

CNC TOOLING

CATALOG



1954
foundation
of the Ledermann & Co. production site in Horb a.N

carbide-tipped tools for metal working, automotive
engineering and machine construction

1956
brazed tools for milling and drilling in
wood and plastic

introduction of the LEUCO hol-
low-ground circular saw blade

1957
Segment Hogger for stepped
cut and circular cut

1962
first cutterhead with HW turnover
knives for wood and plastic

1966
introduction LEUCOMAT (grinding machine)

Jointing / Chamfering Cutterhead with 12
mm turnover knife and with or without spurs

THAT'S LEUCO!

The company Ledermann & Co. was founded in 1954 by Willi Ledermann and Josef Störzer in Horb am Neckar / Germany. The LEUCO brand was born.

Today, almost 60 years later, LEUCO is one of the world's largest suppliers of carbide and diamond-tipped machine tools for wood and plastic processing. Wealth of ideas and technical know-how have been the heart of LEUCO since the beginning. The product range includes circular saw blades, hoggers, bore-type and shank-type cutters, drills, clamping systems and inserts.

Sharpening service, application consulting and service packages bundled under the term „Tool management“ complete the spectrum. LEUCO sells via direct sales. Our customers are sawmills, building-, furniture- and paneling-industry as well as interior finishing.

Internationally, around 1,100 employees work for LEUCO. Sales affiliates are in Australia, Belgium, England, Japan, Malaysia, Poland, Russia, Singapore, Thailand, Ukraine, USA and Belarus. Sales and production subsidiaries are in China, France, Switzerland and South Africa.



1973
synchronously adjustable
jointing and pre-milling cutterhead

1975
s-System for Circular Saw Blades and Hoggers

Scoring Saw Blade
D192 and D110

LEUCO is the first tool manufacturer to
present diamond tools on the LIGNA



1979
Leuco Tool Corporation U.S Opened
Cylinder Boring Bit with turnover knives

1983
Leuco Tool Corporation Illinois opened
SuperProfiler with bore



1985
Clamping chuck ps-System

1987
Diamond Saw Blade

SERVICE



AS GOOD AS NEW: EXCELLENT RESHARPENING SERVICE

As a premium manufacturer, we know cutting materials and cutting edge geometries vary and have access to the original data. Among others, LEUCO offers carbide-tipped tools with different carbide grades and thus meets the application like no other. As a manufacturer, LEUCO has the know-how for the best service.

In addition, the excellent LEUCO sharpening service is characterized by:

- | well-trained, knowledgeable LEUCO employees
- | the most modern high-tech systems in the company service centers
- | availability of your tools based on strict sharpening schedules

LEUCO diamond and carbide service:

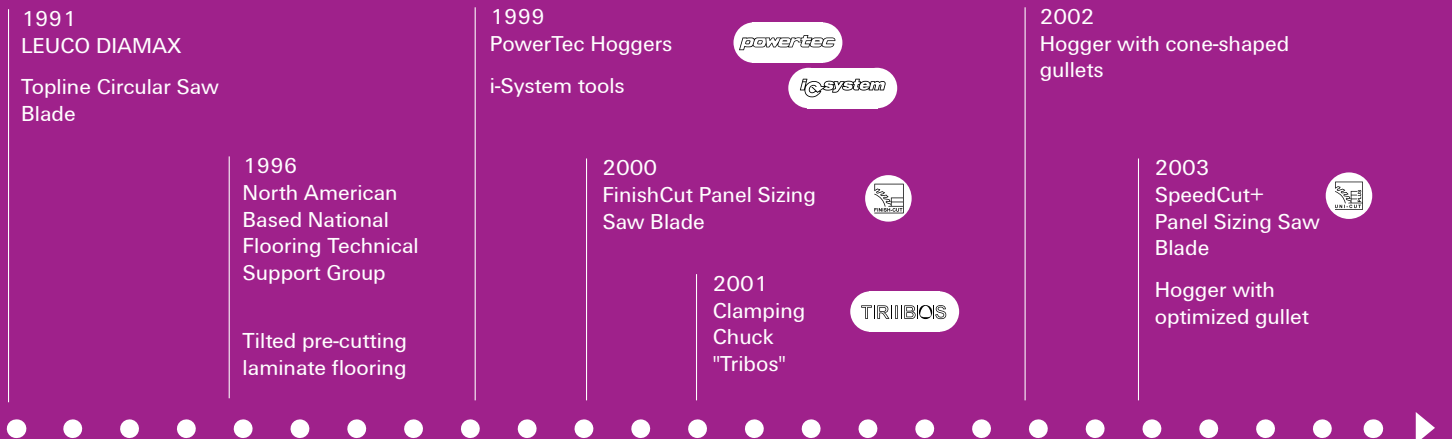
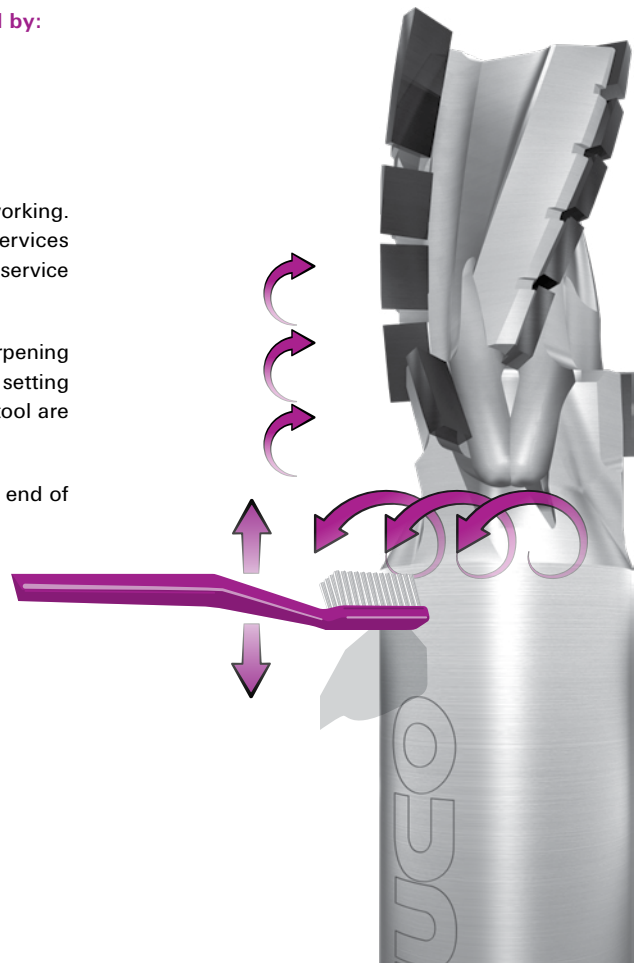
The maintenance of quality tools is necessary for optimal results in woodworking. This is satisfied with a worldwide network of specialists and sharpening services that put your tools back in shape. Our pickup and delivery service has its own service network covering your area as well.

As a quality-aware tool manufacturer we repair all of your tools. Whether sharpening all tooth geometries, tooth replacement, adjustment, alignment, eroding and setting - the precision and quality required, throughout the entire life-span of the tool are the factors in measuring the work of our LEUCO Service Team.

Please find the contact info of your qualified LEUCO service partner at the end of the catalog or give us a call: +800.631.0096

**"GOOD SERVICE IS NOT JUST SMILING
AT THE CUSTOMER, BUT MAKING THE
CUSTOMER SMILE."**

**THIS IS WHAT WE STRIVE FOR...
TO WIN YOUR SMILE!"**





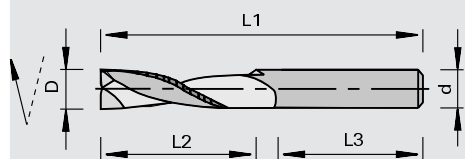
 SOLID WOOD	 Saw mills	 Beams and jointed goods	 Boards and planed goods	 Staircase construction	 Parquet	 Doors	 Solid wood furniture
 WOOD-BASED MATERIALS	 Kitchen	 Office furniture	 Laminate	INDUSTRY KNOW HOW RANGE OF APPLICATIONS LEUCO tools are used in the whole process chain of the woodworking and furniture industry, from the original material to the end product. The tools are perfectly adapted to the application parameters, performance data, processing sequences and demands of the different industry segments.			
 NON WOOD	 Aluminum	 Facade materials	 Composite materials				

2005 Topcoat Saw Blade coating NF Diamond Saw Blade	2006 Power DIA Profiler	2007 g5 Sizing Saw Blade (for excellent cutting)	2008 Solid Tungsten Carbide High-Performance Drill Bit	2010 LEUCO p-System tools PowerTec III Hoggers	2011 Aerodynamic LowNoise Jointing Cutters	2013 LEUCO High Performance Spirals LEUCO g5-System Saw Blades and Grooving Cutters with a tooth group combination of 5 teeth: noise reduced, low cutting pressure, excellent cutting quality

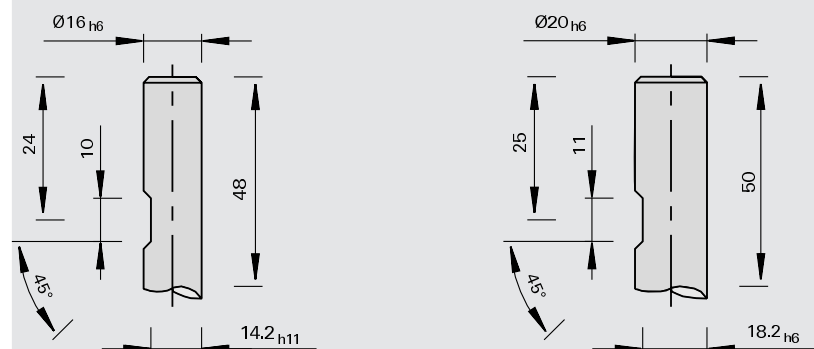
Solid Tungsten Carbide Shank-Type Cutters

Shank design for finishing cutter with chip breakers Class-No. 129460

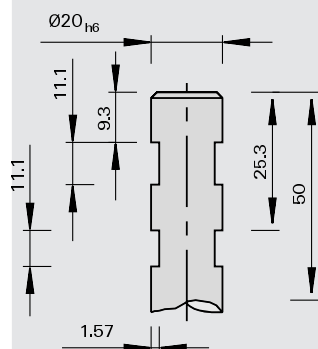
Cylindrical shank without clamping surface



For clamping in spacer sleeves according to DIN 6359 also called Weldon chuck

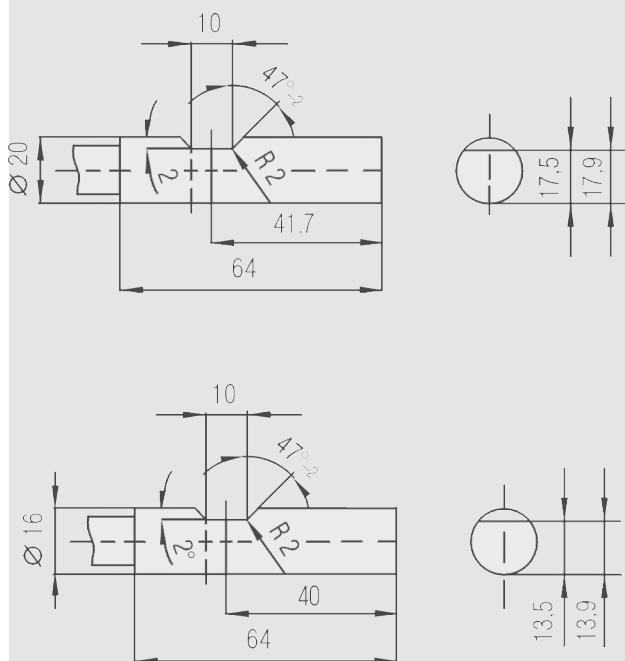


For clamping in special clamping chucks by MAKAL

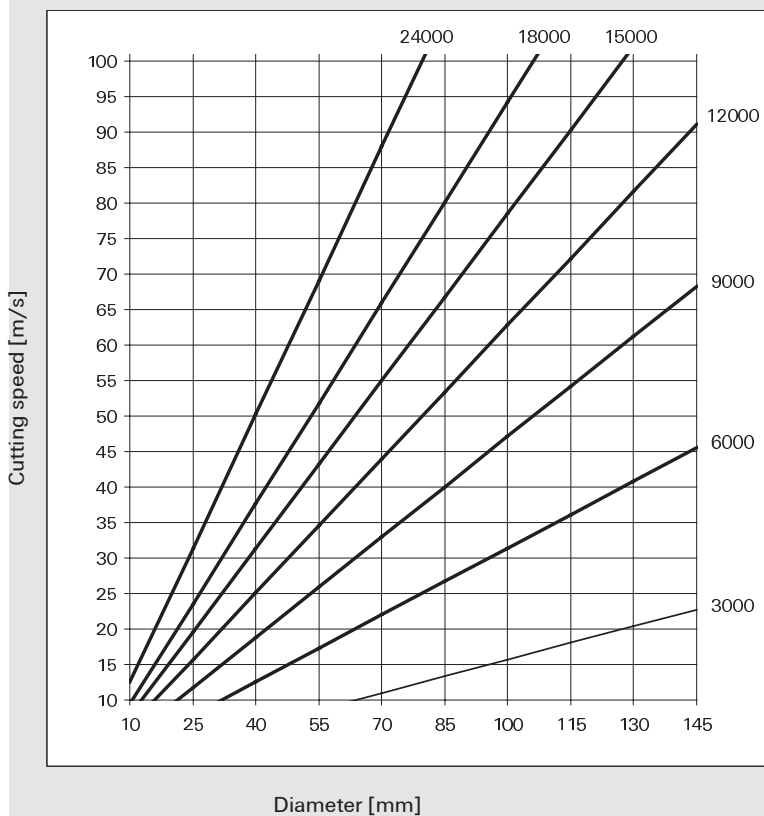


Clamping surface on Shank-Type Cutters

Particularly for solid carbide Lock-Case Cutters used in horizontal drilling/-milling aggregates of Homag and Weeke.



Determination of RPM [min-1]

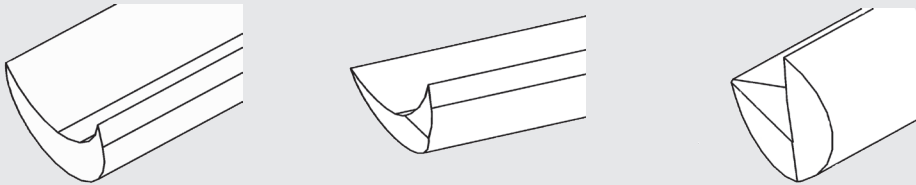


Wood Router Technical Information

Straight Flute Vs. Spiral Routers

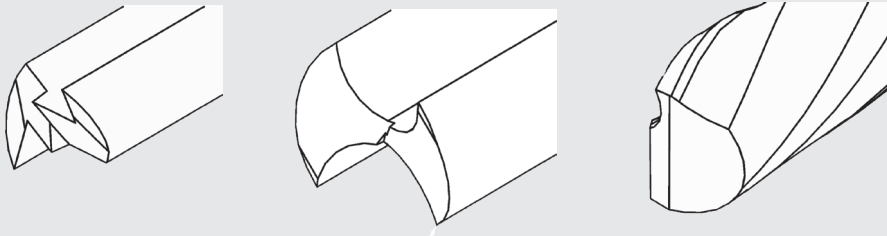
Straight flute router bits are generally used for routing plastics, and other soft materials. They are a great choice for hand feed operations. Spiral flute router bits should only be used in automatic feed operations. They are good for use on all materials.

Crescent Point



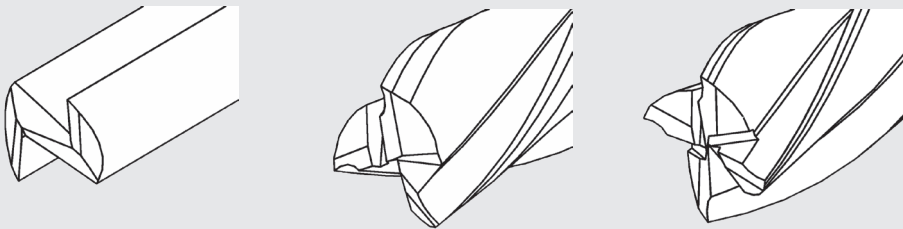
Crescent points are typically found on 1 flute router bits. They are good for both plunging, and flat bottom cutting.

Fishtail Point



Fishtail points are the most commonly seen end points in the wood router industry. They are perfect when a rigid plunge point is required.

Endmill Point



Endmill points are most often found on 3 and 4 flute routers. They are good for achieving smooth finish on flat bottom surface, and are commonly used in the plastic routing industry.

Flute Types

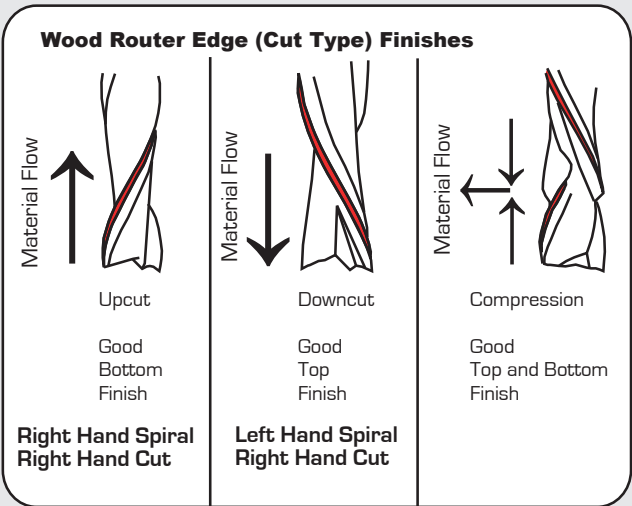
- 1 Flute routers are a good choice for soft materials. They provide a good finish, and are capable of faster feed rates.
- 2 Flute routers work well with harder materials, providing an excellent finish to the material.

Upcut, Downcut, and Compression Bits

Upcut routers are used when a good bottom finish is desired on the material. Chip flow in an upward direction.

Downcut routers produce the best finish to the top of the material. Chip flow in a downward direction.

Compression routers are best used when both top, and bottom finish are important. They are best used with material that has laminate on both the top, and bottom. Chip flow in a sideways direction.



Wood Router Material Usage and Feed Rates

Based on 18,000 RPM Feed Rate in "Inches" per minute

Tool Description	Soft Woods	Hard Woods	Soft Plywood	Hard Plywood Board	Particle Board	Laminate Particle Plastics	Laminate Plywood Plastics	Soft Ductile Plastics	Hard Brittle Material	Fiber Reinforced Material	Solid Surface	Plastic Laminated	Aluminum
1 FLUTE ROUTERS													
Straight "V" Flute	100-300	100-250	100-250	100-250	100-250								
Straight "O" Flute	100-300							350	300				
Straight "O" Flute (Soft or Hard Plastics)								350	300				
Upcut Spiral	150-300	150-300			150-300								
"O" Flute Upcut Spiral (Soft Plastics)									200		100-180		
Upcut Spiral (Hard Plastics & Aluminum)										100			150
"O" Flute Downcut Spiral (Hard Plastics)								150	150		150-180		
Downcut Spiral	150-300	150-300			150-300								
"O" Flute Downcut Spiral (Hard Plastics)	150-300	150-300			150-300								
Downcut Spiral (Hard Plastics & Aluminum)										150			100
"O" Flute Downcut Spiral (Soft Plastics)								150	150		100-180		
Compression Spiral	100-600	100-600	100-600	100-600	100-500	100-600	100-600						
Mortise (Compression Spiral)	100-600	100-600	100-600	100-600	100-500	100-600	100-600						

2 FLUTE ROUTERS													
Straight Cut (Natural Wood & Hard Plastics)	200-400	200-400	200-400	200-400	200-400								
Straight Cut (Hard Plastics)									250	150			
"O" Flute Straight Cut (Soft Plastics)									250	150	150-200		
"O" Flute Straight Cut (Hard Plastics)									250	150	150-200		
Upcut Spiral	200-450	200-400			200-450			200			150-200		
Upcut Spiral (Hard Plastics & Aluminum)										150	150-200		150
Upcut Spiral (High Impact)	200-450	200-400			200-450								
"O" Flute Upcut Slow Spiral (Soft & Hard Plastics)								275	250		150		
Upcut Spiral Chipbreaker Finisher	400-1500	400-1200	400-1400	400-1200	400-1000								
Upcut Spiral Chipbreaker Finisher (High Impact)	400-1500	400-1200	400-1400	400-1200	400-1000								
Downcut Spiral	200-450	200-400			200-450						150-200		
Downcut Spiral (Hard Plastic & Aluminum)										150	150-200		150
Downcut Slow Spiral (Hard Plastic & Aluminum)								300	275		150		
Downcut Spiral (High Impact)	200-450	200-400			200-450								
Downcut Spiral Chipbreaker Finisher	400-1500	400-1200	400-1400	400-1200	400-1000								
Downcut Spiral Chipbreaker Finisher (High Impact)	400-1500	400-1200	400-1400	400-1200	400-1000								
Compression	400-1200	400-1000	400-1200	400-1000	400-800	400-1200	400-1000						
Chipbreaker Finisher Compression	400-1500	400-1200	400-1400	400-1200	400-1000	400-1400	400-1200						
Compression (High Wear)	400-1200	400-1000	400-1200	400-1000	400-800	400-1200	400-1000						



Material Usage and Feed Rates Continued

Based on 18,000 RPM Feed Rate in “Inches” per minute

Tool Description	Soft Woods	Hard Woods	Soft Plywood	Hard Plywood Board	Particle Board	Laminate Particle Plastics	Laminate Plywood Plastics	Soft Ductile Plastics	Hard Brittle Material	Fiber Reinforced Material	Solid Surface	Plastic Laminated	Aluminum
3 FLUTE ROUTERS													
Upcut Slow Spiral Finisher	200-600	200-500			200-500				300		100-300		
Downcut Slow Spiral Finisher (Soft Plastics)	200-600	200-500			200-500				300		100-300		
Upcut Spiral Chipbreaker Finisher	500-1600	500-1500	700-1800	700-1600	600-1200								
Downcut Spiral Chipbreaker Finisher	500-1600	500-1500	700-1800	700-1600	600-1201								
Upcut Spiral (Hard Plastics)										150			
Upcut Spiral Helix Ripper	700-1200	700-1200	700-1500	700-1500	600-1500								
Upcut Spiral High Helix Ripper	700-1200	700-1200	700-1500	700-1500	600-1500								
Upcut Spiral Hogger (High Impact)	700-1200	700-1200	700-1500	700-1500	600-1500								
Downcut Spiral (Hard Plastics)										150			
Downcut Slow Spiral Helix Ripper	700-1200	700-1200	700-1500	700-1500	600-1500								
Downcut Slow Spiral High Helix Ripper	700-1200	700-1200	700-1500	700-1500	600-1500								
Downcut Spiral Hogger (High Impact)	700-1200	700-1200	700-1500	700-1500	600-1500								
Compression	400-1200	400-1000	400-1200	400-1000	400-800	400-1200	400-1000						
Compression (High Wear)	400-1200	400-1000	400-1200	400-1000	400-800	400-1200	400-1000						
Mortise Compression	400-1200	400-1000	400-1200	400-1000	400-800	400-1200	400-1000						

4 FLUTE ROUTERS

Upcut Spiral (Hard Plastics)										100-300			
Upcut Combination Spiral (High Speed)	1000-1800	1000-1800	1200-3000	1200-2800	1000-2000								
Downcut Spiral (Hard Plastics)										150			
Downcut Combination Spiral (High Speed)	1000-1800	1000-1800	1200-3000	700-2200	1200-2800								
Compression	500-1600	500-1500	700-2400	700-2200	600-1800	700-2400	700-2200						
Combination Compression	1000-1800	1000-1800	1200-3000	1200-2800	1000-2000	1200-3000	1200-2800						
Mortise Compression	800-1600	500-1500	700-2400	700-2200	600-1600	700-2400	700-2200						

SPECIALTY TOOLS

Diamond Burr Fiberglass Finisher (Hard Plastics)										125			
2 Flute Diamond Burr Fiberglass Finisher (Hard Plastics)										125			
Flush Trim Laminate Bit (Plastic Laminate)										hand feed			
7° Bevel Laminate Bit (Plastic Laminate)										hand feed			

HP+ Compression Spirals

Product



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DUR

Tungsten Carbide (HM)

MAN / MECH

Machine / Application

| CNC Routers
 | sizing, jointing, grooving and dividing
 in raw and laminated panel materials
 | for cutting of openings and contours
 | traveling plunge cut using Z and
 X or Y axis

Design

| n max 30,000 min-1
 | solid carbide
 | helix angle: 30°
 | end point type: endmill
 | multiple shear configurations
 available to best suit the
 application

Advantages

| maximum edgelifelife thanks to
 superior ultra hard carbide
 | high rates of feed and best
 quality thanks to helical
 geometry

Notes

| improve performance by
 using precision clamping
 systems like: Heatshrink,
 PS-System and Sino.
 | also suited for use in
 mechanical draw-in collet
 chucks



Compression Spirals (mm)

OD	CEL (total)	CEL (up-cut)	SHK OD	OAL	Z	Rotation	Type	Ident-No.
5mm	25mm	8mm	6mm	80mm	2+2	RH	Compression	80506045
6mm	25mm	8mm	6mm	80mm	2+2	RH	Compression	80506046
8mm	25mm	8mm	8mm	80mm	2+2	RH	Compression	80506047
9.525mm	22mm	9.525mm	9.525mm	75mm	3+3	RH	Compression	80499333
10mm	22mm	10mm	10mm	75mm	3+3	RH	Compression	80499332
10mm	22mm	10mm	10mm	80mm	2+2	RH	Compression	80504455
10mm	22mm	10mm	10mm	80mm	3+3	RH	Compression	80504456
10mm	28mm	10mm	10mm	80mm	3+3	RH	Compression	80504457
10mm	32mm	10mm	10mm	90mm	2+2	RH	Compression	80504458
12mm	28mm	10mm	12mm	90mm	2+2	RH	Compression	80506696

Compression Spirals (inch)

OD	CEL (total)	CEL (up-cut)	SHK OD	OAL	Z	Rotation	Type	Ident-No.	
1/4"	7/8"	.250"	1/4"	2 - 1/2"	2+2	RH	Compression	80507805	S
3/8"	1 - 1/8"	.240"	3/8"	3"	2+2	RH	Compression w/chip-breaker	80504596	S
3/8"	1 - 1/8"	.375"	3/8"	3"	2+2	RH	Compression	80498760	S
1/2"	1 - 1/4"	.375"	1/2"	3 - 1/2"	3+3	RH	Compression	80507806	
1/2"	1 - 1/8"	.375"	1/2"	3 - 1/2"	2+2	RH	Compression	80507807	
1/2"	1 - 3/8"	.640"	1/2"	3 - 1/2"	2+2	RH	Compression	80498762	S
1/2"	1 - 3/8"	11mm	1/2"	3 - 1/2"	2+2	RH	Compression	80507808	
1/2"	45mm	.640"	1/2"	4"	2+2	RH	Compression	80504608	

HP+ Mortise Compression Spirals

Product



Machine / Application

- | CNC Routers
- | sizing, jointing, grooving and dividing in raw and laminated panel materials
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | n max 30,000 min-1
- | solid carbide
- | helix angle: 30°
- | end point type: endmill
- | multiple shear configurations available to best suit the application

Advantages

- | maximum edgelife thanks to superior ultra hard carbide
- | high rates of feed and best quality thanks to helical geometry

LEUCO



Tungsten Carbide (HM)

MAN / MECH

Notes

- | improve performance by using precision clamping systems like: Heatshrink, PS-System and Sino.
- | also suited for use in mechanical draw-in collet chucks

OD	CEL (total)	CEL (up-cut)	SHK OD	OAL	Z	Rotation	Type	Ident-No.	
3/8"	1 - 1/8"	.200"	3/8"	3"	2+2	RH	Mortise Compression	80498759	S
3/8"	1 - 1/8"	.200"	3/8"	3 - 1/2"	2+2	RH	Mortise Compression	80487924	S
3/8"	1 - 1/8"	.200"	3/8"	3 - 1/2"	3+3	RH	Mortise Compression	80497158	
3/8"	1 - 1/8"	.188"	3/8"	3"	2+2	RH	Mortise Compression	80497015	
3/8"	1 - 1/8"	.185"	3/8"	3"	2+2	RH	Mortise Compression	80497014	
1/2"	1 - 3/8"	.200"	1/2"	3 - 1/2"	2+2	RH	Mortise Compression	80493378	S
1/2"	1 - 3/8"	.200"	1/2"	3 - 1/2"	3+3	RH	Mortise Compression	80497159	S
1/2"	1 - 5/8"	.200"	1/2"	3 - 1/2"	2+2	RH	Mortise Compression	80508520	
1/2"	45mm	.200"	1/2"	4"	2+2	RH	Mortise Compression	80504609	

HP+ Downcut Spirals

Product



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Tungsten Carbide (HM)

MAN / MECH

Machine / Application - CNC Routers - sizing, jointing, grooving and dividing in raw and laminated panel materials - for cutting of openings and contours - traveling plunge cut using Z and X or Y axis	Design - n max 30,000 min-1 - solid carbide - helix angle: 30° - end point type: endmill - multiple shear configurations available to best suit the application	Advantages - maximum edgelife thanks to superior ultra hard carbide - high rates of feed and best quality thanks to helical geometry	Notes - improve performance by using precision clamping systems like: Heatshrink, PS-System and Sino. - also suited for use in mechanical draw-in collet chucks
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OD	CEL (total)	CEL (up-cut)	SHK OD	OAL	Z	Rotation	Type	Ident-No.	
1/4"	7/8"	N/A	1/4"	2 - 1/2"	2"	RH	Downcut	80499369	S
3/8"	1"	N/A	3/8"	3"	2"	RH	Downcut	80498761	S
1/2"	1 - 1/2"	N/A	1/2"	3 - 1/2"	2"	RH	Downcut	80498763	S



Industrial Grade Spirals

Product



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Tungsten Carbide (HM)

MAN / MECH

Machine / Application

| CNC Routers
 | sizing, jointing, grooving and dividing
 | in raw and laminated panel materials
 | for cutting of openings and contours
 | traveling plunge cut using Z and
 | X or Y axis

Design

| n max 30,000 min-1
 | solid carbide
 | helix angle: 30°
 | end point type: endmill
 | multiple shear configurations
 | available to best suit the
 | application

Advantages

| extended edge life and
 | dependable performance
 | for demanding production
 | environments.
 | optimized geometry delivers
 | excellent feed rates, clean
 | finishes, and reliable
 | everyday durability.

Notes

| improve performance by
 | using precision clamping
 | systems like: Heatshrink,
 | PS-System and Sino.
 | also suited for use in
 | mechanical draw-in collet
 | chucks



Compression

OD	CEL (total)	CEL (up-cut)	SHK OD	OAL	Z	Rotation	Type	Ident-No.
1/4"	7/8"	.250"	1/4"	2 1/2"	2+2	RH	Compression	
3/8"	1 - 1/8"	.375"	3/8"	3 1/2"	2+2	RH	Compression	80483846
3/8"	1 - 1/8"	.200"	3/8"	3 1/2"	3+3	RH	Compression	
1/2"	1 - 3/8"	.640"	1/2"	3 1/2"	2+2	RH	Compression	80483850

Mortise Compression

OD	CEL (total)	CEL (up-cut)	SHK OD	OAL	Z	Rotation	Type	Ident-No.
3/8"	1 - 1/8"	.200"	3/8"	3"	2+2	RH	Mortise Compression	
3/8"	1 - 1/8"	.200"	3/8"	3 1/2"	2+2	RH	Mortise Compression	80483845
1/2"	1 - 3/8"	.200"	1/2"	3 1/2"	2+2	RH	Mortise Compression	80483849

Downcut

OD	CEL (total)	CEL (up-cut)	SHK OD	OAL	Z	Rotation	Type	Ident-No.
1/4"	7/8"		1/4"	2 1/2"	2	RH	Downcut	
3/8"	1"	.375	3/8"	3"	2	RH	Downcut	80501003
1/2"	1 - 1/8"		1/2"	3 1/2"	2	RH	Downcut	80483851

129460
Standard Compression Spiral

Product

Drawing



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Tungsten Carbide (HM)

MAN / MECH

Machine / Application	Design	Advantages	Notes
- l CNC Routers - l sizing, jointing and dividing in raw and laminated panel materials - l for cutting of openings and contours - l traveling plunge cut using Z and X or Y axis	- l n max 30,000 min-1 - l solid carbide - l helix angle: 30° - l end point type: crescent	- l excellent finish on top and bottom of the material - l high rates of feed and best quality thanks to helical geometry	- l improve performance by using precision clamping systems like: PS-System and Sino. - l also suited for use in mechanical draw-in collet chucks

O D	CEL	SHK	OAL	Z	Ident-No Left Hand	Ident-No.
1/8	3/8	1/4	2-1/2	1+1		1724906
3/16	5/8	1/4	2-1/2	1+1		1721269
1/4	7/8	1/4	2-1/2	1+1		500034
3/8	1-1/8	3/8	3	1+1		500028
1/2	1	1/2	3	1+1		500031
1/2	1-1/8	1/2	3	1+1		1720712
1/2	1-3/8	1/2	3-1/2	1+1		1721372
1/2	1-5/8	1/2	3-1/2	1+1	500037	500029
5/8	2-1/4	5/8	4	1+1		500038
3/4	2	3/4	4	1+1		500030

129460
Standard Compression Hard Surface Spiral

Product

Drawing



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DUR

Tungsten Carbide (HM)

MAN / MECH

Machine / Application	Design	Advantages	Notes
- l CNC Routers - l sizing, jointing and dividing in raw and laminated panel materials - l for cutting of openings and contours - l traveling plunge cut using Z and X or Y axis	- l n max 30,000 min-1 - l solid carbide - l helix angle: 30° - l end point type: crescent	- l excellent finish on top and bottom of the material - l high rates of feed and best quality thanks to helical geometry	- l improve performance by using precision clamping systems like: PS-System and Sino. - l also suited for use in mechanical draw-in collet chucks

OD	CEL	SHK	OAL	Z	Ident-No.
1/2	1	1/2	3	1+1	1731169

129460

Standard Mortise Compression Spiral

Product

Drawing



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DUR

Tungsten Carbide (HM)

MAN / MECH

Machine / Application

- CNC Routers
- sizing, jointing, grooving and dividing in raw and laminated panel materials
- for cutting of openings and contours
- traveling plunge cut using Z and X or Y axis

Design

- short upshear for grooving applications
- n max 30,000 min-1
- solid carbide
- helix angle: 30°
- end point type: cresent

Advantages

- excellent finish on top and bottom of the material
- high rates of feed and best quality thanks to helical geometry

Notes

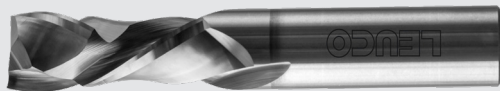
- improve performance by using precision clamping systems like: PS-System and Sino.
- also suited for use in mechanical draw-in collet chucks

O D	CEL	Mortise	SHK	OAL	Z	Ident-No.
1/4	7/8	.175	1/4	2-1/2	1+1	1738630
3/8	7/8	.188	3/8	3	1+1	1721270
1/2	7/8	.200	1/2	3	1+1	1721287
1/2	1-5/8	.200	1/2	3-1/2	1+1	1722167



129460

Standard Compression Spiral



LEUCO



Tungsten Carbide (HM)

MAN / MECH

Machine / Application

- l CNC Routers
- l sizing, jointing and dividing in raw and laminated panel materials
- l for cutting of openings and contours
- l traveling plunge cut using Z and X or Y axis

Design

- l n max 30,000 min-1
- l solid carbide
- l helix angle: 30°
- l end point type: endmill

Advantages

- l excellent finish on top and bottom of material
- l high rates of feed and best quality thanks to helical geometry

Notes

- l improve performance by using precision clamping systems like: PS-System and Sino.
- l also suited for use in mechanical draw-in collet chucks

O D	CEL	SHK	OAL	Z	Ident-No. Left Hand	Ident-No.
1/4	7/8	1/4	2-1/2	2+2		1721351
3/8	1-1/8	3/8	3	2+2		80385992
1/2	1	1/2	3	2+2		500039
1/2	1-1/8	1/2	3	2+2		1725980
1/2	1-5/16	1/2	3	2+2		1727268
1/2	1-3/8	1/2	3-1/2	2+2		500059
1/2	1-5/8	1/2	4	2+2		1720542
5/8	2-1/4	5/8	5	2+2	80340354	80385996
3/4	1-7/8	3/4	4	2+2		1720404
3/4	2-1/2	3/4	5	2+2		80401327
3/4	3-1/4	3/4	6	2+2		80364788

129460

Standard Mortise Compression Spiral

Product

Drawing



LEUCO

LEUCO
DUR

Tungsten Carbide (HM)

MAN / MECH

Machine / Application

- l CNC Routers
- l sizing, jointing, grooving and dividing in raw and laminated panel materials
- l for cutting of openings and contours
- l traveling plunge cut using Z and X or Y axis

Design

- l short upshear for grooving applications
- l n max 30,000 min-1
- l solid carbide
- l helix angle: 30°
- l end point type: endmill

Advantages

- l excellent finish on top and bottom of material
- l high rates of feed and best quality thanks to helical geometry

Notes

- l improve performance by using precision clamping systems like: PS-System and Sino.
- l also suited for use in mechanical draw-in collet chucks

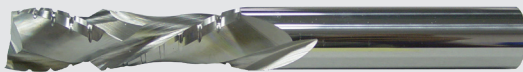
O D	CEL	Mortise	SHK	OAL	Z	Ident-No (LH)	Ident-No.(RH)
1/4	7/8	.188	1/4	2-1/2	2+2		80378789
3/8	7/8	.188	3/8	3	2+2		1727198
3/8	1-1/8	.188	3/8	3	2+2	1741175	1728997
1/2	7/8	.200	1/2	3	2+2		1722001
1/2	1-3/8	.200	1/2	3-1/2	2+2		80375417

Standard Chipbreaker Finisher Compression Spiral

129460

Product

Drawing



LEUCO

LEUCO
DUR

Tungsten Carbide (HM)

MAN / MECH

Machine / Application

- l CNC Routers
- l sizing, jointing and dividing in raw and laminated panel materials
- l for cutting of openings and contours
- l traveling plunge cut using Z and X or Y axis

Design

- l n max 30,000 min-1
- l solid carbide
- l helix angle: 30°
- l end point type: endmill

Advantages

- l excellent finish on top and bottom of material
- l high rates of feed and best quality thanks to helical geometry

Notes

- l improve performance by using precision clamping systems like: PS-System and Sino.
- l also suited for use in mechanical draw-in collet chucks

O D	CEL	SHK	OAL	Z	Ident-No.
3/8	7/8	3/8	3	2+2	1731188
3/8	1-1/8	3/8	3	2+2	1723614
1/2	1	1/2	3	2+2	1739164
1/2	1-1/8	1/2	3	2+2	1723554
1/2	1-3/8	1/2	3-1/2	2+2	1721299
1/2	1-5/8	1/2	4	2+2	1723221
5/8	2-1/4	5/8	5	2+2	1731190

129460

Standard Straight Cut (Natural Wood and Hard Plastics)

Product

Drawing



LEUCO

LEUCO
DUR

Tungsten Carbide (HM)

MAN / MECH

Machine / Application

| CNC Routers
 | sizing, jointing, grooving and
 dividing in raw and laminated
 panel materials
 | for cutting of openings and
 contours
 | traveling plunge cut using Z
 and X or Y axis

Design

| n max 30,000 min-1
 | solid carbide
 | end point type: fishtail

Advantages

| good finish on top and bottom
 of the material

Notes

| improve performance by using
 precision clamping systems
 like: PS-System and Sino.
 | also suited for use in mechani-
 cal draw-in collet chucks

O D	CEL	SHK	OAL	Z	Comments	Ident-No.
1/8	1/2	1/4	2	2		1720534
5/32	5/8	1/4	2	2		1723266
3/16	3/4	1/4	2	2		1721079
7/32	3/4	1/4	2-1/2	2		1723372
1/4	7/8	1/4	2-1/2	2		1722023
1/4	7/8	1/4	2-1/2	2		1731106
1/4	1	1/4	2-1/2	2		1721699
1/4	1-1/8	1/4	3	2		1720533
9/32	1	5/16	2-1/2	2		1721443
5/16	1-1/8	5/16	3	2		1721300
5/16	1-1/8	1/2	3	2		288616
3/8	1-1/8	3/8	3	2		1723267
3/8	1-1/4	3/8	3	2		1724406
3/8	1-1/4	1/2	3	2		1723686
7/16	1	1/2	3	2		1722640
1/2	1-1/8	1/2	3	2		1720634
1/2	1-1/4	1/2	3-1/2	2		1720532
1/2	1-5/8	1/2	3-1/2	2		1720635
17/32	1-1/8	1/2	3	2		1731107
5/8	2-1/8	5/8	4	2		1731108
3/4	1-5/8	3/4	4	2		1724664

129460

Standard Upcut Spiral

Product

Drawing



LEUCO

LEUCO
DUR

Tungsten Carbide (HM)

MAN / MECH

Machine / Application

- CNC Routers
- sizing, jointing and dividing in raw and laminated panel materials
- for cutting of openings and contours
- traveling plunge cut using Z and X or Y axis

Design

- n max 30,000 min-1
- solid carbide
- helix angle: 30°
- end point type: fishtail

Advantages

- excellent finish on bottom of material
- poor finish on top of material
- high rates of feed and best quality thanks to helical geometry

Notes

- improve performance by using precision clamping systems like: PS-System and Sino.
- also suited for use in mechanical draw-in collet chucks

O D	CEL	SHK	OAL	Z	Comments	Ident-No (LH)	Ident-No.(RH)
1/8	1/2	1/4	2	2		1722193	1727416
5/32	1/2	1/4	2-1/2	2			1731131
5/32	5/8	1/4	2	2			500002
3/16	3/4	3/16	2	2			500003
3/16	3/4	1/4	2	2		1731134	500004
3/16	3/4	1/4	2-1/2	2			1723282
7/32	3/4	1/4	2-1/2	2			1730085
7/32	1	1/4	2-1/2	2			1731133
1/4	7/8	1/4	2-1/2	2			500006
1/4	1	1/4	2-1/2	2		1731136	500008
1/4	1-1/8	1/4	3	2			1720570
9/32	1	5/16	2-1/2	2			1730087
5/16	1-1/8	5/16	3	2			500010
5/16	1-1/4	5/16	3	2			1731137
5/16	1-1/8	1/2	3	2		1731138	500012
3/8	1	3/8	3	2			1722307
3/8	1-1/8	3/8	3	2			500014
3/8	1-1/4	3/8	3	2		1731139	1721019
3/8	1-1/4	1/2	3	2			500016
7/16	1	1/2	3	2			1721487
1/2	1-1/8	1/2	3	2			500018
1/2	1-1/4	1/2	3-1/2	2			1720572
1/2	1-5/8	1/2	3-1/2	2		1722535	500020
1/2	2-1/8	1/2	4	2			500022
17/32	1-1/8	1/2	3	2			1731140
5/8	1-5/8	5/8	3-1/2	2			1730063
5/8	2-1/8	5/8	4	2		1731141	500024
3/4	1-5/8	3/4	4	2			1720732
3/4	2-1/8	3/4	4	2		1731142	500026
1	3	1	5	2			1731143



129460

Standard Upcut Spiral (Hard Plastics and Aluminum)

Product

Drawing



LEUCO

LEUCO
DUR

Tungsten Carbide (HM)

MAN / MECH

Machine / Application

| CNC Routers
 | sizing, jointing and dividing in
 | hard plastics and aluminum
 | for cutting of openings and
 | contours
 | traveling plunge cut using Z
 | and X or Y axis

Design

| n max 30,000 min-1
 | solid carbide
 | helix angle: 30°
 | end point type: endmill

Advantages

| excellent finish on bottom of
 | material
 | poor finish on top of material
 | high rates of feed and best
 | quality thanks to helical
 | geometry

Notes

| improve performance by using
 | precision clamping systems
 | like: PS-System and Sino.
 | also suited for use in mechani-
 | cal draw-in collet chucks

O D	CEL	SHK	OAL	Z	Ident-No (LH)	Ident-No.(RH)
1/8	1/2	1/4	2	2		1722264
5/32	9/16	1/4	2	2		1722458
3/16	5/8	1/4	2	2	1731144	1721035
7/32	5/8	1/4	2-1/2	2		1730040
1/4	3/4	1/4	2-1/2	2	1731145	1720795
9/32	3/4	3/8	2-1/2	2		1731146
5/16	13/16	3/8	2-1/2	2		1720190
3/8	7/8	3/8	2-1/2	2		1722275
7/16	1	1/2	3	2		1730042
1/2	1	1/2	3	2		1721135

129460
Standard Upcut Spiral Chipbreaker Finisher

Product



Drawing

LEUCO

LEUCO
DUR

Tungsten Carbide (HM)

MAN / MECH

Machine / Application	Design	Advantages	Notes
- CNC Routers - sizing, jointing and dividing in raw and laminated panel materials - for cutting of openings and contours - traveling plunge cut using Z and X or Y axis	- n max 30,000 min-1 - solid carbide - helix angle: 30° - end point type: endmill	- excellent finish on bottom of material - poor finish on top of material - high rates of feed and best quality thanks to helical geometry	- improve performance by using precision clamping systems like: PS-System and Sino. - also suited for use in mechanical draw-in collet chucks

O D	CEL	SHK	OAL	Z	Ident-No.
3/8	1-1/8	3/8	3	2	1730003
1/2	1-1/8	1/2	3	2	1722300
1/2	1-5/8	1/2	3-1/2	2	1721356
1/2	2-1/8	1/2	4	2	1720803
1/2	1-7/8	1/2	3-1/2	2	1727333
5/8	2-1/8	5/8	4	2	1731147
3/4	2-1/8	3/4	4	2	1728819



129460

Standard Downcut Spiral

Product

Drawing



LEUCO

LEUCO
DUR

Tungsten Carbide (HM)

MAN / MECH

Machine / Application

- l CNC Routers
- l sizing, jointing, grooving and dividing in raw and laminated panel materials
- l for cutting of openings and contours
- l traveling plunge cut using Z and X or Y axis

Design

- l n max 30,000 min-1
- l solid carbide
- l helix angle: 30°
- l end point type: fishtail

Advantages

- l excellent finish on top of material
- l poor finish on bottom of material
- l high rates of feed and best quality thanks to helical geometry

Notes

- l improve performance by using precision clamping systems like: PS-System and Sino.
- l also suited for use in mechanical draw-in collet chucks

O D	CEL	SHK	OAL	Z	Ident-No. Left Hand	Ident-No.
1/8	1/2	1/8	2	2		1722686
1/8	1/2	1/4	2	2	1731166	500001
5/32	1/2	1/4	2-1/2	2		1723585
5/32	5/8	1/4	2	2		500003
3/16	3/4	3/16	2	2		1730072
3/16	3/4	1/4	2	2		500005
3/16	3/4	1/4	2	2		1731167
3/16	3/4	1/4	2-1/2	2		1723290
7/32	3/4	1/4	2-1/2	2		1727726
7/32	1	1/4	2-1/2	2		1721281
1/4	7/8	1/4	2-1/2	2		80375424
1/4	1	1/4	2-1/2	2	1722064	80375423
1/4	1-1/8	1/4	3	2		80385957
9/32	1	5/16	2-1/2	2		1720845
5/16	1-1/8	5/16	3	2		500011
5/16	1-1/4	5/16	3	2		1731168
5/16	1-1/8	1/2	3	2	1731171	500013
3/8	1	3/8	3	2		1723257
3/8	1-1/8	3/8	3	2		500015
3/8	1-1/4	3/8	3	2	1731172	1721018
3/8	1-1/4	1/2	3	2		500017
7/16	1	1/2	3	2		1721301
1/2	1-1/8	1/2	3	2		80375418
1/2	1-1/4	1/2	3-1/2	2	80375419	1720573
1/2	1-5/8	1/2	3-1/2	2		80375419
1/2	2-1/8	1/2	4	2		500023
17/32	1-1/8	1/2	3	2		1729016
5/8	1-5/8	5/8	3-1/2	2		500025
5/8	2-1/8	5/8	4	2	1731174	1731173
3/4	1-5/8	3/4	4	2		1720807
3/4	2-1/8	3/4	4	2	1731175	500027
1	3	1	5	2		1728578

129460

Standard Downcut Spiral (Hard Plastics and Aluminum)

Product

Drawing



LEUCO

LEUCO
DUR

Tungsten Carbide (HM)

MAN / MECH

Machine / Application

- l CNC Routers
- l sizing, jointing, grooving and dividing in hard plastics and aluminum materials
- l for cutting of openings and contours
- l traveling plunge cut using Z and X or Y axis

Design

- l n max 30,000 min-1
- l solid carbide
- l helix angle: 30°
- l end point type: endmill

Advantages

- l excellent finish on top of material
- l poor finish on bottom of material
- l high rates of feed and best quality thanks to helical geometry

Notes

- l improve performance by using precision clamping systems like: PS-System and Sino.
- l also suited for use in mechanical draw-in collet chucks

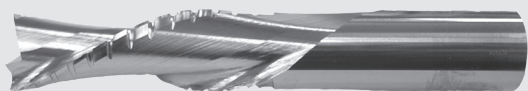
O D	CEL	SHK	OAL	Z	Ident-No.
1/8	1/2	1/4	2	2	1720577
5/32	9/16	1/4	2	2	1721277
3/16	5/8	1/4	2	2	1721683
7/32	3/4	1/4	2-1/2	2	1720837
1/4	3/4	1/4	2-1/2	2	1720578
9/32	3/4	3/8	2-1/2	2	1725587
5/16	13/16	3/8	2-1/2	2	1720191
3/8	7/8	3/8	2-1/2	2	1722253
7/16	1	1/2	3	2	1721922

129460

Standard Downcut Spiral Chipbreaker Finish

Product

Drawing



LEUCO

LEUCO
DUR

Tungsten Carbide (HM)

MAN / MECH

Machine / Application

- l CNC Routers
- l sizing, jointing, grooving and dividing in raw and laminated panel materials
- l for cutting of openings and contours
- l traveling plunge cut using Z and X or Y axis

Design

- l n max 30,000 min-1
- l solid carbide
- l helix angle: 30°
- l end point type: endmill

Advantages

- l excellent finish on top of material
- l poor finish on bottom of material
- l high rates of feed and best quality thanks to helical geometry

Notes

- l improve performance by using precision clamping systems like: PS-System and Sino.
- l also suited for use in mechanical draw-in collet chucks

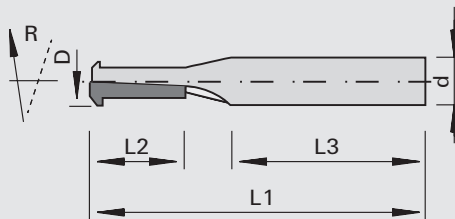
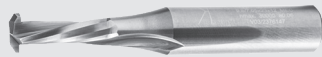
O D	CEL	SHK	OAL	Z	Ident-No.
3/8	1-1/8	3/8	3	2	1720494
1/2	1-1/8	1/2	3	2	1730265
1/2	1-5/8	1/2	3-1/2	2	1721357
1/2	1-7/8	1/2	3-1/2	2	1723655
1/2	2-1/8	1/2	4	2	1721588
5/8	2-1/8	5/8	4	2	1730610
3/4	2-1/8	3/4	4	2	1724997

129650

Profile Grooving Shank-Type Cutters VHW - for Lamello Clamex P®

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

| 5-axis CNC machines
 | for the milling of Lamello
 Clamex P® profile grooves
 | particularly for profile grooves
 to be cut into the panel surface
 further away from the panel
 edge and if the housing of the
 angular aggregate does not
 allow the use of bore type tool
 for Lamello Clamex P®

Design

| Massive solid tungsten carbide
 | Spiral design Z=2
 | TC 104 topcoat coating
 | Disposable tool
 | Not resharpenable

Advantages

| High rigidity = low vibration
 even with difficult materials
 | Low cutting pressure and good
 cutting quality thanks to spiral
 design
 | Hard coating and additionally
 low coefficient of friction for
 longer edge life

Notes

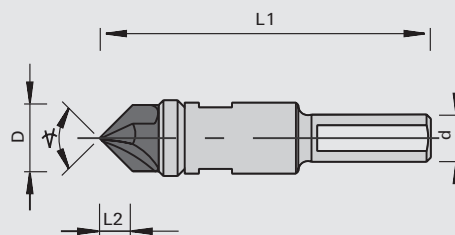
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
9.8	23	12	36	80	2	186879 L
[mm]	[mm]	[mm]	[mm]	[mm]		

130610

VHW countersink - Z=3

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

| CNC machines
 | For subsequent countersinking
 of predrilled holes
 | For use in the drilling units of
 CNC machines
 | Also suitable for milling of
 V-grooves, ornamental grooves
 and letters as well as for
 chamfering of solid wood and
 wood-based panel materials

Design

| VHW cutting head Z=3
 | Special grind
 | Shank with clamping surface
 and length adjusting screw
 | For mechanical feed
 | Righthand rotation

Advantages

| VHW cutting edge
 | Good concentricity and
 drilling properties due to special
 geometry

Notes

| recommended RPM for
 countersinking: 2,500 - 3,000
 min-1

Ø D	L2	Ø d	L1	Z	∠ of point	Ident-No.
18	9,0	10	70	3	90	80487758 L
[mm]	[mm]	[mm]	[mm]		[°]	

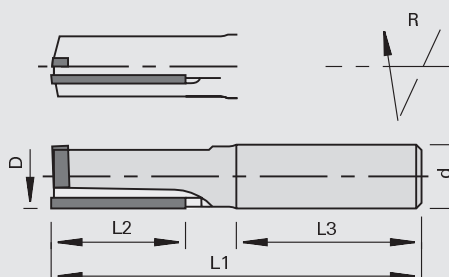
229222

DIAMAX Shank-Type Cutters DP

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for jointing and sizing without overlap marks in wood-based panels, solid woods and plastics

Design

| Polished face and high-finish clearance angle
 | With HW plunge tip for diagonal plunge-cutting (simultaneous feed using Z and X axis)
 | Ø 10 mm with plunge tip integrated in VHW body, all other diameters with brazed HW plunge tip
 | Straight cutter axis
 | Solid tungsten carbide body for Ø 5 mm to Ø 10 mm

Advantages

| high quality machining of MDF and hard woods
 | no overlap-marks thanks to continuous cutting edge
 | increased stability thanks to special design of brazing area

Notes

| Clamping elements: ps-System, TRIBOS, draw-in collet chuck
 | Ø D=12 and 16 mm with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	n _{max}	Resharpining area	Ident-No. [L]	Ident-No. [R]
5.0	12	12	40	60	1	24000	0.2		183566 L
6.0	12	12	40	60	1	24000	0.2		183567 L
8.0	12	12	35	60	1	24000	0.5		178659 L
8.0	12	12	40	60	2	24000	0.5		183568 L
8.0	22	12	35	70	2	24000	0.5		187724 L
10	22	12	35	70	2	24000	1.2	186785 L	186784 L
12	25.4	12	35	70	1	24000	1.2		181102 L
16	25.4	16	45	85	1	24000	1.2		181104 L
16	35	16	45	95	1	24000	1.2		181106 L
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[mm]		

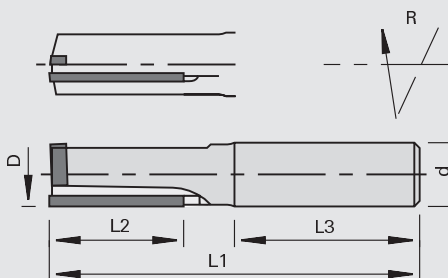
229222

DIAMAX Shank-Type Cutters DP - Z=1

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for jointing without overlap marks in solid woods and wood-based panels
- | not suitable for dividing and deep grooves
- | for light millwork only

Design

- | polished face and high-finish clearance angle
- | with HW plunge tip for diagonal plunge-cutting (travelling plunge-cut using Z and X axis)
- | straight cutter axis
- | resharpening area 0.8 mm

Advantages

- | high quality machining of MDF and hard woods
- | no overlap-marks thanks to continuous cutting edge

Notes

- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- | with thread for length adjusting screw

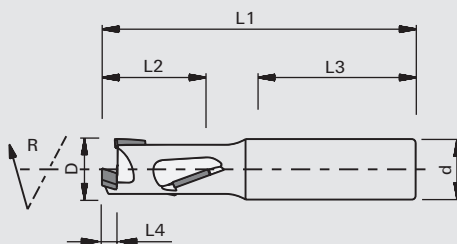
Ø D	L2	Ø d	L3	L1	Z	nmax	Ident-No. [R]
8.0	22	8	35	65	1+1	24000	187842 L
8.0	22	12	35	65	1+1	24000	182664 L
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

229222

DIAMAX Shank-Type Cutters DP - Z=1+1

Product

Drawing


LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for jointing, rabbeting, grooving
 and copying in raw, melamine-,
 paper-, HPL-laminated, foiled
 and veneered panels

Design

| with DP plunge tip for diagonal
 plunge-cutting
 | with shear angle
 | resharpenable several times
 | n max = 24,000 min-1

Advantages

| optimum cutting quality thanks
 to larger shear angle, alternating
 top and bottom
 | smooth running thanks to
 special tool body
 | Chip-free grooving possible from
 groove depths of 4.5 mm

Notes

| Feed rates up to 8 m/min
 | Recommended clamping
 elements: ps-System, TRIBOS,
 heat-shrinking chuck
 | Tools with Ø d = 12, 16 and
 20 mm without thread and
 Ø d = 25 mm with thread for
 length adjusting screw

Ø D	L2	L4	Ø d	L3	L1	Z	Resharpener area	Ident-No. [L]	Ident-No. [R]
8	22	4.1	12	40	69	1+1	0.6		186994 L
8.5	15	4.1	12	40	65	1+1	0.6		187249 L
10	22	4.1	12	40	69	1+1	0.6		186789 L
10	32	4.1	12	40	79	1+1	0.6		186995 L
12	22	4.1	12	40	69	1+1	0.8		186790 L
12	28	4.1	12	40	75	1+1	0.8	186793 L	186792 L
12	28	8.7	25	55	95	1+1	0.8		187166 L
16	22	4.1	16	45	78	1+1	1.0		186794 L
16	28	4.1	16	45	83	1+1	1.0		186795 L
16	35	4.1	16	45	90	1+1	1.0	186797 L	186796 L
16	35	12.6	16	45	90	1+1	1.0		187167 L
18	28	4.1	16	45	85	1+1	1.0		186798 L
18	28	4.1	20	45	95	1+1	1.0	186799 L	186800 L
18	35	4.1	16	45	92	1+1	1.0	186801 L	186802 L
18	35	4.1	20	55	102	1+1	1.0	186804 L	186803 L
18	43	4.1	16	45	100	1+1	1.0	186806 L	186805 L
18	43	12.6	20	55	110	1+1	1.0		187168 L
18	43	4.1	20	55	110	1+1	1.0	186808 L	186807 L
18	43	4.1	25	55	110	1+1	1.0	186913 L	186912 L
20	35	4.1	20	55	102	1+1	1.0		186809 L
20	52	4.1	25	55	120	1+1	1.0	186811 L	186810 L
20	52	12.3	25	55	120	1+1	1.0		187169 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

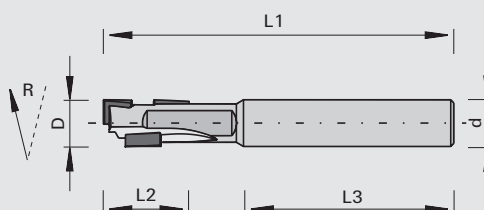
Ø D	L2	L4	Ø d	L3	L1	Z	Resharpener area	Ident-No.
1/2"	1"	4.1	1/2"	1 3/8"	2 2/3	1+1	1.0	186791 L
[inch]	[inch]	[mm]	[inch]	[inch]	[inch]		[mm]	

229040

Grooving Shank-Type Cutters DP

Product

Drawing


LEUCO
topline_{plus}

LEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | especially for grooving but also for jointing, and dividing in raw and laminated panels as well as for example in glued veneered woods (Multiplex)

Design

| extremely rigid VHW tool body
 | with alternating shear angle
 | with DP plunge tip
 | polished face
 | n max = 24,000 min-1

Advantages

| optimum cutting quality thanks to shear angle, alternating top and bottom
 | smooth running thanks to special cutting edge configuration
 | very long edge lives, less cutting forces and less noise thanks to optimized tool body
 | clean ground of groove

Notes

| clamping elements: hydro expansion chuck ps-System or TRIBOS with precision reducing sleeves Ident-No. 183032 or 182305 or with heat shrink-fit chuck Ident-No. 80362923

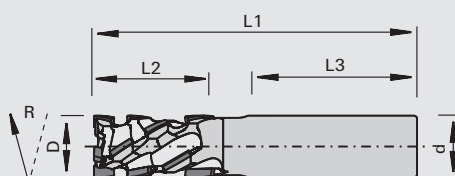
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
8.0	14	8.0	36	60	1+1	R 185734 L
[mm]	[mm]	[mm]	[mm]	[mm]		

229122

DIAREX High-Performance Shank-Type Cutters DP - Z=2+2

Product

Drawing


LEUCO
DIAREX

Polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for jointing, rabbeting, grooving and copying in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

| with DP plunge tip for diagonal plunge-cutting
 | with shear angle
 | resharpening area 1.2 mm
 | n max = 24,000 min-1

Advantages

| optimum cutting quality thanks to shear angle, alternating top and bottom
 | smooth running thanks to 4-wing design of cutting edges
 | very long edge lives, less cutting forces and less noise thanks to optimized tool body

Notes

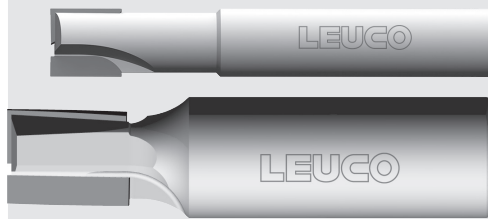
| feed rates up to 20 m/min
 | Clamping elements: ps-System, TRIBOS, draw-in collet chuck
 | with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
16	28	16	45	80	2+2		186147 L
16	38	16	45	90	2+2	186149 L	186148 L
20	28	20	55	95	2+2		186150 L
20	28	25	55	95	2+2	186152 L	186151 L
20	38	20	55	105	2+2		186153 L
20	38	25	55	105	2+2	186155 L	186154 L
20	48	20	55	115	2+2		186156 L
20	48	25	55	115	2+2	186158 L	186157 L
25	65	25	55	130	2+2	186160 L	186159 L
[mm]	[mm]	[mm]	[mm]	[mm]			

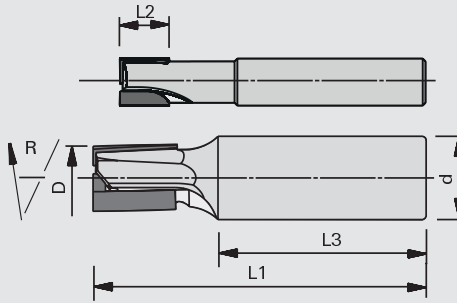
229342

High-Performance Shank-Type Cutters DP - for the machining of solid core panels

Product



Drawing



LEUCO
topline

LEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for jointing and sizing without overlap marks in solid woods and wood-based panels
 | especially suited for the machining of plastic solid core panels (e.g. Trespa®, Corian®, Varicor®, LG-HiMacs, etc.)

Design

| high-performance tool for pre- and finish-milling
 | Ø D = 8 mm - Ø D = 10 mm solid carbide design of tool body
 | Ø D > 10 mm tool body made from steel
 | with face shear angles
 | with DP plunging tip
 | face cutting for diagonal plunge-cutting
 | polished face
 | n max = 24.000 min-1

Advantages

Notes

| Clamping elements: ps-System, TRIBOS, draw-in collet chuck, heat-shrinking chuck
 | Ø D > 10 mm with thread for length adjusting screw

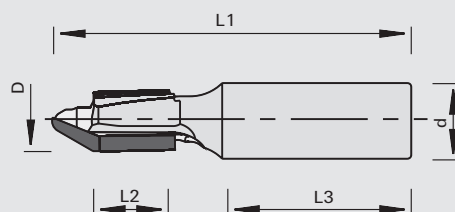
Ø D	L2	Ø d	L3	L1	Z	Resharpeneing area	Ident-No.
8	10	10	40	65	1+1	0.5	R 187261 L
10	10	10	40	65	1+1	0.6	R 187262 L
12	15	16	45	75	2+1	1.0	R 186436 L
12	15	16	45	75	3+1	1.0	R 186305 L
12	22	16	45	75	2+1	1.0	R 186437 L
14	28	16	45	80	2+1	1.5	R 186438 L
16	20	20	50	80	2+1	2.8	R 186439 L
16	20	20	50	80	3+1	1.6	R 186431 L
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

229322

Multi-purpose shank-type cutting jointer DP - for solid core panel machining

Product

Drawing


LEUCO
topline_{plus}

LEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for jointing without overlap marks, sizing and milling of cutouts in plastic solid core panels (e.g. Trespa®, Corian®, Varicor®, LG-HiMacs, etc.) and fiber cement boards

Design

| special PCD type in topline design
 | with alternating shear angle and DP plunge tip

Advantages

| flexible multi-function tool
 | vertical boring and through-drilling
 | milling of any hole diameters >Ø16 mm and cutouts
 | profile grooves 60° with R=3 mm
 | Chamfering of edges 30°
 | only 1 tool change location required

Notes

| Clamping elements: ps-System, TRIBOS, heat-shrinking chuck

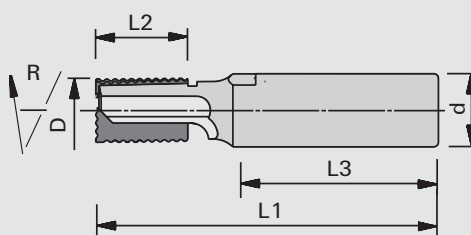
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	20	20	48	95	2+1	187373 L
[mm]	[mm]	[mm]	[mm]	[mm]		

229021

High-Performance Roughing Shank-Type Cutters DP - for the machining of solid core panels

Product

Drawing


LEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for pre-sizing in roughing quality in wood-based panels, solid wood and plastic
 | especially suited for the machining of plastic solid core panels (e.g. Trespa®, Corian®, Varicor®, LG-HiMacs, etc.)

Design

| high-performance tool for rough and finish milling
 | with alternating shear angle
 | with DP plunge tip
 | face cutting for diagonal plunge-cutting
 | n max = 24,000 min-1

Advantages

Notes

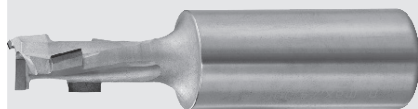
| Clamping elements: ps-System, TRIBOS, draw-in collet chuck
 | with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Resharpining area	Ident-No.
14	20	16	45	75	2+1	1.5	R 186579 L
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

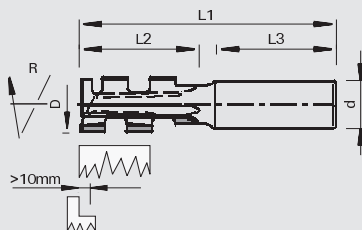
229222

DIAMAX Shank-Type Cutters DP - Inch Size

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

l CNC routers "Inch-Program"
l for jointing, rabbeting, grooving
and copying in raw, melamine-,
paper-, HPL-laminated, foiled
and veneered panels

Design

l with HW plunge tip for
diagonal plunge-cutting
l with shear angle
l resharpening area 1.5 mm
l n max = 24,000 min-1

Advantages

l optimum cutting quality thanks
to shear angle, alternating top
and bottom
l smooth running thanks to spiral
cut configuration
l very long edge lives, less cutting
forces and less noise thanks to
optimized tool body

Notes

l feed rates up to 12 m/min
l Clamping elements: ps-
System, Tribos, draw-in collet
chuck
l with thread for length
adjusting screw

Ø D	L2	Ø d	L3 mm	L1 mm	Z	Replacement#	Ident#
3/8	3/4	1/2	40	75	1+1		1741647
1/2	1	1/2	40	75	1+1	183445	1741648
1/2	1 3/8	1/2	45	95	1+1	1728816	1741649
5/8	1 3/8	5/8	45	95	1+1	1728832	1741650
3/4	1 5/8	3/4	55	110	1+1		1741651
5/8	1 3/8	5/8	45	95	2+2		1741652
3/4	1 5/8	3/4	55	110	2+2		1741653
3/4	2 1/16	3/4	55	115	1+1		1728723
1/2	7/8	1/2	40	75	2+2		1740903
[inch]	[inch]	[inch]	[inch]	[inch]			

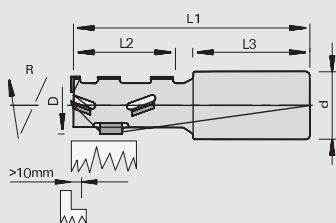
229222

DIAMAX High-Performance Shank-Type Cutters DP - Z=2+2

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

l CNC routers
l for jointing, rabbeting, grooving
and copying in raw, melamine-,
paper-, HPL-laminated, foiled
and veneered panels

Design

l with HW plunge tip for
diagonal plunge-cutting
l with shear angle
l resharpening area 1.5 mm
l n max = 24,000 min-1

Advantages

l optimum cutting quality thanks
to shear angle, alternating top
and bottom
l smooth running thanks to
4-wing design of cutting edges
l very long edge lives, less cutting
forces and less noise thanks to
optimized tool body

Notes

l feed rates up to 20 m/min
l Clamping elements: ps-
System, Tribos, draw-in collet
chuck
l with thread for length
adjusting screw

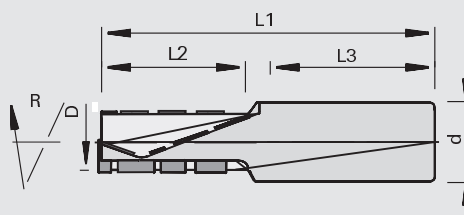
Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
20	28	20	55	95	2+2	183411	183410
20	38	20	55	105	2+2	183413	183412
20	48	20	55	115	2+2	183415	183414
20	28	25	55	95	2+2	183405	183404
20	38	25	55	105	2+2	183407	183406
20	48	25	55	115	2+2	183409	183408
[mm]	[mm]	[mm]	[mm]	[mm]			

229022

High-Performance Shank-Type Cutters DP - Z=2+1+2

Product

Drawing

LEUCO
toplineLEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

| high-performance tool for rough and finish milling
 | Z=1 in middle layer and Z=2 in covering layer
 | face cutting for diagonal plunge-cutting
 | with shear angle
 | resharpening area 3.0 mm
 | n max = 30,000 min-1

Advantages

| good cutting quality on top and bottom edge thanks to opposing shear angle
 | reduced vibrations thanks to variable pitch
 | optimum good chip disposal thanks to open arrangement of cutting edges

Notes

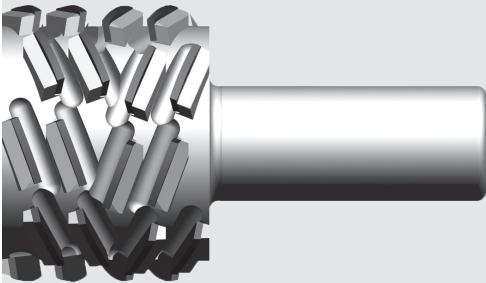
| feed speed up to 20 m/min when jointing
 | feed speed up to 12 m/min when sizing
 | Clamping elements: ps-System, Tribos, draw-in collet chuck
 | with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	H	Ident-No. [L]	Ident-No. [R]
20	28	25	60	100	2+1+2	12-25		181481
25	35	25	60	110	2+1+2	18-32		181483
25	42	25	60	120	2+1+2	25-40		181485 s
25	48	25	62	120	2+1+2	32-45	181486	181487
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

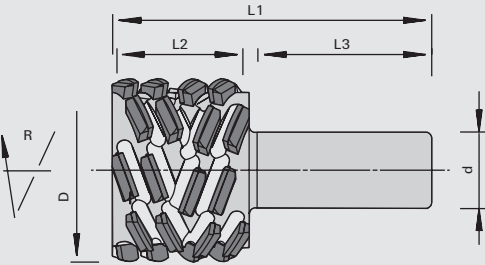
229324

p-System High-Performance Jointing Shank-Type Cutters CM DP

Product



Drawing



LEUCO
topline

LEUCO
p-system

polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC stationary machines
- | for chip-free high-performance jointing of solid woods (free of knots) along and across the grain
- | for jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- | Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- | symmetrical and asymmetrical design
- | non-convex design
- | extremely scoring cut
- | resharpening area 4 mm

Advantages

- | maximum cutting quality and edge lives
- | large depth of cut possible
- | chip-free cuts even on the exit side
- | perfectly suitable for laser-edge-technology

Notes

- | with thread for length adjusting screw
- | recommended feed rate per tooth: wood-based panels 0.55 mm, solid wood 0.28 mm
- | crowned design on request
- | clamping element: precision clamping element e.g. ps-System, TRIBOS
- | sense of rotation according to DIN-EN 50144

Ø D	L2	Ø d	L3	L1	Z	Shear◁	Ident-No. [R]
48	28,2	25	62.2	100	3+3	70	184081
48	38	25	57.4	105	3+3	70	184082
60	38	25	57.4	105	3+3	70	184083 s
60	38	25	57.4	105	4+4	70	184084
60	43	25	57.5	110	3+3	70	185821 s
60	47,8	25	57.6	115	3+3	70	185819 s
60	57,6	25	57.8	125	3+3	70	185820 s
60	67,4	25	56.8	135	3+3	70	184080 s
[mm]	[mm]	[mm]	[mm]	[mm]		[°]	

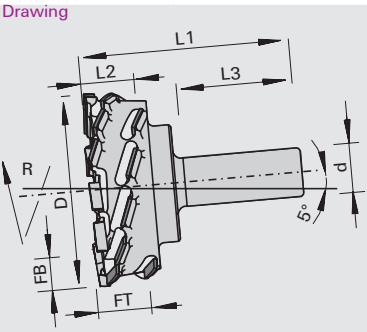
229324

p-System High-Performance Rabbeting Shank-Type Cutter CM DP

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- 5-axis machining centers
- for chip-free high-performance rabbeting of solid woods (free of knots) along and accross the grain
- for high-performance rabbeting of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- extremely scoring cut
- tool to be used on spindle tilted by 5°
- resharpening area front 2.5 mm, peripheral side 3 mm

Advantages

- maximum cutting quality on both rabbeting sides and maximum edge lives
- chip-free cuts even on the exit side

Notes

- recommended feed rate per tooth: wood-based panels 0.5 - 0.8 mm, solid wood 0.25 - 0.4 mm
- clamping element: precision clamping element e.g. ps-System, TRIBOS, heat shrink-fit chuck
- with thread for length adjusting screw
- sense of rotation according to DIN-EN 50144

Ø D	L2	Ø d	L3	L1	Z	FB	FT	Shear∠	Ident-No. [R]
100	18,6	25	65	99	3+3	10	15	70	184731
100	28,3	25	65	110	3+3	16	25	70	184732 s
100	43	25	65	120	3+3	16	38	70	184733 s
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[°]	

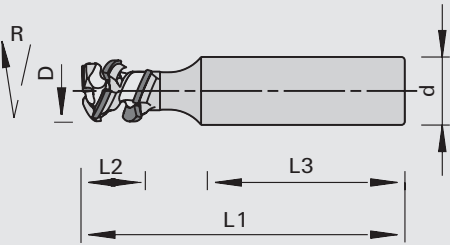
229324

p-System High-Performance Grooving Shank-Type Cutters CM DP

Product



Drawing



LEUCO
topline

LEUCO
p-system

polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC stationary machines
- | for grooves, cut outs, pockets and as forend cutter
- | for chip-free high-performance grooving of solid woods (free of knots) along and across the grain
- | for high-performance grooving of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- | Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- | extremely scoring cut

Advantages

- | maximum cutting quality and edge lives
- | chip-free cuts even on the exit side

Notes

- | minimal grooving depth 0.5 mm
- | as from 25 mm Z=2 is possible, bottom cutting edge is Z=1 always
- | convex bottom cutting edge for better bottom quality of rabbet, however corner of rabbet not absolutely sharp
- | for ramping or circular plunging only
- | recommended feed rate per tooth: wood-based panels 0.3 - 0.35 mm, solid wood 0.15 - 0.2 mm
- | clamping element: precision clamping element e.g. ps-System, TRIBOS, heat shrink-fit chuck
- | with thread for length adjusting screw
- | sense of rotation according to DIN-EN 50144

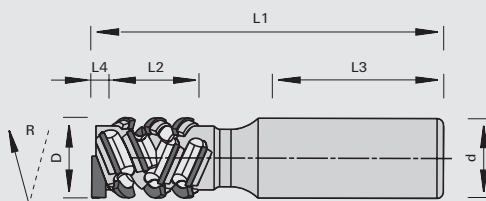
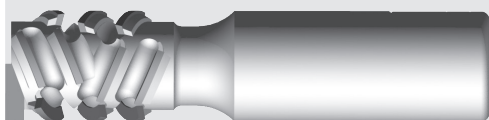
Ø D	L2	Ø d	L3	L1	Z	Shear∠	Resharpening area	Ident-No. [R]
8.0	3,3	10	50	65	1+1	70	0.4	186095
10	4,8	12	45	65	1+1	70	0.9	186096 s
10	10,4	12	45	70	1+1	70	0.9	186097
12	21,4	12	50	90	1+1	70	1.4	185506 s
12	10,2	16	45	80	1+1	70	1.4	185505
12	21,4	16	45	90	1+1	70	1.4	185507
16	14	16	45	85	1+1	70	1.9	185508
16	24,4	16	45	90	1+1	70	1.9	185509 s
16	32,2	16	45	90	1+1	70	1.9	186098
18	19	16	55	95	1+1	70	2.4	185612
18	7,0	20	55	90	1+1	70	2.4	185613
18	19	20	55	95	1+1	70	2.4	185614
25	9,4	25	50	95	1+1	70	2.4	185615 s
25	18	25	50	100	1+1	70	2.4	185616 s
[mm]	[mm]	[mm]	[mm]	[mm]		[°]	[mm]	

229324

p-System High-Performance Shank-Type Cutters CM DP

Product

Drawing

LEUCO
toplineLEUCO
p-system

polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC stationary machines
- | for chip-free high-performance jointing and dividing of solid woods (free of knots) along and across the grain
- | for jointing and dividing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- | Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- | extremely scoring cut
- | DP plunge tip

Advantages

- | maximum cutting quality and edge lives
- | large depth of cut possible
- | chip-free cuts even on the exit side
- | perfectly suitable for laser-edge-technology

Notes

- | adjust the tool to run centrally to the workpiece
- | Tools with plunge tip (L4) must project at least 4,5 mm on bottom side of workpiece in order to bring p-System cutting edges into action
- | for ramping or circular plunging only
- | recommended feed rate per tooth: wood-based panels 0.3 - 0.35 mm, solid wood 0.15 - 0.2 mm
- | clamping element: precision clamping element e.g. ps-System, TRIBOS
- | with thread for length adjusting screw
- | sense of rotation according to DIN-EN 50144

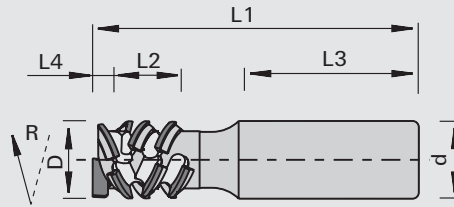
Ø D	L4	L2	Ø d	L3	L1	Z	H	Shear◀	Resharpener area	Ident-No. [R]
12	3.1	13,5	16	45	85	1+1	10,5	70	1.5	185500 s
12	3.1	21,5	16	45	90	1+1	18,5	70	1.5	185501
14	3.4	27	16	45	100	1+1	24	70	1.8	185502
16	3.4	20,9	16	45	90	1+1	17,9	70	2.0	185503
16	3.4	26,1	16	45	100	1+1	23,1	70	2.0	185504
20	3.8	25,9	25	55	105	1+1	22,9	70	2.5	184379
20	3.8	29,5	25	55	110	1+1	26,5	70	2.5	184380
20	3.8	33,1	25	55	115	1+1	30,1	70	2.5	184381
25	3.8	26,5	25	55	105	2+2	23,5	70	2.5	184382
25	3.8	30,8	25	55	110	2+2	27,8	70	2.5	184383
25	3.8	48	25	55	130	2+2	45	70	2.5	184384
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[°]	[mm]	

229324

p-System High-Performance Shank-Type Cutters CM DP - Weeke BHX 050/055

Product

Drawing

LEUCO
toplineLEUCO
p-system

polycrystalline diamond [DP]

MEC

Machine / Application

- WEEKE BHX 050 and BHX 055 with delivery date as from Sept. 01, 2015
- BHX 50/055 machines with CNC controlled clamping devices (servo) and with delivery date as from 01.01.2014 only can be updated by the manufacturer (Note: Service charges will occur)
- for chip-free high-performance jointing and dividing of solid woods (free of knots) along and across the grain
- for jointing and dividing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- extremely scoring cut
- asymmetrical design
- DP plunge tip

Advantages

- maximum cutting quality and edge lives
- chip-free cuts even on the exit side
- increased contact pressure than conventional shank-type cutters

Notes

- Tools with plunge tip (L4) must project at least 4,5 mm on bottom side of workpiece in order to bring p-System cutting edges into action. D 30 is without plunge tip
- for ramping or circular plunging only
- recommended feed rate per tooth: wood-based panels 0.3 - 0.35 mm, solid wood 0.15 - 0.2 mm
- clamping element: precision clamping element e.g. ps-System, TRIBOS
- with thread for length adjusting screw
- sense of rotation according to DIN-EN 50144

Ø D	L4	L2	Ø d	L3	L1	Z	Shear $\angle$	Resharping area	Ident-No. [R]
20	4.0	25,1	25	51	105	1+1	70	2.5	185664
25	4.0	25,7	25	53	105	2+2+1	70	2.5	185663
25	4.0	30	25	53	110	2+2+1	70	2.5	185823 s
25	4.0	47,2	25	53	125	2+2+1	70	2.5	185824
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[°]	[mm]	

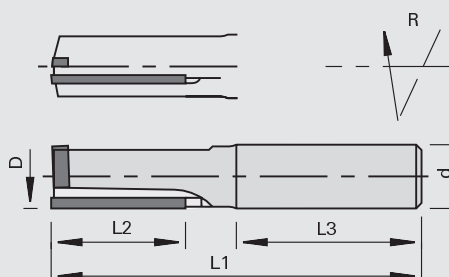
229222

DIAMAX Shank-Type Cutters DP

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for jointing and sizing without overlap marks in wood-based panels, solid woods and plastics

Design

| Polished face and high-finish clearance angle
 | With HW plunge tip for diagonal plunge-cutting (simultaneous feed using Z and X axis)
 | Ø 10 mm with plunge tip integrated in VHW body, all other diameters with brazed HW plunge tip
 | Straight cutter axis
 | Solid tungsten carbide body for Ø 5 mm to Ø 10 mm

Advantages

| high quality machining of MDF and hard woods
 | no overlap-marks thanks to continuous cutting edge
 | increased stability thanks to special design of brazing area

Notes

| Clamping elements: ps-System, TRIBOS, draw-in collet chuck
 | Ø D=12 and 16 mm with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	nmax	Resharpining area	Ident-No. [L]	Ident-No. [R]
5.0	12	12	40	60	1	24000	0.2		183566 L
6.0	12	12	40	60	1	24000	0.2		183567 L
8.0	12	12	35	60	1	24000	0.5		178659 L
8.0	12	12	40	60	2	24000	0.5		183568 L
8.0	22	12	35	70	2	24000	0.5		187724 L
10	22	12	35	70	2	24000	1.2	186785 L	186784 L
12	25.4	12	35	70	1	24000	1.2		181102 L
16	25.4	16	45	85	1	24000	1.2		181104 L
16	35	16	45	95	1	24000	1.2		181106 L
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[mm]		

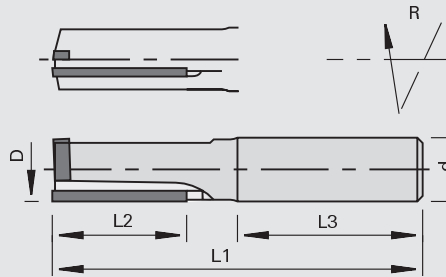
229222

DIAMAX Shank-Type Cutters DP - Z=1

Product



Drawing


LEUCO
topline

LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for jointing without overlap marks in solid woods and wood-based panels
- | not suitable for dividing and deep grooves
- | for light millwork only

Design

- | polished face and high-finish clearance angle
- | with HW plunge tip for diagonal plunge-cutting (travelling plunge-cut using Z and X axis)
- | straight cutter axis
- | resharpening area 0.8 mm

Advantages

- | high quality machining of MDF and hard woods
- | no overlap-marks thanks to continuous cutting edge

Notes

- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- | with thread for length adjusting screw

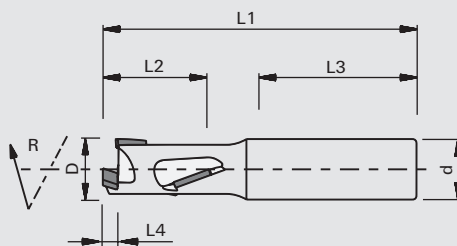
Ø D	L2	Ø d	L3	L1	Z	nmax	Ident-No. [R]
8.0	22	8	35	65	1+1	24000	187842 L
8.0	22	12	35	65	1+1	24000	182664 L
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

229222

DIAMAX Shank-Type Cutters DP - Z=1+1

Product

Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for jointing, rabbeting, grooving
 and copying in raw, melamine-,
 paper-, HPL-laminated, foiled
 and veneered panels

Design

| with DP plunge tip for diagonal
 plunge-cutting
 | with shear angle
 | resharpenable several times
 | n max = 24,000 min-1

Advantages

| optimum cutting quality thanks
 to larger shear angle, alternating
 top and bottom
 | smooth running thanks to
 special tool body
 | Chip-free grooving possible from
 groove depths of 4.5 mm

Notes

| Feed rates up to 8 m/min
 | Recommended clamping
 elements: ps-System, TRIBOS,
 heat-shrinking chuck
 | Tools with Ø d = 12, 16 and
 20 mm without thread and
 Ø d = 25 mm with thread for
 length adjusting screw

Ø D	L2	L4	Ø d	L3	L1	Z	Resharpener area	Ident-No. [L]	Ident-No. [R]
8	22	4.1	12	40	69	1+1	0.6		186994 L
8.5	15	4.1	12	40	65	1+1	0.6		187249 L
10	22	4.1	12	40	69	1+1	0.6		186789 L
10	32	4.1	12	40	79	1+1	0.6		186995 L
12	22	4.1	12	40	69	1+1	0.8		186790 L
12	28	4.1	12	40	75	1+1	0.8	186793 L	186792 L
12	28	8.7	25	55	95	1+1	0.8		187166 L
16	22	4.1	16	45	78	1+1	1.0		186794 L
16	28	4.1	16	45	83	1+1	1.0		186795 L
16	35	4.1	16	45	90	1+1	1.0	186797 L	186796 L
16	35	12.6	16	45	90	1+1	1.0		187167 L
18	28	4.1	16	45	85	1+1	1.0		186798 L
18	28	4.1	20	45	95	1+1	1.0	186799 L	186800 L
18	35	4.1	16	45	92	1+1	1.0	186801 L	186802 L
18	35	4.1	20	55	102	1+1	1.0	186804 L	186803 L
18	43	4.1	16	45	100	1+1	1.0	186806 L	186805 L
18	43	12.6	20	55	110	1+1	1.0		187168 L
18	43	4.1	20	55	110	1+1	1.0	186808 L	186807 L
18	43	4.1	25	55	110	1+1	1.0	186913 L	186912 L
20	35	4.1	20	55	102	1+1	1.0		186809 L
20	52	4.1	25	55	120	1+1	1.0	186811 L	186810 L
20	52	12.3	25	55	120	1+1	1.0		187169 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

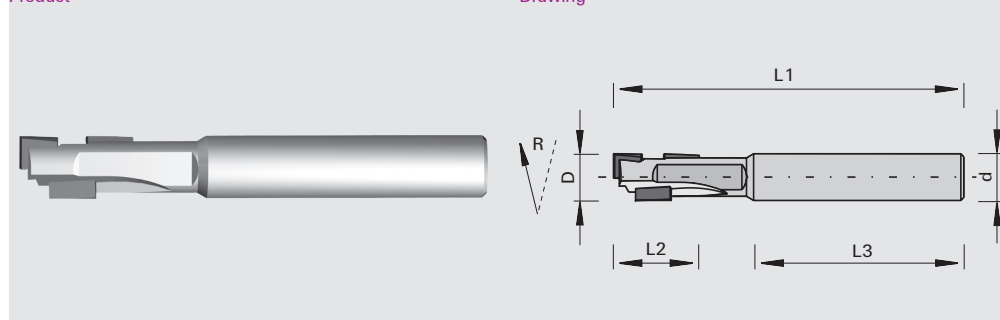
Ø D	L2	L4	Ø d	L3	L1	Z	Resharpener area	Ident-No.
1/2"	1"	4.1	1/2"	1 3/8"	2 2/3	1+1	1.0	186791 L
[inch]	[inch]	[mm]	[inch]	[inch]	[inch]		[mm]	

229040

Grooving Shank-Type Cutters DP

Product

Drawing


LEUCO
topline

LEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | especially for grooving but also for jointing, and dividing in raw and laminated panels as well as for example in glued veneered woods (Multiplex)

Design

| extremely rigid VHW tool body
 | with alternating shear angle
 | with DP plunge tip
 | polished face
 | $n_{max} = 24,000 \text{ min}^{-1}$

Advantages

| optimum cutting quality thanks to shear angle, alternating top and bottom
 | smooth running thanks to special cutting edge configuration
 | very long edge lives, less cutting forces and less noise thanks to optimized tool body
 | clean ground of groove

Notes

| clamping elements: hydro expansion chuck ps-System or TRIBOS with precision reducing sleeves Ident-No. 183032 or 182305 or with heat shrink-fit chuck Ident-No. 80362923

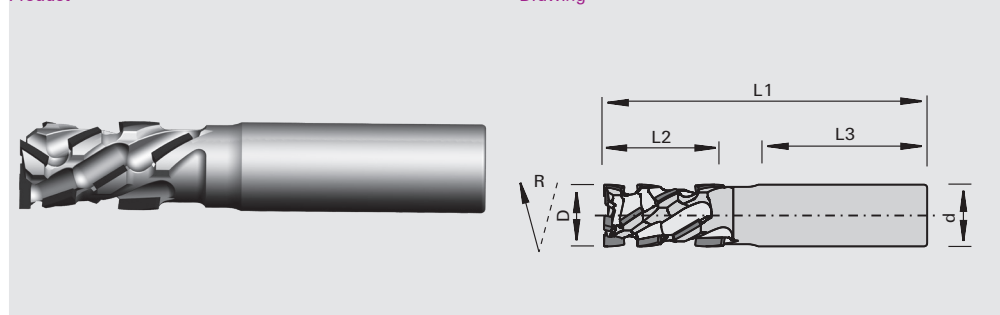
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
8.0	14	8.0	36	60	1+1	R 185734 L
[mm]	[mm]	[mm]	[mm]	[mm]		

229122

DIAREX High-Performance Shank-Type Cutters DP - Z=2+2

Product

Drawing


LEUCO
DIAREX

Polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for jointing, rabbeting, grooving and copying in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

| with DP plunge tip for diagonal plunge-cutting
 | with shear angle
 | resharpening area 1.2 mm
 | $n_{max} = 24,000 \text{ min}^{-1}$

Advantages

| optimum cutting quality thanks to shear angle, alternating top and bottom
 | smooth running thanks to 4-wing design of cutting edges
 | very long edge lives, less cutting forces and less noise thanks to optimized tool body

Notes

| feed rates up to 20 m/min
 | Clamping elements: ps-System, TRIBOS, draw-in collet chuck
 | with thread for length adjusting screw

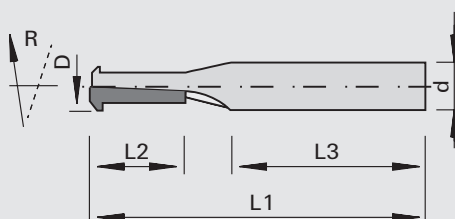
Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
16	28	16	45	80	2+2		186147 L
16	38	16	45	90	2+2	186149 L	186148 L
20	28	20	55	95	2+2		186150 L
20	28	25	55	95	2+2	186152 L	186151 L
20	38	20	55	105	2+2		186153 L
20	38	25	55	105	2+2	186155 L	186154 L
20	48	20	55	115	2+2		186156 L
20	48	25	55	115	2+2	186158 L	186157 L
25	65	25	55	130	2+2	186160 L	186159 L
[mm]	[mm]	[mm]	[mm]	[mm]			

229268

Profile Grooving Shank-Type Cutters DP - for Lamello Clamex P®

Product

Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

| 5-axis CNC machines
 | for the milling of Lamello Clamex P® profile grooves
 | particularly for profile grooves to be cut into the panel surface further away from the panel edge and if the housing of the angular aggregate does not allow the use of Lamello Clamex P® bore type tool

Design

| DP-tipped
 | disposable tool

Advantages

| problem solution if space problems occur with angular aggregates (touching of the panel with the aggregate's bottom side when using bore-type cutters with DØ100,4 mm)

Notes

| depending on the type of workpiece a pre-grooving operation with a negative solid carbide finishing spiral cutter can make sense (reduced risk of chipping of sensitive laminations) resp. reduces the cutting pressure when milling the profile grooves

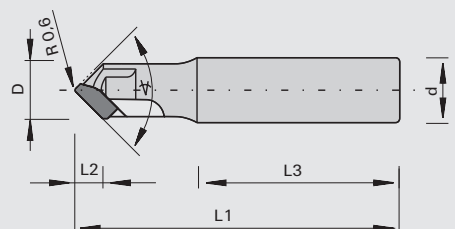
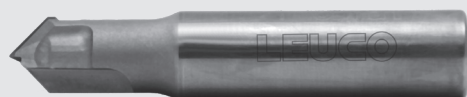
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	20	12	40	70	1	185703 L
[mm]	[mm]	[mm]	[mm]	[mm]		

229360

Relief-Picture Shank-Type Cutter DP - 90°

Product

Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

| CNC machines
 | for grooving operations in relief-picture technique (i.e. Pic2Plate)

Design

| cutting material: DP
 | topline design
 | resharpening area 2 mm

Advantages

| very long edge lives particularly in hard panel materials
 | optimal cutting quality thanks to specialized blade preparation

Notes

| the relief-picture technique is a computer-based method to transfer image information by milling onto board materials
 | clamping systems : precision clamping element e.g. TRIBOS or heat shrink-fit chuck

Ø D	L2	L3	Ø d	L1	Z	∠ of point	Ident-No.
14	7,0	50	16	80	1	90	185156 L
[mm]	[mm]	[mm]	[mm]	[mm]		[°]	

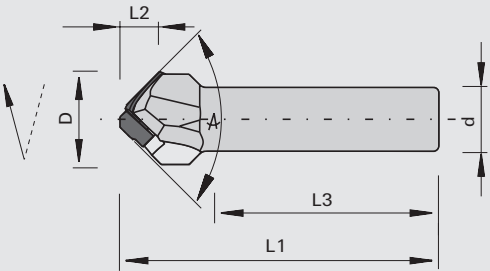
229460

V-Groove Cutter DP for aluminum composite materials

Product



Drawing



LEUCO
topline

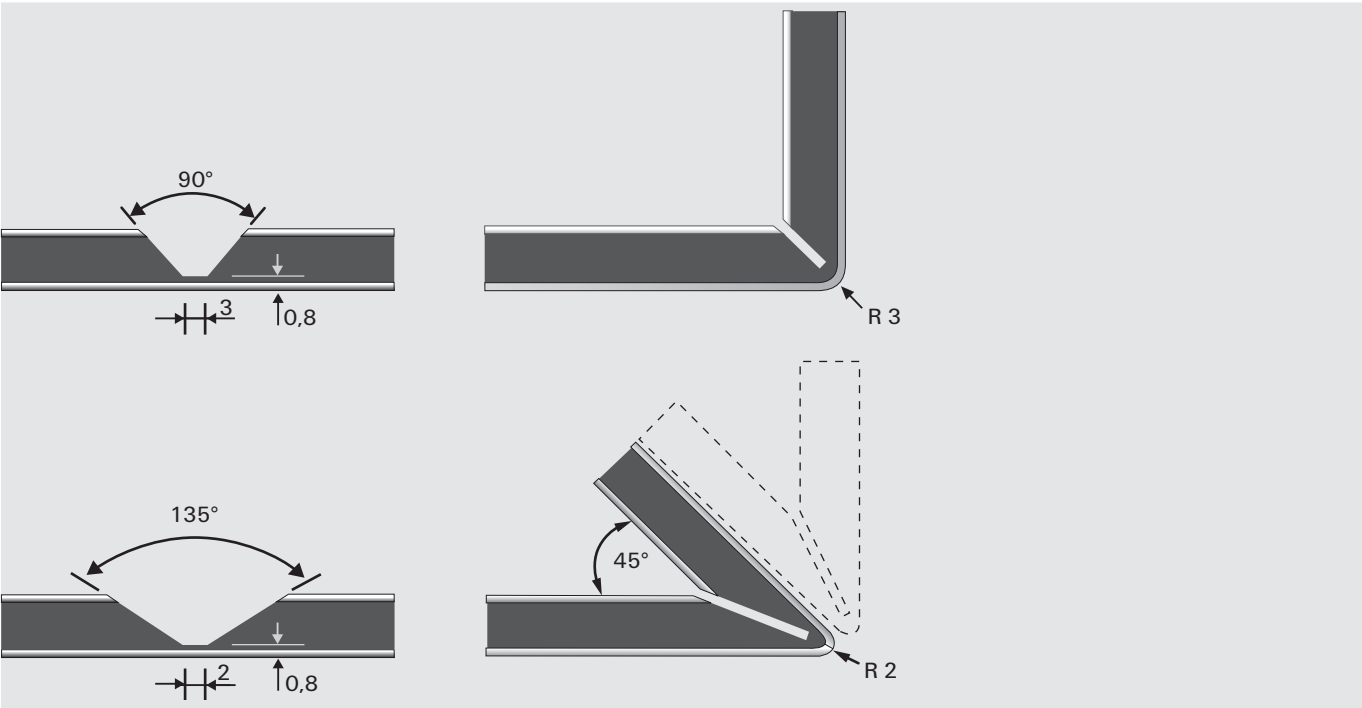
LEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application	Design	Advantages	Notes
- CNC machines - for V-grooves in aluminum composite materials (Aluco-bond, Dibond, etc.)	- cutting material: DP - topline design - resharpening area 2 mm	- very long edge lives particularly in composite materials with mineral core - optimal cutting quality thanks to polished face and special division of cut	clamping elements: ideal use in precision clamping elements e.g. ps-System, TRIBOS or heat-shrinking chuck

Ø D	L2	L3	Ø d	L1	Z	∠ of point	Ident-No.
18	7,5	40	12	60	1+1	90	186499 L
32	6,2	40	12	60	1+1	135	186500 L
[mm]	[mm]	[mm]	[mm]	[mm]		[°]	

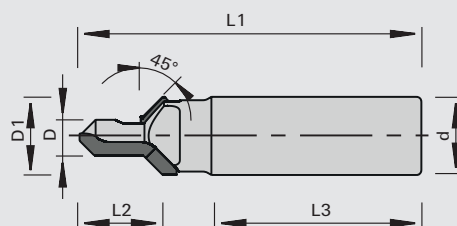


229332

Multi-purpose Drill-Chamfer Router DP - for the machining of solid core panels

Product

Drawing


LEUCO
topline_{plus}

LEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | chip-free drilling and countersinking as well as milling of larger hole diameters and cutouts particularly in plastic solid core panels (e.g. Trespa®, Corian®, Varicor®, LG-HiMacs, etc.) and fiber cement boards

Design

| special PCD type in topline design
 | with alternating shear angle and DP plunge tip

Advantages

| flexible multi-function tool
 | vertical boring and through-drilling
 | milling of any hole diameters >Ø8 mm and cutouts
 | drilling and countersinking 45°
 | only 1 tool change location required

Notes

| Clamping elements: ps-System, TRIBOS, heat-shrinking chuck

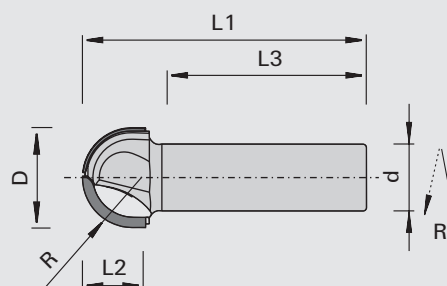
Ø D1	Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	8	17	16	41	70	1+2	187374 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

229560

DIAMAX Spherical Shank-Type Cutters DP

Product

Drawing


LEUCO
topline_{plus}

LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

| CNC machines
 | for contour milling and template copying
 | for 3D-milling work, 3D-models, relief-milling work

Design

| TOPLINE design
 | resharpener area 1.5 mm
 | n max = 24,000 min-1

Advantages

| long edge lives
 | high quality of cut thanks to polished cutting edges and ultra-fine eroding of back of the tooth

Notes

| clamping elements: we recommend the use of the tools in high precision clamping chucks such as hydro expansion chucks "ps-System", TRIBOS or heat shrink-fit chucks

R	Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	20	14	20	55	85	2	185240 L
15	30	19	20	55	85	2	185241 L
20	40	24	20	55	85	2	185242 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

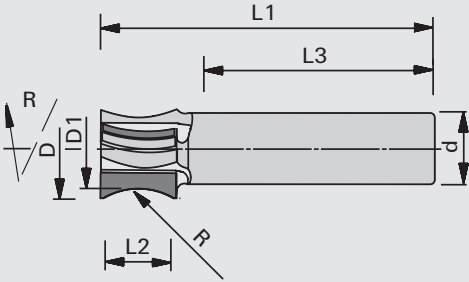
229360

High-Performance Radius Shank-Type Cutters DP - for the machining of solid core panels

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for slight rounding of wood-based panels, solid wood and plastic
- | especially suited for the machining of plastic solid core panels (e.g. Trespa®, Corian®, Varicor®, LG-HiMacs, etc.)
- | for panel thickness up to 14 mm

Design

- | high-performance tool for finish milling, Z=3
- | with alternating shear angle
- | without plunge tip
- | polished face
- | radius R=16
- | n max = 24,000 min-1

Advantages

Notes

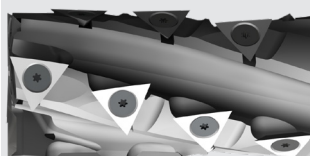
- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- | with thread for length adjusting screw

R	Ø D	Ø D1	L2	Ø d	L3	L1	Z	Resharpener area	Ident-No.
16	22.3	18	14	16	55	75	3	1.5	R 186578 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

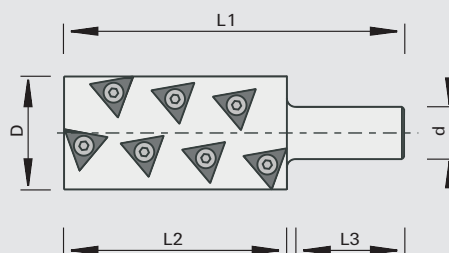
128260

Shank-Type Cutters with HW Turnover Knives - t3-System

Product



Drawing


LEUCO
t3system

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC and joinery machines
- For offset- and chip-free jointing, rabbeting and sizing of solid wood

Design

- Rounded triangular turnover knives with cutting edges drawing from bottom to top and from top to bottom
- Cutting material: HW
- HL Solid 20 for hard wood and soft wood
- HL Board 06 for wood-based materials, plastics and hard woods
- topcoat coating for increased edge lives

Advantages

- absolutely chip-free jointing and rabbeting
- Thanks to the rounded turnover knives the machined surface is offset-free
- excellent edge and surface quality
- very high milling performance
- spiral plunge-cutting for free form milling
- Triangular turnover knives with rounded edges 3 edge lives

Notes

- Spiral plunge-cutting, pockets larger than Ø 60
- Feed per tooth fz = 0.2-0.5 mm
- Turnover knife 9209773 scoring without projection, suitable for jointing without groove
- When used in collet chucks, use lock washer with screw 9260834

Ø D	L2	Ø d	L3	L1	Z	Number of cutting edges	Ident-No.
54	78	20	52	133.5	2+2	14	187268 L
54	63	25	52	120	2+2	12	187299 L
54	78	25	52	133.5	2+2	14	187300 L
54	106,5	25	52	162.5	2+2	18	187113 L
61	79,1	25	52	139.2	2+2	14	187330 C
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

Turnover Knives	B	H	S	LEUCODUR	Class-No.	PU	Ident-No.
	20,38	17.9	3.0	HL Solid 20	150557	10	9209773 L
	20,88	18.3	3.0	HL Board 06	150566	10	187692 L
	20,88	18.3	3.0	HL Solid 20	150567	10	187251 L
	20,88	18.3	3.0	HL Solid 20 topcoat	150667	10	187694 L
	[mm]	[mm]	[mm]			[pc.]	

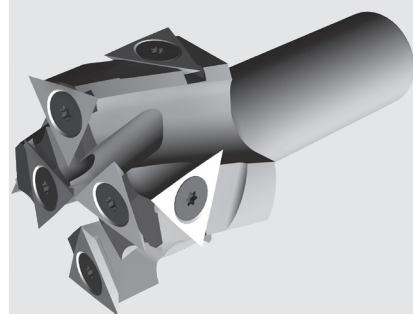
Spare parts / Accessories

	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x9 T15	995125	10	80492032 L
Screwdrivers	T15x100	985730	1	80504539 L
Torque Screwdrivers without insert	4,2 Nm	985730	1	80504561 L
Lock washer with screw	D=26 / M6x16	997300	1	9260834 L
	[mm]		[pc.]	

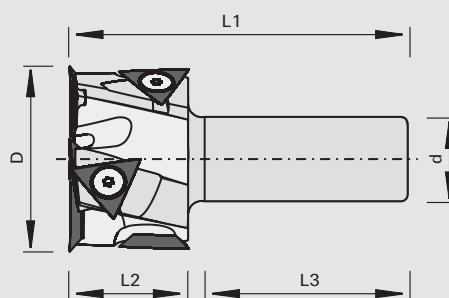
128260

Rabbeting Shank-Type Cutters with HW Turnover Knives - t3-System

Product



Drawing


LEUCO
t3system

Tungsten Carbide [HW]

MEC

Machine / Application

| CNC and joinery machines
 | for offset and chip-free
 rabbeting of solid wood and
 wood-based materials

Design

| Rounded triangular turnover
 knives with cutting edges
 drawing from top to bottom
 | also for rabbets <21 mm
 | Cutting material: HW
 | HL Solid 20 for hard wood and
 soft wood
 | HL Board 06 for wood-based
 materials, plastics and hard
 woods
 | topcoat coating for increased
 edge lives

Advantages

| absolutely chip-free rabbeting
 | Thanks to the rounded turnover
 knives the machined surface is
 offset-free
 | excellent edge and surface
 quality
 | very high milling performance
 | spiral plunge-cutting for free
 form milling
 | Triangular turnover knives with
 rounded edges 3 edge lives

Notes

| Spiral plunge-cutting, pockets
 larger than Ø 60
 | Feed per tooth fz = 0.2-0.5
 mm
 | Turnover knife 9209773
 scoring without projection,
 suitable for jointing without
 groove
 | When used in collet chucks,
 use lock washer with screw
 9260834

Ø D	L2	Ø d	L3	L1	Z	Number of cutting edges	Ident-No.
54	35	25	61	100	2+2	8	187269 C
61	35	25	61	100	2+2	8	187369 L
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

Turnover Knives	B	H	S	LEUCODUR	Class-No.	PU	Ident-No.
	20,38	17.9	3.0	HL Solid 20	150557	10	9209773 L
	20,88	18.3	3.0	HL Board 06	150566	10	187692 L
	20,88	18.3	3.0	HL Solid 20	150567	10	187251 L
	20,88	18.3	3.0	HL Solid 20 topcoat	150667	10	187694 L
	[mm]	[mm]	[mm]			[pc.]	

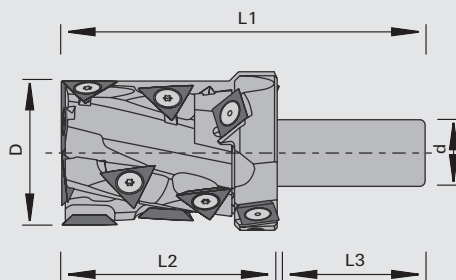
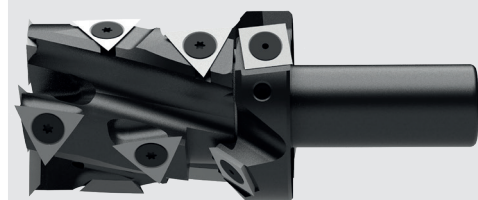
Spare parts / Accessories	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x9 T15	995125	10	80492032 L
Screwdrivers	T15x100	985730	1	80504539 L
Torque Screwdrivers without insert	4,2 Nm	985730	1	80504561 L
Lock washer with screw	D=26 / M6x16	997300	1	9260834 L
	[mm]		[pc.]	

128260

Socket hole milling cutter HW - t3-System

Product

Drawing


LEUCO
t3system

Tungsten Carbide [HW]

MEC

Machine / Application

Joinery machines, e.g. Hundegger, Weinmann, Krüsi
for milling of socket holes in soft and hard wood, glued laminated timber, wood and panel materials as well as gypsum board and hardwood laminated, beech veneer lumber

Design

Rounded triangular turnover knives with cutting edges drawing from top to bottom
Cutting material: HW
HL Solid 20

Advantages

Drilling and chamfering 2x45° in the same operation
Thanks to the rounded turnover knives the machined surface is offset-free
Excellent edge and surface quality
Very high milling performance
spiral plunge-cutting for free form milling
Triangular turnover knives with rounded edges, 3 edge lives

Notes

Ø D	L2	Ø d	L3	L1	Z	Number of cutting edges	Ident-No.
61	80	25	55	136.5	2+2+2	16	80479566 C
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

Turnover Knives	B	H	S	LEUCODUR	Class-No.	PU	Ident-No.
	14	14	2.0	HL Solid 30	150558	10	003079 L
	20,38	17.9	3.0	HL Solid 20	150557	10	9209773 L
	20,88	18.3	3.0	HL Solid 20	150567	10	187251 L
	20,88	18.3	3.0	HL Solid 20 topcoat	150667	10	187694 L
	20,88	18.3	3.0	HL Board 06	150566	10	187692 L
	[mm]	[mm]	[mm]			[pc.]	

Spare parts / Accessories

Dimension

Class-No.

PU

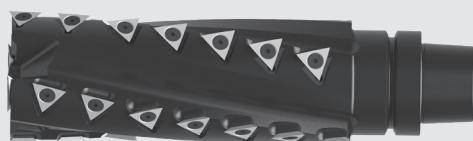
Ident-No.

Countersunk Screws	M5x6 T20 D=Ø9,3	995125	10	176199 L
Screwdrivers	T20x100	985730	1	166092 L
Countersunk Screws	M5x9 T15	995125	10	80492032 L
Screwdrivers	T15x100	985730	1	80504539 L
Torque Screwdrivers without insert	4,2 Nm	985730	1	80504561 L
	[mm]		[pc.]	

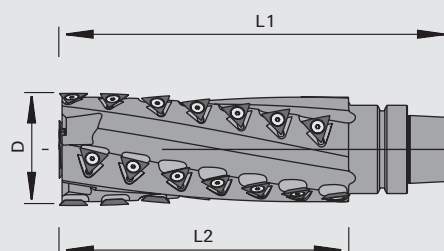
128260

Monolithic shank-type cutter HSK 63E with turnover knives - t3-System

Product



Drawing



LEUCO
t3system

Tungsten Carbide [HW]

MEC

Machine / Application

| CNC and joinery machines
 | for shoulder- and chip-free
 jointing, rabbeting and sizing
 of soft and hard wood, glued
 laminated timber, wood and
 panel materials as well as
 gypsum board and hardwood
 laminated, beech veneer
 lumber

Design

| Triangular turnover knives with
 rounded cutting edges drawing
 from bottom to top and from
 top to bottom
 | Monolithic design thanks to the
 removal of the interface

Advantages

| Absolutely chip-free jointing and
 rabbeting
 | Thanks to the rounded turnover
 knives the machined surface is
 offset-free
 | Excellent edge and surface
 quality
 | Very high milling performance
 | spiral plunge-cutting for free
 form milling
 | Triangular turnover knives with
 rounded edges, 3 edge lives
 | further optimization of the
 concentricity due to the removal
 of the interface

Notes

Ø D	L2	Ø d	L1	Z	Number of cutting edges	Ident-No.
80	207,6	HSK 63E	280.5	2+2	32	80482108 C
[mm]	[mm]	[mm]	[mm]		[pc.]	

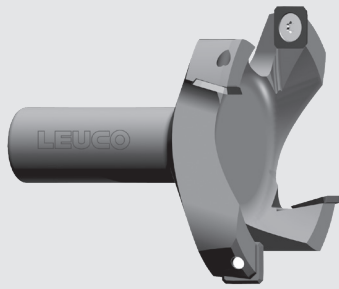
Turnover Knives	B	H	S	Class-No.	PU
	20,38	17.9	3.0	HL Solid 20	150557 10 9209773 L
	20,88	18.3	3.0	HL Solid 20	150567 10 187251 L
	20,88	18.3	3.0	HL Solid 20 topcoat	150667 10 187694 L
	20,88	18.3	3.0	HL Board 06	150566 10 187692 L
	[mm]	[mm]	[mm]		[pc.]

Spare parts / Accessories	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x9 T15	995125	10	80492032 L
Screwdrivers	T15x100	985730	1	80504539 L
Torque Screwdrivers without insert	4,2 Nm	985730	1	80504561 L
	[mm]		[pc.]	

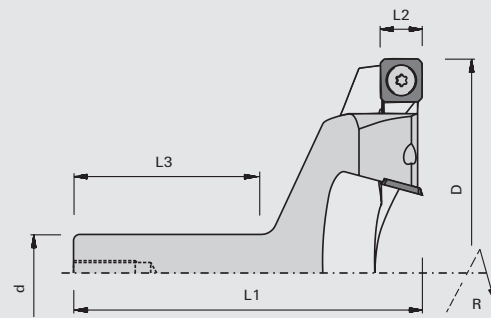
128200

Planing Shank-Type Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- l CNC routers
- l for planing and panel raising in wood-based materials
- l not suitable for rabbeting

Design

- l cutting material: HL Solid 20

Advantages

- l high milling performance when dressing the workbench boards, e.g. with Nesting technology
- l smooth surface thanks to special cutting edge geometry

Notes

- l with thread for length adjusting screw
- l sense of rotation according to VDMA 8849

Ø D	L2	Ø d	L3	L1	Z	nmax	Ident-No. [R]
100	14	20	45	96	4	15200	182619 C
100	14	25	55	96	4	15200	182620 L
150	14	25	55	113	4	10100	182621 C
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	14	14	2.0	150557	10	182441 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x6 T20 D=Ø9,3	995125	10	176199 L
Screwdrivers	T20x100	985730	1	166092 L
	[mm]		[pc.]	

129460

CNC Spoilboard Surfacing

Product



LEUCO

LEUCO
DUR

Tungsten Carbide (HM)

Machine / Application

| CNC routers
 | for surfacing of spoilboards on CNC routers

Design

| 4 sided carbide inserts
 | straight or upshear

Advantages

| maximum edgelife thanks to superior ultra hard carbide

Notes

| improve performance by using precision clamping systems like: PS-System and Sino.
 | also suited for use in mechanical draw-in collet chucks
 | 2 1/2" Diameter 16,000 max RPM
 | 4" Diameter 14,000 max RPM

Straight Cut

Large Diameter	SHK	# of Wings	Ident-No.
2 1/2"	1/2"	2	1727559
4"	3/4"	2	1738562
4"	3/4"	3	1727679

Up Shear Cut

Large Diameter	SHK	# of Wings	Ident-No.
2 1/2"	1/2"	2	1720640
4"	3/4"	3	1727664

Carbide Inserts (Indexable - 4 cutting edges)

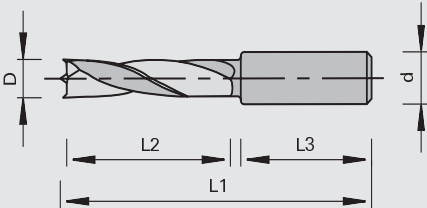
Description	Size	Ident-No.
Replacement Inserts	14mm x 14mm x 2mm	3079
Replacement Insert Screw	M5 x 7	180839
Insert Wrench	T - 15 Torx	163161

Brad Point Drill - 4 Flute / 57.5 & 70mm Long

Product



Drawing




tungsten carbide [HW]

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | 2 negative spurs
- | centering point
- | spiral with back guide
- | HW-tipped

Advantages

- | chip-free hole edges thanks to negative spurs
- | safe drilling thanks to centering point
- | reduced chipping on panel face thanks to spiral with back guide

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck
- | 2 flute drills available in standard sizes

D	d	L3	L1	Ident-No. (L)	Ident-No. (R)
4	10	20	57.5	1739379	1739378
5	10	20	57.5	1739381	1739380
6	10	20	57.5	1739383	1739382
1/4"	10	20	57.5	1739385	1739384
7	10	20	57.5	1739387	1739386
8	10	20	57.5	1739389	1739388
9	10	20	57.5	1739391	1739390
3/8"	10	20	57.5	1739393	1739392
10	10	20	57.5	1739395	1739394
11	10	20	57.5	1739397	1739396
12	10	20	57.5	1739399	1739398
1/2"	10	20	57.5	1739401	1739400

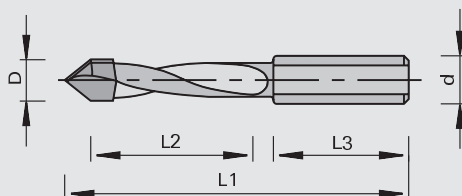
D	d	L3	L1	Ident-No. (L)	Ident-No. (R)
4	10	20	70	1739331	1739330
5	10	20	70	1739333	1739332
6	10	20	70	1739335	1739334
1/4"	10	20	70	1739337	1739336
7	10	20	70	1739339	1739338
8	10	20	70	1739341	1739340
9	10	20	70	1739343	1739342
3/8"	10	20	70	1739345	1739344
10	10	20	70	1739347	1739346
11	10	20	70	1739349	1739348
12	10	20	70	1739351	1739350
1/2"	10	20	70	1739353	1739352

V-Point Drill - 4 Flute / 57.5 & 70mm Long

Product



Drawing



tungsten carbide [HW]

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for drilling of through-holes in solid woods and wood-based panels

Design

- 2 v-point edges (60° angle)
- HW-tipped
- cylindrical shank with clamping surface
- spiral with back guide

Advantages

- protection of the hole edge upon exiting thanks to spiral with back guide
- reduced chipping on panel face thanks to spiral with back guide

Notes

- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combo chuck, quick-change chuck
- 2 flute drills available in standard sizes

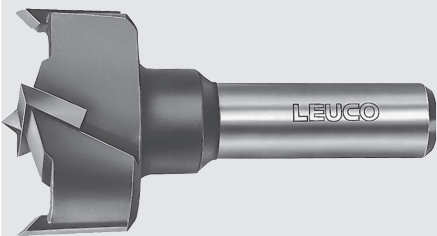
D	d	L3	L1	Ident-No. (L)	Ident-No. (R)
4	10	20	57.5	1739403	1739402
5	10	20	57.5	1739405	1739404
6	10	20	57.5	1739407	1739406
1/4"	10	20	57.5	1739409	1739408
7	10	20	57.5	1739411	1739410
8	10	20	57.5	1739413	1739412
9	10	20	57.5	1739415	1739414
3/8"	10	20	57.5	1739417	1739416
10	10	20	57.5	1739419	1739418
11	10	20	57.5	1739421	1739420
12	10	20	57.5	1739423	1739422
1/2"	10	20	57.5	1739425	1739424

D	d	L3	L1	Ident-No. (L)	Ident-No. (R)
4	10	20	70	1739355	1739354
5	10	20	70	1739357	1739356
6	10	20	70	1739359	1739358
1/4"	10	20	70	1739361	1739360
7	10	20	70	1739363	1739362
8	10	20	70	1739365	1739364
9	10	20	70	1739367	1739366
3/8"	10	20	70	1739369	1739368
10	10	20	70	1739371	1739370
11	10	20	70	1739373	1739372
12	10	20	70	1739375	1739374
1/2"	10	20	70	1739377	1739376

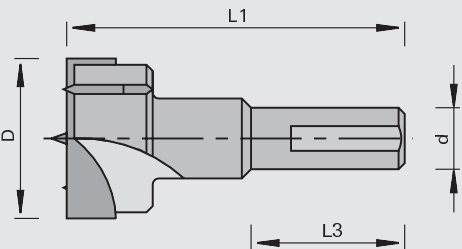


Hinge Boring Drill - 57.5 & 70mm Long

Product



Drawing



tungsten carbide [HW]

Machine / Application

- | hardware hinge machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of hinge hardware holes in solid woods and wood-based panels

Design

- | 2 rakers, 2 spurs and centering point
- | HW-tipped

Advantages

- | chip-free holes thanks to scoring cut of the spurs

Notes

- | cylindrical shank with clamping surface
- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-clamping chuck

D	d	L3	L1	Ident-No. (L)	Ident.-No. (R)
15	10	25	57.5	1739958	1739957
18	10	25	57.5	1739960	1739959
20	10	25	57.5	1739962	1739961
25	10	25	57.5	1739964	1739963
26	10	25	57.5	1739966	1739965
35	10	25	57.5	1739968	1739967
40	10	25	57.5	1739970	1739969

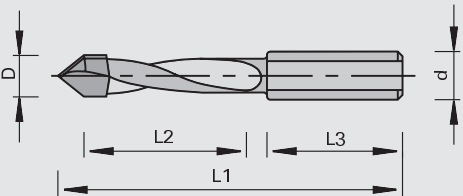
D	d	L3	L1	Ident-No. (L)	Ident.-No. (R)
15	10	25	70	1739972	1739971
18	10	25	70	1739974	1739973
20	10	25	70	1739976	1739975
25	10	25	70	1739978	1739977
26	10	25	70	1739980	1739979
35	10	25	70	1739982	1739981
40	10	25	70	1739984	1739983

130013
Mosquito Through-Hole Bits HW

Product



Drawing



MOSQUITO

Tungsten Carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of through-holes in solid woods and wood-based panels

Design

- | special cutting edge geometry
- | HW-plunging tip made from super-fine grain material

Advantages

- | chip-free hole edges thanks to special cutting edge geometry
- | long edge lives thanks to HW plunging tip
- | high process safety thanks to constant quality of the bores for a long time

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	27	10	26	57.5	182458 L	182459 L
8.0	27	10	26	57.5	182460 C	182461 C
5.0	35	10	26	70	182462 L	182463 L
6.0	35	10	26	70	183689 L	183688 L
7.0	35	10	26	70	183691 L	183690 L
8.0	35	10	26	70	182464 L	182465 L
10	35	10	26	70	183693 L	183692 L
[mm]	[mm]	[mm]	[mm]	[mm]		

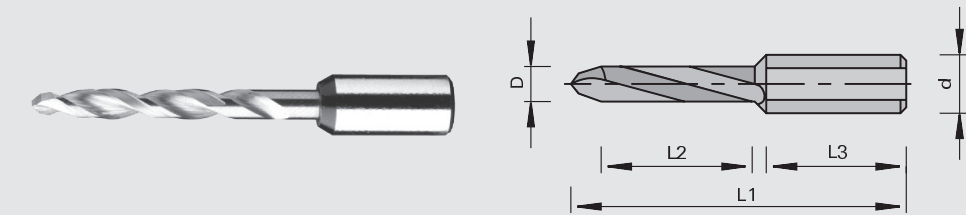


130013

Mosquito Through-Hole Bits with solid carbide body

Product

Drawing



MOSQUITO

Solid Tungsten Carbide

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of through-holes in solid woods and wood-based panels

Design

- | special cutting edge geometry
- | boring part made from fine-grain solid tungsten carbide

Advantages

- | chip-free hole edges thanks to special cutting edge geometry
- | high feed rates and edge lives increased up to sixfold compared to traditional dowel bits thanks to solid carbide design
- | high process safety thanks to constant quality of the bores for a long time

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 included in delivery
- | through-hole bit with shank length L3=24 mm is not suitable for Weeke adjusting screw
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
3.0	27	10	30	70	183687 L	183686 L
4.0	35	10	24	70	183167 L	183166 L
4.5	35	10	24	70	80356921 L	80356920 L
5.0	35	10	24	70	183153 L	183152 L
6.0	35	10	24	70	183155 L	183154 L
8.0	35	10	24	70	183157 L	183156 L
10	35	10	24	70	186523 L	186524 L
[mm]	[mm]	[mm]	[mm]	[mm]		

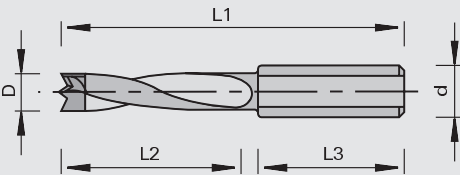
Ø D	L2	Ø d	L3	L1		Ident-No. [R]
6.0	35	10	50	100	for Lamello Clamex P®	184289 L
[mm]	[mm]	[mm]	[mm]	[mm]		

130213
Mosquito Dowel Bits HW

Product



Drawing



MOSQUITO

Tungsten Carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | special cutting edge geometry
- | 2 spurs
- | centering point
- | HW-tipped

Advantages

- | chip-free hole edges thanks to special cutting edge geometry with spurs
- | safe drilling thanks to centering point
- | high process safety thanks to constant quality of the bores for a long time
- | tool life increased up to sixfold compared to traditional dowel bits thanks to wear-resistant HW plunging tip

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	25	10	27	57.5	181168 L	181167 L
6.0	25	10	27	57.5	181522 L	181521 L
7.0	27	10	27	57.5	183159 O	183158 O
8.0	25	10	27	57.5	181170 L	181169 L
9.0	27	10	27	57.5	183161 O	183160 O
10	25	10	27	57.5	181524 L	181523 L
5.0	35	10	30	70	181172 L	181171 L
6.0	35	10	30	70	181526 L	181525 L
7.0	35	10	30	70	183163 L	183162 L
8.0	35	10	30	70	181174 L	181173 L
9.0	35	10	30	70	183165 O	183164 O
10	35	10	30	70	181528 L	181527 L
[mm]	[mm]	[mm]	[mm]	[mm]		

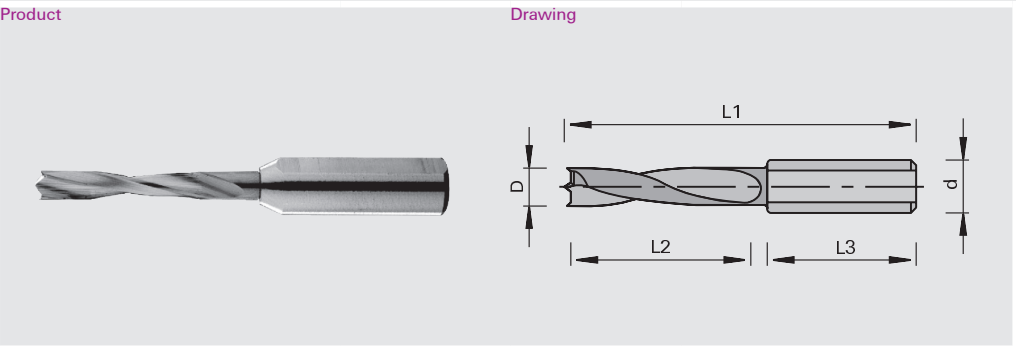


130213

Mosquito Dowel Bits with solid carbide body

Product

Drawing



MOSQUITO

Solid Tungsten Carbide

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | special cutting edge geometry
- | 2 spurs
- | centering point
- | boring part made from fine-grain solid tungsten carbide

Advantages

- | chip-free hole edges thanks to special cutting edge geometry with spurs
- | safe drilling thanks to centering point
- | high feed rates and edge lives increased up to sixfold compared to traditional dowel bits thanks to solid carbide design
- | high process safety thanks to constant quality of the bores for a long time

Notes

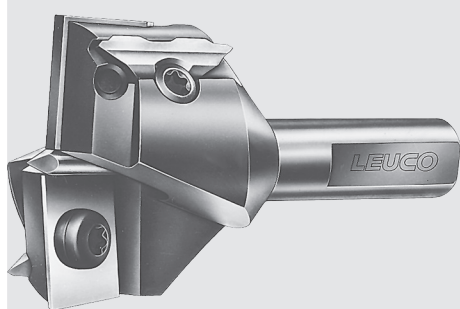
- | adjusting screw Ident-No. 001600 M5x10 DIN 551 included in delivery
- | through-hole bit with shank length L3=22 mm is not suitable for Weeke adjusting screw
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
3.0	9,0	10	35	57.5	183143 O	183142 O
3.0	18	10	31	57.5	182380 L	182381 L
4.0	20	10	29	57.5	182382 C	182383 C
5.0	22	10	27	57.5	182384 L	182385 L
6.0	22	10	25	57.5	183145 O	183144 O
8.0	22	10	25	57.5	183147 O	183146 O
3.0	18	10	43.5	70	182386 L	182387 L
4.0	30	10	31.5	70	182388 L	182389 L
5.0	30	10	31.5	70	182390 L	182391 L
6.0	30	10	30	70	183149 L	183148 L
8.0	35	10	22	70	183151 L	183150 L
[mm]	[mm]	[mm]	[mm]	[mm]		

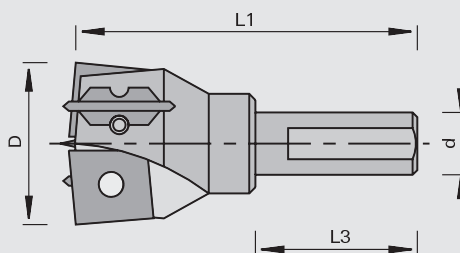
130135 / 130137

Cylinder Boring Bits with HW Turnover Knives

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- hardware hinge machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of hinge hardware holes in solid woods and wood-based panels

Design

- 2 rakers, 2 turnover spurs and centering point

Advantages

- long edge lives thanks to wear-resistant HW grade
- chip-free hardware hinge holes thanks to scoring cut of the turnover spurs

Notes

- replaceable and adjustable centering point
- cylindrical shank with clamping surface
- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-clamping chuck

Ø D	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
25	10	26	57.5		162612 S
26	10	26	57.5		162614 L
30	10	26	57.5		162616 C
35	10	26	57.5	162619 L	162618 L
25	10	26	70		182570 C
26	10	26	70		182571 C
30	10	26	70		182572 C
35	10	26	70	184896 L	182573 L
[mm]	[mm]	[mm]	[mm]		

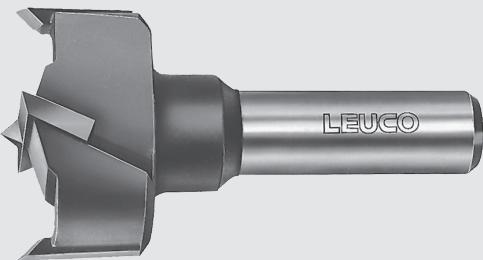
Turnover Knives	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Turnover Knives	11x12x1,5	162614, 182571	150515	10	162637 L
Turnover Knives	15,7x12x1,5	162619, 162618, 182573	150515	10	163846 L
Turnover Knives	13x12x1,5	162616, 182572	150515	10	162638 L
Turnover Knives	10,5x12x1,5	162612, 182570	150515	10	162636 L
Spurs	18x5,7x3,5	For all	150556	10	187303 L
Centering Points	3x33,5	For all	165512	10	162624 L
	[mm]			[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Set Screws	M6x6 DIN EN ISO 4028	For all	995161	10	163841 L
Countersunk Screws	M3,5x6 T15 D=Ø5,4	162619, 162618, 182573, 162614, 162616, 182571, 182572, 184896	995125	10	162648 L
Countersunk Screws	M3,5x5,5 T15 D=Ø5,4	162612, 182570	995125	10	162649 L
Head Cap Screws	M3,5x3,8 T15	162612, 162614, 162616, 182570, 182571, 182572	995115	10	162645 L
Head Cap Screws	M3,5x6,5 T15	162619, 162618, 182573, 184896	995115	10	162644 L
	[mm]			[pc.]	

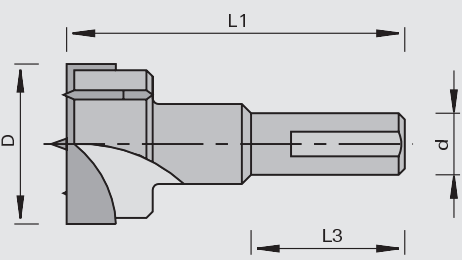
130115 / 130117

Cylinder Boring Bits HW - Z=2+2

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- | hardware hinge machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of hinge hardware holes in solid woods and wood-based panels

Design

- | 2 rakers, 2 spurs and centering point
- | HW-tipped

Advantages

- | chip-free holes thanks to scoring cut of the spurs

Notes

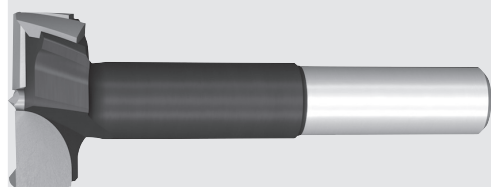
- | cylindrical shank with clamping surface
- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-clamping chuck

Ø D	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
15	10	26	57.5	003303 L	003302 L
16	10	26	57.5	003305 L	003304 L
18	10	26	57.5	003309 L	003308 L
20	10	26	57.5	003313 L	003312 L
22	10	26	57.5	003315 L	003314 L
25	10	26	57.5	003319 L	003318 L
26	10	26	57.5	003321 L	003320 L
30	10	26	57.5	003327 L	003326 L
35	10	26	57.5	003333 L	003332 L
40	10	26	57.5	003337 L	003336 L
15	10	26	70	178978 L	172250 L
18	10	26	70	178983 L	178984 L
20	10	26	70	178979 L	172251 L
22	10	26	70	182257 L	182258 L
25	10	26	70	178980 L	172252 L
26	10	26	70	182374 L	182375 L
30	10	26	70	178981 L	172253 L
35	10	26	70	178982 L	172254 L
40	10	26	70	182259 L	182260 L
[mm]	[mm]	[mm]	[mm]		

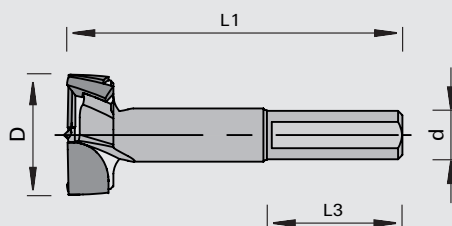
130115 / 130117

Cylinder Boring Bits HW - "Light"

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- hardware hinge machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of hinge hardware holes in solid woods and wood-based panels

Design

- 2 rakers, 2 spurs and centering point
- HW-tipped

Advantages

- chip-free bore holes even on partly open holes near the edge of the panel thanks to particular geometry of spurs
- excellent chip removal thanks to big gullets
- the shorter center point allows for drilling deep holes close to the bottom of panel
- low cutting pressure

Notes

- cylindrical shank with clamping surface
- with length adjusting screw M5x10 DIN 551
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-clamping chuck

Ø D	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
15	10	26	57.5	184677 L	184676 L
18	10	26	57.5	185029 L	185028 L
20	10	26	57.5	185031 L	185030 L
25	10	26	57.5	184679 L	184678 L
26	10	26	57.5	185033 L	185032 L
35	10	26	57.5	184681 L	184680 L
[mm]	[mm]	[mm]	[mm]		
Ø D	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
15	10	26	70	184685 L	184684 L
18	10	26	70	185035 L	185034 L
20	10	26	70	185037 L	185036 L
25	10	26	70	184687 L	184686 L
26	10	26	70	185039 L	185038 L
35	10	26	70	184689 L	184688 L
[mm]	[mm]	[mm]	[mm]		



130110

Drill Bits HW for Lamello Cabineo® pockets

Product	Drawing		Notes LEUCO DUR Tungsten Carbide [HW] MEC
Machine / Application CNC machining centers for precise and time-efficient plunge cutting of 3-fold bores for Lamello Cabineo® with drilling units	Design Set consisting of two left and a right HW cylinder boring bit 2 HW rakers with ground spurs Ground centering point	Advantages	Notes Type A: for Atemag drilling unit Type B: for Benz drilling unit

Set of drill bits

Ø D	Ø d	L3	L1	Type	Ident-No.
15	6	22.5	37	B	80499238 0
15	6	22.5	37	A	80499239 0
[mm]	[mm]	[mm]	[mm]		

Individual drill bit

Ø D	Ø d	L3	L1	Type		Ident-No.
15	6	22.5	37	A/B	L	80499240 0
15	6	22.5	37	B	R	80499241 0
15	6	22.5	37	A	R	80499242 0
[mm]	[mm]	[mm]	[mm]			



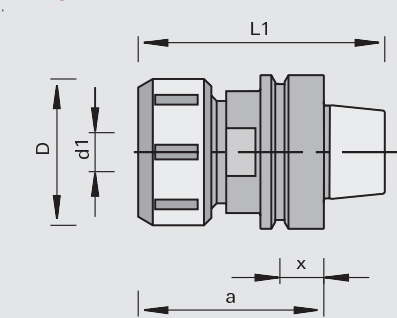
933289

Draw-In Collet Chucks with HSK shank

Product



Drawing



LEUCO
CNC

Machine / Application

- CNC machining centers with automatic tool changer
- for precise clamping of shank-type tools with cylindrical shank

Design

- interface according to DIN 69893 HSK 50F, HSK 63F and HSK 63E
- lock nut with sleeve bearing
- # 1734715 with static nut - RH
- Rotation only

Advantages

- flexible utilization by collet chucks

Notes

- for right- and lefthand rotation
- Ident-No. 175795 for IMA (up to 12/94) similar to DIN 69893
- included in delivery: collet chuck, clamping nut without spanner wrench
- attention: different interfaces in case of CMS machines, according to spindle performance (KW)

Ø d1min	Ø d	Ø D	L1	a	x	Type	Ident-No.	
2-25	HSK 63F	60	101	76	18	462E / OZ25	Homag, IMA from 01/95, Weeke from 03/98, HOLZ-HER, SCM, CMS (12+15 KW)	173293
2-25	HSK 63F	63	101	76	18	472E / ER40	Static nut for Komo RH only	1734715
2-25	HSK 63F	60	101	76	9	462E / OZ25	IMA up to 12/94	175795
2-25	HSK 63F	60	140	115	18	462E / OZ25	Homag, IMA from 01/95, Weeke from 03/98, HOLZ-HER, CMS (12+15 KW)	179170
2-25	HSK 63F	60	101	76	18	472E / ER40	Komo-RH only w/static nut	1734715
2-20	HSK 63F	50	94	70	18	470E / ER32		1739775

Spare parts

Dimension

Ident-No.

Lock Nut with sleeve bearing	M48 x 2R X 60MM OD	178764
Torque wrench	200 TH 30 to 150 FT/LB	1741286
Torque wrench with collet nut key	For chuck 1739775 (470E/ER32) - Key ER32 Slotted	1747857
Torque wrench with collet nut key	For chuck 1734715 (472E/ER40) - Key ER40 Slotted	80392724
Torque wrench with collet nut key	For chuck 173293 (462E/OZ25) - C Spanner Hook	1741287
Torque wrench with collet nut key	For chuck 175795 (462E/OZ25) - C Spanner Hook	1741287
Torque wrench with collet nut key	For chuck 179170 (462E/OZ25) - C Spanner Hook	1741287

Key: 1747857

Key: 80392724

Key: 1741287

ER 32 Slotted

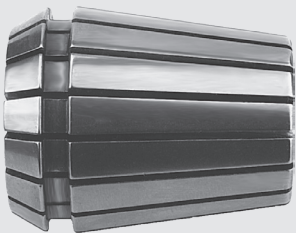
ER40 Slotted

C Spanner Hook

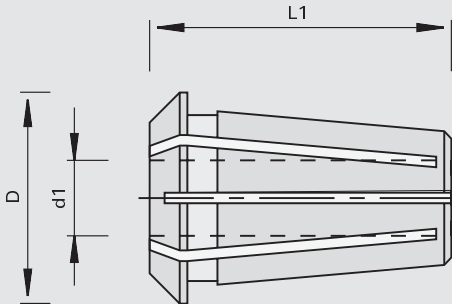


933280
Precision Collets - Metric 462E/SYOZ25

Product



Drawing



LEUCO
GmbH

Machine / Application

for use in draw-in collet chuck
Type 462E/SYOZ25

Design

clamping tolerance 0.5 mm
according to DIN 6388 Type
462E/SYOZ25

Advantages

optimum transmission of
clamping force

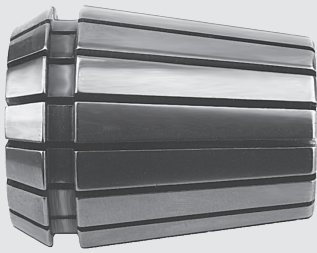
Notes

Ø d1min	Ø D	L1	Ident-No.
2	35.05	52	183803 o
3	35.05	52	183804
4	35.05	52	183805
5	35.05	52	183806
6	35.05	52	180213
7	35.05	52	183807 o
8	35.05	52	180358
9,5	35.05	52	175817
10	35.05	52	170782
12	35.05	52	168742
13	35.05	52	180215
14	35.05	52	170783
15	35.05	52	183808 o
16	35.05	52	168743
18	35.05	52	180216
20	35.05	52	168744
25	35.05	52	168745
[mm]	[mm]	[mm]	

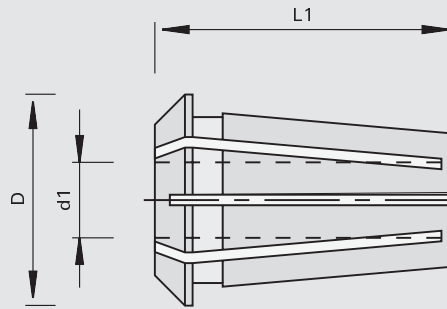
933280

Precision Collets - Inch Size

Product



Drawing

LEUCO
CNC

Machine / Application

for use in draw-in collet chuck
Type 462E (RD035/SYOZ25)
Type 470E (ER32)

Design

clamping tolerance
462E = 0.50mm DIN 6388
470E & 472E = 1.0mm DIN
6499

Advantages

optimum transmission of
clamping force

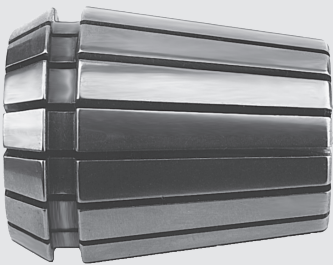
Notes

Ø D	Ø d 1 min	L1	Type	Ident-No.
34.8	1/8	52	462E	1739116
34.8	1/4	52	462E	1741038
34.8	3/8	52	462E	1739152
34.8	1/2	52	462E	1741039
34.8	5/8	52	462E	1741040
34.8	3/4	52	462E	1741041
34.8	7/8	52	462E	1723194
34.8	15/16	52	462E	1723195
34.8	1	52	462E	715048
33	3/32	40	470E	1723056
33	1/8	40	470E	1723057
33	3/16	40	470E	1723059
33	1/4	40	470E	1723061
33	5/16	40	470E	1723063
33	3/8	40	470E	1723065
33	7/16	40	470E	1723067
33	1/2	40	470E	1723069
33	9/16	40	470E	1723071
33	5/8	40	470E	1723073
33	11/16	40	470E	1723075
33	3/4	40	470E	1723077
[mm]	[inch]	[mm]		

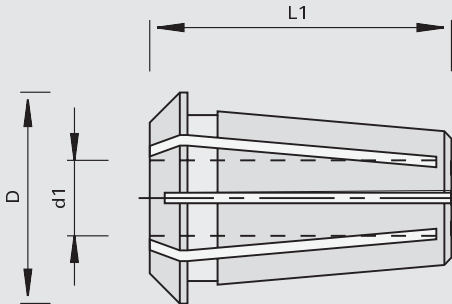


933280
Precision Collets - Inch Size

Product



Drawing





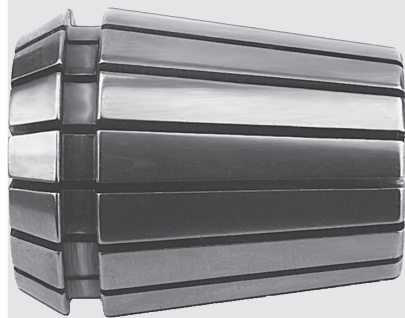
Machine / Application	Design	Advantages	Notes
I for use in draw-in collet chuck Type 472E (ER40)	I clamping tolerance 472E = 1.0mm DIN 6499	I optimum transmission of clamping force	

Ø D	Ø d 1 min	L1	Type	Ident-No.
41	3/16	46	472E	1723080
41	1/4	46	472E	1723082
41	9/32	46	472E	1723083
41	5/16	46	472E	1723084
41	11/32	46	472E	1723085
41	3/8	46	472E	1723086
41	13/32	46	472E	1723087
41	7/16	46	472E	1723088
41	1/2	46	472E	1723090
41	17/32	46	472E	1723091
41	9/16	46	472E	1723092
41	19/32	46	472E	1723093
41	5/8	46	472E	1723094
41	21/32	46	472E	1723095
41	11/16	46	472E	1723096
41	23/32	46	472E	1723097
41	3/4	46	472E	1723098
41	25/32	46	472E	1723099
41	13/16	46	472E	1723100
41	27/32	46	472E	1723101
41	7/8	46	472E	1723102
41	29/32	46	472E	1723103
41	15/16	46	472E	1723104
41	31/32	46	472E	1723105
41	1	46	472E	1723106
[mm]	[inch]	[mm]		

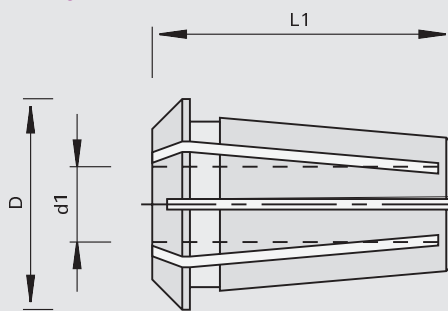
933280

Precision collets - 430E/ER25, 470E/ER32, 472E/ER40

Product



Drawing


LEUCO
CNC

Machine / Application

for use in draw-in collet chuck
Type 430E/ER25, 470E/ER32,
472E/ER40

Design

slotted from top and bottom
clamping tolerance 1 mm

Advantages

Notes

Type 430E/ER25 Ø 6 - 16
mm for special chuck
Type 470E/ER32 Ø 3 - 20
mm
Type 472E/ER40 Ø 6 - 25
mm

Ø D	Ø d1	Ø d1	L1	Type	Ident-No.
33	3		40	470E/ER32	173647 O
33	4		40	470E/ER32	173648 C
33	5		40	470E/ER32	173649 C
33	6		40	470E/ER32	173650 L
33	7		40	470E/ER32	173651 O
33	8		40	470E/ER32	173652 L
33	10		40	470E/ER32	173653 L
33	12		40	470E/ER32	173654 L
33	13		40	470E/ER32	173655 O
33	14		40	470E/ER32	173656 C
33	16		40	470E/ER32	173657 L
33	18		40	470E/ER32	173658 O
33	19		40	470E/ER32	173659 O
33	20		40	470E/ER32	173660 L
33		1/4"	40	470E/ER32	175829 L
33		1/2"	40	470E/ER32	175830 L
33		5/8"	40	470E/ER32	175831 S
33		3/4"	40	470E/ER32	175832 O
41	6		46	472E/ER40	180912 C
41	8		46	472E/ER40	180913 L
41	10		46	472E/ER40	180914 C
41	12		46	472E/ER40	175833 L
41	16		46	472E/ER40	175834 L
41	18		46	472E/ER40	175835 C
41	20		46	472E/ER40	175836 L
41	25		46	472E/ER40	175837 L
41	30		46	472E/ER40	80329695 O
41		1/4"	46	472E/ER40	175838 O
41		1/2"	46	472E/ER40	175839 C
41		5/8"	46	472E/ER40	175840 C
41		3/4"	46	472E/ER40	175841 O
41		1"	46	472E/ER40	175842 S
26	6		34	430E/ER25	181986 O
26	8		34	430E/ER25	181987 L
26	10		34	430E/ER25	181988 L
26	12		34	430E/ER25	181989 L
26	14		34	430E/ER25	181990 O
26	16		34	430E/ER25	181991 L
[mm]	[mm]	[inch]	[mm]		



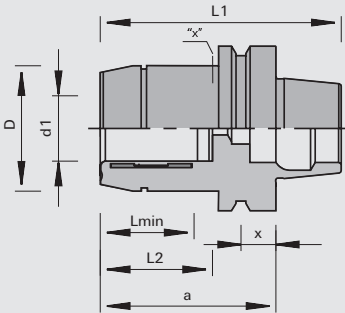
933240

Hydro Clamping Chuck ps-System with HSK 63F

Product



Drawing



LEUCO
ps-system

Machine / Application

- | CNC machining centers with automatic tool changer
- | for precise clamping of shank-type tools with cylindrical shank

Design

- | n max = 30,000 min -1
- | interface DIN 69893 HSK 63 F

Advantages

- | minimization of setup-times thanks to easy and quick tool change
- | high cutting quality and long edge lives thanks to high concentricity
- | optimum torque transfer

Notes

- | for right- and lefthand rotation
- | with bore for installation of micro chips for electronic tool detection
- | x = pressurization by means of screwdriver
- | hexagonal screwdriver is not included in delivery
- | Lmin minimum clamping length = minimum shaft length

Ø d1	Lmin	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
10	31	41	HSK 63F	30	105	80	18	1.2	184725 L
12	36	46	HSK 63F	32	105	80	18	1.16	184306 L
16	39	49	HSK 63F	38	105	80	18	1.20	184307 L
20	41	51	HSK 63F	52.5	105	80	18	1.30	184308 L
25	47	57	HSK 63F	52.5	109	84	18	1.28	184309 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Ø d1	Lmin	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
3/8"	31	41	HSK 63F	30	105	80	18	1.2	184724 L
1/2"	36	47,5	HSK 63F	32	105	80	18	1.2	184726 L
[inch]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Suitable for	Class-No.	PU	Ident-No.
Screwdrivers	SW4x100	184306, 184724, 184725, 184726	985730	1	166091 L
Screwdrivers	SW5x150	184307, 184308, 184309	985730	1	168703 L
	[mm]			[pc.]	

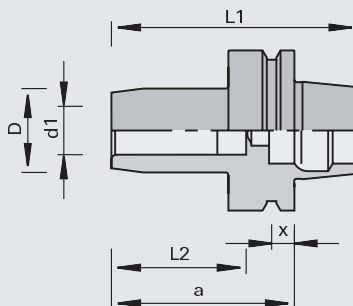
933299

TRIBOS Power Shrink Chucks

Product



Drawing



LEUCO
CNC

Machine / Application

- l CNC machining centers with automatic tool changer
- l for precise clamping of shank-type tools with cylindrical shank

Design

- l $n_{max} = 40,000 \text{ min}^{-1}$

Advantages

- l low weight is easy on machine bearing
- l suitable for high RPM's
- l optimum chip extraction thanks to slim design
- l increased process safety, long edge lives and high machining quality thanks to very high concentricity and repeating accuracy ($< 0.003 \text{ mm}$)

Notes

- l for right- and lefthand rotation
- l different diameters upon request
- l allowed projection: $4 \times d1$
- l clamping of the tools by means of the clamping device
- l can also be done at LEUCO upon request
- l TRIBOS chuck with reinforced design especially for heavy roughing can be delivered upon request
- l delivery without retaining bolts; please choose retaining bolts according to the machine (see page with retaining bolts)

Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
12	48,5	HSK 63F	19	100	75	18	0.69	180257 L
16	48,5	HSK 63F	26	100	75	18	0.74	180899 L
20	52,9	HSK 63F	30	100	75	18	0.77	180258 L
25	55	HSK 63F	35	100	75	18	0.79	180710 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Ø d1	L2	Ø d	Ø D	L1	a	Ident-No.
20	55	SK 30 (DIN)	30	127	80	180888 L
25	55	SK 30 (DIN)	35	127	80	180836 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts	Class-No.	PU	Ident-No.
Mounting Devices (manual)	985201	1	180261 L
Mounting Devices (automatic)	985201	1	181159 S
Reducing inserts for Mounting Device for Ø d = 6	955530	1	183719 C
Reducing inserts for Mounting Device for Ø d = 8	955530	1	183720 C
Reducing inserts for Mounting Device for Ø d = 10	955530	1	183721 C
Reducing inserts for Mounting Device for Ø d = 12	955530	1	180263 L
Reducing inserts for Mounting Device for Ø d = 16	955530	1	180902 L
Reducing inserts for Mounting Device for Ø d = 20	955530	1	180264 L
Reducing inserts for Mounting Device for Ø d = 25	955530	1	180711 C
Length Adjustment Gauge TRIBOS system without interface cable	985300	1	180828 C
Interface Cables for Adjusting Gauges for RS 232C interface	985300	1	180829 S

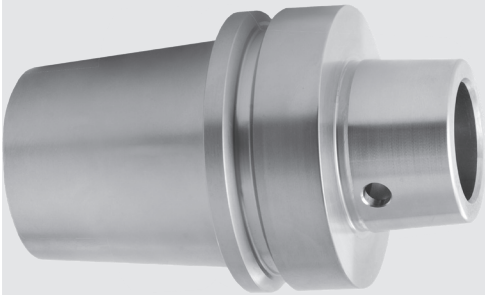
[pc.]



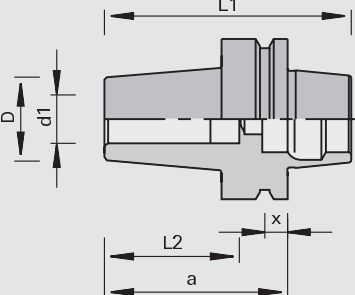
933297

Heat-Shrinking Chucks

Product



Drawing



LEUCO
CNC

Machine / Application

- l CNC machining centers with automatic tool changer
- l for precise clamping of shank-type tools with cylindrical shank

Design

- l n max = 30,000 min-1
- l interface DIN 69893 HSK 63F
- l from high-quality hot work tool steel

Advantages

- l increased process safety, long edge lives and high machining quality thanks to very high concentricity and repeating accuracy (< 0.003 mm)

Notes

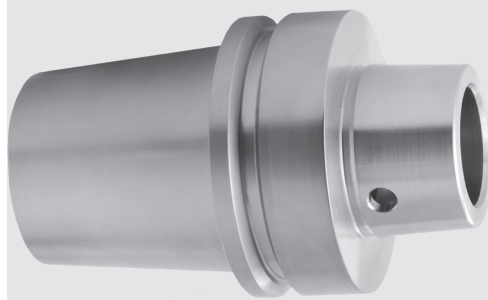
- l for clockwise and counter-clockwise rotation
- l can be clamped and unclamped with all conventional shrinking devices

Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
6,0	36	HSK 63F	20	100	75	18	0.81	186684 L
6,0	36	HSK 63F	20	115	90	18	0.864	80499308 O
8,0	36	HSK 63F	20	100	75	18	0.81	186685 L
8,0	36	HSK 63F	20	115	90	18	0.853	80447794 O
10	41	HSK 63F	26	100	75	18	0.88	183081 L
10	41	HSK 63F	24	115	90	18	0.933	80499309 O
12	47	HSK 63F	28	100	75	18	0.830	183082 L
12	46	HSK 63F	24	115	90	18	0.919	80499310 O
14	47	HSK 63F	28	100	75	18	0.91	183083 L
16	51	HSK 63F	28	100	75	18	0.850	183084 L
16	44	HSK 63F	27	115	90	18	0.954	80499311 O
18	51	HSK 63F	30	100	75	18	1.01	183085 L
20	51	HSK 63F	30	100	75	18	0.930	183086 L
20	51	HSK 63F	33	115	90	18	1.07	80426307 O
25	51	HSK 63F	30	100	75	18	0.91	183087 L
25	52	HSK 63F	36	115	90	18	1.1	80426306 O
25	134	HSK 63F	36	185	160	18	1.96	185520 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

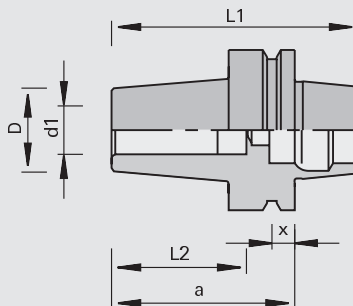
933297

Heat-Shrinking Chucks - joinery machines

Product



Drawing

LEUCO
CNC

Machine / Application

for joinery machines
for precise clamping of shank-type tools with cylindrical shank and reduced Hundegger shaft

Design

in max = 30,000 min-1
interface DIN 69893 HSK 63F, HSK 63E, HSK 80A, HSK 80E, HSK 80F, HSK 100A
from high-quality hot work tool steel

Advantages

increased process safety, long edge lives and high machining quality thanks to very high concentricity and repeating accuracy (< 0.003 mm)

Notes

for clockwise and counter-clockwise rotation
can be clamped and unclamped with all conventional shrinking devices

Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
20	52	HSK 63E	33	112	80	18	1.5	80483321 S
20	52	HSK 63E	33	112	85	18	1.6	80483322 S
20	52	HSK 63E	33	132	100	18	1.2	80483319 C
20	52	HSK 63E	33	192	160	18	1.8	80483305 O
20	52	HSK 63E	33	207	175	18	2.5	80483323 S
25	58	HSK 63E	44	112	85	18	1.6	80483341 S
25	58	HSK 63E	44	147	115	18	1.8	80483334 C
25	58	HSK 63E	44	192	160	18	2.5	80483313 O
30	62	HSK 63E	44	132	100	18	1.5	80483361 S
30	62	HSK 63E	44	177	145	18	3.6	80483362 S
30	62	HSK 63E	44	217	185	18	2.8	80483363 S
30	62	HSK 63E	44	242	210	18	2.8	80483364 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
20	52	HSK 63F	33	100	75	18	0.9	80483302 O
20	52	HSK 63F	33	185	160	18	1.8	80483301 O
20	52	HSK 63F	33	210	185	18	2.6	80483320 S
25	58	HSK 63F	44	100	75	18	1.0	80483311 O
25	58	HSK 63F	44	160	135	18	3.0	80483335 S
25	58	HSK 63F	44	185	160	18	2.5	80483332 C
25	58	HSK 63F	44	210	185	18	2.7	80483336 S
25	58	HSK 63F	44	225	200	18	3.2	80483310 O
30	62	HSK 63F	44	100	75	18	0.9	80483317 O
30	62	HSK 63F	44	120	95	18	1.7	80483355 S
30	62	HSK 63F	44	225	200	18	3.2	80483354 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
20	52	HSK 80A	33	145	105	18	1.6	80483306 O
20	52	HSK 80A	33	200	160	18	2.2	80483307 O
20	52	HSK 80A	33	240	200	18	2.6	80483308 O
25	58	HSK 80A	44	155	115	18	2.2	80483314 O
25	58	HSK 80A	44	200	160	18	2.9	80483352 C
25	58	HSK 80A	44	240	200	18	3.5	80483353 C
30	62	HSK 80A	44	115	75	18	1.6	80483368 S
30	62	HSK 80A	44	135	95	18	1.8	80483369 S
30	62	HSK 80A	44	135	95	18	1.7	80483378 C
30	62	HSK 80A	44	152	112	18	2.1	80483370 S
30	62	HSK 80A	44	185	145	18	3.8	80483371 S
30	62	HSK 80A	44	215	175	18	4.1	80483372 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
30	62	HSK 80A	44	225	185	18	4.3	80483373 S
30	62	HSK 80A	44	245	205	18	4.5	80483374 S
40	62	HSK 80A	58	135	95	18	2.0	80483379 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	
Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
20	52	HSK 80E	33	115	75	18	1.4	80483324 S
20	52	HSK 80E	33	225	185	18	3.0	80483325 S
25	58	HSK 80E	44	115	75	18	1.5	80483342 S
25	58	HSK 80E	44	160	120	18	3.0	80483343 S
25	58	HSK 80E	44	225	185	18	3.8	80483344 S
25	58	HSK 80E	44	245	205	18	4.5	80483345 S
30	62	HSK 80E	44	115	75	18	1.6	80483365 S
30	62	HSK 80E	44	225	185	18	3.0	80483366 S
30	62	HSK 80E	44	245	205	18	3.1	80483367 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	
Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
20	52	HSK 80F	33	112	80	18	1.4	80483303 O
20	52	HSK 80F	33	192	160	18	2.2	80483304 O
25	58	HSK 80F	44	112	80	18	1.5	80483333 C
25	58	HSK 80F	44	117	85	18	1.6	80483337 S
25	58	HSK 80F	44	177	145	18	3.4	80483338 S
25	58	HSK 80F	44	192	160	18	2.9	80483312 O
25	58	HSK 80F	44	207	175	18	2.4	80483339 S
25	58	HSK 80F	44	237	205	18	2.5	80483340 S
30	62	HSK 80F	44	107	75	18	1.2	80483356 S
30	62	HSK 80F	44	144	112	18	1.8	80483357 S
30	62	HSK 80F	44	207	175	18	2.5	80483358 S
30	62	HSK 80F	44	217	185	18	2.8	80483359 S
30	62	HSK 80F	44	237	205	18	3.2	80483360 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	
Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
20	52	HSK 100A	33	125	75	18	1.8	80483326 S
20	52	HSK 100A	33	135	85	18	1.7	80483327 S
20	52	HSK 100A	33	155	105	18	2.5	80483331 C
20	52	HSK 100A	33	195	145	18	4.0	80483328 S
20	52	HSK 100A	33	210	160	18	3.1	80483309 O
20	52	HSK 100A	33	225	175	18	2.7	80483329 S
20	52	HSK 100A	33	235	185	18	2.8	80483330 S
25	58	HSK 100A	44	125	75	18	1.8	80483346 S
25	58	HSK 100A	44	145	90	18	1.8	80483347 S
25	58	HSK 100A	44	165	115	18	3	80483315 O
25	58	HSK 100A	44	195	145	18	4.0	80483348 S
25	58	HSK 100A	44	210	160	18	3.7	80483316 O
25	58	HSK 100A	44	225	175	18	4.5	80483349 S
25	58	HSK 100A	44	235	185	18	2.9	80483350 S
25	58	HSK 100A	44	255	205	18	3.7	80483351 S
30	62	HSK 100A	44	125	75	18	1.9	80483375 S
30	62	HSK 100A	44	195	145	18	4.0	80483376 S
30	62	HSK 100A	44	235	185	18	3.0	80483377 S
40	90	HSK 100A	90	200	150	18	6.4	80483318 O
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

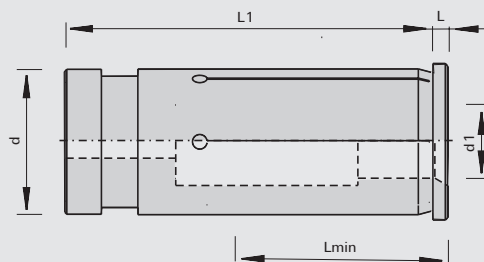
933280

Universal Reducing Bushings, highly precise

Product



Drawing


LEUCO
CNC

Machine / Application

for holding shank tools in TRIBOS, ps-System and all standard hydro expansion chuck

Design

concentric accuracy ≤ 0.003 mm
shank diameter tolerance h7 or g7
coolant-tight up to 80 bar

Advantages

permanent concentricity and tool-change repeat accuracy ≤ 0.003 mm

Notes

Lmin minimum clamping length = minimum shaft length

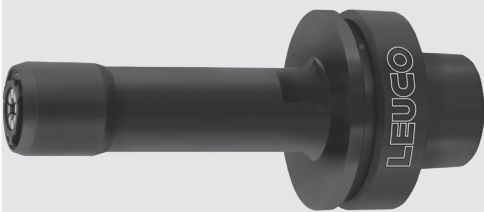
$\emptyset d1$	$\emptyset d1$	Lmin	$\emptyset d$	L1	L	Ident-No.
3		27	12	45	2.0	183022 C
4		27	12	45	2.0	183023 C
5		27	12	45	2.0	183024 C
6		27	12	45	2.0	183025 L
8		27	12	45	2.0	183026 L
8		27	16	47.5	2.5	186099 L
10		32	16	47.5	2.5	186100 L
12		37	16	47.5	2.5	186101 L
3	1/8	27	20	50.5	2.0	183027 C
		27	20	50.5	2.0	186914 C
4		27	20	50.5	2.0	183028 C
5		27	20	50.5	2.0	183029 C
6		27	20	50.5	2.0	183030 C
8		27	20	50.5	2.0	183032 L
10		32	20	50.5	2.0	183034 L
12		37	20	50.5	2.0	183036 L
14		37	20	50.5	2.0	183038 C
16		38	20	50.5	2.0	183040 L
6		27	25	54.5	3.0	182304 L
8		27	25	54.5	3.0	182305 L
10		32	25	54.5	3.0	182306 L
12		37	25	54.5	3.0	182307 L
14		37	25	54.5	3.0	182308 L
16		38	25	54.5	3.0	182309 L
18		38	25	54.5	3.0	182310 L
20		42	25	54.5	3.0	182311 L
	1/2"	37	25	54.5	3.0	182653 L
	3/4"	42	25	54.5	3.0	182655 S
[mm]	[inch]	[mm]	[mm]	[mm]	[mm]	



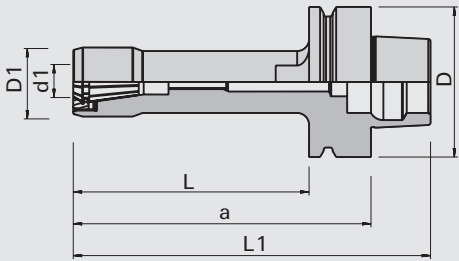
933289

Draw-in collet chuck system 426E/ER16 with HSK 63F - clamping zone Ø 1-10 mm

Product



Drawing



LEUCO
GNC

Machine / Application

| CNC machining centers,
especially 5-axis
| for precise clamping of shank-
type tools with cylindrical
shank

Design

| internal collet nut
| hardened and ground
| for double-slotted collets
| n max = 24,000 min-1

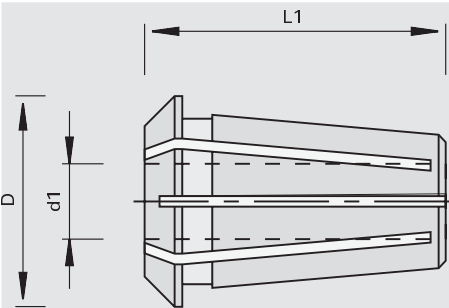
Advantages

| slim design
| high stability even with large
projection
| high concentric accuracy
| high clamping force

Notes

| also available for left-hand
sense of rotation
| included in delivery: collet
chuck with clamping nut,
without collet and mounting
accessories
| torques: 426E/ER16: 50 Nm
(44 Lbf.ft)

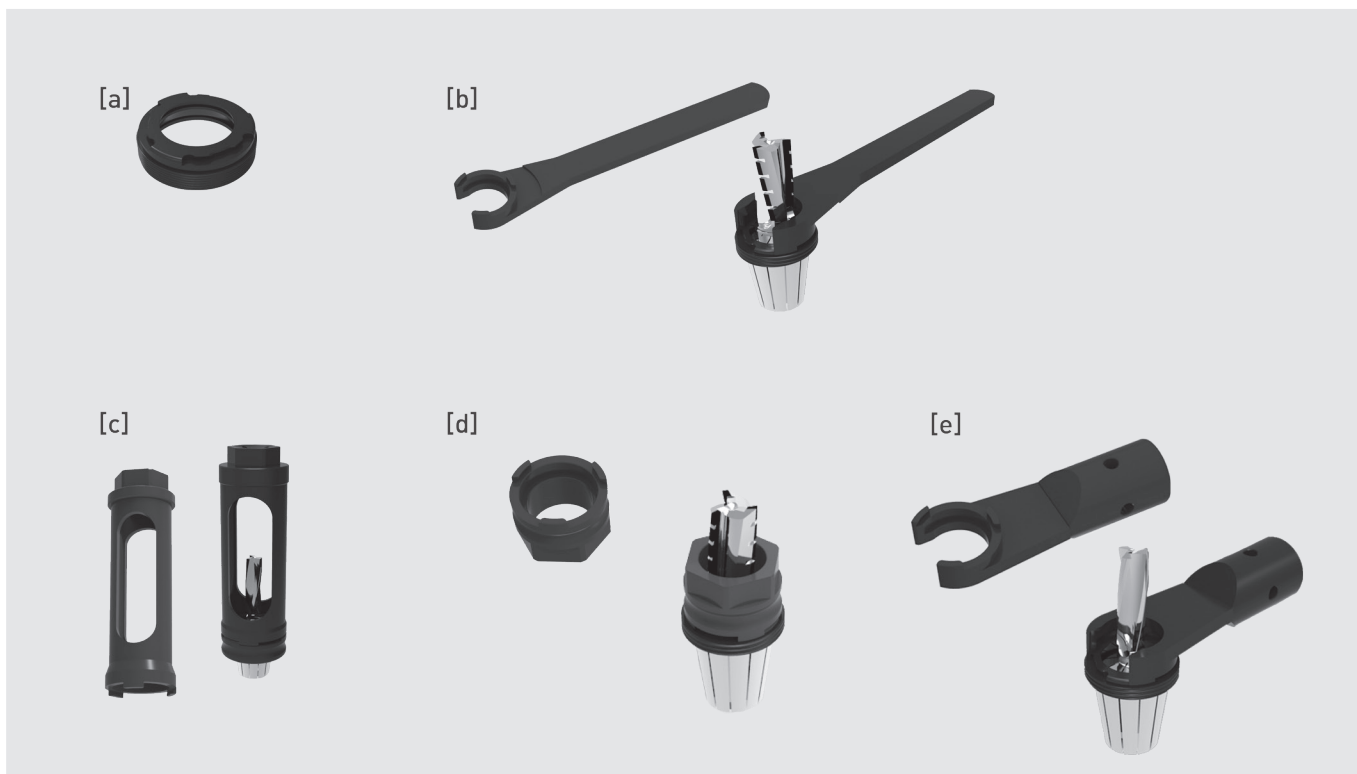
Ø d1	Ø D1	Ø d	Ø D	L	L1	a	Ident-No.
1-10	29	HSK 63F	63	50	101	76	184847 L
1-10	29	HSK 63F	63	74	125	100	184848 L
1-10	29	HSK 63F	63	99	150	125	184849 L
1-10	29	HSK 63F	63	124	175	150	184850 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	



Collets 426E / ER 16

Ø d1	Ø D	L1	Ident-No.
1	17.25	27.5	184865 O
2	17.25	27.5	184866 O
3	17.25	27.5	184867 O
4	17.25	27.5	184868 O
5	17.25	27.5	184869 O
6	17.25	27.5	184870 L
7	17.25	27.5	184871 O
8	17.25	27.5	184872 L
9	17.25	27.5	184873 O
10	17.25	27.5	184874 L
[mm]	[mm]	[mm]	

Accessories	Dimension	Class-No.	PU	Ident-No.
[a] Clamping Nuts		995290	1	184875 L
[b] Hand Spanner		985720	1	184878 L
[c] Torque Nut		985720	1	184884 L
[d] Screw-in aid		985720	1	184881 L
[e] torque adapter		985300	1	184887 L
[f] torque wrench	40-200 Nm	985300	1	184890 L
	[mm]		[pc.]	



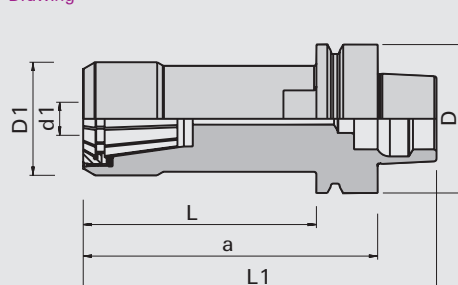
933289

Draw-in collet chuck system 470E/ER32 with HSK 63F - clamping zone Ø 2-20 mm

Product



Drawing



LEUCO
CNC

Machine / Application

- l CNC machining centers, especially 5-axis
- l for precise clamping of shank-type tools with cylindrical shank

Design

- l internal collet nut
- l hardened and ground
- l for double-slotted collets
- l n max = 24,000 min-1

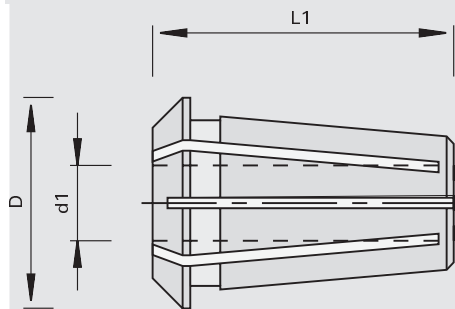
Advantages

- l slim design
- l high stability even with large projection
- l high concentric accuracy
- l high clamping force

Notes

- l also available for left-hand sense of rotation
- l included in delivery: collet chuck with clamping nut, without collet and mounting accessories
- l torque: 470E/ER32: 130 Nm (96 Lbf.ft)

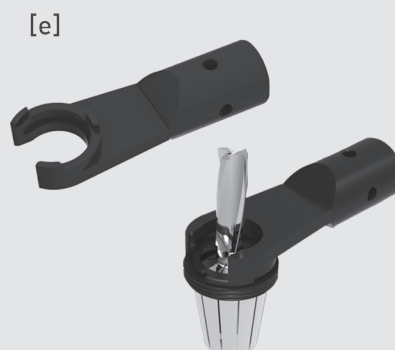
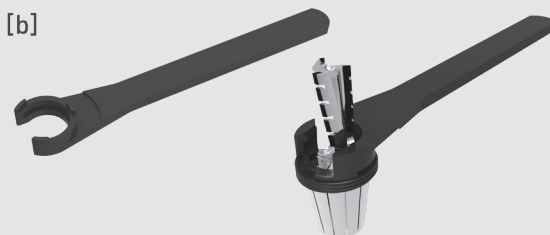
Ø d1	Ø D1	Ø d	Ø D	L	L1	a	Ident-No.
2-20	48	HSK 63F	63	34	85	60	184851 L
2-20	48	HSK 63F	63	44	95	70	184852 C
2-20	48	HSK 63F	63	89	140	115	184853 L
2-20	48	HSK 63F	63	99	150	125	184854 L
2-20	48	HSK 63F	63	124	175	150	184855 C
2-20	48	HSK 63F	63	154	205	180	184856 L
2-20	48	HSK 63F	63	174	225	200	184857 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	



Collets 470E / ER 32

Ø d1	Ø D	L1	Ident-No.
3	33	40	173647 O
4	33	40	173648 C
5	33	40	173649 C
6	33	40	173650 L
7	33	40	173651 O
8	33	40	173652 L
10	33	40	173653 L
12	33	40	173654 L
13	33	40	173655 O
14	33	40	173656 C
16	33	40	173657 L
18	33	40	173658 O
19	33	40	173659 O
20	33	40	173660 L
[mm]	[mm]	[mm]	

Accessories	Dimension	Class-No.	PU	Ident-No.
[a] Clamping Nuts		995290	1	184876 L
[b] Hand Spanner		985720	1	184879 L
[c] Torque Nut		985720	1	184885 L
[d] Screw-in aid		985720	1	184882 L
[e] torque adapter		985300	1	184888 L
[f] torque wrench	40-200 Nm	985300	1	184890 L
	[mm]		[pc.]	



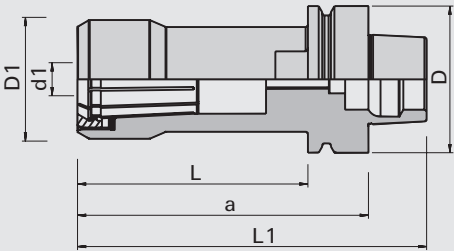
933289

Draw-in collet chuck system 462E/OZ25 with HSK 63F - clamping zone Ø 2-25 (1") mm

Product



Drawing



Machine / Application

- | CNC machining centers, especially 5-axis
- | for precise clamping of shank-type tools with cylindrical shank

Design

- | internal collet nut
- | hardened and ground
- | for double-slotted collets
- | n max = 24,000 min-1

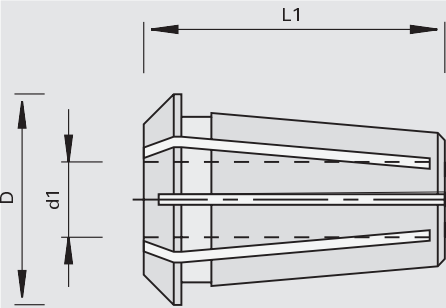
Advantages

- | slim design
- | high stability even with large projection
- | high concentric accuracy
- | high clamping force

Notes

- | also available for left-hand sense of rotation
- | included in delivery: collet chuck with clamping nut, without collet and mounting accessories
- | torques: 462E/OZ25: 150 Nm (110 Lbf.ft)

Ø d1	Ø D1	Ø d	Ø D	L	L1	a	Ident-No.
2-25	51	HSK 63F	63	50	101	76	184858 L
2-25	51	HSK 63F	63	89	140	115	184860 L
2-25	51	HSK 63F	63	124	175	150	184861 C
2-25	51	HSK 63F	63	149	200	175	184862 O
2-25	51	HSK 63F	63	174	225	200	184863 O
2-25	51	HSK 63F	63	199	250	225	184864 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	



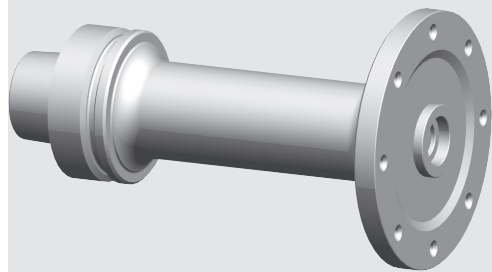
HSK-F63 Collet chucks 462E / OZ 25 /

Ø d1	Ø d1	Ø D	L1	Ident-No.
2		35.05	52	183803 O
3		35.05	52	183804 L
4		35.05	52	183805 L
5		35.05	52	183806 L
6		35.05	52	180213 L
	1/4"	35.05	52	175815 L
7		35.05	52	183807 O
8		35.05	52	180358 L
	3/8"	35.05	52	185275 L
10		35.05	52	170782 L
12		35.05	52	168742 L
	1/2"	35.05	52	175820 L
13		35.05	52	180215 L
14		35.05	52	170783 L
	5/8"	35.05	52	175823 C
15		35.05	52	183808 O
16		35.05	52	168743 L
[mm]	[inch]	[mm]	[mm]	

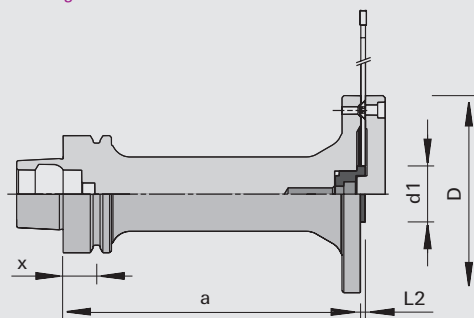
933061

CNC Combi Saw Blade Adapters HSK 63F

Product



Drawing



LEUCO
CNC

Machine / Application

- ! CNC machining centers with automatic tool changer
- ! for precise mounting of circular saw blades

Design

- ! interface DIN 69893 HSK 63 F for high-precision adapter to the machine spindle

Advantages

- ! exchangeable centering adapter can be obtained separately; thus saw blades with different bore diameters can be used on the same mounting device
- ! the mounting of the saw blade can be made with or without lid
- ! adapter available with different a measures

Notes

- ! for right-hand and left-hand rotation
- ! mounting of the saw directly by means of countersunk screws or lid by means of cylinder head screw
- ! included in delivery: lid, countersunk screws, cylinder head screws and centering adapter for saw blade bore Ø 30 mm with retaining ring
- ! Recommendation of the max. saw blade diameter: without lid - Dmax = 360 mm, with lid - Dmax = 430 mm

Ø D	Ø d	Ø d1	L2	a	x	NL	Ident-No.
106	HSK 63F	30	2,5	40	18	8/M5/90	184835 L
106	HSK 63F	30	2,5	50	18	8/M5/90	184836 L
106	HSK 63F	30	2,5	56	18	8/M5/90	187760 L
106	HSK 63F	30	2,5	100	18	8/M5/90	184837 L
106	HSK 63F	30	2,5	130	18	8/M5/90	184838 L
106	HSK 63F	30	2,5	160	18	8/M5/90	184839 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Options	Dimension	Class-No.	PU	Ident-No.
Lid	106x15x20	997300	1	184845 L
Adapter for body thickness 2.0 or 2.2 mm	Ø30	997300	1	185666 L
Adapter	Ø31,75	997300	1	184841 S
Adapter	Ø32	997300	1	184842 C
Adapter	Ø35	997300	1	184843 L
Adapter	Ø40	997300	1	184844 L
	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x12 T20 D=Ø9,3	995125	10	166709 L
Head Cap Screws	M5x16 DIN EN ISO 4762	995111	10	001870 L
Head Cap Screws for adapters	M8x12 DIN 7984	995111	10	184846 L
Locking Rings	8/13x8,4x0,7	995460	1	185497 L
	[mm]		[pc.]	

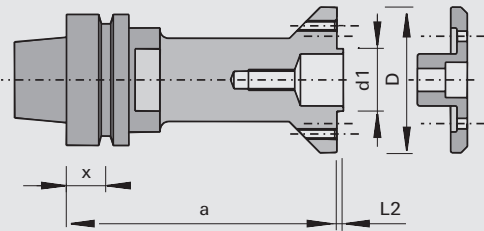
933061

Saw Blade Adapters HSK 63F

Product



Drawing



LEUCO
CNC

Machine / Application

- | CNC machining centers with automatic tool changer
- | for precise mounting of circular saw blades and grooving cutters

Design

- | interface DIN 69893 HSK 63 F for high-precision adapter to the machine spindle

Advantages

Notes

- | for right-hand and left-hand rotation
- | mounting of the saw directly by means of countersunk screws or with lid 183310 by means of cylinder head screw
- | included in delivery:
- | support with countersunk screw
- | lid with cylinder head screws to be ordered separately, if required
- | Recommendation of the max. saw blade diameter: without lid - Dmax = 210 mm, with lid - Dmax = 280 mm

Ø D	Ø d	Ø d1	L2	a	NL	Ident-No.
70	HSK 63F	30	1,8	55	8/M5/52 + 2/6/42	187639 L
70	HSK 63F	30	1,8	70	8/M5/52 + 2/6/42	186083 L
70	HSK 63F	30	1,8	130	8/M5/52 + 2/6/42	186432 L
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x8 T20 D=Ø10	995125	10	164005 L
Countersunk Screws	M5x12 T20 D=Ø9,3	995125	10	166709 L
	[mm]		[pc.]	

Accessories	Dimension	Class-No.	PU	Ident-No.
Cover with 2 pins as twist-lock and cylinder head screw M10	70x24x8 (2/6/42)	997300	1	183310 L
	[mm]		[pc.]	

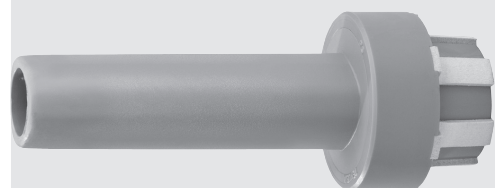


985700

Cone wiper

Product

Drawing



Machine / Application

Design

Advantages

Notes

for cleaning of the inner cones
of the cone tool adaptors

the highly precise machine
spindle and clamping chuck
needs dust-free fit

Ø d

Ident-No.

SK 30

180907 O

HSK 63F

180911 L

[mm]



985202

Mounting devices with clamping lever

Product



Drawing

Machine / Application

for quick and simple mounting and adjusting of cutting tools in draw-in collet chucks or on arbors and tool holders

Design

with two-part clamping jaws made from high-quality light alloy
mounted on stable pedestal which can be fixed onto workbench
quick-grip lever for clamping of clamping chucks or holding arbors

Advantages

variably applicable for all interfaces by simple exchanging of the clamping jaw

Notes

	Ø d	Ident-No.
SK 30 (DIN) / HSK 50F	50	180362 O
SK 40 (DIN)	63,5	180363 C
SK 30 with ring gear (Morbideilli, SCM)	49	180364 S
SK 30 (ISO) CMS / BT 30	46	180365 C
HSK 63F / 63E	63	180366 C
HSK 85 (Weinig)	85	182284 C
	[mm]	

Spare parts	For Ident-No.	Class-No.	PU	Ident-No.
Clamping Jaws (2-parts)	180362	997300	1	180368 S
Clamping Jaws (2-parts)	180363	997300	1	180369 S
Clamping Jaws (2-parts)	180364	997300	1	180370 S
Clamping Jaws (2-parts)	180366	997300	1	180372 S
Clamping Jaws (2-parts)	182284	997300	1	182285 S
Pedestal (without clamping jaw)	For all	997300	1	180374 S
			[pc.]	

985202

Mounting devices without clamping lever

Product



Drawing

Machine / Application

| for quick and simple mounting and adjusting of cutting tools in draw-in collet chucks or on arbors and tool holders

Design

| mounted on stable pedestal which can be fixed onto workbench

Advantages

| simplest handling offering highest comfort thanks to roll clamping system, no clamping or jamming necessary

Notes

| for all adapters HSK 63 F

Ø d1

Ident-No.

HSK 63F
[mm]

182467 L

985300

Digital height measuring device

Product



Drawing

LEUCO
CNC

Machine / Application

| for quick and precise adjusting of cutting tools in draw-in collet chucks or on arbors and tool holders

Design

| repeating precision 0.01 mm
| tungsten carbide-tipped scriber
| digital display

Advantages

| simple adjustment and fixing of the height dimension

Notes

| battery type "LR44" not included in delivery

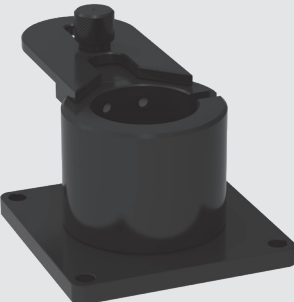
Ident-No.

Digital height measuring device

183684 L

985202

Mounting Device Rigid

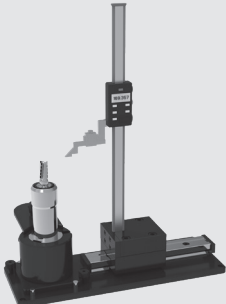
Product		Drawing			
					
Machine / Application		Design		Advantages	
for quick, simple and safe mounting and adjusting of cutting tools in draw-in collet chucks or on arbors and tool holders		- stable steel construction with pedestal for mounting on a workbench - Fixation of the tool adapter by means of mounting forks - Mounting blocks for all common interfaces		suitable mounting forks must be ordered separately	

Ø d1	Ident-No.
HSK 63F	187270 L
HSK Weinig	187271 O
SK30	187272 O
SK40	187273 O
[mm]	

Accessories	Dimension	suitable for	For Ident-No.	Class-No.	PU	Ident-No.
Mounting Fork	SW22	ZETA ER16	187270	997300	1	187274 L
Mounting Fork	SW32	ZETA ER16	187270	997300	1	187368 L
Mounting Fork	SW36	AEROTECH Uni-T	187270	997300	1	187275 L
Mounting Fork	SW38	ZETA ER32/OZ	187270	997300	1	187276 L
Mounting Fork	SW41	SK30	187272	997300	1	187277 O
Mounting Fork	SW46	HSK	187270, 187273	997300	1	187278 L
	[mm]					

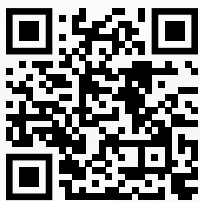
985300

Digital Mounting and Measuring Device

Product		Drawing	
			
Machine / Application		Design	Advantages
Mounting and measuring device for different tool adapters in combination with separately available mounting blocks		robust design Measuring range up to 300 mm (depending on the mounting block used)	easy and fast measurement and adjustment of the tool lengths
		Notes	
		Mounting block HSK 63A/E/F is included in delivery	
		Ident-No.	
Digital Mounting and Measuring Device		187279 O	



MAGENTIFY WOOD PROCESSING



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