Lexicon Edition 7

Version 2



Explanation of abbreviations








A	= dimension A	LH	= left hand rotation
a_e	= cutting thickness (radial)	M	= metric thread
a_p	= cutting depth (axial)	MBM	= minimum order quantity
ABM	= dimension	MC	= multi-purpose steel, coated
APL	= panel raising length	MD	= thickness of knife
APT	= panel raising depth	min^{-1}	= revolutions per minute (RPM)
AL	= working length	MK	= morse taper
AM	= number of knives	m min^{-1}	= metres per minute
AS	= anti sound (low noise design)	m s^{-1}	= metres per second
b	= overhang	n	= RPM
B	= width	n_{max}	= maximum permissible RPM
BDD	= thickness of shoulder	NAL	= position of hub
BEM	= note	ND	= thickness of hub
BEZ	= description	NH	= zero height
BH	= tipping height	NL	= cutting length
BO	= bore diameter	NLA	= pinhole dimensions
CNC	= Computerized Numerical Control	NT	= grooving depth
d	= diameter	P	= profile
D	= cutting circle diameter	POS	= cutter position
D0	= zero diameter	PT	= profile depth
DA	= outside Diameter	PG	= profile group
DB	= diameter of shoulder	QAL	= cutting material quality
DFC	= Dust Flow Control (optimised chip clearance)	R	= radius
DGL	= number of links	RD	= right hand twist
DIK	= thickness	RH	= right hand rotation
DKN	= double keyway	RP	= radius of cutter
DP	= polycrystalline diamond	S	= shank dimension
DRI	= rotation	SB	= cutting width
FAB	= width of rebate	SET	= set
FAT	= depth of rebate	SLB	= slotting width
FAW	= bevel angle	SLL	= slotting length
FLD	= flange diameter	SLT	= slotting depth
f_z	= tooth feed	SP	= tool steel
$f_{z \text{ eff}}$	= effective tooth feed	ST	= Cobalt-basis cast alloys, e.g. Stellite®
GEW	= thread	STO	= shank tolerance
GL	= total length	SW	= cutting angle
GS	= Plunging edge	TD	= diameter of tool body
H	= height	TDI	= thickness of tool
HC	= tungsten carbide, coated	TG	= pitch
HD	= wood thickness (thickness of workpiece)	TK	= reference diameter
HL	= high-alloyed tool steel	UT	= cutting edges with irregular pitch
HS	= high-speed steel (HSS)	V	= number of spurs
HW	= tungsten carbide (TCT)	v_c	= cutting speed
ID	= ident number	v_f	= feed speed
IV	= insulation glazing	VE	= packing unit
KBZ	= abbreviation	VSB	= adjustment range
KLH	= clamping height	WSS	= workpiece material
KM	= edge breaker	Z	= number of teeth
KN	= single keyway	ZA	= number of fingers
KNL	= combination pinhole consists of 2/7/42 2/9/46,35 2/10/60	ZF	= tooth shape (cutting edge shape)
L	= length	ZL	= finger length
l	= clamping length		
LD	= left hand twist		
LEN	= Leitz standard profiles		

Notes to the Lexicon concerning the diagrams and tables

The statements made in the diagrams and tables relate to specific conditions and represent parameters from tests subjected to defined conditions. Variations when using tools in individual case due to special application conditions may be possible. Our support team will provide you with detailed information.

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mm	mm	mm							mm	mm	mm						
70	2.8	20	8+8	HW	WZ	10	165400	37	160	1.8	20	18	HW	WZ	25	166101	72
80	2.8	20	10+10	HW	FZ	10	165401	37	160	2.2	20	48	HW	FZFA/FZFA	5	161008	78
80	3.3	20	18	DP	HZ/WZ	10	190700	30	160	2.5	20	56	HW	FZ/TR	-5	166350	76
100	2.4	12	30	HW	WZ	10	166109	72	160	2.5	20	24	HW	WZ	15	166117	72
100	2.4	22	30	HW	WZ	10	166110	72	160	2.5	20	48	HW	WZ	15	166118	72
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100	2.8	22	10+10	HW	FZ	10	165403	37	160	2.6	20	48	HW	FZ/TR	5	166300	75
100	3.2	20	20	HW	KON/FZ	5	165625	47	160	2.8	20	16+16	HW	FZ	10	165409	37
100	3.2	22	20	HW	KON/FZ	5	165626	47	160	3.2	20	32	HW	KON/WZ	5	165559	46
100	3.3	22	18	DP	HZ/WZ	10	190730	30	160	3.2	20	4	DP	P	5	190302	80
100	3.5	30	35	HW	WZ/WZ/FZ	15	166000	70	160	4.3	55	30	DP	KON/FZ	10	190566	48
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125	2.8	20	12+12	HW	FZ	10	165407	37	180	2.5	30	35	DP	HZFA/ WZFA	10	190713	69
125	2.8	20	12+12	DP	FZ	10	190695	38	180	2.5	30	24	HW	WZ	15	166123	72
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160	1.8	20	32	HW	WZ	5	166102	72									

D	SB	BO	Z	QAL	ZF	SW	ID	Page	D	SB	BO	Z	QAL	ZF	SW	ID	Page
mm	mm	mm							mm	mm	mm						
180	3.2	65	48	DP	FZ	10	190665	36	200	3.2	30	60	HW	FZ/TR	-5	166356	76
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180	4.4	45	36	HW	KON/WZ	5	165633	47, 50	200	4.3	45	30	DP	KON/FZ	10	190572	48, 50
180	4.5	50	36	HW	KON/WZ	5	165567	46	200	4.3	65	30	DP	KON/FZ	10	190615	48, 52
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180	4.7	45	30	DP	KON/FZ	10	190569	48, 50-51	200	4.4	20	36	HW	KON/WZ	5	165569	46, 51-52
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180	5.8	20	36	HW	KON/FZ	5	165631	47	200	4.4	45	36	HW	KON/WZ	5	165574	46, 50
184	1.8	20	48	HW	FZFA/FZFA	0	163525	77	200	4.4	65	36	HW	KON/WZ	5	165576	46, 52
184	2.5	20	24	HW	WZ	15	166124	72	200	4.4	80	36	HW	KON/FZ	5	165637	47
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190	1.8	30	54	HW	FZFA/FZFA	0	169002	77	200	4.8	20	36	HW	KON/WZ	5	165573	46, 51
190	2.4	20	58	HW	FZFA/FZFA	5	161010	78	200	4.8	45	36	HW	KON/FZ	5	165636	47
190	2.5	30	24	HW	WZ	20	166128	72	200	4.8	65	36	HW	KON/WZ	5	165577	46, 53
190	2.6	20	54	HW	FZ/TR	-5	166353	76	200	5.0	30	60	HW	WZ/WZ/FZ	15	166012	70
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190	2.8	30	68	HW	FZ/TR	-5	166354	76	200	6.2	20	36	HW	KON/WZ	5	165570	46, 51
190	2.8	30	54	HW	FZ/TR	5	166302	75	200	6.8	20	36	HW	KON/FZ	5	165635	47
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200	1.8	60	21	HW	FZ	20	057446	11	210	2.4	30	42	HW	WZ	20	166134	73
200	2.0	16	64	HW	WZ	10	059666	28	210	2.8	30	60	HW	WZ	-5	166252	74
200	2.0	30	24	HW	FZ	20	163575	15	210	2.8	30	60	HW	FZ/TR	-5	166358	76
200	2.4	30	36	HW	WZ	10	163105	26	210	3.2	30	18	HW	FZ	20	165109	18
200	2.4	30	60	HW	WZ	10	163106	26	215	4.4	50	42	HW	KON/WZ	5	165578	46
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200	2.4	30	24	HW	FZ	15	165303	17	216	3.0	30	48	HW	WZ	-5	166254	74
200	2.4	40	24	HW	FZ	20	163550	16	216	3.0	30	64	HW	WZ	-5	166255	74
200	2.5	30	40	DP	HZFA/WZFA	10	190715	69	216	3.0	30	64	HW	FZ/TR	-5	166359	76
200	2.5	30	40	DP	HZFA/WZFA	10	190716	69	220	1.2	60	27	HW	FZ	20	057475	11
200	2.8	20	84	HW	FZ/TR	5	166303	75	220	1.2	65	24	HW	FZ	20	057474	11
200	3.0	30	65	HW	WZ/WZ/FZ	10	161253	68	220	1.3	60	24	HW	FZ	25	057476	11
200	3.0	30	65	HW	WZ/WZ/FZ	10	161254	68	220	1.3	60	32	HW	FZ	25	057478	11
200	3.0	30	24	HW	WZ	10	163107	26	220	1.3	65	24	HW	FZ	25	057477	11
200	3.0	30	48	HW	WZ	10	163108	26	220	1.3	65	32	HW	FZ	25	057479	11
200	3.0	30	60	HW	WZ	10	163109	26	220	1.4	60	32	HW	FZ	20	057464	11
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200	3.0	30	48	HW	WZ	10	166131	73	220	1.4	65	32	HW	FZ	20	057465	11
200	3.2	18	80	HW	FZ/TR	-5	166355	76	220	1.4	65	24	HW	FZ	25	057481	11
									220	2.4	40	24	HW	FZ	20	163551	16
									220	2.5	30	45	DP	HZFA/WZFA	10	190717	69

1. Sawing

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220	2.5	40	45	DP	HZFA/ WZFA	10	190718	69
220	3.0	30	70	HW	WZ/WZ/FZ	10	161255	68
220	3.0	40	70	HW	WZ/WZ/FZ	10	161256	68
220	3.1	45	48	DP	KON/FZ	10	190744	48
220	3.2	30	42	HW	HZ/DZ	-5	163075	32
220	3.2	30	72	HW	FZ/TR	-5	166360	76
220	3.2	30	64	HW	FZ/TR	10	163000	33
220	3.2	30	42	HW	HZ/DZ	10	163050	32
220	3.2	30	36	HW	WZ	10	163110	26
220	3.2	30	60	HW	WZ	10	163111	26
220	3.2	30	60	HW	WZ	10	166107	73
220	3.2	30	34	HW	WZ	15	166136	73
220	3.2	45	60	HW	KON/FZ	5	165638	47
220	3.35	30	48	HW	FZ/TR	10	165676	49
220	3.8	60	24	HW	WZ	20	165260	12
220	3.8	60	24	HW	WZ	20	165262	12
220	3.8	65	24	HW	WZ	20	165261	12
220	5.0	30	24	HW	FZ	20	165251	12
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380	4.8	60	84	HW	TR/TR	15 163358	44, 50

1. Sawing

Quick search

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




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1. Sawing

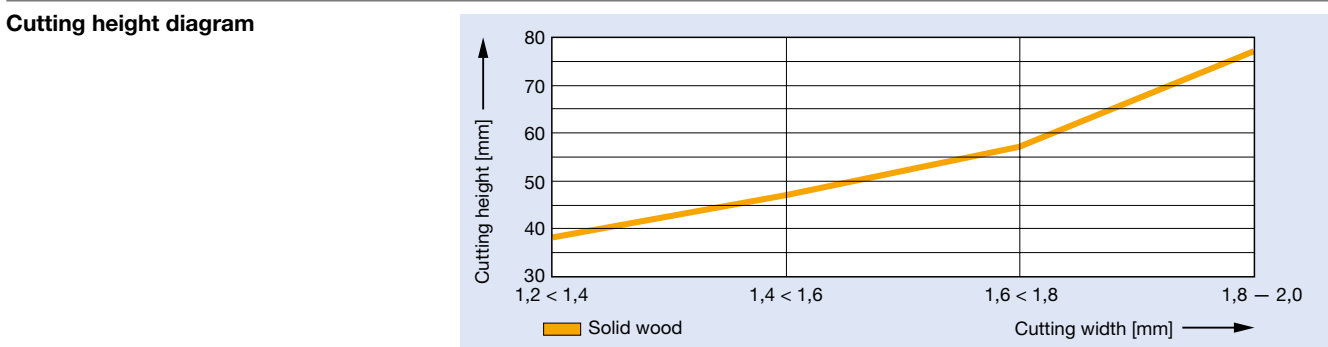
1.1 Solid wood cutting along grain

Application	For splitting or edging timber, for cutting lamellae on horizontal and vertical spindles.
Workpiece material	Softwood and hardwood, wet, frozen, dry or long fibre materials.
Machine	Edging, single blade, multi blade sawblades as well as sawblades with either one or two spindles. Circular saw benches or moulders.

Tooth shape			FZ (square teeth): For multi-purpose application – particularly suitable for wet and dry wood.
			TR (trapezoidal teeth): Recommended for cutting dry wood with minimum marking.
			WZ (alternative top bevel teeth): Ideal for long-fibred wood. Higher quality on the exit surface.

Thin kerf sawblades

Application area	<ul style="list-style-type: none"> - Sawmill industry (laminating strips, lumber etc.). - Solid board production (lamellos and core materials for multiple layer panels etc.). - Parquet flooring industry (for core and surface materials, lamellos). - Moulding products (mouldings, lippings, rulers etc.). - Sport industry (skis, table tennis rackets etc.).
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Thin kerf circular sawblades –
Cutting height depends on the sawblade cutting width SB.

Technical notes	<p>Recommendations:</p> <ul style="list-style-type: none"> - Mount thin kerf sawblades on hydro sleeves. - Check the sawblade clamping flange diameter. - Check the cutting height and the tooth progression (feed rate). - Resharpen and clean resin residues regularly.
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1. Sawing

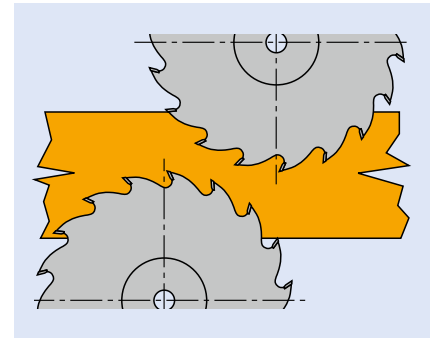
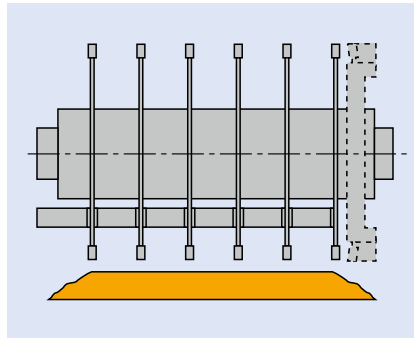
1.1 Solid wood cutting along grain

Advantages

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

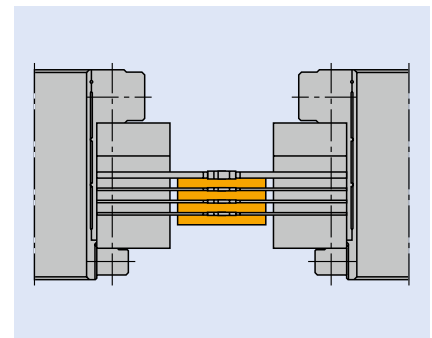
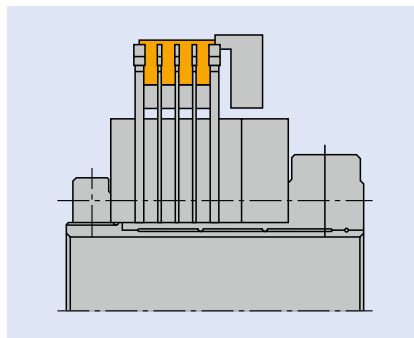
Machine types

Single or multi spindle multi blade machines without automatic feed



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

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

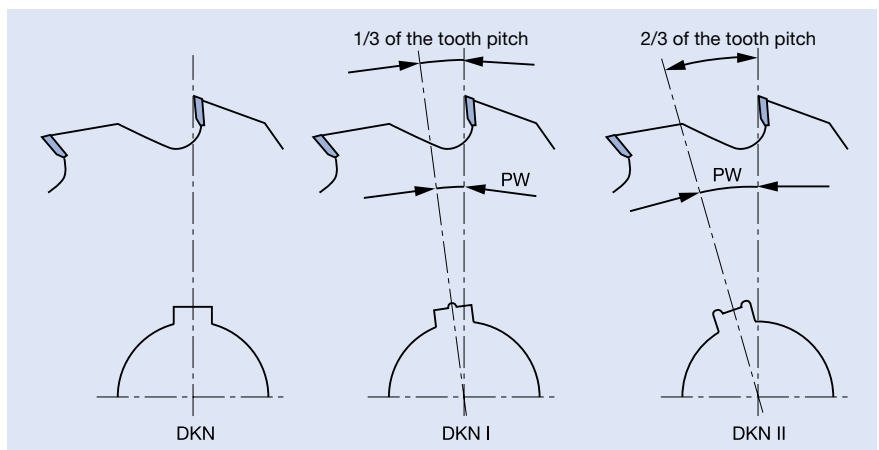


The saw spindle should have high precision bearings for accuracy.

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

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

Position of double keyways for spiral arrangement of circular sawblades



1. Sawing

1.1 Solid wood cutting along grain

1.1.1 Circular sawblades thin kerf



Lamellae cuts *Premium* - middle cut

Application:

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

Machine:

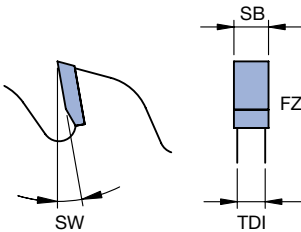
Moulders with/without forced guidance of workpieces. Application on single, double, horizontal or vertical spindles.

Workpiece material:

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

Technical information:

Noise reducing design by irregular tooth pitch. Toolbody without heel. Increased cutting performance and less resin formation by special coated toolbody.



Middle cuts

WK 100 2 21

D	SB	TDI	BO	BO _{max}	NLA	FLD	Z	ZF	SW	WSS	ID
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180	1.3	0.8	60	70	3/10/75	100	32	FZ	20	■	057418 ●
180	1.5	1.0	60	70	3/10/75	100	21	FZ	20	■	057443 ●
180	1.8	1.2	60	70	3/10/75	100	21	FZ	20	■	057444 ●
180	1.8	1.3	60	70	3/10/75	100	32	FZ	20	■	057412 ●
200	1.5	1.0	60	80	3/10/75	120	21	FZ	20	■	057445 ●
200	1.5	1.0	60	80	3/10/75	120	36	FZ	20	■	057421 ●
200	1.8	1.2	60	80	3/10/75	120	21	FZ	20	■	057446 ●
220	1.2	0.9	60	80	3/10/75	120	27	FZ	20	■	057475 ●
220	1.2	0.9	65	80	3/11/80	120	24	FZ	20	■	057474 ●
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220	1.3	0.9	65	80	3/11/80	120	24	FZ	25	■	057477 ●
220	1.3	0.9	65	80	3/11/80	120	32	FZ	25	■	057479 ●
220	1.4	1.0	60	80	3/10/75	120	24	FZ	25	■	057480 ●
220	1.4	1.0	60	80	3/10/75	120	32	FZ	20	■	057464 ●
220	1.4	1.0	65	80	3/11/80	120	24	FZ	25	■	057481 ●
220	1.4	1.0	65	80	3/11/80	120	32	FZ	20	■	057465 ●
225	1.5	1.0	60	110	3/10/75	120	25	FZ	20	■	057447 ●
225	1.6	1.2	60	110	3/10/75	130	32	FZ	25	■	057482 ●
225	1.8	1.2	60	110	3/10/75	120	25	FZ	20	■	057448 ●
225	2.0	1.4	40	110	3/10/75	120	40	FZ	20	■	163600 ●
225	2.0	1.4	60	110	3/10/75	120	25	FZ	20	■	057449 ●
250	1.7	1.2	60	120	3/10/75	140	25	FZ	20	■	057450 ●
250	1.7	1.2	60	120	3/10/75	140	36	FZ	20	■	057433 ●
250	2.0	1.4	60	120	3/10/75	140	25	FZ	20	■	057451 ●
250	2.0	1.4	60	120	3/10/75	140	36	FZ	20	■	057434 ●

1. Sawing

1.1 Solid wood cutting along grain

1.1.1 Circular sawblades thin kerf



Lamello cuts - shoulder cut

Application:

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

Machine:

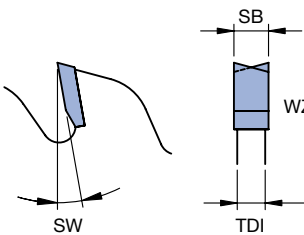
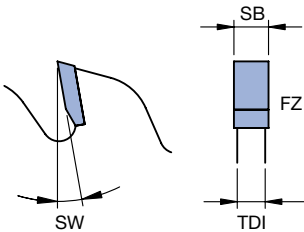
Moulders with/without forced guidance of workpieces. Application on single, double, horizontal or vertical spindles.

Workpiece material:

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

Technical information:

Suitable for utilisation as a set in combination with thin kerf sawblades for middle cuts. Higher cutting performance and less resin formation by special coated toolbody.



Shoulder cuts

WK 100 2 21

D	SB	TDI	BO	NLA	DKN	FLD	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm			°		
200	5.0	4.0	30	3/10/75		120	24	FZ	20	■	165250 ●
220	5.0	4.0	30	3/10/75		120	24	FZ	20	■	165251 ●
225	5.0	4.0	30	3/10/75		120	24	FZ	20	■	165252 ●
225	5.0	4.0	60	3/10/75		120	40	FZ	20	■	165256 ●
250	5.0	4.0	30	3/10/75		140	24	FZ	20	■	165253 ●
250	5.0	4.0	30	3/10/75		140	36	FZ	20	■	165254 ●
250	8.0	6.0	80	4/7/95	13/89	100	24	FZ	15	■	165257 ●
				2/13/100							
300	8.0	6.0	80	4/7/95	13/89	100	24	FZ	15	■	165258 ●
				2/13/100							

Technical information:

Suitable for utilisation as a set in combination with thin kerf sawblades for middle cuts. Special tooth geometry for low cutting forces at low feed rates. Higher cutting performance and less resin formation by special coated toolbody.

Shoulder cuts - reduced number of teeth

WK 150 2, WK 150 2 21

D	SB	TDI	BO	NLA	FLD	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm			°		
180	3.8	3.0	60	3/10/75	100	24	WZ	20	■	165255 ●
				3/11/80						
200	3.8	3.0	60	3/10/75	100	24	WZ	20	■	165259 ●
				3/11/80						
220	3.8	3.0	60	3/10/75	120	24	WZ	20	■	165260 ●
				3/11/80						
220	3.8	3.0	65	3/10/75	120	24	WZ	20	■	165261 ●
				3/11/80						
220	3.8	3.0	60	3/10/75	120	24	WZ	20	■	165262 ●
				3/11/80						
225	3.8	3.0	60	3/10/75	120	24	WZ	20	■	165263 ●
				3/11/80						
250	3.8	3.0	60	3/10/75	120	24	WZ	20	■	165264 ●
				3/11/80						

1. Sawing

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



Circular sawblades with internal and external wiper teeth

Application:

For cutting along grain - shoulder and trimming cuts.

Machine:

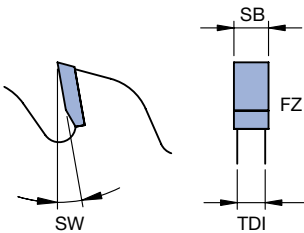
Edging, single blade, multi blade saws as well as saws with one or two spindles.

Workpiece material:

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

Technical information:

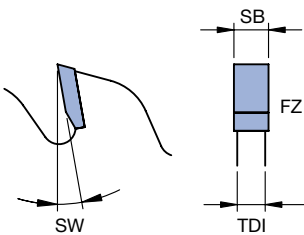
With two internal and external (over D=280 mm) wiper teeth. Large lateral tooth clearance for cuts in wet and frozen wood.



Square and shoulder cuts

WK 150 2

D	SB	TDI	BO	BO _{max}	NLA	DKN	FLD _{max}	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm	mm			°		
250	4.4	2.8	30	80	KNL		130	18	FZ	25	■	165000 ●
250	4.4	2.8	80		19/89	6/5.5/91	130	18	FZ	25	■	165001 ●
					13/89	4/6.6/95						
						2/13/100						
300	5.0	3.2	30	80	KNL		130	20	FZ	25	■	165002 ●
350	5.0	3.2	30	100	KNL		130	24	FZ	25	■	165003 ●
350	5.0	3.2	80	100	19/89	6/5.5/91	130	24	FZ	25	■	165004 ●
					13/89	4/6.6/95						
						2/13/100						
400	5.0	3.2	30	120	KNL		150	28	FZ	25	■	165005 ●
400	5.0	3.2	80	120	19/89	6/5.5/91	150	28	FZ	25	■	165006 ●
					13/89	4/6.6/95						
						2/13/100						
450	5.0	3.2	30	120	KNL		160	28	FZ	25	■	165007 ●



Application:

For cutting along grain - middle cuts.

Middle cuts

WK 100 2 43

D	SB	TDI	BO	BO _{max}	NLA	DKN	FLD _{max}	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm	mm			°		
250	3.5	2.2	30	80	KNL		130	18	FZ	25	■	165008 ●
250	3.5	2.2	80		19/89	6/5.5/91	130	18	FZ	25	■	165009 ●
					13/89	4/6.6/95						
						2/13/100						
300	3.5	2.2	30	80	KNL		110	20	FZ	25	■	165010 ●
300	3.5	2.2	70			21x83	110	20	FZ	25	■	165011 ●
300	3.5	2.2	80			23x90	110	20	FZ	25	■	165012 ●
						13x89						
350	4.0	2.8	30	100	KNL		130	24	FZ	25	■	165013 ●
350	4.0	2.8	80	100	19/89	6/5.5/91	130	24	FZ	25	■	165014 ●
					13/89	4/6.6/95						
						2/13/100						
400	4.0	2.8	30	120	KNL		150	28	FZ	25	■	165015 ●
400	4.0	2.8	80	120	19/89	6/5.5/91	150	28	FZ	25	■	165016 ●
					13/89	4/6.6/95						
						2/13/100						
450	4.4	3.0	30	120	KNL		160	28	FZ	25	■	165017 ●

1. Sawing

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



Circular sawblades with internal and external wiper teeth

Application:

For cutting along grain - middle cuts.

Machine:

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

Workpiece material:

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

Technical information:

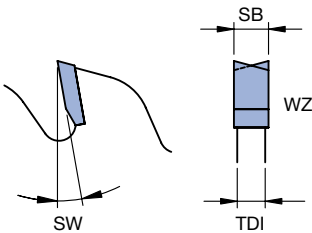
With two external and two or four (over D-320 mm) internal wiper teeth.



Middle cuts - dry

WK 150 2

D	SB	TDI	BO	BO _{max}	NLA	DKN	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm			°		
250	3.2	2.2	70			20.6/83	20	WZ	20	■	165200 ●
300	3.2	2.2	70	80		20.6/83	24	WZ	20	■	165201 ●
320	3.2	2.2	70	80		20.6/83	28	WZ	20	■	165202 ●
350	3.5	2.5	70	100		20.6/83	28	WZ	20	■	165203 ●
400	4.0	2.8	70	100		20.6/83	24	WZ	20	■	165204 ●
500	5.0	3.5	30	100	KNL		28	WZ	20	■	165205 ●



1. Sawing

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



Lamellae cuts - horizontal spindle - external wiper teeth

Application:

For cutting of thin slats on horizontal spindles.

Machine:

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

Workpiece material:

Softwood, dry up to 10% wood moisture content.

Technical information:

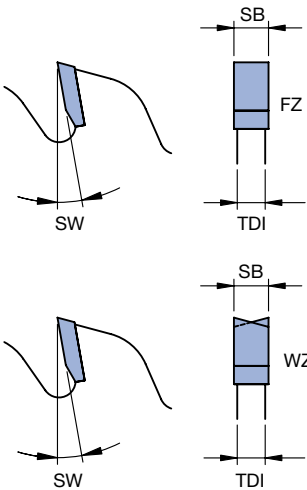
With two external wiper teeth. Higher cutting performance and less resin build up by special coated tool body.



Lamellae cuts on horizontal spindles

WK 100 2, WK 150 2

D	SB	TDI	BO	DKN	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
200	2.0	1.4	30		24	FZ	20	■	163575 ●
250	2.0	1.4	80	19/89	36	WZ	15	■	163576 ●
250	2.4	1.6	80	19/89	32	WZ	15	■	163577 ●
300	2.8	1.8	80	19/89	28	WZ	15	■	163578 ●



1. Sawing

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



Lamellae cuts - horizontal spindle - internal wiper teeth

Application:

For cutting of thin slats on horizontal spindles.

Machine:

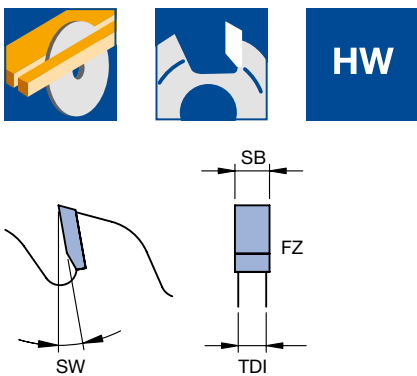
Edging, single blade, multi blade saws as well as saws or moulders with one or two spindles.

Workpiece material:

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

Technical information:

With internal wiper teeth. Efficient energy and wood use by reduced cutting widths.



Lamellae cuts on horizontal spindles

WK 100 4 , WK 100 2

D	SB	TDI	BO	BO _{max}	DKN	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm			°		
200	2.4	1.6	30			24	FZ	25	■	163560 ●
200	2.4	1.6	40	60		24	FZ	20	■	163550 ●
220	2.4	1.6	30			24	FZ	25	■	163559 ●
220	2.4	1.6	40	80		24	FZ	20	■	163551 ●
250	2.4	1.6	30			24	FZ	20	■	163558 ●
250	2.4	1.6	40	90		24	FZ	20	■	163552 ●
250	2.4	1.6	70		21/83	24	FZ	20	■	163553 ●
250	2.4	1.6	80		19x89 13x89	24	FZ	20	■	163554 ●
300	2.8	1.8	30	100		30	FZ	25	■	163555 ●
300	2.8	1.8	80		19x89 13x89	30	FZ	25	■	163556 ●
350	2.8	1.8	30	110		30	FZ	25	■	163557 ●



Lamellae cuts - vertical spindle

Application:

For cutting of thin slats on vertical spindles.

Machine:

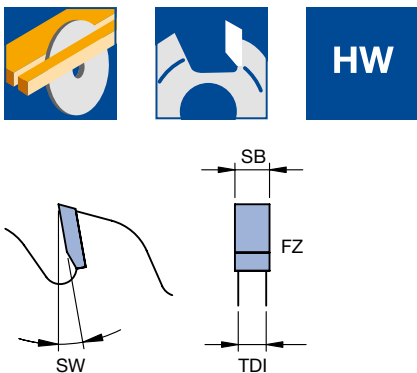
Edging, single blade, multi blade saws as well as saws or moulders with one or two spindles.

Workpiece material:

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

Technical information:

With two external and two internal wiper teeth. Higher cutting performance and less resin build up by special coated tool body.



Lamellae cuts on vertical spindles

WK 100 2

D	SB	TDI	BO	BO _{max}	NLA	FLD _{max}	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm			°		
250	2.4	1.6	60	80	3/10/75	120	24	FZ	20	■	163700 ●
250	2.4	1.6	60	80	3/10/75	120	40	FZ	20	■	163701 ●
270	2.4	1.6	60	80	3/10/75	120	28	FZ	20	■	163702 ●

1. Sawing

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



Lamellae cuts - horizontal spindle

Application:

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

Machine:

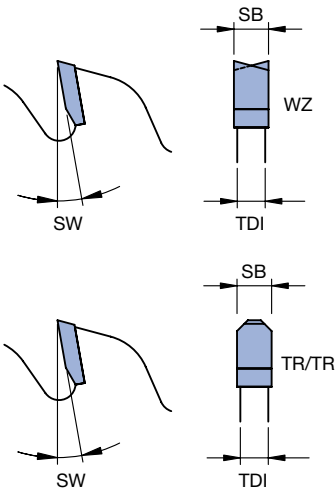
Single blade, multi blade saws as well as saws and moulders with one or two spindles.

Workpiece material:

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

Technical information:

Special tooth geometry for glueable cutting surface. Noise reducing design by irregular tooth pitch. Tool body without recess. Higher cutting performance and less resin build up by special coated tool body.



Lamellae cuts on horizontal spindles

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

Machine	D	SB	TDI	BO	BO _{max}	NLA	DKN	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm	mm	mm			°		
	180	2.2	1.4	30	60	3/10/75		18	FZ	15	■	165300 ●
	180	2.4	1.6	30	60	3/10/75		24	FZ	15	■	165301 ●
	200	2.4	1.6	30	60	3/10/75		18	FZ	15	■	165302 ●
	200	2.4	1.6	30	60	3/10/75		24	FZ	15	■	165303 ●
	225	2.4	1.6	30	60	3/10/75		24	FZ	15	■	165304 ●
	225	2.8	2.0	30	60	3/10/75		24	FZ	15	■	165305 ●
	240	2.8	2.0	40	60	3/10/75		24	FZ	15	■	165306 ●
Raimann	250	2.4	1.6	80		6/5.5/91	19/89	40	WZ	15	■	165309 ●
						4/6.6/95	13/89					
						2/13/100						
	250	2.8	2.0	30	100	3/10/75		24	FZ	15	■	165307 ●
	250	2.8	2.0	70	100		21/80	24	FZ	15	■	165308 ●
Raimann	300	2.8	1.8	80		6/5.5/91	19/89	28	WZFA	15	■	165310 ●
						4/6.6/95	13/89					
						2/13/100						
Raimann	300	2.8	1.8	80		6/5.5/91	19/89	48	TR/TR	15	■	165311 ●
						4/6.6/95	13/89					
						2/13/100						
Raimann	300	3.4	2.2	80		6/5.5/91	19/89	28	FZ	15	■	165312 ●
						4/6.6/95	13/89					
						2/13/100						
Raimann	300	4.0	2.8	80		6/5.5/91	19/89	28	TR/TR	15	■	165313 ●
						4/6.6/95	13/89					
						2/13/100						
Raimann	300	4.0	2.8	80		6/5.5/91	19/89	48	TR/TR	15	■	165314 ●
						4/6.6/95	13/89					
						2/13/100						

1. Sawing

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



Shoulder and square cuts - middle cut

Application:

For cutting along grain - shoulder and trimming cuts.

Machine:

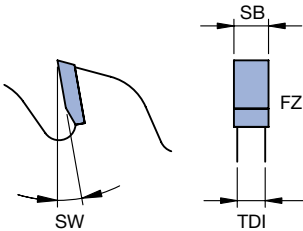
Edging, single blade, multi blade saws as well as saws with one or two spindles.

Workpiece material:

Softwood and hardwood wet and dry.

Technical information:

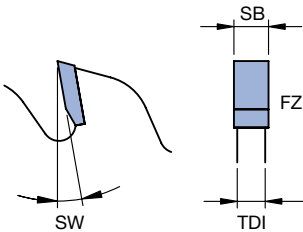
Large chip gullet and big lateral tooth clearance for cuts in wet wood.



Shoulder and square cuts

WK 100 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
200	4.0	2.6	30	KNL	18	FZ	25	■	165100 ●
250	4.0	2.6	30	KNL	18	FZ	20	■	165101 ●
300	4.0	2.6	30	KNL	24	FZ	20	■	165102 ●
350	4.4	3.0	30	KNL	24	FZ	20	■	165104 ●
400	5.0	3.2	30	KNL	28	FZ	20	■	165105 ●
450	5.0	3.2	30	KNL	28	FZ	20	■	165106 ●
500	5.0	3.2	30	KNL	32	FZ	20	■	165107 ●



Middle cuts

WK 100 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
200	3.2	2.2	30	KNL	18	FZ	25	■	165108 ●
210	3.2	2.2	30	KNL	18	FZ	20	■	165109 ●
250	3.2	2.2	30	KNL	18	FZ	20	■	165110 ●
300	3.2	2.2	30	KNL	24	FZ	20	■	165111 ●
350	3.2	2.2	30	KNL	24	FZ	20	■	165113 ●
400	4.0	2.8	30	KNL	28	FZ	20	■	165114 ●
450	4.0	2.8	30	KNL	28	FZ	20	■	165115 ●
500	4.0	2.8	30	KNL	32	FZ	20	■	165116 ●

1. Sawing

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



Sizing solid wood along grain

Application:

For cutting along grain - sizing wood and wood derived materials.

Machine:

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

Workpiece material:

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

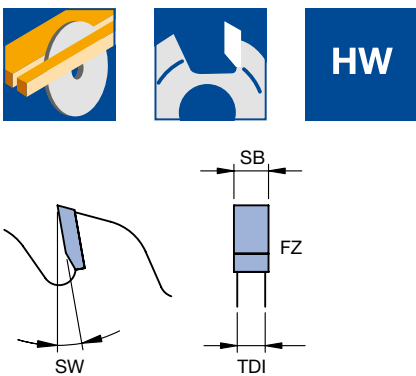
Technical information:

Design with chip thickness limitation.

Circular sawblade FZ with thickness limitation

WK 100 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
250	3.2	2.2	30	KNL	18	FZ	20	■	166050 ●
300	3.5	2.4	30	KNL	14	FZ	20	■	166051 ●
350	3.5	2.4	30	KNL	16	FZ	20	■	166052 ●
400	4.0	2.8	30	KNL	18	FZ	20	■	166053 ●
450	4.0	2.8	30	KNL	20	FZ	20	■	166054 ●
500	4.0	2.8	30	KNL	24	FZ	20	■	166055 ●



Universal sizing

Application:

For multi-purpose application in solid wood and wood derived materials.

Machine:

Trimming and cross cutting saws.

Workpiece material:

Softwood and hardwood wet and dry.

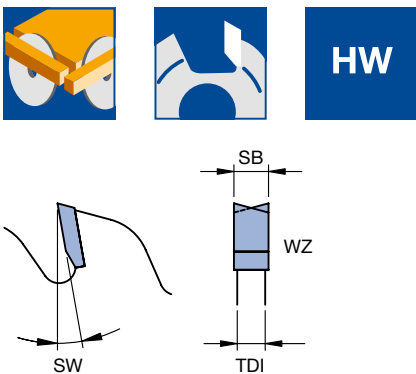
Technical information:

Design with chip thickness limitation.

Circular sawblade WZ with thickness limitation

WK 150 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
250	3.2	2.2	30	KNL	24	WZ	20	■ ■	166076 ●
300	3.2	2.2	30	KNL	28	WZ	20	■ ■	166077 ●
350	3.2	2.2	30	KNL	32	WZ	20	■ ■	166078 ●
400	4.0	2.8	30	KNL	36	WZ	20	■ ■	166079 ●
450	4.0	2.8	30	KNL	42	WZ	20	■ ■	166080 ●
500	4.0	2.8	30	KNL	48	WZ	20	■ ■	166081 ●
550	4.8	3.5	30	KNL	54	WZ	20	■ ■	166082 ●
600	4.8	3.5	30	KNL	60	WZ	20	■ ■	166083 ●
700	4.8	3.5	30	KNL	60	WZ	20	■ ■	166084 ●

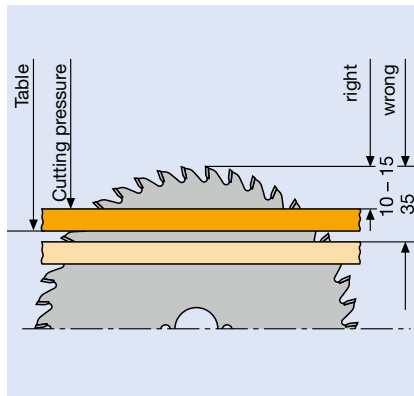


1. Sawing

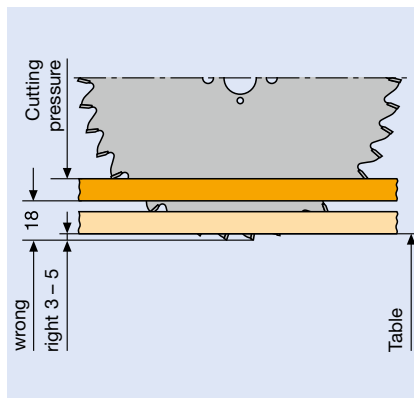
1.2 Solid wood cutting across grain

Application area	For trim, cross, mitre and sizing cuts.
Workpiece material	Solid wood with or without coating, plywood, glulam, solid surface materials.
Machine	Combined table, mitre, radial, underfloor and optimising saws.

Application

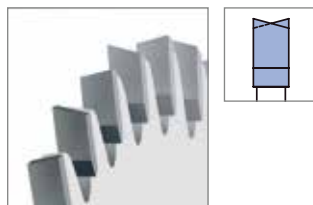


The cutting force of sawblades with a positive cutting angle and the spindle below the workpiece or for sawblades with a negative cutting angle and the spindle above the workpiece. Press the material onto the table.



On radial saws, the use of sawblades with a negative cutting angle cutting against the feed is obligatory (see EN 1870-17). The negative cutting angle presses the material onto the table.

Tooth shape



WZ (alternative top bevel teeth): Multi purpose tooth shape, economical to purchase and maintain – suitable for solid wood and wood derived materials.



Trimming at high feed rates

Application:

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

Machine:

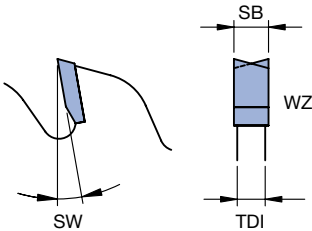
Cross, trimming and optimising saws.

Workpiece material:

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

Technical information:

Large lateral tooth clearance and a high number of teeth. Stable corner angle of 20° for tear-free cutting results and long tool life.



Trimming at high feed rates

WK 150 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
400	3.5	2.8	30	2/10/60 2/15/63	120	WZ	10	■	165450 ●
450	4.8	3.5	30	2/10/60 2/15/63	138	WZ	10	■	165451 ●
450	5.0	3.2	30	2/10/60 2/15/63	108	WZ	10	■	165452 ●
500	4.8	3.5	30	2/10/60 2/15/63	144	WZ	10	■	165454 ●
500	4.8	3.5	35	2/10/60 2/15/63	144	WZ	10	■	165455 □
500	5.2	3.2	30	2/10/60 2/15/63	120	WZ	10	■	165453 ●
520	4.6	3.4	30	2/10/60 2/15/63	144	WZ	10	■	165456 ●
550	5.0	3.2	30	2/10/60 2/15/63	96	WZ	10	■	165457 ●
550	5.2	3.2	30	2/10/60 2/15/63	120	WZ	10	■	165459 ●
550	5.2	3.2	30	2/10/60 2/15/63	160	WZ	10	■	165458 ●
600	5.4	4.0	30	2/10/60 2/15/63	172	WZ	10	■	165461 ●
600	5.8	4.0	30	2/10/60 2/15/63	108	WZ	10	■	165460 ●
630	5.4	4.4	30	2/10/60 2/15/63	180	WZ	10	■	165462 ●



Trimming with negative cutting angle

Application:

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

Machine:

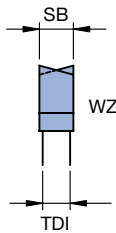
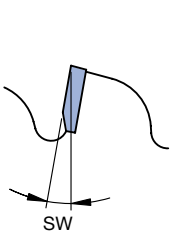
Cross, trimming, mitre and radial saws as well as double mitre cutting saws.

Workpiece material:

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

Technical information:

Specially for manually operated machines. Position of spindle above the workpiece.



Circular sawblade WZ with neg. cutting angle

WK 160 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
300	3.2	2.4	30	KNL	36	WZ	-5	■	165500 ●
300	3.2	2.4	30	KNL	60	WZ	-5	■	165501 ●
300	3.2	2.4	30	KNL	96	WZ	-5	■	165502 ●
305	3.2	2.4	30	KNL	60	WZ	-5	■	165503 ●
350	3.2	2.4	30	KNL	36	WZ	-5	■	165504 ●
350	3.2	2.4	30	KNL	60	WZ	-5	■	165505 ●
350	3.5	2.8	30	KNL	108	WZ	-5	■	165506 ●
355	3.2	2.4	30	KNL	72	WZ	-5	■	165507 ●
400	3.8	2.8	30	KNL	42	WZ	-5	■	165508 ●
400	3.8	2.8	30	KNL	60	WZ	-5	■	165509 ●
400	3.8	2.8	30	KNL	120	WZ	-5	■	165510 ●
450	3.8	2.8	30	KNL	48	WZ	-5	■	165511 ●
500	4.4	3.2	30	KNL	54	WZ	-5	■	165512 ●

1. Sawing

1.2 Solid wood cutting across grain

1.2.2 Circular sawblades WZ with neg. cutting angle



Trimming with negative cutting angle *Excellent*

Application:

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

Machine:

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

Workpiece material:

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

Technical information:

Specially for manually operated machines. Position of spindle above the workpiece.

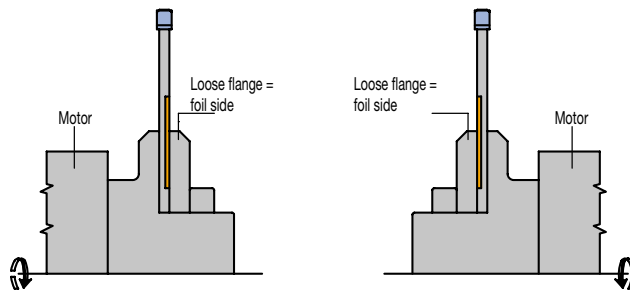
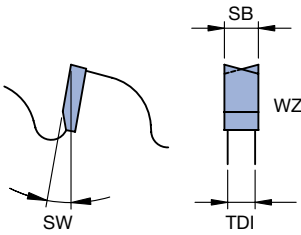
Excellent design. Tool body with vibration damping steel foil.



Circular sawblade WZ with neg. cutting angle

WK 180 2

D	SB	TDI	BO	NLA	Z	ZF	SW	Foil	WSS	ID
mm	mm	mm	mm	mm			°			
300	3.5	2.6	30	KNL	96	WZ	-5	left	■	161330 ●
300	3.5	2.6	30	KNL	96	WZ	-5	right	■	161331 ●
350	3.5	2.6	30	KNL	108	WZ	-5	left	■	161332 ●
350	3.5	2.6	30	KNL	108	WZ	-5	right	■	161333 ●
400	3.5	2.6	30	KNL	120	WZ	-5	left	■	161334 ●
400	3.5	2.6	30	KNL	120	WZ	-5	right	■	161335 ●





Trimming, crossing and mitre cuts

Application:

For cross cutting, trimming and angled cuts.

Machine:

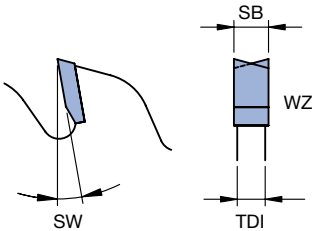
Cross and trimming saws and CNC controlled joinery machines, cross cutting twin saws.

Workpiece material:

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

Technical information:

Large lateral tooth clearance.



Circular sawblade WZ

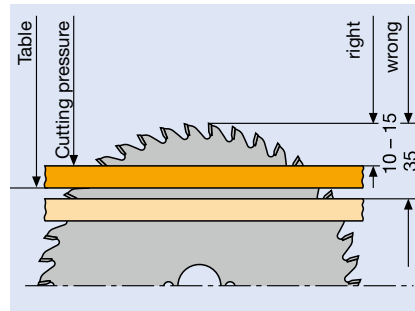
WK 150 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
Routech	440	7.0	4.0	75	6/9/100	12+2+2	WZ	20	■	165326 ●
					2/8.5/100					
Routech	500	4.4	3.2	75	2/8.5/100	28+2+2+2	WZ	20	■	165328 ●
					6/10.6/100					
Routech	500	7.0	4.0	75	6/9/100	14+2+2+2	WZ	20	■	165327 ●
					2/8.5/100					
Essetre	520	5.4	3.5	60	8/6.5/100	72	WZ	20	■	165332 ●
Weinmann	555	5.2	3.6/6	55	6/7/75	54+2+2	WZ	20	■	165325 ●
Essetre	600	5.4	3.5	80	8/9.5/120	72	WZ	20	■	165333 ●
	600	6.0	4.0	30	2/14/400	48	WZ	15	■	057570 ●
Routech	600	7.0	4.0	75	6/9/125	16+2+2+2	WZ	20	■	165329 ●
					2/8.5/125					
	630	5.0	3.6	30	2/10/160	62	WZ	15	■	057567 ●
					2/14/400					
Uniteam	640	5.4	3.6	30	8/6.5/160	36+2+2	WZ	20	■	165330 ●
					8/6.5/130					
					4/10.5/90					
	700	6.0	4.4	30		72	WZ	15	■	165334 ●
	750	6.0	4.4	30		72	WZ	15	■	165335 ●
	800	6.0	4.4	30		72	WZ	15	■	165336 ●
Uniteam	850	8.0	6.0	30	8/6.5/160	60+2+2+2	WZ	20	■	165331 ●
					8/6.5/130					
					4/10.5/90					

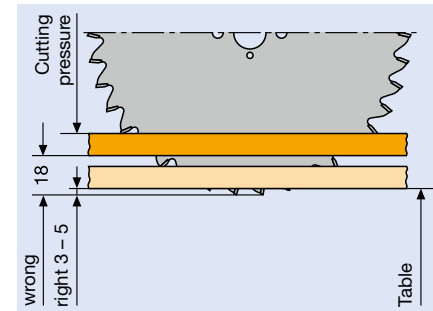
1. Sawing

1.3 Sizing

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



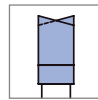
The positive cutting angle presses the material onto the table for sawblades with a positive cutting angle and the spindle below the workpiece.



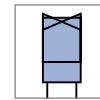
The negative cutting angle presses the material onto the table for sawblades with a negative cutting angle and the spindle above the workpiece.

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

Tooth shape



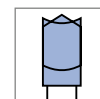
WZ (alternative top bevel teeth):
Multi-purpose tooth shape, economical to purchase and maintain. Ideal for chipboard, veneered chipboard, solid wood, block board, plywood.



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



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



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

1. Sawing

1.3 Sizing

1.3.1 Sizing sawblades WZ



Sizing *Premium*

Application:

For sizing and cross cutting with/without scoring.

Machine:

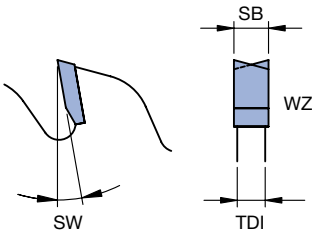
Table and sizing saws.

Workpiece material:

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

Technical information:

Premium design with vibration damping ornaments (over D-200). Marked dimensions with irregular tooth pitch (UT).



Sizing sawblade WZ

WK 170 2

D	SB	TDI	BO	NLA	Z	ZF	Type	SW	WSS	ID
mm	mm	mm	mm	mm				°		
150	3.2	2.2	30		48	WZ		10	■ ■	163100 ●
180	2.4	1.6	30		30	WZ	UT	10	■ ■	163101 ●
180	3.0	2.0	30		24	WZ	UT	10	■ ■	163102 ●
180	3.2	2.2	30		58	WZ		10	■ ■	163103 ●
180	3.5	2.5	30		30	WZ	UT	10	■ ■	163104 ●
200	2.4	1.6	30	KNL	36	WZ	UT	10	■ ■	163105 ●
200	2.4	1.6	30	KNL	60	WZ		10	■ ■	163106 ●
200	3.0	2.0	30	KNL	24	WZ	UT	10	■ ■	163107 ●
200	3.0	2.0	30	KNL	48	WZ	UT	10	■ ■	163108 ●
200	3.0	2.0	30	KNL	60	WZ		10	■ ■	163109 ●
220	3.2	2.2	30	KNL	36	WZ	UT	10	■ ■	163110 ●
220	3.2	2.2	30	KNL	60	WZ		10	■ ■	163111 ●
250	2.4	1.6	30	KNL	40	WZ	UT	10	■ ■	163112 ●
250	2.4	1.6	30	KNL	80	WZ		10	■ ■	163113 ●
250	3.2	2.2	30	KNL	40	WZ	UT	10	■ ■	163114 ●
250	3.2	2.2	30	KNL	60	WZ	UT	10	■ ■	163115 ●
250	3.2	2.2	30	KNL	80	WZ		10	■ ■	163116 ●
300	2.4	1.6	30	KNL	48	WZ	UT	10	■ ■	163117 ●
300	2.4	1.6	30	KNL	96	WZ		10	■ ■	163118 ●
300	3.2	2.2	30	KNL	36	WZ	UT	10	■ ■	163119 ●
300	3.2	2.2	30	KNL	48	WZ	UT	10	■ ■	163120 ●
300	3.2	2.2	30	KNL	72	WZ	UT	10	■ ■	163121 ●
300	3.2	2.2	30	KNL	96	WZ		10	■ ■	163122 ●
350	3.5	2.5	30	KNL	32	WZ	UT	10	■ ■	163134 ●
350	3.5	2.5	30	KNL	54	WZ	UT	10	■ ■	163123 ●
350	3.5	2.5	30	KNL	72	WZ	UT	10	■ ■	163124 ●
350	3.5	2.5	30	KNL	84	WZ	UT	10	■ ■	163125 ●
350	3.5	2.5	30	KNL	108	WZ		10	■ ■	163126 ●
400	3.5	2.5	30	KNL	48	WZ	UT	10	■ ■	163127 ●
400	3.5	2.5	30	KNL	60	WZ	UT	10	■ ■	163128 ●
400	3.5	2.5	30	KNL	84	WZ	UT	10	■ ■	163129 ●
400	3.5	2.5	30	KNL	96	WZ	UT	10	■ ■	163130 ●
400	3.5	2.5	30	KNL	120	WZ		10	■ ■	163131 ●
450	3.8	2.8	30	KNL	66	WZ	UT	10	■ ■	163132 ●
500	3.8	2.8	30	KNL	72	WZ	UT	10	■ ■	163133 ●

1. Sawing

1.3 Sizing 1.3.1 Sizing sawblades WZ



Sizing without scoring *Premium* - Mamba

Application:

For sizing and cross cutting without scoring.

Machine:

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

Workpiece material:

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

Technical information:

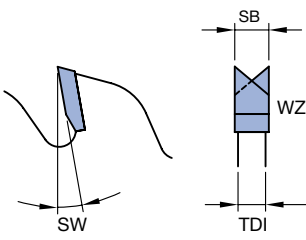
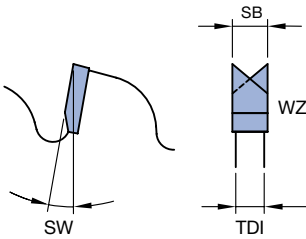
Special WZ with 40° corner angle for tear-free cuts on both sides. **Premium** design with vibration damping laser ornaments.



Circular sawblade Mamba, negative cutting angle

WK 880 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
250	3.2	2.2	30	KNL	80	WZ	-5	■	163225 ●
303	3.5	2.5	30	KNL	96	WZ	-5	■	163226 ●



Technical information:

Special WZ with 40° corner angle for tear-free cuts on both sides. **Premium** design with vibration damping laser ornaments.

Circular sawblade Mamba, positive cutting angle

WK 870 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
300	3.5	2.5	30	KNL	96	WZ	5	■	163200 ●
350	3.5	2.5	30	KNL	108	WZ	5	■	163201 ●

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



Sizing and cutting veneer stacks - reduced cutting width

Application:

For sizing and cross cutting with and without scoring.

Machine:

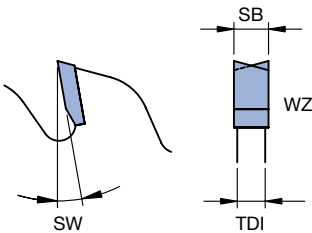
Table, sizing and veneer cutting saws.

Workpiece material:

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

Technical information:

Reduced cutting width and special designed tool body. Less cutting and feed forces are necessary.



Circular sawblade WZ

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

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
160	1.8	1.0/2.5	16	1/6/33	48	WZ	10	■	060574 ●
180	1.6	1.0/2.5	16	1/6/33	56	WZ	10	■	060591 ●
180	2.4	1.6	16	KNL	58	WZ	10	■	059665 ●
200	2.0	1.4	16	KNL	64	WZ	10	■	059666 ●
250	1.7	1.0/2.4	30	KNL	80	WZ	10	■	058520 ●
300	1.7	1.0/2.4	30	KNL	96	WZ	10	■	058521 ●
450	3.0	2.2	30	2/14/125 KNL	120	WZ	20	■	058461 ●



Sizing without scoring *Excellent* - Katana

Application:

For sizing and cross cutting without scoring.

Machine:

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

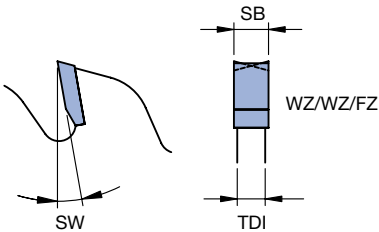
Workpiece material:

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

Technical information:

Katana tooth combination with alternate angle of cutting face for best cutting results.

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



Circular sawblade Katana

WK 879 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
255	2.8	2.0	30	KNL	80	WZ/WZ/FZ	10		161200 ●
303	3.2	2.2	30	KNL	100	WZ/WZ/FZ	10		161201 ●
355	3.0	2.2	30	KNL	120	WZ/WZ/FZ	10		161202 ●
400	3.2	2.5	30	KNL	130	WZ/WZ/FZ	20		161203 ●
450	3.6	2.8	30	KNL	140	WZ/WZ/FZ	20		161204 ●
500	4.0	3.5	30	KNL	150	WZ/WZ/FZ	20		161205 ●
550	4.0	3.5	30	KNL	160	WZ/WZ/FZ	20		161206 ●



Sizing *Excellent* - WhisperCut

Application:

For sizing and trimming with scoring.

Machine:

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

Workpiece material:

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

Technical information:

Extreme noise reduction. Special design and grouping of teeth for perfect cuts and reduced cutting forces. **Excellent** design with plastic filled laser ornaments for vibration damping and reduction of noise level. Stable tooth geometry for a long tool life. Universal use for various materials. Resharpenable two times.

Circular sawblade WhisperCut

WK 879 2 DP

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
250	3.2	2.4	30	KNL	50	HZFA/WZFA	10		190697 ●
303	3.2	2.4	30	KNL	60	HZFA/WZFA	10		190698 ●
350	3.2	2.4	30	KNL	70	HZFA/WZFA	10		190699 ●

Application:

For scoring with feed.

Machine:

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

Workpiece material:

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

Scoring sawblade

WK 272 2

D	SB	BO	Z	ZF	SW	WSS	ID
mm	mm	mm			°		
80	3.3	20	18	HZ/WZ	10		190700 ●
100	3.3	22	18	HZ/WZ	10		190730 ●
120	3.3	20	18	HZ/WZ	10		190701 ●
120	3.3	22	18	HZ/WZ	10		190702 ●
125	3.3	20	18	HZ/WZ	10		190703 ●

1. Sawing

1.3 Sizing

1.3.4 Sizing sawblades HZ/DZ



Sizing without scoring *Excellent*

Application:

For sizing and cross cutting without scoring.

Machine:

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

Workpiece material:

Chipboard and fibre materials plastic and paper coated, veneered.

Technical information:

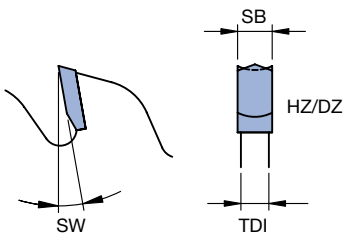
Excellent design with plastic filled laser ornaments for vibration damping and reduction of noise level.



Circular sawblade

WK 874 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
250	3.2	2.2	30	KNL	54	HZ/DZ	10	■	161300 ●
303	3.2	2.2	30	KNL	68	HZ/DZ	10	■	161301 ●
350	3.5	2.5	30	KNL	80	HZ/DZ	10	■	161302 ●





Sizing without scoring *Premium*

Application:

For sizing and cross cutting without scoring.

Machine:

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

Workpiece material:

Chipboard and fibre materials plastic and paper coated, veneered.

Technical information:

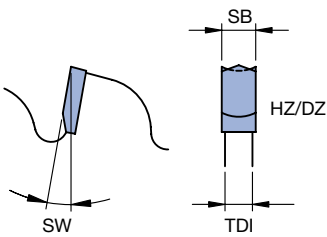
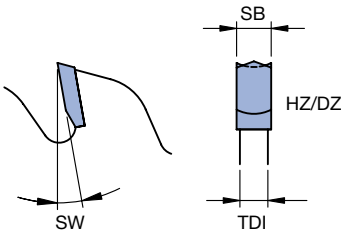
Premium design with vibration damping laser ornaments.

Circular sawblade, positive cutting angle

WK 274 2



D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
220	3.2	2.2	30	KNL	42	HZ/DZ	10	■	163050 ●
250	3.2	2.2	30	KNL	48	HZ/DZ	10	■	163051 ●
303	3.2	2.2	30	KNL	60	HZ/DZ	10	■	163054 ●
303	3.5	2.5	30	KNL	60	HZ/DZ	10	■	163052 ●
350	3.5	2.5	30	KNL	72	HZ/DZ	10	■	163053 ●



Machine:

Vertical panel sizing saws without scoring unit.

Technical information:

Premium design with vibration damping laser ornaments. Better cutting edge at the exit side of the sawblade by negative cutting angle.

Circular sawblade, negative cutting angle

WK 864 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
220	3.2	2.2	30	KNL	42	HZ/DZ	-5	■	163075 ●
250	3.2	2.2	30	KNL	48	HZ/DZ	-5	■	163076 ●
303	3.2	2.2	30	KNL	60	HZ/DZ	-5	■	163077 ●

1. Sawing

1.3 Sizing

1.3.5 Sizing sawblades FZ/TR



Sizing with scoring *Premium*

Application:

For sizing and trimming with scoring.

Machine:

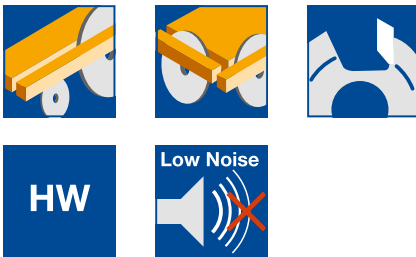
Table and sizing saws, vertical panel sizing saws with scoring unit.

Workpiece material:

Chipboard and fibre materials, paper and plastic coated.

Technical information:

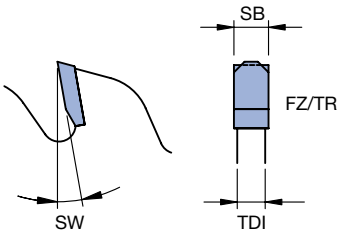
Premium design with vibration damping laser ornaments. Marked dimensions with irregular tooth pitch (UT).



Circular sawblade

WK 852 2

D	SB	TDI	BO	NLA	Z	ZF	Type	SW	WSS	ID
mm	mm	mm	mm	mm				°		
220	3.2	2.2	30	KNL	64	FZ/TR		10	■	163000 ●
250	3.2	2.2	30	KNL	60	FZ/TR	UT	10	■	163002 ●
250	3.2	2.2	30	KNL	80	FZ/TR		10	■	163003 ●
280	3.2	2.2	30	KNL	60	FZ/TR	UT	10	■	163004 ●
300	3.2	2.2	30	KNL	72	FZ/TR	UT	10	■	163005 ●
300	3.2	2.2	30	KNL	96	FZ/TR		10	■	163006 ●
350	3.5	2.5	30	KNL	84	FZ/TR	UT	10	■	163007 ●
350	3.5	2.5	30	KNL	108	FZ/TR		10	■	163008 ●





Sizing

Application:

For sizing and cross cutting with and without scoring.

Machine:

Table and sizing saws.

Workpiece material:

Solid wood along grain.

Technical information:

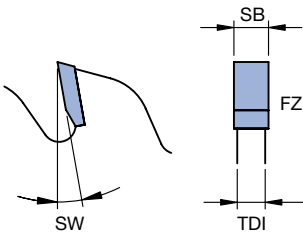
Reduced number of teeth and large gullet for deep cutting depths.

Circular sawblade FZ

WK 120 2



D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
350	3.5	2.5	30	KNL	12	FZ	20	■	163025 ●
400	3.5	2.5	30	KNL	14	FZ	20	■	163026 ●
450	3.8	2.8	30	KNL	16	FZ	20	■	163027 ●



1. Sawing

1.3 Sizing 1.3.6 Sizing sawblades FZ



Sizing, scoring, hogging

Application:

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

Machine:

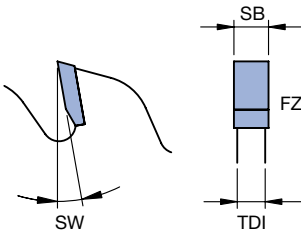
Table, sizing and vertical panel sizing saws.

Workpiece material:

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

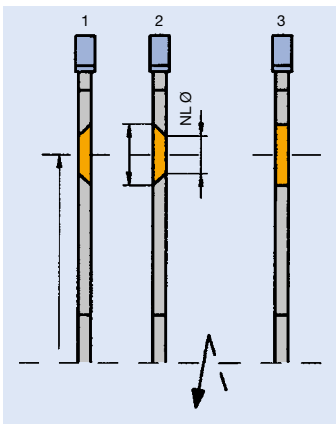
Technical information:

Also suitable for assembly on hogsers and segment hogsers.



Scoring sawblade - Circular sawblade for mounting on hogger. HW design.
WK 100 2

D	SB	TDI	BO	NLA	Type	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm				°		
150	3.2	2.2	30			42	FZ	10	■ ■	165375 ●
180	3.2	2.2	30			48	FZ	10	■ ■	165378 ●
180	3.2	2.2	65	6/6/90	2	36	FZ	10	■ ■	165376 ●
180	3.2	2.2	65	6/6/90	1	36	FZ	10	■ ■	165377 ●
180	3.2	2.2	65	6/6/90	2	48	FZ	10	■ ■	165379 ●
180	3.2	2.2	65	6/6/90	1	48	FZ	10	■ ■	165380 ●
180	3.2	2.2	65	6/6/90	2	58	FZ	10	■ ■	165381 ●
180	3.2	2.2	65	6/6/90	1	58	FZ	10	■ ■	165382 ●
200	3.2	2.2	30			54	FZ	10	■ ■	165383 ●



Type 1:

Countersink right

Type 2:

Countersink left

Type 3:

Pinhole without countersink

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

1. Sawing

1.3 Sizing 1.3.6 Sizing sawblades FZ



Sizing, scoring, hogging *Excellent*

Application:

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

Machine:

Table, sizing and vertical panel sizing saws.

Workpiece material:

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

Technical information:

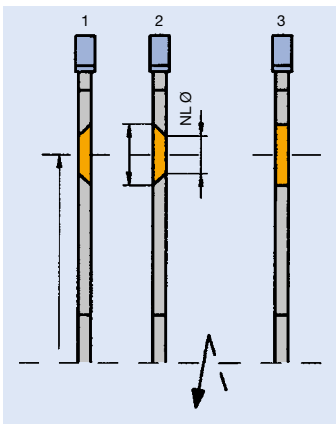
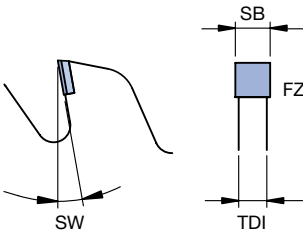
Also suitable for assembly on hogsers and segment hogsers.



Scoring sawblade - circular sawblade for mounting on hogger. DP design.

WK 800 2

D	SB	TDI	BO	NLA	Type	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm				°		
180	3.2	2.2	65	6/6/90	2	24	FZ	10	■ ■	190660 □
180	3.2	2.2	65	6/6/90	1	24	FZ	10	■ ■	190661 □
180	3.2	2.2	65	6/6/90	2	36	FZ	10	■ ■	190662 □
180	3.2	2.2	65	6/6/90	1	36	FZ	10	■ ■	190663 □
180	3.2	2.2	65	6/6/90	2	48	FZ	10	■ ■	190664 □
180	3.2	2.2	65	6/6/90	1	48	FZ	10	■ ■	190665 □



Type 1:

Countersink right

Type 2:

Countersink left

Type 3:

Pinhole without countersink



Scoring sawblades with adjustable cutting width

Application:

For scoring with feed.

Machine:

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

Workpiece material:

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

Technical information:

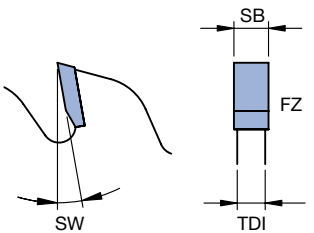
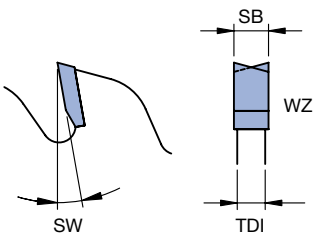
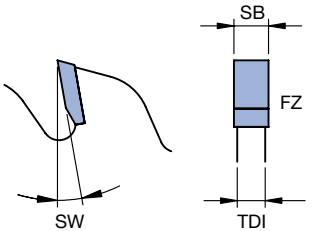
2 part design, adjustable with spacers. Scoring depth 1.50 - 2.00 mm.



Scoring sawblades adjustable, HW design

WK 200 2, WK 250 2

Machine	D mm	SB mm	BO mm	Z	ZF	SW °	WSS	ID
	70	2.8 - 3.8	20	8+8	WZ	10	■	165400 ●
Felder, Striebig	80	2.8 - 3.8	20	10+10	FZ	10	■	165401 ●
Schelling	100	2.8 - 3.8	20	10+10	FZ	10	■	165402 ●
Altendorf	100	2.8 - 3.8	22	10+10	FZ	10	■	165403 ●
SCM, Felder	120	2.8 - 3.8	20	12+12	FZ	10	■	165404 ●
Martin T74 Automatic	120	2.8 - 3.6	22	12+12	FZ	10	■	165405 ●
Altendorf	120	2.8 - 3.8	22	12+12	FZ	10	■	165406 ●
Felder	125	2.8 - 3.8	20	12+12	FZ	10	■	165407 ●
Martin	140	2.8 - 3.8	36	12+12	WZ	10	■	165408 ●
SCM	160	2.8 - 3.8	20	16+16	FZ	10	■	165409 ●
Altendorf	180	3.0 - 3.8	22	18+18	WZ	10	■	165410 ●
SCM	200	4.3 - 5.2	20	30+30	FZ	10	■	165411 ●



Scoring sawblades for Altendorf Rapido-System, HW design

WK 200 2

Machine	D mm	SB mm	BO mm	Z	ZF	SW °	WSS	ID
Altendorf	120	2.8 - 3.8	50	12+12	FZ	10	■	165412 ●
Altendorf	180	3.0 - 3.8	50	18+18	FZ	10	■	165413 ●



Scoring sawblades with adjustable cutting width

Excellent

Application:

For scoring with feed.

Machine:

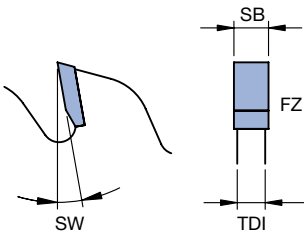
Table and sizing saws, vertical panel sizing saws with scoring unit.

Workpiece material:

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

Technical information:

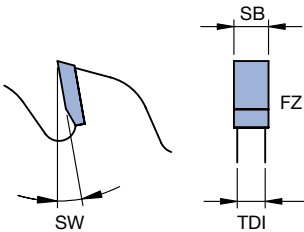
2 part design, adjustable with spacers. Scoring depth 1.50 - 2.00 mm.



Scoring sawblades adjustable, Diamaster PRO

WK 200 2

D	SB	BO	Z	ZF	SW	WSS	ID
mm	mm	mm			°		
120	2.8 - 3.8	20	12+12	FZ	10	■	190731 ●
120	2.8 - 3.8	22	12+12	FZ	10	■	190694 ●
125	2.8 - 3.8	20	12+12	FZ	10	■	190695 ●



Scoring sawblades for Altendorf Rapido-System, Diamaster PRO

WK 200 2

D	SB	BO	Z	ZF	SW	WSS	ID
mm	mm	mm			°		
120	2.8 - 3.8	50	12+12	FZ	10	■	190704 ●

1. Sawing

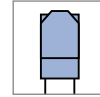
1.4 Panel sizing

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

Tooth shape



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



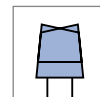
FZ/TR (square/trapezoidal teeth):
Tooth shape for plastic coated and foil coated wood derived materials.



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



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



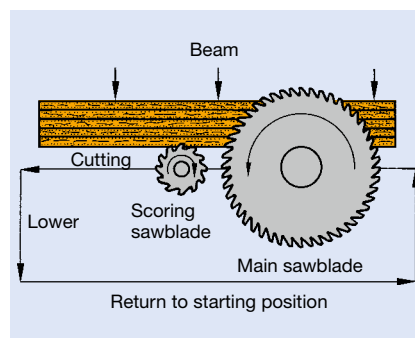
KON/WZ (alternative top bevel teeth – conical): For scoring sawblades. Prevents splitting of the cut edge by the main sawblade as it passes through the bottom surface of the panel with low cutting pressure.

Scoring sawblades

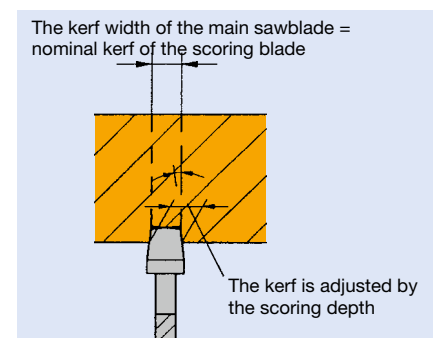
A scoring saw is recommended for a high cut edge quality on both sides of coated panels. The scoring sawblade cutting width (kerf) is slightly larger than the width (kerf) of the main sawblade so the exiting tooth of the main sawblade does not touch the bottom surface cut edge.

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

Schematic representation



Panel sizing machine with scoring saw and top pressure beam.



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



Sizing of single boards and stacks of boards *Premium*

Application:

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

Machine:

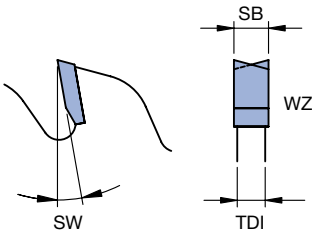
Panel sizing saws with pressure beam.

Workpiece material:

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

Technical information:

For feed rates $v_f > 40 \text{ m min}^{-1}$ WZ can be reground to WZFA. **Premium** design with vibration damping laser ornaments.



Circular sawblade

WK 250 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
	300	4.4	3.2	30	KNL	48	WZ	15	■	163300 ●
Holz-Her, Mayer, Schelling	350	4.4	3.2	30	KNL	54	WZ	15	■	163301 ●
Holz-Her, Mayer, Schelling	350	4.4	3.2	30	KNL	72	WZ	15	■	163302 ●
Homag	350	4.4	3.2	60	2/14/100	72	WZ	15	■	163304 ●
Gabbiani, SCM	350	4.4	3.2	80	4/9/100	54	WZ	15	■	163305 ●
					2/14/110					
					2/7/110					
Mayer	355	4.4	3.2	30	KNL	72	WZ	15	■	163306 ●
Homag	380	4.8	3.5	60	2/14/100	54	WZ	15	■	163307 ●
					2/14/125					
Mayer, Schelling	400	4.4	3.2	30	KNL	60	WZ	15	■	163308 ●
					2/13/94					
Mayer, Schelling	400	4.4	3.2	30	KNL	72	WZ	15	■	163309 ●
					2/13/94					
Schelling	430	4.4	3.2	30	KNL	72	WZ	15	■	163310 ●
Mayer, Schelling	450	4.4	3.2	30	KNL	54	WZ	15	■	163311 ●
					2/13/94					
Mayer, Schelling	450	4.4	3.2	30	KNL	72	WZ	15	■	163312 ●
					2/13/94					
Schelling	480	4.4	3.2	30	KNL	72	WZ	15	■	163313 ●
					2/13/94					
Schelling	500	5.2	3.5	30	KNL	60	WZ	15	■	163314 ●
	500	5.2	3.5	80		60	WZ	15	■	163315 ●
Schelling	520	4.4	3.2	30	2/13/94	72	WZ	15	■	163316 ●
	550	5.2	3.5	30	KNL	60	WZ	15	■	163317 ●
	550	5.2	3.5	80	2/13/100	60	WZ	15	■	163318 ●



Sizing of single boards and stacks of boards *Premium*

Application:

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

Machine:

Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

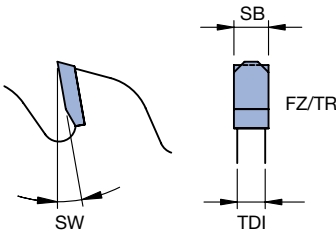
Chipboard and fibre materials paper and plastic coated, veneered.

Technical information:

Premium design with vibration damping laser ornaments.

Circular sawblade

WK 852 2



Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
Homag	300	4.4	3.2	30	KNL	60	FZ/TR	15	■	163400 ●
Homag	300	4.4	3.2	60	2/14/100	72	FZ/TR	15	■	163401 ●
Selco	300	4.4	3.2	65	2/9/110	60	FZ/TR	15	■	163402 ●
Homag	300	4.4	3.2	75		60	FZ/TR	15	■	163403 ●
Homag	308	3.2	2.4	60	2/14/100	96	FZ/TR	15	■	163404 ●
Homag	310	4.4	3.2	60	2/14/100	72	FZ/TR	15	■	163405 ●
Felder, Mayer	320	4.4	3.2	30	KNL	60	FZ/TR	15	■	163406 ●
Selco	320	4.4	3.2	65	2/9/110	60	FZ/TR	15	■	163407 ●
Holz-Her, Mayer,	350	4.4	3.2	30	KNL	72	FZ/TR	15	■	163408 ●
Schelling										
Homag	350	4.4	3.2	60	2/14/100	72	FZ/TR	15	■	163409 ●
Homag	350	4.4	3.2	75		72	FZ/TR	15	■	163410 ●
Gabbiani, SCM	350	4.4	3.2	80	4/9/100	72	FZ/TR	15	■	163454 ●
					2/7/110					
					2/14/110					
Selco	355	4.4	3.2	65	2/9/110	72	FZ/TR	15	■	163412 ●
					2/9/100					
Giben, Homag	355	4.4	3.2	75		72	FZ/TR	15	■	163413 ●
Schelling	360	4.4	3.2	30	2/13/94	72	FZ/TR	15	■	163414 ●
Selco	360	4.4	3.2	65	2/9/100	72	FZ/TR	15	■	163415 ●
					2/9/110					
	370	4.4	3.2	30	2/13/94	72	FZ/TR	15	■	163416 ●
					KNL					
Giben	380	4.4	3.2	50	2/13/80	72	FZ/TR	15	■	163417 ●
					6/13/80					
Homag	380	4.4	3.2	60	2/14/100	72	FZ/TR	15	■	163418 ●
					2/14/125					
Homag	380	4.8	3.5	60	2/14/100	72	FZ/TR	15	■	163419 ●
					2/14/125					
Giben	380	4.4	3.2	75	3/15/75	72	FZ/TR	15	■	163420 ●
					2/7/110					
Mayer, Schelling	400	4.4	3.2	30	KNL	72	FZ/TR	15	■	163421 ●
					2/13/94					
Anthon	400	4.4	3.2	60	2/11/85	72	FZ/TR	15	■	163422 ●
Giben, Homag	400	4.4	3.2	75	4/15/105	72	FZ/TR	15	■	163423 ●
					2/7/110					
Gabbiani, Selco	400	4.4	3.2	80	2/14/110	72	FZ/TR	15	■	163455 ●
					2/7/110					
					4/9/100					
					4/19/120					
					2/9/130					
Homag	420	4.8	3.5	60	2/14/125	72	FZ/TR	15	■	163426 ●
					2/19/120					
Schelling	430	4.4	3.2	30	KNL	72	FZ/TR	15	■	163427 ●
Giben	430	4.4	3.2	75	4/15/105	72	FZ/TR	15	■	163428 ●

1. Sawing

1.4 Panel sizing

1.4.2 Panel sizing sawblades FZ/TR

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
Selco	430	4.4	3.2	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	72	FZ/TR	15	■	163429 ●
Mayer, Schelling	450	4.4	3.2	30	KNL 2/13/94	72	FZ/TR	15	■	163430 ●
Homag	450	4.8	3.5	60	2/14/125 2/19/120	72	FZ/TR	15	■	163431 ●
Gabbiani, SCM	450	4.4	3.2	80	2/9/100 2/14/110 2/7/110	72	FZ/TR	15	■	163432 ●
Selco	450	4.8	3.6	80	2/9/130 4/19/120	72	FZ/TR	15	■	163433 ●
Schelling	460	4.4	3.2	30	2/13/94	72	FZ/TR	15	■	163434 ●
Giben	470	4.4	3.2	75	4/15/105	96	FZ/TR	15	■	163435 ●
Schelling	480	4.4	3.2	30	KNL 2/13/94	72	FZ/TR	15	■	163436 ●
Homag	480	4.8	3.5	60	2/19/120	72	FZ/TR	15	■	163437 ●
Selco	480	4.8	3.5	80	2/9/130 4/19/120	72	FZ/TR	15	■	163438 ●
Schelling	500	5.2	3.5	30	KNL	60	FZ/TR	15	■	163439 ●
Anthon, Homag	500	5.2	3.5	60	2/11/115 2/19/120	60	FZ/TR	15	■	163440 □
Selco	510	4.8	3.5	80	2/9/130 4/19/120	72	FZ/TR	15	■	163441 ●
Schelling	520	4.4	3.2	30	2/13/94	72	FZ/TR	15	■	163442 ●
Homag	520	4.8	3.5	60	2/11/115 2/19/120	72	FZ/TR	15	■	163443 ●
Selco	520	4.8	3.5	70	4/11/130	72	FZ/TR	15	■	163444 ●
Homag	570	4.8	3.5	60	2/11/115 2/19/120	60	FZ/TR	22	■	163445 ●
Homag, Anthon	600	5.8	4.0	60	2/19/120 2/11/115 2/11/85	60	FZ/TR	22	■	163446 ●
Homag, Anthon	600	5.8	4.0	60	2/19/120 2/11/115 2/11/85	72	FZ/TR	22	■	163447 ●
Homag	670	5.8	4.2	60	2/11/148 2/19/120	42	FZ/TR	22	■	163448 ●
Schelling	680	6.2	4.2	40	2/13/114 2/13/140	60	FZ/TR	22	■	163449 ●
Anthon	700	6.2	4.4	80	1/17/110	60	FZ/TR	22	■	163450 ●
Schelling	720	6.5	4.5	40	2/13/140 2/13/114	60	FZ/TR	22	■	163451 ●
Homag	730	6.2	4.2	60	2/11/148 2/19/120	60	FZ/TR	22	■	163452 ●
Anthon	750	7.0	5.0	80	1/17/110	70	FZ/TR	22	■	163453 ●



Sizing of single boards in finish cut quality

Excellent - RazorCut

Application:

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

Machine:

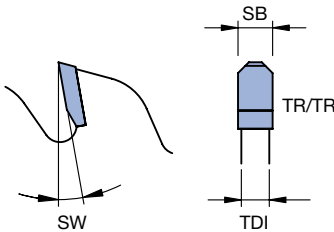
Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

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

Technical information:

Special cutting geometry for excellent cutting results in finish cut quality. **Excellent** design with plastic filled laser ornaments for vibration damping and reduction of noise level. Irregular tooth pitch.



Circular sawblade RazorCut

WK 878 2 87

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
Felder, Holz-Her, Striebig	250	3.2	2.2	30	KNL	60	TR/TR	15	■	161100 ●
	280	3.2	2.2	30	KNL	60	TR/TR	15	■	161101 ●
	300	4.4	3.2	30	KNL	60	TR/TR	15	■	161102 ●
Striebig	300	3.2	2.2	30	KNL	72	TR/TR	15	■	161103 ●
Homag	300	4.4	3.2	60	2/14/100	72	TR/TR	15	■	161104 ●
Selco	300	4.4	3.2	65	2/9/110	60	TR/TR	15	■	161134 □
Homag	308	3.2	2.4	60	2/14/100	96	TR/TR	15	■	161105 ●
Homag	310	4.4	3.2	60		72	TR/TR	15	■	161106 ●
Giben	320	4.4	3.2	50	3/15/80	60	TR/TR	15	■	161107 ●
Holz-Her, Mayer, Schelling	350	4.4	3.2	30	KNL	72	TR/TR	15	■	161108 ●
Homag	350	4.4	3.2	60	2/14/100	72	TR/TR	15	■	161109 ●
Homag	350	4.4	3.2	75		72	TR/TR	15	■	161110 ●
Giben, Homag	355	4.4	3.2	75		72	TR/TR	15	■	161111 ●
Selco	355	4.4	3.2	80	2/9/130	72	TR/TR	15	■	161112 ●
					4/19/120					
Schelling	360	4.4	3.2	30	2/13/94	72	TR/TR	15	■	161113 ●
	370	4.4	3.2	30	KNL	72	TR/TR	15	■	161114 ●
Holz-Her	380	4.4	3.2	30	KNL	72	TR/TR	15	■	161132 ●
Giben	380	4.4	3.2	50	4/13/80	72	TR/TR	15	■	161115 ●
Homag	380	4.4	3.2	60	2/14/100	72	TR/TR	15	■	161116 ●
					2/14/125					
Homag	380	4.8	3.5	60	2/14/100	72	TR/TR	15	■	161117 ●
					2/14/125					
Mayer, Schelling	400	4.4	3.2	30	KNL	72	TR/TR	15	■	161118 ●
					2/13/94					
Giben, Homag	400	4.4	3.2	75	4/15/105	72	TR/TR	15	■	161119 ●
					2/7/110					
Selco	400	4.4	3.2	80	2/9/130	72	TR/TR	15	■	161120 ●
					4/19/120					
Gabbiani, SCM	400	4.4	3.2	80	4/9/100	72	TR/TR	15	■	161121 ●
					2/14/110					
					2/7/110					
Homag	420	4.8	3.5	60	2/14/125	72	TR/TR	15	■	161122 ●
					2/19/120					
Schelling	430	4.4	3.2	30	KNL	72	TR/TR	15	■	161123 ●
Giben	430	4.4	3.2	75	4/15/105	72	TR/TR	15	■	161124 ●
					2/7/110					
Selco	430	4.4	3.2	80	2/9/130	72	TR/TR	15	■	161125 ●
					4/19/120					



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

1. Sawing

1.4 Panel sizing

1.4.3 Panel sizing sawblades TR/TR

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
Mayer, Schelling	450	4.4	3.2	30	2/13/94	72	TR/TR	15	■	161126 ●
Homag	450	4.8	3.5	60	2/14/125	72	TR/TR	15	■	161127 ●
Selco	450	4.8	3.5	80	2/9/130	72	TR/TR	15	■	161128 ●
Schelling	460	4.4	3.2	30	2/13/94	72	TR/TR	15	■	161129 ●
Homag	480	4.8	3.5	60	2/19/120	72	TR/TR	15	■	161130 ●
Selco	480	4.8	3.5	80	2/9/130	72	TR/TR	15	■	161133 □
Schelling	520	4.8	3.5	30	2/13/94	72	TR/TR	15	■	161131 ●



Sizing of single boards *Premium*

Application:

For panel sizing of single boards with scoring.

Machine:

Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

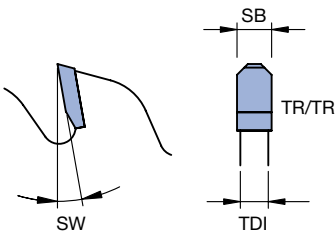
Chipboard and fibre materials plastic coated.

Technical information:

Premium design with vibration damping laser ornaments.

Circular sawblade

WK 858 2



Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
Selco	300	4.4	3.2	30	KNL	60	TR/TR	15	■	163350 ●
Selco	300	4.4	3.2	65	2/9/110	60	TR/TR	15	■	163351 ●
Selco	320	4.4	3.2	65	2/9/110	60	TR/TR	15	■	163352 ●
Holz-Her, Mayer, Schelling	350	4.4	3.2	30	KNL	72	TR/TR	15	■	163353 ●
Homag	350	4.4	3.2	60	2/14/100	72	TR/TR	15	■	163354 ●
Selco	355	4.4	3.2	65	2/9/110	72	TR/TR	15	■	163355 ●
Schelling	360	4.4	3.2	30	KNL	72	TR/TR	15	■	163356 ●
Holz-Her	380	4.4	3.2	30	KNL	72	TR/TR	15	■	163357 ●
Homag	380	4.8	3.5	60	2/14/100	84	TR/TR	15	■	163358 ●
Selco	380	4.4	3.2	65	2/9/110	72	TR/TR	15	■	163359 ●
Mayer, Schelling	400	4.4	3.2	30	KNL	72	TR/TR	15	■	163360 ●
Selco	400	4.4	3.2	65	2/9/110	72	TR/TR	15	■	163361 ●
Selco	430	4.4	3.2	65	2/9/110	72	TR/TR	15	■	163362 ●
Mayer, Schelling	450	4.4	3.2	30	KNL	72	TR/TR	15	■	163363 ●
Homag	450	4.8	3.5	60	2/14/125	72	TR/TR	15	■	163364 ●
Schelling	460	4.4	3.2	30	2/13/94	72	TR/TR	15	■	163365 ●
Selco	470	4.8	3.5	70	4/11/130	72	TR/TR	15	■	163366 ●
Anthon, Homag	500	4.8	3.5	60	2/11/115	72	TR/TR	15	■	163367 ●
Homag	520	4.8	3.5	60	2/19/120	72	TR/TR	15	■	163368 ●

1. Sawing

1.4 Panel sizing

1.4.3 Panel sizing sawblades TR/TR



Sizing of single boards and stacks of boards *Excellent*

Application:

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

Machine:

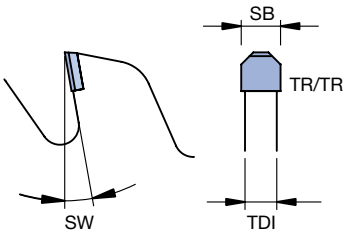
Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

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

Technical information:

DP tipped for long tool life. Irregular tooth pitch for better running. **Excellent** design with plastic filled laser ornaments for damping vibration and noise reduction.



Panel sizing sawblade TR/TR, Diamaster PLUS

WK 278 2, WK 858 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
	300	4.4	3.2	30	KNL	60	TR/TR	15		190706 ●
Homag	308	3.2	2.4	60	2/14/100	96	TR/TR	10		190746 ●
Holz-Her, Mayer, Schelling	350	4.4	3.2	30	KNL	72	TR/TR	15		190707 ●
Homag	350	4.4	3.2	60	2/14/100	72	TR/TR	15		190708 ●
					2/14/125					
Homag	380	4.4	3.2	60	2/14/100	72	TR/TR	15		190709 ●
					2/14/125					
Homag	380	4.8	3.5	60	2/14/100	72	TR/TR	15		190710 ●
					2/14/125					
Mayer, Schelling	400	4.4	3.2	30	KNL	72	TR/TR	15		190711 ●
					2/13/94					
Homag	450	4.8	3.5	60	2/14/125	72	TR/TR	15		190712 ●
					2/19/120					



Scoring sawblade KON/WZ

Application:

For scoring with feed.

Machine:

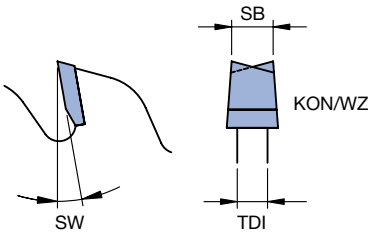
Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), alu composite panels (z.B. Alucobond®).

Technical information:

Scoring depth 1.50 - 2.00 mm. Scoring sawblade has to be selected according to the cutting width of the main sawblade.



Scoring sawblade KON/WZ, HW design

WK 856 2 01, WK 856 2 05

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	n _{max}	WSS ID
	mm	mm	mm	mm	mm			°	min ⁻¹	
	125	3.2	2.5	20		24	KON/WZ	5	18300	165550 ●
	125	3.2	2.5	22		24	KON/WZ	5	18300	165551 ●
Giben, Homag, Mayer	125	4.4	3.5	45		24	KON/WZ	5	15200	165553 ●
Schelling	150	4.4	3.5	20		24	KON/WZ	5	15200	165554 ●
Felder, Mayer	150	4.4	3.5	30		36	KON/WZ	5	15200	165555 ●
Felder, Mayer	150	4.4	3.5	30		24	KON/WZ	5	15200	165556 ●
Homag	150	4.4	3.5	45		24	KON/WZ	5	15200	165557 ●
Homag	150	4.4	3.5	45		28	KON/WZ	5	14300	165558 ●
	160	3.2	2.5	20		32	KON/WZ	5	14300	165559 ●
Steton	160	4.4	3.5	30		36	KON/WZ	5	14300	165560 ●
Giben	160	4.4	3.5	45	3/11/70	36	KON/WZ	5	14300	165561 ●
Gabbiani	160	4.4	3.5	55	3/7/66 3/6/84	36	KON/WZ	5	12700	165562 ●
	180	3.2	2.5	20		36	KON/WZ	5	12700	165563 ●
	180	4.4	3.5	20		36	KON/WZ	5	12700	165564 ●
Homag	180	4.4	3.5	45		30	KON/WZ	5	12700	165565 ●
Anthon	180	4.4	3.5	45		36	KON/WZ	5	12700	165566 ●
Giben	180	4.5	3.2	50	3/13/80	36	KON/WZ	5	11400	165567 ●
Schelling	200	4.4	3.5	20	2/11/66	24	KON/WZ	5	11400	165568 ●
Schelling	200	4.4	3.5	20	2/11/66	36	KON/WZ	5	11400	165569 ●
	200	6.2	4.5	20	2/11/66	36	KON/WZ	5	11400	165570 ●
	200	3.2	2.5	30	2/10/60	60	KON/WZ	5	11400	165571 ●
	200	4.4	3.5	30	2/10/60	36	KON/WZ	5	11400	165572 ●
Schelling	200	4.8	3.5	20		36	KON/WZ	5	11400	165573 ●
Homag	200	4.4	3.5	45		36	KON/WZ	5	11400	165574 ●
Homag	200	5.8	4.6	45		36	KON/WZ	5	11400	165575 ●
Selco	200	4.4	3.5	65	2/9/100	36	KON/WZ	5	11400	165576 ●
					2/9/110					
Selco	200	4.8	3.5	65	2/9/100	36	KON/WZ	5	11400	165577 ●
					2/9/110					
Giben	215	4.4	3.5	50	3/15/80	42	KON/WZ	5	10600	165578 ●
					2/7/80					
Schelling	220	6.5	4.5	20	2/11/66	36	KON/WZ	5	10400	165579 ●
Homag	280	4.8	3.5	45		72	KON/WZ	5	8100	165581 ●
Schelling	300	4.4	3.5	30	2/11/73	48	KON/WZ	5	7600	165582 ●
					2/13/94					
Giben	300	4.4	3.5	50	3/15/80	48	KON/WZ	5	7600	165583 ●
Selco	300	4.4	3.5	65	2/9/100	72	KON/WZ	5	7600	165584 ●
					2/9/110					
Selco	300	4.4	3.5	65	3/15/80	48	KON/WZ	5	7600	165585 □
					2/9/110					

1. Sawing

1.4 Panel sizing

1.4.4 Scoring sawblades for panel saws KON



Scoring sawblades KON/FZ

Application:

For scoring with feed.

Machine:

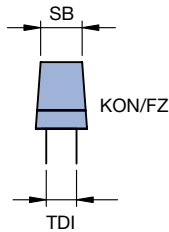
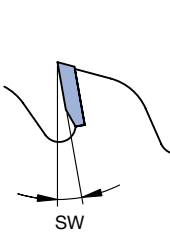
Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), alu composite panels (z.B. Alucobond®).

Technical information:

Scoring depth 1.50 - 2.00 mm. Scoring sawblade has to be selected according to the cutting width of the main sawblade.



Scoring sawblades KON/FZ, HW design

WK 804 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	n_{max}	WSS	ID
	mm	mm	mm	mm	mm			°	min^{-1}		
SCM	100	3.2	2.5	20		20	KON/FZ	5	22900	■	165625 ●
	100	3.2	2.5	22		20	KON/FZ	5	22900	■	165626 ●
	120	3.2	2.5	20		24	KON/FZ	5	19000	■	165627 ●
	125	4.4	3.5	20		24	KON/FZ	5	18300	■	165628 ●
Holz-Her	125	4.4	3.5	45		24	KON/FZ	5	18300	■	165629 ●
Anthon	180	4.4	3.5	20		28	KON/FZ	5	12700	■	165630 ●
Anthon	180	5.8	4.0	20		36	KON/FZ	5	12700	■	165631 ●
Holz-Her	180	4.4	3.5	30	2/10/60	30	KON/FZ	5	12700	■	165632 ●
Homag	180	4.4	3.5	45		36	KON/FZ	5	12700	■	165633 ●
Homag	180	4.8	3.5	45		36	KON/FZ	5	12700	■	165634 ●
Anthon	200	6.8	4.2	20		36	KON/FZ	5	11400	■	165635 ●
Homag	200	4.8	3.5	45		36	KON/FZ	5	11400	■	165636 ●
SCM	200	4.4	3.5	80	2/14/110	36	KON/FZ	5	11400	■	165637 ●
Homag	220	3.2	2.4	45		60	KON/FZ	5	10400	■	165638 ●
	250	4.4	3.5	30	2/10/60	42	KON/FZ	5	9100	■	165639 ●
Holz-Her	280	4.4	3.5	30	2/10/60	48	KON/FZ	5	9100	■	165640 ●



Scoring sawblades KON/FZ *Excellent*

Application:

For scoring with feed.

Machine:

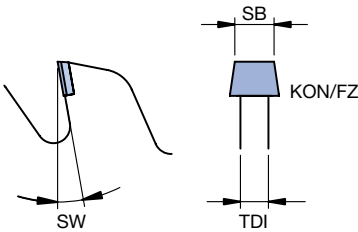
Panel sizing saws with scoring unit and pressure beam.

Workpiece material:

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

Technical information:

Scoring depth 2.00 - 2.50 mm. DP tipped for long tool life. Scoring sawblade has to be selected according to the cutting width of the main sawblade. Usable in combination with HW and DP tipped main sawblade. For use in combination with resharpened HW tipped main sawblades the cutting width (SB) of scoring sawblade is 0.1 mm less.



Scoring sawblades KON/FZ, Diamaster PLUS

WK 804 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
	125	3.1	2.5	20		20	KON/FZ	10		190564 ●
Felder, Mayer	150	4.3	3.2	30		24	KON/FZ	10		190565 ●
Gabbiani	160	4.3	3.5	55	3/ 7/ 66	30	KON/FZ	10		190566 ●
Holz-Her	180	4.3	3.5	30	2/10/ 60	30	KON/FZ	10		190567 ●
Homag	180	4.3	3.5	45		30	KON/FZ	10		190568 ●
Homag	180	4.7	3.5	45		30	KON/FZ	10		190569 ●
Schelling	200	4.3	3.5	20	2/11/66	30	KON/FZ	10		190570 ●
Homag	200	4.3	3.5	30	2/10/ 60	30	KON/FZ	10		190571 ●
Homag	200	4.3	3.5	45		30	KON/FZ	10		190572 ●
Selco	200	4.3	3.5	65	2/ 9/100	30	KON/FZ	10		190615 ●
					2/ 9/110					
Homag	200	4.7	3.5	45		30	KON/FZ	10		190573 ●
Selco	200	4.7	3.5	65	2/9/110	30	KON/FZ	10		190574 ●
					2/9/100					
Homag	220	3.1	2.4	45		48	KON/FZ	10		190744 ●
Schelling	300	4.3	3.5	30	2/11/73	48	KON/FZ	10		190743 ●
					2/13/94					

1. Sawing

1.4 Panel sizing

1.4.5 Scoring sawblades - softforming / postforming



Scoring sawblade - softforming / postforming

Application:

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

Machine:

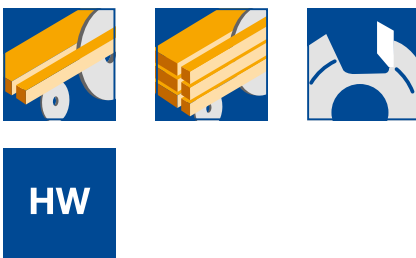
Panel sizing saws with adjustable soft and postforming units and pressure beam.

Workpiece material:

Chipboard and fibre materials paper and plastic coated.

Technical information:

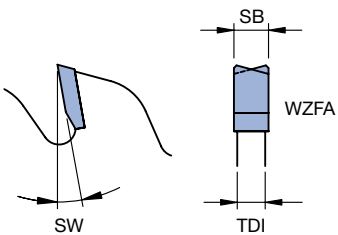
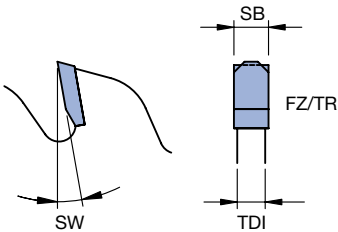
Tooth shape according to machine manufacturers' specification.



Circular sawblade FZ/TR

WK 852 2

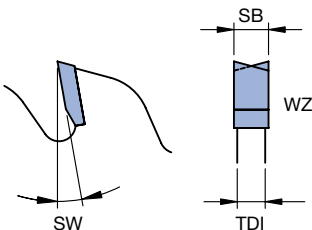
Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	n_{max}	WSS	ID
	mm	mm	mm	mm	mm			°	min^{-1}		
	220	3.35	2.5	30		48	FZ/TR	10	10400	■	165676 ●
	250	4.55	3.2	30	2/10/60	48	FZ/TR	10	9100	■	165677 ●
Holz-Her	280	4.55	3.2	30	2/10/60	60	FZ/TR	10	8100	■	165678 ●
Homag	280	3.45	2.4	45		60	FZ/TR	10	8100	■	165675 ●
Homag	350	4.55	3.2	75		72	FZ/TR	10	6500	■	165679 ●
	450	4.8	3.5	30	2/10/60	72	FZ/TR	10	4200	■	165680 ●



Circular sawblade WZFA

WK 251 2, WK 851 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	n_{max}	WSS	ID
	mm	mm	mm	mm	mm			°	min^{-1}		
	180	4.55	3.2	30		36	WZFA	10	12700	■	165681 ●
Schelling	300	4.55	3.2	30	2/11/73 2/13/94	72	WZFA	10	7600	■	165682 ●
Selco	300	4.55	3.2	65	2/9/110	72	WZFA	10	7600	■	165683 ●



Circular sawblade WZ

WK 850 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	n_{max}	WSS	ID
	mm	mm	mm	mm	mm			°	min^{-1}		
Homag	280	4.55	3.2	45		84	WZ	10	8100	■	165684 ●
Homag	280	4.95	3.5	45		84	WZ	10	8100	■	165685 ●

1. Sawing

1.4 Panel sizing

1.4.6 Overview scoring and main sawblades

Machine – Type	Tool Type	ABM mm	Z	QAL	ZF	System	ID
Holz-Her- Tectra 6120 Classic	Main sawblade	350x4.4x30	54	HW	WZ		163301 ●
	Main sawblade	350x4.4x30	72	HW	WZ		163302 ●
	Main sawblade	350x4.4x30	72	HW	FZ/TR		163408 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut	161108 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR		163353 ●
	Main sawblade	350x4.4x30	72	DP	TR/TR		190707 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ	AS LowNoise UT	190567 ●
Holz-Her- Tectra 6120 Dynamic, Lift, Power	Main sawblade	380x4.4x30	72	HW	TR/TR	RazorCut	161132 ●
	Main sawblade	380x4.4x30	72	HW	TR/TR		163357 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ	AS LowNoise UT	190567 ●
Holz-Her- Zentrex 6220 Classic	Main sawblade	380x4.4x30	72	HW	TR/TR	RazorCut	161132 ●
	Main sawblade	380x4.4x30	72	HW	TR/TR		163357 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ	AS LowNoise UT	190567 ●
Holz-Her- Zentrex 6220 Dynamic, Lift, Power	Main sawblade	430x4.4x30	72	HW	WZ		163310 ●
	Main sawblade	430x4.4x30	72	HW	FZ/TR		163427 ●
	Main sawblade	430x4.4x30	72	HW	TR/TR	RazorCut	161123 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ	AS LowNoise UT	190567 ●
Homag- HKL300	Main sawblade	350x4.4x60	72	HW	WZ		163304 ●
	Main sawblade	350x4.4x60	72	HW	FZ/TR		163409 ●
	Main sawblade	350x4.4x60	72	HW	TR/TR	RazorCut	161109 ●
	Main sawblade	350x4.4x60	72	HW	TR/TR		163354 ●
	Main sawblade	350x4.4x60	72	DP	TR/TR		190708 ●
	Scoring sawblade	180x4.4x45	30	HW	KON/WZ		165565 ●
	Scoring sawblade	180x4.4x45	36	HW	KON/WZ		165566 ●
	Scoring sawblade	180x4.4x45	36	HW	KON/FZ		165633 ●
	Scoring sawblade	180x4.3/5.1x45	30	DP	KON/FZ	AS LowNoise UT	190568 ●
Homag- HKL600	Main sawblade	600x5.8x60	60	HW	FZ/TR		163446 ●
	Main sawblade	600x5.8x60	72	HW	FZ/TR		163447 ●
	Scoring sawblade	200x5.8x45	36	HW	KON/WZ		165575 ●
Homag- HPP130	Main sawblade	300x4.4x60	72	HW	FZ/TR		163401 ●
	Main sawblade	300x4.4x60	72	HW	TR/TR	RazorCut	161104 ●
	Scoring sawblade	150x4.4x45	24	HW	KON/WZ		165557 ●
	Scoring sawblade	150x4.4x45	28	HW	KON/WZ		165558 ●
Homag- HPP200	Main sawblade	350x4.4x60	72	HW	WZ		163304 ●
	Main sawblade	350x4.4x60	72	HW	FZ/TR		163409 ●
	Main sawblade	350x4.4x60	72	HW	TR/TR	RazorCut	161109 ●
	Main sawblade	350x4.4x60	72	HW	TR/TR		163354 ●
	Main sawblade	350x4.4x60	72	DP	TR/TR		190708 ●
	Scoring sawblade	200x4.4x45	36	HW	KON/WZ		165574 ●
	Scoring sawblade	200x4.3/5.1x45	30	DP	KON/FZ	AS LowNoise UT	190572 ●
Homag- HPP300, HPL300, HKL300	Main sawblade	380x4.8x60	54	HW	WZ		163307 ●
	Main sawblade	380x4.4x60	72	HW	FZ/TR		163418 ●
	Main sawblade	380x4.8x60	72	HW	FZ/TR		163419 ●
	Main sawblade	380x4.4x60	72	HW	TR/TR	RazorCut	161116 ●
	Main sawblade	380x4.8x60	72	HW	TR/TR	RazorCut	161117 ●
	Main sawblade	380x4.8x60	84	HW	TR/TR		163358 ●
	Scoring sawblade	180x4.4x45	30	HW	KON/WZ		165565 ●
	Scoring sawblade	180x4.4x45	36	HW	KON/WZ		165566 ●
	Scoring sawblade	180x4.4x45	36	HW	KON/FZ		165633 ●
	Scoring sawblade	180x4.8x45	36	HW	KON/FZ		165634 ●
	Scoring sawblade	180x4.3/5.1x45	30	DP	KON/FZ	AS LowNoise UT	190568 ●
	Scoring sawblade	180x4.7/5.5x45	30	DP	KON/FZ	AS LowNoise UT	190569 ●

1. Sawing

1.4 Panel sizing

1.4.6 Overview scoring and main sawblades

Machine – Type	Tool Type	ABM mm	Z	QAL	ZF	System	ID
Homag-HPP400	Main sawblade	450x4.8x60	72	HW	FZ/TR		163431 ●
	Main sawblade	450x4.8x60	72	HW	TR/TR	RazorCut	161127 ●
	Main sawblade	450x4.8x60	72	HW	TR/TR		163364 ●
	Main sawblade	450x4.8x60	72	DP	TR/TR		190712 ●
	Scoring sawblade	180x4.8x45	36	HW	KON/FZ		165634 ●
	Scoring sawblade	180x4.7/5.5x45	30	DP	KON/FZ	AS LowNoise UT	190569 ●
Schelling-ASH	Main sawblade	720x6.5x40	60	HW	FZ/TR		163451 ●
	Scoring sawblade	220x6.5x20	36	HW	KON/WZ		165579 ●
Schelling-fh3	Main sawblade	300x4.4x30	48	HW	WZ		163300 ●
	Main sawblade	300x4.4x30	60	HW	FZ/TR		163400 ●
	Main sawblade	300x4.4x30	60	HW	TR/TR	RazorCut	161102 ●
	Main sawblade	300x4.4x30	60	HW	TR/TR		163350 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ	AS LowNoise UT	190567 ●
Schelling-fh3 Plus package	Main sawblade	350x4.4x30	54	HW	WZ		163301 ●
	Main sawblade	350x4.4x30	72	HW	WZ		163302 ●
	Main sawblade	350x4.4x30	72	HW	FZ/TR		163408 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut	161108 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR		163353 ●
	Main sawblade	350x4.4x30	72	DP	TR/TR		190707 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ	AS LowNoise UT	190567 ●
Schelling-fh4 (former version)	Main sawblade	350x4.4x30	54	HW	WZ		163301 ●
	Main sawblade	350x4.4x30	72	HW	WZ		163302 ●
	Main sawblade	350x4.4x30	72	HW	FZ/TR		163408 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut	161108 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR		163353 ●
	Main sawblade	350x4.4x30	72	DP	TR/TR		190707 ●
	Scoring sawblade	300x4.4x30	48	HW	KON/WZ		165582 ●
Schelling-fh4 (new version)	Main sawblade	360x4.4x30	72	HW	FZ/TR		163414 ●
	Main sawblade	360x4.4x30	72	HW	TR/TR	RazorCut	161113 ●
	Main sawblade	360x4.4x30	72	HW	TR/TR		163356 ●
	Scoring sawblade	200x4.4x20	24	HW	KON/WZ		165568 ●
	Scoring sawblade	200x4.4x20	36	HW	KON/WZ		165569 ●
	Scoring sawblade	200x4.3/5.1x20	30	DP	KON/FZ	AS LowNoise UT	190570 ●
Schelling-fh5	Main sawblade	400x4.4x30	60	HW	WZ		163308 ●
	Main sawblade	400x4.4x30	72	HW	WZ		163309 ●
	Main sawblade	400x4.4x30	72	HW	FZ/TR		163421 ●
	Main sawblade	400x4.4x30	72	HW	TR/TR	RazorCut	161118 ●
	Main sawblade	400x4.4x30	72	HW	TR/TR		163360 ●
	Main sawblade	400x4.4x30	72	DP	TR/TR		190711 ●
	Scoring sawblade	200x4.4x20	24	HW	KON/WZ		165568 ●
	Scoring sawblade	200x4.4x20	36	HW	KON/WZ		165569 ●
	Scoring sawblade	200x4.3/5.1x20	30	DP	KON/FZ	AS LowNoise UT	190570 ●
Schelling-fh6	Main sawblade	460x4.4x30	72	HW	FZ/TR		163434 ●
	Main sawblade	460x4.4x30	72	HW	TR/TR	RazorCut	161129 ●
	Main sawblade	460x4.4x30	72	HW	TR/TR		163365 ●
	Scoring sawblade	200x4.4x20	24	HW	KON/WZ		165568 ●
	Scoring sawblade	200x4.4x20	36	HW	KON/WZ		165569 ●
	Scoring sawblade	200x4.3/5.1x20	30	DP	KON/FZ	AS LowNoise UT	190570 ●
Schelling-fh8, fm8	Main sawblade	520x4.4x30	72	HW	WZ		163316 ●
	Main sawblade	520x4.4x30	72	HW	FZ/TR		163442 ●
	Main sawblade	520x4.8x30	72	HW	TR/TR	RazorCut	161131 ●
	Scoring sawblade	200x4.4x20	24	HW	KON/WZ		165568 ●
	Scoring sawblade	200x4.4x20	36	HW	KON/WZ		165569 ●
	Scoring sawblade	200x4.8x20	36	HW	KON/WZ		165573 ●
	Scoring sawblade	200x4.3/5.1x20	30	DP	KON/FZ	AS LowNoise UT	190570 ●
Schelling-fm10	Main sawblade	680x6.2x40	60	HW	FZ/TR		163449 ●
	Scoring sawblade	200x6.2x20	36	HW	KON/WZ		165570 ●

1. Sawing

1.4 Panel sizing

1.4.6 Overview scoring and main sawblades

Machine – Type	Tool Type	ABM mm	Z	QAL	ZF	System	ID	
Schelling- fm6	Main sawblade	460x4.4x30	72	HW	FZ/TR	RazorCut	163434 ●	
	Main sawblade	460x4.4x30	72	HW	TR/TR		161129 ●	
	Main sawblade	460x4.4x30	72	HW	TR/TR		163365 ●	
	Scoring sawblade	200x4.4x20	24	HW	KON/WZ	AS LowNoise UT	165568 ●	
	Scoring sawblade	200x4.4x20	36	HW	KON/WZ		165569 ●	
	Scoring sawblade	200x4.3/5.1x20	30	DP	KON/FZ		190570 ●	
Schelling- FSM	Main sawblade	720x6.5x40	60	HW	FZ/TR		163451 ●	
Schelling- FTM Option	Main sawblade	680x6.2x40	60	HW	FZ/TR		163449 ●	
	Scoring sawblade	220x6.5x20	36	HW	KON/WZ		165579 ●	
Schelling- s45	Main sawblade	350x4.4x30	54	HW	WZ	RazorCut	163301 ●	
	Main sawblade	350x4.4x30	72	HW	WZ		163302 ●	
	Main sawblade	350x4.4x30	72	HW	FZ/TR		163408 ●	
	Main sawblade	350x4.4x30	72	HW	TR/TR	AS LowNoise UT	161108 ●	
	Main sawblade	350x4.4x30	72	HW	TR/TR		163353 ●	
	Main sawblade	350x4.4x30	72	DP	TR/TR		190707 ●	
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●	
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ		190567 ●	
Schelling- s45 Plus package	Main sawblade	400x4.4x30	60	HW	WZ	RazorCut	163308 ●	
	Main sawblade	400x4.4x30	72	HW	WZ		163309 ●	
	Main sawblade	400x4.4x30	72	HW	FZ/TR		163421 ●	
	Main sawblade	400x4.4x30	72	HW	TR/TR	AS LowNoise UT	161118 ●	
	Main sawblade	400x4.4x30	72	HW	TR/TR		163360 ●	
	Main sawblade	400x4.4x30	72	DP	TR/TR		190711 ●	
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●	
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ		190567 ●	
Selco- EB 100	Main sawblade	360x4.4x65	72	HW	FZ/TR	AS LowNoise UT	163415 ●	
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●	
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ		190615 ●	
Selco- EB 70 (kit 80), EB 75, EB 80	Main sawblade	320x4.4x65	60	HW	TR/TR	AS LowNoise UT	163352 ●	
	Main sawblade	320x4.4x65	60	HW	FZ/TR		163407 ●	
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●	
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ		190615 ●	
Selco- EB 70 (L)	Main sawblade	300x4.4x65	60	HW	FZ/TR	AS LowNoise UT	163402 ●	
	Main sawblade	300x4.4x65	60	HW	TR/TR		163351 ●	
	Main sawblade	300x4.4x65	60	HW	TR/TR		161134 □	
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●	
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ		190615 ●	
Selco- EB 90	Main sawblade	355x4.4x80	72	HW	TR/TR	RazorCut	161112 ●	
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●	
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ	AS LowNoise UT	190615 ●	
Selco- EB 95	Main sawblade	355x4.4x65	72	HW	FZ/TR	AS LowNoise UT	163412 ●	
	Main sawblade	355x4.4x65	72	HW	TR/TR		163355 ●	
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●	
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ		190615 ●	
Selco- EB 110, EB 108, EB 120, WN 125, WN 200, WN 600/132, WN 512, WN 600/145, WN 600/162	Main sawblade	400x4.4x80	72	HW	FZ/TR	AS LowNoise UT	163424 ●	
	Main sawblade	400x4.4x80	72	HW	TR/TR		RazorCut	161120 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●	
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ		190615 ●	
Selco- EB 120, WN 125	Main sawblade	430x4.4x80	72	HW	TR/TR	RazorCut	161125 ●	
	Main sawblade	430x4.4x80	72	HW	FZ/TR		163429 ●	
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●	
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ	AS LowNoise UT	190615 ●	

1. Sawing

1.4 Panel sizing

1.4.6 Overview scoring and main sawblades

Machine – Type	Tool Type	ABM mm	Z	QAL	ZF	System	ID
Selco- WN 600/132, WN 200	Main sawblade	450x4.8x80	72	HW	FZ/TR		163433 ●
	Main sawblade	450x4.8x80	72	HW	TR/TR	RazorCut	161128 ●
	Scoring sawblade	200x4.8x65	36	HW	KON/WZ		165577 ●
	Scoring sawblade	200x4.7/5.5x65	30	DP	KON/FZ	AS LowNoise UT	190574 ●
Selco- WN 600/145, WN 512	Main sawblade	480x4.8x80	72	HW	FZ/TR		163438 ●
	Main sawblade	480x4.8x80	72	HW	TR/TR	RazorCut	161133 □
	Scoring sawblade	200x4.8x65	36	HW	KON/WZ		165577 ●
	Scoring sawblade	200x4.7/5.5x65	30	DP	KON/FZ	AS LowNoise UT	190574 ●

1. Sawing

1.4 Panel sizing

1.4.7 Circular sawblades for floor production



Middle cuts

Application:

For cutting of panels along grain for floor production.

Machine:

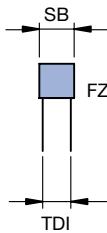
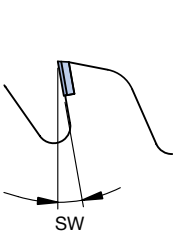
Multi blade saws.

Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered.

Technical information:

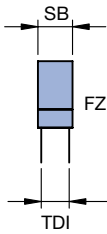
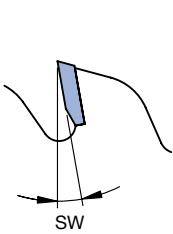
Circular sawblades BO = 115 mm for Hydro-Duo sleeve ID **030555** or BO = 110 mm for clamping flange TR 810 0. Tip height 5.5 mm.



Circular sawblade DP tipped

WK 800 2

Machine	D	SB	TDI	BO	NLA	DKN	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm	mm			°		
Paul	210	2.2	1.6	100	4/7/120	13/109	36	FZ	3	■ ■	190676 □
Paul	210	2.2	1.6	115	8/7/131		36	FZ	3	■ ■	190677 □
Homag	250	2.0	1.6	100	3/18/150		48	FZ	3	■ ■	190678 □
Paul	250	2.0	1.6	100	4/7/140	13/109	48	FZ	3	■ ■	190679 □
Paul	250	2.0	1.6	115	8/7/131		48	FZ	3	■ ■	190680 □
Homag	250	2.2	1.6	100	3/18/150		36	FZ	3	■ ■	190681 □
Paul	250	2.2	1.6	100	4/7/140	13/109	36	FZ	3	■ ■	190682 □
Homag	250	2.2	1.6	100	3/18/150		48	FZ	3	■ ■	190684 □
Paul	250	2.2	1.6	100	4/7/140	13/109	48	FZ	3	■ ■	190685 □
Paul	250	2.2	1.6	115	8/7/131		36	FZ	3	■ ■	190683 □
Paul	250	2.2	1.6	115	8/7/131		48	FZ	3	■ ■	190686 □



Circular sawblade HW tipped

WK 800 2

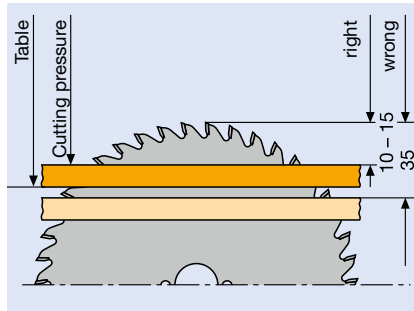
D	SB	TDI	BO	NLA	DKN	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm			°		
250	3.2	2.2	100	4/7/140	13/109	48	FZ	10	■ ■	061434 ●

1. Sawing

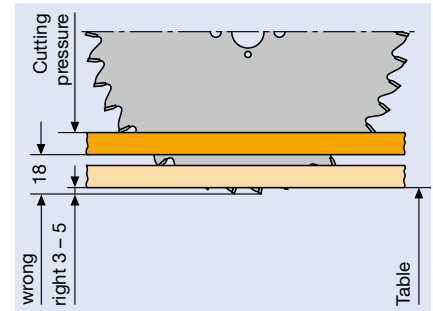
1.5 Cutting non-ferrous metals and plastics

Working process	For splitting, mitre cutting and sizing. Spray lubrication recommended when machining non-ferrous metal profiles.
Workpiece materials	Non-ferrous and plastic profiles, composites, insulating material and aluminium compound materials.
Machines	Splitting, trimming, mitre joint, double cross cutting and sizing machines.

Application



Positive cutting angle:
 The positive cutting angle presses the workpiece onto the table.
 For circular sawblades with the tooth shape FZ/TR and the spindle below the workpiece for cross and mitre cutting with material thickness > 2.5 mm.

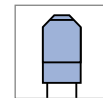


Negative cutting angle:
 The negative cutting angle presses the workpiece onto the table.
 For circular sawblades with the tooth shape FZ/TR and the spindle above the workpieces for cross and mitre cutting with material thickness < 2.5 mm.

Tooth shape



FZ/TR (square/trapezoidal teeth):
 Tooth shape for non-ferrous metals and plastic profiles and boards.



TR/TR (trapezoidal/trapezoidal teeth):
 Tooth shape for better cutting quality with non-ferrous and plastic profiles.
 If altered from the standard FZ/TR shape.



Cross and mitre cuts

Application:

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

Machine:

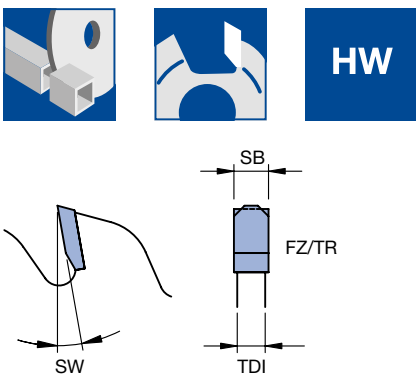
Cross, trimming, mitre and radial saws as well as double mitre cutting saws and CNC machining centres.

Workpiece material:

Non-ferrous metal or plastic profiles.

Technical information:

Spray lubrication recommended when processing non-ferrous metal profiles.



Circular sawblade FZ/TR cutting angle 5°

WK 452 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
Elumatec	280	3.2	2.6	32		96	FZ/TR 5		●	165725 ●
	300	3.2	2.6	30	KNL	72	FZ/TR 5		●	165726 ●
	300	3.2	2.6	30	KNL	96	FZ/TR 5		●	165727 ●
Rapid	320	3.2	2.6	30	KNL	84	FZ/TR 5		●	165728 ●
	350	3.4	2.8	30	KNL	84	FZ/TR 5		●	165729 ●
Rapid	350	3.2	2.6	30	KNL	108	FZ/TR 5		●	165730 ●
Emmegi	350	3.2	2.6	32	2/11/63	84	FZ/TR 5		●	165731 ●
					KNL					
Rapid	370	3.8	3.2	30	KNL	96	FZ/TR 5		●	165732 ●
Rapid	400	3.8	3.2	30	KNL	96	FZ/TR 5		●	165733 ●
Emmegi	400	3.8	3.2	32	2/11/63	96	FZ/TR 5		□	165734 □
Kaltenbach	400	3.8	3.2	50	4/15/80	96	FZ/TR 5		□	165735 □
Rapid, Elumatec	420	3.8	3.2	30	KNL	96	FZ/TR 5		●	165736 ●
	430	3.5	2.8	30	KNL	96	FZ/TR 5		●	165737 ●
	450	3.8	3.2	30	2/11/63	110	FZ/TR 5		●	165738 ●
					KNL					
Emmegi	450	3.8	3.2	32	2/11/63	96	FZ/TR 5		●	165739 ●
					KNL					
Rapid, Elumatec	500	4.4	3.8	30	KNL	120	FZ/TR 5		●	165740 ●
Emmegi	500	4.0	3.4	32	2/11/63	96	FZ/TR 5		●	165741 ●
Emmegi	500	4.0	3.4	32	2/11/63	120	FZ/TR 5		●	165742 ●
Elumatec	500	4.4	3.8	32	2/6/75	120	FZ/TR 5		●	165743 ●
					6/9.2-17.2/75					
Emmegi	550	4.0	3.4	32	2/11/63	96	FZ/TR 5		●	165744 ●
Emmegi	550	4.0	3.4	32	2/11/63	126	FZ/TR 5		●	165745 ●
Elumatec	550	4.4	3.8	30	KNL	120	FZ/TR 5		●	165746 ●
Stegmaier	600	4.6	4.0	30	2/11/63	140	FZ/TR 5		●	165747 ●
	600	5.0	4.4	32	2/11/63	132	FZ/TR 5		●	165748 ●
	650	5.0	4.4	30	2/11/63	144	FZ/TR 5		●	165749 ●

1. Sawing

1.5 Cutting non-ferrous metals and plastics 1.5.1 Cross and mitre cut sawblades for profiles



Cross and mitre cuts *Excellent*

Application:

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

Machine:

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

Workpiece material:

Non-ferrous metal or plastic profiles.

Technical information:

Spray lubrication recommended when processing non-ferrous metal profiles.

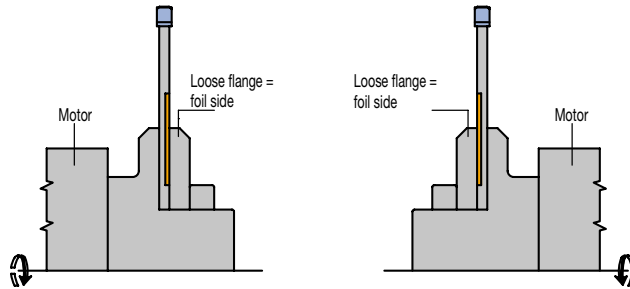
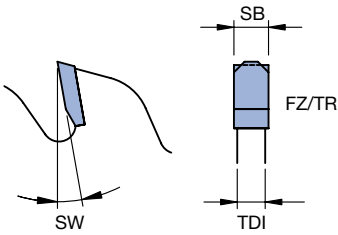
Excellent design. Tool body with vibration damping steel foil.



Circular sawblade FZ/TR cutting angle 5°

WK 472 2

D	SB	TDI	BO	NLA	Z	ZF	SW	Foil	WSS	ID
mm	mm	mm	mm	mm			°			
300	3.2	2.6	30	KNL	96	FZ/TR	5	left		161360 ●
300	3.2	2.6	30	KNL	96	FZ/TR	5	right		161361 ●
350	3.2	2.6	30	KNL	108	FZ/TR	5	left		161362 ●
350	3.2	2.6	30	KNL	108	FZ/TR	5	right		161363 ●





Crossing and mitre cuts with negative cutting angle

Application:

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

Machine:

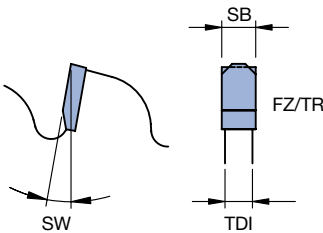
Cross, trimming, mitre and radial saws as well as double mitre cutting saws and CNC machining centres.

Workpiece material:

Non-ferrous metal or plastic profiles.

Technical information:

Spray lubrication recommended when processing non-ferrous metal profiles.
Negative cutting angle for cuts from above.



Circular sawblade FZ/TR cutting angle -5°

WK 462 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
	300	3.2	2.6	30	KNL	72	FZ/TR -5		■ ■	165825 ●
	300	3.2	2.6	30	KNL	96	FZ/TR -5		■ ■	165826 ●
Elektra Beckum, Elu, DeWalt, Fezer, Lurem, Rapid, Ulmia, Scheppach										
Fezer, Rapid, Ulmia	300	3.2	2.6	30	KNL	120	FZ/TR -5		■ ■	165827 ●
	300	3.2	2.6	32	KNL	72	FZ/TR -5		■ ■	165828 □
	300	3.2	2.6	32	KNL	96	FZ/TR -5		■ ■	165829 □
	300	3.2	2.6	32	KNL	120	FZ/TR -5		■ ■	165830 □
Haffner	330	3.2	2.6	30	KNL	96	FZ/TR -5		■ ■	165831 ●
	330	3.2	2.6	32	KNL	96	FZ/TR -5		■ ■	165832 □
Haffner	350	3.4	2.8	30	KNL	84	FZ/TR -5		■ ■	165833 ●
	350	3.8	3.2	30	KNL	84	FZ/TR -5		■ ■	165834 ●
	350	3.8	3.2	32	KNL	84	FZ/TR -5		■ ■	165835 □
	350	3.8	3.2	40	2/10/55	84	FZ/TR -5		■ ■	165836 □
					2/11/63					
					KNL					
Haffner, Ulmia	350	3.2	2.6	30	KNL	108	FZ/TR -5		■ ■	165837 ●
Eisele, Graule	350	3.6	3.0	40	2/9/55	108	FZ/TR -5		■ ■	165838 ●
					4/12/64					
Elumatec	380	3.8	3.2	32		108	FZ/TR -5		■ ■	165839 ●
	400	3.8	3.2	30	KNL	96	FZ/TR -5		■ ■	165840 ●
	400	3.8	3.2	32	2/11/63	96	FZ/TR -5		■ ■	165841 ●
Eisele	400	3.8	3.2	40	2/12/80	96	FZ/TR -5		■ ■	165842 □
					4/12/64					
Kaltenbach	400	3.8	3.2	50	4/15/80	96	FZ/TR -5		■ ■	165843 □
Elumatec, Rapid, Haffner, Wegoma, Ulmia	420	3.8	3.2	30	KNL	108	FZ/TR -5		■ ■	165844 ●
Graule	420	3.8	3.2	40		108	FZ/TR -5		■ ■	165845 □
Rapid	450	3.8	3.2	30	KNL	108	FZ/TR -5		■ ■	165846 ●
Pressta Eisele	450	3.8	3.2	32	2/11/63	108	FZ/TR -5		■ ■	165847 ●
					KNL					
Elu, Wegoma, Rapid	500	4.4	3.8	30	2/11/63	120	FZ/TR -5		■ ■	165848 ●
					6/9/100					
Graule	520	4.4	3.8	50		120	FZ/TR -5		■ ■	165849 ●
Rapid	550	4.0	3.4	30	KNL	132	FZ/TR -5		■ ■	165850 ●
	550	4.0	3.4	32	2/11/63	132	FZ/TR -5		■ ■	165851 □
Stürtz	600	5.2	4.6	30	KNL	138	FZ/TR -5		■ ■	165852 ●

1. Sawing

1.5 Cutting non-ferrous metals and plastics 1.5.1 Cross and mitre cut sawblades for profiles



Crossing and mitre cuts with negative cutting angle *Excellent*

Application:

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

Machine:

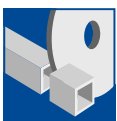
Cross, trimming, mitre and radial saws as well as double mitre cutting saws and CNC machining centres.

Workpiece material:

Non-ferrous metal or plastic profiles.

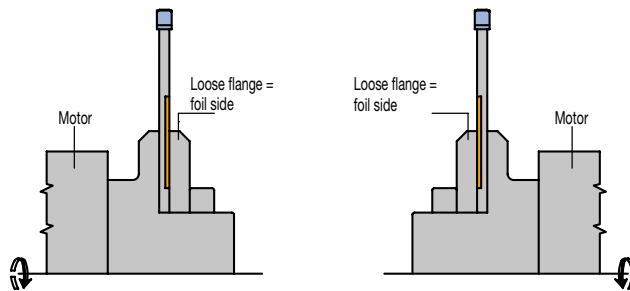
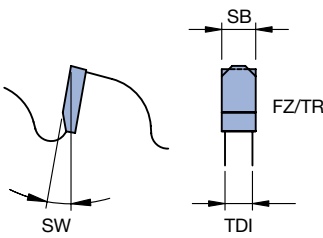
Technical information:

Spray lubrication recommended when processing non-ferrous metal profiles. Negative cutting angle for cuts from above. **Excellent** design. Tool body with vibration damping steel foil.



**Circular sawblade FZ/TR cutting angle -5°
WK 482 2**

D	SB	TDI	BO	NLA	Z	ZF	SW	Foil	WSS	ID
mm	mm	mm	mm	mm			°			
300	3.2	2.6	30	KNL	96	FZ/TR	-5	left		161380 ●
300	3.2	2.6	30	KNL	96	FZ/TR	-5	right		161381 ●
350	3.2	2.6	30	KNL	108	FZ/TR	-5	left		161382 ●
350	3.2	2.6	30	KNL	108	FZ/TR	-5	right		161383 ●





Cross and mitre cuts with reduced cutting width *Premium*

Application:
For trimming and sizing.

Machine:
Cross, trimming, mitre and portable saws.

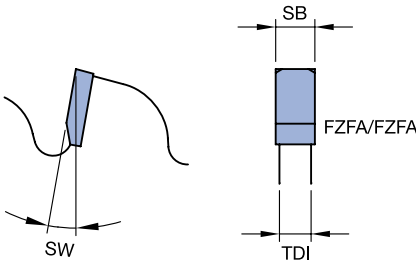
Workpiece material:
Thin walled, non-ferrous metal or plastic profiles, plastic honeycomb boards, fibre reinforced plastics (e.g. GFRP, CFRP), plastic wave boards (e.g. PVC).

Technical information:
Reduced cutting width for thin walled profiles and thin panels. Less resin build up by special coated tool body.



Circular sawblade FZFA cutting angle -5°, thin kerf
WK 467 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
190	1.8	1.4	20		72	FZFA/FZFA	-5		060278 ●
200	1.8	1.4	20	KNL	80	FZFA/FZFA	-5		060274 ●
250	2.0	1.6	30	KNL	100	FZFA/FZFA	-5		060275 ●
300	2.2	1.8	30	KNL	120	FZFA/FZFA	-5		060276 ●
350	2.4	2.0	30	KNL	140	FZFA/FZFA	-5		060279 ●



1. Sawing

1.5 Cutting non-ferrous metals and plastics 1.5.1 Cross and mitre cut sawblades for profiles



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

Application:

For trimming and mitre cutting.

Machine:

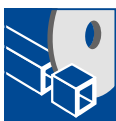
Cross, trimming, mitre and cross cutting twin saws.

Workpiece material:

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

Technical information:

Cutting face with two different cutting angles for smooth surfaces and tear-free cutting edges. **Excellent** design with plastic filled laser ornaments for vibration damping and reduction of noise level.



Circular sawblade GlossCut

WK 377 2

D	SB	TDI	BO	NLA	Z	ZF	WSS	ID
mm	mm	mm	mm	mm				
300	3.0	2.4	30	KNL	72	FZFA/FZFA		161005 ●
300	3.0	2.4	30	KNL	96	FZFA/FZFA		161006 ●
350	3.5	2.8	30	KNL	96	FZFA/FZFA		161007 ●

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



Cross and mitre cuts in finish cut quality *Excellent*

Application:

For trimming and mitre cutting.

Machine:

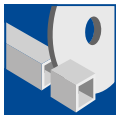
Cross, trimming, mitre and cross cutting twin saws.

Workpiece material:

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

Technical information:

Special tooth geometry for tear-free cutting edges on top and bottom side. DP tipped for long tool life.



Circular sawblade HRFA cutting angle 5°, Diamaster PRO

WK 808 2 DP

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
300	4.4	3.6	30	KNL	60	HRFA	5		190666 □
350	4.4	3.6	30	KNL	70	HRFA	5		190667 □
400	4.4	3.6	30	KNL	80	HRFA	5		762339 □
450	4.4	3.6	30	KNL	90	HRFA	5		190668 □
500	4.4	3.6	30	KNL	100	HRFA	5		762341 □
550	4.4	3.6	30	KNL	110	HRFA	5		762342 □
600	4.8	4.0	30	KNL	120	HRFA	5		762343 □



Sizing in finish cut quality *Excellent* - BrillianceCut

Application:

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

Machine:

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

Workpiece material:

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

Technical information:

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

Circular sawblade BrillianceCut

WK 371 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	WSS	ID
	mm	mm	mm	mm	mm				
	303	3.5	2.5	30	KNL	60	TR/TR	■	161028 ●
Holz-Her, Mayer, Schelling	350	4.4	3.2	30	2/13/94	72	WZ/FA	■	161029 ●
					KNL				
Homag	350	4.4	3.2	60	2/14/100	72	WZ/FA	■	161030 ●
Homag	380	4.8	3.5	60	2/14/100	84	WZ/FA	■	161031 ●
					2/14/125				
					2/19/120				
Mayer, Schelling	400	4.4	3.2	30	2/13/94	72	WZ/FA	■	161032 ●
					KNL				
Mayer, Schelling	450	4.4	3.2	30	KNL	72	WZ/FA	■	161033 ●
Homag	450	4.8	3.5	60	2/14/125	72	WZ/FA	■	161034 ●
					2/19/120				



Sizing in easy melting plastics

Application:

For sizing and cross cutting without scoring.

Machine:

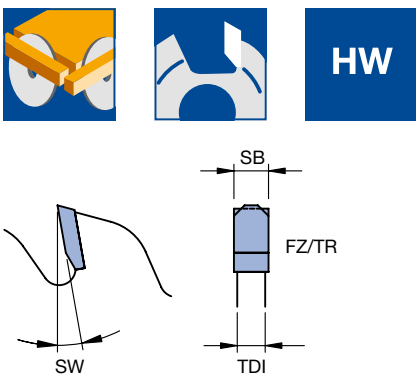
Table and sizing saws, vertical panel sizing saws, panel sizing saws with pressure beam.

Workpiece material:

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

Technical information:

Reduced number of teeth for reduced heating. Large gullets for optimum chip flow.



Circular sawblade FZ/TR, cutting angle 10°

WK 372 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
300	3.6	2.2	30	KNL	20	FZ/TR	10	■	163500 ●
300	3.6	2.2	30	KNL	42	FZ/TR	10	■	163501 ●
350	3.8	2.5	30	KNL	24	FZ/TR	10	■	163502 ●
350	3.8	2.5	30	KNL	48	FZ/TR	10	■	163503 ●
400	3.8	2.5	30	KNL	28	FZ/TR	10	■	163504 ●
400	3.8	2.5	30	KNL	54	FZ/TR	10	■	163505 ●
450	4.0	2.8	30	KNL	34	FZ/TR	10	■	163506 ●
500	4.4	3.0	30	KNL	36	FZ/TR	10	■	163507 ●



Sizing non-ferrous solid material

Application:

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

Machine:

Panel sizing saws with pressure beam.

Workpiece material:

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

Technical information:

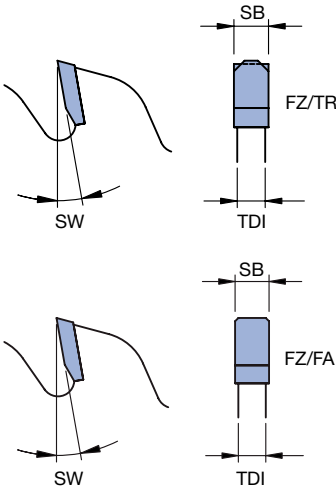
Special tungsten carbide grade for processing non-ferrous metals. Spray lubrication recommended.



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

WK 452 2, WK 457 2, WK 472 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
	350	3.8	3.0	30	KNL	48	FZFA/FZFA	10	■ ■	165925 ●
Mayer	400	4.4	3.5	30	KNL	60	FZFA/FZFA	10	■ ■	165926 ●
Mayer,	450	4.4	3.5	30	KNL	60	FZ/TR	10	■ ■	165927 ●
Schelling					2/13/94					
					2/13/114					
Schelling	460	4.4	3.5	30	2/13/94	48	FZFA/FZFA	10	■ ■	165928 ●
					2/13/114					
Schelling	520	4.4	3.5	30	2/13/94	44	FZFA/FZFA	10	■ ■	165929 ●
					2/13/114					
Schelling	530	4.4	3.5	30	2/13/94	44	FZFA/FZFA	10	■ ■	165930 ●
					2/13/114					
Mayer	570	5.0	4.0	40	2/16/80	48	FZFA/FZFA	10	■ ■	165931 ●
Schelling	620	5.5	4.5	40	2/13/140	36	FZFA/FZFA	10	■ ■	165932 ●
					2/13/114					
Schelling	620	5.5	4.5	40	2/13/140	60	FZ/TR	10	■ ■	165933 ●
					2/13/114					
Schelling	680	5.5	4.5	40	2/13/140	42	FZFA/FZFA	10	■ ■	165934 ●
					2/13/114					



1. Sawing

1.5 Cutting non-ferrous metals and plastics 1.5.2 Circular sawblades für solid panels and blocks



Sizing *Excellent*

Application:
For sizing of single boards.

Machine:
Table, sizing and vertical panel sizing saws.

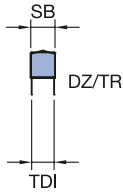
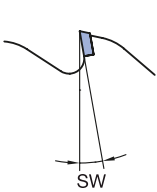
Workpiece material:
Gypsum and cement fibre panels, duroplastics (compact laminated boards, e.g. HPL), fibre reinforced plastics (e.g. GFRP, CFRP), alu composite panels (e.g. Alucobond®). Chipboard and fibre materials plastic coated.

Technical information:
DP tipped for long tool life. **Excellent** design with plastic filled laser ornaments for damping vibrations and reduction of noise level.



Circular sawblade **DZ/TR, Diamaster PRO** WK 872 2

D	SB	BO	NLA	Z	ZF	WSS	ID
mm	mm	mm	mm				
303	3.2	30	KNL	60	DZ/TR		190673 ●
303	3.2	30	KNL	96	DZ/TR		190674 ●



1. Sawing

1.6 Circular sawblades for CNC

Working process	For sizing, separating and trimming cut.
Workpiece materials	Solid wood, wood derived materials, plastics.
Machines	CNC machining centres and aggregates.

Tooth shape



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



Trimming and sizing on CNC machining centres

Application:

For sizing of panels on CNC machining centres.

Machine:

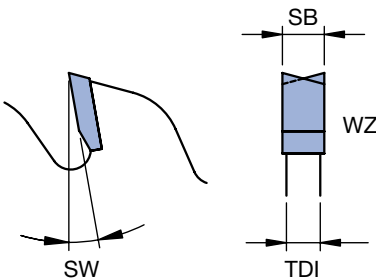
Processing units on CNC machining centres.

Workpiece material:

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

Technical information:

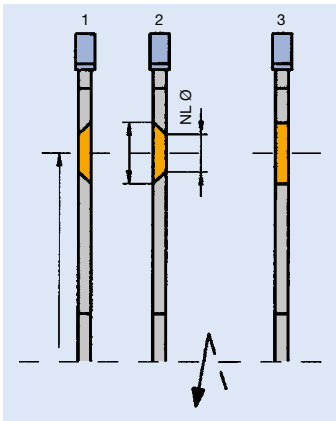
Assembly on sawblade flange of machining aggregates. When sizing coated wood derived materials first score with feed with little infeed (1 - 2 mm) and then cut off against feed. Optimized balancing quality for the use on CNC-aggregates.



Circular sawblade WZ for CNC

WK 150 2, WK 850 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Type	Z	ZF	SW °	WSS	ID
Homag	350	3.6	2.5	30	8/6/90 6/6.8/90	1	16	WZ	15		165975 ●
Homag	350	3.5	2.7	30	8/6/90 6/6.8/90	1	72	WZ	15		165976 ●



Type 1:

Countersink right

Type 2:

Countersink left

Type 3:

Pinhole without countersink



Trimming and sizing on CNC machining centres

Excellent - Katana

Application:

For sizing of panels on CNC machining centres.

Machine:

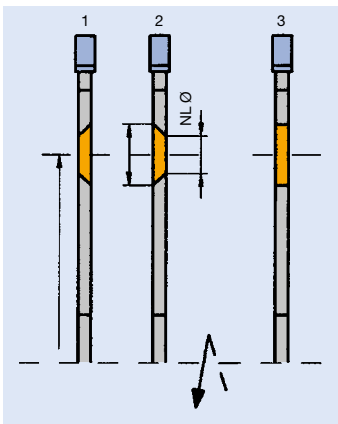
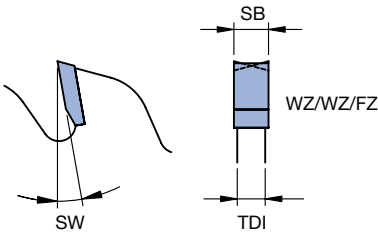
Processing units on CNC machining centres.

Workpiece material:

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

Technical information:

Katana tooth combination with alternate angle of cutting face for best cutting results. **Excellent** design with plastic filled laser ornaments for vibration damping and reduction of noise level. Mounting on flanges of processing units. When sizing wood derived materials first score with feed (1 - 2 mm) and then cut against feed. Optimized balancing quality for the use on CNC-aggregates.



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

Circular sawblade Katana for CNC

WK 879 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Type Z	ZF	SW	WSS	ID
	180	3.0	2.2	30			60 WZ/WZ/FZ	10	●	161267 ●
Homag,	180	3.0	2.2	30	2/6/42	3	60 WZ/WZ/FZ	10	●	161250 ●
Weeke					4/5.5/45	2				
					8/6/90	1				
Flex 5, Flex 5+	180	3.0	2.2	40	8/6.6/52	2	60 WZ/WZ/FZ	10	●	161251 ●
Homag, IMA	200	3.0	2.2	30	2/6.2/42	3	65 WZ/WZ/FZ	10	●	161253 ●
					4/6/52	2				
					8/6/90	1				
IMA	200	3.0	2.2	30	2/6/42	3	65 WZ/WZ/FZ	10	●	161254 ●
					4/6.6/60	2				
	220	3.0	2.2	30	8/6/90	1	70 WZ/WZ/FZ	10	●	161255 ●
Flex 5,	220	3.0	2.2	40	8/6.6/52	2	70 WZ/WZ/FZ	10	●	161256 ●
Flex 5+,										
Homag,										
Weeke										
	240	3.0	2.2	30			75 WZ/WZ/FZ	10	●	161268 ●
	240	3.0	2.2	30	4/6.6/52	1	75 WZ/WZ/FZ	10	●	161257 ●
					4/6.6/52	2				
					8/6/90	1				
Flex 5,	240	3.0	2.2	40	8/6.6/52	2	75 WZ/WZ/FZ	10	●	161258 ●
Flex 5+,										
Weeke,										
Homag										
Biesse,	250	3.0	2.2	30	2/6/42	3	80 WZ/WZ/FZ	10	●	161259 ●
Holz-Her					2/6/50	3				
					8/6/90	1				
Homag,	280	3.0	2.2	30	2/7/42	3	85 WZ/WZ/FZ	10	●	161260 ●
Felder					8/6/90	1				
Format-4										
Homag	350	3.5	2.7	30	8/6/90	1	110 WZ/WZ/FZ	10	●	161263 ●



Trimming and sizing on CNC machining centres

Excellent - WhisperCut

Application:

For sizing of panels on CNC machining centres.

Machine:

Processing units on CNC machining centres.

Workpiece material:

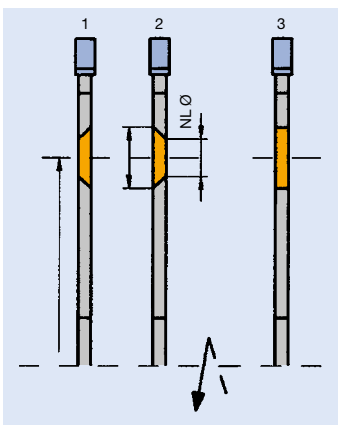
Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), solid wood panels across grain and for mitre joints.

Technical information:

Extreme noise reduction. Special design and grouping of teeth for perfect cuts and reduced cutting forces. **Excellent** design with plastic filled laser ornaments for vibration damping and reduction of noise level. Stable tooth geometry for a long tool life. Universal use for various materials. Resharpenable two times.

Mounting on flanges of processing units. When sizing wood derived materials first score with feed (1 - 2 mm) and then cut against feed.

Optimized balancing quality for the use on CNC-aggregates.



Type 1:

Countersink right

Type 2:

Countersink left

Type 3:

Pinhole without countersink

Circular sawblade WhisperCut for CNC

WK 879 2, WK 879 2 DP

Machine	D	SB	TDI	BO	NLA	Type	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm				°		
Homag, Weeke	180	2.5	2.0	30	8/6/90	1	35	HZFA/WZFA	10		190713 ●
Flex 5, Flex 5+	180	2.5	2.0	40	8/6.6/52	2	35	HZFA/WZFA	10		190714 ●
Homag, IMA	200	2.5	2.0	30	2/6.2/42	3	40	HZFA/WZFA	10		190715 ●
					4/6/52	2					
					8/6/90	1					
IMA	200	2.5	2.0	30	2/6.2/42	3	40	HZFA/WZFA	10		190716 ●
					4/6.6/60	2					
					8/6/90	1					
Flex 5, Flex 5+, Homag, Weeke	220	2.5	2.0	30	8/6/90	1	45	HZFA/WZFA	10		190717 ●
	220	2.5	2.0	40	8/6.6/52	2	45	HZFA/WZFA	10		190718 ●
					4/6.6/52	1	50	HZFA/WZFA	10		190719 ●
					4/6.6/52	2					
					8/6/90	1					
Flex 5, Flex 5+, Homag, Weeke	240	2.5	2.0	40	8/6.6/52	2	50	HZFA/WZFA	10		190720 ●
Biesse, Holz-Her	250	2.5	2.0	30	2/6/42	3	50	HZFA/WZFA	10		190721 ●
					2/6/50	3					
					8/6/90	1					
Homag, Felder	280	2.5	2.0	30	2/7/42	3	55	HZFA/WZFA	10		190722 ●
					8/6/90	1					
Format-4											
Homag	303	3.2	2.4	30	KNL	3	60	HZFA/WZFA	10		190728 □
					8/6/90	1					
Homag	350	3.2	2.4	30	KNL	3	70	HZFA/WZFA	10		190729 □
					8/6/90	1					



Grooving on CNC machining centres

Application:

For grooving.

Machine:

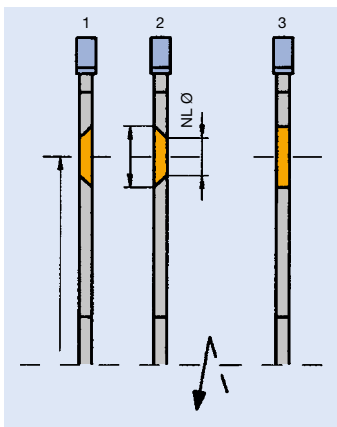
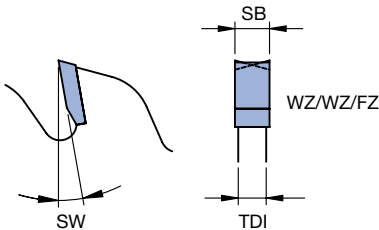
Processing units on CNC machining centres.

Workpiece material:

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

Technical information:

Tooth combination WZ/WZ/FR for tear-free grooves. Mounting on flanges of processing units. Application with feed recommended for tear-free grooves.



Type 1: Countersink right

Type 2: Countersink left

Type 3: Pinhole without countersink

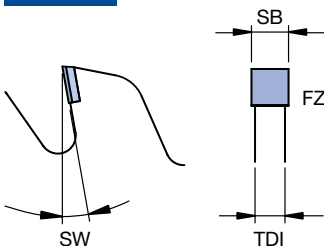
Grooving circular sawblade WZ/WZ/FZ for CNC, HW tipped

WK 859 2

Machine	D	SB	TDI	BO	NLA	Type Z	ZF	SW	WSS	ID	
	mm	mm	mm	mm	mm			°			
Weeke	100	3.5	2.5	30		35	WZ/WZ/FZ	15	■	166000 ●	
Weeke	100	4.0	2.8	30		35	WZ/WZ/FZ	15	■	166008 ●	
Weeke	100	5.0	3.5	30		35	WZ/WZ/FZ	15	■	166001 ●	
	100	8.5	3.5	20		35	WZ/WZ/FZ	15	■	166013 ●	
SCM, Morbidelli, Holz-Her	120	3.5	2.5	20	3/4.5/35	1	35	WZ/WZ/FZ	15	■	166002 ●
Biesse, Felder	120	3.5	2.5	35	4/6.3/50	1	35	WZ/WZ/FZ	15	■	166004 ●
					4/6.3/50	2					
SCM, Morbidelli, Holz-Her	120	4.0	2.8	20	3/4.5/35	1	35	WZ/WZ/FZ	15	■	166009 ●
					3/4.5/35	2					
Biesse, Felder	120	4.0	2.8	35	4/6.3/50	1	35	WZ/WZ/FZ	15	■	166010 ●
					4/6.3/50	2					
SCM, Morbidelli, Holz-Her	120	5.0	3.5	20	3/4.5/35	1	35	WZ/WZ/FZ	15	■	166003 ●
					3/4.5/35	2					
Biesse, Felder	120	5.0	3.5	35	4/6.3/50	1	35	WZ/WZ/FZ	15	■	166005 ●
					4/6.3/50	2					
Homag, Weeke	125	3.5	2.5	30	4/5.5/48	1	35	WZ/WZ/FZ	15	■	166006 ●
					4/5.5/48	2					
Homag, Weeke	125	4.0	2.8	30	4/5.5/48	1	35	WZ/WZ/FZ	15	■	166011 ●
					4/5.5/48	2					
Homag, Weeke	125	5.0	3.5	30	4/5.5/48	1	35	WZ/WZ/FZ	15	■	166007 ●
					4/5.5/48	2					
Homag	200	5.0	3.5	30	4/5.5/52	1	60	WZ/WZ/FZ	15	■	166012 ●
					4/5.5/52	2					

Technical information:

Mounting on flanges of processing units. Application with feed recommended for tear-free grooves.



Grooving circular sawblade FZ for CNC, DP tipped

WF 100 2 DP

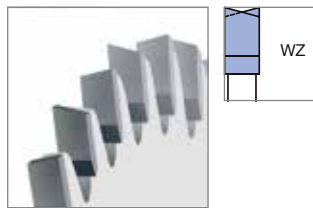
D	SB	TDI	BO	Z	ZF	QAL	SW	WSS	ID
mm	mm	mm	mm				°		
100	4.0	2.5	20	12	FZ	DP	10	■	192303 ●

1. Sawing

1.7 Portable saws and table-top machines

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

Tooth shapes



WZ (alternative top bevel teeth)



FZ/TR (square/trapezoidal teeth)

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

Tooth pitch/cut quality

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

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



Universal sizing

Application:

For cutting along and across grain and sizing.

Machine:

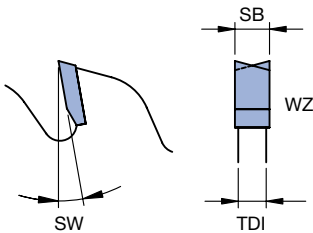
Portable and table saws.

Workpiece material:

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

Technical information:

Tooth shape for universal use.



Circular sawblade WZ pos. cutting angle

WK 150 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
Elu, DeWalt, Peugeot	100	2.4	1.6	12		30	WZ	10		166109 ●
Elu, DeWalt	100	2.4	1.6	22		30	WZ	10		166110 ●
Haffner, Mafell	120	2.4	1.6	20		24	WZ	15		166111 ●
Haffner, Mafell	125	2.4	1.6	20		24	WZ	15		166112 ●
Haffner, Mafell	125	2.4	1.6	20		36	WZ	10		166113 ●
AEG, Bosch, Holz-Her, Metabo	140	2.4	1.6	20		24	WZ	15		166114 ●
AEG, Atlas Copco, Elu, DeWalt, Metabo, Skil	150	2.8	1.8	20		48	WZ	10		166115 ●
Metabo	160	1.6	1.1	20		24	WZ	25		166100 ●
AEG, Atlas Copco, Festool, Haffner, Hilti, Holz-Her, Mafell, Narex, Protool	160	1.8	1.2	20		18	WZ	25		166101 ●
AEG, Atlas Copco, Festool, Haffner, Hilti, Holz-Her, Mafell, Narex, Protool	160	1.8	1.2	20		32	WZ	5		166102 ●
AEG, Atlas Copco, Festool, Haffner, Hilti, Holz-Her, Mafell, Narex, Protool	160	2.5	1.6	20		12	WZ	20		166116 ●
AEG, Atlas Copco, Festool, Haffner, Hilti, Holz-Her, Mafell, Narex, Protool	160	2.5	1.6	20		24	WZ	15		166117 ●
AEG, Atlas Copco, Festool, Haffner, Hilti, Holz-Her, Mafell, Narex, Protool	160	2.5	1.6	20		48	WZ	15		166118 ●
Bosch, DeWalt, Hilti, Makita	165	2.2	1.6	20		24	WZ	15		166119 ●
Bosch, DeWalt, Hilti, Makita	165	2.2	1.6	20		48	WZ	10		166104 ●
Bosch, DeWalt, Hilti, Makita	165	2.4	1.6	20		12	WZ	15		166103 ●
Bosch, Elu, DeWalt, Festool, Haffner	170	2.5	1.6	30		48	WZ	10		166120 ●
Haffner, Makita	180	2.5	1.6	20		24	WZ	15		166121 ●
Haffner, Makita	180	2.5	1.6	20		48	WZ	10		166122 ●
Bosch, Elu, DeWalt, Mafell	180	2.5	1.6	30		24	WZ	15		166123 ●
Bosch, Elu, DeWalt, Mafell	180	2.5	1.6	30		48	WZ	10		166105 ●
AEG, Bosch, DeWalt, Makita, Milwaukee, Skil, Black & Decker	184	2.5	1.6	20		24	WZ	15		166124 ●
AEG, Atlas Copco, Bosch, Protool	190	2.5	1.8	30		24	WZ	20		166128 ●
Bosch, Skil	190	2.8	1.8	16		24	WZ	15		166125 ●
Bosch, Skil	190	2.8	1.8	16		48	WZ	10		166126 ●
AEG, Atlas Copco, Bosch, Elu, DeWalt, Festool, Mafell, Makita, Skil	190	2.8	1.8	30		16	WZ	20		166127 ●

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
AEG, Atlas Copco, Bosch, Elu, DeWalt, Festool, Mafell, Makita, Protool, Skil	190	2.8	1.8	30		48	WZ	10		166129 ●
AEG, Bosch, Elektra Beckum, Festool, Haffner, Holz-Her, Mafell	200	3.0	2.0	30		34	WZ	10		166130 ●
AEG, Bosch, Elektra Beckum, Festool, Haffner, Holz-Her, Mafell	200	3.0	2.0	30		48	WZ	10		166131 ●
AEG, Atlas Copco, Elektra Beckum, Fein, Festool, Haffner, Holz-Her, Mafell, Makita, Metabo, Skil	210	2.4	1.6	30		24	WZ	15		166133 ●
AEG, Atlas Copco, Elektra Beckum, Fein, Festool, Haffner, Holz-Her, Mafell, Makita, Metabo, Skil	210	2.4	1.6	30		42	WZ	20		166134 ●
AEG, Atlas Copco, Elektra Beckum, Fein, Festool, Haffner, Holz-Her, Mafell, Makita, Metabo, Skil	210	2.4	1.6	30		60	WZ	10		166135 ●
Haffner, Holz-Her, Metabo	220	3.2	2.2	30		34	WZ	15		166136 ●
Haffner, Holz-Her, Metabo	220	3.2	2.2	30		60	WZ	10		166107 ●
Festool, Mafell	225	2.6	1.8	30		32	WZ	20		166137 ●
Festool, Mafell	225	2.6	1.8	30		48	WZ	10		166138 ●
Hilti, Mafell	230	2.5	1.8	30		24	WZ	20		166140 ●
Hilti, Mafell	230	2.5	1.8	30		48	WZ	15		166108 ●
AEG, Atlas Copco, Bosch, Holz-Her, Metabo	230	3.2	2.2	30		34	WZ	15		166141 ●
	235	2.5	1.8	30		24	WZ	15		166156 ●
	235	2.5	1.8	30		56	WZ	15		166157 ●
Haffner, Makita, Skil	235	3.2	2.2	30		24	WZ	15		166142 ●
Haffner, Makita, Skil	235	3.2	2.2	30		34	WZ	15		166143 ●
Elu, DeWalt, Festool, Haffner, Holz-Her, Metabo, Protool	240	3.0	2.0	30		34	WZ	15		166144 ●
Elu, DeWalt, Festool, Haffner, Holz-Her, Metabo, Protool	240	3.0	1.8	30		48	WZ	10		166145 ●
Elektra Beckum, Elu, DeWalt, Lurem, Mafell, Metabo, PHM, Scheppach	250	2.8	2.0	30	KNL	24	WZ	25		166146 ●
Elektra Beckum, Elu, DeWalt, Lurem, Mafell, Metabo, PHM, Scheppach	250	2.8	2.0	30	KNL	60	WZ	20		166147 ●
Makita	260	3.2	2.2	30	KNL	60	WZ	10		166148 ●
Lurem, Mafell	280	3.2	2.2	30	KNL	48	WZ	10		166149 ●
Lurem, Mafell	280	3.2	2.2	30	KNL	60	WZ	10		166150 ●
Elektra Beckum, Lurem, Scheppach	315	3.0	2.0	30	KNL	48	WZ	15		166152 ●
Elektra Beckum, Lurem, Scheppach	315	3.2	2.2	30	KNL	28	WZ	20		166151 ●
Elektra Beckum, Lurem, Scheppach	315	3.2	2.2	30	KNL	72	WZ	10		166153 ●
Mafell	355	3.2	2.2	30	KNL	16	WZ	20		166154 ●
Mafell	355	3.2	2.2	30	KNL	32	WZ	20		166155 ●



Trimming from the top

Application:

For sizing across grain, trimming and cross cutting.

Machine:

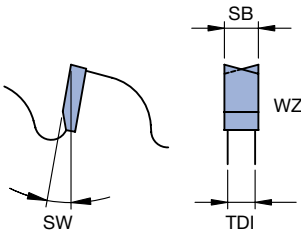
Trimming and mitre saws.

Workpiece material:

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

Technical information:

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



Circular sawblade WZ cutting angle -5°

WK 160 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
AEG, Atlas Copco, Elektra Beckum, Fein, Haffner, Holz-Her, Mafell, Makita, Metabo, Skil	210	2.8	2.0	30		60	WZ	-5	■ ■	166252 ●
Elu, DeWalt, Makita, Metabo	216	3.0	2.0	30		24	WZ	-5	■ ■	166253 ●
Elu, DeWalt, Makita, Metabo	216	3.0	2.0	30		48	WZ	-5	■ ■	166254 ●
Elu, DeWalt, Makita, Metabo	216	3.0	2.0	30		64	WZ	-5	■ ■	166255 ●
Elektra Beckum, Elu, DeWalt, Lurem, Mafell, Metabo, PHM, Scheppach	250	2.4	1.8	30	KNL	48	WZ	-5	■ ■	166256 ●
Elektra Beckum, Elu, DeWalt, Lurem, Mafell, Metabo, PHM, Scheppach	250	2.4	1.8	30	KNL	60	WZ	-5	■ ■	166257 ●
Elektra Beckum, Elu, DeWalt, Lurem, Mafell, Metabo, PHM, Scheppach	250	3.2	2.6	30	KNL	80	WZ	-5	■ ■	166258 ●
Makita	255	2.8	2.0	30	KNL	60	WZ	-5	■ ■	166259 ●
Festool	260	2.5	1.8	30	KNL	60	WZ	-5	■ ■	166250 ●
Festool	260	2.5	1.8	30	KNL	80	WZ	-5	■ ■	166251 ●



Trimming cut

Application:

For sizing, trimming and cross cutting.

Machine:

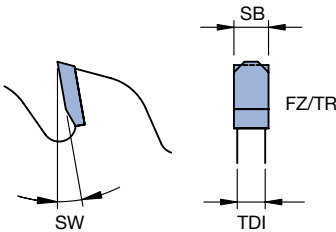
Portable and table saws.

Workpiece material:

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

Technical information:

Solid tooth shape for universal use.



Circular sawblade FZ/TR cutting angle 5°

WK 452 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
AEG, Atlas Copco, Festool, Haffner, Hilti, Holz-Her, Mafell, Narex, Protool	160	2.6	1.8	20		48	FZ/TR	5	■ ■	166300 ●
	180	3.2	2.6	16		42	FZ/TR	5	■ ■	166301 ●
Bosch, Festool, Holz-Her, Mafell, Makita, Skil	190	2.8	1.8	30		54	FZ/TR	5	■ ■	166302 ●
Emmegi	200	2.8	2.2	20		84	FZ/TR	5	■ ■	166303 ●
Eisele, Elu, DeWalt, Haffner	200	3.2	2.6	30	KNL	48	FZ/TR	5	■ ■	166304 ●
Makita	250	3.2	2.6	30	KNL	60	FZ/TR	5	■ ■	166305 ●
Elektra Beckum, Elu, DeWalt, Haffner, Mafell, Makita, Metabo, PHM, Rapid, Scheppach	250	3.2	2.6	30	KNL	80	FZ/TR	5	■ ■	166306 ●
	250	3.2	2.6	32	2/11/63	60	FZ/TR	5	■ ■	166307 □
Elu, Pressta Eisele	250	3.2	2.6	32	2/11/63	80	FZ/TR	5	■ ■	166308 □
Eisele, Graule	250	3.2	2.6	40	2/8/55	80	FZ/TR	5	■ ■	166309 □
					4/12/64					
Eisele, Graule	275	3.4	2.8	40	2/9/55	72	FZ/TR	5	■ ■	166310 ●
					4/12/64					



Trimming from the top

Application:

For sizing across grain, trimming and cross cutting.

Machine:

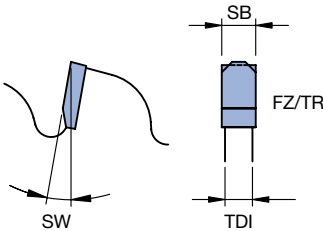
Trimming and mitre saws.

Workpiece material:

Non-ferrous metal or plastic profiles.

Technical information:

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



Circular sawblade FZ/TR cutting angle -5°

WK 462 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
	160	2.5	1.8	20		56	FZ/TR	-5	■ ■	166350 ●
Makita, Bosch, DeWalt	165	2.2	1.6	20		56	FZ/TR	-5	■ ■	166351 ●
Haffner, Makita	180	3.2	2.6	20		42	FZ/TR	-5	■ ■	166352 ●
	190	2.6	1.8	20		54	FZ/TR	-5	■ ■	166353 ●
	190	2.8	2.2	30		68	FZ/TR	-5	■ ■	166354 ●
Fezer	200	3.2	2.6	18		80	FZ/TR	-5	■ ■	166355 ●
Ulmia	200	3.2	2.6	30		60	FZ/TR	-5	■ ■	166356 ●
Festool	210	2.4	1.6	30		64	FZ/TR	-5	■ ■	166357 ●
Hitachi, Metabo, Makita	210	2.8	2.0	30		60	FZ/TR	-5	■ ■	166358 ●
Elu, DeWalt	216	3.0	2.4	30		64	FZ/TR	-5	■ ■	166359 ●
Haffner, Reich	220	3.2	2.6	30		72	FZ/TR	-5	■ ■	166360 ●
	225	2.6	1.8	30		68	FZ/TR	-5	■ ■	166361 ●
	250	3.2	2.6	30	KNL	60	FZ/TR	-5	■ ■	166362 ●
Elu, DeWalt, Fezer	250	3.2	2.6	30	KNL	80	FZ/TR	-5	■ ■	166363 ●
Festool	260	2.4	1.8	30	KNL	68	FZ/TR	-5	■ ■	166364 ●
	275	3.2	2.6	30	KNL	88	FZ/TR	-5	■ ■	166365 ●



Circular sawblades for metals - DryCut

Application:

For splitting, trimming and sizing.

Machine:

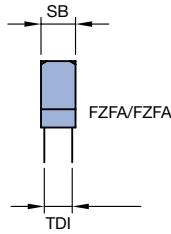
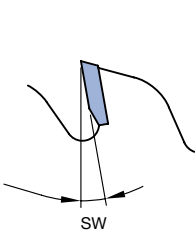
Trimming and mitre saws, portable machines and table saws.

Workpiece material:

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

Technical information:

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



Circular sawblade DryCut

WK 357 2, WK 457 2

D	SB	TDI	BO	Z	ZF	WSS	ID
mm	mm	mm	mm				
160	1.6	1.2	20	48	FZFA/FZFA	■	169000 ●
165	1.6	1.2	20	48	FZFA/FZFA	■	169001 ●
184	1.8	1.4	20	48	FZFA/FZFA	■	163525 ●
190	1.8	1.4	30	54	FZFA/FZFA	■	169002 ●
210	1.8	1.4	30	60	FZFA/FZFA	■	169003 ●
225	2.2	1.8	30	64	FZFA/FZFA	■	169004 ●
254	2.2	1.8	30	72	FZFA/FZFA	■	169005 ●
300	2.2	1.8	30	80	FZFA/FZFA	■	163527 ●
305	2.4	2.0	25.4	80	FZFA/FZFA	■	163526 ●
355	2.4	2.0	25.4	80	FZFA/FZFA	■	169006 ●
400	3.0	2.4	30	84	FZFA/FZFA	■	163528 ●



Sizing in finish cut quality *Excellent* - GlossCut

Application:
For trimming and sizing.

Machine:
Portable and table saws.

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

Technical information:
Cutting face with two different cutting angles for smooth surfaces and tear-free cutting edges. **Excellent** design with plastic filled laser ornaments for vibration damping and reduction of noise level (over D-210 mm).



Circular sawblade GlossCut
WK 357 2

D	SB	TDI	BO	NLA	Z	ZF	WSS	ID
mm	mm	mm	mm	mm				
160	2.2	1.6	20		48	FZFA/FZFA		161008 ●
165	2.2	1.6	20		48	FZFA/FZFA		161009 ●
190	2.4	1.8	20		58	FZFA/FZFA		161010 ●
210	2.4	1.8	30		68	FZFA/FZFA		161011 ●
250	2.8	2.0	30	KNL	72	FZFA/FZFA		161012 ●

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



Universal sizing

Application:

For universal use on building sites.

Machine:

Universal cutting saws.

Workpiece material:

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

Technical information:

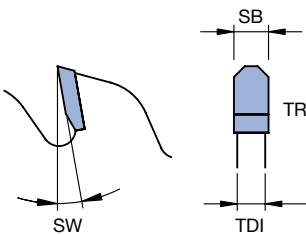
Tool body with round closed form and stable tooth shape. Special tungsten carbide grade for all requirements on construction sites. Noise reducing design.



Circular sawblades TR for saw benches

WK 123 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
350	3.5	2.5	30	KNL	24	TR	10		166025 ●
400	3.8	2.8	30	KNL	28	TR	10		166026 ●
450	4.0	3.0	30	KNL	32	TR	10		166027 ●
500	4.0	3.0	30	KNL	36	TR	10		166028 ●





Cutting facade panels *Excellent*

Application:
For trimming and sizing.

Machine:
Table and sizing saws, portable and radial cross saws.

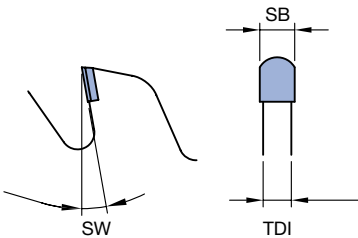
Workpiece material:
Gypsum and cement based panels.

Technical information:
DP tipped for long tool life.



Circular sawblades DP design WK 808 2 DP

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
160	3.2	2.4	20		4	P	5	■	190302 ●
184	3.2	2.4	20		4	P	5	■	190696 ●
190	3.2	2.4	20		4	P	5	■	190303 ●
190	3.2	2.4	30		4	P	5	■	190745 ●
225	3.2	2.4	30		6	P	5	■	190304 ●
300	3.2	2.4	30	KNL	8	P	5	■	190305 ●



Reducing rings

Technical information:

For reducing the bore of circular sawblades reducing rings can be used. Attention: When using reducing rings, pay attention to the distance to the flange. Reducing rings in riffle design.

Reducing ring riffled

TB 100 0 02

D	BO	DIK	ID
mm	mm	mm	
20	16	1.0	061148 ●
20	16	1.6	061104 ●
30	20	1.4	061149 ●
30	25.4	1.8	061150 ●
32	30	1.8	061151 ●

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

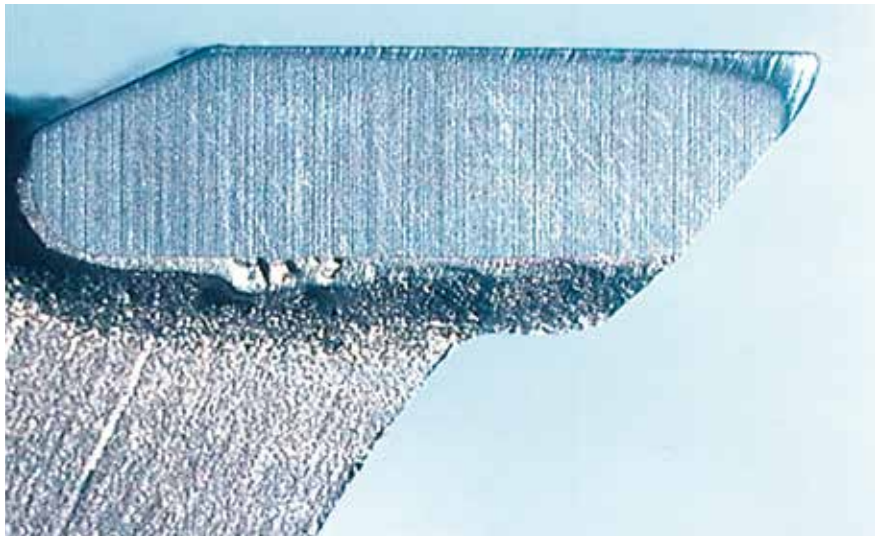
Problem	Possible cause	Action
Exceeded tolerances of horizontally cut lamellas	- Sawblade tensioning not suitable for horizontal application.	Check the sawblade tensioning.
	- High resin build up on tool, tool runs very hot from friction in cut.	Clean sawblades and check if blunt.
	- Thickness and position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

Rounding of cutting edge

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

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

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



Worn HW saw tooth.

Cutting edge chips and cutting edge fracture

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

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

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



Choked gullet.

Cracking of tool body

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

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



Fracture in the saw body.

Cutting edge rounding of DP

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

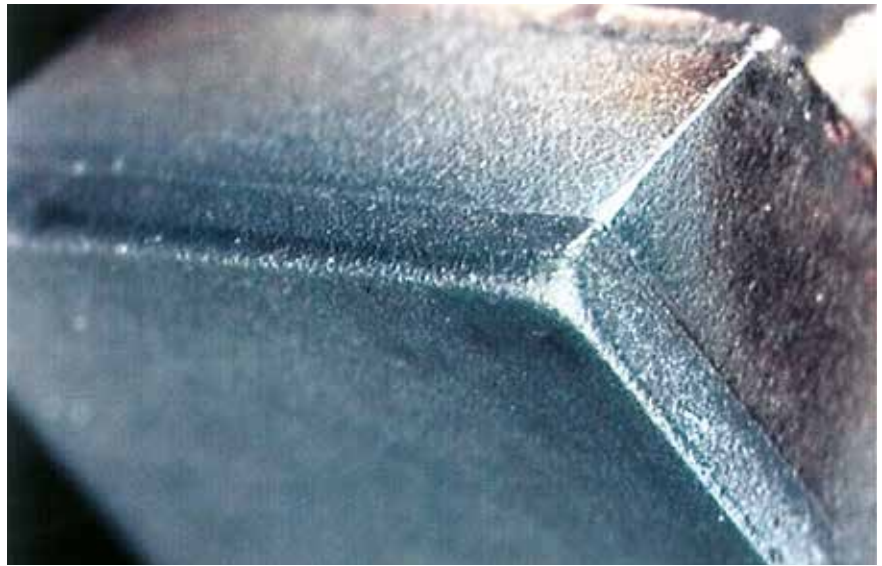
Rounding of the minor cutting edges can lead to reduced performance time and to deterioration in the cut and edge quality.

Action:

- Additional lateral eroding to the tooth relief angle.

This leads to:

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



Worn DP saw tooth.

Cutting edge chips and cutting edge fracture

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

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

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

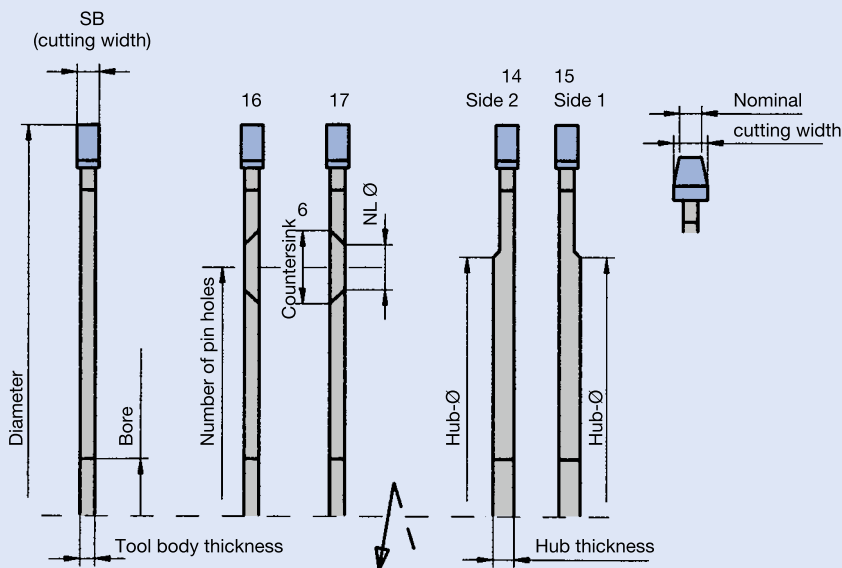
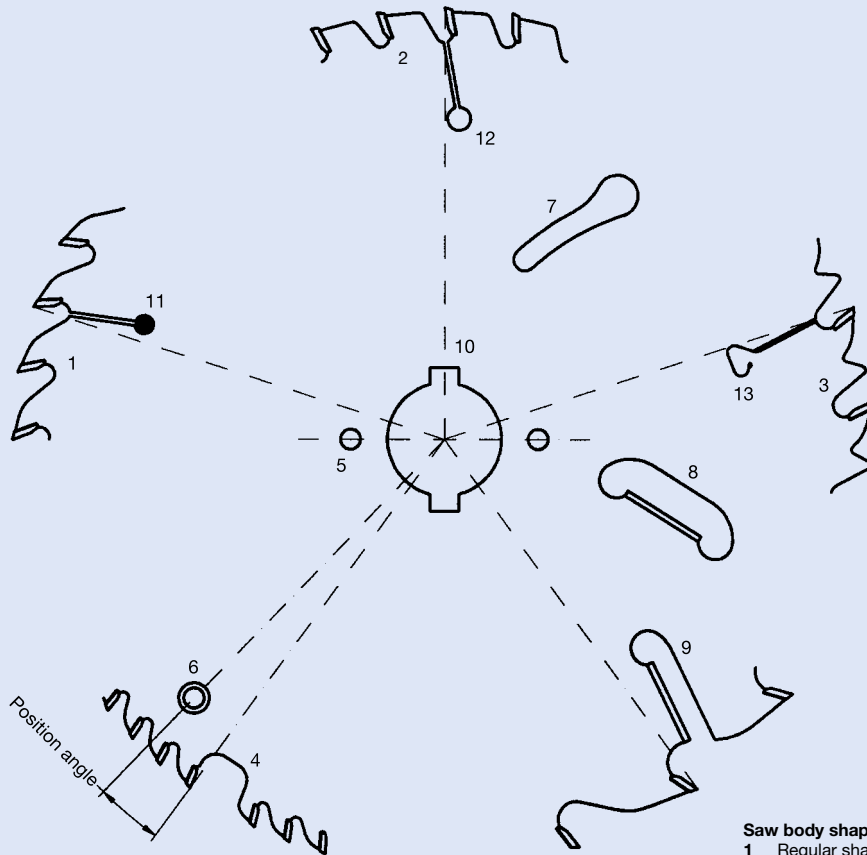
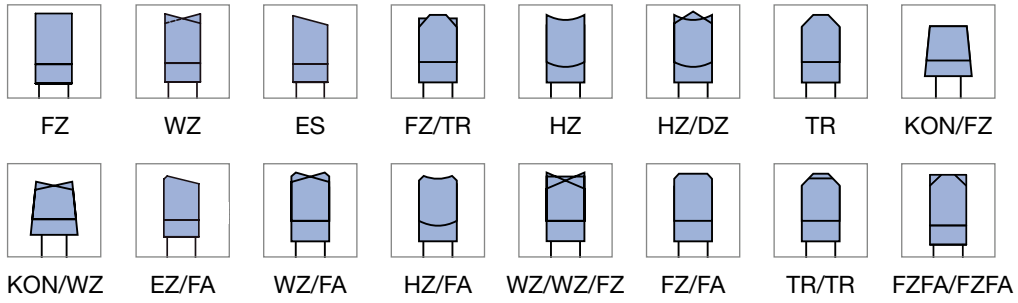
The condition of cutting edges and saw bodies must be checked regularly. When the performance time is up, the tools must be resharpened by experts.



Cutting edge fracture of a DP saw tooth.

Enquiry/order form special tools – sawing

Tooth shapes



Saw body shape:

- 1 Regular shape
- 2 Round shape
- 3 Limitor

Cut out:

- 4 Tooth cut out

Pinholes:

- 5 Pinhole
- 6 Pinhole with countersink

Additional elements in the saw body:

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

Expansion slots:

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

Position of hub:

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

Direction of rotation:

- 16 Right hand rotation
- 17 Left hand rotation

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Key to pictograms



Sawing thin kerf



Sawing hollow metal



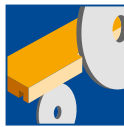
Sawing horizontal



Sawing crosscut metal



Sawing along grain



Scoring, hogging



Sawing across grain



Grooving, horizontal and vertical



Sawing universal



Tipped tool



Scoring, sawing



Low Noise Low noise



Scoring and sawing stacks



Tungsten carbide



Sawing hollow sections



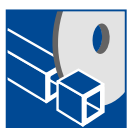
Polycrystalline diamond (PCD)



Sawing plastic single



Sawing plastic stacks



Sawing solid transparent plastic

