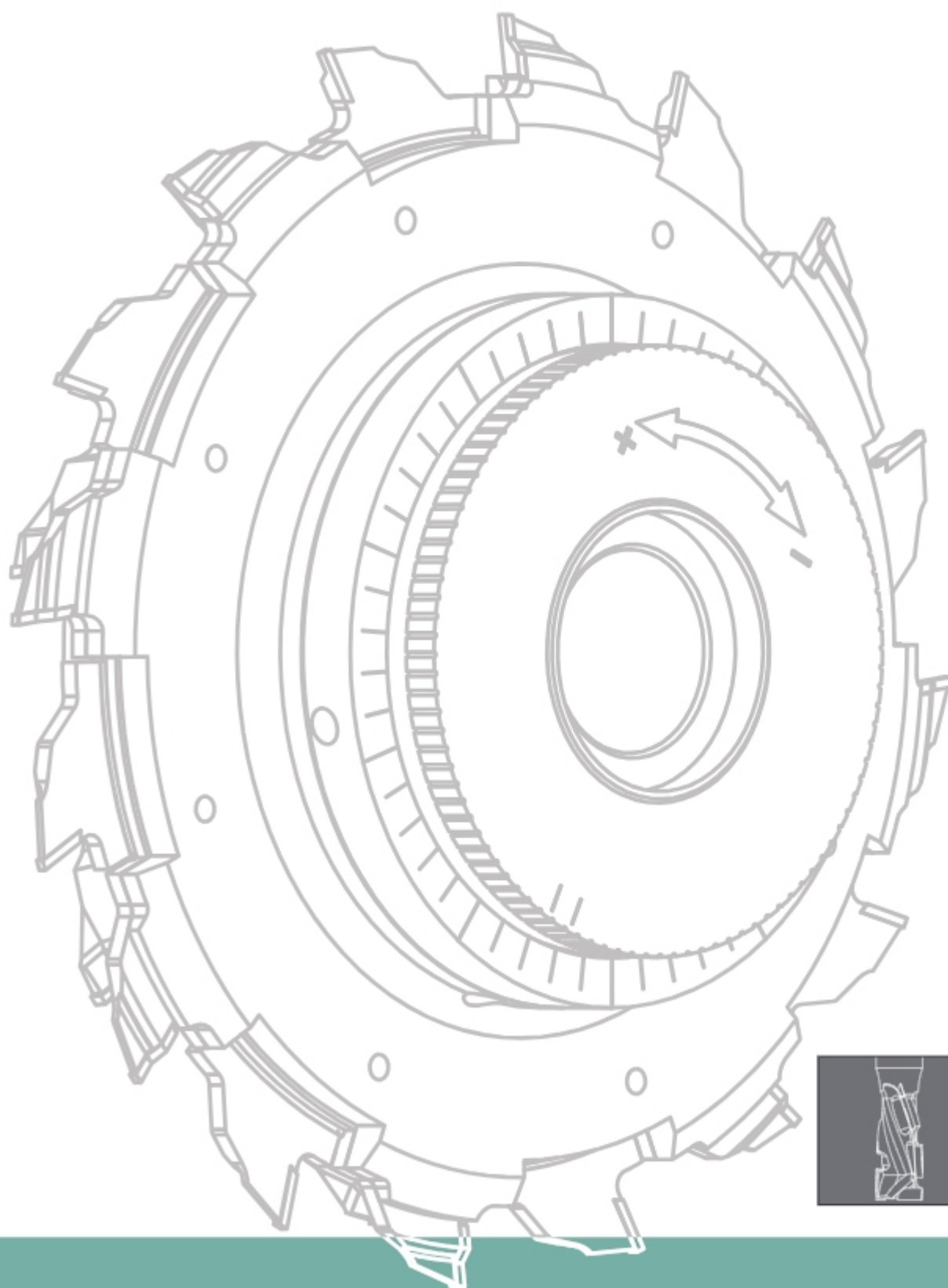




11. DIA tools

DIA tools

Tools with DIA tips designed for professional machining of solid wood and other wood-based materials such as chipboard, laminates, MDF, HDF, PVC and CORIAN. Use and selection of a proper diamond significantly increases life of tools in comparison with traditional tools with carbide (HM) blades.

The *DIA tools* chapter includes only example types and models of tools with DIA blades. The main part of our offer are special tools designed and manufactured 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. Every DIA special tool or set of tools is 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.

DIA tools are produced with various clamping types, however, we put special focus on hydro clamping or all types of clamping on conical HSK shanks. The clamping construction guarantee run-out tolerance reduced to minimum.

Thanks to hydro system, which allows for perfect balancing of the tool, we obtain very high surface quality and ability to work with high cutting and feed speed.

All types of 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. Time of design and production process of cutters or catalogue sets marked with "+" as well as special tools made on client's special request usually doesn't exceed 10-15 working days after agreeing all the details.

Orders should include:

- outer diameter (D) or diameters range,
- bore diameter (d),
- 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

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Pictograms



solid dry hardwood



hard exotic wood



chipboard



plywood



laminated board



MDF



HDF



HPL



plastics



construction board



corian



single cut



multi-rip saw blade



cutting in stack



cylinder boring bits



scoring saw blade



aluminium body



cross and longitudinal cut



formatting



rebating



grooving



edge machining



profiling



mechanical feed



manual feed



CNC machine



DIA blade



carbide



non-resharpenable



2-3 times resharpenable



4-6 times resharpenable



5-6 times resharpenable

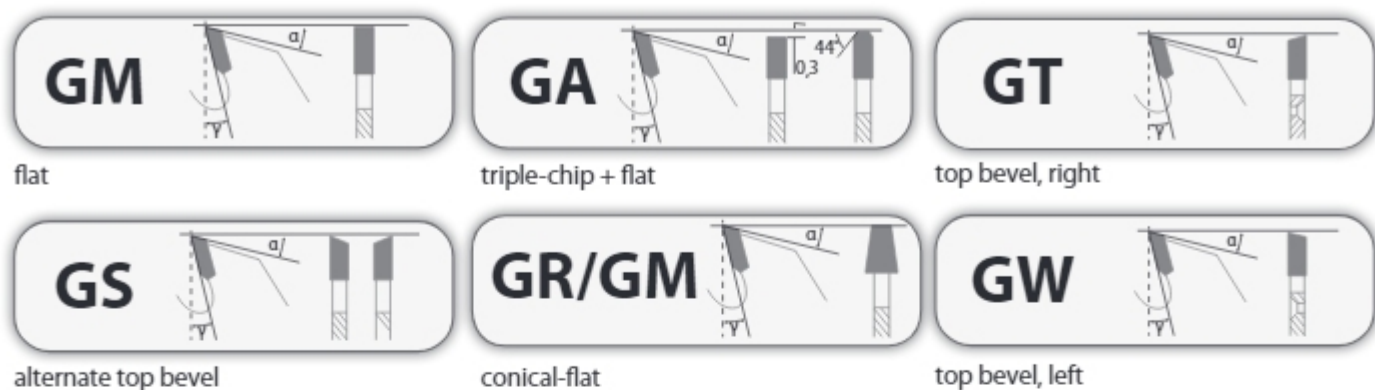


7-9 times resharpenable



multiple resharpening

Tooth configuration



Cutters with shear angle are designed for working on CNC centres: IMA, Reichenbahr, Homag, Bisse. They are used for rebating, grooving and forming. Drilling blade is made from HM.

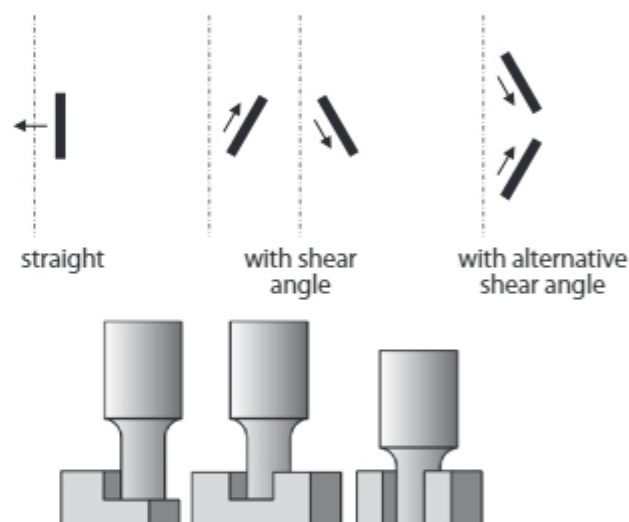
Cutters' construction guarantees:

- quiet and stable work,
- better surface quality,
- increased life.

Type of material:

- MDF, HDF,
- chipboard,
- laminated chipboard,
- CORIAN,
- laminates,
- hard exotic wood.

Teeth



Diagrams determining P (minute feed) in relation to height of the removed material a.

Type of work: formatting with drilling ability.

Rotation speed:

$D = 10 \div 12 \text{ mm}; n = 18\,000 \div 24\,000 \text{ obr/min}$

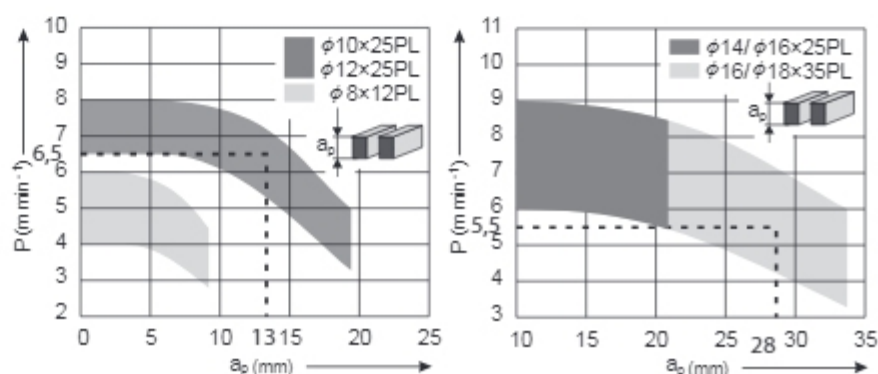
$D = 14 \div 20 \text{ mm}; n = 16\,000 \div 24\,000 \text{ obr/min}$

Teeth number:

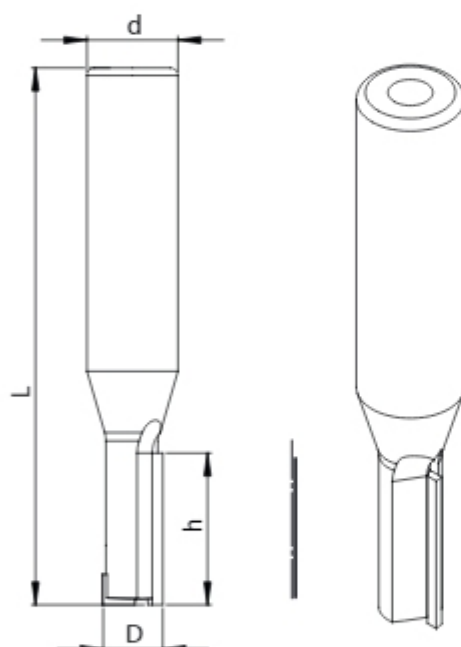
$z = 1 \text{ and } z = 1+1$

Drilling blade HM, optionally DP.

Technical parameters TJD group



TJD-01



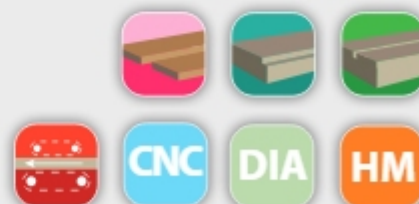
Straight shank cutters type **TJD-01**.

Type of work: formatting, splitting, rebating, grooving and copying on CNC machines. Used especially for making very small inner radiuses.

Material: solid hardwood, chipboard, plywood, MDF, HDF, construction board, plastics.

Specification:

- polished PCD surface,
- PCD drilling blade,
- optional body from HM or special alloy in order to increase stiffness and life of the tool,
- sharpening zone 0,5-1,5 mm,
- $P_{max} = 2-3 \text{ m/min.}$
- $n_{max} = 24\ 000 \text{ r.p.m.}$



Catalogue number	Type	D mm	h mm	d mm	L mm	z	↙	
TJD01.0102B	TJD-01	8	20	12	70	1	R	•
TJD01.0102BL	TJD-01	8	20	12	70	1	L	+
TJD001.8350HM	TJD-01	10	22	12	81	2	R	•
TJD01.029G	TJD-01	10	25	12	71	1	R	•
TJD01.028G	TJD-01	10	20	12	66	1	R	+
TJD01.028GL	TJD-01	10	20	12	66	1	L	+
TJD01.029GL	TJD-01	10	25	12	71	1	L	+

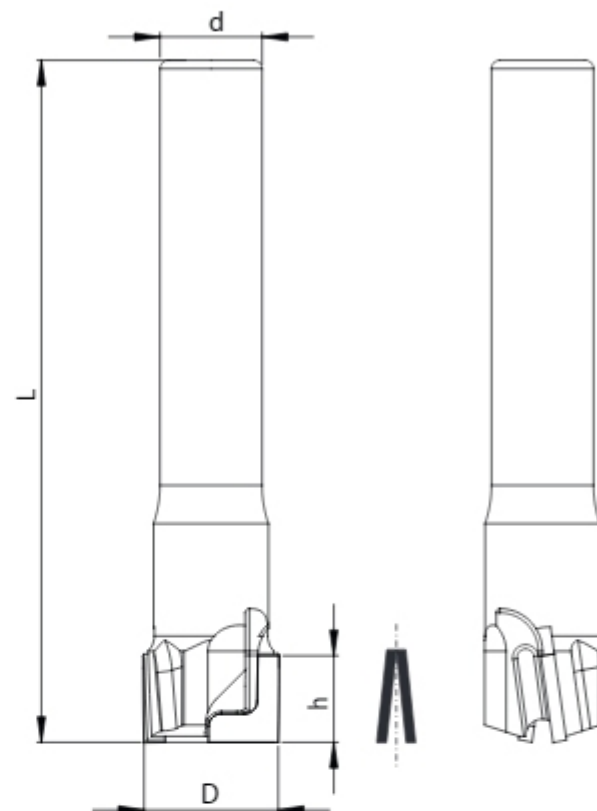
Straight shank cutters type **TJD-06**

Type of work: grooving, rebating, drilling on CNC machines.

Material: solid hardwood, laminated materials, chipboard, plywood, MDF, HDF.

Specification:

- high quality machining,
- drilling ability,
- negative hook angle,
- PCD Drilling blade,
- resharpenable 2-3 times,
- $P_{max} = 3-6 \text{ m/min.}$
- $n_{max} = 24\,000 \text{ r.p.m.}$

TJD-06

Catalogue number	Type	D mm	h mm	d mm	L mm	z		
TJD006.6010	TJD-06	6	6	12	60	1	R	+
TJD006.3570HM	TJD-06	6	15	6	66	1	R	•
TJD006.6020	TJD-06	8	6	12	60	1	R	+
TJD006.6030	TJD-06	10	8	12	65	2	R	+
TJD006.6040	TJD-06	10	12	12	67	2	R	+
TJD006.6050	TJD-06	12	12	12	70	2	R	+
TJD006.6060	TJD-06	16	16	12	80	2	R	+
TJD006.6070	TJD-06	20	10	12	80	2	R	+
TJD006.6080	TJD-06	20	15	12	80	2	R	+
TJD006.6090	TJD-06	25	10	12	85	2	R	+
TJD006.6100	TJD-06	30	15	12	90	2	R	+

TJD-07

Straight shank cutters type **TJD-07** resharpenable 2-3 times.

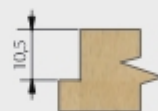
Type of work: formatting, splitting, rebating.

Material: solid hardwood, laminated materials, chipboard, plywood, MDF, HDF.

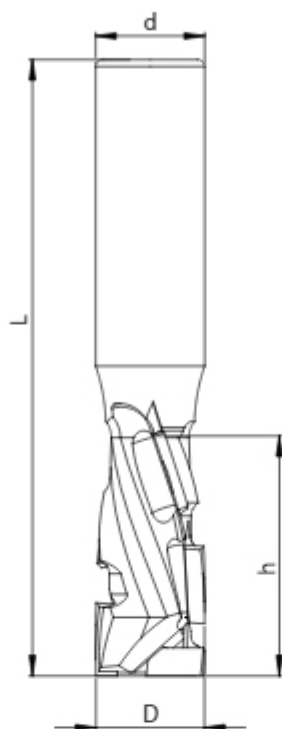
Specification:

- blades positions at big shear angle guarantee quiet and stable work,
- long life,
- HM drilling blade (PCD on request),
- spiral blades guarantee high cutting quality, lower cutting resistance and longer life of the blade,
- $P_{max} = 3-6 \text{ m/min}$,
- $N_{max} = 24000 \text{ r.p.m.}$

We offer all cutters also in "L" version.



Minimum rebate size
of laminated material.



Catalogue number	Type	D mm	h mm	d mm	L mm	z	↺	
TJD007.0460	TJD-07	10	25	12	76	1+1	R	•
TJD007.4910	TJD-07	10	35	12	88	1+1	R	•
TJD007.0040R	TJD-07	12	25	12	78	1+1	R	•
TJD007.0050R	TJD-07	12	35	12	88	1+1	R	+
TJD007.0181	TJD-07	14	25	16	81	1+1	R	+
TJD007.0092	TJD-07	14	35	16	81	1+1	R	+
TJD007.0021R	TJD-07	16	25	16	81	1+1	R	•
TJD007.0020R	TJD-07	16	25	25	91	1+1	R	+
TJD007.0030R	TJD-07	16	35	16	91	1+1	R	+
TJD007.0030RL	TJD-07	16	35	16	91	1+1	L	+
TJD007.0034R	TJD-07	16	35	25	96	1+1	R	+
TJD007.0171R	TJD-07	16	43	16	100	1+1	R	•
TJD007.0080R	TJD-07	18	35	25	96	1+1	R	•
TJD007.0061R	TJD-07	18	43	20	109	1+1	R	•
TJD007.0060R	TJD-07	18	43	25	109	1+1	R	•
TJD007.0392	TJD-07	18	52	25	112	1+1	R	+
TJD007.0120R	TJD-07	20	25	20	86	1+1	R	•
TJD007.0150R	TJD-07	20	35	20	96	1+1	R	•
TJD007.0071R	TJD-07	20	43	20	109	1+1	R	•
TJD007.0270R	TJD-07	20	52	20	112	1+1	R	•

Economical straight shank cutters type **TJD-073** resharpenable 3-4 times. New design of the **TJD-073** cutter, including cutting tips position allows for better chip flow during work which results in increased life of the tool and better cutting quality. Shank cutters are designed for top-spindle CNC routers.

Type of work: formatting, splitting, rebating.

Material: laminated materials, chipboard, plywood, MDF, HDF.

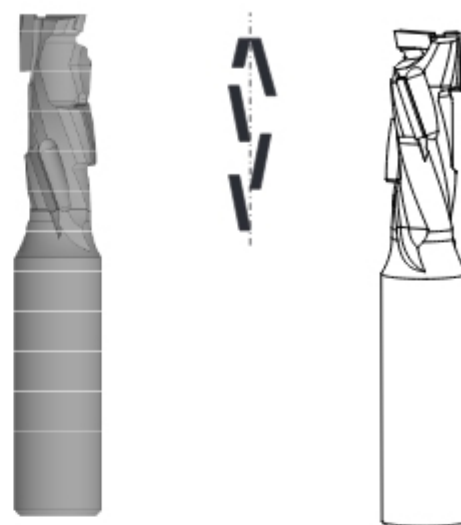
Specification:

- blades positions at big shear angle guarantee quiet and stable work,
- long life,
- spiral blades guarantee high cutting quality, lower cutting resistance and longer life of the blade,

We offer all cutters also in "L" version.

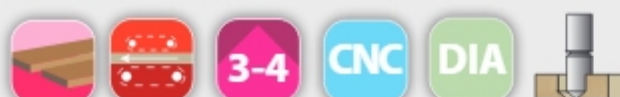
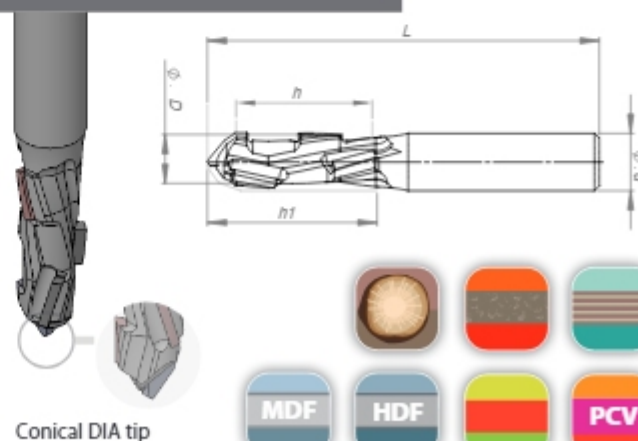


TJD-073



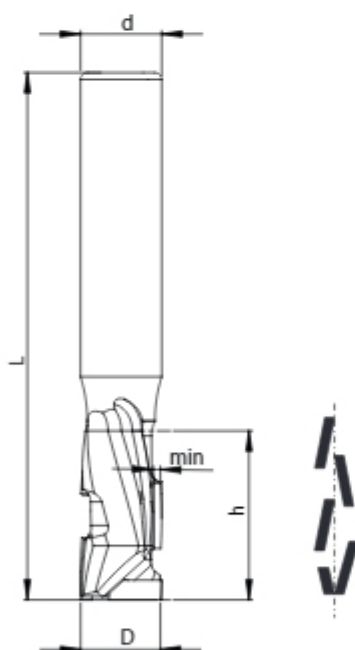
Catalogue number	Type	D mm	h mm	d mm	L mm	z	↙	
TJD073.0050	TJD-073	12	35	12	88	1+1	R	•
TJD073.1260	TJD-073	12	44	12	95	1+1	R	•
TJD073.0254	TJD-073	14	44	12	100	1+1	R	•
TJD073.0030	TJD-073	16	35	16	91	1+1	R	•
TJD073.4790	TJD-073	16	52	16	115	1+1	R	•

TJD-073S



Catalogue number	Type	D mm	h mm	h1 mm	d mm	L mm	z	↙	
TJD073.0460S	TJD-073S	10	25	30	12	88	1+1 DIA	R	•
TJD073.0050S	TJD-073S	12	30	37	12	92	1+1 DIA	R	•

TJD-08



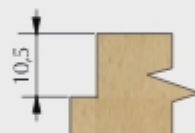
Straight shank cutters type **TJD-08** single use (non-resharpenable). Used PKD tip has been reduced to minimum, so that the cutters are not subject to resharpening and costly regeneration. Shank cutters type TJD-08 are convenient offer for companies processing wood-based materials and plastics on CNC routers.

Type of work: formatting, splitting, rebating

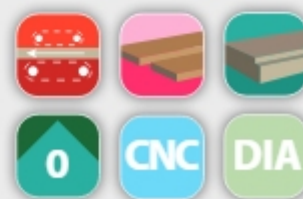
Material: chipboard, plywood, MDF, HDF, plastics

Specification:

- one positioning of the machine without corrections after resharpening,
- no problems with servicing (regeneration),
- very low price,
- long life and cutting quality,
- $P_{max} = 3-6 \text{ m/min.}$
- $N_{max} = 24\,000 \text{ r.p.m.}$



Minimum rebate size
of laminated material.



Catalogue number	Type	D mm	h mm	d mm	L mm	z	↗	
TJD008.1240	TJD-08	12	24	12	78	1+1	R	•
TJD008.0022	TJD-08	16	25	16	81	1+1	R	+
TJD008.0051	TJD-08	12	35	12	88	1+1	R	•
TJD008.0032	TJD-08	16	35	16	91	1+1	R	•

Shank cutter with multiple resharpening possibility typ **TJD-10** designed for formatting on CNC machines. The tool can work with left or right rotation to avoid material chipping.

Type of work: formatting.

Material: chipboard, MDF.

Specification:

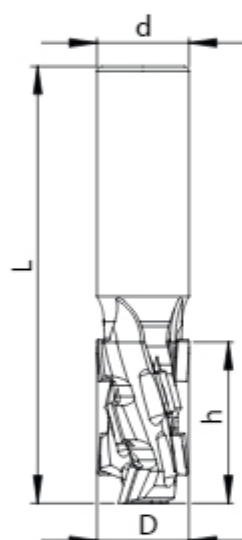
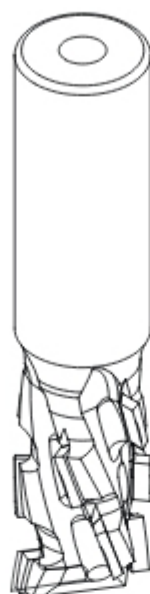
- highly efficient formatting of laminated materials with perfect edge quality,
- works with both rotation directions,
- $P_{max} = 14 \text{ m/min.}$
- $N_{max} = 24\,000 \text{ r.p.m.}$

TJD-10



Catalogue number	Type	D mm	H2 mm	d mm	L mm	z	
TJD010.0100	TJD-10	25	30	25	135	1+1	+

TDT-08A



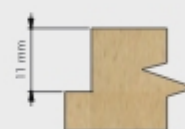
Economical turbo shank cutters type **TDT-08A** $z=2+2$ designed for CNC routers.

Type of work: formatting, curvilinear splitting, grooving rebating.

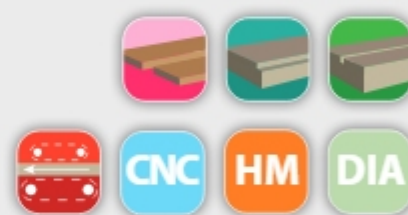
Material: chipboard, plywood, MDF, HDF, laminates.

Specification:

- tools construction guarantees highly efficient cutting with perfect edge quality thanks to blades with positive and negative shear angle,
- increased teeth number $z=2+2$ enables for feed speed up to 12-14 m/min,
- HM or PCD drilling blad,
- $P_{max} = 8-10 \text{ m/min}$,
- $n_{max} = 24\,000 \text{ rpm}$.



Minimum rebate size
of laminated material.



Catalogue number	Type	D mm	h mm	d mm	L mm	z		
TDT08A.0850	TDT-08A	12	23	12	80	2+2	R	•
TDT08A.0440	TDT-08A	16	20	20	80	2+2	R	+
TDT08A.0451	TDT-08A	16	27	16	90	2+2	R	•
TDT08A.0450	TDT-08A	16	27	20	90	2+2	R	•
TDT08A.0065	TDT-08A	16	35	16	95	2+2	R	•
TDT08A.0595	TDT-08A	16	45	16	105	2+2	R	•
TDT08A.0460	TDT-08A	18	27	20	90	2+2	R	+
TDT08A.0470	TDT-08A	18	35	20	95	2+2	R	•
TDT08A.0480	TDT-08A	18	45	20	105	2+2	R	+
TDT08A.0490	TDT-08A	20	27	20	90	2+2	R	+
TDT08A.0500	TDT-08A	20	35	20	95	2+2	R	+
TDT08A.0510	TDT-08A	20	45	20	105	2+2	R	+
TDT08A.0520	TDT-08A	20	54	20	115	2+2	R	+

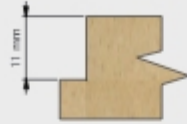
Straight shank cutters type **TD-04**, with multiple resharpening possibility.

Type of work: formatting, splitting, rebating.

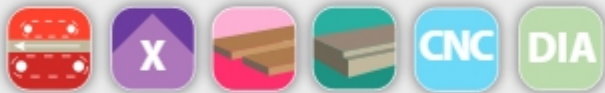
Material: solid hardwood, chipboard, plywood, MDF, HDF, laminates.

Specification:

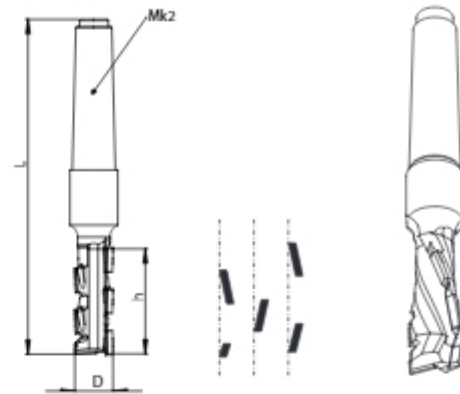
- $P_{max} = 3-6 \text{ m/min}$,
- $N_{max} = 24\,000 \text{ r.p.m.}$



Minimum rebate size
of laminated material.



TD-04



Catalogue number	Type	D mm	h mm	d mm	L mm	z	↗	
TD04.010	TD-04	16	25	Mk2	140	1+1	R	+
TD04.010L	TD-04	16	25	Mk2	140	1+1	L	+
TD04.020	TD-04	16	35	Mk2	150	1+1	R	+
TD04.020L	TD-04	16	35	Mk2	150	1+1	L	+

Shank cutters type **TD-008** for box hinge. Special blade geometry guarantees high quality of the machined slot and long life of the tool.

Type of work: dowel drilling.

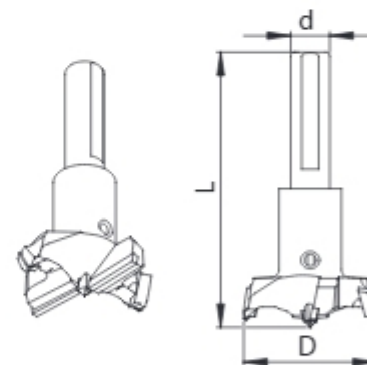
Material: glued wood, chipboard, plywood, MDF and others.

Specification:

- $P_{max} = 3-6 \text{ m/min}$,
- $N_{max} = 24\,000 \text{ r.p.m.}$

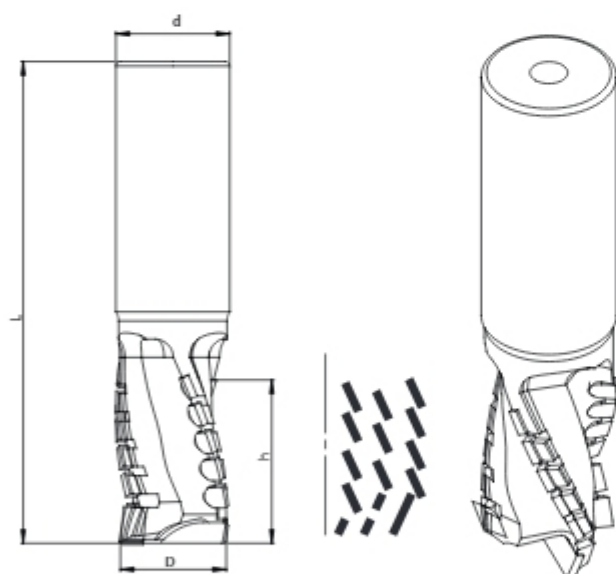


TD-008



Catalogue number	Type	D mm	h mm	d mm	L mm	z	n _{max}	↗	
TD008.8010	TD008	15	7	10	57	2+2	24000	R	+
TD008.8020	TD008	20	7	10	57	2+2	24000	R	+
TD008.8030	TD008	25	7	10	57	2+2	24000	R	+
TD008.8040	TD008	30	7	10	57	2+2	24000	R	+
TD008.8050	TD008	35	7	10	57	2+2	24000	R	+
TD008.8060	TD008	40	7	10	57	2+2	18000	R	+
TD008.8070	TD008	50	7	10	57	2+2	18000	R	+
TD008.8080	TD008	60	7	10	57	2+2	18000	R	+
TD008.8090	TD008	65	7	10	57	2+2	18000	R	+

TDT-01



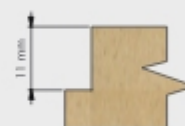
Turbo shank cutter type **TDT-01** for formatting and splitting on CNC routers.

Type of work: formatting, splitting.

Material: chipboard, MDF, HPL, veneer, laminated materials.

Specification:

- high performance in roughing and finishing,
- very high cutting quality on bottom and top edge of the machined material thanks to alternative cutting angles,
- sharpening zone 3 mm,
- P_{max} in splitting = 15 m/min.
- P_{max} in formatting = 20 m/min.
- N_{max} = 24 000 r.p.m.



Minimum rebate size of laminated material.



Catalogue number	Type	D mm	h mm	d mm	L mm	z	↗	
TDT01.018C	TDT-01	18	40	25	122	3+3	R	+
TDT01.018CL	TDT-01	18	40	25	122	3+3	L	+
TDT01.025	TDT-01	25	40	25	122	3+3	R	+
TDT01.025L	TDT-01	25	40	25	122	3+3	L	+
TDT01.02025	TDT-01	20	40	25	122	3+3	R	+
TDT01.02025L	TDT-01	20	40	25	122	3+3	L	+

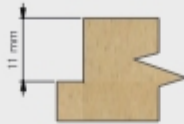
Turbo shank cutter type **TDT-04** designed for roughing and finishing.

Type of work: roughing and finishing.

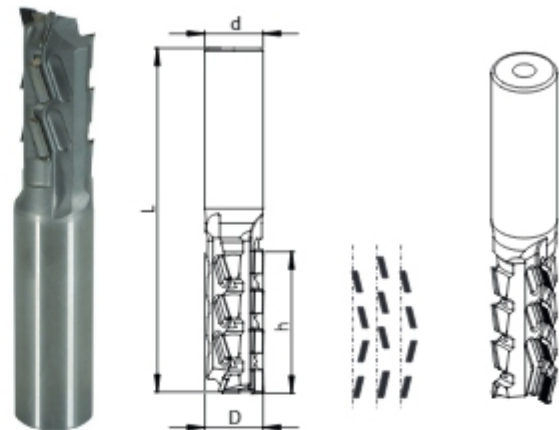
Material: solid hardwood, exotic hardwood, MDF, HPL, veneered board, plastics.

Specification:

- PCD drilling blade,
- on request we offer increased density of cutting lines $z=4+4$ with $\varnothing$ more than 20 mm,
- $P_{max} = 12 - 16 \text{ m/min}$,
- $N_{max} = 24\,000 \text{ r.p.m.}$



Minimum rebate size of laminated material.



Catalogue number	Type	D mm	h mm	d mm	L mm	z	↗	
TDT04.601	TDT-04	18	40	20	103	3+3	R	+
TDT04.601L	TDT-04	18	40	20	103	3+3	L	+
TDT04.602	TDT-04	20	40	20	103	3+3	R	+
TDT04.602L	TDT-04	20	40	20	103	3+3	L	+
TDT04.603	TDT-04	20	50	20	113	3+3	R	+
TDT04.603L	TDT-04	20	50	20	113	3+3	L	+
TDT04.605	TDT-04	25	50	25	103	3+3	R	+
TDT04.605L	TDT-04	25	50	25	103	3+3	L	+
TDT04.702	TDT-04	25	50	25	113	3+3	R	+
TDT04.702L	TDT-04	25	50	25	113	3+3	L	+

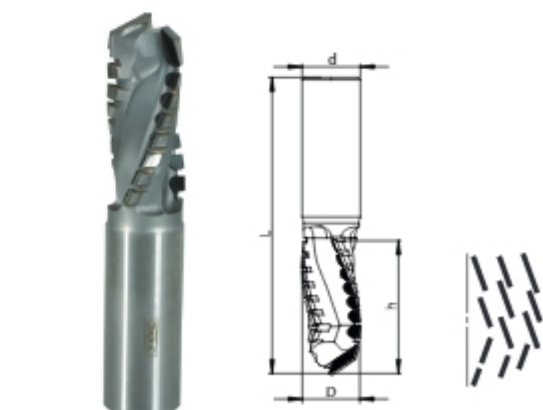
Turbo shank cutter type **TDT-06** designed for roughing and finishing.

Type of work: roughing and finishing.

Material: solid hardwood, exotic hardwood, MDF, HPL, veneered board, plastics.

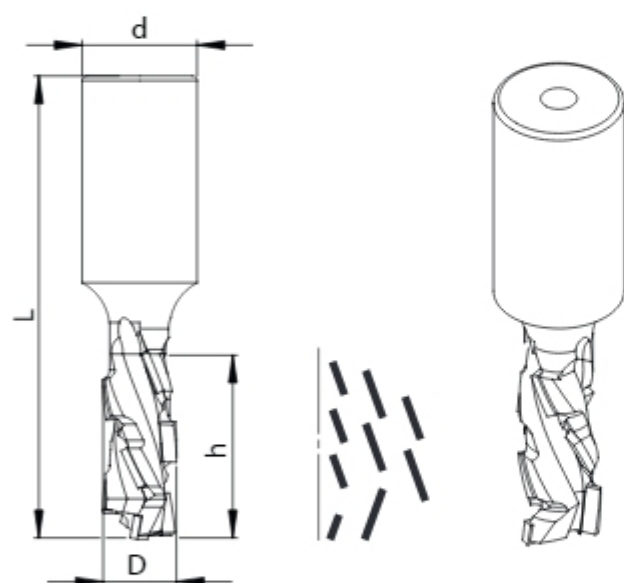
Specification:

- PCD drilling blade,
- On request we offer increased density of cutting lines $z=4+4$ with $\varnothing$ more than 20 mm.



Catalogue number	Type	D mm	h mm	d mm	L mm	z	↗	
TDT06.007	TDT-06	25	57	25	120	3+3	R	+
TDT06.007L	TDT-06	25	57	25	120	3+3	L	+

TDT-07



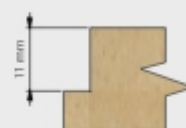
Highly efficient turbo shank cutter type **TDT-07** designed for formatting and splitting on CNC routers.

Type of work: formatting and splitting.

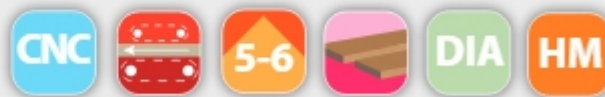
Material: chipboard, MDF, melamine and laminated boards.

Specification:

- optimal chip flow,
- HM drilling blade,
- $P_{max} = 12 \text{ m/min.}$
- $N_{max} = 24\,000 \text{ r.p.m.}$



Minimum rebate size of laminated material.



Catalogue number	Type	D mm	h mm	d mm	L mm	z	↗	
TDT07.008A	TDT-07	16	30	25	105	3+3	R	+
TDT07.008AL	TDT-07	16	30	25	105	3+3	L	+
TDT07.005	TDT-07	18	30	25	105	3+3	R	+
TDT07.005L	TDT-07	18	30	25	105	3+3	L	+
TDT07.002	TDT-07	18	40	25	110,5	3+3	R	+
TDT07.002L	TDT-07	18	40	25	110,5	3+3	L	+
TDT07.0031	TDT-07	20	40	25	110,5	3+3	R	+
TDT07.0031L	TDT-07	20	40	25	110,5	3+3	L	+
TDT07.0070	TDT-07	20	48	25	118,5	3+3	R	+
TDT07.0070L	TDT-07	20	48	25	118,5	3+3	L	+

Highly efficient turbo shank cutter type **TDT-09** for formatting, splitting, grooving and copying on CNC routers.

Type of work: formatting, splitting, grooving, copying.

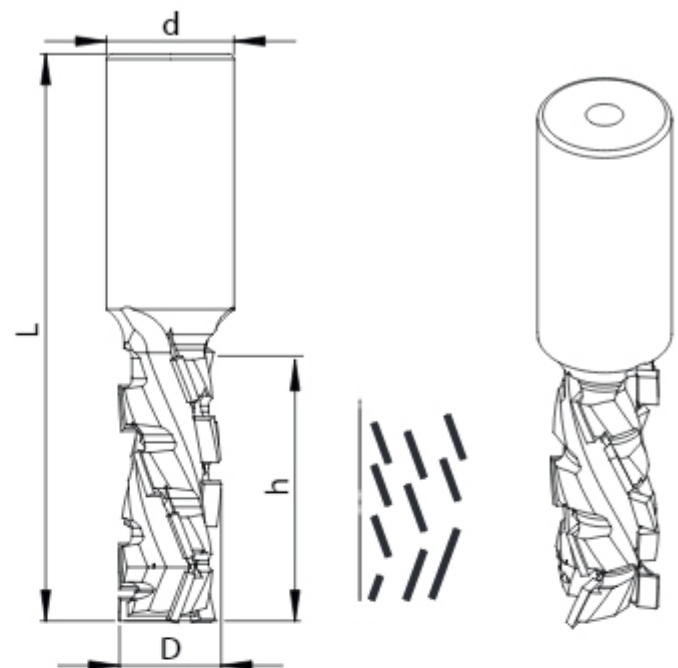
Material: chipboard, MDF, laminates.

Specification:

- big helix line angle guaranteeing high cutting quality and life of the tool,
- gentle chip flow,
- PCD drilling blade,
- $P_{max} = 14 \text{ m/min}$,
- $N_{max} = 24\,000 \text{ r.p.m.}$



Minimum rebate size
of laminated material.



Catalogue number	Type	D mm	h mm	d mm	L mm	z	↗	
TDT09.0050	TDT-09	18	25	20	84,5	3+3	R	•
TDT09.0050L	TDT-09	18	25	20	84,5	3+3	L	+
TDT09.0010	TDT-09	18	30	20	93	3+3	R	+
TDT09.0010L	TDT-09	18	30	20	93	3+3	L	+
TDT09.0130	TDT-09	18	35	20	98	3+3	R	+
TDT09.0130L	TDT-09	18	35	20	98	3+3	L	+
TDT09.0140	TDT-09	18	43	20	101	3+3	R	•
TDT09.0140L	TDT-09	18	43	20	101	3+3	L	+
TDT09.0090	TDT-09	18	52	20	115	3+3	R	+
TDT09.0090L	TDT-09	18	52	20	115	3+3	L	+
TDT09.0030	TDT-09	20	25	20	84,5	3+3	R	+
TDT09.0030L	TDT-09	20	25	20	84,5	3+3	L	+
TDT09.0040	TDT-09	20	30	20	93	3+3	R	+
TDT09.0040L	TDT-09	20	30	20	93	3+3	L	+
TDT09.0060	TDT-09	20	35	20	98	3+3	R	+
TDT09.0060L	TDT-09	20	35	20	98	3+3	L	+
TDT09.0020	TDT-09	20	43	20	101	3+3	R	+
TDT09.0020L	TDT-09	20	43	20	101	3+3	L	+
TDT09.0150	TDT-09	20	52	20	115	3+3	R	+
TDT09.0150L	TDT-09	20	52	20	115	3+3	L	+

TDT-15

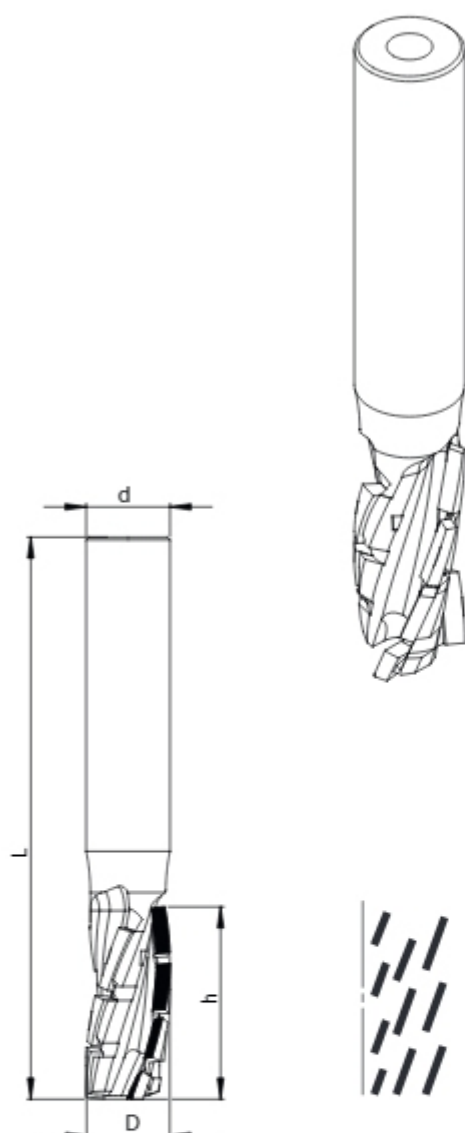
Turbo shank cutter type **TDT-15** designed for formatting and splitting on CNC routers with vacuum bed.

Type of work: formatting, splitting.

Material: chipboard, MDF, HDF.

Specification:

- used in highly efficient machining of raw material,
- chip flow up,
- D = 12, D = 16 resharable 2-3 times,
- D = 20 resharable 4-6 times,
- $P_{max} = 10-18 \text{ m/min}$,
- $n_{max} = 24\,000 \text{ r.p.m.}$



Catalogue number	Type	D mm	h mm	d mm	L mm	z	↗	
TDT015.0020	TDT-15	12	25	12	75	3	R	+
TDT015.0040	TDT-15	16	25	16	75	3	R	+
TDT015.0070	TDT-15	20	40	25	106	3	R	+
TDT015.0021	TDT-15	12	25	25	106	3	R	+
TDT015.0110	TDT-15	12	35	12	88	3	R	+
TDT015.0120	TDT-15	16	25	16	106	3	R	+
TDT015.0130	TDT-15	16	35	16	106	3	R	+
TDT015.0140	TDT-15	16	43	16	106	3	R	+
TDT015.0150	TDT-15	20	25	25	106	3	R	+
TDT015.0160	TDT-15	20	35	25	106	3	R	+
TDT015.0170	TDT-15	20	43	20	106	3	R	+
TDT015.0180	TDT-15	20	60	25	106	3	R	+

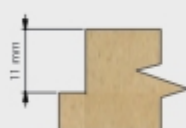
Turbo shank cutter type **TDT-0151** designed for formatting and splitting on CNC routers with vacuum bed.

Type of work: formatting, splitting.

Material: chipboard, MDF, HDF.

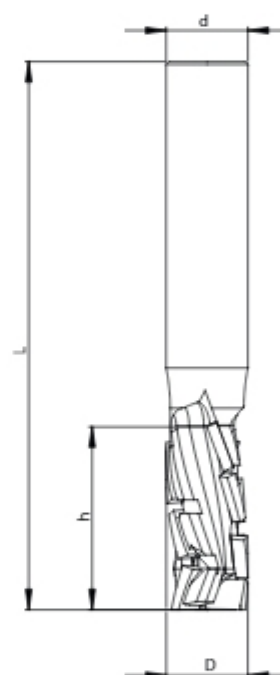
Specification:

- used in highly efficient machining of laminated material material: HDF, MDF, chipboard,
- very high cutting quality on bottom and top edge of the machined material thanks to alternative cutting angles,
- $D = 12$, $D = 16$ resharable 3-4 times,
- $D = 20$ resharable 4-6 times,
- $P_{max} = 10-15 \text{ m/min}$,
- $n_{max} = 24\,000 \text{ r.p.m.}$



Minimum rebate size of laminated material.

TDT-0151



3 cutting lines on 3 spirals



Catalogue number	Type	D mm	h mm	d mm	L mm	z	↺	
TDT0151.S010	TDT-0151	12	25	12	80	3	R	•
TDT0151.S020	TDT-0151	12	35	12	90	3	R	+
TDT0151.S030	TDT-0151	16	25	16	80	3	R	+
TDT0151.S040	TDT-0151	16	35	16	95	3	R	•
TDT0151.S050	TDT-0151	16	43	16	100	3	R	+
TDT0151.S060	TDT-0151	20	25	20	80	3	R	+
TDT0151.S070	TDT-0151	20	35	20	90	3	R	+
TDT0151.S080	TDT-0151	20	43	20	100	3	R	+

TDT-0153

3 full cutting lines
on 6 spirals

Turbo shank cutter type **TDT-0153** designed for formatting and splitting on CNC routers

PCD shank cutter from the TDT-TURBO group, resharpenable 3-4 times, with plunge tip and heavy duty body from special wolfram steel.

(W) wolfram steel body

TDT-0153 cutter strengthened body and design allows for a very quiet and stable work with feed speed up to 20 m/min with high cutting quality and increased life..

Type of work: formatting, splitting.

Material: chipboard, MDF, HDF, laminates.

Specification:

- used in highly efficient machining of laminated material: HDF, MDF, chipboard, laminates,
- very high cutting quality on bottom and top edge of the machined material thanks to alternative cutting angles,
- resharpenable 3-4 times,
- $P_{max} = 15-20$ m/min,
- $n_{max} = 24\,000$ r.p.m.

New dimension of Nesting



Catalogue number	Type	D mm	h mm	d mm	L mm	z		
TDT0153.0013 (W)	TDT-0153	12	24	12	70	3+1	R	•
TDT0153.0160 (W)	TDT-0153	16	35	16	95	3+1	R	+

Highly efficient turbo shank cutter z=4+4 type **TDT-10** designed for formatting, splitting, grooving and copying on CNC routers.

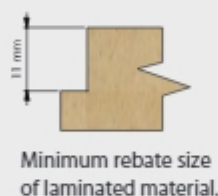
Type of work: formatting, splitting, grooving, copying.

Material: solid hardwood, exotic hardwood, chipboard, MDF, HDF, raw boards, melamine and paper, HPL, veneer, materials coated with finish foil.

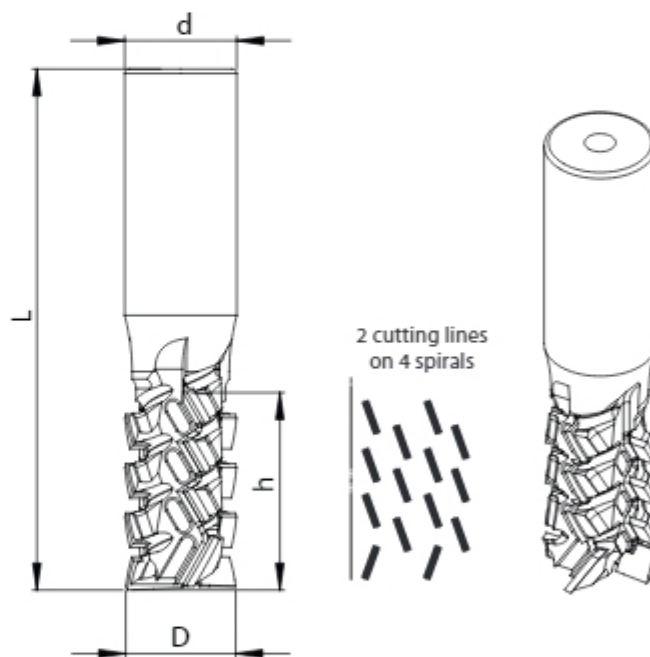
Innovative construction of shank tools with increased density of cutting blades positioned spirally at a big angle. The cutters are designed for very efficient work with the highest quality of the machined material. Four simultaneously cutting blades are positioned at a very big shear angle. It guarantees very long life as well as quiet and stable work of the tool. Spirally arranged 4 cutting lines perfectly remove chip leaving the machined elements clean.

Specification:

- D = 20 resharable 5-6 times,
- D = 22, D = 25 resharable 7-9 times,
- two PCD drilling blades,
- $P_{max} = 20-25 \text{ m/min}$,
- $n_{max} = 24\,000 \text{ r.p.m.}$

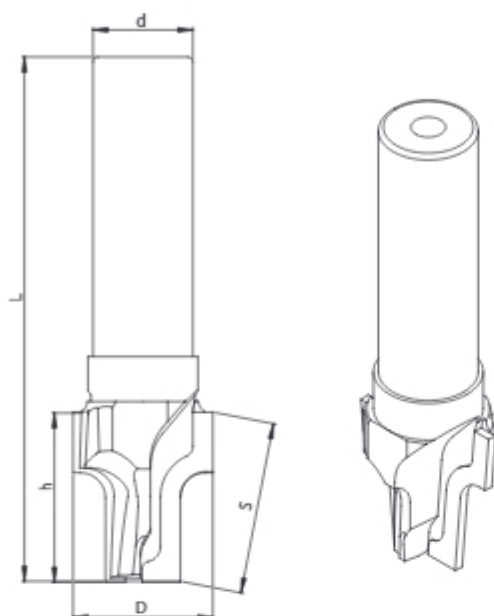


TDT-10



Catalogue number	Type	D mm	h mm	d mm	L mm	z	↗	
TDT010.0040	TDT-10	20	25	20	87	4+4	R	+
TDT010.0040L	TDT-10	20	25	20	87	4+4	L	+
TDT010.0050	TDT-10	20	35	20	97	4+4	R	•
TDT010.0050L	TDT-10	20	35	20	97	4+4	L	+
TDT010.0030	TDT-10	22	43	16	105	4+4	R	•
TDT010.0030L	TDT-10	22	43	16	105	4+4	L	+
TDT010.0020	TDT-10	25	43	25	116	4+4	R	•
TDT010.0020L	TDT-10	25	43	25	116	4+4	L	+

TPD-05 R or L



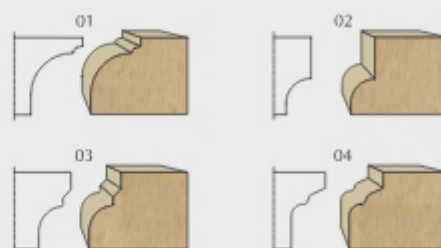
Profile shank cutter type **TPD-05** right or left designed for profiling on CNC machines.

Type of work: profiling.

Material: chipboard, plywood, MDF.

Specification:

- $P_{max} = 8-12$ m/min,
- $N_{max} = 18\,000$ r.p.m.

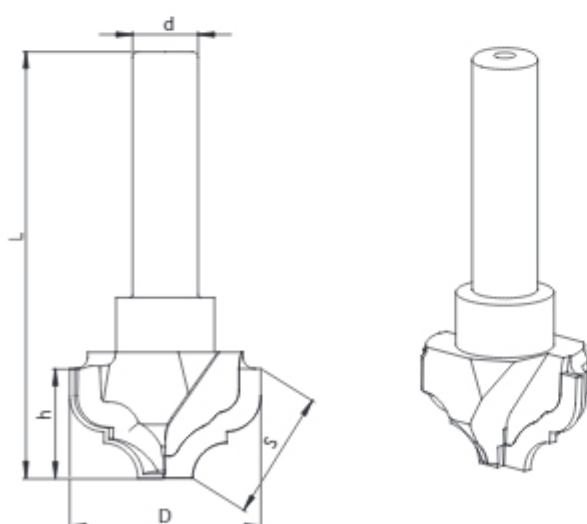


Example profiles.



Type	D mm	h mm	d mm	L mm	s mm	z	n_{max}	
TPD-05	26	28	20	68	29,2	2	18000	+

TPD-07 R or L



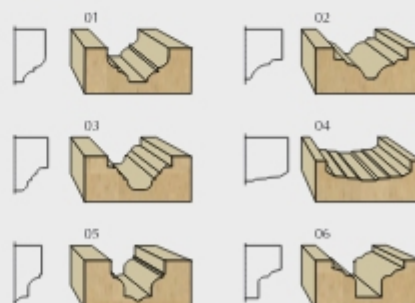
Profile shank cutter type **TPD-07** right or left designed for profiling on CNC machines.

Type of work: profiling.

Material: chipboard, plywood, MDF.

Specification:

- $P_{max} = 8-12$ m/min,
- $N_{max} = 18\,000$ r.p.m.



Example profiles.



Type	D mm	h mm	d mm	L mm	s mm	z	n_{max}	
TPD-07	34	24	12	55	25,8	2	18000	+

Profile shank cutter type **TPD-08** right or left designed for profiling on CNC machines.

Type of work: profiling.

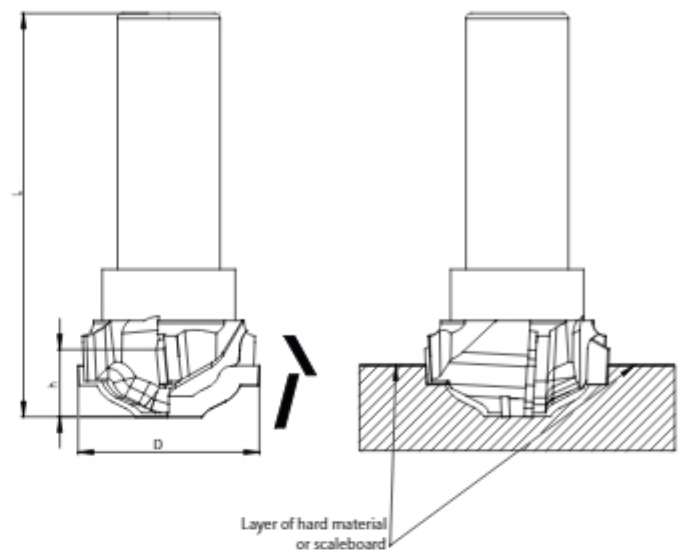
Material: chipboard, plywood, MDF.

Specification:

- profile shank cutters are designed for very precise machining,
- tools are equipped with additional blades directing chip down,
- $P_{max} = 8-12 \text{ m/min}$,
- $N_{max} = 24\,000 \text{ r.p.m.}$



TPD-08 R or L



Type	D mm	h mm	d mm	L mm	z	n_{max}	
TPD-08	35,4	12	20	78	2+2	18000	+

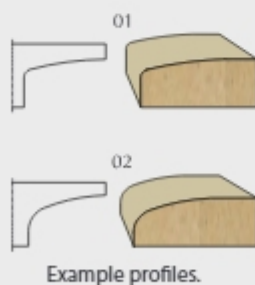
Profile shank cutter type **TPD-10** right or left designed for profiling on CNC machines.

Type of work: profiling.

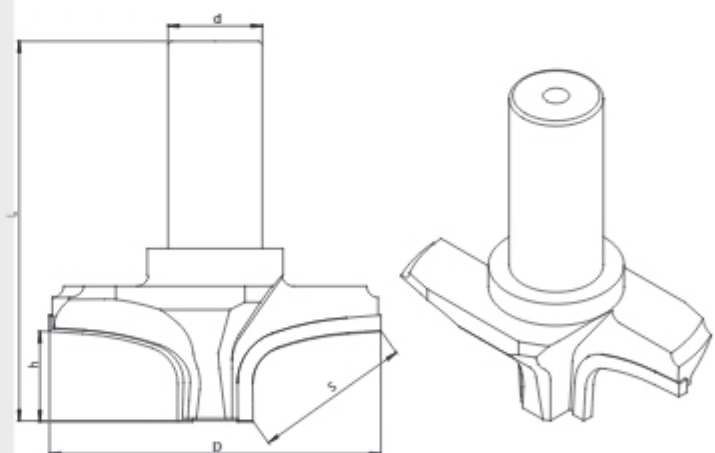
Material: chipboard, plywood, MDF.

Specification:

- $P_{max} = 8-12 \text{ m/min}$,
- $N_{max} = 18\,000 \text{ r.p.m.}$

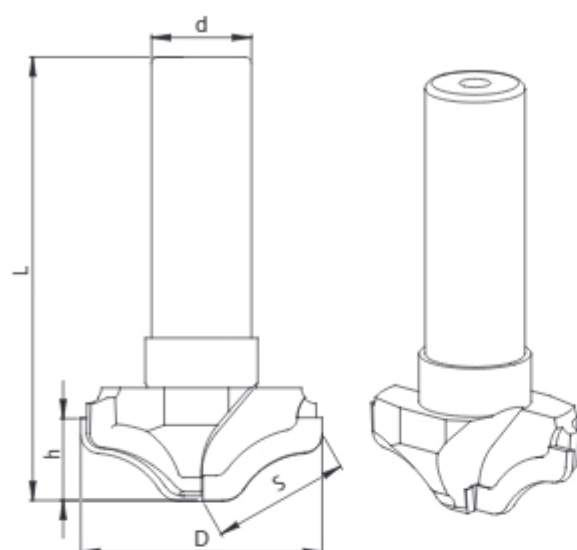


TPD-10 R or L



Type	D mm	h mm	d mm	L mm	s mm	z	n_{max}	
TPD-10	81	21	16	75	37	2	18000	+

TPD-13 R or L



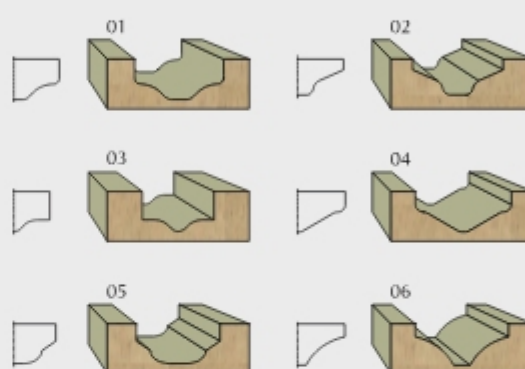
Profile shank cutter type **TPD-13** right or left designed for profiling on CNC machines.

Type of work: profiling.

Material: chipboard, plywood, MDF.

Specification:

- $P_{max} = 8-12 \text{ m/min}$,
- $N_{max} = 24\,000 \text{ r.p.m.}$



Example profiles.



Type	D mm	h mm	d mm	L mm	s mm	z	n _{max}	
TPD-13	36	12	25	53,6	21,6	2	18000	+

Profile shank cutter type **TPD-18** designed for T-grooving.

Type of work: profiling.

Material: chipboard, plywood, MDF.

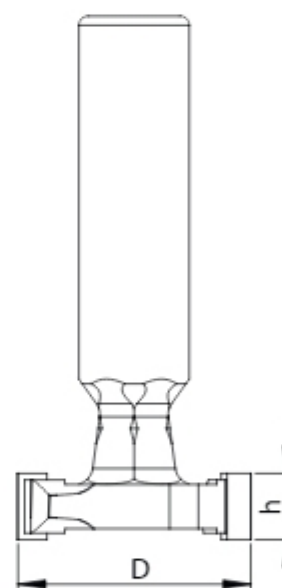
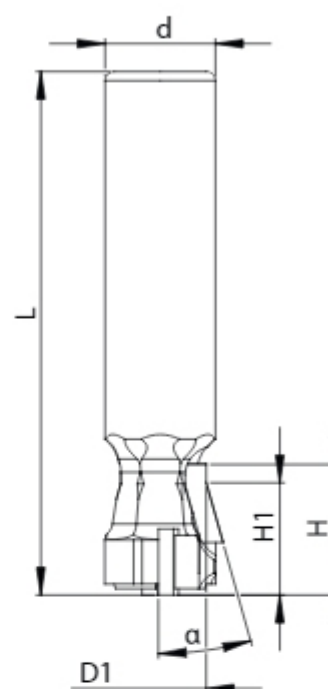
Specification:

- highly efficient machining quality thank to properly selected construction and PKD type,
- tools offered also in special versions (on request),
- sharpening zone 2 mm,
- $P_{max} = 3-5 \text{ m/min.}$
- $N_{max} = 24\,000 \text{ r.p.m.}$



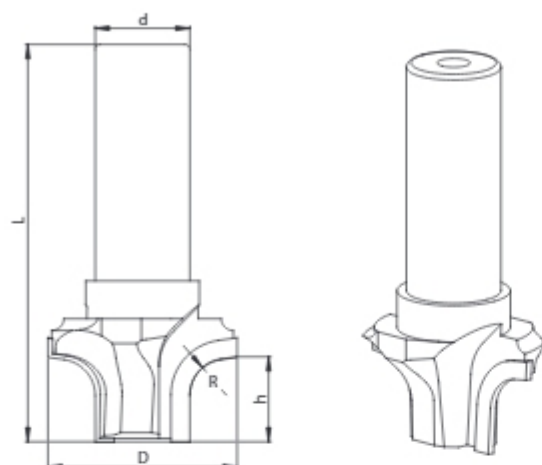
Example profiles.

TPD-18



Catalogue number	Type	D mm	h mm	d mm	D ₁ mm	L mm	H mm	H ₁ mm	α	z	↗	
TPD018.0170	TPD-18	25,40	7,20	12	10,50	60	14,20	12,20	15,6°	2+1	R	+
TPD018.0110	TPD-18	27,40	7,60	16	10,50	63	13,50	7,60	20°	2+1	R	+
TPD018.0070	TPD-18	34,30	10,50	12	29,60	60	20,50			2+1	R	+
TPD018.0050	TPD-18	36,00	7,00	10	32,25	60	14,00	11,00	45°	2+1	R	+
TPD018.0010	TPD-18	37,75	9,15	25	27,85	90	17,80	12,35	20°	2+1	R	+

TPD-20 R or L



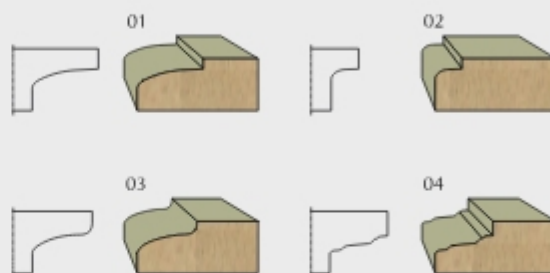
Profile shank cutter type **TPD-20** designed for profiling on CNC machines.

Type of work: profiling.

Material: chipboard, plywood, MDF.

Specification:

- $P_{max} = 8-12$ m/min,
- $N_{max} = 24\,000$ r.p.m.

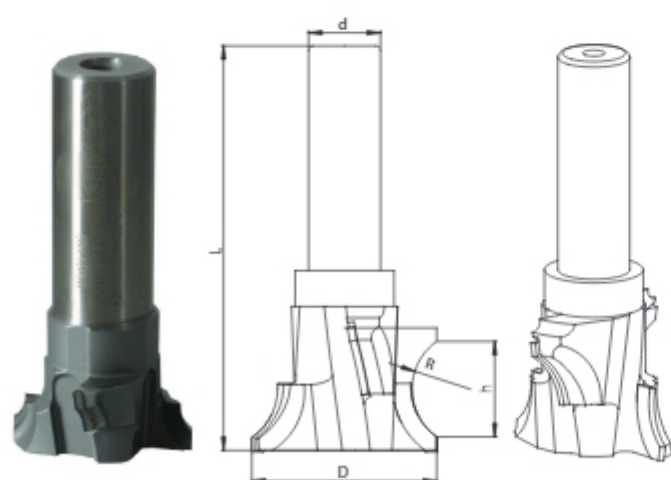


Example profiles.



Type	D mm	h mm	d mm	L mm	R mm	z	n _{max}
TPD-20	42	22	20	75	8	2	18000 +

TPD-30 R or L



Profile shank cutter type **TPD-30** designed for profiling on CNC machines.

Type of work: profiling.

Material: chipboard, plywood, MDF.

Specification:

- $P_{max} = 8-12$ m/min,
- $N_{max} = 24\,000$ r.p.m.



Type	D mm	h mm	d mm	L mm	R mm	z	n _{max}
TPD-30	52	40	25	105	26	4	18000 +

Straight brazed cutter type **FD-01**.

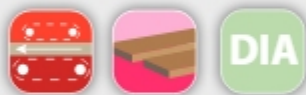
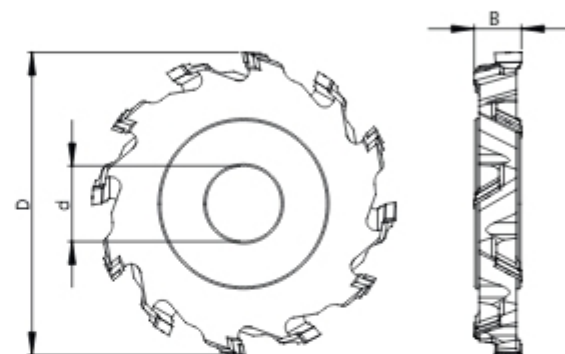
Type of work: formatting.

Material: chipboard, plywood, MDF, HDF.

Specification:

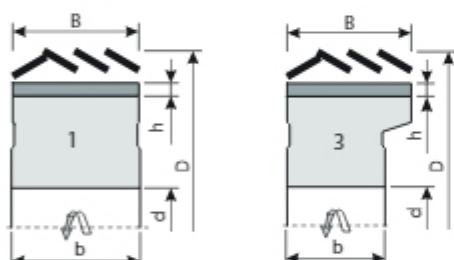
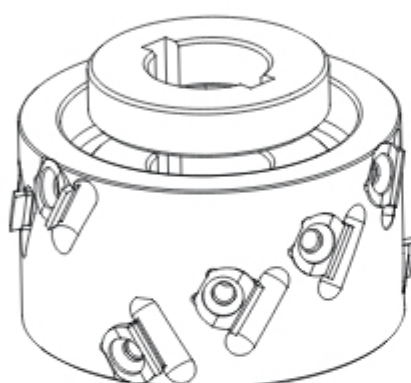
- $P_{max} = 20-30 \text{ m/min}$,
- $N_{max} = 9\,000 \text{ r.p.m.}$

FD-01



Catalogue number	Type	D mm	B mm	d mm	z	n_{max}	
FD01.012	FD-01	50	20	16	4+4	9000	+
FD01.005	FD-01	70	10	20	3+3	9000	+
FD01.0020	FD-01	100	22	25	3+3	9000	+
FD01.030	FD-01	125	8	40	4+4	9000	+
FD01.009	FD-01	125	12	30	6+6	9000	+
FD01.022	FD-01	125	15	30	4+4	9000	+
FD001.0260	FD-01	125	20	30	4+4	9000	+
FD001.0270	FD-01	125	25	30	4+4	9000	+
FD01.011	FD-01	125	28	30	4+4	9000	+
FD01.014	FD-01	125	30	30	4+4	9000	+
FD01.018	FD-01	125	45	30	4+4	9000	+
FD01.002	FD-01	160	15	30	4+4	9000	+
FD01.0026	FD-01	160	15	30	6+6	9000	+
FD001.0230	FD-01	160	17	40	8+8	9000	+
FD001.0280	FD-01	160	20	30	4+4	9000	+
FD001.0290	FD-01	160	25	30	4+4	9000	+
FD001.0100	FD-01	180	10,5	40	8+8	9000	+
FD001.0130	FD-01	180	16	30	4+4	9000	+
FD01.008	FD-01	200	25	30	6+6	9000	+

FDKA



Cutter head **FDKA** with aluminum body and exchangeable inserts. Multi-use aluminum body and exchangeable blades give significantly lower maintenance costs after a couple of life cycles.

Aluminum body results in tool weight lower by 60%. It significantly reduces spindle work load compared to steel body tools. Lower tool weight means also noise reduction and stable machine work.

Type of work: formatting.

Material: veneered chipboard covered with laminate, foil or paper.

Specification:

- $P_{max} = 20-25 \text{ m/min}$,
- $N_{max} = 16\,500 \text{ r.p.m.}$



Cat. number	Type	D mm	B mm	b mm	d mm	z	Nr	n_{max}	
FDKA.0010	FDKA	100	44	40,6	30	3+3	3	16 500	R •
FDKA.0010L	FDKA	100	44	40,6	30	3+3	3	16 500	L •
FDKA.0030	FDKA	125	64	40,6	30	3+3	3	12 500	R •
FDKA.0030L	FDKA	125	64	40,6	30	3+3	3	12 500	L •

Spare parts for cutter heads FDKA

Cat. nr	Name	Dimensions		
PD.FDKA.0010 PD.FDKA.0030	Spacer ring	60 x 13 x 30,1 60 x 34 x 30,1		+
P.FDKA	Insert (not sharpened)	16 x 4		•

Cat. nr	Name	Dimensions		
WHAS00006	Screw TOR 1128	M6x10		•

Additional ring makes cutter more universal.

Option Nr. 1 b=53,6mm with additional ring PD.FDKA.0010 or PD.FDKA.0030.

Straight brazed cutter type **FD-002**, designed for surface formatting on edge banders and formatting machines with mechanical feed. Helically arranged blades, positioned at a big angle guarantee very efficient and high quality machining.

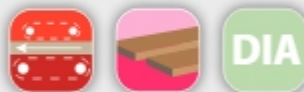
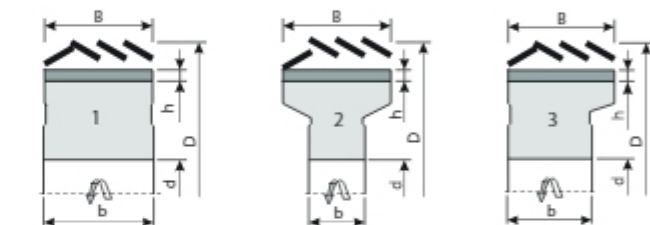
Type of work: formatting.

Material: veneered chipboard covered with laminate, foil or paper.

Specification:

- sharpening zone for DIA = 3 mm is 2 mm,
- sharpening zone for DIA = 5 mm is 4 mm,
- big shear angle guarantees high machining quality,
- $P_{max} = 20-26 \text{ m/min}$,
- $n_{max} = 15\,000 \text{ rpm}$.

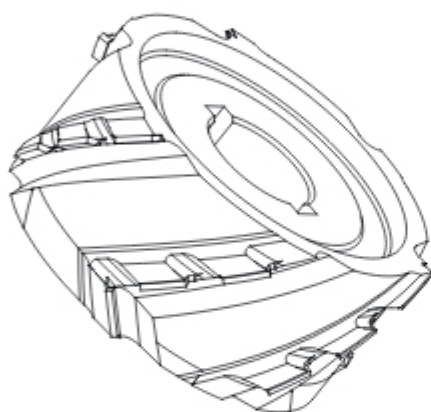
FD-002



Machine	Type	D mm	B mm	b mm	d mm	z	Keyway mm	Nr	DIA h=3mm	DIA h=5mm
IMA/Brandt	FD-002	100	34	37,6	30	3+3	3x8	1	+	+
IMA/Brandt	FD-002	100	43	40,6	30	3+3	3x8	3	+	+
	FD-002	100	43	45	30	3+3	3x8	1	+	+
IMA/Brandt	FD-002	100	48	40,6	30	3+3	3x8	3	+	+
Holzner	FD-002	100	48	25	30	3+3	3x8	2	+	+
	FD-002	100	48	50	30	3+3	3x8	1	+	+
Holzner	FD-002	100	63	25	30	3+3	3x8	2	+	+
Homag	FD-002	125	34	37,6	30	3+3	3x8	1	+	+
Homag	FD-002	125	63	40,6	30	3+3	3x8	2	+	+
IMA	FD-002	125	63	40,6	30	3+3	3x8	3	+	+

Catalogue number	Type	Machine	D mm	B mm	b mm	d mm	z	Nr	DIA h mm	↗
FD002.606425B.2	FD-002	FELDER	60	64	62	25	2+2	2	3	R •
FD002.606425B.2L	FD-002	FELDER	60	64	62	25	2+2	2	3	L •
FD002.1560	FD-002	IMA/Brandt	100	43,5	40,6	30	3+3	3	3	R •
FD002.1560L	FD-002	IMA/Brandt	100	43,5	40,6	30	3+3	3	3	L •
FD002.1561	FD-002	IMA/Brandt	100	43,5	40,6	30	3+3	3	5	R •
FD002.1561L	FD-002	IMA/Brandt	100	43,5	40,6	30	3+3	3	5	L •
FD002.1600	FD-002	IMA/Brandt	100	48	40,6	30	3+3	3	3	R •
FD002.1600L	FD-002	IMA/Brandt	100	48	40,6	30	3+3	3	3	L •
FD002.2100	FD-002	IMA/Brandt	100	63	40,6	30	3+3	3	3	R •
FD002.2100L	FD-002	IMA/Brandt	100	63	40,6	30	3+3	3	3	L •

FD-025



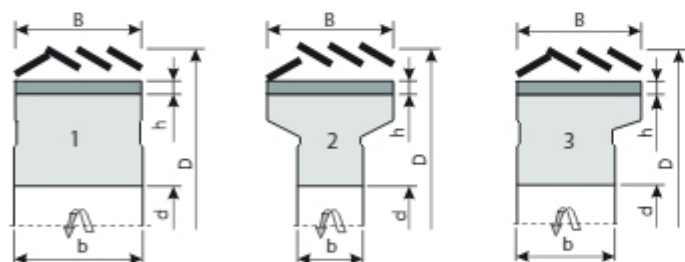
Straight brazed cutter type **FD-025**, designed for surface formatting on edge banders and formatting machines with mechanical feed. Helically arranged blades, positioned at a big angle guarantee very efficient and high quality machining of hard-machinable materials.

Type of work: formatting.

Material: veneered chipboard covered with laminate, foil or paper.

Specification:

- sharpening zone for DIA = 3 mm is 2 mm,
- sharpening zone for DIA = 5 mm is 4 mm,
- **very big shear angle** guarantees high machining quality,
- $P_{max} = 22-26$ m/min
- $N_{max} = 15\,000$ r.p.m.



Machine	Type	D mm	B mm	b mm	d mm	z	Keyway mm	Nr	DIA h=3mm	DIA h=5mm
IMA/Brandt	FD-025	100	34	37,6	30	3+3	3x8	1	+	+
IMA/Brandt	FD-025	100	43	40,6	30	3+3	3x8	3	+	+
IMA/Brandt	FD-025	100	48	40,6	30	3+3	3x8	3	+	+
Holzler	FD-025	100	48	25	30	3+3	3x8	2	+	+
Holzler	FD-025	100	63	25	30	3+3	3x8	2	+	+
Homag	FD-025	125	34	37,6	30	3+3	3x8	1	+	+
Homag	FD-025	125	63	40,6	30	3+3	3x8	2	+	+
IMA	FD-025	125	63	40,6	30	3+3	3x8	3	+	+

Straight brazed cutter type **FD-021**, designed for surface formatting on edge banders and formatting machines with mechanical feed.

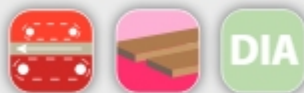
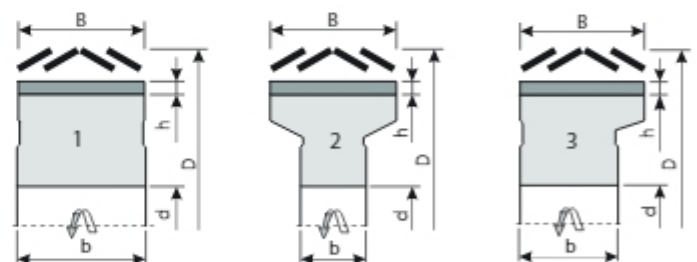
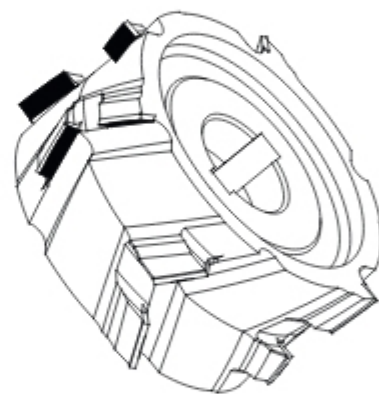
Type of work: formatting.

Material: chipboard, plywood, MDF, HDF.

Specification:

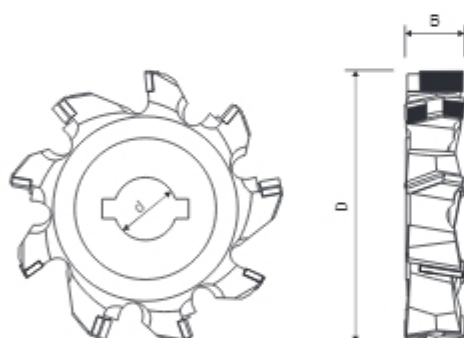
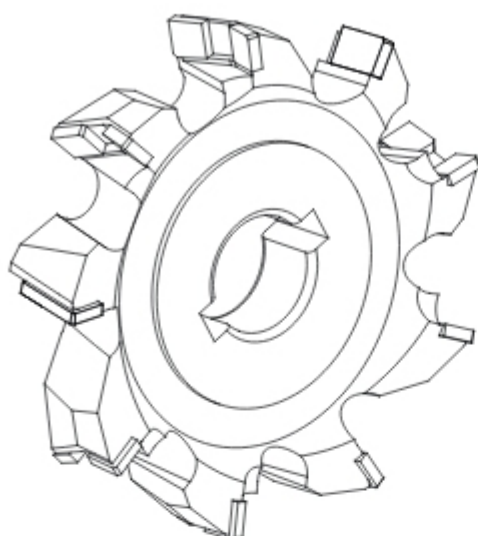
- symmetrically arranged blades,
- $P_{max} = 22-26 \text{ m/min}$,
- $n_{max} = 15\,000 \text{ rpm}$.

FD-021



Machine	Catalogue number	Type	D mm	B mm	b mm	d mm	z	Keyway mm	Nr	
OTT	FD021.0010	FD-021	85	45	45	30	3+3	8x3	1	+
IMA/Brandt	FD021.0020	FD-021	100	34	37,6	30	3+3	8x3	1	+
Holzner	FD021.0030	FD-021	100	48	25	30	3+3	8x3	2	+
IMA/Brandt	FD021.0041	FD-021	100	43,6	40,6	30	3+3	8x3	2	+
Holzner	FD021.0051	FD-021	100	52	25	30	3+3	8x3	2	+
Homag	FD021.0060	FD-021	100	34	37,6	30	3+3	8x3	1	+
Homag	FD021.0180	FD-021	125	43	40,6	30	3+3	8x3	1	+
Homag	FD021.0170	FD-021	125	63	40,6	30	3+3	8x3	2	+

FD-03



Straight brazed cutter type **FD-03**, designed for pre-cutting, before profiling veneered elements

FD-03 cutter is used when thick layer of the removed material does not allow for obtaining high quality edges on edge banders and production lines.

Type of work: pre-cutting.

Material: chipboard, MDF.

Specification:

- $P_{max} = 18 \text{ m/min}$,
- $N_{max} = 9\,000 \text{ r.p.m.}$



Catalogue number	Type	D mm	B mm	d mm	z	n_{max}	
FD003.0010	FD-03	70	15	16	9+3+3	9000	+
FD003.0020	FD-03	70	25	20	9+3+3	9000	+

Set of straight brazed cutters type **ZFD-01** designed for formatting machines.

Type of work: formatting.

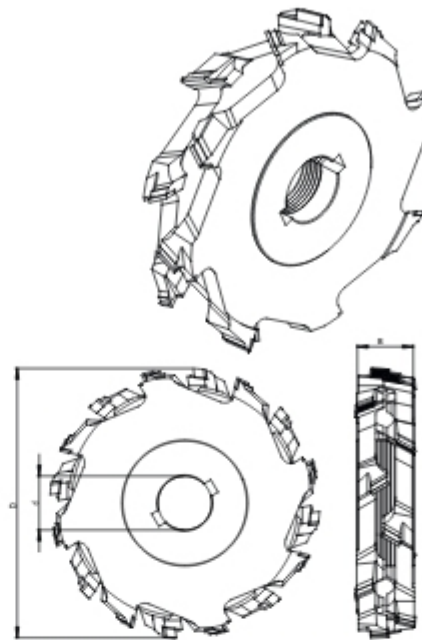
Material: chipboard, plywood, MDF, HDF.

Specification:

- variable sharpening zone,
- machining materials with various width,
- $P_{max} = 35 \text{ m/min}$,
- $N_{max} = 9\,000 \text{ r.p.m.}$



ZFD-01



Catalogue number	Type	D mm	B mm	d mm	z	n_{max}	
ZFD001.0060	ZFD-01	120	24÷36	30	6+6	9000	+
ZFD01.001	ZFD-01	125	24÷36	30	6+6	9000	+
ZFD001.0040	ZFD-01	125	24÷45	30	6+6	9000	+
ZFD01.003	ZFD-01	140	34÷60	30	6+6	9000	+
ZFD001.0070	ZFD-01	160	24÷36	30	6+6	9000	+

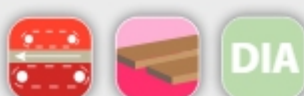
Set of straight brazed cutters type **ZFD-02** designed for formatting machines.

Type of work: formatting.

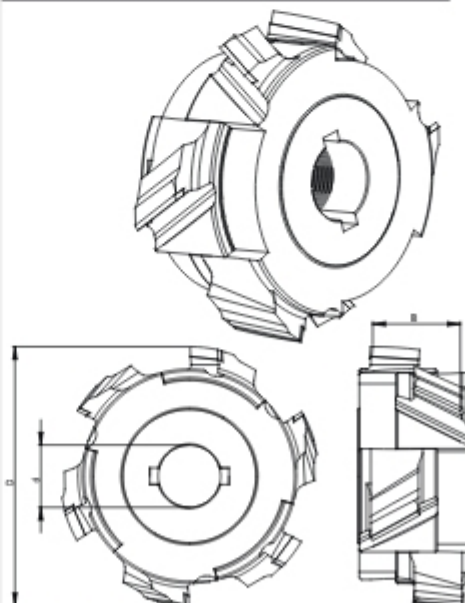
Material: chipboard, plywood, MDF, HDF.

Specification:

- variable sharpening zone,
- machining materials with various width,
- $P_{max} = 20\text{-}25 \text{ m/min}$,
- $N_{max} = 9\,000 \text{ r.p.m.}$

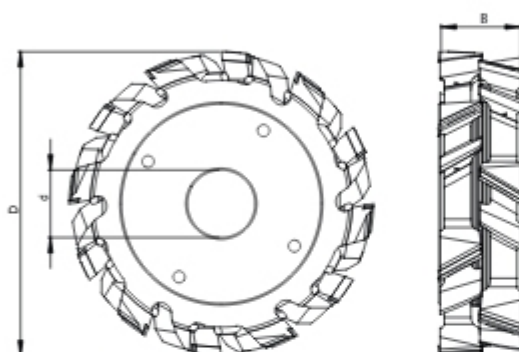
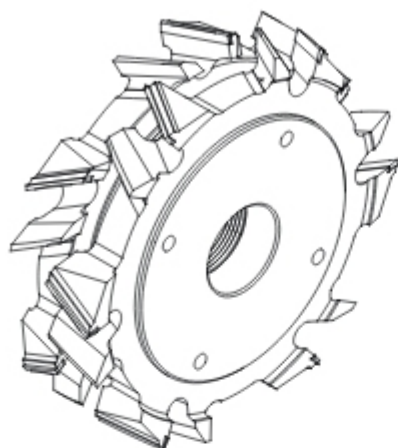


ZFD-02



Catalogue number	Type	D mm	B mm	d mm	z	n_{max}	
ZFD02.020	ZFD-02	120	24÷36	30	3+3	9000	+
ZFD02.021	ZFD-02	125	24÷36	30	3+3	9000	+
ZFD02.022	ZFD-02	125	24÷45	30	3+3	9000	+

ZFD-002



Set of straight brazed cutters type **ZFD-01** designed for formatting machines.

Type of work: formatting.

Material: chipboard, plywood, MDF, HDF.

Specification:

- optionally offered with anti-kickback system and blade protection against removed material,
- machining materials with various width possible thanks to axial regulation of working part width,
- very long life of tools thanks to variable cutting points zone,
- $P_{max} = 30 \text{ m/min.}$
- $N_{max} = 6\,000 \text{ r.p.m.}$



Catalogue number	Type	D mm	B mm	d mm	z	n_{max}	
ZFD002.2010	ZFD-002	180	22÷32	30	4+4	6000	+
ZFD002.2020	ZFD-002	180	24÷36	30	4+4	6000	+
ZFD002.2030	ZFD-002	180	34÷42	30	4+4	6000	+
ZFD002.2040	ZFD-002	180	22÷32	40	4+4	6000	+
ZFD002.2050	ZFD-002	180	24÷36	40	4+4	6000	+
ZFD002.2060	ZFD-002	180	34÷42	40	4+4	6000	+

Profile brazed cutters type **FPD-102** right or left designed for profiling machines.

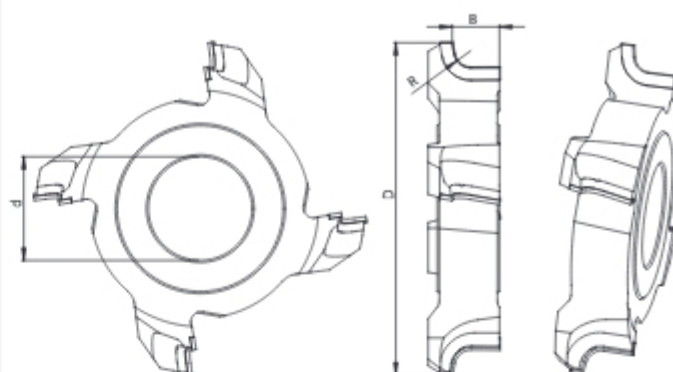
Type of work: profiling.

Material: chipboard, plywood, MDF.

Specification:

- $P_{max} = 25 \text{ m/min}$,
- $N_{max} = 9\,000 \text{ r.p.m.}$

FPD-102 R or L



Catalogue number	Type	D mm	B mm	R mm	d mm	z	n_{max}	
FPD102.0020L	FPD-102	160	30	10	35	4	9000	+
FPD102.0030L	FPD-102	160	30	12	35	4	9000	+
FPD102.0040L	FPD-102	160	30	14	35	4	9000	+
FPD102.0050L	FPD-102	160	30	16	35	4	9000	+

Profile brazed cutters type **FPD-116** right or left designed for profiling machines.

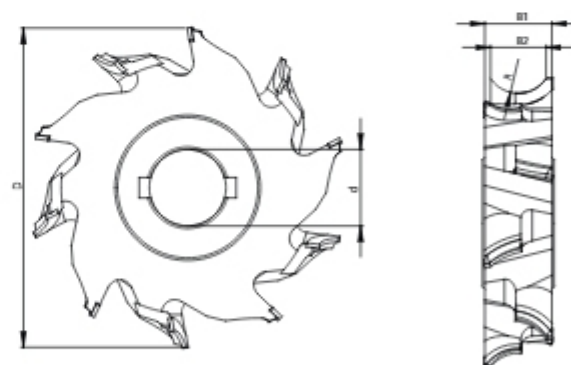
Type of work: profiling.

Material: chipboard, plywood, MDF.

Specification:

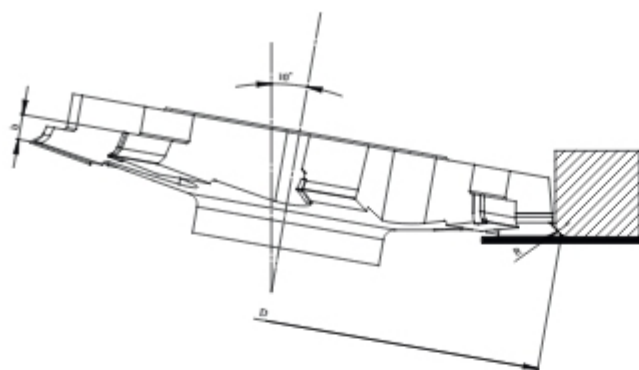
- $P_{max} = 18\text{--}25 \text{ m/min}$,
- $N_{max} = 9\,000 \text{ r.p.m.}$

FPD-116



Catalogue number	Type	D mm	B ₁ mm	B ₂ mm	R mm	d mm	z	n_{max}	
FPD116.0020	FPD-116	100	30	26	18	30	4+4	9000	+
FPD116.0090	FPD-116	125	56	40	20	30	3+3	9000	+
FPD116.0010	FPD-116	160	18	17	9	35	6+6	9000	+
FPD116.0500	FPD-116	180	30	24	16	35	4+4	9000	+
FPD116.0510	FPD-116	180	48	40	25	35	4+4	9000	+
FPD116.0520	FPD-116	180	64	56	35	35	4+4	9000	+

FPD-300



Profile brazed cutters **FPD-300** with PCD blades.

Type of work: postforming.

Material: chipboard, plywood, MDF.

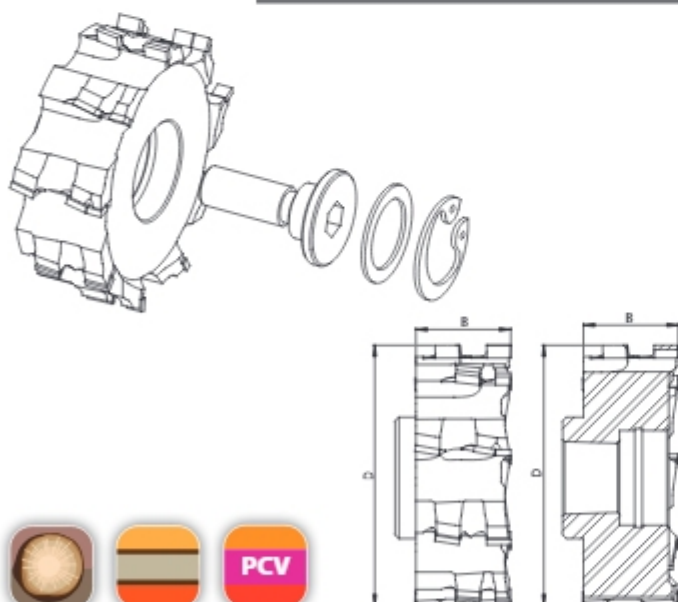
Specification:

- for Homag and IMA machines,
- $P_{max} = 25 \text{ m/min}$,
- $N_{max} = 9\,000 \text{ r.p.m.}$



Catalogue number	Type	D mm	R mm	d mm	z	
FPD300.3010	FPD-300	180	3	35	4+4	+
FPD300.3020	FPD-300	180	4	35	4+4	+
FPD300.3030	FPD-300	180	5	35	4+4	+
FPD300.3040	FPD-300	180		35	4+4	+
FPD300.3050	FPD-300	200		35	4+4	+

FD-500



Profile brazed cutters **FD-500** designed for edge beveling.

Type of work: edge machining.

Material: solid hardwood, veneered board, plastics.

Specification:

- for Homag and IMA machines,
- safety ring HSK25R guarantees minimum radial runout and precise balancing of the tools for optimal cutting quality,
- blade with shear angle,
- $N_{max} = 18\,000 \text{ r.p.m.}$



Catalogue number	Type	D mm	B mm	d mm	z	n_{max}	
FD500.0130	FD-500	70	20	HSK25	9+3+3	18000	+
FD500.0101	FD-500	70	50	HSK25	9+3+3+3	18000	+
FD500.0101L	FD-500	70	50	HSK25	9+3+3+3	18000	+
FD500.0110P	FD-500	75	22	20	12+4	18000	+
FD500.0110	FD-500	75	22	20	12+4	18000	+
FD500.0140L	FD-500	75	25	HSK25	12+4	18000	+

Profile brazed cutters **FPD-501** designed for edge milling

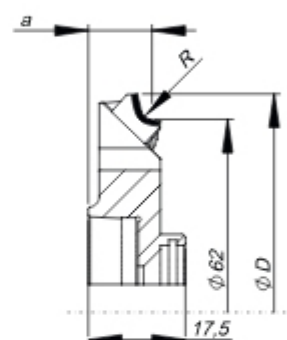
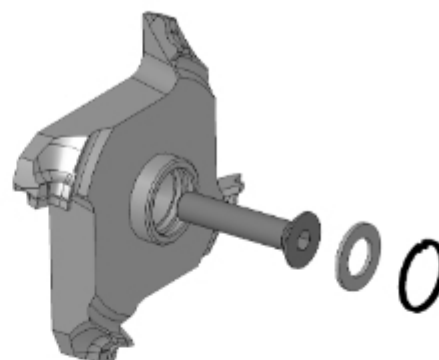
Type of work: edge rounding

Material: solid hardwood, veneered board, edging from plastics

Specification:

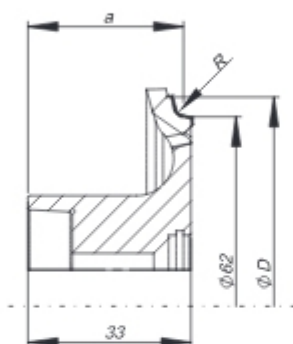
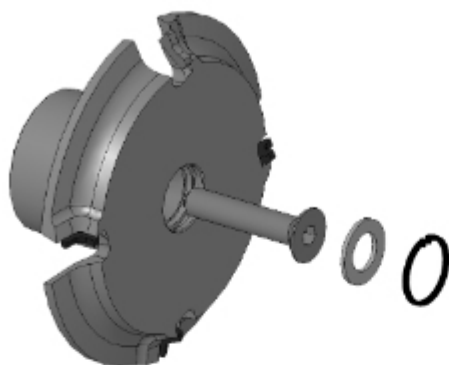
- for Homag machines
- safety ring HSK32 guarantees minimum radial runout and precise balancing of the tools for optimal cutting quality
- blade with shear angle
- $N_{max} = 18\,000$ r.p.m.

FPD-501



Catalogue number	D mm	R mm	a mm	d mm	z	n_{max}	↕	
FPD501.0010.4	68,1	1,0	11,5	HSK32	4	18000	R	+
FPD501.0010.4L	68,1	1,0	11,5	HSK32	4	18000	L	+
FPD501.0015.4	68,1	1,5	11,5	HSK32	4	18000	R	+
FPD501.0015.4L	68,1	1,5	11,5	HSK32	4	18000	L	+
FPD501.0020.4	71,2	2,0	11,5	HSK32	4	18000	R	+
FPD501.0020.4L	71,2	2,0	11,5	HSK32	4	18000	L	+
FPD501.0025.4	71,2	2,5	11,5	HSK32	4	18000	R	+
FPD501.0025.4L	71,2	2,5	11,5	HSK32	4	18000	L	+
FPD501.0030.4	71,2	3,0	11,5	HSK32	4	18000	R	+
FPD501.0030.4L	71,2	3,0	11,5	HSK32	4	18000	L	+
FPD501.0010.6	68,1	1,0	11,5	HSK32	6	18000	R	+
FPD501.0010.6L	68,1	1,0	11,5	HSK32	6	18000	L	+
FPD501.0015.6	68,1	1,5	11,5	HSK32	6	18000	R	+
FPD501.0015.6L	68,1	1,5	11,5	HSK32	6	18000	L	+
FPD501.0020.6	71,2	2,0	11,5	HSK32	6	18000	R	+
FPD501.0020.6L	71,2	2,0	11,5	HSK32	6	18000	L	+
FPD501.0025.6	71,2	2,5	11,5	HSK32	6	18000	R	+
FPD501.0025.6L	71,2	2,5	11,5	HSK32	6	18000	L	+
FPD501.0030.6	71,2	3,0	11,5	HSK32	6	18000	R	+
FPD501.0030.6L	71,2	3,0	11,5	HSK32	6	18000	L	+

FPD-502



Profile brazed cutters **FPD-502** designed for edge milling

Type of work: edge rounding

Material: solid hardwood, veneered board, edging from plastics

Specification:

- for Homag machines
- safety ring HSK32 guarantees minimum radial runout and precise balancing of the tools for optimal cutting quality
- blade with shear angle
- optimal chip flow
- $N_{max} = 18\,000$ r.p.m.



Catalogue number	D mm	R mm	a mm	d mm	z	n_{max}		
FPD502.0010.4	74	1,0	31,5	HSK32	4	18000	R	+
FPD502.0010.4L	74	1,0	31,5	HSK32	4	18000	L	+
FPD502.0015.4	74	1,5	31,5	HSK32	4	18000	R	+
FPD502.0015.4L	74	1,5	31,5	HSK32	4	18000	L	+
FPD502.0020.4	74	2,0	31,5	HSK32	4	18000	R	+
FPD502.0020.4L	74	2,0	31,5	HSK32	4	18000	L	+
FPD502.0025.4	74	2,5	31,5	HSK32	4	18000	R	+
FPD502.0025.4L	74	2,5	31,5	HSK32	4	18000	L	+
FPD502.0030.4	74	3,0	31,5	HSK32	4	18000	R	+
FPD502.0030.4L	74	3,0	31,5	HSK32	4	18000	L	+
FPD502.0010.6	74	1,0	31,5	HSK32	6	18000	R	+
FPD502.0010.6L	74	1,0	31,5	HSK32	6	18000	L	+
FPD502.0015.6	74	1,5	31,5	HSK32	6	18000	R	+
FPD502.0015.6L	74	1,5	31,5	HSK32	6	18000	L	+
FPD502.0020.6	74	2,0	31,5	HSK32	6	18000	R	+
FPD502.0020.6L	74	2,0	31,5	HSK32	6	18000	L	+
FPD502.0025.6	74	2,5	31,5	HSK32	6	18000	R	+
FPD502.0025.6L	74	2,5	31,5	HSK32	6	18000	L	+
FPD502.0030.6	74	3,0	31,5	HSK32	6	18000	R	+
FPD502.0030.6L	74	3,0	31,5	HSK32	6	18000	L	+

Profile brazed cutters **FPD-503** designed for edge milling

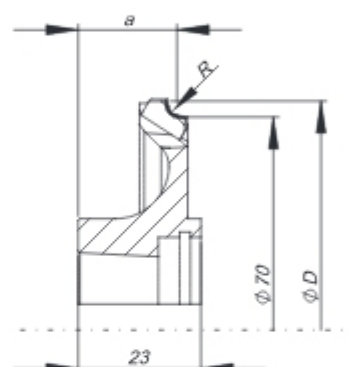
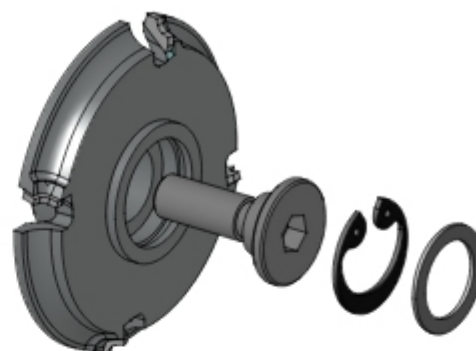
Type of work: edge rounding

Material: solid hardwood, veneered board, edging from plastics

Specification:

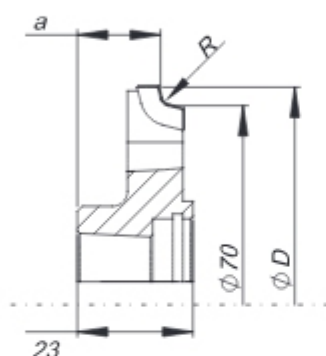
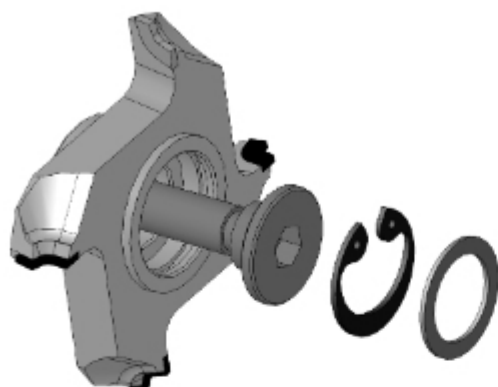
- for Homag, IMA machines
- safety ring HSK25 guarantees minimum radial runout and precise balancing of the tools for optimal cutting quality
- blade with shear angle
- $N_{max} = 24\,000$ r.p.m.

FPD-503



Catalogue number	D mm	R mm	a mm	d mm	z	n_{max}		
FPD503.0010.4	74	1,0	17,5	HSK25	4	24000	R	+
FPD503.0010.4L	74	1,0	17,5	HSK25	4	24000	L	+
FPD503.0015.4	76	1,5	18,0	HSK25	4	24000	R	+
FPD503.0015.4L	76	1,5	18,0	HSK25	4	24000	L	+
FPD503.0020.4	76	2,0	18,5	HSK25	4	24000	R	+
FPD503.0020.4L	76	2,0	18,5	HSK25	4	24000	L	+
FPD503.0025.4	78	2,5	19,0	HSK25	4	24000	R	+
FPD503.0025.4L	78	2,5	19,0	HSK25	4	24000	L	+
FPD503.0030.4	78	3,0	19,5	HSK25	4	24000	R	+
FPD503.0030.4L	78	3,0	19,5	HSK25	4	24000	L	+
FPD503.0010.6	74	1,0	17,5	HSK25	6	24000	R	+
FPD503.0010.6L	74	1,0	17,5	HSK25	6	24000	L	+
FPD503.0015.6	76	1,5	18,0	HSK25	6	24000	R	+
FPD503.0015.6L	76	1,5	18,0	HSK25	6	24000	L	+
FPD503.0020.6	76	2,0	18,5	HSK25	6	24000	R	+
FPD503.0020.6L	76	2,0	18,5	HSK25	6	24000	L	+
FPD503.0025.6	78	2,5	19,0	HSK25	6	24000	R	+
FPD503.0025.6L	78	2,5	19,0	HSK25	6	24000	L	+
FPD503.0030.6	78	3,0	19,5	HSK25	6	24000	R	+
FPD503.0030.6L	78	3,0	19,5	HSK25	6	24000	L	+

FPD-504



Profile brazed cutters **FPD-504** designed for edge milling

Type of work: edge rounding

Material: solid hardwood, veneered board, edging from plastics

Specification:

- for Homag, IMA machines
- safety ring HSK25 guarantees minimum radial runout and precise balancing of the tools for optimal cutting quality
- blade with shear angle
- optimal chip flow
- $N_{max} = 24\,000$ r.p.m.



Catalogue number	D mm	R mm	a mm	d mm	z	n _{max}	↕	
FPD504.0010.4	75,1	1,0	16,5	HSK25	4	24000	R	+
FPD504.0010.4L	75,1	1,0	16,5	HSK25	4	24000	L	+
FPD504.0015.4	76,1	1,5	16,5	HSK25	4	24000	R	+
FPD504.0015.4L	76,1	1,5	16,5	HSK25	4	24000	L	+
FPD504.0020.4	77,5	2,0	16,5	HSK25	4	24000	R	+
FPD504.0020.4L	77,5	2,0	16,5	HSK25	4	24000	L	+
FPD504.0025.4	78,1	2,5	16,5	HSK25	4	24000	R	+
FPD504.0025.4L	78,1	2,5	16,5	HSK25	4	24000	L	+
FPD504.0030.4	78,8	3,0	16,5	HSK25	4	24000	R	+
FPD504.0030.4L	78,8	3,0	16,5	HSK25	4	24000	L	+
FPD504.0010.6	75,1	1,0	16,5	HSK25	6	24000	R	+
FPD504.0010.6L	75,1	1,0	16,5	HSK25	6	24000	L	+
FPD504.0015.6	76,1	1,5	16,5	HSK25	6	24000	R	+
FPD504.0015.6L	76,1	1,5	16,5	HSK25	6	24000	L	+
FPD504.0020.6	77,5	2,0	16,5	HSK25	6	24000	R	+
FPD504.0020.6L	77,5	2,0	16,5	HSK25	6	24000	L	+
FPD504.0025.6	78,1	2,5	16,5	HSK25	6	24000	R	+
FPD504.0025.6L	78,1	2,5	16,5	HSK25	6	24000	L	+
FPD504.0030.6	78,8	3,0	16,5	HSK25	6	24000	R	+
FPD504.0030.6L	78,8	3,0	16,5	HSK25	6	24000	L	+

Profile brazed cutters **FD-505** designed for edge milling

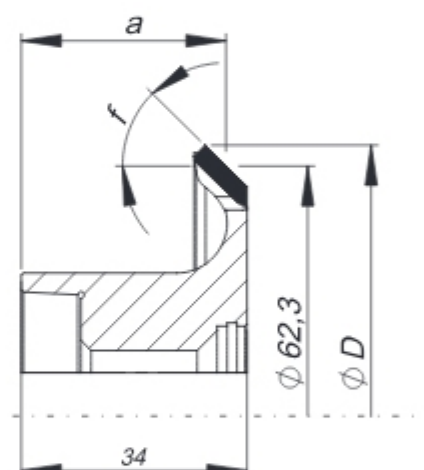
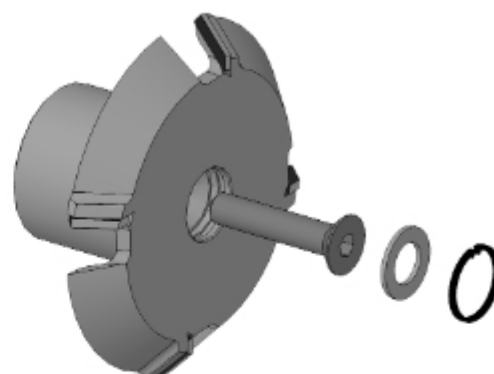
Type of work: edging

Material: solid hardwood, veneered board, edging from plastics

Specification:

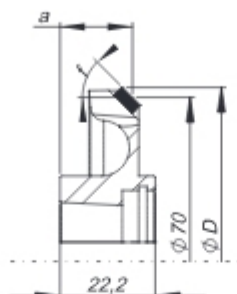
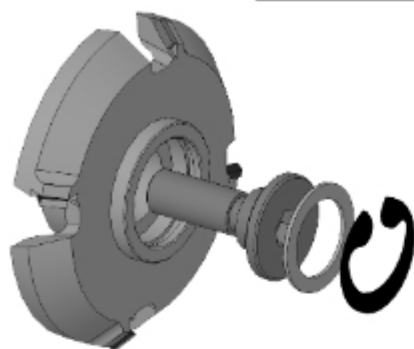
- for Homag machines
- safety ring HSK32 guarantees minimum radial runout and precise balancing of the tools for optimal cutting quality
- blade with shear angle
- optimal chip flow
- $N_{max} = 18\,000$ r.p.m.

FD-505



Catalogue number	D mm	f (chamfer)	a mm	d mm	z	n_{max}		
FD505.0200.4	65,1	20°	31,5	HSK32	4	18000	R	+
FD505.0200.4L	65,1	20°	31,5	HSK32	4	18000	L	+
FD505.0450.4	70	45°	31,5	HSK32	4	18000	R	+
FD505.0450.4L	70	45°	31,5	HSK32	4	18000	L	+
FD505.0200.6	65,1	20°	31,5	HSK32	6	18000	R	+
FD505.0200.6L	65,1	20°	31,5	HSK32	6	18000	L	+
FD505.0450.6	70	45°	31,5	HSK32	6	18000	R	+
FD505.0450.6L	70	45°	31,5	HSK32	6	18000	L	+

FD-506



Profile brazed cutters **FD-506** designed for edge milling

Type of work: edging

Material: solid hardwood, veneered board, edging from plastics

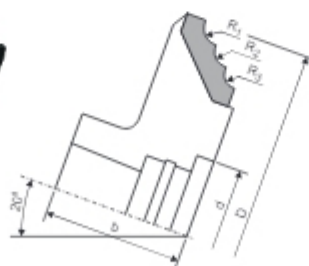
Specification:

- for Homag, IMA machines
- safety ring HSK25 guarantees minimum radial runout and precise balancing of the tools for optimal cutting quality
- blade with shear angle
- optimal chip flow
- $N_{max} = 24\,000$ r.p.m.



Catalogue number	D mm	f (chamfer)	a mm	d mm	z	n _{max}	↗	
FD506.0200.4	73	20°	16,5	HSK25	4	24000	R	+
FD506.0200.4L	73	20°	16,5	HSK25	4	24000	L	+
FD506.0450.4	73	45°	17,5	HSK25	4	24000	R	+
FD506.0450.4L	73	45°	17,5	HSK25	4	24000	L	+
FD506.0200.6	73	20°	16,5	HSK25	6	24000	R	+
FD506.0200.6L	73	20°	16,5	HSK25	6	24000	L	+
FD506.0450.6	73	45°	17,5	HSK25	6	24000	R	+
FD506.0450.6L	73	45°	17,5	HSK25	6	24000	L	+

FPD-550 L



Profile brazed cutters **FPD-550 L** designed for edge bevelling.

Type of work: edge machining.

Material: solid hardwood, veneered board, plastics.

Specification:

- for Homag and IMA machines,
- safety ring HSK25R guarantees minimum radial runout and precise balancing of the tools for optimal cutting quality,
- blade with shear angle,
- $N_{max} = 18\,000$ r.p.m.



Catalogue number	Type	D mm	R ₁ mm	R ₂ mm	R ₃ mm	z	
FPD550.0010	FPD-550	81,1	1,5	2,0	3,0	HSK25	4 +
FPD550.0020	FPD-550	81,1	1,5	2,0	3,0	HSK25	6 +
FPD550.0110	FPD-550	81,1	3,0	2,0		HSK25	4 +
FPD550.0120	FPD-550	81,1	3,0	2,0		HSK25	6 +

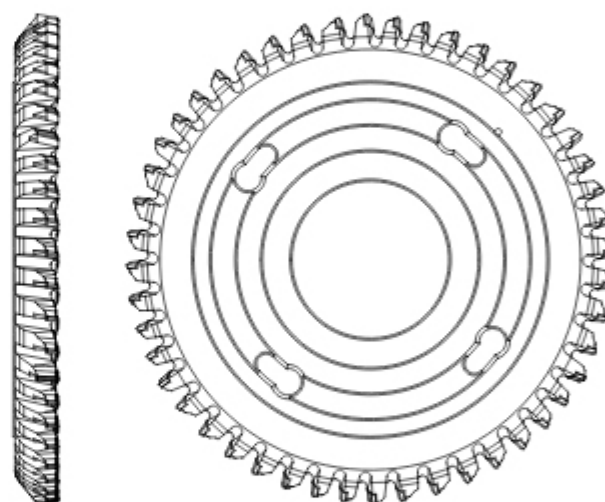
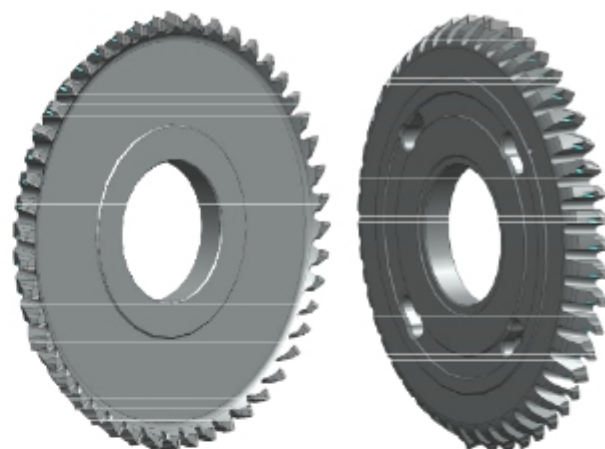
Inserted hogger type **GFD-011** with radial tooth shape, irregular pitch, new cutting geometry and negative hook angle guarantees highest edge quality.

Material: chipboard and MDF – raw or covered with laminate, foil and paper as well as low-density furniture board (not suitable for veneered board)

Specification:

- for Homag, IMA and IDM machines,
- high cutting quality thanks to precise positioning,
- increased life,
- concurrent working system cutter head / cutter head,
- tip height 6 mm,
- $N_{max} = 9\,000$ r.p.m.

GFD-011



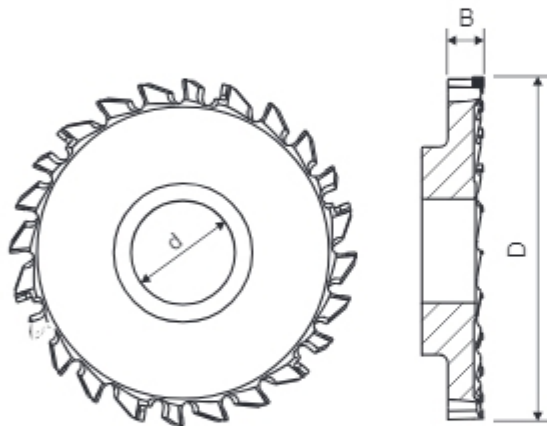
Catalogue number	Type	D mm	B mm	b mm	d mm	z	DIA mm	n _{max}	↙	
GFD011.0040	GFD-011	250	23	11	80	48 (42+6)	6	9000	P	•
GFD011.0040L	GFD-011	250	23	11	80	48 (42+6)	6	9000	L	•
GFD011.0041	GFD-011	250	23	11	60	48 (42+6)	6	9000	P	•
GFD011.0041L	GFD-011	250	23	11	60	48 (42+6)	6	9000	L	•
GFD011.0030	GFD-011	250	23	11	80	36 (30+6)	6	9000	P	•
GFD011.0030L	GFD-011	250	23	11	80	36 (30+6)	6	9000	L	•
GFD011.0031	GFD-011	250	23	11	60	36 (30+6)	6	9000	P	•
GFD011.0031L	GFD-011	250	23	11	60	36 (30+6)	6	9000	L	•

GFD-02

Inserted hogger type **GFD-02** designed for drawer band production.

Specification:

- shear angle increases tool life and reduces noise,
- sharpening zone 4,5 mm,
- $N_{max} = 9\,000$ r.p.m.



Type	D mm	B mm	d mm	z	n_{max}	
GFD-02	200	20	60	24+6+6	9000	+
GFD-02	200	22	80	24+6+6	9000	+
GFD-02	250	20	60	32+8+8	9000	+
GFD-02	250	22	80	32+6+6	9000	+
GFD-02	260	20	60	36+9+9	9000	+
GFD-02	280	20	60	40+10+10	9000	+

Inserted hogger FINISH-LINE type **GFD-05**.

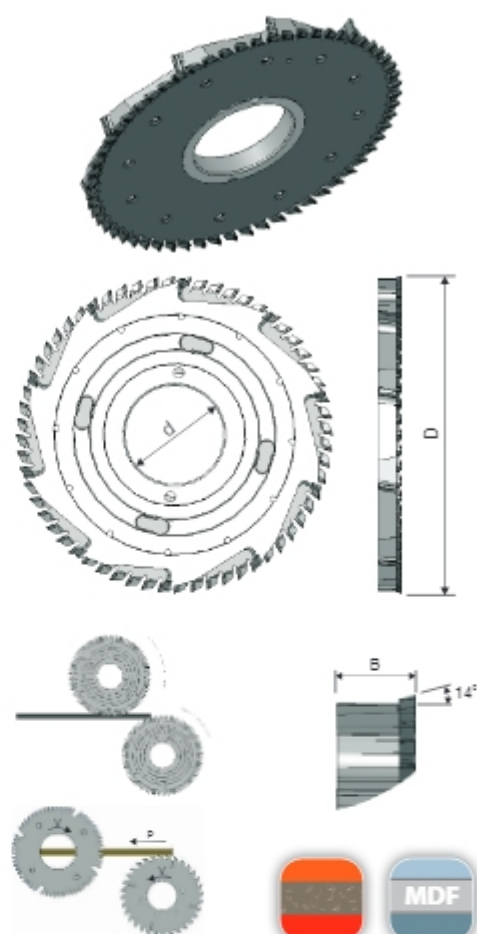
Type of work: formatting.

Material: chipboard, MDF, HDF.

Specification:

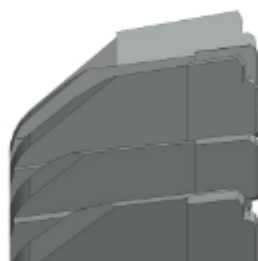
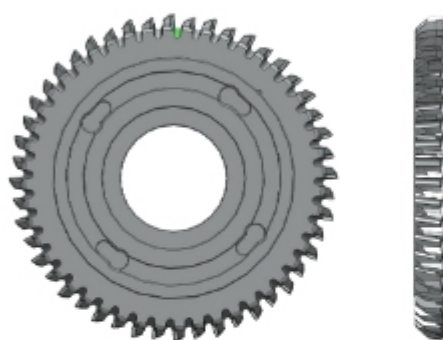
- for Homag, IMA and IDM machines,
- very aggressive blade geometry guarantees highest quality cutting,
- concurrent working system cutter head / cutter head,
- scorer / cutter head working system,
- sharpening zone 4,5 mm,
- shear angle guarantees quiet and stable work,
- $N_{max} = 6\ 000$ r.p.m.

GFD-05



Catalogue number	Type	D mm	B mm	d mm	z	↗	
GFD05.007	GFD-05	200	22	35	24+4	R	+
GFD05.007L	GFD-05	200	22	35	24+4	L	+
GFD05.003P	GFD-05	250	18	80	56+6x4	R	+
GFD05.009	GFD-05	250	20	35	36+6	R	+
GFD05.009L	GFD-05	250	20	35	36+6	L	+
GFD05.003	GFD-05	250	20	80	56+6x4	R	+
GFD05.003L	GFD-05	250	20	80	56+6x4	L	+
GFD05.011	GFD-05	255	19	80	60+10	R	+
GFD05.011L	GFD-05	255	19	80	60+10	L	+
GFD05.015	GFD-05	255	19	80	60+10	R (GT)	+
GFD05.015L	GFD-05	255	19	80	60+10	R (GW)	+
GFD05.006	GFD-05	255	19	80	66+10	R	+
GFD.006L	GFD-05	255	19	80	66+10	L	+
GFD05.0070	GFD-05	255	32,33	60	48+4	R	+
GFD05.0070L	GFD-05	255	32,33	60	48+4	L	+
	GFD-05	250	14,5	60	48		+
	GFD-05	250	14,5	80	48		+
	GFD-05	250	14,5	60	54		+
	GFD-05	250	14,5	80	54		+
	GFD-05	250	14,5	60	60		+
	GFD-05	250	14,5	80	60		+

GFD-09



Inserted hogger type **GFD-09**

Type of work: formatting

Material: chipboard, MDF, HDF

Specification:

- for Homag, IMA and IDM machines
- long life thanks to special blade construction
- optimal tooth shape allows for soft formatting before final finishing
- high cutting quality thanks to precise positioning
- minimum machine retooling time thanks to increased life
- maximum thickness of the formatted element 60 mm
- concurrent working system cutter head / cutter head
- scorer / cutter head working system
- shear angle increases tool life
- sharpening zone 4,5 mm
- $N_{max} = 6\,000$ r.p.m.



Catalogue number	Type	D mm	B mm	d mm	z	z		
GFD009.0500	GFD-09	250	10,5	60	36	6000	R	+
GFD009.0500L	GFD-09	250	10,5	60	36	6000	L	+
GFD009.0510	GFD-09	250	10,5	60	48	6000	R	+
GFD009.0510L	GFD-09	250	10,5	60	48	6000	L	+
GFD009.0520	GFD-09	250	10,5	60	60	6000	R	+
GFD009.0520L	GFD-09	250	10,5	60	60	6000	L	+
GFD009.0530	GFD-09	250	10,5	80	36	6000	R	+
GFD009.0530L	GFD-09	250	10,5	80	36	6000	L	+
GFD009.0540	GFD-09	250	10,5	80	48	6000	R	+
GFD009.0540L	GFD-09	250	10,5	80	48	6000	L	+
GFD009.0550	GFD-09	250	10,5	80	60	6000	R	+
GFD009.0550L	GFD-09	250	10,5	80	60	6000	L	+

Inserted hogger type **GFD-08** with trapezoidal tooth shape.

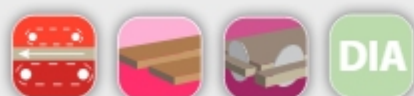
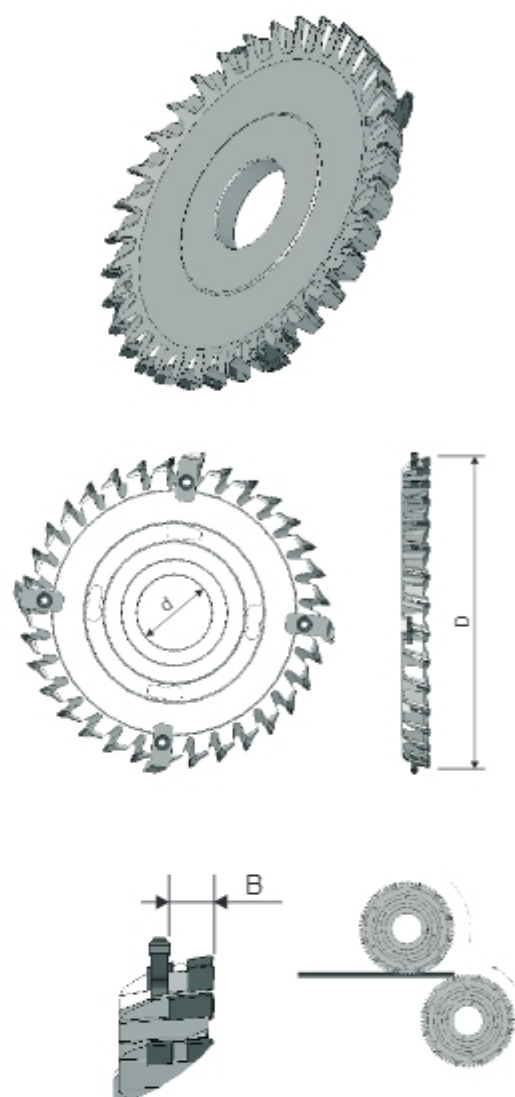
Type of work: formatting, cross and longitudinal cutting.

Material: chipboard, MDF, HDF.

Specification:

- for Homag, IMA and IDM machines,
- special construction allows for very soft formatting of long elements with high excess material,
- high cutting quality thanks to precise positioning,
- minimum machine retooling time thanks to increased life,
- maximum thickness of formatted element 50 mm,
- concurrent working system cutter head / cutter head,
- scorer / cutter head working system,
- shear angle increases tool life,
- sharpening zone 4,5 mm,
- $N_{max} = 6\,000$ r.p.m.

GFD-008

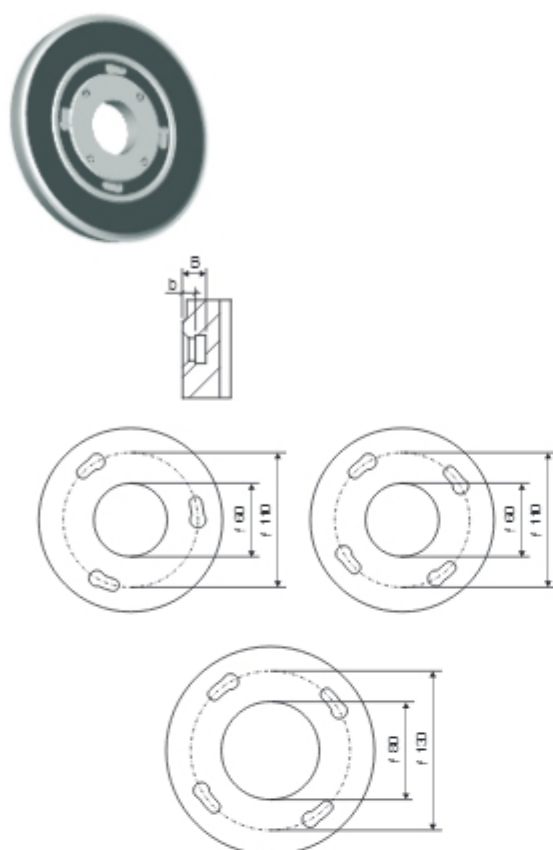


Type	D mm	B mm	d mm	z	
GFD-008	250	10	60	33+11	+
GFD-008	250	10	80	33+11	+
GFD-008	250	10	60	48+12	+
GFD-008	250	10	80	48+12	+
GFD-008	250	10	60	36+6	+
GFD-008	250	10	80	36+6	+

UGF-01

Fast mounting system type **UGF-01** designed for machines with hydraulic clamping.

Orders for cutter heads and brazed cutters equipped with this system should look as follows: GFD-03 + UGF-01.



Type	D mm	d mm	N	
UGF-01	110	60	3	+
UGF-01	110	60	4	+
UGF-01	130	80	4	+

Scoring saw blade with polycrystalline diamond (PCD) with straight teeth (GM) type **PD-403**, designed for cutting homogenous materials without impurities, used on automatic lines with pneumatic clamping systems.

Type of cut: cross and longitudinal.

Material: laminated chipboard, MDF, HDF.



PD-403



Type	D mm	B mm	d mm	z		
PD-403	180	3,2	50	36	GM	+
PD-403	180	3,2	50	48	GM	+
PD-403	200	3,2	50	36	GM	+
PD-403	200	3,2	50	48	GM	+
PD-403	200	3,2	50	60	GM	+

Scoring and formatting saw blade with straight (GM) or top bevel (GW or GT) teeth type **PD-404**, with polycrystalline diamond (PCD) tips designed for cutting homogenous materials without impurities, used on automatic lines, mounted on sleeves.

Type of cut: cross and longitudinal.

Material: laminated chipboard, MDF, HDF.



PD-404



Type	D mm	B mm	b mm	d mm	z	nx _{d1}	D ₁	
PD-404	180	3,2	2,2	65	32	6x6,5	90	+
PD-404	180	3,2	2,2	65	48	6x6,5	90	+
PD-404	180	4,0	2,2	65	32	6x6,5	90	+
PD-404	180	4,0	2,2	65	48	6x6,5	90	+
PD-404	200	3,2	2,2	80	32	4x6,5	140	+
PD-404	200	3,2	2,2	80	48	4x6,5	140	+
PD-404	200	4,0	3,0	80	32	4x6,5	140	+
PD-404	200	4,0	3,0	80	48	4x6,5	140	+

PD-405



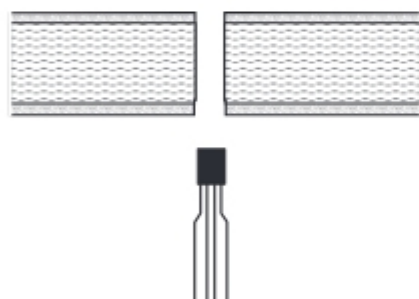
Set of scoring saw blades type **PD-405** with adjustable width, polycrystalline diamond (PCD) tips and straight teeth - GM.

Type of cut: scoring.

Material: laminated chipboard, laminates, MDF, HDF.

Width is regulated with the following spacers:

- 0,05 mm - 1 pc.
- 0,1 mm - 1 pc.
- 0,2 mm - 2 pcs.
- 0,3 mm - 1 pc.



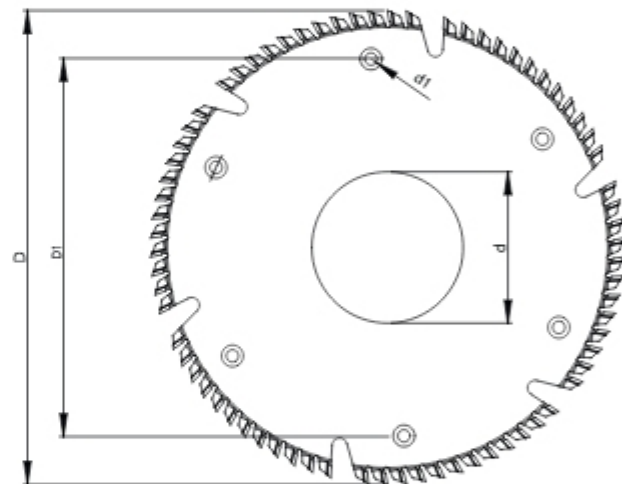
Catalogue number	Type	D mm	B mm	d mm	z		DIA mm	
D4050008	PD-405	100	2,8÷3,6	20	2x10	GM	4,9	+
D4050010	PD-405	120	2,8÷3,6	20	2x10	GM	4,9	+
D4050019	PD-405	120	2,8÷3,6	22	2x10	GM	4,9	+
D4050004	PD-405	125	2,8÷3,6	20	2x10	GM	4,9	+
D4050021	PD-405	125	2,8÷3,6	22	2x10	GM	4,9	+
D4050013	PD-405	125	2,8÷3,6	20	2x12	GM	4,9	+
D4050013.4	PD-405	125	2,8÷3,6	20	2x12	GM	4,0	•
D4050012	PD-405	125	2,8÷3,6	22	2x12	GM	4,9	+
D4050012.4	PD-405	125	2,8÷3,6	22	2x12	GM	4,0	•

Scoring saw blades width straight (GM) or top bevel (GW or GT) teeth, type **PD-406** with polycrystalline diamond (PCD) tips designed for formatting.

Type of cut: cross and longitudinal.

Material: laminated chipboard, laminates, MDF, HDF.

PD-406



GM



GW

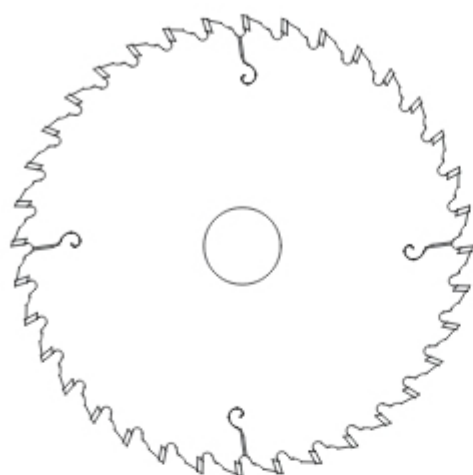


GT



Type	D mm	B mm	b mm	d mm	z	nx _{d1}	D ₁	
PD-406	250	4,0	3,0	80	48	6x6,5	200	+
PD-406	250	4,0	3,0	80	54	6x6,5	200	+
PD-406	250	4,0	3,0	80	72	6x6,5	200	+
PD-406	250	4,0	3,0	100	48	6x6,5	200	+
PD-406	250	4,0	3,0	100	54	6x6,5	200	+
PD-406	250	4,0	3,0	100	72	6x6,5	200	+

PD-408



Scoring saw blade type **PD-408** with conical-flat and conical-alternate bevel (GR/GM, GR/GS) teeth, with polycrystalline diamond (PCD) tips designed for scoring chipboard, laminated board, MDF, HDF and other homogenous materials, used on manual formatting machines and automatic lines.

Type of cut: scoring.

Material: laminated chipboard, MDF, HDF.



GR/GM



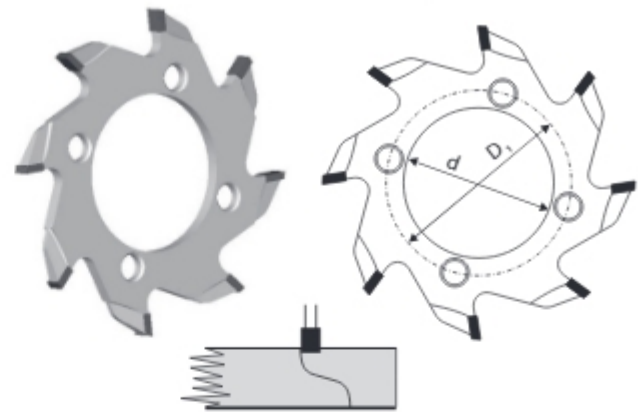
Catalogue number	Type	D mm	B ₁ /B ₂ mm	b mm	d mm	z	DIA mm	
D4080082	PD-408	100	3,2/4,3	2,5	20	20	GR/GM	4,9 +
D4080822	PD-408	125	2,8/3,6	2,2	20	24	GR/GM	4,0 •
D4080088	PD-408	125	2,8/3,6	2,2	20	24	GR/GM	4,9 +
D4080085	PD-408	125	2,8/3,6	2,2	22	24	GR/GM	4,9 +
D4080697	PD-408	125	3,1/4,2	2,5	20	24	GR/GM	4,0 •
D4080726	PD-408	125	3,1/4,2	2,5	22	24	GR/GM	4,0 +
D4080079	PD-408	125	3,2/4,3	2,5	20	24	GR/GM	4,9 +
D4080023	PD-408	125	3,2/4,3	2,5	22	24	GR/GM	4,9 +
D4080304	PD-408	150	4,4/5,4	3,0	30	24	GR/GM	4,9 +
D4080301	PD-408	150	4,4/5,4	3,0	30	36	GR/GM	4,9 +
D4080823	PD-408	180	4,4/5,4	3,2	45	36	GR/GM	4,0 +
D4080083	PD-408	180	4,4/5,6	3,4	45	36	GR/GM	4,9 •
D4080089	PD-408	200	4,4/5,4	3,0	30	36	GR/GM	4,9 +
D4080053A	PD-408	200	4,4/5,4	3,0	45	36	GR/GM	4,9 +

Scoring saw blade type **PD-409** with polycrystalline diamond (PCD) tips designed for scoring laminated materials before profiling. Used mainly on HOMAG machines.

Type of cut: laminate scoring.

Material: chipboard, MDF, HDF.

PD-409



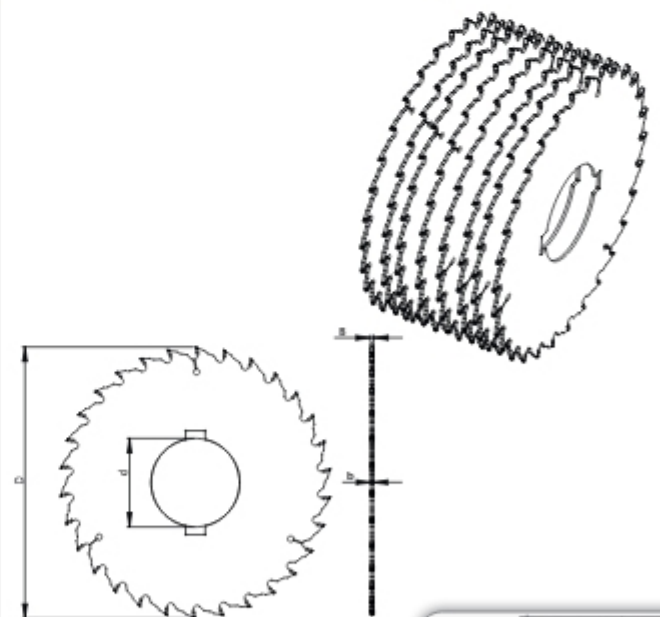
Type	D mm	B mm	b mm	d mm	z	nxd ₁	D ₁	
PD-409	70	4,0	3,0	34	8	4x5,5	42	+

Scoring saw blade type **PD-502** with polycrystalline diamond (PCD) tips designed for multi-rip machines.

Type of cut: multi-rip scoring.

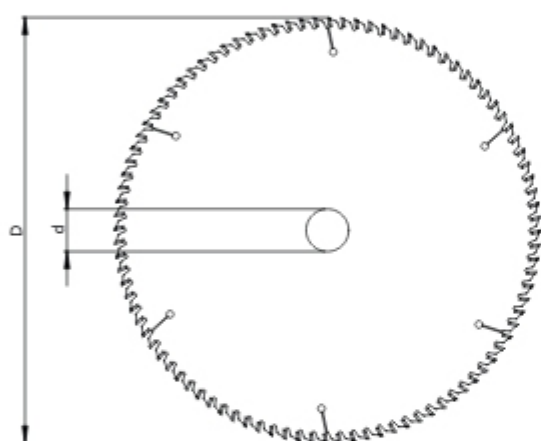
Material: chipboard, plywood, MDF, HDF.

PD-502



Type	D mm	B mm	b mm	d mm	z		
PD-502	210	2,4	1,8	75	30	GR/GM	+
PD-502	230	2,8	2,2	75	30	GR/GM	+
PD-502	250	3,2	2,2	75	24	GR/GM	+

PD-505



Universal saw blade with medium number of alternate top bevel teeth (GS), type **PD-505**, with polycrystalline diamond (PCD) tips designed for cross and longitudinal cutting of glued wood, plywood, chipboard, used on manual formatting machines and automatic lines.

Type of cut: single, cross and longitudinal.

Material: glued wood, plywood, MDF chipboard, laminated chipboard.



GS



DIA

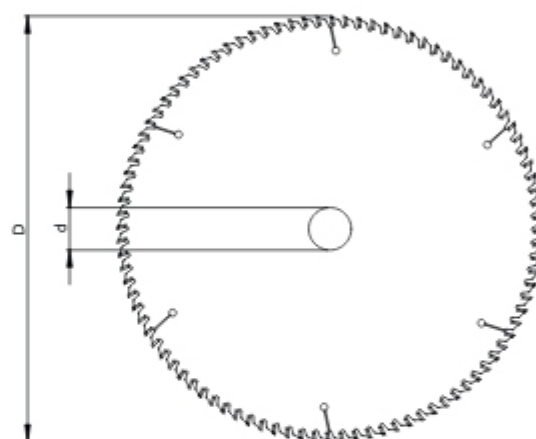
Type	D mm	B mm	b mm	d mm	z		
PD-505	250	3,2	2,3	30	60	GS	+
PD-505	250	3,2	2,3	30	80	GS	+
PD-505	300	3,2	2,5	30	60	GS	+
PD-505	300	3,2	2,5	30	72	GS	+
PD-505	300	3,2	2,5	30	96	GS	+
PD-505	350	3,5	2,5	30	60	GS	+
PD-505	350	3,5	2,5	30	72	GS	+
PD-505	350	3,5	2,5	30	96	GS	+
PD-505	350	4,0	3,0	30	60	GS	+
PD-505	350	4,0	3,0	30	72	GS	+
PD-505	350	4,0	3,0	30	96	GS	+

Saw blade, type **PD-506** with polycrystalline diamond (PCD) tips designed for cutting chipboard, laminated board, MDF, HDF and other homogenous materials without impurities, used on manual formatting machines and automatic lines.

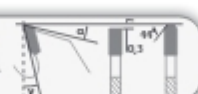
Type of cut: single, cross and longitudinal.

Material: laminated chipboard, MDF, HDF.

PD-506

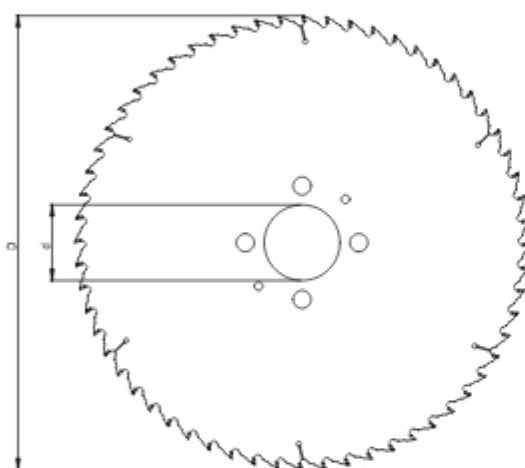


GA



Type	D mm	B mm	b mm	d mm	z		
PD-506	250	3,2	2,3	30	60	GA	+
PD-506	250	3,2	2,3	30	80	GA	+
PD-506	300	3,2	2,4	30	60	GA	+
PD-506	300	3,2	2,4	30	72	GA	+
PD-506	300	3,2	2,4	30	96	GA	+
PD-506	350	3,5	2,5	30	60	GA	+
PD-506	350	3,5	2,5	30	72	GA	+
PD-506	350	3,5	2,5	30	96	GA	+
PD-506	350	4,0	3,0	30	60	GA	+
PD-506	350	4,0	3,0	30	72	GA	+
PD-506	350	4,0	3,0	30	96	GA	+

PD-521



Saw blade, type **PD-521** with polycrystalline diamond (PCD) tips and triple chip + flat teeth (GA) designed for cutting in stack chipboard, laminated board, MDF, HDF and other homogenous materials without impurities, used on manual formatting machines and automatic lines.

Type of cut: in stack, cross and longitudinal.

Material: chipboard, laminated chipboard, MDF, HDF.



Type	D mm	B mm	b mm	d mm	z		
PD-521	300	4,4	3,0	30/60/75/80	60	GA	+
PD-521	300	4,4	3,0	30/60/75/80	72	GA	+
PD-521	350	4,4	3,2	30/60/75/80	60	GA	+
PD-521	350	4,4	3,2	30/60/75/80	72	GA	+
PD-521	380	4,4	3,2	30/60/75/80	60	GA	+
PD-521	380	4,4	3,2	30/60/75/80	72	GA	+
PD-521	400	4,4	3,2	30/60/75/80	60	GA	+
PD-521	400	4,4	3,2	30/60/75/80	72	GA	+
PD-521	450	4,4	3,2	30/60/75/80	60	GA	+
PD-521	450	4,4	3,2	30/60/75/80	72	GA	+
PD-521	480	4,6	3,6	30/60/75/80	60	GA	+
PD-521	480	4,6	3,6	30/60/75/80	72	GA	+
PD-521	480	4,8	3,6	30/60/75/80	60	GA	+
PD-521	480	4,8	3,6	30/60/75/80	72	GA	+