

6. Shank tools

Shank tools

Shank tools offered as cutters with brazed HSS or HM tips, cutter heads with exchangeable inserts and spiral monolithic cutters. Shank cutters with tips from high speed steel (HSS) designed for professional machining of solid soft wood and with carbide (HM) tips designed for professional machining of solid soft and hard wood, glued wood and other wood-based materials. They are used for through and dowel drilling, grooving, rebating, edge profiling and nesting.

Shank cutters and cutter heads are made from the highest quality high speed cutting steel in special heat treatment technology, 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. Monolithic spiral cutters are made entirely from carbide in advanced profile sharpening technology.

The tools are designed and produced with or without shear angle and optimized chip flow as well as geometry guaranteeing chip flow up or down, depending on needs, in case of monolithic shank cutters. Very precise balancing of the tools allows for working with rotation speed up to 24 000 r.p.m. All shank tools are designed mostly for CNC machines.

All types of cutters and cutter heads are manufactured on modern CNC machines of world-renowned producers, which guarantee high accuracy and precision of the produced tools. The construction and production remains in accordance with all points of safety standard EN/PN-847-1 concerning tools for mechanical woodworking.

The *Shank tools* chapter includes only example types of cutters and cutter heads and sets of cutter heads with basic dimensions. On request, we can suggest, design and manufacture a proper tool for the required type of work, material, parameters and conditions during machining. The production time of catalogue cutters or sets indicated with "+" as well as special tools made on client's request, in most cases does not take more than 10-15 working days.

Orders should include:

- outer diameter (D) or diameters range,
- shank diameter (d),
- shank length (s),
- number of teeth (z) or spindle rotation speed and feed speed,
- type of machined material,
- profile drawing with dimensions or profile sample,
- other information relevant for designing and production process.



Contents

6. SHANK TOOLS

Pictograms	6.4
Shank tools coding system	6.5
Rotation direction	6.5
Basic machining parameters	6.5
6.1 Cutters with brazed tip	6.6
6.2 Cutter heads with exchangeable inserts	6.8
6.3 Sets of profile cutter heads	6.19
6.4 Spiral monolithic cutters	6.21

Pictograms



solid dry softwood



solid dry hardwood



chipboard



glued wood



MDF



plastics



grooving



edge machining



profiling



rebating



finishing



formatting



engraving



through drilling



dowel drilling



step drilling



counterboring



chip breaking



mechanical feed



manual feed



high-speed cutting steel



carbide

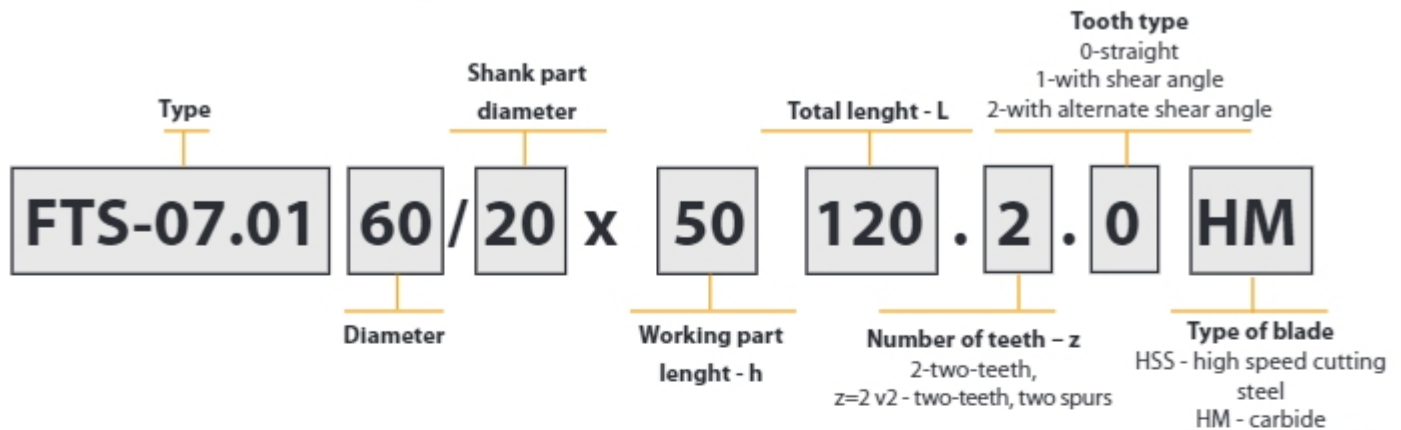


carbide monolith

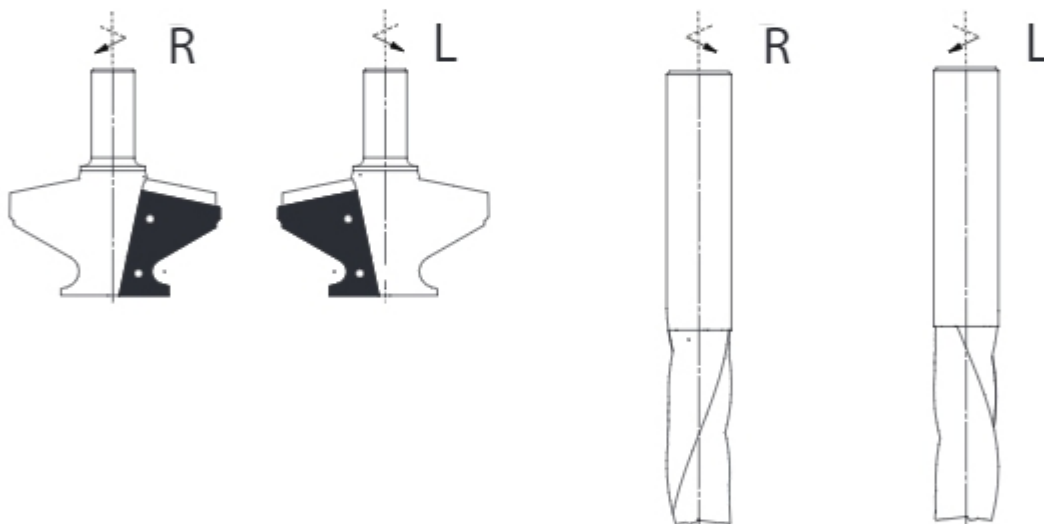


CNC

Shank tools coding system



Rotation direction



6

Basic cutting parameters

Cutting speed V_c

$$V_c = \frac{D \times n \times \pi}{60\,000} \text{ [m/s]}$$

D - tool diameter [mm]
 n - rotation speed [1/min]
 p_z - feed per tooth [mm]
 p_{min} - feed per minute [m/min]
 z - number of teeth
 $\pi = 3,14$

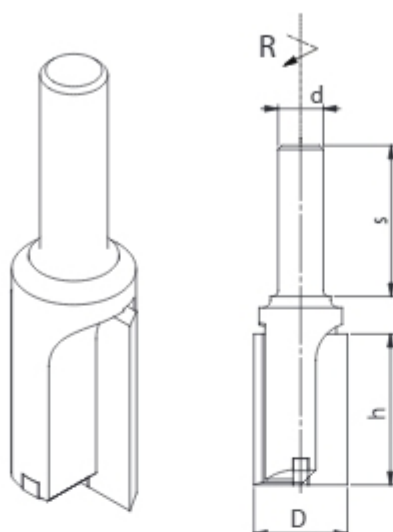
Feed p_{min} / p_z

$$p_{min} \text{ [m/min]} \longleftrightarrow p_z \text{ [mm/tooth]}$$

$$p_{min} = \frac{p_z \times n \times z}{1\,000}$$

$$p_z = \frac{p_{min} \times 1\,000}{n \times z}$$


TW-01-2




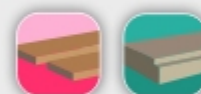
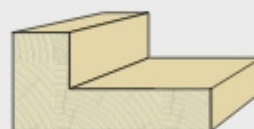
Straight shank cutter, type **TW-01-2** with two cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for longitudinal cutting – formatting or rebating.

Type of work: formatting, rebating.

Material:

 solid softwood

 solid hardwood, glued wood, chipboard, MDF



D n d z	12 24000 25 2		14 24000 25 2		16 24000 25 2		18 24000 25 2		20 24000 25 2		25 24000 25 2		30 24000 25 2		40 24000 25 2	
	h mm	HSS HM	HSS HM	HSS HM	HSS HM	HSS HM	HSS HM	HSS HM	HSS HM	HSS HM	HSS HM	HSS HM	HSS HM	HSS HM		
10	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+
15	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+
20	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+
25	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+
30	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+
40	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+
50			+	+	+	+	+	+	+	+	+	+	+	+	+	+
60			+	+	+	+	+	+	+	+	+	+	+	+	+	+


Catalogue number	Type	D mm	dxs mm	h mm	L mm	z		
TW.01-2.18/003	TW-01-2	12	12x30	30	65	2	HM	R +
TW.01-2.38/001	TW-01-2	14	12x30	30	60	2	HM	R +
TW.01-2.20/002	TW-01-2	16	12x30	30	65	2	HM	R +
TW.01-2.45/002	TW-01-2	18	12x30	30	65	2	HM	R +
TW.01-2.21/001	TW-01-2	20	12x30	30	65	2	HM	R •
TW.01-2.23/001	TW-01-2	25	12x30	30	65	2	HM	R +
TW.01-2.02/001	TW-01-2	30	12x30	30	65	2	HM	R +


TW-07

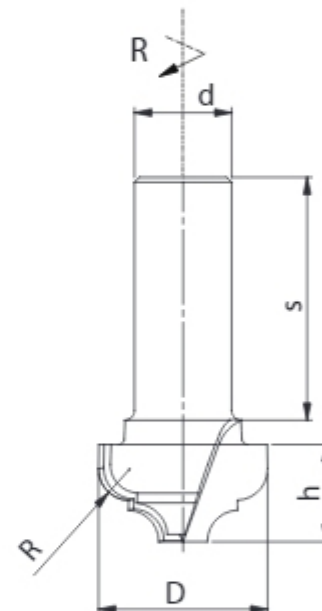
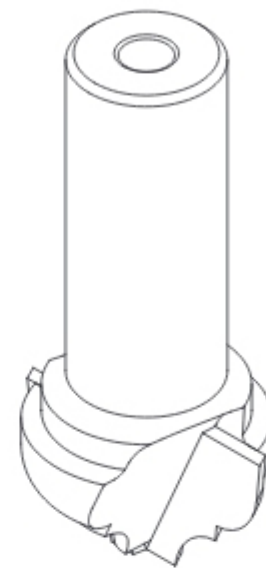
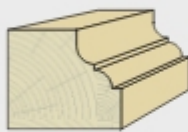
Profile shank cutter, type **TW-07** with two cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for surface profiling. Special blade geometry allows for dowel drilling.

Type of work: profiling, dowel drilling.

Material:

 solid softwood

 hard wood, glued wood, chipboard, MDF



6

D n d _{max} z	35 24000 25 2		40 24000 25 2		55 24000 25 2		70 24000 25 2	
	B mm	HSSHM	HSSHM	HSSHM	HSSHM	HSSHM		
20	+	+	+	+	+	+	+	+
25	+	+	+	+	+	+	+	+
30	+	+	+	+	+	+	+	+
35			+	+	+	+	+	+
40					+	+	+	+

Catalogue number	Type	D mm	d _{xs} mm	h mm	L mm	R mm	z			
TW.07.01/001	TW-07	35	10x30	20	55	2x6,5	2	HM	R	+
TW.07.01/002	TW-07	35	12x30	20	55	2x6,5	2	HM	R	+

FTS-01 / 10

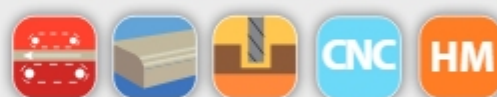
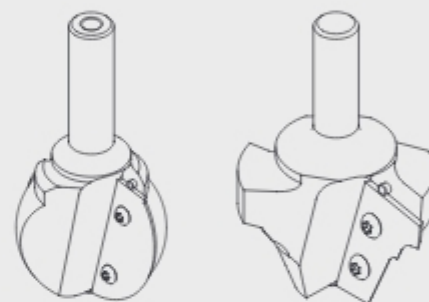
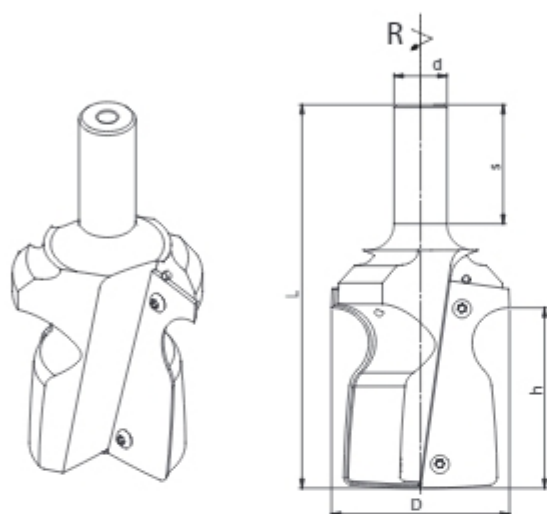
Profile shank cutter head, type **FTS-01** or **FTS-10** with suitable number of cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head with body working with given blade profile (HM inserts). Cutter heads FTS-01 and FTS-10 are designed and produced only on client's individual request.

FTS-01 R or L

Cutter head **FTS-01** designed for surface profiling. Special blade geometry allows for dowel drilling.

Type of work: profiling, dowel drilling.

Material: solid hardwood, glued wood, chipboard, MDF and others.

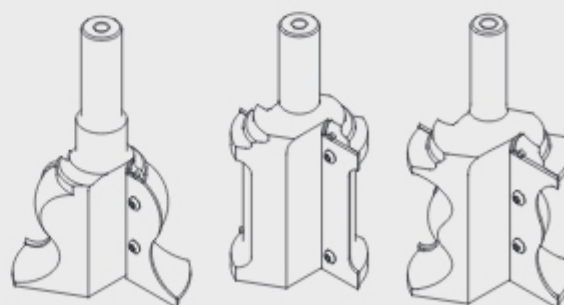
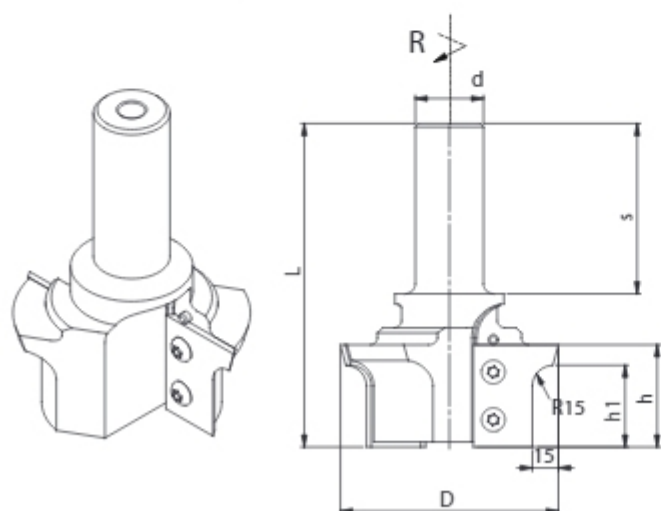


FTS-10 R or L

Cutter head **FTS-10** designed for surface profiling without dowel drilling ability.

Type of work: profiling without dowel drilling ability.

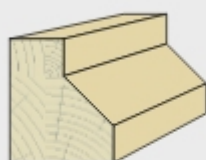
Material: solid hardwood, glued wood, chipboard, MDF and others.



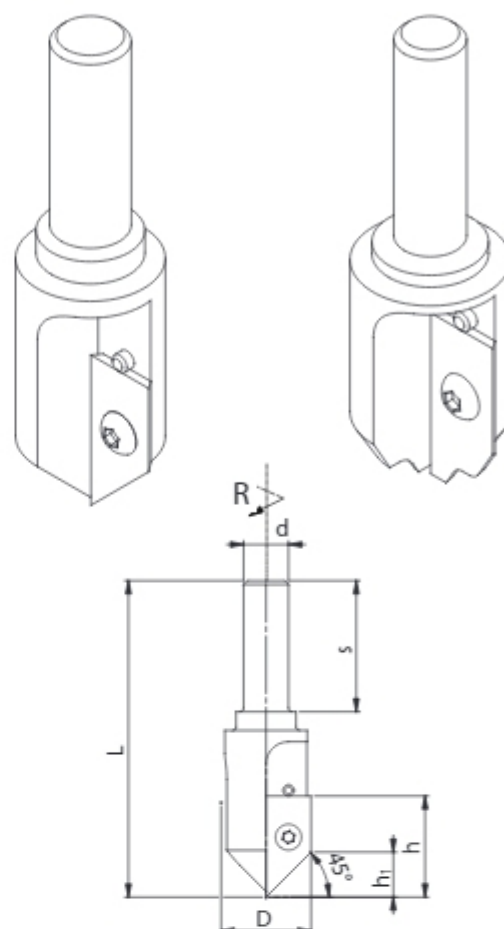
Profile shank cutter head, type **FTS-02** with one cutting tooth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head with body working with given blade profile (HM inserts) is used for surface profiling. Cutter heads FTS-02 are designed and produced only on client's individual request, within the range of $h_1=12$ mm.

Type of work: profiling, dowel drilling.

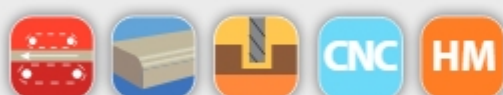
Material: solid hardwood, glued wood, chipboard, MDF and others.



FTS-02 R or L



6



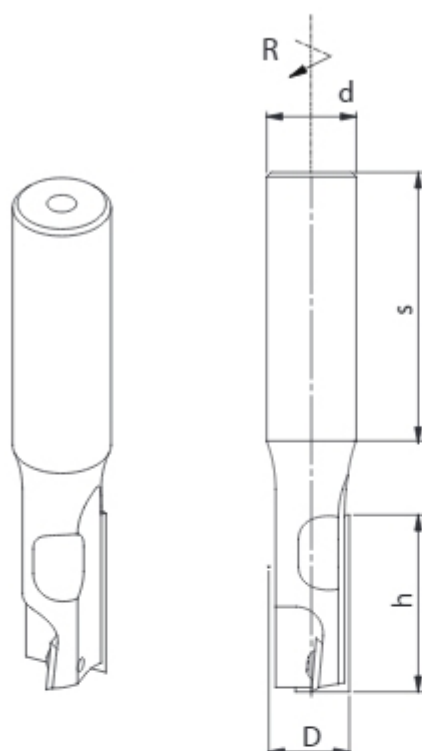
D mm	20 24000 25 1	22 24000 25 1	24 24000 25 1
h mm			
27	+	+	+

Catalogue number	Type	D mm	d _{xs} mm	h mm	h ₁ mm	L mm	∠	z			
FTS.02.01/001	FTS-02	24	12	27	12	83	45°	1	HM	R	+
FTS.02.01/002	FTS-02	24	25	27	12	113	45°	1	HM	R	+

Spare parts for cutter heads FTS-02

Cat. nr	Name	Dimensions			Cat. nr	Name	Dimensions		
N0000910	Knife	27x12x1,5 - P		+	WHAS00004	Screw STAMPF 94	M4x6		•
N0000911	Knife	27x12x1,5 - L		+	WHA100003	Locating pin	3x6		•

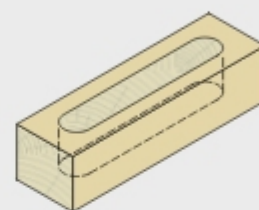
FTS-03 R or L



Straight shank cutter head, type **FTS-03** with one cutting tooth and one drilling blade designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head is used for rebating and grooving with drilling ability.

Type of work: rebating, grooving, drilling, formatting.

Material: solid hardwood, glued wood, chipboard, MDF and others.



D n d z	18 24000 25 1+1	20 24000 25 1+1	25 24000 25 1+1	30 24000 25 1+1
h mm				
12	+	+	+	+
29,5	+	+	+	+
39,5	+	+	+	+
49,5	+	+	+	+

Catalogue number	Type	D mm	d x s mm	h mm	L mm	z			
FTS.03P1853.01	FTS-03	18	25x60	29,5	106	1+1	HM	R	+
FTS.03P2053.01	FTS-03	20	25x60	29,5	106	1+1	HM	R	+
FTS.03P2553.01	FTS-03	25	25x55	29,5	100	1+1	HM	R	+
FTS.03P3053.01	FTS-03	30	25x56	29,5	100	1+1	HM	R	+

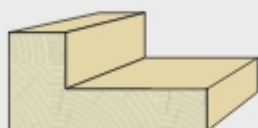
Spare parts for cutter heads FTS-03

Cat. nr	Name	Dimensions		Cat. nr	Name	Dimensions	
N0000801	Knife	7,5 x 12 x 1,5 for D=18; 20	•	N0000813	Knife	12 x 12 x 1,5 for D=25; 30	•
N0000814	Knife	29,5 x 12 x 1,5	•	WHAS00004	Screw STAMPF 94	M4x6	•

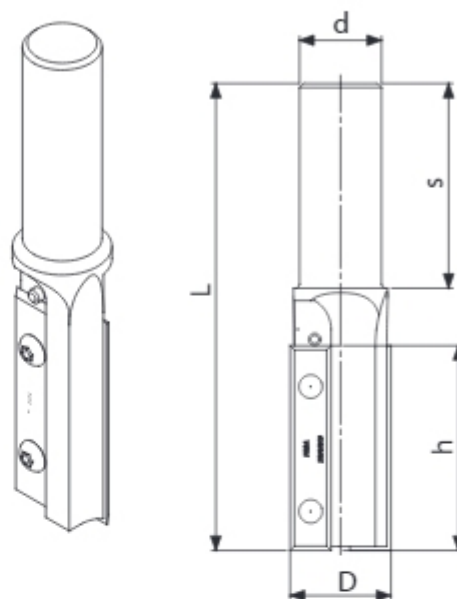
Straight shank cutter head, type **FTS-06** with two cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head is used for rebating and formatting.

Type of work: formatting, rebating.

Material: solid hardwood, glued wood, chipboard, MDF and others.



FTS-06 R or L






6

D mm	18 24000 25 2	20 24000 25 2	25 24000 25 2	27 24000 25 2
h mm				
29,5	+	+	+	+
39,5	+	+	+	+
49,5	+	+	+	+

Catalogue number	Type	D mm	d _{xs} mm	h mm	L mm	z			
FTS.06P1843.01	FTS-06	18	20x45	29,5	95	2	HM	R	+
FTS.06P1845.01	FTS-06	18	20x45	49,5	110	2	HM	R	+
FTS.06P2043.01	FTS-06	20	20x60	29,5	95	2	HM	R	+
FTS.06P2045.01	FTS-06	20	20x60	49,5	125	2	HM	R	•
FTS.06P2253.01	FTS-06	22	25x60	29,5	105	2	HM	R	+
FTS.06P2255.01	FTS-06	22	25x60	49,5	125	2	HM	R	+
FTS.06P2553.01	FTS-06	25	25x55	29,5	105	2	HM	R	+
FTS.06P2555.01	FTS-06	25	25x60	49,5	125	2	HM	R	+
FTS.06P2753.01	FTS-06	27	25x60	29,5	105	2	HM	R	+
FTS.06P2755.01	FTS-06	27	25x60	49,5	125	2	HM	R	+

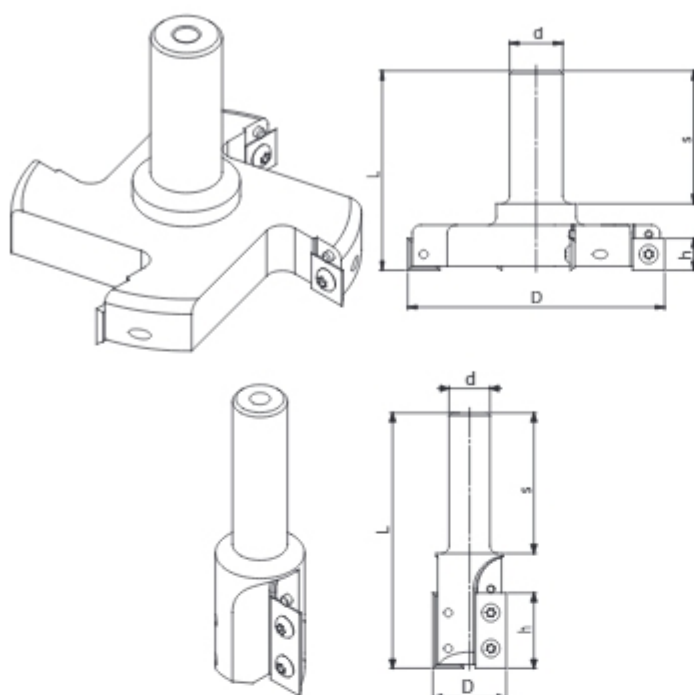
Spare parts for cutter heads FTS-06

Cat. nr	Name	Dimensions	
N0000814	Knife	29,5 x 12 x 1,5	
N0000816	Knife	49,5 x 12 x 1,5	

Cat. nr	Name	Dimensions	
WHAS00004	Screw STAMPF 94	M4x6	

On request, we offer cutter head FTS-06 with drilling ability (brazed drilling tip).

FTS-07.01 R or L



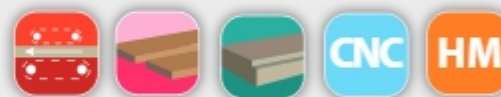
Straight shank cutter head, type **FTS-07.01** with suitable number of cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head is used for rebating and formatting.

Type of work: formatting, rebating.

Material: solid hardwood, glued wood, chipboard, MDF and others.



6



D mm	30 18000 25 2	35 18000 25 2	40 18000 25 2	45 18000 25 3	50 18000 25 3	60 18000 25 4	70 18000 25 4	80 18000 25 4	90 18000 25 4
h mm									
12	+	+	+	+	+	+	+	+	+
29,5	+	+	+	+	+	+	+	+	+
39,5	+	+	+	+	+	+	+	+	+
49,5	+	+	+	+	+	+	+	+	+
59,5	+	+	+	+	+	+	+	+	+

Catalogue number right	Catalogue number left	Type	D mm	dx mm	h mm	L mm	z		
FTS.07P3011.01	FTS.07L3011.01	FTS.07.01	30	10x40	12	70	2	HM	+
FTS.07P4053.01	FTS.07L4053.01	FTS.07.01	40	25x60	29,5	105	2	HM	+
FTS.07P5045.01	FTS.07L5045.01	FTS.07.01	50	20x64	49,5	120	2	HM	+
FTS.07P8051.01	FTS.07L8051.01	FTS.07.01	80	25x60	12	85	4	HM	+

Spare parts for cutter heads FTS-07.01

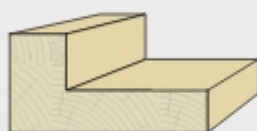
Cat. nr	Name	Dimensions	
	Knife	B x 12 x 1,5	+

Cat. nr	Name	Dimensions	
WHAS00004	Screw STAMPF 94	M4x6	•
WHA100003	Locating pin	3x6	•

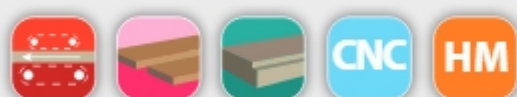
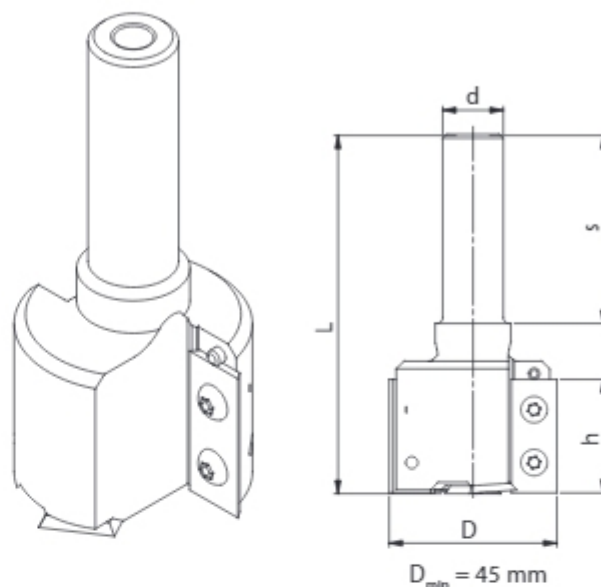
Straight shank cutter head, type **FTS-07.02** with two cutting teeth and two spurs, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head is used for precise rebating and formatting.

Type of work: precise formatting, rebating.

Material: solid hardwood, glued wood, chipboard, MDF and others.



FTS-07.02 R or L



6

Catalogue number right	Catalogue number left	Type	D mm	d _{xs} mm	h mm	L mm	z		
FTS.07P4533.02	FTS.07L4533.02	FTS.07.02	45	16x60	30	95	2 v2	HM	+
FTS.07P5041.01	FTS.07L5041.01	FTS.07.02	50	20x50	12	80	2 v2	HM	+
FTS.07P6045.01	FTS.07L6045.01	FTS.07.02	60	20x60	50	120	2 v2	HM	+
FTS.07P6046.02	FTS.07L6046.02	FTS.07.02	60	25x55	60	125	2 v2	HM	+

Spare parts for cutter heads FTS-07.02

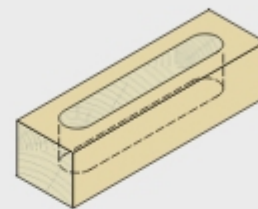
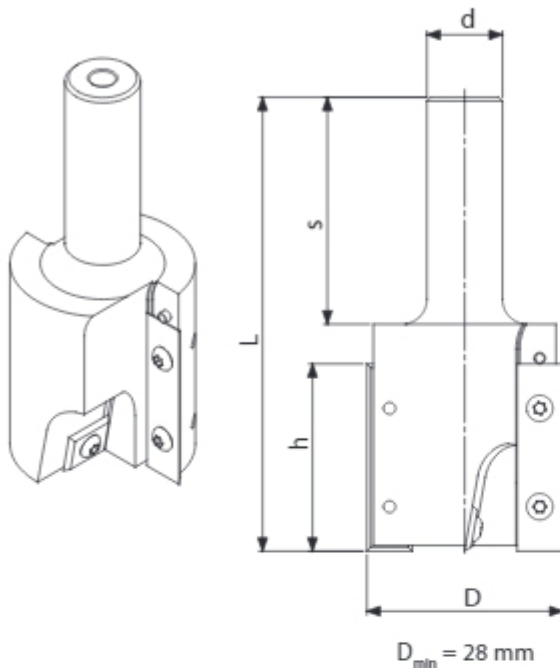
Cat. nr	Name	Dimensions			Cat. nr	Name	Dimensions		
	Knife	B x 12 x 1,5		+	WHAS00004	Screw STAMPF 94	M4x6		•
N0000818	Knife	14 x 14 x 2		•	WHAS00008	Screw TOR 1064	M5x6,5		•
					WHA100003	Locating pin	3x6		•

FTS-07.03 R or L

Straight shank cutter head, type **FTS-07.03** with two cutting teeth and one drilling blade, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head is used for rebating and grooving with drilling ability.

Type of work: rebating, grooving, drilling, formatting.

Material: solid hardwood, glued wood, chipboard, MDF and others.





D mm	28 18000 25 2+1	30 18000 25 2+1	35 18000 25 2+1	40 18000 25 2+1	50 18000 25 2+1
h mm					
12	+	+	+	+	+
29,5	+	+	+	+	+
39,5	+	+	+	+	+
49,5	+	+	+	+	+
59,5	+	+	+	+	+

Catalogue number right	Catalogue number left	Type	D mm	dxs mm	h mm	L mm	z		
FTS.07P2813.01	FTS.07L2813.01	FTS.07.03	28	12x49	29,5	85	2+1	HM	+
FTS.07P3045.01	FTS.07L3045.01	FTS.07.03	30	20x62	49,5	118	2+1	HM	+
FTS.07P3545.01	FTS.07L3545.01	FTS.07.03	35	20x62	49,5	118	2+1	HM	+
FTS.07P4056.02	FTS.07L4056.02	FTS.07.03	40	25x55	59,5	120	2+1	HM	+
FTS.07P4033.02	FTS.07L4033.02	FTS.07.03	40	16x55	29,5	90	2+1	HM	+

Spare parts for cutter heads FTS-07.03

Cat. nr	Name	Dimensions	
N0000813	Knife	12x12x1,5	 •
	Knife	B x 12 x 1,5	 +

Cat. nr	Name	Dimensions	
WHAS00004	Screw STAMPF 94	M4x6	 •
WHAI00003	Locating pin	3x6	 •

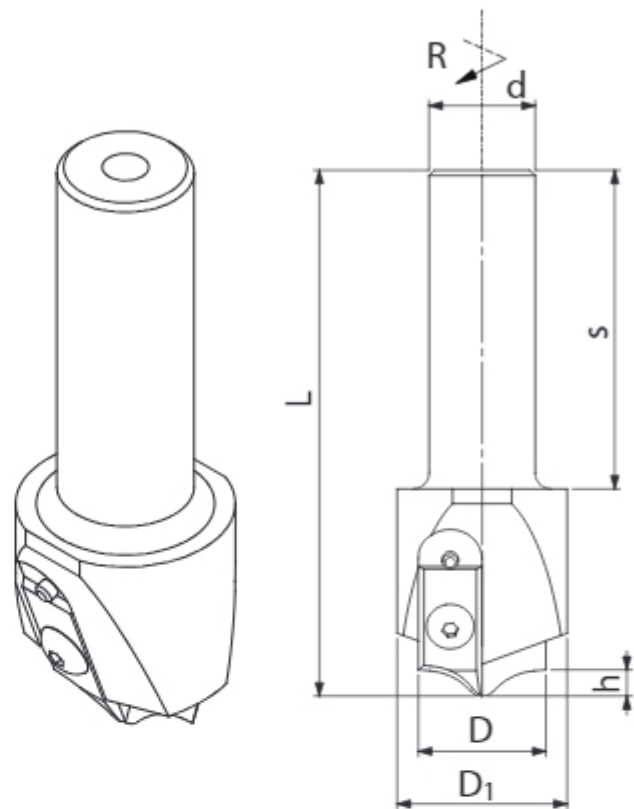
Universal profile cutter head, type **FTS-11** with two cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head used for surface profiling. Insert profile, which shape must remain within dimensions shown in the drawing ($h_{\max} = 8 \text{ mm}$), is made only according to individual order. The cutter head body is universal, special blade geometry allows for dowel drilling.

Type of work: profiling, dowel drilling.

Material: solid hardwood, glued wood, chipboard, MDF and others.



FTS-11



6



Catalogue number (without knives)	Type	D ₁ mm	D mm	d _{xs} mm	h mm	L mm	z		
FTS.11.01.K	FTS-11	32	24	25x40	8	89	2	HM	R +

Spare parts for cutter heads FTS-11

Cat. nr	Name	Dimensions	
	Knife	Bx12x1,5 P/L	
WHAS00004	Screw STAMPF 94	M4x6	

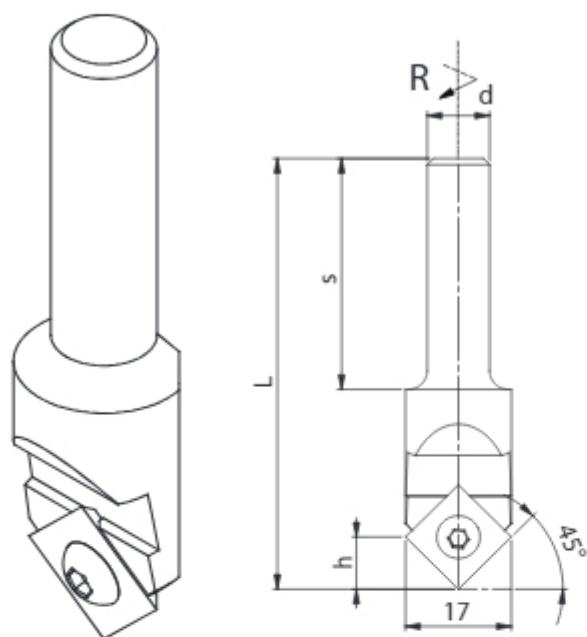
Cat. nr	Name	Dimensions	
WHAI00003	Locating pin	3x6	

FTS-11-B

Universal profile cutter head, type **FTS-11-B** with one cutting tooth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head is used for grooving and edge beveling of the machined elements.

Type of work: grooving, edge beveling, dowel drilling.

Material: solid hardwood, glued wood, chipboard, MDF and others.



6



Catalogue number	Type	D mm	dxs mm	h mm	L mm	z			
FTS.11.10.00	FTS-11-B	17	10x20	8	48	1	HM	R	+
FTS.11.08.00	FTS-11-B	17	10x37	8	70	1	HM	R	+
FTS.11.11.00	FTS-11-B	17	12x47	8	80	1	HM	R	+
FTS.11.09.00	FTS-11-B	17	16x47	8	80	1	HM	R	+
FTS.11.12.00	FTS-11-B	17	25x52	8	80	1	HM	R	+
FTS.11.07.00	FTS-11-B	17	12x100	8	133	1	HM	R	+

Spare parts for cutter heads FTS-11-B

Cat. nr	Name	Dimensions		
N0000854	Knife	12 x 12 x 1,5		•

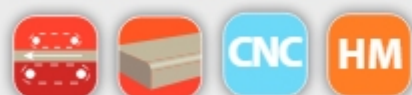
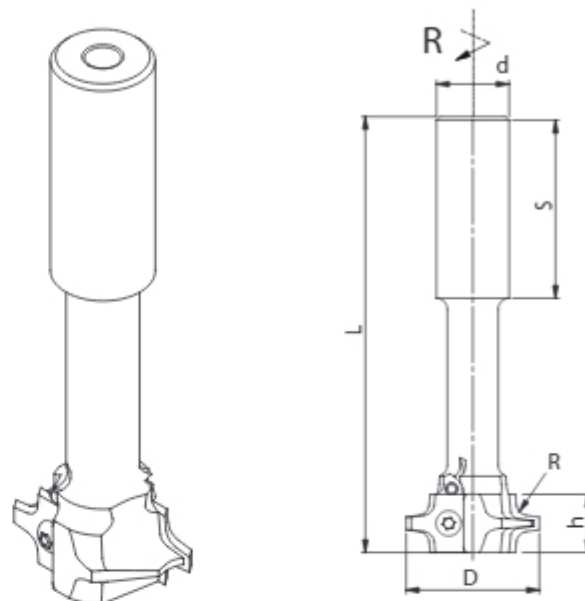
Cat. nr	Name	Dimensions		
WHAS00004	Screw STAMPF 94	M4x6		•

Universal profile cutter head, type **FTS-13** with two cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. Cutter head with universal body, used for edge rounding with radius from R2 to R5. Parallel cutting blades. Cutter head working with high rotation speed.

Type of work: edge rounding with radius R.

Material: solid hardwood, glued wood, chipboard, MDF and others.

FTS-13 R or L



Catalogue number	Type	D mm	dxs mm	h mm	L mm	R mm	z			
FTS.13.18.00	FTS-13	38	16x40	16	90	2	2	HM	R	+
FTS.13.22.00	FTS-13	38	20x50	16	100	3	2	HM	R	+
FTS.13.14.00	FTS-13	38	25x50	16	100	5	2	HM	R	+

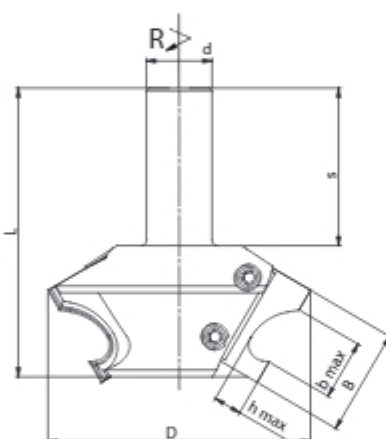
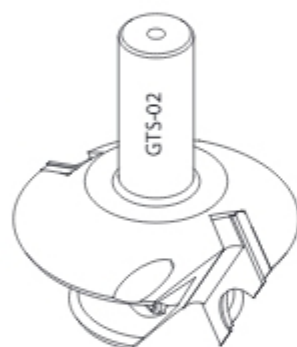
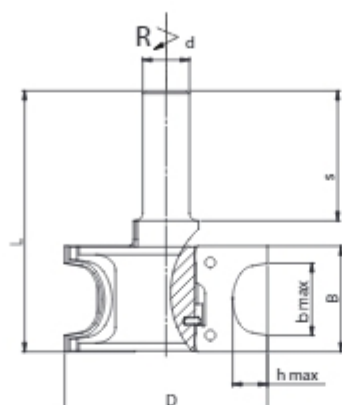
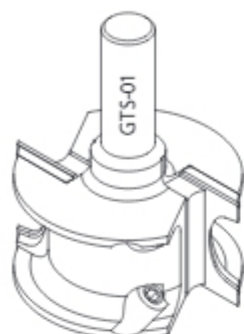
Spare parts for cutter heads FTS-13

Cat. nr	Name	Dimensions		
	Profile knife	16x17,5x2 R		+
WHAS00004	Screw STAMPF 94	M4x6		•

Cat. nr	Name	Dimensions		
WHAI00003	Locating pin	3x6		•

GTS-01 R or L

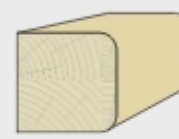
GTS-02 R or L



Universal profile cutter head, type **GTS-01** and **GTS-02** with two cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head is used for surface profiling. Profile, which shape should remain within dimensions shown in the drawing is made only according to individual order. Universal cutter head, apart from cutting knife, includes also clamping wedges with shape matching the profile insert.

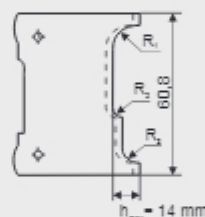
Type of work: profiling

Material: solid hardwood, glued wood, chipboard, MDF and others.



Example of profile for shank cutter head GTS-01.02

Example of profile for shank cutter head GTS-01.01



Maximum depth of profile knives for width 60 mm and 40 mm.



D mm	82 12000 25 2	86 12000 25 2	100 12000 25 2
B mm	GTS.01.01	GTS.01.02	GTS.02
40	+		+
60		+	

Catalogue number (without inserts)	Type	D mm	dxs mm	bmax mm	hmax mm	z	
GTS.01.01.K	GTS-01.01	82	25x55	32	12	2	HM R +
GTS.01.02.K	GTS-01.02	86	25x60	52	14	2	HM R +

Spare parts for cutter heads GTS-01 | GTS-02

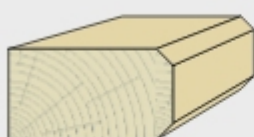
Cat. nr	Name	Dimensions	
	Knife	B x 30 x 1,5	+
	Support insert	B x 28 x 1,5	+

Cat. nr	Name	Dimensions	
	Clamping block	B-2 x 12 x 8	•
WHAW00005	Screw	M8x16	•

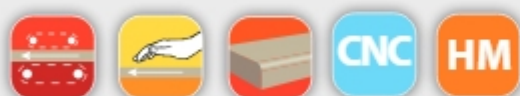
Set of cutter heads on shank, type **GTZ-01** with suitable number of cutting teeth designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The set is used for edge beveling of the machined elements. Width is regulated with spacer rings included in the set.

Type of work: edge profiling, rounding, beveling.

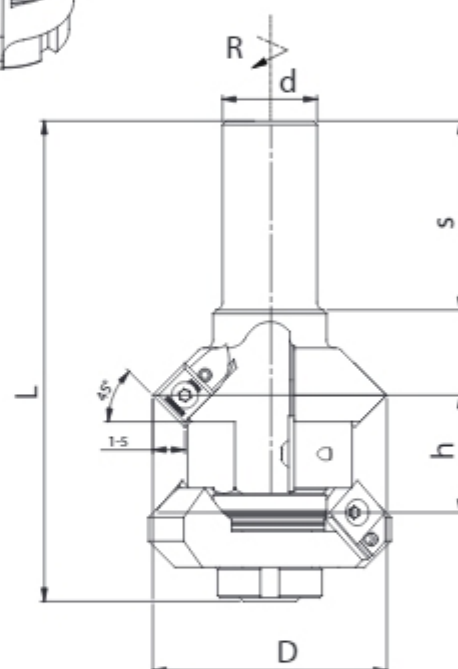
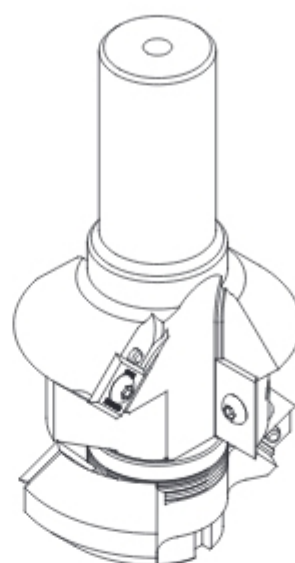
Material: solid hardwood, glued wood, chipboard, MDF and others.



D mm	65 12000 25 2+2
h mm	
10-22	+
20-32	+
30-42	+



GTZ-01 R or L



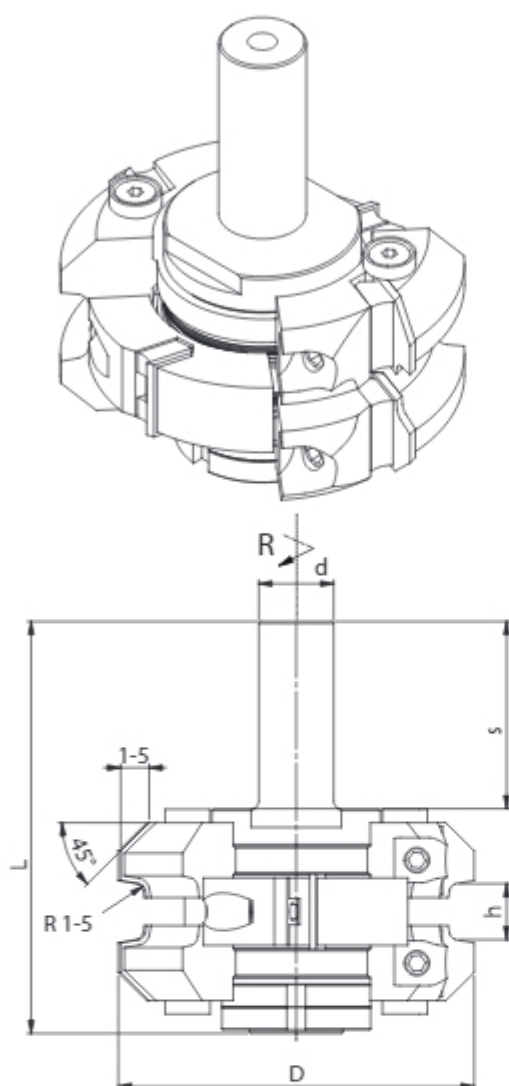
6

Catalogue number	Type	D mm	dcs mm	h mm	L mm	z			
GTZ.01.07	GTZ-01	65	20x50	10-22	127	2	HM	R	+
GTZ.01.01	GTZ-01	65	25x50	10-22	127	2	HM	R	+
GTZ.01.05	GTZ-01	65	25x50	20-32	137	2	HM	R	+
GTZ.01.03	GTZ-01	65	25x50	30-42	150	2	HM	R	+

Spare parts for cutter heads GTZ-01

Cat. nr	Name	Dimensions		Cat. nr	Name	Dimensions	
N0000805	Knife	20 x 12 x 1,5		N0000809	Knife	40 x 12 x 1,5	
N0000813	Knife	12 x 12 x 1,5		WHAS00004	Screw STAMPF 94	M4x6	
N0000808	Knife	30 x 12 x 1,5		WHA100003	Locating pin	3x6	

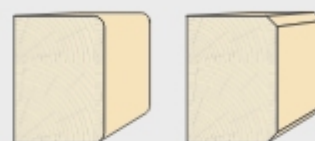
GTZ-06 R or L



Set of cutter heads on shank, type **GTZ-06** with suitable number of cutting teeth designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The set is used for rounding and edge beveling of the machined elements. Increased regulation range. Width is regulated with spacer rings included in the set.

Type of work: edge profiling, rounding, beveling.

Material: solid hard wood, glued wood, chipboard, MDF and others.







D mm	95 12000 25 2+2
h mm	
10-30	+
16-40	+
16-50	+
20-55	+





Catalogue number	Type	D mm	dcs mm	h mm	R mm	L mm	z		
GTZ.06.15.00	GTZ-06	95	25x50	10-30	5	120	2	HM	R +
GTZ.06.03.00	GTZ-06	95	25x50	16-40	5	130	2	HM	R +
GTZ.06.01.00	GTZ-06	95	25x50	16-50	3	140	2	HM	R +

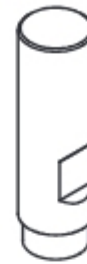
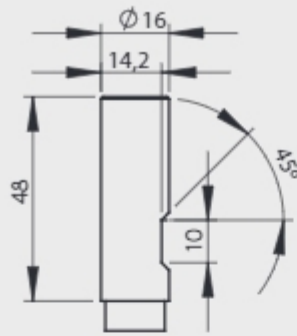
Spare parts for cutter heads GTZ-06

Cat. nr	Name	Dimensions	
	Profile knife P/L	20x20x2 R	 +
N0000810	Knife	50 x 12 x 1,5	 •
N0000808	Knife	30 x 12 x 1,5	 •
N0000809	Knife	40 x 12 x 1,5	 •

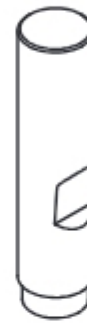
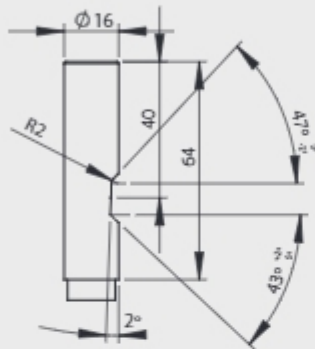
Radius R and edge beveling angle should be given with the order.

Cat. nr	Name	Dimensions	
WHAT00044	Weating sleeve	12x6,5x3,6	 +
WHAS00004	Screw STAMPF 94	M4x6	 •
WHAW00004	Screw DIN 915	M6x16	 •
WHAW00005	Screw DIN 915	M8x16	 •
WHAS00006	Screw TOR 1128	M6x10	 •

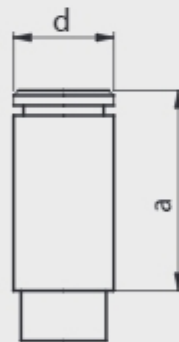
Weldon



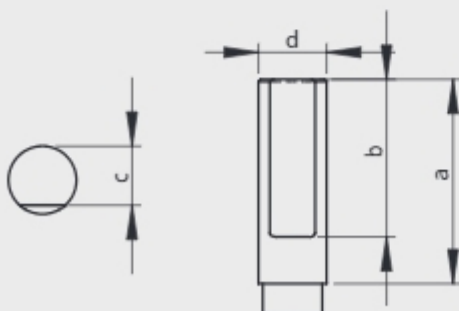
Homag / Weeke



Seeger

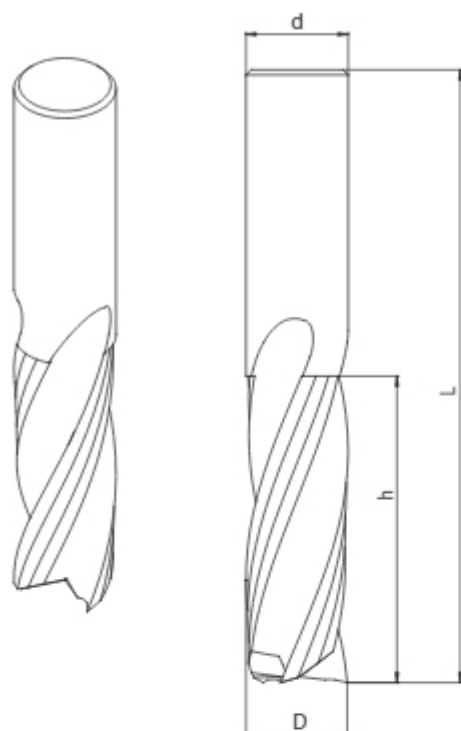


With flat part



When ordering shank tools with non-standard clamping, type of shank part and necessary dimensions should be given.

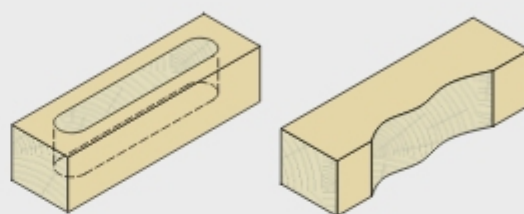
THM-01 R



Shank cutter, type **THM-01** with two or three cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for groove finishing, formatting and nesting. Special geometry guarantees chip flow up.

Type of work: precise grooving, formatting.

Material: solid softwood, solid hard wood, glued wood, chipboard, MDF, plastics.



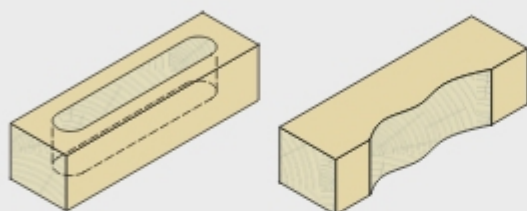
Catalogue number	Type	D mm	h mm	L mm	z	n _{max}	HM	
THM.01.09/022	THM-01	6	25	60	2	24000	HM	•
THM.01.09/023*	THM-01	6	25	70	2	24000	HM	•
THM.01.09/006	THM-01	6	25	70	3	24000	HM	•
THM.01.09/024	THM-01	6	30	70	2	24000	HM	•
THM.01.07/017	THM-01	8	25	70	2	24000	HM	•
THM.01.07/013	THM-01	8	32	80	3	24000	HM	•
THM.01.06/025	THM-01	10	32	70	2	24000	HM	•
THM.01.06/001	THM-01	10	32	70	3	24000	HM	•
THM.01.06/026	THM-01	10	45	100	2	24000	HM	•
THM.01.01/001	THM-01	12	32	80	3	24000	HM	•
THM.01.01/003	THM-01	12	52	100	3	24000	HM	•
THM.01.02/001	THM-01	14	32	80	3	24000	HM	•
THM.01.02/005	THM-01	14	55	110	3	24000	HM	•
THM.01.03/001	THM-01	16	35	90	3	24000	HM	•
THM.01.03/026	THM-01	16	60	110	3	24000	HM	•
THM.01.04/001	THM-01	18	52	100	3	24000	HM	•
THM.01.05/001A	THM-01	20	55	110	3	24000	HM	•
THM.01.05/002	THM-01	20	70	120	3	24000	HM	•

* THM.01.09/023 - shank part d=8 mm

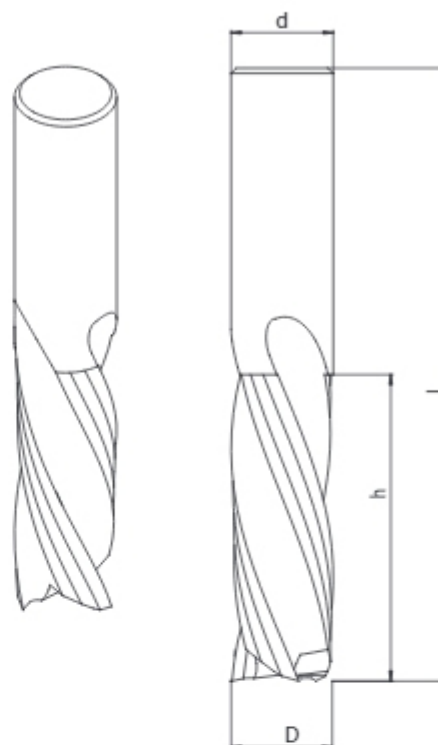
Shank cutter, type **THM-02 L** with two or three cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for groove finishing, formatting and nesting. Special geometry guarantees chip flow up.

Type of work: precise grooving, formatting.

Material: solid softwood, solid hard wood, glued wood, chipboard, MDF, plastics.



THM-02 L

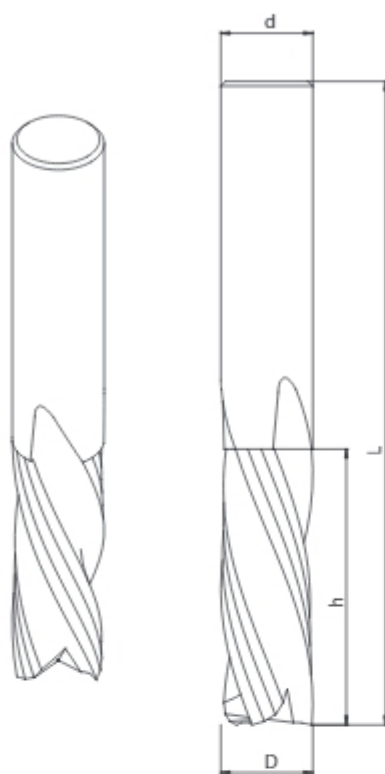


6



Catalogue number	Type	D mm	h mm	L mm	z	n _{max}		
THM.02.07/002	THM-02	8	25	70	2	24000	HM	•
THM.02.06/002	THM-02	10	32	70	2	24000	HM	•
THM.02.01/001	THM-02	12	32	80	3	24000	HM	+
THM.02.02/001	THM-02	14	32	80	3	24000	HM	+
THM.02.03/001	THM-02	16	35	90	3	24000	HM	+
THM.02.04/001	THM-02	18	52	100	3	24000	HM	+
THM.02.05/001A	THM-02	20	55	110	3	24000	HM	•

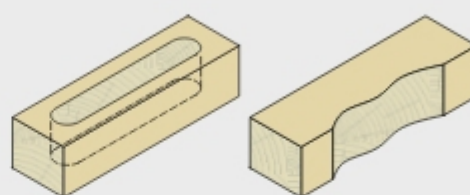
THM-03 / 04



Shank cutter, type **THM-03** or **THM-04** with two or three cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for groove finishing, formatting and nesting. Special geometry guarantees chip flow down. Increased chip flow efficiency.

Type of work: precise grooving, formatting.

Material: solid softwood, solid hard wood, glued wood, chipboard, MDF, plastics.



6



THM-03 R

Catalogue number	Type	D mm	h mm	L mm	z	n _{max}		
THM.03.09/001	THM-03	6	22	60	2	24000	HM	+
THM.03.07/006	THM-03	8	25	70	2	24000	HM	+
THM.03.06/001	THM-03	10	32	70	3	24000	HM	+
THM.03.01.013	THM-03	12	32	80	3	24000	HM	+
THM.03.02/001	THM-03	14	32	80	3	24000	HM	+
THM.03.03/003	THM-03	16	35	90	3	24000	HM	+
THM.03.05.002	THM-03	20	55	110	3	24000	HM	+

THM-04 L

Catalogue number	Type	D mm	h mm	L mm	z	n _{max}		
THM.04.07/002	THM-04	8	25	70	2	24000	HM	+
THM.04.06/001	THM-04	10	32	70	3	24000	HM	+
THM.04.01/001	THM-04	12	32	80	3	24000	HM	+
THM.04.02/001	THM-04	14	32	80	3	24000	HM	+
THM.04.03/001	THM-04	16	35	90	3	24000	HM	+
THM.04.05.001	THM-04	20	55	110	3	24000	HM	+

THM-05

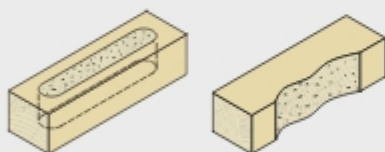
Shank cutter, type **THM-05** with two or three cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for roughing. Special geometry guarantees chip flow up. The cutter working with increased machining parameters.

THM-35 Premium

Shank cutter with increased life, type **THM-35 Premium** with relieved flank (clearance) face and polished cutting surfaces, designed for professional cutting of solid wood and wood based materials. Cutter designed for very efficient roughing. Adapted to increased work parameters.

Type of work: pre-grooving, pre-formatting.

Material: solid softwood, solid hard wood, glued wood, chipboard, MDF, plastics.



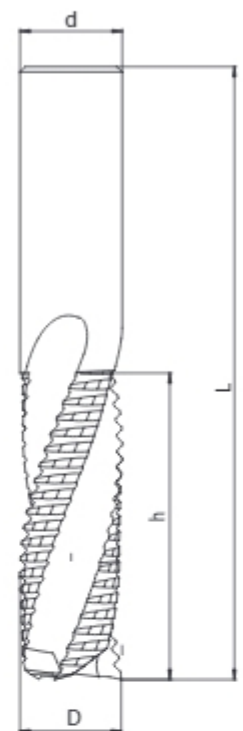
THM-05 / 35 R



THM-05

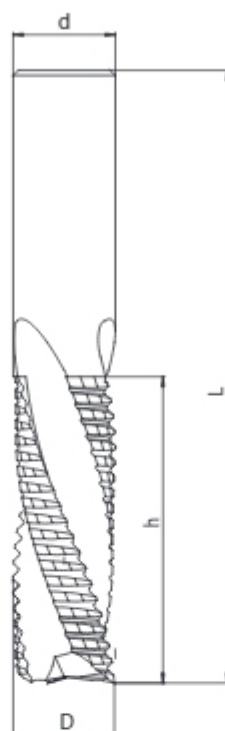
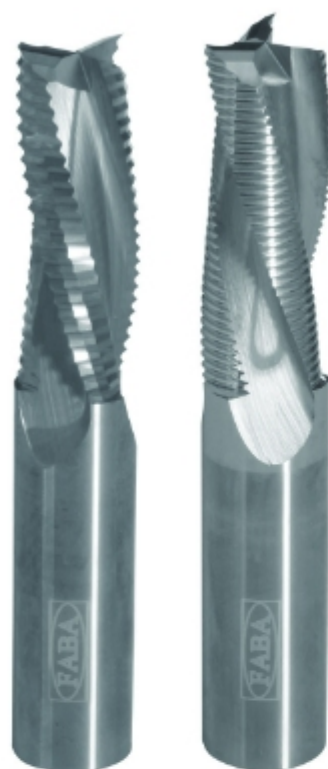


THM-35
Premium



Catalogue number THM-05		Catalogue number THM-35		D mm	h mm	L mm	z	n _{max}	
THM.05.09/002	•			6	25	60	3	24000	HM
THM.05.09/006	•	THM.35.09.006	•	6	30	70	2	24000	HM
THM.05.07/010	•	THM.35.07.010	•	8	25	70	2	24000	HM
THM.05.07/004	•			8	32	80	3	24000	HM
THM.05.06/024	•	THM.35.06.024	•	10	32	70	2	24000	HM
THM.05.06/001	•	THM.35.06.001	•	10	32	70	3	24000	HM
THM.05.06/025	•			10	45	100	2	24000	HM
THM.05.01/001	•	THM.35.01.001	•	12	32	80	3	24000	HM
THM.05.01/008	•			12	52	100	3	24000	HM
THM.05.02/001	•	THM.35.02.001	•	14	32	80	3	24000	HM
THM.05.02/024	•			14	55	110	3	24000	HM
THM.05.03/001	•	THM.35.03.001	•	16	35	90	3	24000	HM
THM.05.03/057	•			16	60	110	3	24000	HM
THM.05.04/001	•	THM.35.04.001	+	18	52	100	3	24000	HM
THM.05.05/001A	•	THM.35.05.001A	•	20	55	110	3	24000	HM
THM.05.05/005	•			20	70	120	3	24000	HM

THM-06 / 36 L



THM-06 THM-36
Premium

THM-06

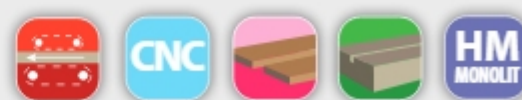
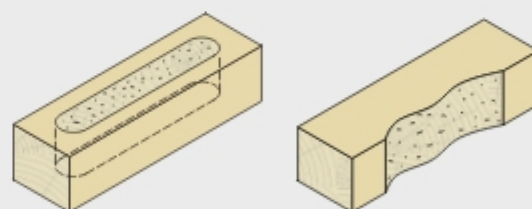
Shank cutter, type **THM-06** with two or three cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for pre-grooving. Special geometry guarantees chip flow up. The cutter working with increased machining parameters.

THM-36 Premium

Shank cutter with increased life, type **THM-36 Premium** with relieved flank (clearance) face and polished cutting surfaces, designed for professional cutting of solid wood and wood based materials. Cutter designed for very efficient roughing. Adapted to increased work parameters.

Type of work: pre-grooving, pre-formatting.

Material: solid softwood, solid hard wood, glued wood, chipboard, MDF, plastics.

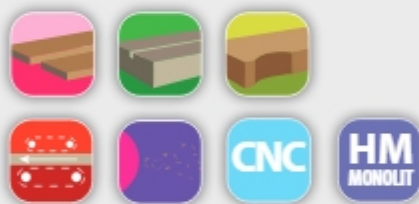
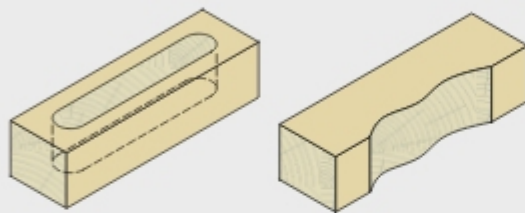


Catalogue number THM-06		Catalogue number THM-36		D mm	h mm	L mm	z	n _{min}	
THM.06.07/002	•	THM.36.07.002	•	8	25	70	2	24000	HM
THM.06.06/003	•	THM.36.06.003	•	10	32	70	2	24000	HM
THM.06.01/001	+	THM.36.01.001	+	12	32	80	3	24000	HM
THM.06.02/001	+	THM.36.02.001	+	14	32	80	3	24000	HM
THM.06.03/001	+	THM.36.03.001	+	16	35	90	3	24000	HM
THM.06.04/001	+	THM.36.04.001	+	18	52	100	3	24000	HM
THM.06.05/001A	+	THM.36.05.001A	+	20	55	110	3	24000	HM

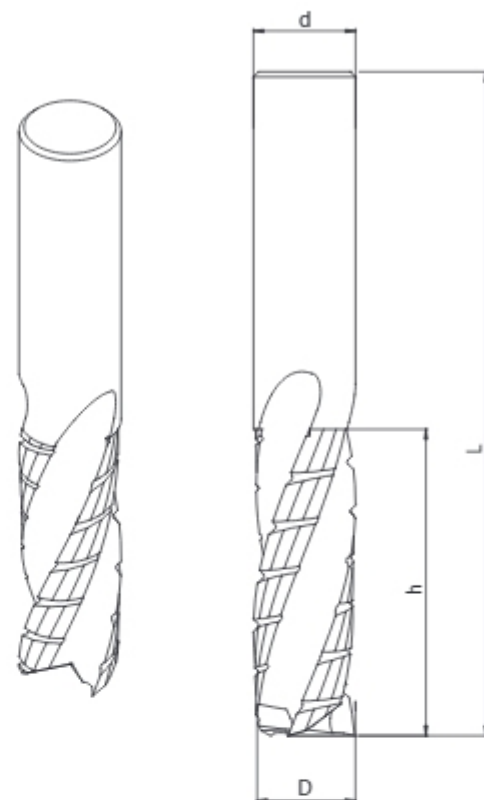
Shank cutter, type **THM-07** or **THM-08** with three cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for pre-grooving, grooving, formatting and nesting. Special geometry guarantees chip flow up. Additional chip breakers allow for better chip fragmentation. Increased chip flow efficiency. The cutter working with increased machining parameters.

Type of work: grooving, pre-formatting and precise formatting.

Material: solid softwood, solid hard wood, glued wood, chipboard, MDF, plastics.



THM-07 / 08



6

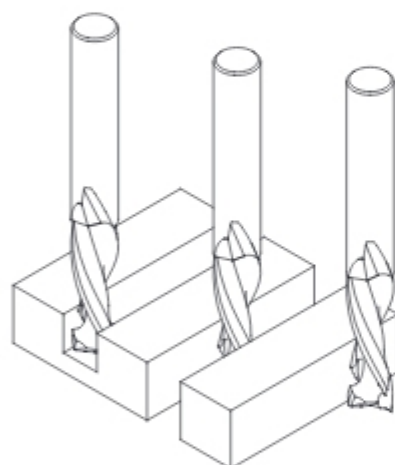
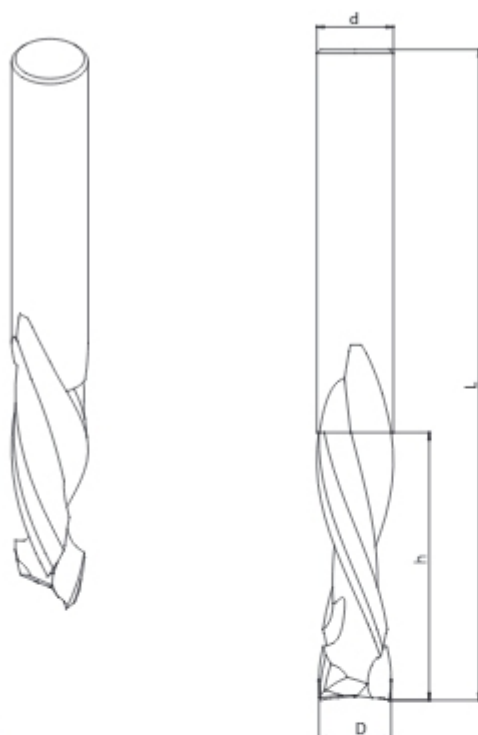
THM-07 R

Catalogue number	Type	D mm	h mm	L mm	z	n _{max}		
THM.07.06/001	THM-07	10	25	70	3	24000	HM	+
THM.07.01/001	THM-07	12	32	80	3	24000	HM	+
THM.07.03/001	THM-07	16	52	110	3	24000	HM	+
THM.07.05/001A	THM-07	20	55	110	3	24000	HM	+

THM-08 L

Catalogue number	Type	D mm	h mm	L mm	z	n _{max}		
THM.08.06/001	THM-08	10	25	70	3	24000	HM	+
THM.08.01/001	THM-08	12	32	80	3	24000	HM	+
THM.08.03/001	THM-08	16	52	110	3	24000	HM	+
THM.08.05/001A	THM-08	20	55	110	3	24000	HM	+

THM-09 R



Shank cutter, type **THM-09** with two cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for precise formatting of two-sided veneered board. No veneer ripping thank to alternative direction of turbo-type spiral cutting line. The cutter working with increased machining parameters. Lower cutting resistance. Multiple sharpening possibility.

Type of work: finishing.

Material: solid softwood, solid hard wood, glued wood, chipboard, MDF, plastics.

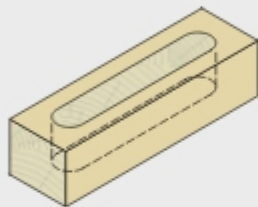


Catalogue number	Type	D mm	h mm	L mm	z	n _{min}		
THM.09.07.002	THM-09	8	32	80	2+2	24000	HM	+
THM.09.07.010	THM-09	8	32	80	3+3	24000	HM	+
THM.09.06/001	THM-09	10	32	80	2+2	24000	HM	•
THM.09.06.012	THM-09	10	32	80	3+3	24000	HM	+
THM.09.01.024	THM-09	12	32	80	3+3	24000	HM	+
THM.09.01/001	THM-09	12	42	90	2+2	24000	HM	•
THM.09.02/001	THM-09	14	52	110	2+2	24000	HM	+
THM.09.03/001	THM-09	16	52	110	2+2	24000	HM	+
THM.09.03.015	THM-09	16	52	110	3+3	24000	HM	+
THM.09.05/001	THM-09	20	52	110	2+2	24000	HM	+
THM.09.05.005	THM-09	20	52	110	3+3	24000	HM	+

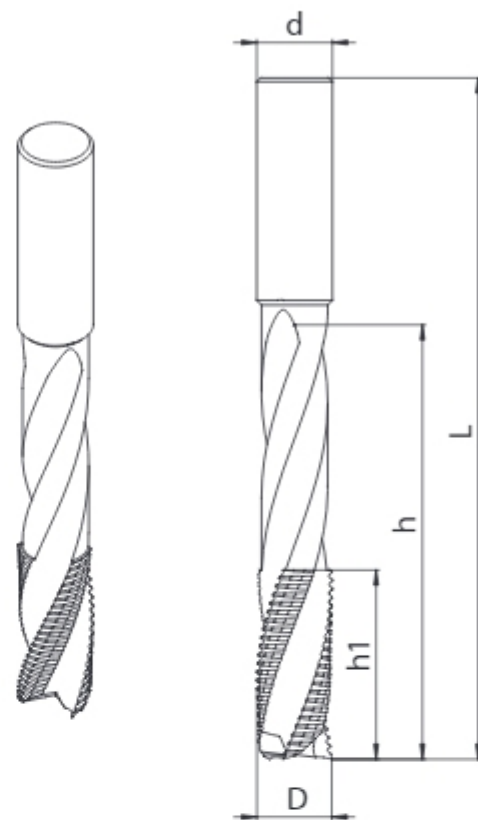
Shank cutter, type **THM-10** with three cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for pre-cutting holes for door locks. Cutting depth up to 95 mm with chip flow. The cutter working with increased machining parameters.

Type of work: deep pre-cutting.

Material: solid softwood, solid hard wood, glued wood, chipboard, MDF, plastics.



THM-10 R

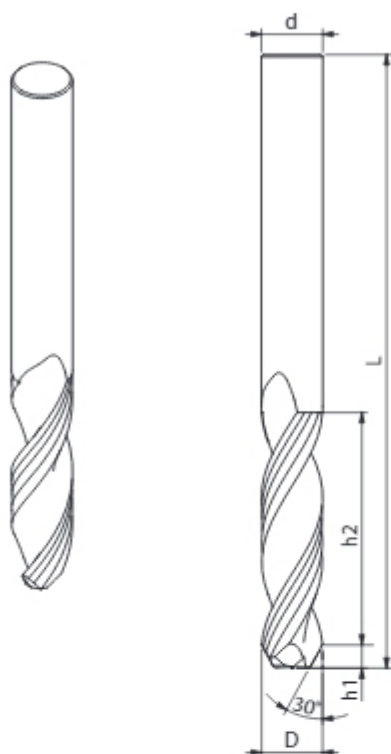


6



Catalogue number	Type	D mm	d mm	h ₁ mm	h mm	L mm	z	n _{max}		
THM.10.03/001	THM-10	16	16	60	100	150	3	24000	HM	•
THM.10.03.036	THM-10	16	16	60	100	150	3	24000	HM	+
THM.10.03/002	THM-10	16,5	18	60	100	160	3	24000	HM	+
THM.10.04/003	THM-10	18	18	60	100	160	3	24000	HM	+

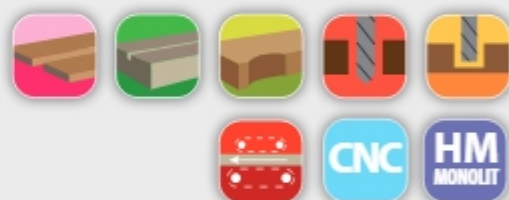
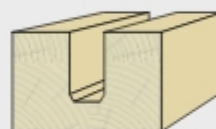
THM-11 / 12



Shank cutter, type **THM-11** or **THM-12** with three cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for groove finishing, formatting, drilling as well as dowel and through drilling. Additional 30° bevel increases edge quality after cutting. Special geometry guarantees chip flow up.

Type of work: grooving, formatting, finishing, drilling.

Material: solid softwood, solid hard wood, glued wood, chipboard, MDF, plastics.



THM-11 R

Catalogue number	Type	D mm	h ₂ mm	h ₁ mm	L mm	z	n _{max}	HM	+
THM.11.01/001	THM-11	12	45	9	110	3	24000	HM	+
THM.11.02/001	THM-11	14	40	9	100	3	24000	HM	+
THM.11.03/001	THM-11	16	50	9	120	3	24000	HM	+

THM-12 L

Catalogue number	Type	D mm	h ₂ mm	h ₁ mm	L mm	z	n _{max}	HM	+
THM.12.01/001	THM-12	12	45	9	110	3	24000	HM	+
THM.12.02/001	THM-12	14	40	9	100	3	24000	HM	+
THM.12.03/001	THM-12	16	50	9	120	3	24000	HM	+

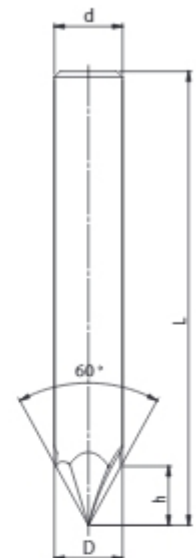
Monolith shank cutter, type **THM-13** with two cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for engraving as well as beveling and counterboring.

Type of work: engraving, beveling, counterboring.

Material: solid softwood, solid hard wood, glued wood, chipboard, MDF, plastics.



THM-13 R

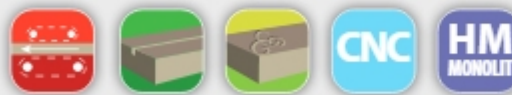


Catalogue number	Type	D mm	h mm	L mm	z	n _{max}		
THM.13.07/001	THM-13	8	7	70	2	24000	HM	•
THM.13.01/001	THM-13	12	9	80	2	24000	HM	•

Monolith shank cutter, type **THM-14** with two cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for engraving and shape grooving.

Type of work: engraving, shape-grooving.

Material: solid softwood, solid hard wood, glued wood, chipboard, MDF, plastics.

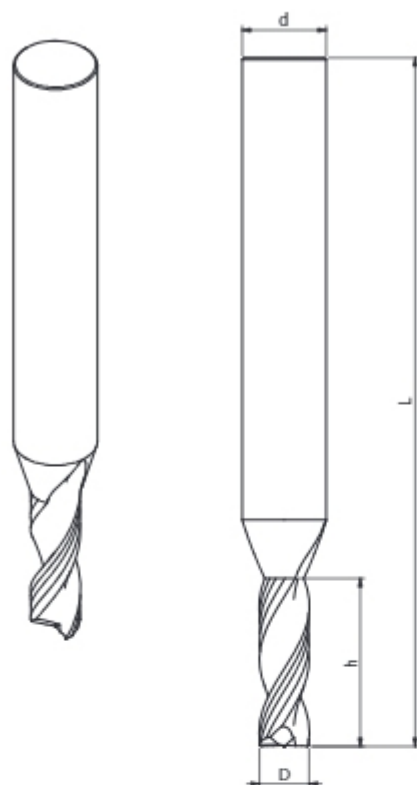


THM-14 R



Catalogue number	Type	D mm	h mm	L mm	R mm	z	n _{max}		
THM.14.09/001	THM-14	6	9	60	3	2	24000	HM	•
THM.14.09.017	THM-14	6	22	60	3	2	24000	HM	+
THM.14.07.006	THM-14	8	25	70	4	2	24000	HM	+
THM.14.07/001	THM-14	8	11	70	4	2	24000	HM	•
THM.14.06/002	THM-14	10	13	80	5	2	24000	HM	•
THM.14.06.017	THM-14	10	32	80	5	2	24000	HM	+
THM.14.01.013	THM-14	12	32	80	6	2	24000	HM	+
THM.14.03.011	THM-14	16	52	110	8	2	24000	HM	+

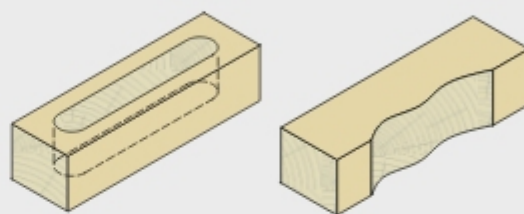
THM-15 / 16



Monolith shank cutter, type **THM-15** or **THM-16** with two or three cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for groove finishing, formatting and nesting. Special geometry guarantees chip flow up. Thicker shank part.

Type of work: grooving, finishing.

Material: solid softwood, solid hard wood, glued wood, chipboard, MDF, plastics.



THM-15 R

Catalogue number	Type	D mm	d mm	h mm	L mm	z	n _{max}		
THM.15.12/001	THM-15	5	6	15	60	2	24000	HM	+
THM.15.09/001	THM-15	6	8	20	70	2	24000	HM	+
THM.15.08/001	THM-15	7	8	20	70	2	24000	HM	+
THM.15.07/001	THM-15	8	10	30	80	2	24000	HM	+
THM.15.17/001	THM-15	9	10	30	80	2	24000	HM	+
THM.15.06/001	THM-15	10	12	30	80	2	24000	HM	+

THM-16 L

Catalogue number	Type	D mm	d mm	h mm	L mm	z	n _{max}		
THM.16.12/001	THM-16	5	6	15	60	2	24000	HM	+
THM.16.09/001	THM-16	6	8	20	70	2	24000	HM	+
THM.16.07/001	THM-16	8	10	30	80	2	24000	HM	+

Step drills **THM-25** are produced only on client's individual request.

Step and profile shank cutters are offered with positive and negative helix line.

Optionally, the tool can be produced with a different profile.

Advantages of using stepped and profile THM:

- possibility of performing a couple of operations with one tool,
- eliminating machining runout by using only one mounting of the tool,
- faster completion of the operation compared to working with a few tools,
- smaller quantity of holders on the machine,
- increased life and cutting quality,
- lower energy costs,
- lower costs of discrete manufacturing.

Material: solid softwood, solid hard wood, glued wood, chipboard, MDF, plastics.

Order should include all dimensions shown in the drawing.

THM-25 step

