



Diamond Milling Cutters



Precision creates value

Selection Guide PCD Router Cutters

Part-No.	Article	Number of teeth Z	Plunge cutting tip	Softwood	Hardwood	Multiplex, Plywood	MDF, Chipboard raw	OSB	Chipboard, veneered	Chipboard, laminated	Chipboard, paper coated	MDF, veneered	MDF, laminated	MDF, paper coated	Composite materials, HPL, Trespa	Thermoplastics	Fibre-reinforced GFK, CFK	Mineral plastics Corian, Varior	Gypsum plaster boards	Cement boundes wood fibre board, gypsum fibre board
Feed range				B	A	A	C	B	B	C	B	B	C	B	A	A	A	A	B	A
12100	Diastart-UNO	1+1	PCD				X	X		X			X						X	X
12200	Diastart-DUO	2	PCD			X	X	X		X			X						X	X
12500	Dianova	1	PCD				X	X	O	O		O	O							
12550	Dianova-UNO	1	TC				X								X					
12660	Dianova-DUO	2	PCD					X	O	X	O	O	X	O						
13510	Dianorm	1	PCD				X	X	O	X		O	X							
13700	Dianorm-DUO	2	PCD					X	X	X	O	X	X	O						
13701	Dianorm-DUO	2	PCD		O	O	O	X				O	O	O						X
13750	Dianorm-TRIO	3	PCD			X			X	X	X	X	X	X	O					
14250	Diatec-DUO	2	PCD			X	X								X	X	X	X		X
14253	Diatec-TRIO	3	PCD	O	X	X	X	X	O	X	O	O	X	O	X	O	X	X	X	X
14256	Diatec-TRIO-Roughing cutter	3	PCD	O	X	X	X	X		X			X		X	O	X	X	X	X
14300	Diatec	2	TC				X		O	X	O	O	X	O						
14310	Diatec-Pro-DUO	2+2	PCD	O	X	X	O	O	X	X	X	X	X	X						
14330	Diatec-Pro-TRIO	3+3	PCD	O	X	X	O	O	X	X	X	X	X	X						
15530	Diatec-WOOD	2+2	PCD	X	X	O														
15540	Diamatic-DUO	2	PCD			X	O													
15551	Diamatic	3	PCD				O	X	X	X	X	X	X	X						
15552	Diamatic-Plus	3	PCD		X	X	O	X	X	X		X	X							
15553	Diamatic	3	PCD				O	X	X	X	X	X	X	X						
15555	Diamatic-TRIO	3	PCD				O	X	X	X	X	X	X	X						
15556	Diamatic-Quattro	4	PCD				O	X	X	X	X	X	X	X						
15600	Megaspeed	4+2+4	PCD				O	X		X			X						X	
15700	Gigaspeed-UNO	1	PCD	X	X	X	O	O	X	X	X	X	X	X						
15700	Gigaspeed-DUO	2	PCD	X	X	X	O	O	X	X	X	X	X	X						
15700	Gigaspeed-TRIO	3	PCD	X	X	X	O	X	X		X	X		X	O			O		
15750	Gigaspeed-Particle	3	-				X	X	X	X	X	X	X	X						
17600	4Cut Decorative groove	1	-			X	X								X			O		
17030	4Cut Router cutter	2	-				X		X	X		X	X							
17525 Ø 82mm	4Cut Surfacing cutter	3	-		O	X	X								X	X		X		
17525 Ø 150mm	4Cut Surfacing cutter	6	-				X													

- X

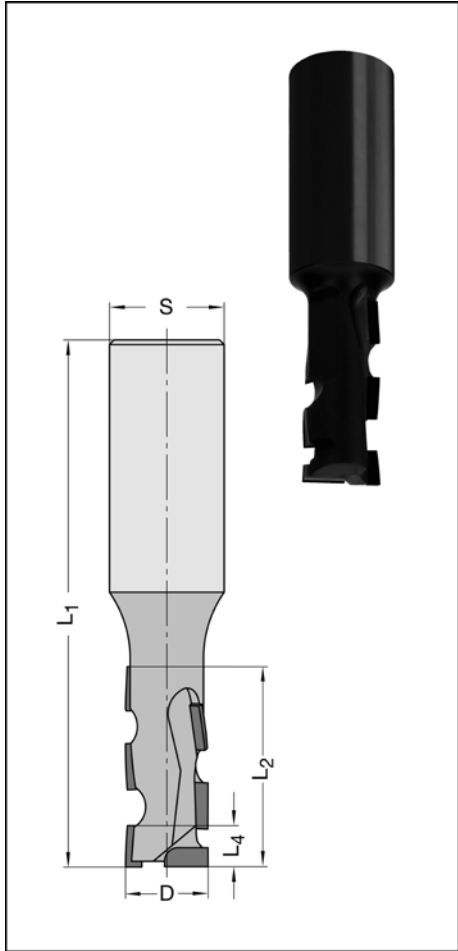
Recommendations
- X

Well suitable
- O

Suitable with certain restrictions

Feed ranges for R.P.M. = 24 000

Feed range vf [m/min]			
Number of teeth	A	B	C
1	3 - 4	5 - 7	7 - 10
2	6 - 9	10 - 14	13 - 20
3	9 - 13	14 - 22	20 - 30
4	12 - 17	19 - 29	17 - 40



12100

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
10	26	9,2	75	2,5	12 x 40	12100-9-10262-L
10	26	9,2	75	2,5	12 x 40	12100-9-10262-R
12	26	9,2	75	2,5	12 x 40	12100-9-12262-L
12	26	9,2	75	2,5	12 x 40	12100-9-12262-R
12	26	9,2	80	2,5	16 x 45	12100-9-12263-L
12	26	9,2	80	2,5	16 x 45	12100-9-12263-R
12	35	9,2	85	2,5	12 x 40	12100-9-12352-L
12	35	9,2	85	2,5	12 x 40	12100-9-12352-R
12,7	26	9,2	75	2,5	12,7 x 40	12100-9-12726-L
12,7	26	9,2	75	2,5	12,7 x 40	12100-9-12726-R
15,88	35	9,2	90	2,5	15,88 x 45	12100-9-15835-L
15,88	35	9,2	90	2,5	15,88 x 45	12100-9-15835-R
16	26	9,2	80	2,5	16 x 45	12100-9-16263-L
16	26	9,2	80	2,5	16 x 45	12100-9-16263-R
16	35	9,2	90	2,5	16 x 45	12100-9-16353-L
16	35	9,2	90	2,5	16 x 45	12100-9-16353-R
16	35	9,2	105	2,5	25 x 60	12100-9-16356-L
16	35	9,2	105	2,5	25 x 60	12100-9-16356-R
18	26	9,2	90	2,5	20 x 55	12100-9-18265-L
18	26	9,2	90	2,5	20 x 55	12100-9-18265-R
18	35	9,2	100	2,5	20 x 55	12100-9-18355-L
18	35	9,2	100	2,5	20 x 55	12100-9-18355-R
18	43	9,2	115	2,5	25 x 60	12100-9-18436-L
18	43	9,2	115	2,5	25 x 60	12100-9-18436-R
19,05	43	9,2	115	2,5	25,4 x 60	12100-9-19054-L
19,05	43	9,2	115	2,5	25,4 x 60	12100-9-19054-R
20	26	9,2	95	2,5	25 x 60	12100-9-20266-L
20	26	9,2	95	2,5	25 x 60	12100-9-20266-R
20	52	9,2	120	2,5	25 x 60	12100-9-20526-L
20	52	9,2	120	2,5	25 x 60	12100-9-20526-R
25	26	9,2	95	2,5	25 x 60	12100-9-25266-L
25	26	9,2	95	2,5	25 x 60	12100-9-25266-R
25	52	9,2	120	2,5	25 x 60	12100-9-25526-L
25	52	9,2	120	2,5	25 x 60	12100-9-25526-R

Technical details

- * tool body made of steel
- * burnished
- * periphery tips and plunge tip made from pcd
- * alternative shear cut
- * several times regrindable
- * without length adjusting screw

Application

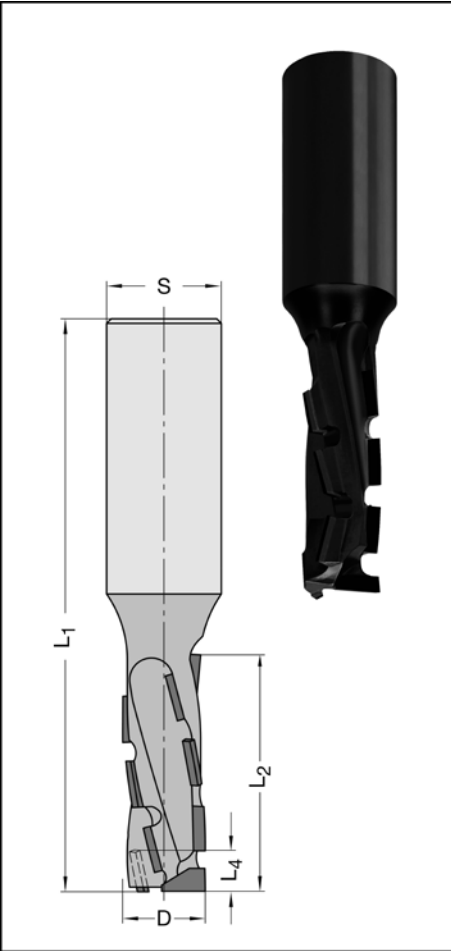
- * grooving, sizing, severing and rebating of classically wood composites
- * suitable for axial and ramp plunge cutting

Special advantages

- * cost effective
- * PCD-plunge tip also cutting on periphery (Z2)
- * Dianova tip seat design

Application data

R.P.M. = 18 000 - 24 000
v_f = 3 - 7 m/min



12200

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
15,88	37	9,2	90	2,5	15,88 x 45	12200-9-15837-L
15,88	37	9,2	90	2,5	15,88 x 45	12200-9-15837-R
16	28	9,2	100	2,5	20 x 55	12200-9-16285-L
16	28	9,2	100	2,5	20 x 55	12200-9-16285-R
16	37	9,2	90	2,5	16 x 45	12200-9-16373-L
16	37	9,2	90	2,5	16 x 45	12200-9-16373-R
18	28	9,2	95	2,5	25 x 60	12200-9-18286-L
18	28	9,2	95	2,5	25 x 60	12200-9-18286-R
18	47	9,2	115	2,5	25 x 60	12200-9-18476-L
18	47	9,2	115	2,5	25 x 60	12200-9-18476-R
19,05	47	9,2	115	2,5	25,4 x 60	12200-9-19057-L
19,05	47	9,2	115	2,5	25,4 x 60	12200-9-19057-R
20	28	9,2	95	2,5	25 x 60	12200-9-20286-L
20	28	9,2	95	2,5	25 x 60	12200-9-20286-R
20	47	9,2	120	2,5	25 x 60	12200-9-20476-L
20	47	9,2	120	2,5	25 x 60	12200-9-20476-R
25	28	9,2	95	2,5	25 x 60	12200-9-25286-L
25	28	9,2	95	2,5	25 x 60	12200-9-25286-R
25	47	9,2	120	2,5	25 x 60	12200-9-25476-L
25	47	9,2	120	2,5	25 x 60	12200-9-25476-R

Technical details

- * tool body made of steel
- * burnished
- * periphery tips and plunge tip made from pcd
- * alternative shear cut
- * several times regrindable
- * without length adjusting screw

Application

- * grooving, sizing, severing and rebating of classically wood composites
- * suitable for axial and ramp plunge cutting

Special advantages

- * cost effective
- * Dianova tip seat design

Application data

R.P.M. = 18 000 - 24 000
v_f = 6 - 10 m/min

12500

D mm	L ₂ mm	L ₁ mm	Z	T.H. mm	Shank mm	Part-No.
4	12	55	1	1,5	6 x 35	12500-8-04120-R
5	12	70	1	2,0	10 x 45	12500-8-05120-R
5	12	60	1	2,0	6 x 40	12500-8-05121-R
6	12	70	1	2,5	12 x 45	12500-8-06122-R
6	15	60	1	2,5	8 x 40	12500-8-06150-R
8	12	70	1	2,5	12 x 45	12500-8-08122-R
8	15	55	2	2,5	8 x 35	12500-8-08150-R
8	22	70	1 + 1	2,5	8 x 40	12500-8-08221-R
8	22	75	2	2,5	12 x 40	12500-8-08222-R
8	22	75	1	2,5	12 x 40	12500-8-08223-R
10	15	65	2	2,5	10 x 40	12500-8-10151-R
10	22	75	2	2,5	12 x 40	12500-8-10002-R
10	22	75	1	2,5	12 x 40	12500-8-10022-R
10	22	75	1+1	2,5	12 x 40	12500-8-10222-R

D = 12 mm see no. 12550 Z1 (page 5.5)

Technical details

- * tool body made of solid TC
- * periphery tips and plunge tip made of pcd
- * one or two straight periphery cutting edges, Z 1+1 design with alternate shear angle
- * up to 3 times regrindable

Application

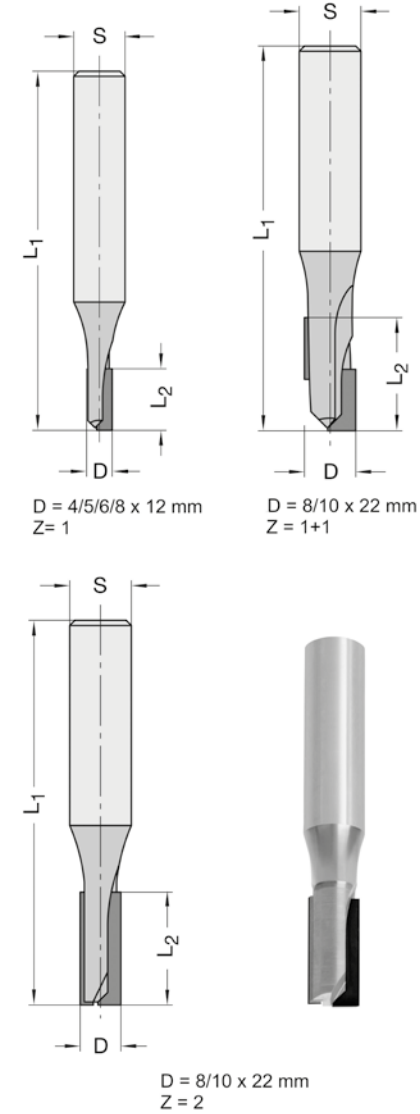
- * grooving, jointing and severing of classically wood composites, diverse plastics and aluminium
- * applicable for ramp plunge cutting

Special advantages

- * continuous cutting edges for line-free cut (Z1 and Z2)

Application data

Z1: R.P.M. = 18 000 - 24 000, v_f = 1 - 2 m/min
Z2: R.P.M. = 18 000 - 24 000, v_f = 2 - 4 m/min



12550

D mm	L ₂ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
12*	25	70	3,0	12 x 35	12550-8-12252-R
16	35	95	3,0	16 x 45 m. E. M 6	12550-8-16353-R

Technical details

- * tool body made of steel or high-density metal (*)
- * steel body nickel coated
- * TC plunge tip
- * straight cutting edge
- * several times regrindable

Application

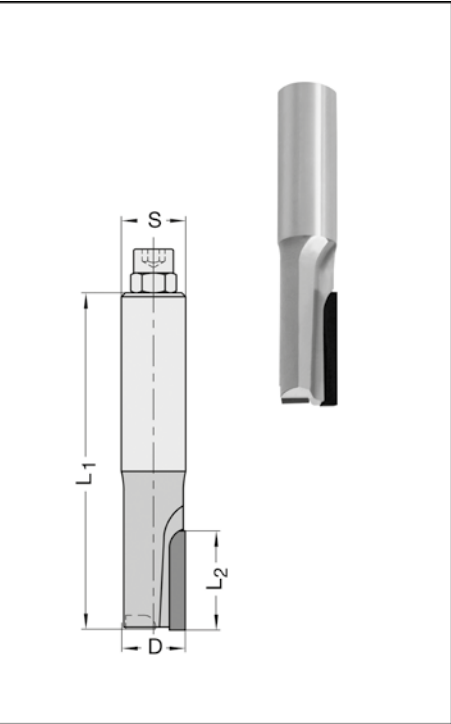
- * grooving, sizing, severing and rebating of wood composites and plastics (HPL, Trespa, Corian)
- * applicable for axial- and ramp plunge cutting

Special advantages

- * Dianova tip seat design
- * line-free cut

Application data

Wood composites: R.P.M. = 18 000 - 24 000, v_f = 2 - 8 m/min
Plastic materials: R.P.M. = 18 000 - 24 000, v_f = 1 - 4 m/min



Dianova-PLUS

12660

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
16	33*	9,5	100	3,0	20 x 55 m. E. M 8	12660-8-16285-R
18	33*	9,5	100	3,0	25 x 55 m. E. M 8	12660-8-18286-R
18	43*	9,5	110	3,0	25 x 55 m. E. M 8	12660-8-18386-R
18	53*	9,5	120	3,0	25 x 55 m. E. M 8	12660-8-18486-L
18	53*	9,5	120	3,0	25 x 55 m. E. M 8	12660-8-18486-R

* The last 5 mm on shank side with single cutting edge (Z1).

Technical details

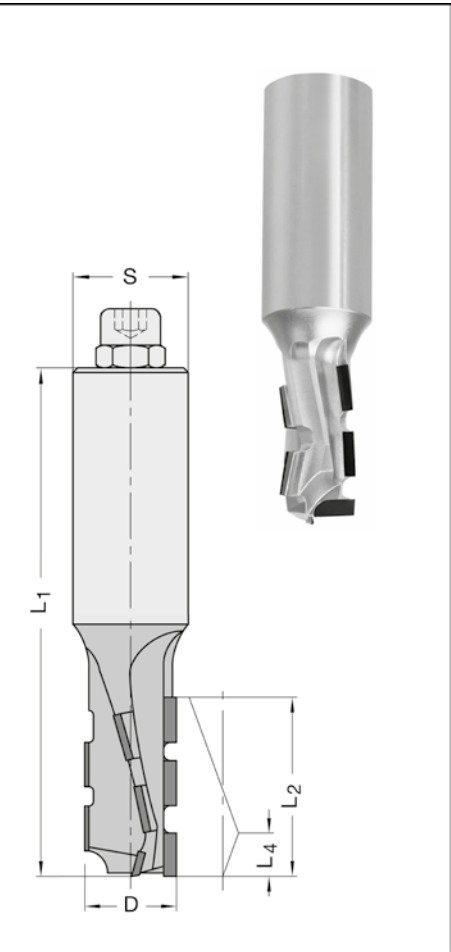
- * tool body made of steel
- * nickel coated
- * periphery tips and plunge tip made from pcd
- * alternative shear cut
- * up to 6 times regrindable

Application

- * grooving, sizing, severing and rebating of classically wood composites
- * applicable for axial- and ramp plunge cutting

Application data

R.P.M. = 18 000 - 24 000
v_f = 8 - 20 m/min



13510

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
12	26	9,4	80	4,0	12 x 45	13510-9-12262-L
12	26	9,4	80	4,0	12 x 45	13510-9-12262-R
16	26	9,4	90	4,0	16 x 50 m.E. M 6	13510-9-16263-R
16	35	9,4	100	4,0	16 x 50 m.E. M 6	13510-9-16353-L
16	35	9,4	100	4,0	16 x 50 m.E. M 6	13510-9-16353-R
16	35	9,4	105	4,0	25 x 55 m. E. M 8	13510-9-16356-R
18	35	9,4	100	4,0	16 x 50 m.E. M 6	13510-9-18353-R
18	35	9,4	105	4,0	25 x 55 m. E. M 8	13510-9-18356-L
18	35	9,4	105	4,0	25 x 55 m. E. M 8	13510-9-18356-R
18	43	9,4	110	4,0	20 x 55 m. E. M 8	13510-9-18435-L
18	43	9,4	110	4,0	20 x 55 m. E. M 8	13510-9-18435-R
18	43	9,4	110	4,0	25 x 55 m. E. M 8	13510-9-18436-L
18	43	9,4	110	4,0	25 x 55 m. E. M 8	13510-9-18436-R
20	35	9,4	105	4,0	25 x 55 m. E. M 8	13510-9-20356-R
20	52	9,4	120	4,0	20 x 55 m. E. M 8	13510-9-20525-L
20	52	9,4	120	4,0	20 x 55 m. E. M 8	13510-9-20525-R
20	52	9,4	120	4,0	25 x 55 m. E. M 8	13510-9-20526-L
20	52	9,4	120	4,0	25 x 55 m. E. M 8	13510-9-20526-R

Technical details

- * tool body made of steel
- * nickel coated
- * periphery tips and plunge tip made from pcd
- * alternative shear cut
- * up to 10 times regrindable

Application

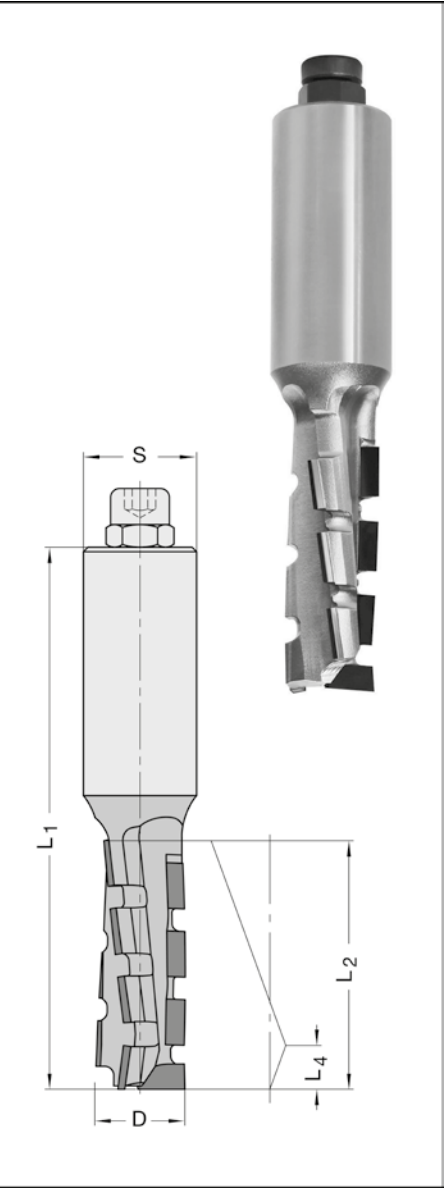
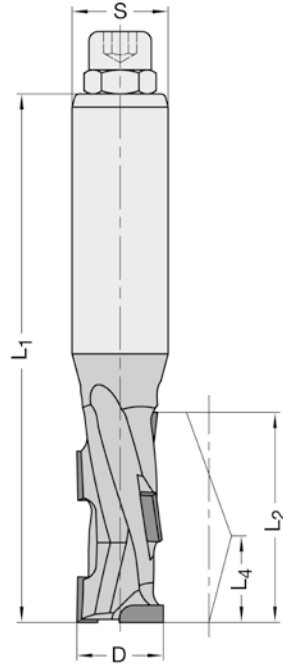
- * grooving, sizing, severing and rebating of classically wood composites
- * applicable for axial- and ramp plunge cutting

Special advantages

- * Dianova tip seat design

Application data

R.P.M. = 18 000 - 24 000
v_r = 3 - 7 m/min



13700 for chipboard and MDF

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
20	52*	9,5	120	4,0	25 x 55 m. E. M 8	13700-9-20486-L
20	52*	9,5	120	4,0	25 x 55 m. E. M 8	13700-9-20486-R

*The last 4 mm resp. 5 mm on shank side with single cutting edge (Z1).

Technical details

- * tool body made of steel
- * nickel coated
- * periphery tips and plunge tip made from pcd
- * real Z2-tipping on 3 flutes without overlap areas
- * alternative shear cut
- * up to 7 times regrindable

Application

- * grooving, sizing, severing and rebating on classically wood composites
- * applicable for axial- and ramp plunge cutting

Special advantages

- * gap less, real Z2-tipping
- * cutting edge geometry especially applicable for chip- and MDF-board

Application data

R.P.M. = 18 000 - 24 000
v_r = 5 - 12 m/min

13701 for hardwood and composite materials

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
20	40*	10	105	4,0	25 x 55 m. E. M 8	13701-9-20356-L
20	40*	10	105	4,0	25 x 55 m. E. M 8	13701-9-20356-R
20	55*	10	120	4,0	25 x 55 m. E. M 8	13701-9-20486-L
20	55*	10	120	4,0	25 x 55 m. E. M 8	13701-9-20486-R

*The last 4 mm resp. 5 mm on shank side with single cutting edge (Z1).

Technical details

- * tool body made of steel
- * nickel coated
- * periphery tips and plunge tip made from pcd
- * real Z2-tipping on 3 flutes without overlap areas
- * alternative shear cut
- * up to 7 times regrindable

Application

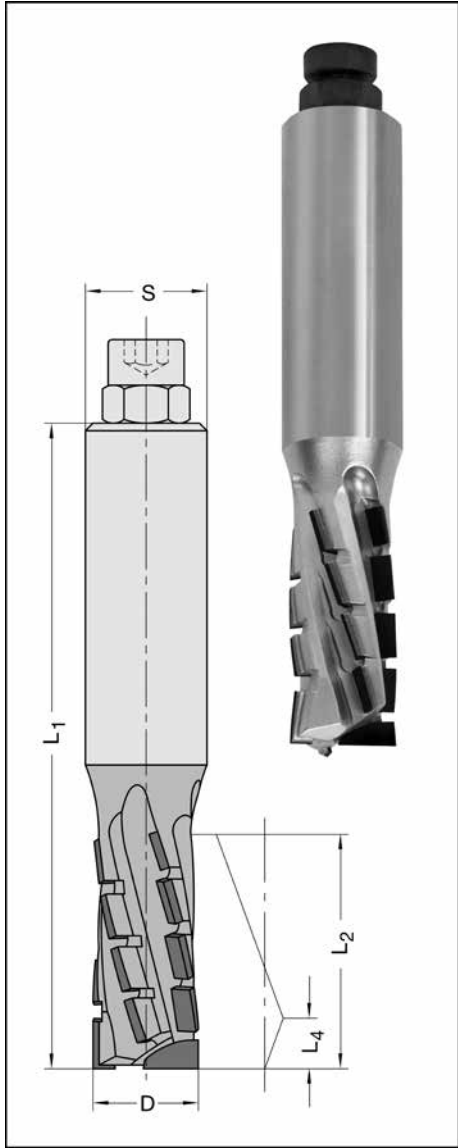
- * grooving, sizing, severing and rebating of classically wood composites, laminates (HPL) and solid wood
- * applicable for axial- and ramp plunge cutting

Special advantages

- * gap less, real Z2-tipping
- * cutting edge geometry especially applicable for hardwood, laminates and Multiplex

Application data

R.P.M. = 18 000 - 24 000
v_r = 3 - 10 m/min



13750

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
12	24	7	75	3,0	12 x 40	13750-9-12242-R
14	30	7	85	3,0	16 x 45 m. E. M 6	13750-9-14303-R
25*	70	8,5	140	4,5	25 x 60 m. E. M 8	13750-9-25706-R

Technical details

- * tool body made of steel (*) or high-density metal
- * nickel coated
- * periphery tips and plunge tip made from pcd
- * real Z3-tipping on 4 flutes without overlap areas
- * alternative shear cut
- * up to 4 times regrindable (Ø12 and Ø14)
- * up to 7 times regrindable (Ø25)

Application

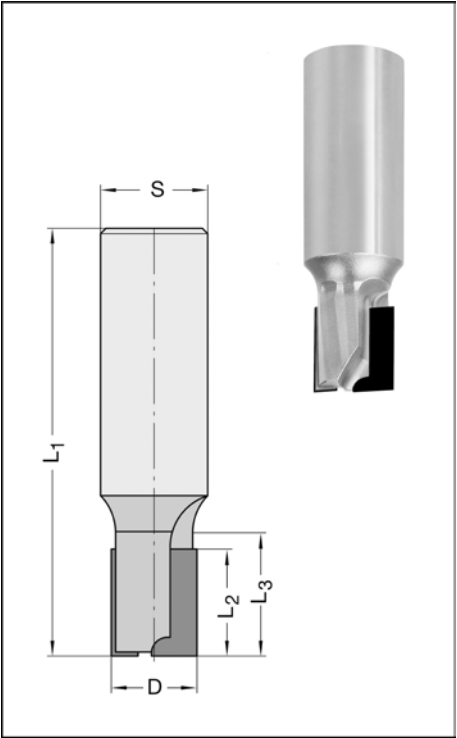
- * grooving, sizing, severing and rebating on classically wood composites
- * applicable for axial- and ramp plunge cutting

Special advantages

- * cutting edge geometrie especially applicable for machining of chip- and MDF board
- * on certain conditions useable for machining composite materials and solid wood
- * Ø 12 and 14 mm especially applicable for nesting operation by uncommon or wavering board thicknesses
- * up to 30% longer life time possible compared to Diamatic router cutters

Application data:

R.P.M. = 18 000 - 24 000
v_f = 18 - 35 m/min



14250

D mm	L ₂ mm	L ₃ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
5	10	12	50	1,5	6 x 35	14250-9-05100-R
6	15	20	65	2,0	6 x 40	14250-9-06150-R
8	15	20	65	2,5	8 x 40	14250-9-08150-R
8	20	25	70	2,5	8 x 40	14250-9-08200-R
10	10	15	75	2,5	10 x 50	14250-9-10100-R
10	15	20	75	2,5	10 x 45	14250-9-10150-R
10	20	25	80	2,5	10 x 50	14250-9-10200-R
12	15	20	70	3,0	12 x 45	14250-9-12152-R
12	20	25	75	3,5	12 x 45	14250-9-12202-R
12	25	30	75	3,5	12 x 45	14250-9-12252-R
12	30	35	80	3,0	12 x 40	14250-9-12302-R
16*	10	20	80	4,5	16 x 50 m. E. M 6	14250-9-16103-R
16*	15	25	80	4,5	16 x 50 m. E. M 6	14250-9-16153-R
16*	20	25	80	5,0	20 x 50 m. E. M 8	14250-9-16205-R
16	25	30	80	4,5	16 x 45	14250-9-16253-R
18*	15	25	80	5,0	18 x 50 m. E. M 8	14250-9-18155-R
18*	20	25	80	5,0	18 x 50 m. E. M 8	14250-9-18205-R
20*	20	30	85	5,0	20 x 50 m. E. M 8	14250-9-20205-R

Technical details

- * tool body made of steel (*) or solid tungsten carbide
- * periphery tips and plunge tip made from pcd
- * alternative shear cut
- * several times regrindable

Application

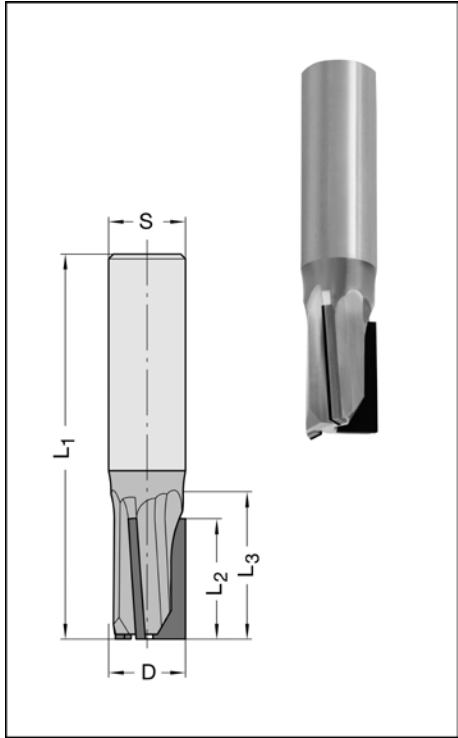
- * finishing, grooving, sizing, severing (nesting) and rebating of particularly abrasive workpiece materials
- * applicable for axial- and ramp plunge cutting

Spezial advantages

- * continous cutting edges for line-free cut

Application data

Heat-setting material/Thermoplastics / HPL: R.P.M. = 15 000 - 22 000, v_f = 1 - 5 m/min
Solid surface: R.P.M. = 15 000 - 22 000, v_f = 4 - 8 m/min
Wood based panels: R.P.M. = 18 000 - 24 000, v_f = 6 - 9 m/min



14253

D mm	L ₂ mm	L ₃ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
10	25	35	70	3,0	10 x 35	14253-9-10250-R
12	10	19	70	3,0	12 x 40	14253-9-12102-R
12	15	24	70	3,0	12 x 40	14253-9-12152-R
12	20	29	75	3,0	12 x 40	14253-9-12202-R
12	25	34	80	3,0	12 x 40	14253-9-12252-R
14	15	23	70	4,0	14 x 40	14253-9-14151-R
14	20	28	75	4,0	14 x 40	14253-9-14201-R
14	25	33	80	4,0	14 x 40	14253-9-14251-R
16	10	25	80	4,5	16 x 50	14253-9-16103-R
16	15	30	80	4,5	16 x 45	14253-9-16153-R
16	20	30	80	4,5	16 x 45	14253-9-16203-R
16	25	30	80	4,5	16 x 45	14253-9-16253-R
16	30	35	85	4,5	16 x 45	14253-9-16303-R
16	35	40	90	4,5	16 x 45	14253-9-16353-R
20	10	15	85	4,5	20 x 60	14253-9-20105-R
20	15	20	85	4,5	20 x 60	14253-9-20155-R
20	20	25	85	4,5	20 x 55	14253-9-20205-R
20	25	30	90	4,5	20 x 55	14253-9-20255-R
20	30	35	95	4,5	20 x 55	14253-9-20305-R

Technical details

- * tool body made of solid tungsten carbide
- * periphery tips and plunge tip made from pcd
- * alternative shear cut (2 negative; 1 positive)
- * several times regrindable

Application

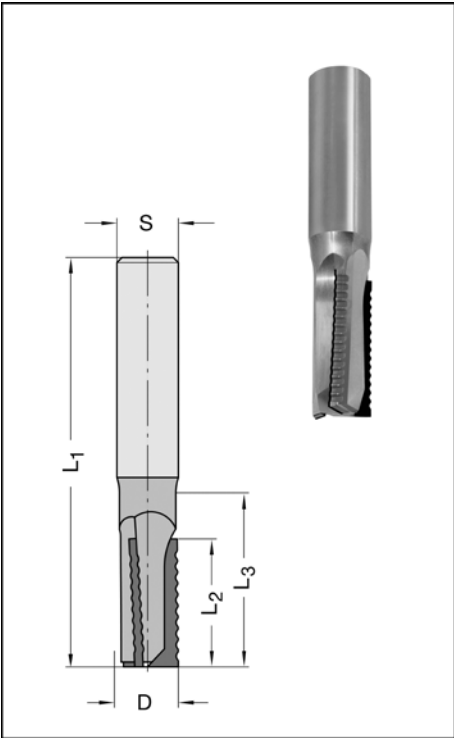
- * finishing, grooving, sizing, severing (nesting) and rebating of particularly abrasive workpiece materials
- * applicable for axial- and ramp plunge cutting

Special advantages

- * continious cutting edges for line-free cut

Application data

- * Heat-setting material/Thermoplastics / HPL: R.P.M. = 15 000 - 18 000, v_f = 3 - 8 m/min
- * Solid surface: R.P.M. = 15 000 - 18 000, v_f = 6 - 10 m/min
- * Wood based panels: R.P.M. = 18 000 - 24 000, v_f = 12 - 20 m/min



14256

D mm	L ₂ mm	L ₃ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
12	10	19	70	3,0	12 x 45	14256-9-12102-R
12	15	24	70	3,0	12 x 40	14256-9-12152-R
12	20	29	75	3,0	12 x 40	14256-9-12202-R
12	25	34	80	3,0	12 x 40	14256-9-12252-R
14	15	23	70	4,0	14 x 40	14256-9-14151-R
14	20	28	75	4,0	14 x 40	14256-9-14201-R
14	25	33	80	4,0	14 x 40	14256-9-14251-R
16	10	25	80	4,5	16 x 50	14256-9-16103-R
16	15	30	80	4,5	16 x 45	14256-9-16153-R
16	20	30	80	4,5	16 x 45	14256-9-16203-R
16	25	30	80	4,5	16 x 45	14256-9-16253-R
16	30	35	85	4,5	16 x 45	14256-9-16303-R
16	35	40	90	4,5	16 x 45	14256-9-16353-R
20	10	15	85	4,5	20 x 60	14256-9-20105-R
20	15	20	85	4,5	20 x 60	14256-9-20155-R
20	20	25	85	4,5	20 x 55	14256-9-20205-R
20	25	30	90	4,5	20 x 55	14256-9-20255-R
20	30	35	95	4,5	20 x 55	14256-9-20305-R

Technical details

- * tool body made of solid tungsten carbide
- * periphery tips and plunge tip made from pcd
- * alternative shear cut (2 negative; 1 positive)
- * roughing ground
- * several times regrindable

Application

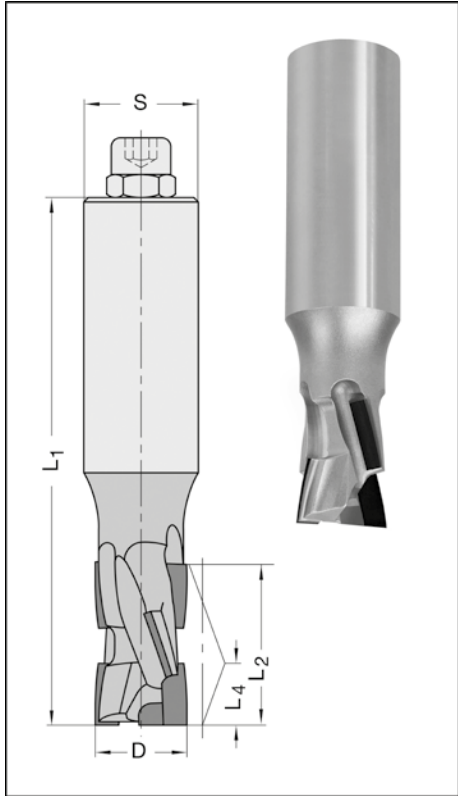
- * roughing, grooving, sizing, severing (nesting) and rebating of particularly abrasive workpiece materials
- * applicable for axial- and ramp plunge cutting

Special advantages

- * roughing ground for increased chip volume and reduced cutting force

Application data

- * Heat-setting material/Thermoplastics / HPL: R.P.M. = 15 000 - 18 000, v_f = 5 - 9 m/min
- * Solid surface: R.P.M. = 15 000 - 18 000, v_f = 8 - 12 m/min
- * Wood based panels: R.P.M. = 18 000 - 24 000, v_f = 15 - 25 m/min



14300

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
20	25	13,5	105	4,5	25 x 60 m. E. M 8	14300-9-20256-L
20	25	13,5	105	4,5	25 x 60 m. E. M 8	14300-9-20256-R
20	35	13,5	115	4,5	25 x 60 m. E. M 8	14300-9-20356-R

Technical details

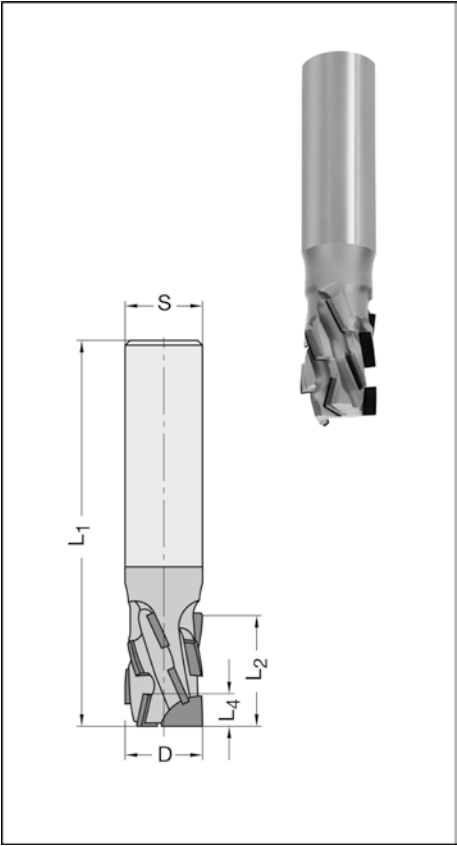
- * tool body made of steel
- * TC plunge tip
- * nickel coated design
- * alternative shear cut
- * up to 10 times regrindable

Application

- * grooving, sizing, severing and rebating on wood based panels. Especially applicable for MDF, raw
- * applicable for axial- and ramp plunge cutting

Application data

R.P.M. = 18 000 - 24 000
v_r = 5 - 15 m/min (lower adjustment up to 20 m/min)



14330

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
12*	22	4,3	80	2,5	12 x 40	14330-9-12222-R
16	23	6,7	80	3,0	16 x 40 m. E. M 6	14330-9-16233-R
16	34	6,7	85	3,0	16 x 40 m. E. M 6	14330-9-16343-R
18	42	8	110	3,0	25 x 55 m. E. M 8	14330-9-18426-L
18	42	8	110	3,0	25 x 55 m. E. M 8	14330-9-18426-R
20	42	8	110	3,0	25 x 55 m. E. M 8	14330-9-20426-R
25	42	8	110	3,0	25 x 55 m. E. M 8	14330-9-25426-R

Technical details

- * tool body made of steel, or high-density metal (*)
- * nickel coated (design with steel tool body)
- * periphery tips and plunge tip made from pcd
- * alternative shear cut
- * several times regrindable

Application

- * grooving, sizing and severing of classically wood composites

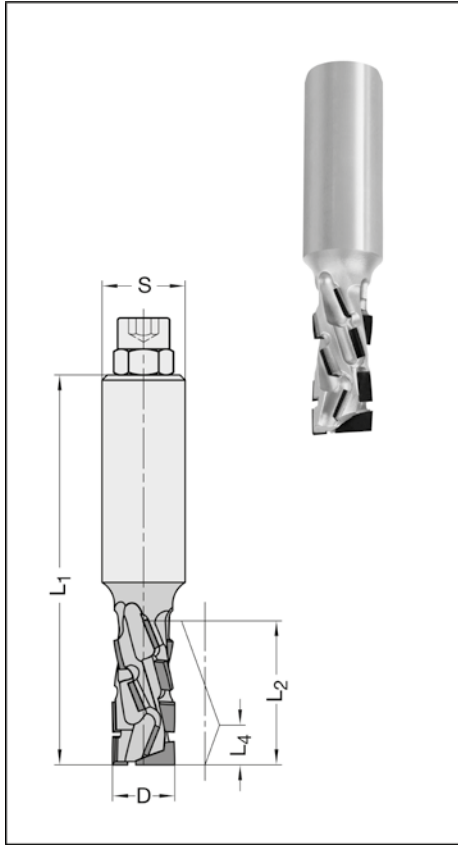
Special advantages

- * consistently Z3+3 tipping on 6 flutes
- * improved life time and cutting quality compare to classcially Z3 tools

Application data

R.P.M. = 18 000 - 24 000
v_r = 15 - 25 m/min

Diatec-PRO DUO



14310

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
10*	22	6	70	3,0	10 x 40	14310-9-10022-R
12**	24	8	70	3,0	12 x 40	14310-9-12242-R
12**	28	7,5	75	3,0	16 x 40 m. E. M 6	14310-9-12283-R
16	28	8	85	3,0	16 x 40 m. E. M 6	14310-9-16283-R
16**	42	8	100	3,0	16 x 50 m. E. M 6	14310-9-16423-R
18	28	8	93	4,5	25 x 55 m. E. M 8	14310-9-18286-R
18	35	8	105	4,5	25 x 55 m. E. M 8	14310-9-18356-R
18	42	9	110	4,5	25 x 55 m. E. M 8	14310-9-18426-R
20	28	8	105	4,5	25 x 55 m. E. M 8	14310-9-20286-L
20	28	8	105	4,5	25 x 55 m. E. M 8	14310-9-20286-R
20	42	8	110	4,5	25 x 55 m. E. M 8	14310-9-20426-L
20	42	8	110	4,5	25 x 55 m. E. M 8	14310-9-20426-R
25	48	8	120	4,5	25 x 55 m. E. M 8	14310-9-25486-R

Technical details

- * tool body made of steel, solid TC (*), or high-density metal (**)
- * nickel coated (design with steel tool body)
- * periphery tips and plunge tip made from pcd
- * alternative shear cut
- * several times regrindable

Application

- * grooving, sizing and severing of classically wood composites

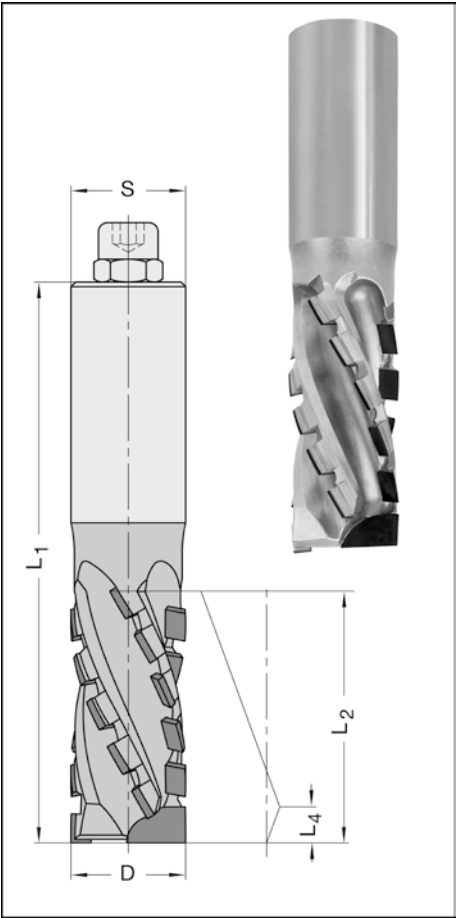
Special advantages

- * consistently Z2+2 tipping on 4 flutes
- * long tool life when used on nesting machines
- * very well suited for use with dust extraction turbines

Application data

R.P.M. = 18 000 - 24 000
v_r = 8 - 16 m/min

Diatec-WOOD



15530

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
25	55	8	125	4,5	25 x 55 m. E. M 8	15530-9-25556-R

Technical details

- * tool body made of steel
- * nickel coated
- * periphery tips and plunge tip made of pcd
- * alternative shear cut
- * up to 10 times regrindable

Application

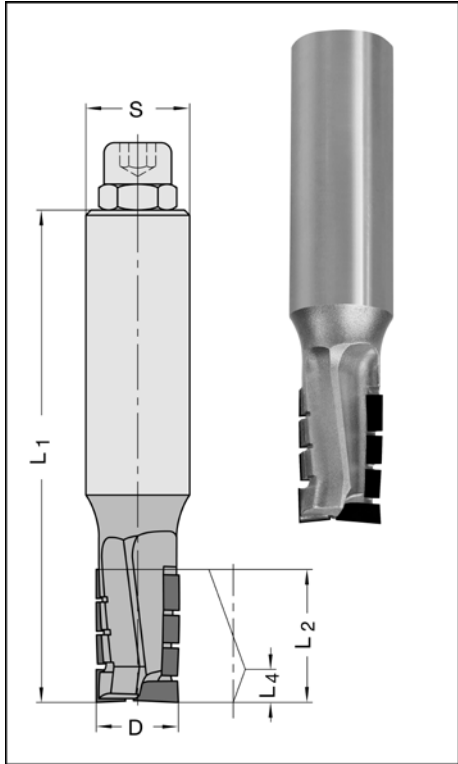
- * grooving, sizing, severing and rebating of **solid wood**
- * applicable for axial- and ramp plunge cutting

Special advantages

- * cutting edge geometry especially for solid wood

Application data

R.P.M. = 18 000 - 24 000
v_r = 5 - 15 m/min



15540

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
16	25	6,5	95	3,0	20 x 55 m. E. M 8	15540-9-16255-R

Technical details

- * tool body made of steel
- * nickel coated
- * periphery tips and plunge tip made of pcd
- * alternative shear cut
- * large chip space
- * up to 3 times regrindable

Application

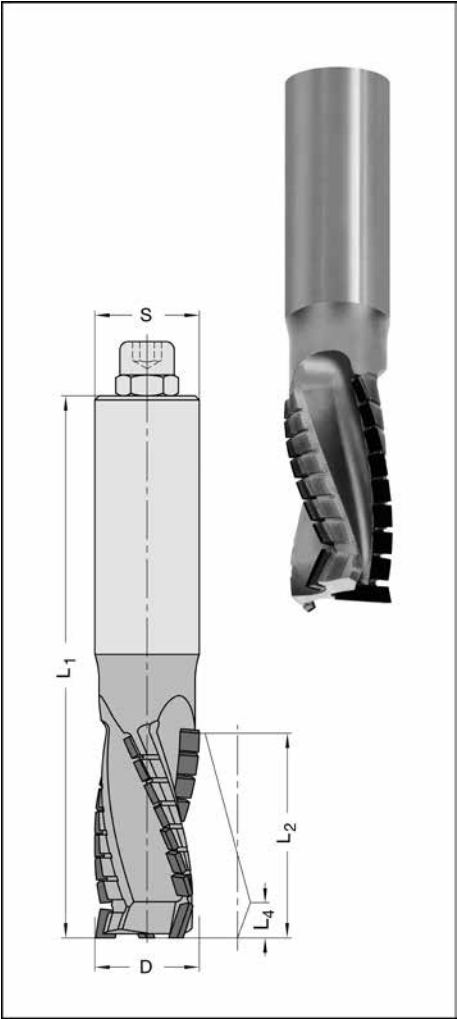
- * grooving, sizing, severing and rebating of multilex
- * applicable for axial- and ramp plunge cutting

Special advantages

- * cutting edge geometry especially for machining multilex

Application data

R.P.M. = 18 000 - 24 000
v_f = 5 - 10 m/min



15551 chip removal downwards

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
12,7	28	7	80	3,0	12 x 45	15551-9-12701-L
12,7	28	7	80	3,0	12 x 45	15551-9-12701-R
16	25	7,5	100	4,5	20 x 55 m. E. M 8	15551-9-16255-R
16	35	7,5	110	4,5	20 x 55 m. E. M 8	15551-9-16355-L
16	35	7,5	110	4,5	20 x 55 m. E. M 8	15551-9-16355-R
20	28	7	110	4,5	25 x 60 m. E. M 8	15551-9-20286-R
20	38	7	120	4,5	25 x 60 m. E. M 8	15551-9-20386-L
20	38	7	120	4,5	25 x 60 m. E. M 8	15551-9-20386-R
20	48	7	125	4,5	20 x 55 m. E. M 8	15551-9-20485-R
20	48	7	130	4,5	25 x 60 m. E. M 8	15551-9-20486-L
20	48	7	130	4,5	25 x 60 m. E. M 8	15551-9-20486-R
25	28	8,5	110	4,5	25 x 60 m. E. M 8	15551-9-25286-L
25	28	8,5	110	4,5	25 x 60 m. E. M 8	15551-9-25286-R
25	38	8,5	120	4,5	25 x 60 m. E. M 8	15551-9-25386-L
25	38	8,5	120	4,5	25 x 60 m. E. M 8	15551-9-25386-R
25	48	8,5	130	4,5	25 x 60 m. E. M 8	15551-9-25486-L
25	48	8,5	130	4,5	25 x 60 m. E. M 8	15551-9-25486-R

Technical details

- * tool body made of steel
- * nickel coated
- * periphery tips and plung tip made of pcd
- * alternative shear cut
- * chip removal downwards (short L4 dimension)
- * chip removal downwards (negative spiral)
- * support the clamping of smaller workpieces
- * up to 7 times regrindable

Application

- * grooving sizing and severing of classically wood composites
- * especially applicable for chip- and MDF board, laminated, paper coated or veneered
- * applicable for axial- and ramp plunge cutting

Application data

R.P.M. = 18 000 - 24 000
v_f = 10 - 20 m/min

15552

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
18	45	9	120	4,5	25 x 60 m. E M 8	15552-9-18456-L
18	45	9	120	4,5	25 x 60 m. E M 8	15552-9-18456-R
25	45	9	120	4,5	25 x 60 m. E M 8	15552-9-25456-L
25	45	9	120	4,5	25 x 60 m. E M 8	15552-9-25456-R

Technical details

- * tool body made of steel
- * nickel coated
- * periphery tips and plunge tip made of pcd
- * alternative shear cut
- * chip removal downwards (negative spiral)
- * large Z3 ranges
- * up to 10 times resharpenable

Application

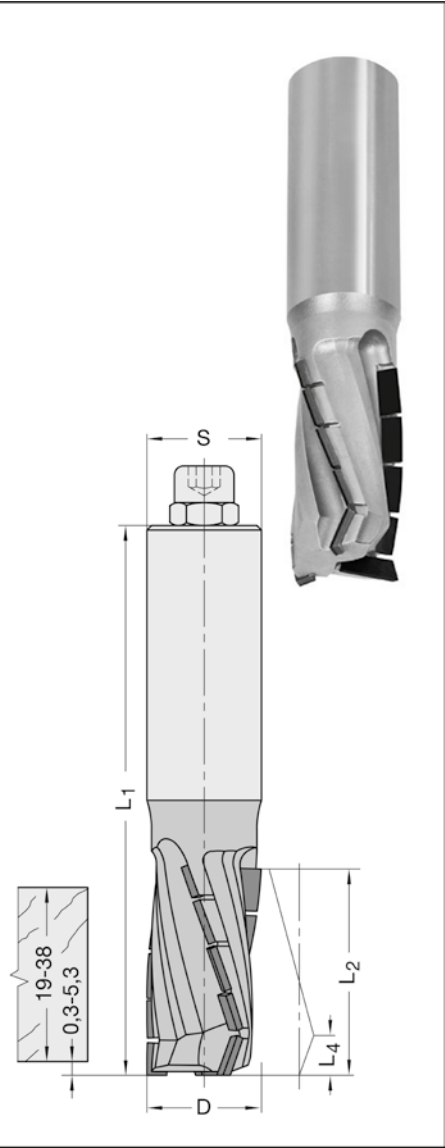
- * grooving, sizing and severing of classically wood composites
- * large Z3 ranges allow oscillating cutting

Special advantages

- * optimized for standard board thicknesses
- * ideal Z3-use by accompanying magnetic tool card

Application data

R.P.M. = 18 000 - 24 000
v_f = 13 - 26 m/min



15553 chip removal upwards

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
16	35	29	110	3,0	20 x 55 m. E. M 8	15553-9-16355-R
20	28	17,5	110	4,5	25 x 60 m. E. M 8	15553-9-20286-R
20	38	29	120	4,5	25 x 60 m. E. M 8	15553-9-20386-R
20	48	40	125	4,5	25 x 60 m. E. M 8	15553-9-20486-R
25	38	29	120	4,5	25 x 60 m. E. M 8	15553-9-25386-L
25	38	29	120	4,5	25 x 60 m. E. M 8	15553-9-25386-R
25	48	40	130	4,5	25 x 60 m. E. M 8	15553-9-25486-R

Technical details

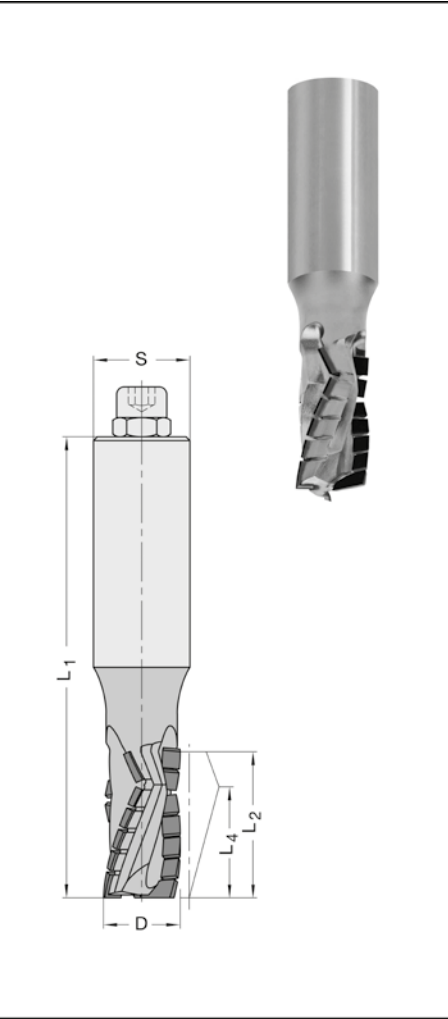
- * tool body made of steel
- * nickel coated
- * periphery tips and plung tip made of pcd
- * alternative shear cut
- * chip removal upwards (long L4 dimension)
- * chip removal upwards (**positive** spiral)
- * up to 7 times regrindable

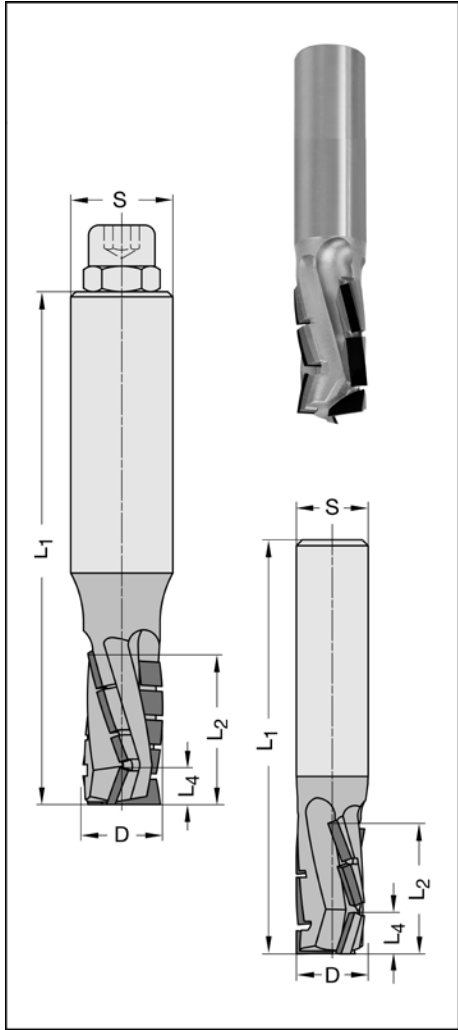
Application

- * grooving sizing and severing of classically wood materials
- * especially applicable for chip- and MDF board, laminated, paper coated or veneered
- * applicable for axial- and ramp plunge cutting

Application data

R.P.M. = 18 000 - 24 000
v_f = 10 - 20 m/min





15555 high performance design

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
12	22	7	75	3,0	12 x 45	15555-9-12222-R
12,7	28	7	85	3,0	12 x 45	15555-9-12701-R
12,7	28	7	85	3,0	12,7 x 45	15555-9-12728-R
16	21	6,5	85	4,5	20 x 55 m. E. M 8	15555-9-16215-R
16	29	6,5	100	4,5	20 x 55 m. E. M 8	15555-9-16295-R
18	52	13	130	4,5	20 x 64 m. E. M 8	15555-9-18525-R

Technical details

- * tool body made of high-density metal
- * periphery tips and plunge tip made of pcd
- * alternative shear cut
- * several times regrindable

Application

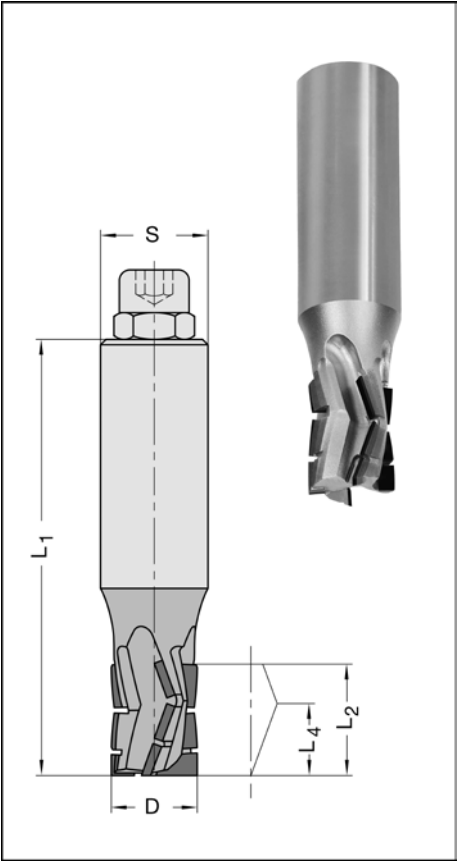
- * grooving, sizing and severing of classically wood materials
- * applicable to axial- and ramp plunge cutting

Special advantages

- * for nesting machining
- * high performance design thanks to tool body made of high-density metal

Application data

R.P.M. = 18 000 - 24 000
v_r = 15 - 35 m/min



15556

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
16	21	12,7	85	3,0	20 x 55 m. E. M 8	15556-9-16215-R

Technical details

- * tool body made of high-density metal
- * periphery tips and plunge tip made of pcd
- * alternative shear cut
- * several times resharpenable

Application

- * grooving, sizing and severing of chip- and MDF-boards
- * applicable for axial- and ramp plunge cutting

Special advantages

- * especially applicable for nesting operation
- * optimal for board thicknesses of 16 mm and 19 mm

Application data

R.P.M. = 18 000 - 24 000
v_r = 20 - 40 m/min

15600

D mm	L ₂ mm	L ₄ mm	h mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
50	22	12,5	10 - 19	85	4,5	25 x 60	15600-9-50226-R
50	28	12	16 - 25	90	4,5	25 x 60	15600-9-50286-R
50	48	25	25 - 45	110	4,5	25 x 60	15600-9-50486-R

Technical details

- * tool body made of steel
- * nickel coated
- * alternative shear cut
- * up to 7 times resharpenable

Application

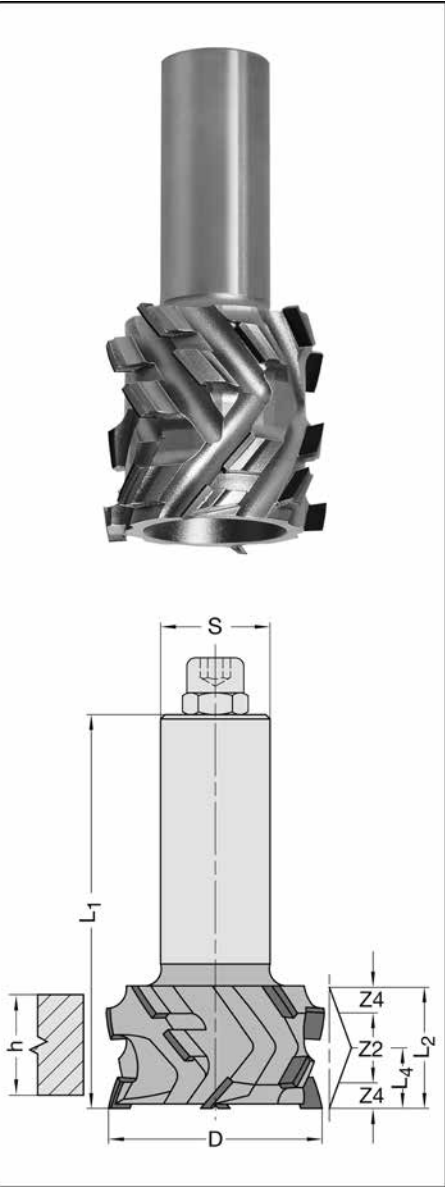
- * sizing, rebating and severing of classically wood composites

Special advantages

- * very well edge quality also on high cutting speed
- * on the outside section Z4, in the centre position Z2

Application data

R.P.M. = 18 000 - 24 000
v_f = 20 - 35 m/min



15700

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
18	48	6	110	4,5	20 x 50 m. E. M8	15700-9-18485-R
25	28	6,5	95	4,5	25 x 55 m. E. M 8	15700-9-25286-R

Technical details

- * tool body made of steel
- * nickel coated
- * alternative shear cut
- * up to 7 times resharpenable

Application

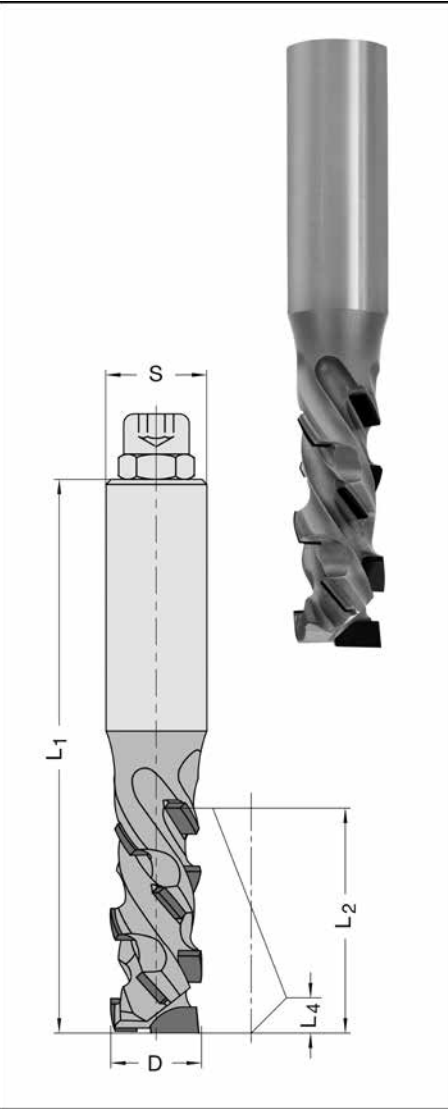
- * sizing, grooving and severing on classically wood composites

Special advantages

- * extreme shear angle
- * very well edge quality also on high feed speed
- * especially efficient on veneered wood composites

Application data

R.P.M. = 18 000 - 24 000
v_f = 5 - 15 m/min



15700

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
12*	24	6	70	2,5	12 x 35	15700-9-12242-R
16	35	5	85	2,5	16 x 40 m. E. M 6	15700-9-16353-R
18	43	5	105	3,5	20 x 50 m. E. M 8	15700-9-18435-R
20	43	8	105	3,5	20 x 50 m. E. M 8	15700-9-20435-R
25	48	10	115	4,5	25 x 55 m. E. M 8	15700-9-25486-R

Technical details

- * tool body made of steel or solid tungsten carbide (*)
- * nickel coated
- * alternative shear cut
- * up to 5 times regrindable

Application

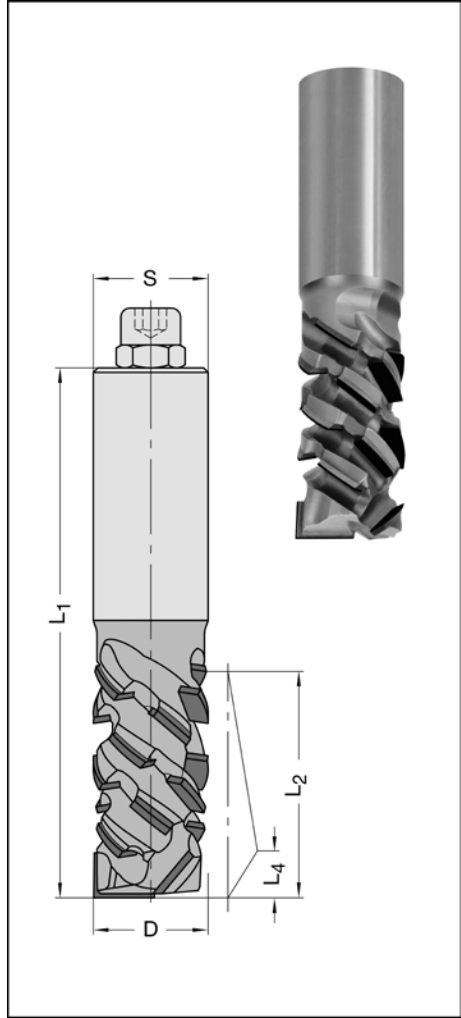
- * sizing, grooving and severing of classically wood composites

Special advantages

- * extreme shear angle
- * very well edge quality also on high feed speed
- * especially efficient on veneered wood composites
- * especially good results on the exit cut on the edge banding process

Application data

R.P.M. = 18 000 - 24 000
v_f = 12 - 25 m/min



15700

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
50	48	25	110	4,0	25 x 55 m. E. M 8	15700-9-50486-R
80	32	16	90	4,0	25 x 55 m. E. M 8	15700-9-80326-R
80	81,5	42,5	145	4,0	25 x 55 m. E. M 8	15700-9-80856-R

Technical details

- * tool body made of steel
- * nickel coated
- * alternative shear cut
- * up to 6 times regrindable

Application

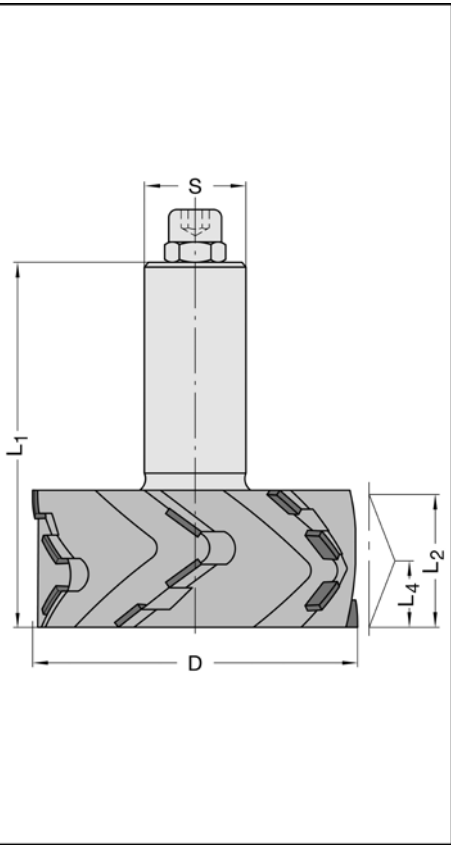
- * sizing of classically panel materials and solid wood

Special advantages

- * extreme shear angle
- * very well edge quality also on high feed speed
- * high cutting speed thanks to large cutting circle diameter
- * especially efficient on veneered panel materials

Application data

R.P.M. = 19 000 - 24 000 (D 50 x 48 mm)
R.P.M. = 11 000 - 16 000 (D 80 x 32 mm)
R.P.M. = 10 000 - 15 000 (D 80 x 81,5 mm)
v_f = 20 - 45 m/min



Gigaspeed-PARTICLE

15750

D mm	L ₂ mm	L ₄ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
80	25	13	85	4,5	25 x 55 m. E. M8	15750-9-80256-R

Technical details

- * tool body made of steel
- * nickel coated
- * alternative shear cut
- * up to 6 times regrindable

Application

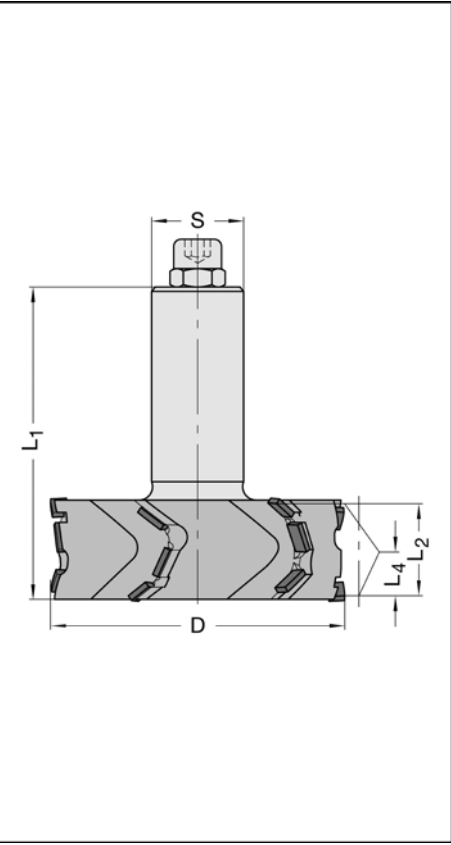
- * sizing of laminated chipboard 16 - 22 mm

Special advantages

- * very well edge quality also on high feed rates

Application data

R.P.M. = 15 000 - 18 000
v_f = 20 - 50 m/min



17030

D mm	L ₂ mm	L ₄ mm	L ₁ mm	AS	Shank mm	Part-No.
25	40*	12,6	120	7+1	25 x 55 m. E. M 8	17030-9-25406-R
25	54*	13,9	120	10	20 x 55 m. E. M 8	17030-9-25505-R
25	54*	13,9	120	10	25 x 55 m. E. M 8	17030-9-25506-R

AS = number of cutting edges (tips)
* The last 4 or 5 mm on shank side with single cutting edge (Z1).

Technical details

- * tool body made of steel
- * burnished
- * tips helically positioned
- * 4- resp. 2-sided reversible pcd tips

Application

- * grooving, sizing, severing and rebating of classically wood composites
- * type AS 7+1 with rebate tip
- * combined use of pcd and solid TC tips possible (see page 4.10)

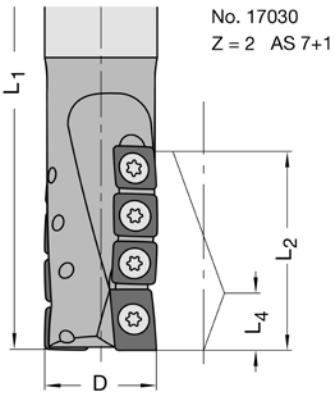
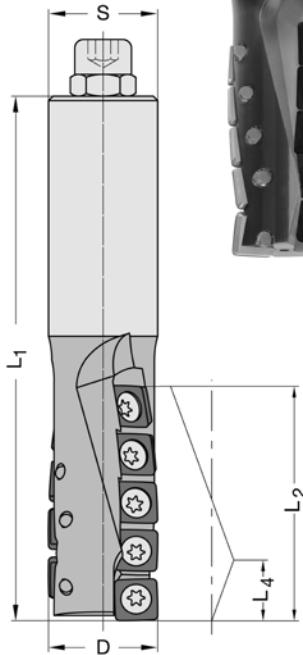
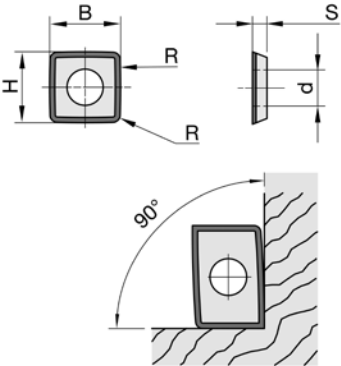
Application data

R.P.M. = 18 000 - 24 000
v_f = 8 - 15 m/min

Special advantages

- reversible pcd tips with 4 life times
- reversible pcd rebated tip with 2 life times for 90° rebate
- easy changing and turning of tips in case of damaging or blunting

Spare parts / Accessories			Part-No.
Reversible PCD tip	9,8 x 9,8 x 2,0 mm, 4-sided, convex design		72014-9-09800-0
Reversible PCD tip	14 x 9,8 x 2,0 mm, 2-sided, convex design 90° corner		72014-9-14980-0
Torx-screw	M 4 x 6, T15, with centring collar, for D = 20 mm		39081-0-04006-R
Torx-screw	M 4 x 7, T15, with centring collar, for D = 25 mm		39081-0-04070-R
Torx key	T15, with handle		39077-0-04015-2



17525 Z3 positive

D ₁ /D ₂ mm	L ₂ mm	L ₁ mm	Shank mm	Part-No.
82/80	8	80	25 x 55 m. E. M 8	17525-9-80006-R
122/120	8	85	25 x 55 m. E. M 8	17525-9-12006-R

Technical details

- * tool body made of steel
- * burnished
- * positive shear angle
- * mechanical feed

Application

- * surfacing of all common panel materials (wood and plastics)

Application data

R.P.M. = 10 000
v_f = 10 - 20 m/min

Reversible PCD tips exchangeable against solid TC, No. 20525-5 (page 4.20), No. 72014-6 (page 7.4)

17525 Z6 negative

D ₁ mm	L ₂ mm	L ₁ mm	Shank mm	Part-No.
150	8	90	25 x 55 m. E. M 8	17525-9-15006-R

Technical details

- * tool body made of steel
- * burnished
- * negative shear angle
- * mechanical feed

Application

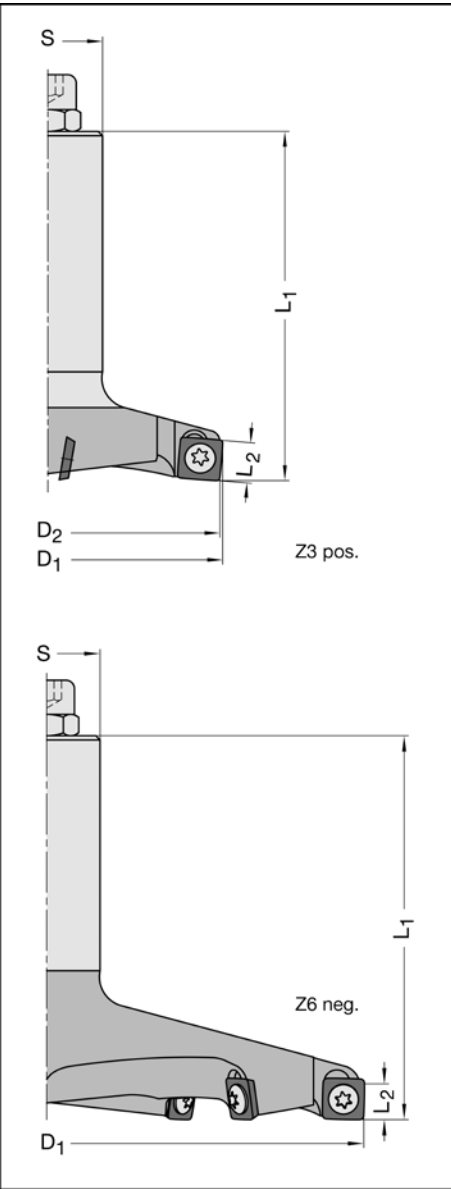
- * surfacing of all common panel marterials (wood and plastics)
- * especially for surfacing of nesting spoil boards (MDF)

Application data

R.P.M. = 9 000
v_f = 12 - 30 m/min

Reversible PCD tips exchangeable against solid TC tips, No. 20525-5 (page 4.20), No. 72014-6 (page 7.4)

Spare parts / Accessories			Part-No.
Reversible PCD tip	9,8 x 9,8 x 2,0 mm, 4-sided, convex design		72014-9-09800-0
Torx-screw	M 4 x 7, T15, with centring collar, spec. design		39081-0-04070-R
Torx key	T15, with handle		39077-0-04015-2



PCD V-Groove / Engraving Cutter

Z1

PCD Edge Rounding Cutters

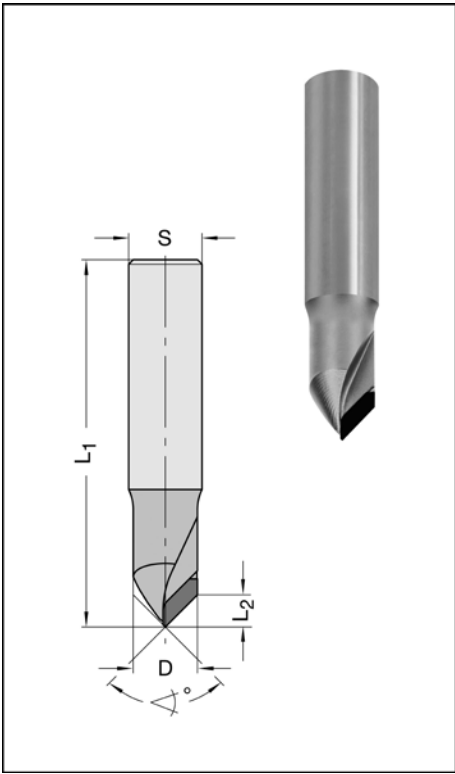
16010

Angle	D mm	L ₂ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
90°	14	7	80	3,5	16 x 50	16010-9-14453-R

Technical details
* tool body made of steel
* nickel coated

Application
* for machining of V-grooves, decorative grooves, lettering or bevelling of HPL and classically wood composites
* not applicable for machining of Alucobond boards

Application data
R.P.M. 18 000 - 24 000
v_f = 3 - 8 m/min



16030 Z2

R mm	d mm	D mm	L ₂ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
10	19,1	23,0	11,9	75	3,5	20 x 50	16030-9-23105-R
16	20,0	26,0	17	85	4,5	20 x 50	16030-9-26165-R
16	18,0	31,6	24	95	5,0	20 x 50	16030-9-32165-R
25	29,2	34,8	22,2	95	5,0	20 x 50	16030-9-35255-R

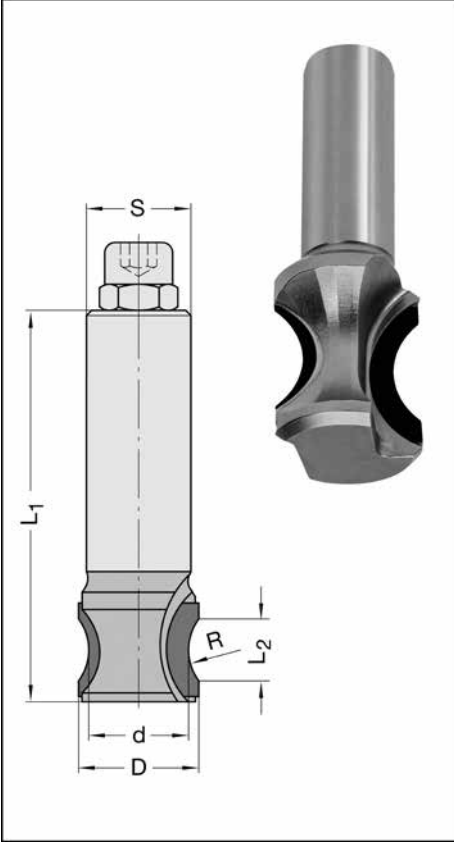
16030 Z2+2

R mm	d mm	D mm	L ₂ mm	L ₁ mm	T.H. mm	Schaft mm	Part-No.
25	40,0	52,4	33	117	6,5	20 x 55	16030-9-52255-R

Technical details
* tool body made of steel
* nickel coated
* alternative shear cut
* several times regrindable

Application
* for convex edge rounding
* machining of HPL and classically wood composites

Application data
R.P.M. = 18 000 - 24 000
v_f = 3 - 8 m/min



PCD V-Groove / Bevelling Cutters

Z2

4CUT PCD Decorative Groove Cutter

Z1

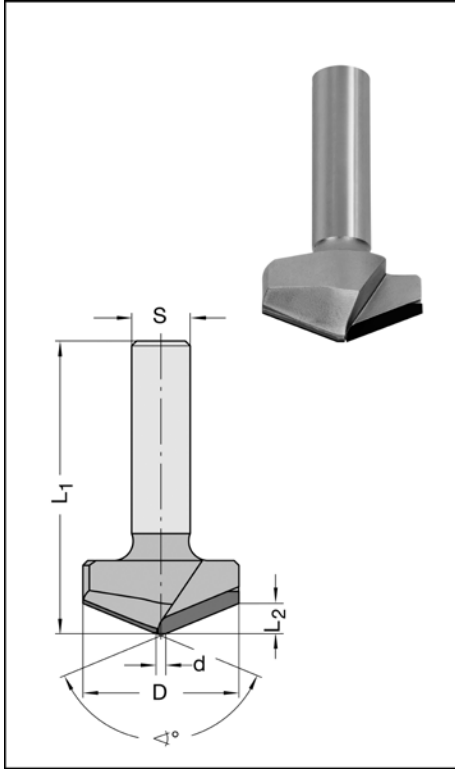
16010

Angle	D mm	d mm	L ₂ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
90°	18	3	7,5	60	3,5	12 x 45	16010-9-18452-R
135°	32	2	6,2	60	3,5	12 x 40	16010-9-32222-R
90°	63	3	30	95	3,5	25 x 60	16010-9-63456-R

Technical details
* tool body made of steel
* nickel coated

Application
* for machining of V-grooves, decorative grooves or bevelling of HPL and classically wood composites
* applicable for machining of Alucobond boards

Application data
R.P.M. = 18 000 - 24 000
v_f = 3 - 8 m/min



17600

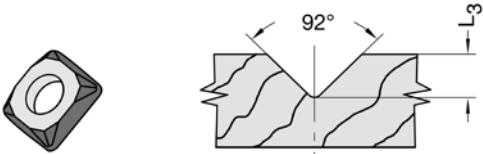
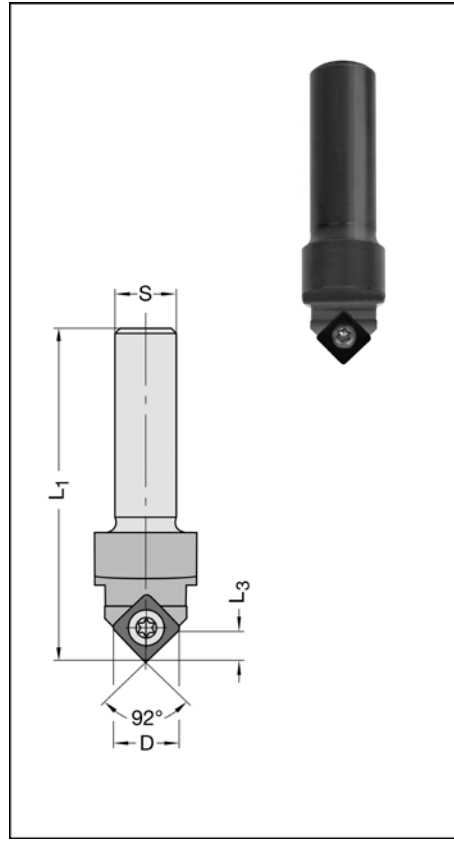
D mm	L ₃ mm	L ₁ mm	Shank mm	Part-No.
12,9	5,6	65	8 x 40	17600-9-12900-R
12,9	5,6	65	12 x 40	17600-9-12902-R

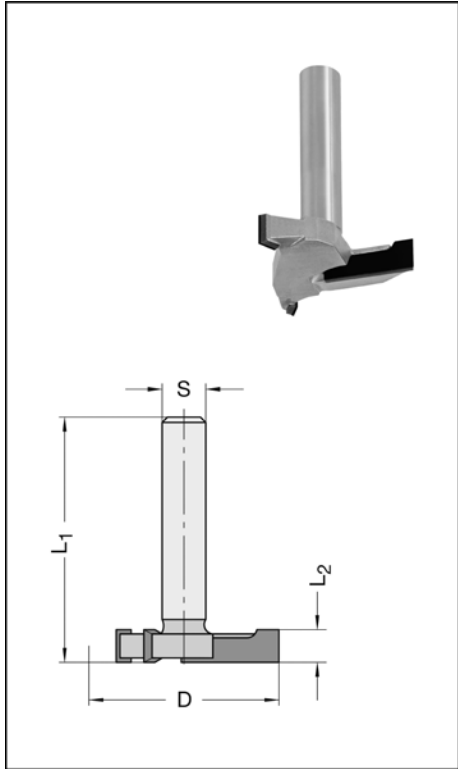
Technical details
Tempered tool body supplied with one reversible diamond (PCD) tip, profiled on 4-sides. With shear cut from top. For manual and mechanical feed. Right-hand rotation.

Application
* for machining decorative grooves, lettering or for bevelling on HPL or classically wood composites

Application data
R.P.M. = 12 000
v_f = 0,5 - 2 m/min

Spare parts / Accessories		Part-No.
Reversible PCD tip	9,8 x 9,8 x 2 mm, 4-sided	72014-9-09800-4
Torx-screw	M 4 x 7, T15, with centring collar, spec. design	39081-0-04070-R
Torx key	T15, with handle	39077-0-04015-2





16020-9 Connector system "Fixchip"

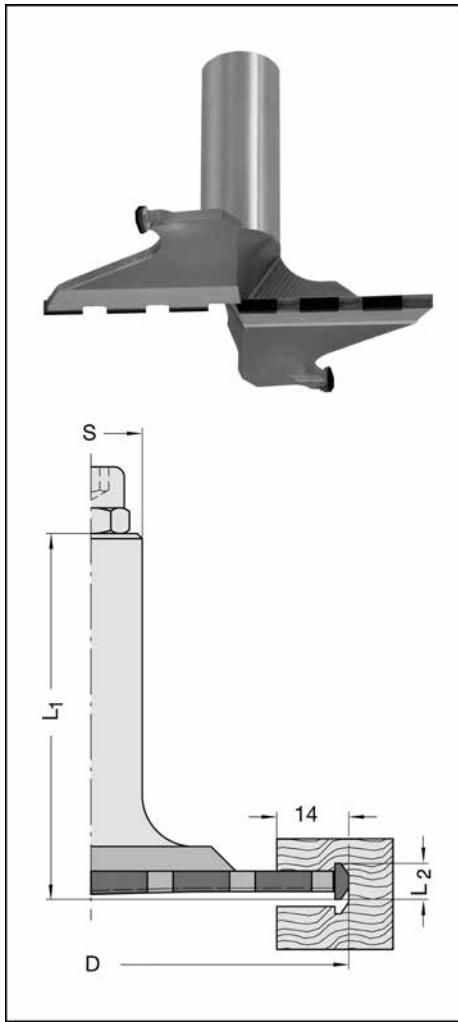
D mm	L ₂ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
35	6	45	-	8 x 35	16020-9-35600-R

Technical details
* tool body made of steel
* nickel coated
* cutting edges made of pcd

Application
* lateral grooving for fixchip connections

Special advantages
* long life time thanks to pcd cutting edges
* optimally adapted for use on nesting machines

Application data
R.P.M. = 18 000 - 24 000
v_f = 3 - 8 m/min



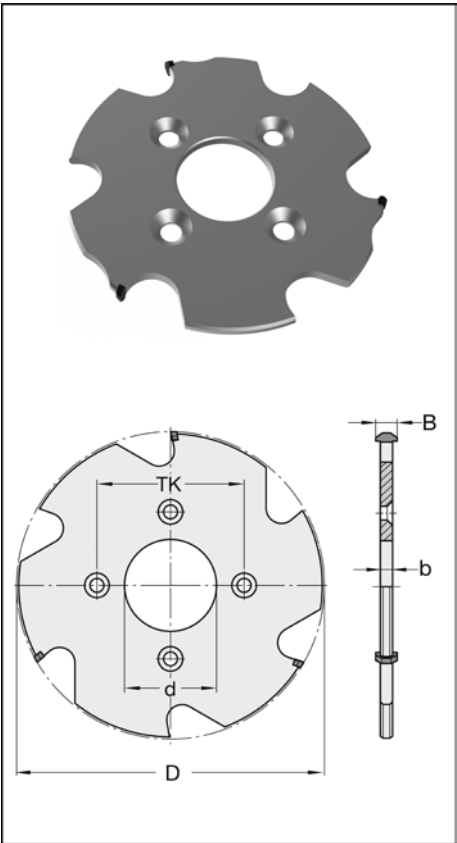
16020-9 Connector system "Clamex"

D mm	L ₂ mm	L ₁ mm	T.H. mm	Shank mm	Part-No.
100,4	5,4	71	5,0	20 x 50	16020-9-10045-R

Technical details
* cutter body made of steel
* mechanical feed

Application
* for machining the Lamello Clamex system groove in classically wood composites
* especially for the application on nesting machines
* applicable for axial plunging
* circular pocket and Lamello system groove in one tool

Application data
R.P.M. = 16 000 - 18 000
v_f = 0,5 - 1,5 m/min



40190 Connector system "Clamex"

D mm	B mm	b mm	d mm	T.H. mm	NL pcs./ø/pcd	Part-No.
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Usable with the Lamello Zeta P2
100,4 7,0 4,0 22 3,0 4/4,5/36 * 40190-9-00001-V

Usable with JSO arbors No. 21079 and No. 39498
100,4 7,0 4,0 22 3,0 4/6,5/36 40190-9-00003-V
100,4 7,0 4,0 30 3,0 4/6,5/48 40190-9-00002-V

Appropriate arbors no. 21079 (page 6.13) and no. 39498 (page 6.7)

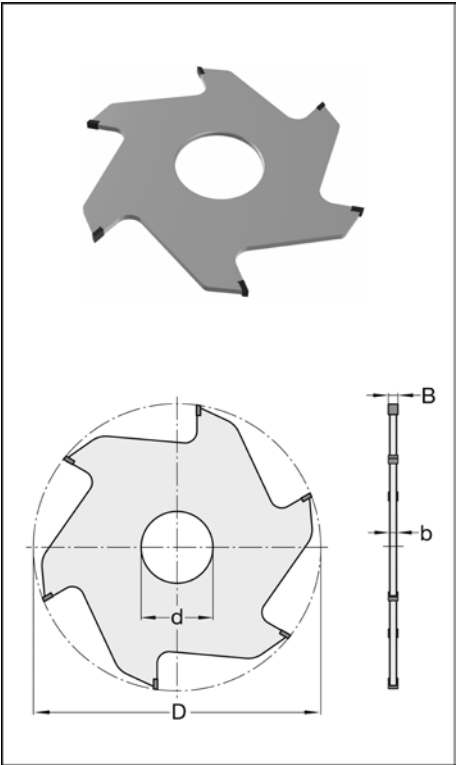
Technical details
* tool body made of steel
* mechanical and manual feed

Application
* for machining the Lamello Clamex P® - system groove in classically wood composites

Application data
R.P.M. = 18 000 - 24 000
v_f = 2,5 - 8 m/min

40190-9 assembled on arbor No. 21079, cylindrical shank

D mm	B mm	d mm	Shank mm	Part-No.
100,4	7,0	22	16 x 65 m. E.	40190-9-10223-R
100,4	7,0	30	16 x 65 m. E.	40190-9-10303-R
100,4	7,0	30	20 x 65 m. E.	40190-9-10305-R
100,4	7,0	22	25 x 65 m. E.	40190-9-10226-R
100,4	7,0	30	25 x 65 m. E.	40190-9-10306-R



40180

D mm	B mm	b mm	d mm	T.H. mm	Part-No.
100	3,0	2,2	30	4,0	40180-9-10030-0
100	4,0	2,8	30	4,0	40180-9-10040-0
100	5,0	3,2	30	4,0	40180-9-10050-0

TCT Grooving saw blades No. 40150/40160 page 4.59

Technical details
* tool body made of steel
* square teeth design
* mechanical feed
* several times regrindable

Application
* grooving of classically wood composites
* usable with arbors No. 21079 (page 6.13) and No. 39498-0 (page 6.7)

Application data
R.P.M. = 8 000 - 12 000
v_f = 8 - 15 m/min

Extra cost for:
- enlarging bore, No. 39710-0-01000-0
- adaption of keyway, No. 39720-0-01000-0
- drilling countersunk holes for arbor No. 21079, No. 39745-0-00004-0
see pages 7.31 - 7.32

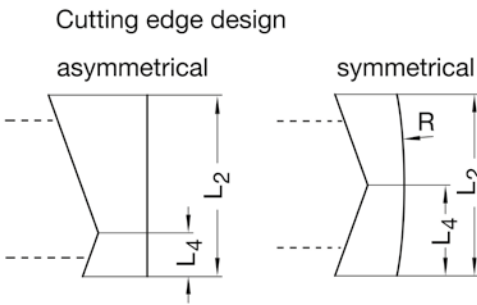
41650 Z2

D mm	L ₂ mm	L ₄ mm	T.H. mm	d mm	Machine	Part-No.
Cutting edge design asymmetrical, boss pos. 3, ND= 41 mm						
70	48	9,5	3,0	30 DKN	HolzHer Aggr. 1801	41650-9-07048-R
70	48	9,5	3,0	30 DKN	HolzHer Aggr. 1801	41650-9-07048-L
Cutting edge design asymmetrical, boss pos. 3, ND= 39,5 mm						
70	64	9,5	3,0	30 DKN	HolzHer Aggr. 1801	41650-9-07064-R
70	64	9,5	3,0	30 DKN	HolzHer Aggr. 1801	41650-9-07064-L

41650 Z3

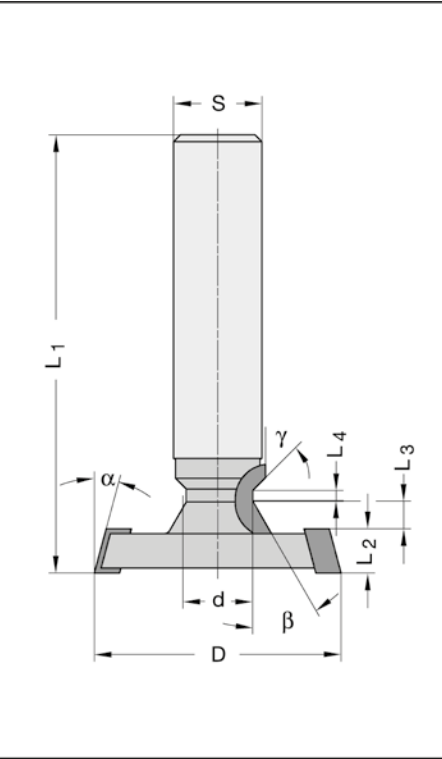
D mm	L ₂ mm	L ₄ mm	T.H. mm	d mm	Machine	Part-No.
Cutting edge design asymmetrical, boss pos. 1, ND= 45 mm						
85	43	9,5	3,0	30 DKN	Ott	41650-9-08543-R
85	43	9,5	3,0	30 DKN	Ott	41650-9-08543-L
Cutting edge design asymmetrical, boss pos. 1, ND= 36 mm						
100	34	9,5	3,0	30 DKN	IMA, Brandt	41650-9-10034-R
100	34	9,5	3,0	30 DKN	IMA, Brandt	41650-9-10034-L
Cutting edge design asymmetrical, boss pos. 3, ND= 41 mm						
100	48	9,5	3,0	30 DKN	IMA, Brandt, SCM	41650-9-10048-R
100	48	9,5	3,0	30 DKN	IMA, Brandt, SCM	41650-9-10048-L
100	63	9,5	3,0	30 DKN	IMA, Brandt, SCM	41650-9-10063-L
Cutting edge design convex symmetrical, boss pos. 2, ND= 41 mm						
125	43	-	3,0	30 DKN	Homag, Biesse	41650-9-12543-0

- Technical details**
- * tool body made of steel
 - * nickel coated
 - * alternative shear cut
 - * JSO-tip-protector
 - * several times regrindable
- Application**
- * jointing of classically panel materials. With or without feed on edge banding machines
- Special advantages**
- * JSO-tip protector support the chip flow and has positive effects on the life time

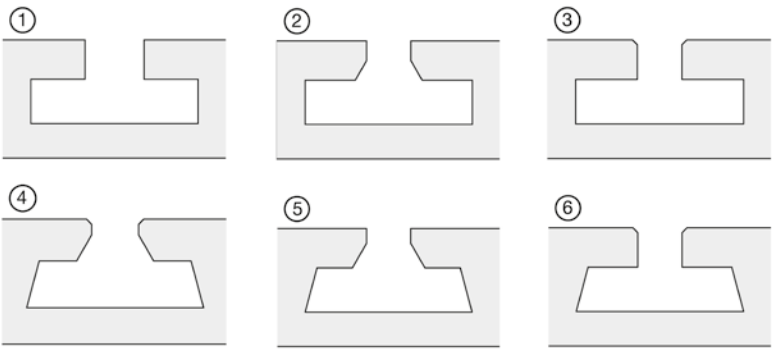


16020 T-slot router cutter Z2+1

- Technical details**
- * on large diameter (D) two straight or bevelled pcd cutting edges
 - * cutting on periphery, top and bottom, with or without shear angle
 - * on small diameter (d) one straight or profiled pcd cutting edge, with or without shear angle
 - * on request with length adjusting screw on shank
- Application**
- * for machining T-slots in classically wood composites and plastics
 - * for use in mechanical - and / or manual feed
- On demand**
- Order information: Dimensions as per drawing or cad-datas



Examples of profiles



16035 PCD profile router cutter Z3 (nesting)

- Technical details**
- * on large diameter (D) three continous pcd cutting edges for edge rounding, bevelling or profiling, with shear angle
 - * on small diameter (d) three helically wings, fully tipped (Z=3)
 - * several times regrindable
- Application**
- * for severing and simultaneous profiling of classically wood composites and plastics on nesting machines
 - * diameter, cutting edge layout and edge geometry will be determined corresponding to profile, material thickness (h), R.P.M. and feed rate for optimum performance
 - * for use in mechanical feed, righthand rotation
- Special advantages**
- * minimised cutting force and feed force
- On demand**
- Order information: Dimensions as per drawing or cad-datas

