

2. Hogger Units

Hogger Units

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Hoggers with carbide tips (HM) designed for professional machining of solid soft and hard wood, glued wood and other wood-based materials. As standard, each hogger GSZ-01 includes a saw blade, a hogger with segments and a special sleeve; GSZ-02 and GSZ-03 include a saw blade, a cutter and a sleeve. Hoggers during formatting solid wood work unassisted and during machining wood-based materials they work together with a scoring saw blade.

Hoggers are made from the highest quality steel in special heat treatment technology, in a vacuum heater, which has been properly selected for the type of work, parameters and conditions prevailing during the machining, in order to guarantee proper work of the tool, both in standard and extreme conditions.

The *Hogger Units* chapter includes only example types and models of hoggers with basic dimensions. Big part of our offer are hoggers on client's special request, meeting buyer's specific demands. Before we start designing and production process we take into consideration many issues connected with client's requirements such as expected machining quality, type and parameters of the machine, workpiece material and many others. Hoggers are produced with various types of clamping. Clamping construc-

tion guarantees easy installation of the whole sets on the machine. Designing and production time of hoggers or sets of hoggers made on client's request, in most cases, does not take more than 10 working days after agreeing all the details.

All types of hoggers are manufactured on modern CNC machines of world-renowned producers, which guarantee high accuracy and precision of the produced tools. Interoperational and final control verifies tools production and guarantees that every tool sent to the client is manufactured according to technical documentation and standards. The construction and production remains in accordance with all points of safety standard EN/PN-847-1 concerning tools for mechanical woodworking.

Orders should include:

- outer diameter (D) or diameters range,
- bore diameter (d),
- width of formatted element (s),
- number of teeth (z) or spindle rotation speed and feed speed,
- type of machined material,
- other information relevant for designing and production process.



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2

Pictograms



solid dry softwood



solid dry hardwood



solid wet softwood



solid wet hardwood



solid frozen wood



chipboard



plywood



laminated board



MDF board



HDF board



longitudinal cut



cross and longitudinal cut



cutting with scoring saw blade



mechanical feed



carbide



stellite

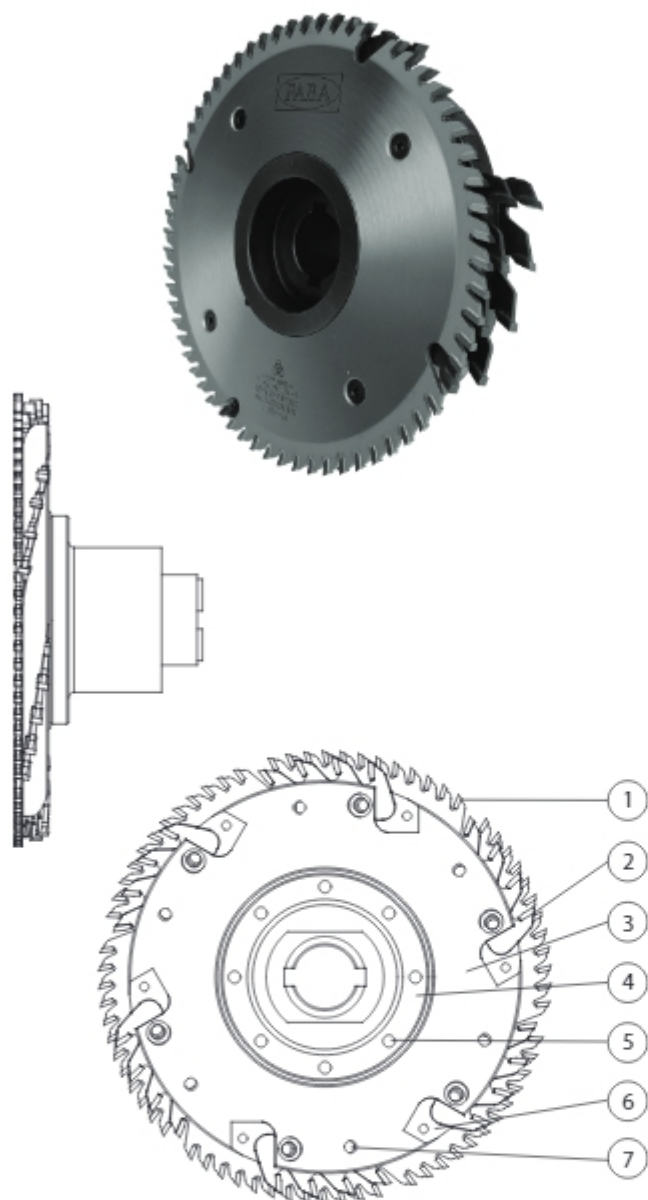
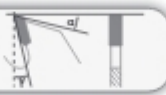
- product available on stock
- + approximate production time 9 days

GSZ-01


Complete hogger unit, type **GSZ-01** with very hard carbide tips (T), designed for gross formatting and hogging of chipboard and MDF on automatic lines.

Type of cut: cross and longitudinal, formatting with and without a scoring saw blade.

Przeznaczenie: gross chipboard and MDF.

**GM**

Type	D mm	B mm	d mm	z segment	z	↗		
GSZ-01	250	19	35	6x4	48	L/R	GM	+
GSZ-01	250	19	35	6x4	72	L/R	GM	+
GSZ-01	300	30	35	6x7	72	L/R	GM	+
GSZ-01	350	40	35	6x10	72	L/R	GM	+

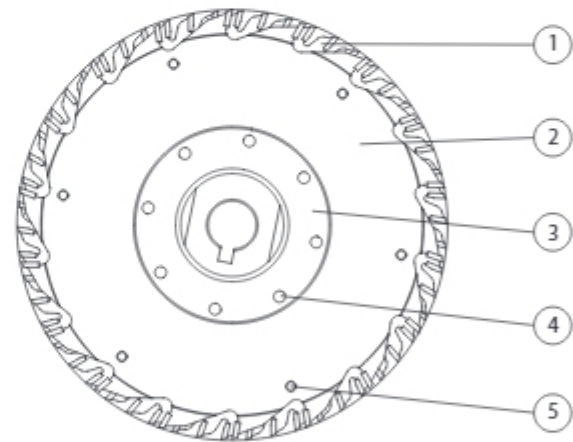
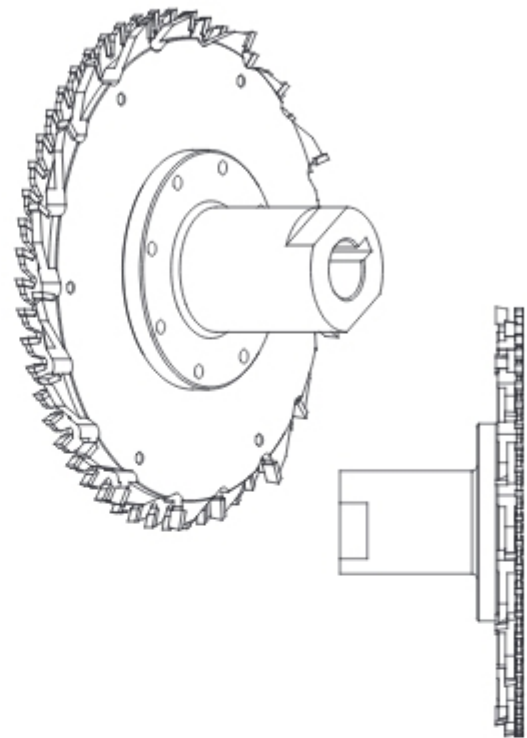
Elements							
	1. Saw blade	2. Hogger segment	3. Body	4. Sleeve	5. M8x20	6. M8x12	7. M6x16
GSZ-01 D=250	PI-406T 250x4,0/80 z=72	PI-541 250x6,0/2,8 z=4					
Quantity	1	6	1	1	4	12	6

Complete hogger unit, type **GSZ-02** with very hard carbide tips (T), designed for formatting and hogging solid wood.

Type of cut: cross and longitudinal.

Material: solid wood.






GSZ-02



GM



Type	D mm	B mm	d mm	z Cutter	z	↕		
GSZ-02	251	15,1	35	9+9	54	L/R	GM	+
GSZ-02	301	15,7	35	12+12	72	L/R	GM	+

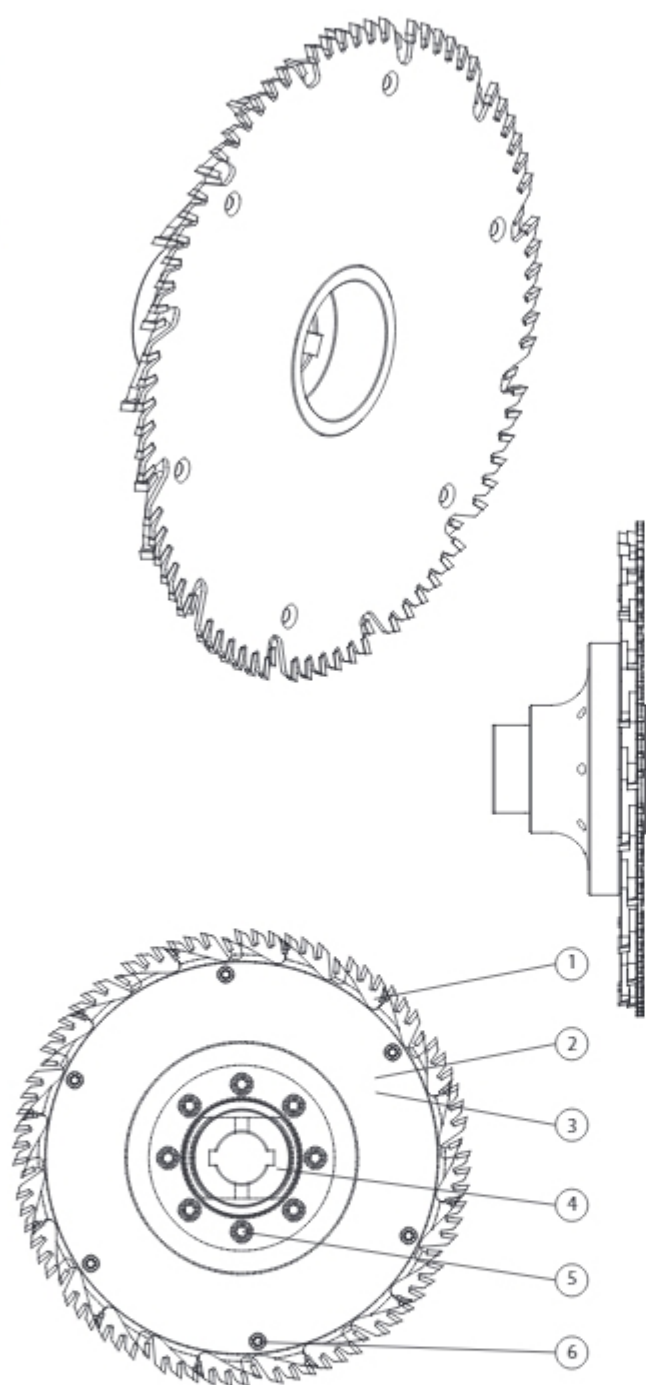
Elements					
	1. Saw blade	2. Cutter	3. Sleeve	4. M8x20	5. M6x10 TOR1128
GSZ-02 D=251	PI-404T 250x4,4/80 z=54	251x12x80 z=9+9			
Quantity	1	1	1	8	6







GSZ-03

Complete hogger unit, type **GSZ-03** with very hard carbide tips (T), designed for formatting and hogging solid wood.

Type of cut: cross and longitudinal.

Material: solid wood.

**GM**

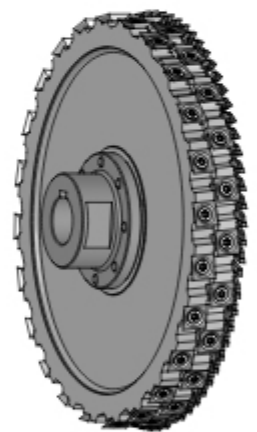
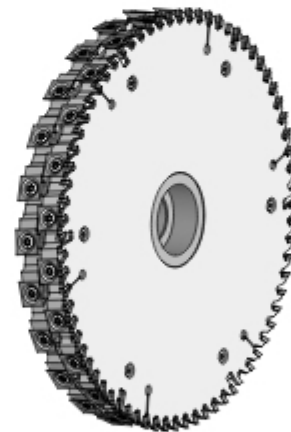
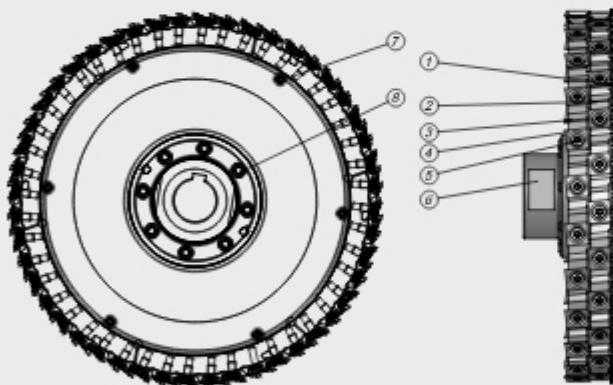
Type	D mm	B mm	d mm	Z Cutter	z	↗	
GSZ-03	250	16,5	35	2x6	72	L/R	GM +
Elements							
	1. Saw blade	2. Cutter	3. Cutter	4. Sleeve	5. M8x20	6. TOR1244	
GSZ-03 D=250	PI-406T 250x4,0/80 z=72	245x8,0/6,0x80 z=6	250x8,0/6,0x80 z=6				
Quantity	1	1	1	1	4	6	

Complete hogger unit, type **GSZ-04** with exchangeable very hard carbide tips (T), designed for formatting and hogging solid wood.

Type of cut: cross and longitudinal.

Material: solid wood.

GSZ-04



GT

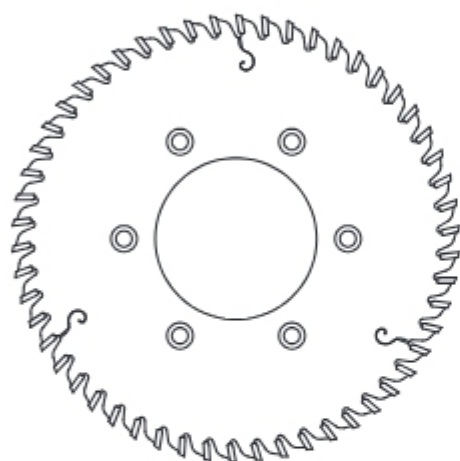


GW



Type	D mm	B mm	d mm	z (cutter)	z (saw blade)	L/R	GW/GT	+
GSZ-04	350	42	40	24+24	72	L/R	GW/GT	+
Elements	1. Saw blade	2. Cutter (ST)	3. Cutter (AL)	4. Insert	5. Screw	6. Sleeve	7. Screw	8. Screw
GSZ-04	PI-406T	350x21x80	350x21x80	N0000705	TOR6344	TOR1244	M6x16	PN 82302
D=355	355x4,4/80 z=72			21x21x5,5	M7x16,5			M8x48/40
Quantity	1	1	1	48	48	1	6	8

PI-404



PI-404T

Scoring and formatting saw blades with flat teeth (GM), type **PI-404T** with very hard carbide tips (T), designed for cutting boards on automatic lines, mounted on sleeves.

Type of cut: cross and longitudinal.

Material: plywood, chipboard, laminated board, MDF.

PI-404S

Scoring and formatting saw blades with flat teeth (GM), type **PI-404S** with super hard carbide tips (S), designed for cutting homogenous materials without impurities on automatic lines, mounted on sleeves.

Type of cut: cross and longitudinal.

Material: laminated board, MDF, HDF.

PI-404T



PI-404S



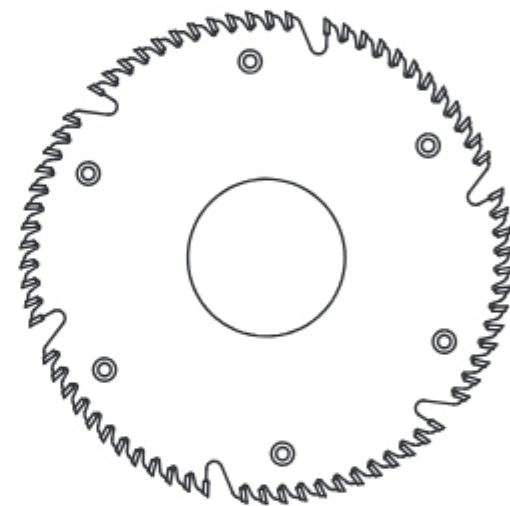
Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ	
S0400001	PI-404T	180	3,2	2,2	65	6/6,5-10,5/90	48	10°	GM-P •
S0400002	PI-404T	180	3,2	2,2	65	6/6,5-10,5/90	48	10°	GM-L •
S0400358	PI-404T	180	3,2	2,2	65	6/6,5-10,5/90	54	10°	GM-P +
S0400359	PI-404T	180	3,2	2,2	65	6/6,5-10,5/90	54	10°	GM-L +
S0400511	PI-404S	220	4,0	2,8	80	6/6,5-10,5/154	48	12°	GM-P +
S0400510	PI-404S	220	4,0	2,8	80	6/6,5-10,5/154	48	12°	GM-L +
S0400820	PI-404T	250	4,4	2,8	80	6/7,0-11,6/200	54	10°	GM-P +
S0400821	PI-404T	250	4,4	2,8	80	6/7,0-11,6/200	54	10°	GM-L +

Formatting saw blade with flat teeth (GM), type **PI-406T** with very hard carbide tips (T), designed for working in a set with the hogger GSZ-01.

Type of cut: cross and longitudinal.

Material: chipboard, veneered board, laminated board, MDF.

PI-406T



2



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z		
S0600021	PI-406T	200	4,0	2,8	80	4/6,5-10,5/140	60	GM-P	•
S0600022	PI-406T	200	4,0	2,8	80	4/6,5-10,5/140	60	GM-L	•
S0600007	PI-406T	250	4,0	3,0	80	6/6,5-10,5/200	72	GM-P	•
S0600008	PI-406T	250	4,0	3,0	80	6/6,5-10,5/200	72	GM-L	•
S0600011	PI-406T	250	4,0	3,0	100	6/6,5-10,5/200	72	GM-P	•
S0600012	PI-406T	250	4,0	3,0	100	6/6,5-10,5/200	72	GM-L	•

PI-540

Special hogger segment with flat teeth (GM), type **PI-540** with carbide tips.



GM



Type	D mm	z	γ		
PI-540	250	10	15°	GM	+
PI-540	330	16	15°	GM	+

PI-541

Hogger segment with flat teeth (GM), type **PI-541** with very hard carbide tips.



GM



Catalogue number	Type	D mm	B mm	b mm	Driver holes	z	γ		
P4100001	PI-541	200/250	6	2,8	2/9,5/33	4	15°	GM	•

PI-542

Hogger segment with flat teeth (GM), type **PI-542** with very hard carbide tips.



GM



Catalogue number	Type	D mm	B mm	b mm	Driver holes	z	γ		
P4200001	PI-542	250	5,0	2,8	2/8,5/50	7	15°	GM	+

Segments are made only on request according to client's dimensions and requirements.

A special milling (hogging) segment with straight teeth (GM), type **PI-540** and carbide tips.

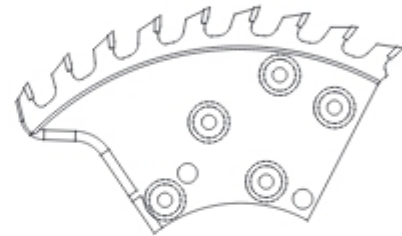
Type of cut: longitudinal.

Material: solid wet wood (soft and hard), frozen wood.

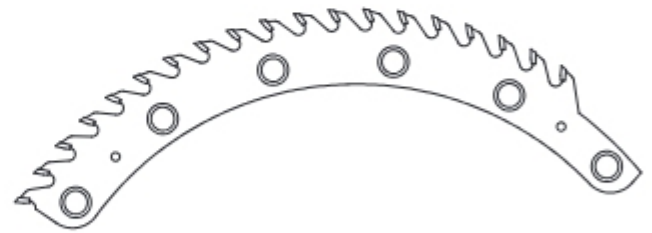


Type	D mm	B mm	b-b ₁ mm	z		
PI-540	413,5	3,5	2,5-7,0	9	GM	+
PI-540	414	3,5	2,5-7,0	11	GM	+

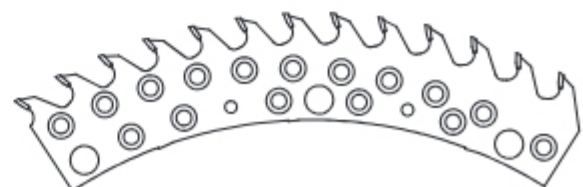
Special hogger segments PI-540



Type	D mm	B mm	b mm	z		
PI-540	555	5,8	5,0	19	GM	+
PI-540	555	6,0	5,0	19	GM	+
PI-540	555	6,2	5,0	19	GM	+



Type	D mm	B mm	b mm	z		
PI-540	730	4,5	3,5	13	GM	+



Segments are made only on request according to client's dimensions and requirements.

Special hogger segments

PI-540

A special milling (hogging) segment with straight teeth (GM), type **PI-540** and carbide tips.

Type of cut: longitudinal.

Material: solid wet wood (soft and hard), frozen wood.

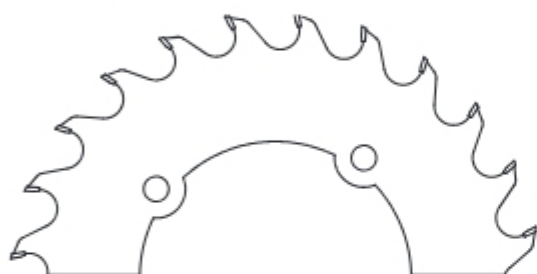


GM

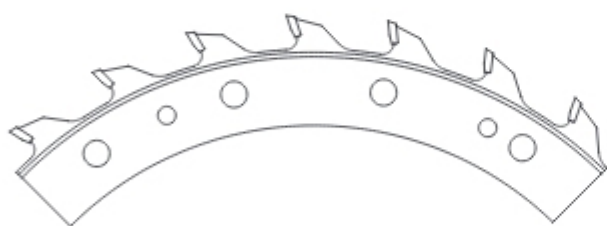


HM

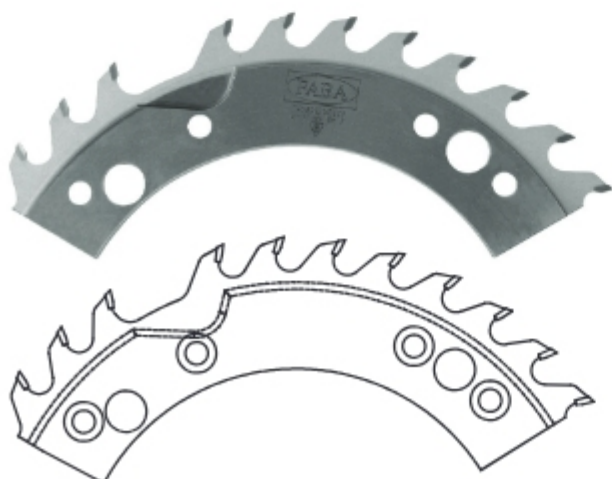
STL



Type	D mm	B mm	b mm	z		
PI-540	338	6,5	5,0	19	GM	+
PI-540	360	4,8	3,6	12	GM	+



Type	D mm	B mm	b-b ₁ mm	z		
PI-540	400	3,5	2,5-5,0	8	GM	+
PI-540	403	3,5	2,5-5,0	7	GM	+
PI-540	403	3,5	2,5-5,0	11	GM	+
PI-540	411	4,0	3,0-5,0	7	GM	+
PI-540	570	4,5	3,5-5,0	19	GM	+



Type	D mm	B mm	b-b ₁ mm	z		
PI-540	401	3,2	2,4-6,0	11 FSW	GM	+
PI-540	405	3,2	2,4-6,0	11	GM	+

Segments are made only on request according to client's dimensions and requirements.