LEUCO
MAGENTIFY WOOD PROCESSING

SAW BLADES

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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 hollow-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
synchronically 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:

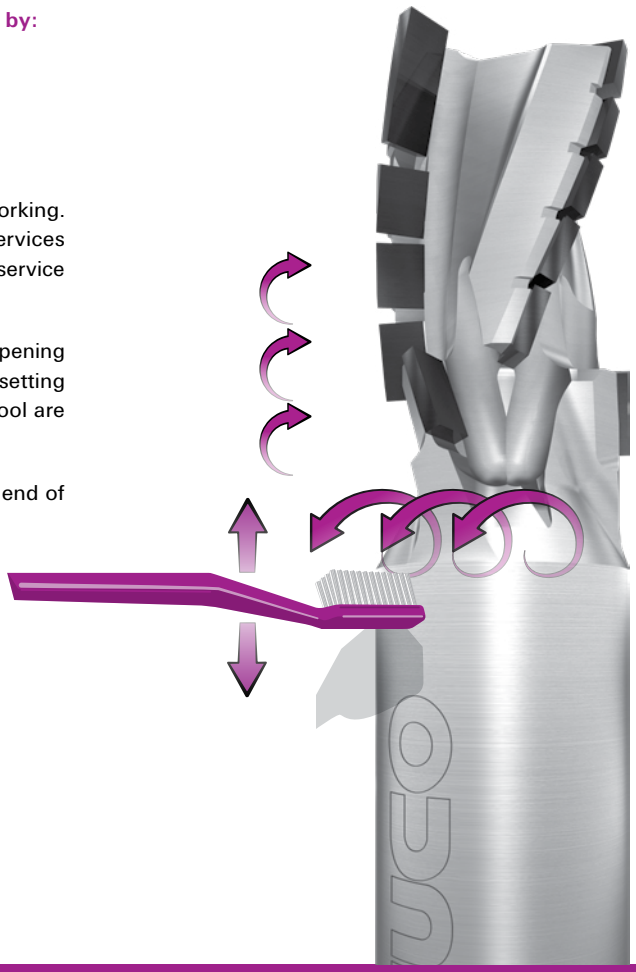
- well-trained, knowlegeable LEUCO employees
- the most modern high-tech systems in the company service centers
- availability of your tools based on strict sharpening schedules

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!"

1991
LEUCO DIAMAX

Topline Circular Saw Blade

1996
North American Based National Flooring Technical Support Group

Tilted pre-cutting laminate flooring

1999
PowerTec Hoggers

i-System tools

2000
FinishCut Panel Sizing Saw Blade

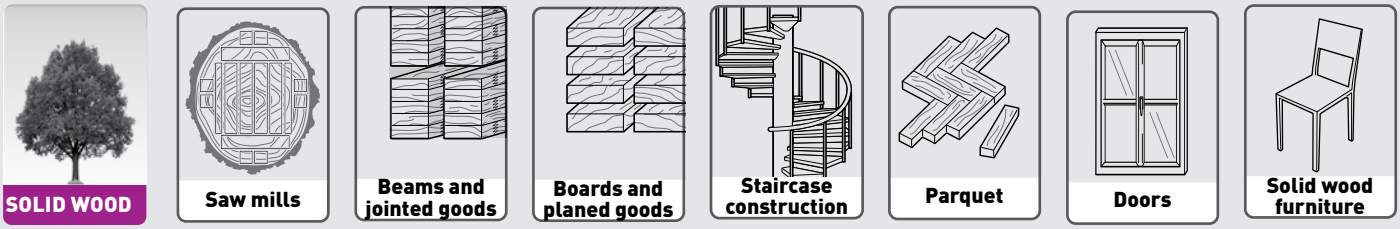
2001
Clamping Chuck "Tribos"

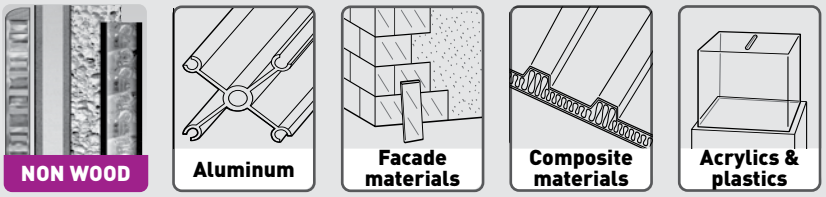
2002
Hogger with cone-shaped gullets

2003
SpeedCut+ Panel Sizing Saw Blade

Hogger with optimized gullet

APPLICATION & DESIGN





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.

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

Code designations of the cutting materials

NEW - according to ISO	Signification	Old name
SP	alloyed tool steel (minimum 0.6% C and no more than 5 % alloy constituents)	SP
HS	high-alloyed steel (more than 12 % alloy elements Mo, V, Co in total)	HSS
ST	casting alloy on cobalt basis e.g. Stellite	Stellite
HW	uncoated tungsten carbide	HM
VHW	solid tungsten carbide	VHM
DP	polycrystalline diamond	DIA

02

Tool Attributes

Short form	Significance
NL	pin holes
KN	keyway
DKN	double keyway
n	permitted range of RPM
n max	maximum RPM
U min-1	rotations per minute
Vc	cutting speed
Vf	feedrate
Z	number of teeth

03

Types of feed

Short form	Significance
MEC	mechanical feed
MAN	manual feed

04

Delivery signs

Short form	Significance
&	modification and/or mounting of stock parts
o	available on short notice
s	production per drawing
#	new type in process
$	Superstandard

All Ident-No. are available from stock unless specifically indicated.

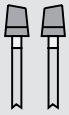
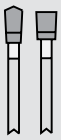
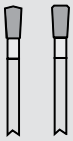
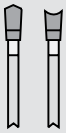
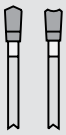
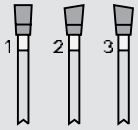
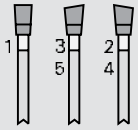
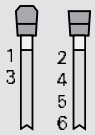
LEUCO Ledermann GmbH & Co. KG fulfills all demands of ISO 9001:2008.

The certificate-no. is 01 100 010679.

Tooth configuration

The tooth design has a big influence on the edge quality and is depending on the following factors:

- workpiece material
- mode of application (with and across the grain)
- direction of cut (along / across the grain)

	F	Flat		DA	Inverted-v		KO-WS	Conical-alternate bevel
	F-FA	Flat with chamfers on both sides		DA-F	Inverted-v + flat		KO-HR-FA	Conical hollow back with chamfer
	F-WFA	Flat with alternating chamfer		DA-F-FA	Inverted-v + flat with chamfer		D	Hollow-ground
	WS	Alternate top bevel		DA-D	Inverted-v + hollow-ground		D-FA	Hollow-ground with two-sided chamfer
	WS-FA	Alternate top bevel with chamfer		DA-D-FA	Inverted-v + hollow-ground with chamfer		HR	Hollow back
	TR	Triple-chip		ES	Top bevel		HR-FA	Hollow back with chamfer
	TR-F	Triple-chip + flat		ES-L	Top bevel, left		G3	G3
	TR-F-FA	Triple-chip + flat with chamfer		ES-R	Top bevel, right		G5	G5
	TR-TR	Triple-chip + triple-chip		KO-F	Conical-flat		G6	G6

PitchRx Spray Bottle

PitchRx is a water-based solution that removes pitch and resin buildup from all woodworking tools and cloth-backed sanding belts. Pitch builds up on your tools and cuts down productivity and performance. Using PitchRx increases the life of the blades, bits and reduces sharpening and replacement costs.

Cutting speed (standard values)

HW Saw Blades

Workpiece material	Cutting speed vc [m/s]
Al-Mg-Cu	40 - 60
Al-Si alloys	15 - 40
Panels veneered both sides	60 - 90
Thermosets (Pertinax®, Restitex®, etc.)	15 - 50
Exotic woods	50 - 85
Veneers	70 - 100
Gypsum plaster boards	40 - 65
Hardboards	50 - 80
Hard woods	60 - 100
Plastic laminated particle boards	60 - 80
Plastic profiles without filling	30 - 70
Pressed laminated woods	40 - 65
Pure aluminum	60 - 80
Raw particle boards	50 - 80
Laminated boards	60 - 80
Laminates, hard paper, fabric	50 - 70
Particle boards	60 - 80
Plywood boards	50 - 80
Thermoplastic (PA, PE, PMMA etc.)	30 - 70
Wood core plywood	50 - 90
Condensed woods	40 - 65
Soft fiber boards	60 - 100
Soft woods	60 - 100
Cement bonded boards	40 - 60

DP Saw Blades

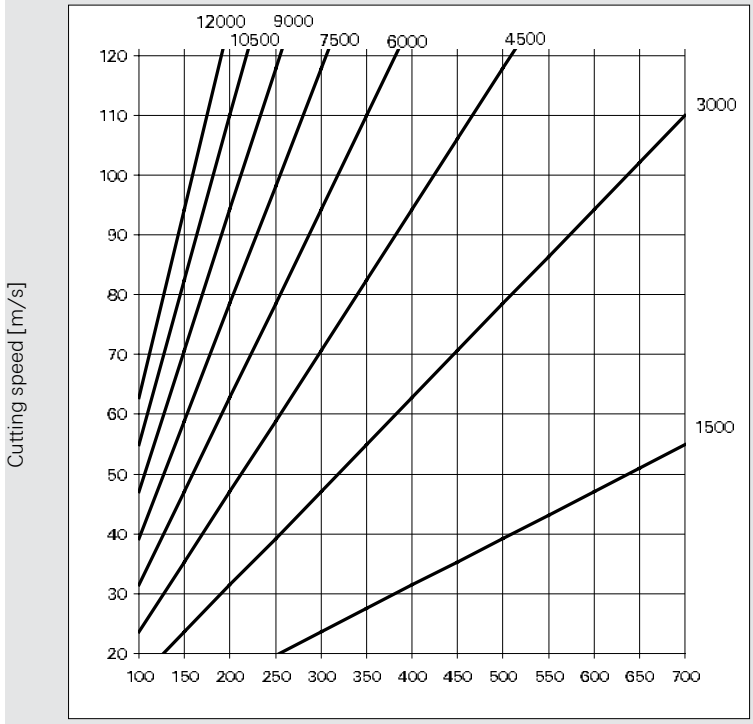
Workpiece material	Cutting speed vc [m/s]
CFRP, GFRP	40 - 60
Thermosets (Pertinax®, Restitex®, etc.)	50 - 80
Polymer bound boards (Corian®, Varicor®)	60 - 90
Pressed laminated woods	40 - 60
Laminated particle boards and MDF boards	50 - 80
Foil-coated particle boards and MDF boards	64 - 100
Veneered particle boards and MDF boards	65 - 100
Raw particle boards and MDF boards	65 - 100
Plywood boards	65 - 100
Thermoplastic (PA, PE, PMMA etc.)	60 - 90
Wood core plywood	60 - 80
Condensed woods	70 - 100
	50 - 80

Feed rate per tooth

HW Saw Blades

Workpiece material	Feed rate per tooth fz [mm]
Al-Mg-Cu	0,05 - 0,12
Al-Si alloys	0,03 - 0,08
Panels veneered both sides	0,03 - 0,10
Thermosets (Pertinax®, Restitex®, etc.)	0,02 - 0,05
Hardboards	0,03 - 0,08
Plastic laminated particle boards	0,03 - 0,15
Plastic profiles without filling	0,03 - 0,15
Solid wood with the grain	0,10 - 0,50
Solid wood across the grain	0,02 - 0,20
Polymer bound boards (Corian®, Varicor®)	0,05 - 0,15
Pure aluminum	0,05 - 0,12
Particle boards, MDF boards	0,05 - 0,25
Plywood boards	0,05 - 0,25
Thermoplastic (PA, PE, PMMA etc.)	0,05 - 0,08

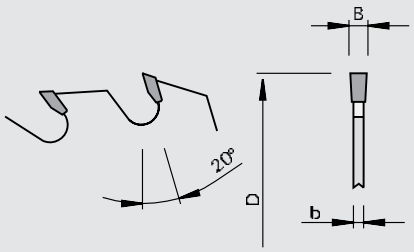
Determination of RPM [min-1]



Rip Saws

Product

Drawing



LEUCO highline

LEUCO DUR

tungsten carbide [HW]

LOW

Machine / Application
- rip saws
- table saws
- for ripping cuts in solid woods

Design
- tooth configuration: flat or triple chip / flat „Tr/Ch Flat"
- laser plate technology
- Leuco HL board 10 carbide

Advantages
- extended edge life
- noise reduction thanks to laser ornaments

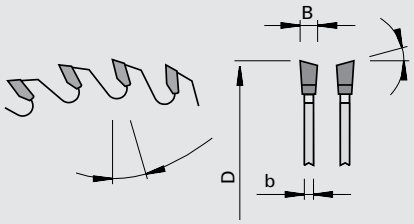
Notes
- alteration of bore possible

Ø D	B	b	Ø d	Z	Tooth Shape-Style	Hook Angle	Comments	Ident-No.
10	3.2	2.2	5/8	24	Tr/Ch Flat	20		1739127
12	3.2	2.2	1	30	Flat	20		1738726
12	4.3	2.9	1	30	Tr/Ch Flat	20		1738728
12	3.2	2.2	3.125	36	Tr/Ch Flat	20	MJ-Glueline rip w/0 deg radial	1738730
12	4	2.5	3.125	36	Tr/Ch Flat	20	MJ-Glueline rip w/0 deg radial	1738732
14	3.5	2.5	1	30	Flat	20		1740014
14	4.3	3	1	36	Tr/Ch Flat	20	Glueline rip w/0 deg radial	1740016
[inch]			[inch]					

Highline XP Rip Saws

Product

Drawing



HIGHLINEXP

LEUCO DUR

tungsten carbide [HW]

LOW

Machine / Application
- rip saws
- table saws
- for ripping cuts in solid hard & softwood, raw & laminated wood based panels

Design
- tooth configuration: 5° degree ATB
- laser plate technology
- Leuco HL board 10 carbide

Advantages
- extended edge life
- noise reduction thanks to laser ornaments

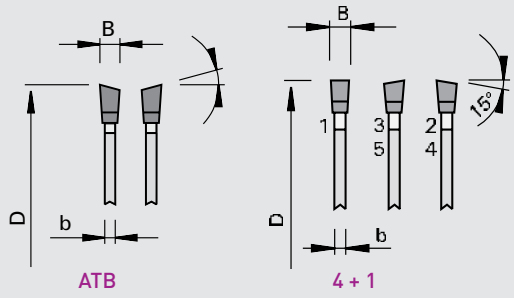
Notes
- alteration of bore possible

Ø D	B	b	Ø d	Z	Tooth Shape-Style	Hook Angle	Comments	Ident-No.
10	2.5	1.8	5/8	24	5° ATB	20°		80507570
[inch]			[inch]					

Table and Miter Chop Saw Blades

Product

Drawing



LEUCO highline

LEUCO DUR

tungsten carbide [HW]

LOW NOISE

Machine / Application

- table, chop, & miter saws
- for sizing cuts in solid woods, wood based panels and laminated panels

Design

- tooth configuration: alternate top bevel „ATB"
- tooth configuration: alternate top bevel / flat „combo (4+1)"
- laser plate technology
- Leuco HL board 06 carbide

Advantages

- optimum cutting quality
- extended edge life
- noise reduction thanks to laser ornaments

Notes

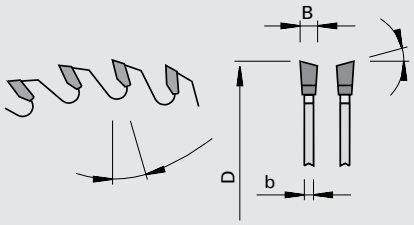
- alteration of bore possible except 8 1/4" Ø D

Ø D	B	b	Ø d	Z	Tooth Shape-Style	Hook Angle	Comments	Ident-No.
8 1/4	2.2	1.6	5/8 w/KO	40	Combo (4&1)	8	Sliding Compound / Miter	1738752
9	2.2	1.6	5/8	40	Combo (4&1)	8	Sliding Compound / Miter	1738754
10	3.2	2.2	5/8	80	ATB 15°	5		1738738
10	2.9	2.2	5/8	80	Combo (4&1)	-2	Sliding Compound / Miter	1738758
12	3.2	2.2	1	60	ATB 15°	10		1738740
12	3.2	2.2	1	72	ATB 15°	10		1738742
12	2.9	2.2	5/8	96	ATB 20°	15		1738744
12	2.9	2.2	1	96	ATB 20°	15		1739129
12	2.8	2	1	80	Combo (4&1)	0	Sliding Compound / Miter	1738762
12	4.0	2.8	1	60	Combo (4&1)	0	Sliding Compound / Miter	1740018
14	3.8	2.8	1	100	ATB 15°	5		1738746
14	4.2	3.2	1	70	Combo (4&1)	0	Sliding Compound / Miter	1740020
15	3.0	2.2	1	100	Combo (4&1)	-5°	Sliding Compound / Miter	1738764
[inch]			[inch]					

Highline XP Table and Miter Chop Saw Blades

Product

Drawing



HIGHLINE XP

LEUCO DUR

tungsten carbide [HW]

LOW

Machine / Application

- table, chop, & miter saws
- for ripping cuts in solid hard & softwood, raw & laminated wood based panels

Design

- tooth configuration: 15° & 30° degree ATB / Combo
- laser plate technology
- Leuco HL board 10 carbide

Advantages

- extended edge life
- noise reduction thanks to laser ornaments

Notes

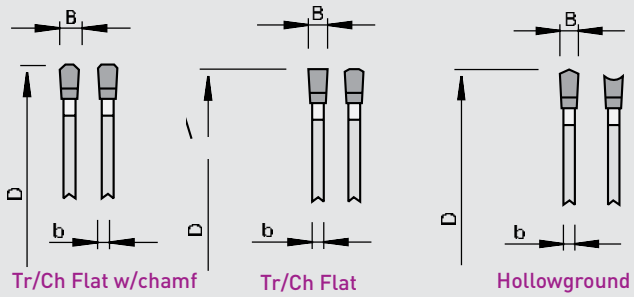
- alteration of bore possible

Ø D	B	b	Ø d	Z	Tooth Shape-Style	Hook Angle	Comments	Ident-No.
10	2.2	1.6	5/8	90	ATB 15° w/face sheer	-2°	Ultimate/Polish	80507571
10	2.5	1.8	5/8	40	ATB 15°	15°	General Purpose	80507568
10	2.5	1.8	5/8	60	ATB 30°	10°	Fine Finish	80507561
10	2.5	1.8	5/8	80	ATB 30°	-2°	Ultra Fine Finish	80507566
10	2.5	1.8	5/8	50	Combo (4&1)	15°	Combination	80507565
12	3.0	2.2	1	80	ATB 30°	-2°	Fine Finish	80507562
12	3.0	2.2	1	60	Combo (4&1)	15°	Combination	80507567
12	2.5	1.8	1	44	ATB 15°	15°	General Purpose	80507569

Table and Miter Chop Saw Blades

Product

Drawing



LEUCO highline

LEUCO DUR

tungsten carbide [HW]

LOW

Machine / Application

- table saws
- chop and miter saws
- for sizing cuts in wood based panels, laminated panels, non-ferrous metals, solid surface & heavy plastics

Design

- tooth configuration: triple chip / flat „Tr/Ch Flat"
- tooth configuration: triple chip / flat w/chamfers
- tooth configuration: inverted-v hollowground
- Leuco HL board 06 carbide
- Leuco HL board 10 For non-ferrous metal

Advantages

- optimum cutting quality
- extended edge life
- noise reduction thanks to laser ornaments

Notes

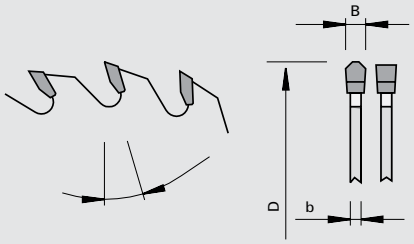
- alteration of bore possible

Ø D	B	b	Ø d	Z	Tooth Shape-Style	Hook Angle	Comments	Ident-No.
10	3.2	2.2	5/8	40	Tr/Ch Flat	5		1738766
10	3.2	2.2	5/8	60	Tr/Ch Flat	5		1738768
10	3.2	2.2	5/8	80	Tr/Ch Flat	5		1738770
10	3.2	2.2	5/8	48	Hollowground	10		1738784
10	3.2	2.5	5/8	80	Tr/Ch Flat w/.3 chamf	-2	solid surface & heavy plastic	1738792
10	3	2.2	5/8	80	Tr/Ch Flat	-5	melamine	1740030
10	3.2	2.2	1	100	Tr/Ch Flat	-5	melamine	1740624
10	2.5	1.8	5/8	80	Tr/Ch Flat	-5	non-ferrous metal	1738786
12	2.8	2.2	1	80	Tr/Ch Flat	-5	non-ferrous metal	1738788
12	2.8	2.2	1	96	Tr/Ch Flat	-5	non-ferrous metal	1738790
12	3.2	2.2	1	60	Tr/Ch Flat	10		1738772
12	3.2	2.2	1	72	Tr/Ch Flat	10		1738774
12	3.5	2.2	1	80	Tr/Ch Flat	5		1740022
12	3.2	2.5	1	90	Tr/Ch Flat w/.3 chamf	-2	solid surface & heavy plastic	1738794
12	3.2	2.2	1	100	Tr/Ch Flat	-5	melamine	1740032
14	3.2	2.2	1	100	Tr/Ch Flat	-5	melamine	1740034
14	3.8	2.8	1	100	Tr/Ch Flat	10		1738776
14	3.5	2.2	1	80	Tr/Ch Flat	5		1740024
[inch]			[inch]					

Highline XP Table and Miter Chop Saw Blades

Product

Drawing



HIGHLINE XP

LEUCO DUR

tungsten carbide [HW]

LOW

Machine / Application
- table, chop, & miter saws
- for ripping cuts in aluminum/ plastics

Design
- tooth configuration: triple chip flat
- laser plate technology

Advantages
- extended edge life
- noise reduction thanks to laser ornaments

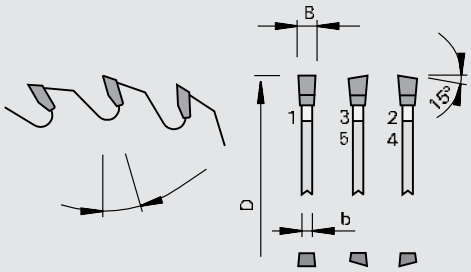
Notes
- alteration of bore possible

Ø D	B	b	Ø d	Z	Tooth Shape-Style	Hook Angle	Comments	Ident-No.
10	2.5	1.8	1	96	Triple Chip Flat	-5°	Aluminum/Plastics	80507564
12	2.5	1.8	5/8	40	Triple Chip Flat	-5°	Aluminum/Plastics	80507563

Specialty Cutting - G5 for Thin Plastics

Product

Drawing



tungsten carbide [HW]

Machine / Application
- table saws
- chop and miter saws
- for cutting in thin walled plastics

Design
- tooth configuration: G5
- Leuco HL board 06 carbide

Advantages
- excellent cutting quality thanks to special tooth geometry
- extremely long edge life
- noise reduction thanks to laser ornaments

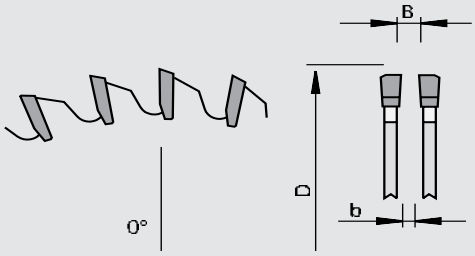
Notes
- alteration of bore possible

Ø D	B	b	Ø d	Z	Tooth Shape-Style	Comments	Ident-No.
10	2.5	1.8	5/8	80	G5		1738778
12	3	2.2	1	100	G5		1738780
14	3	2.2	1	100	G5		1738782
[inch]			[inch]				

Steel - Dry Cut Chop Saw Blades

Product

Drawing



tungsten carbide [HW]

Machine / Application
- chop and miter saws
- for cutting in steel

Design
- tooth configuration: flat with alternating chamfer
- Leuco HL steel 17 carbide

Advantages
- noise reduction thanks to laser ornaments

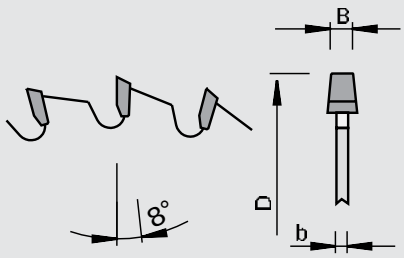
Notes
- alteration of bore possible

Ø D	B	b	Ø d	Z	Tooth Shape-Style	Hook Angle	Comments	Ident-No.
12	2.2	1.8	1	60	Flat w/alt chamf	0		1738796
14	2.2	1.8	1	80	Flat w/alt chamf	0		1738798
[inch]			[inch]					

Conical Scoring

Product

Drawing



LEUCO highline

LEUCO DUR

tungsten carbide [HW]

LOW

Machine / Application
- table saws w/scoring unit
- for scoring of wood based panels

Design
- tooth configuration: flat conical
- one piece design
- Leuco HL board 03 carbide

Advantages
- optimum cutting quality
- extended edge life
- no shims

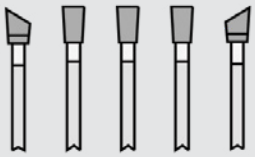
Notes
- alteration of bore possible

Ø D	B	b	Ø d	Z	Tooth Shape-Style	Hook Angle	Comments	Ident-No.
100	3.5-4.3	2.5	3/4	24	Flat-Conical	8	One piece design	1740026
120	3.5-4.3	2.5	3/4	24	Flat-Conical	8	One piece design	1740028
[inch]			[inch]					

Table Saw - Dado Sets

Product

Drawing



LEUCO highline

LEUCO DUR

tungsten carbide [HW]

LOW

Machine / Application
- table saws
- for dado cuts in solid wood & wood based panels

Design
- Leuco HL 10 carbide

Advantages
- optimum cutting quality
- extended edge life

Notes
- alteration of bore possible

Ø D	B	Ø d	Z	Tooth Shape-Style	Hook Angle	Comments	Ident-No.
8	1/8 - 13/16	5/8	24+24	One way w/flat	-5	Dado set w/Z4 chippers	1740658
10	1/8 - 13/16	1	24+24	One way w/flat	-5	Dado set w/Z4 chippers	1740659
[inch]		[inch]					

Dado Set Components

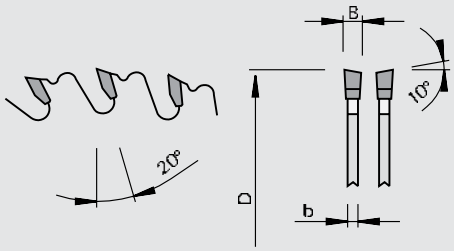
Ø D	B	b	Ø d	Z	Tooth Shape-Style	Comments	Ident-No.
8	3.8	3.2	5/8	4	flat	spare chipper	80341863
8	2.4	1.6	5/8	4	flat	spare chipper	80341864
10	3.8	3.2	1	4	flat	spare chipper	80341852
10	2.4	1.6	1	4	flat	spare chipper	80341854

101320

Trimming Saw Blades HW - with chip limiter “WS” - topline

Product

Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application
- Table saws
- Suitable for manual feed
- for sizing cuts in solid woods
- especially for knotty woods

Design
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 20

Advantages
- no chipped edges from knots thanks to chip limiter
- noise-reduction thanks to laser ornaments

Notes

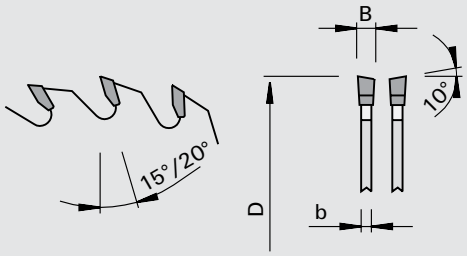
Ø D	B	b	Ø d	Z	NL	Ident-No.
300	3,2	2.2	30	28	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	193240 L
350	3,5	2.5	30	32	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	193241 L
400	4,0	2.8	30	36	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	193242 L
450	4,4	3.0	30	40	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	193243 L
500	4,4	3.2	30	44	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	193244 L
[mm]	[mm]	[mm]	[mm]			

101620/107520

Trimming Saw Blades HW “WS”

Product

Drawing



LEUCO highline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application
- table saws
- for sizing cuts in solid woods

Design
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 10

Advantages
- noise-reduction thanks to laser ornaments for saw blades of more than Ø 250 mm

Notes
- larger bore (max. Ø 80 mm) available for a surcharge

Ø D	B	b	Ø d	Z	Hook angle	NL	Class-No.	Ident-No.
200	3,2	2.2	30	24	20	2/7/42	107520	189932 L
250	3,2	2.2	30	24	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189933 L
250	4,4	2.8	30	20	15	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189934 S
300	3,2	2.2	30	24	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189935 L
[mm]	[mm]	[mm]	[mm]		[°]			

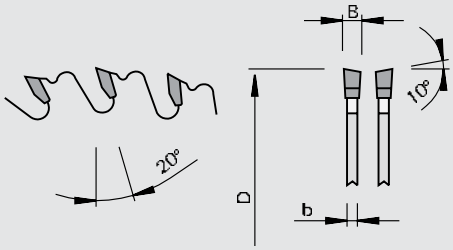
Ø D	B	b	Ø d	Z	Hook angle	NL	Class-No.	Ident-No.
300	3,2	2.2	30	28	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189936 L
300	3,2	2.2	30	36	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189937 L
350	3,5	2.5	30	24	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189938 L
350	3,5	2.5	30	32	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189939 L
350	3,5	2.5	30	36	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189940 L
350	4,4	2.8	30	28	15	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189941 L
400	3,5	2.5	30	28	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189942 L
400	3,5	2.5	30	36	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189943 L
[mm]	[mm]	[mm]	[mm]		[°]			

101620

Trimming Saw Blades HW - with chip limiter “WS”

Product

Drawing



LEUCO highline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application
- table saws
- special saws
- for sizing cuts in solid woods
- especially for knotty woods

Design
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 10

Advantages
- no chipped edges from knots thanks to chip limiter
- noise-reduction thanks to laser ornaments

Notes
- larger bore (max. Ø 80 mm) available for a surcharge

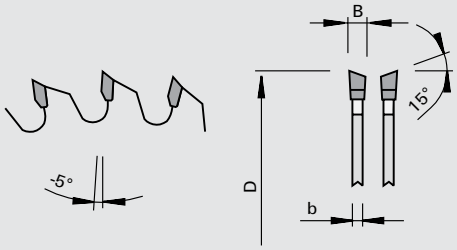
Ø D	B	b	Ø d	Z	NL	Ident-No.
250	3,2	2.2	30	24	2/7/42 + 2/9,5/46,5 + 2/10/60	189946 L
300	3,2	2.2	30	28	2/7/42 + 2/9,5/46,5 + 2/10/60	189947 L
315	3,2	2.2	30	28	2/7/42 + 2/9,5/46,5 + 2/10/60	189948 L
350	3,5	2.5	30	32	2/7/42 + 2/9,5/46,5 + 2/10/60	189949 L
400	3,5	2.5	30	36	2/7/42 + 2/9,5/46,5 + 2/10/60	189950 L
450	3,8	2.8	30	40	2/7/42 + 2/9,5/46,5 + 2/10/60	189951 L
500	3,8	2.8	30	44	2/7/42 + 2/9,5/46,5 + 2/10/60	189952 L
[mm]	[mm]	[mm]	[mm]			

101320 / 102328

Trimming and sizing saw blades HW “WS” - easyFix

Product

Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

easyFix

Machine / Application
- chop and miter saws
- For cross cuts in solid wood and wood-based materials

Design
- Tooth configuration: alternate top bevel “WS”
- Cutting material: HW
- Class-No. 101320 HL Board 20 for wood-based materials
- Class-No. 102328 HL Board 06 for solid wood

Advantages
- easyFix: NEW, EASY HANDLING, easy and smooth mounting of the saw blade on the machine despite high-precision bore tolerance
- High cutting quality and safe handling thanks to negative hook angle
- Noise reduction thanks to laser ornaments

Notes

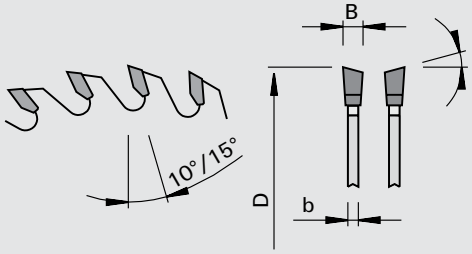
Ø D	B	b	Ø d	Z	NL		Ident-No.
300	3,2	2.2	40	72	2/9/55 + 4/12/64	Graule	193245 L
350	3,4	2.2	40	42	2/9/55 + 4/12/64	Graule	193246 L
350	3,2	2.2	40	72	2/9/55 + 4/12/64	Graule	193247 L
420	4,0	2.8	40	54	2/9/55 + 4/12/64	Graule	193248 L
420	3,5	2.5	40	84	2/9/55 + 4/12/64	Graule	193249 L
520	4,4	3.2	50	60	2/9/55 + 4/12/64	Graule	193250 L
[mm]	[mm]	[mm]	[mm]				

102620/102628/107520

Sizing Saw Blades HW “WS”

Product

Drawing



LEUCO highline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application
- table saws
- special saws
- for sizing cuts in wood-based panels

Design
- tooth configuration: alternate top bevel “WS”
- cutting material: HW
- Class-No. 107520 HL Board 10, hook angle 15°
- Class-No. 102620/102628 HL Board 06, hook angle 10°

Advantages
- optimum cutting quality, feed rate and adjustment for material thickness thanks to various numbers of teeth
- noise-reduction thanks to laser ornaments from Ø 250 mm upwards

Notes
- larger bore (max. Ø 80 mm) available for a surcharge

Ø D	B	b	Ø d	Z	KN	NL	Class-No.	Ident-No.
150	3,2	2.2	30	24		2/7/42	107520	189953 L
[mm]	[mm]	[mm]	[mm]		[mm]			

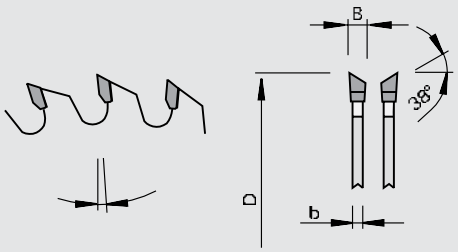
Ø D	B	b	Ø d	Z	KN	NL	Class-No.	Ident-No.
150	3,2	2.2	30	36		2/7/42	102620	189954 L
150	3,2	2.2	30	48		2/7/42	102620	189955 L
180	3,2	2.2	30	30		2/7/42	107520	189956 L
180	3,2	2.2	30	54		2/7/42	102620	189957 L
200	3,2	2.2	30	34		2/7/42	107520	189958 L
200	3,2	2.2	30	48		2/7/42	102620	189959 L
200	3,2	2.2	30	64		2/7/42	102620	189960 L
250	3,2	2.2	30	40		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189961 L
250	3,2	2.2	30	48		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189962 L
250	3,2	2.2	30	60		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189963 L
250	3,2	2.2	30	80		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189964 L
300	3,2	2.2	30	48		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189965 L
300	3,2	2.2	30	60		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189966 L
300	3,2	2.2	30	72		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189967 L
300	3,2	2.2	30	96		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189968 L
315	3,2	2.2	30	48		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189969 L
315	3,2	2.2	30	72		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189970 L
350	3,5	2.5	30	54		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189971 L
350	3,5	2.5	30	72		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189972 L
350	3,5	2.5	30	84		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189973 L
350	3,5	2.5	30	108		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189974 L
400	3,5	2.5	30	60		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189975 L
400	3,5	2.5	30	84		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189976 L
400	3,5	2.5	30	96		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189977 L
400	3,5	2.5	30	120		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189978 L
400	3,5	2.5	50	60	8x8,2	2/10/60	102628	189979 O
450	3,8	2.8	30	66		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189980 L
500	3,8	2.8	30	72		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189981 L
[mm]	[mm]	[mm]	[mm]		[mm]			

102628

Sizing Saw Blades HW “WS - profiles, ledges and plastic profiles

Product

Drawing



LEUCO highline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application
- chop and miter saws
- table saws
- for sizing and trimming cuts in wood-based panels

Design
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 06

Advantages
- chip-free cutting without using a scoring aggregate thanks to 38 degree ATB
- noise-reduction thanks to laser ornaments

Notes
- for profiles, ledges and plastic profiles

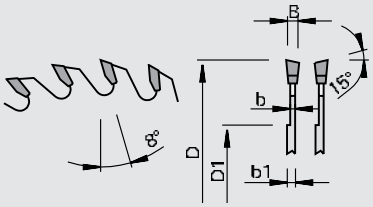
Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
250	3,2	2.2	30	80	2/7/42 + 2/9,5/46,5 + 2/10/60	-2	189982 L
300	3,2	2.2	30	96	2/7/42 + 2/9,5/46,5 + 2/10/60	2	189983 L
[mm]	[mm]	[mm]	[mm]			[°]	

102323

Sizing Saw Blades HW - thin rim design of the steel plate “WS”

Product

Drawing



Tungsten Carbide [HW]

Machine / Application
- table saws
- machines Scheer FM
- for sizing cuts in thin-walled plastic profiles and veneers

Design
- extra thin rim design of the steel plate
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 06

Advantages
- improved stability thanks to relieved tool body

Notes

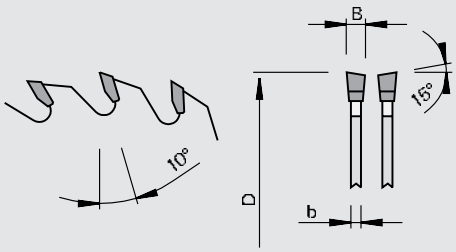
Ø D	B	b1	b	Ø D1	Ø d	Z	NL	Ident-No.
160	1,8	2.2	1.0	80	16	48	2/7,5/31,5	188209 L
180	1,6	2.2	1.0	105	16	56	1/6/33	188210 L
250	1,7	2.2	1.0	170	30	80		188211 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

102321

Sizing Saw Blades HW - thin “WS” - wood-based panels

Product

Drawing



Tungsten Carbide [HW]

Machine / Application
- chop and miter saws
- table saws
- for clipping and miter cuts in solid woods, mainly in MDF
- for cross cutting of profiles (e.g. plastic profiles)

Design
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 03 plus

Advantages
- long edge lives

Notes

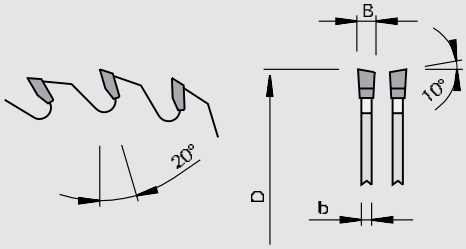
Ø D	B	b	Ø d	Z	NL	Ident-No.
150	2,4	1.8	30	48		189699 L
180	2,4	1.8	30	60		189700 L
200	2,4	1.8	30	64		189701 L
250	2,4	1.8	30	80	2/7/42 + 2/9,5/46,5 + 2/10/60	189702 L
300	2,4	1.8	30	96	2/7/42 + 2/9,5/46,5 + 2/10/60	189704 L
300	2,6	2.2	30	96	2/7/42 + 2/9,5/46,5 + 2/10/60	189705 L
350	2,6	2.2	30	108	2/7/42 + 2/9,5/46,5 + 2/10/60	189706 L
[mm]	[mm]	[mm]	[mm]			

102321

Sizing Saw Blades HW - thin “WS” - solid woods

Product

Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application
- table saws
- sizing saws
- cut-off saws
- for sizing and clipping cuts in solid woods

Design
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 06

Advantages

Notes

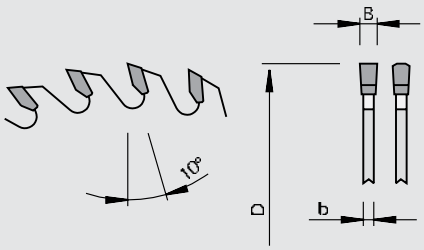
Ø D	B	b	Ø d	Z	NL	Ident-No.
180	2,4	1.8	30	30		188064 L
200	2,4	1.8	30	32		188065 L
250	2,4	1.8	30	40	2/7/42 + 2/9,5/46,5 + 2/10/60	188067 L
300	2,4	1.8	30	48	2/7/42 + 2/9,5/46,5 + 2/10/60	188068 L
350	2,6	2.0	30	54	2/7/42 + 2/9,5/46,5 + 2/10/60	188069 L
[mm]	[mm]	[mm]	[mm]			

102678

Sizing Saw Blades HW “TR-F” - hook angle 10°

Product

Drawing



LEUCO highline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application
- table saws
- vertical panel sizing saws
- for sizing cuts in plastic-laminated panels

Design
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 06

Advantages
- noise-reduction thanks to laser ornaments

Notes
- larger bore (max. Ø 50 mm) available for a surcharge

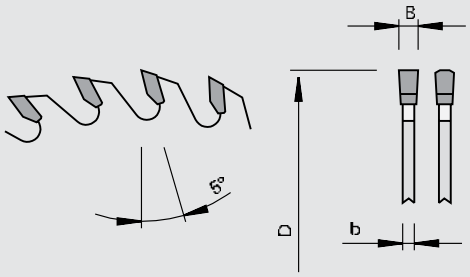
Ø D	B	b	Ø d	Z	NL	Ident-No.
250	3,2	2.2	30	80	2/7/42 + 2/9,5/46,5 + 2/10/60	189984 L
300	3,2	2.2	30	72	2/7/42 + 2/9,5/46,5 + 2/10/60	189985 L
300	3,2	2.2	30	96	2/7/42 + 2/9,5/46,5 + 2/10/60	189986 L
350	3,5	2.5	30	96	2/7/42 + 2/9,5/46,5 + 2/10/60	189987 L
[mm]	[mm]	[mm]	[mm]			

102678

Sizing Saw Blades HW “TR-F” - hook angle 5°

Product

Drawing



LEUCO highline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application
- table saws
- vertical panel sizing saws
- for sizing cuts in plastic-laminated panels

Design
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 06

Advantages
- improved bottom edge (without scoring sawblade) thanks to 5 degree hook angle
- noise-reduction thanks to laser ornaments

Notes
- larger bore (max. Ø 50 mm) available for a surcharge

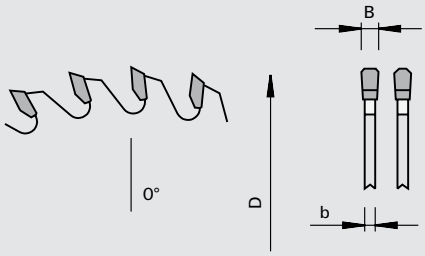
Ø D	B	b	Ø d	Z	NL	Ident-No.
250	3,2	2.2	30	80	2/7/42 + 2/9,5/46,5 + 2/10/60	189988 L
300	3,2	2.2	30	96	2/7/42 + 2/9,5/46,5 + 2/10/60	189989 L
[mm]	[mm]	[mm]	[mm]			

102388

Sizing Saw Blades HW - solid Surface “TR-F-FA”

Product

Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application
- table saws
- vertical panel sizing saws
- especially for the machining of solid surface materials and hard wood-based panels such as Corian®, compact boards, ...

Design
- with laser ornaments
- tooth configuration: triple chip / flat with chamfer “TR-FA”
- cutting material: HW HL Board 06

Advantages
- less vibration and noise thanks to laser ornaments

Notes

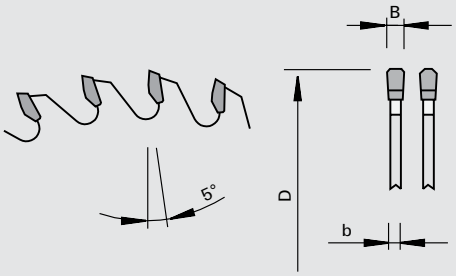
Ø D	B	b	Ø d	Z	NL	Ident-No.
303	3,2	2.5	30	84	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	193133 L
[mm]	[mm]	[mm]	[mm]			

102388

Sizing Saw Blades HW “TR-F-FA” - plastics

Product

Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application
- table saws
- vertical panel sizing saws
- for finish cuts in varying thermoplastic materials

Design
- with laser ornaments
- tooth configuration: triple chip / flat with chamfer “TR-F-FA”
- cutting material: HW HL Board 06

Advantages
- less vibration and noise thanks to laser ornaments

Notes

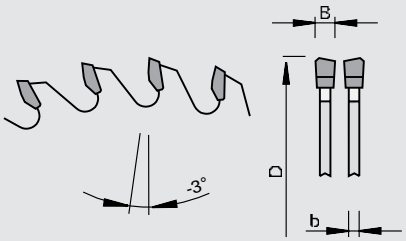
Ø D	B	b	Ø d	Z	NL	Ident-No.
303	3,2	2.2	30	84	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	193109 L
[mm]	[mm]	[mm]	[mm]			

102388

Sizing Saw Blades HW “WS-FA” - plastics

Product

Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application
- table saws
- vertical panel sizing saws
- for finish cuts in varying thermoplastic materials, even with thickness > 15mm

Design
- saw blade body coating: non-stick effect and corrosion protection
- with laser ornaments
- tooth configuration: alternate top bevel with chamfer “WS-FA”
- cutting material: HW HL Board 06

Advantages
- thinner cutting width for reduced cutting pressure, also in thicker materials
- less vibration and noise thanks to laser ornaments

Notes

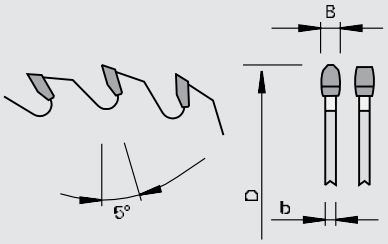
Ø D	B	b	Ø d	Z	NL	Ident-No.
303	2,8	2.2	30	96	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	193378 L
[mm]	[mm]	[mm]	[mm]			

102388

Sizing Saw Blades HW “TR-F K” - anti fingerprint

Product

Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application
- table saws
- vertical panel sizing saws

Design
- with laser ornaments
- tooth configuration: TR-F K
- cutting material: HW HL Board 04 plus

Advantages
- excellent cutting quality in “anti fingerprint” materials and for conventional plastics
- no scoring on the cutting surface due to convex tooth sides
- no flares on the surface of sensible materials
- less vibration and noise thanks to laser ornaments

Notes

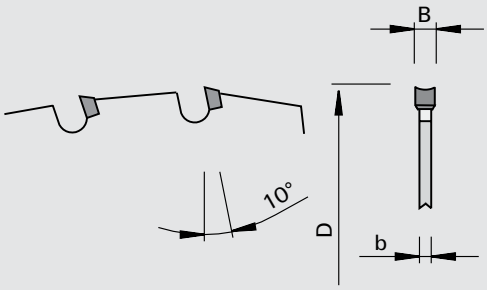
Ø D	B	b	Ø d	Z	NL	Ident-No.
300	3,2	2.2	30	84	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	193195 L
[mm]	[mm]	[mm]	[mm]			

202289

Sizing Saw Blades DP “HR” - nn-System DP flex

Product

Drawing



LEUCO nn system

DP FLEX

Polycrystalline diamond [DP]

NO

Machine / Application
- sizing saws and table saws
- Vertical panel sizing saws
- clipping saws
- for precise cutting in all common wood-based panels such as raw and laminated particle and MDF boards, plywood boards, HDF, WPC, cement and gypsum fiber boards, mineral composites, Alucobond, ...
- for ripping and cross cuts in solid wood, glued laminated timber, thermotreated wood

Design
- resharpenable up to max. 2 times
- smallest gullets - LEUCO patent
- special cutting edge geometry
- Tooth configuration: hollow back tooth “HR”
- Cutting material: DP
- new since 08/2023: LEUCO topcoat non-stick coating

Advantages
- hardly perceivable noise level
- highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping
- reduced cutting pressure thanks to hollow back tooth geometry

Notes
- it is not recommended to use the saw blades for longitudinal cuts in soft wood and material thicknesses of more than 40 mm
- chip-free cuts can only be guaranteed in combination with a suitable scoring saw blade
- Attention! for these saw blades the thickness of the splitting wedge must range between 2.0 and 2.4 mm
- included in delivery: splitting wedge must be ordered separately

Ø D	B	b	Ø d	Z	NL	Ident-No.
250	2,5	2.0	30	50	2/7/42 + 2/9/46 + 2/10/60 + 8/5,2/90	192440 L
254	2,5	2.0	15,875	50		192441 C
260	2,5	2.0	30	60	2/7/42 + 2/9/46 + 2/10/60	192442 L
280	2,5	2.0	30	60	2/7/42 + 2/9/46 + 2/10/60	192443 L
303	2,5	2.0	30	60	2/7/42 + 2/9/46 + 2/10/60 + 8/5,2/90	192444 L
303	2,5	2.0	30	95	2/10/60 + 2/9/46 + 2/9/46,5 + 2/7/42	193238 L
315	2,5	2.0	30	64	2/7/42 + 2/9/46 + 2/10/60	192445 L
350	2,5	2.0	30	72	2/7/42 + 2/9/46 + 2/10/60 + 8/5,2/90	192446 L
[mm]	[mm]	[mm]	[mm]			

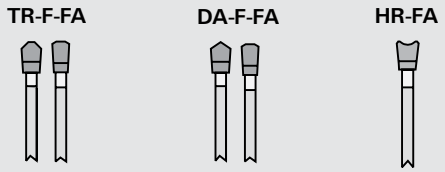
Accessories	B	For Ø D	for machine	Class-No.	PU	Ident-No.
Splitting wedge	2,25	240-250	HOLZ-HER Vertikal	985500	1	192429 L
Splitting wedge	2,25	250-350	Martin T60A	985500	1	192535 L
Splitting wedge	2,25	300	Putsch	985500	1	192457 L
Splitting wedge	2,25	300-350	Altendorf F45	985500	1	192425 L
Splitting wedge	2,25	300-350	Striebig Standard III Control Evolution	985500	1	192430 L
Splitting wedge	2,25	300-350	Striebig Standard Eco	985500	1	192431 C
	[mm]	[mm]				

202180

DIAREX Sizing Saw Blades DP

Product

Drawing



LEUCO DIAREX

Polycrystalline diamond [DP]

LOW

Machine / Application

- table saws
- vertical panel sizing saws
- for finish cuts in varying materials

Design

- resharpening area 2.0 mm
- cutting material: DP in different designs depending on the application

Advantages

- long edge lives thanks to tooth group with higher number of quality-forming cutting edges
- less vibration and noise thanks to laser ornaments

Notes

TR-F-FA
- universal and robust geometry
- for melamine-laminated or HPL-laminated wood-based materials as well as composites associated with scoring saw blades
- very good suited for mineral materials

DA-F-FA
for finish cuts in melamine-laminated and HPL-laminated wood-based plates associated with scoring saw blades

HR-FA
- excellent cut quality (on top) thanks to pre-scoring effect and reduced cutting pressure
- well suited for magnet bond boards
- very well suited for thin plates made of CFRP and GFRP

Ø D	B	b	Ø d	Z	NL	Tooth geometry	Ident-No.
250	3,2	2.2	30	48	2/7/42 + 2/9/46 + 2/10/60	TR-F-FA	192955 L
303	3,2	2.2	30	48	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	TR-F-FA	80490705 L
[mm]	[mm]	[mm]	[mm]				

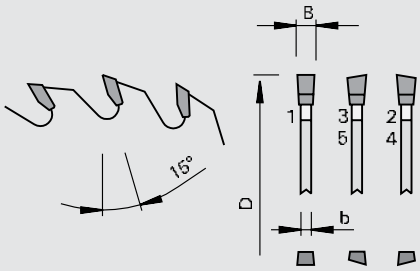
Ø D	B	b	Ø d	Z	NL	Tooth geometry	Ident-No.
303	3,2	2.2	30	60	2/7/42 + 2/9/46 + 2/10/60	TR-F-FA	192957 L
303	3,2	2.2	30	84	2/7/42 + 2/9/46 + 2/10/60	TR-F-FA	192960 L
350	3,2	2.2	30	60	2/7/42 + 2/9/46 + 2/10/60	TR-F-FA	192961 L
400	3,5	2.5	30	60	2/7/42 + 2/9/46 + 2/10/60	TR-F-FA	193100 L
303	3,2	2.2	30	70	2/7/42 + 2/9/46 + 2/10/60	DA-F-FA	192959 L
250	3,2	2.2	30	50	2/7/42 + 2/9/46 + 2/10/60	HR-FA	192956 L
303	3,2	2.2	30	65	2/7/42 + 2/9/46 + 2/10/60	HR-FA	192958 L
350	3,2	2.2	30	65	2/7/42 + 2/9/46 + 2/10/60	HR-FA	192962 L
[mm]	[mm]	[mm]	[mm]				

102348

Sizing Saw Blades HW “G5”

Product

Drawing



LEUCO G5 system

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application

- table saws
- chop and miter saws
- for chip-free sizing cuts as well as clipping and mitre cuts in wood-based panels, solid woods and plastics

Design

- tooth configuration: G5
- cutting material: HW HL Board 04 plus

Advantages

- excellent cutting quality for cross cuts
- excellent cutting quality thanks to special tooth geometry
- extremely long edge lives
- noise-reduction thanks to laser ornaments

Notes

- pay attention to nmax!!!
- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42

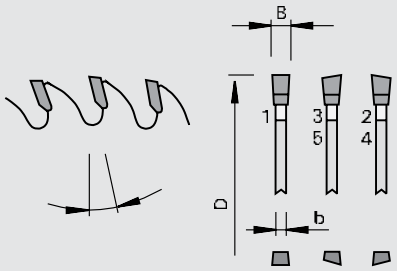
Ø D	B	b	Ø d	Z	NL**		nmax	Ident-No.
200	3,0	2.2	30	65			7630	192789 L
220	3,0	2.2	30	70			6940	192790 L
240	3,0	2.2	30	75			6360	192791 L
250	3,0	2.2	30	80	Combi3		6200	192792 L
280	3,0	2.2	30	85	Combi3		5450	192793 L
300	3,0	2.2	30	100	Combi3		5090	192794 L
303	3,2	2.2	30	100	Combi3	Striebig	5040	192795 L
315	3,0	2.2	30	100	Combi3		4850	192801 L
350	3,0	2.2	30	100	Combi3		4400	192796 L
380	3,0	2.2	32	120		elumatec	3340	192802 L
400	3,0	2.2	30	120	Combi3		3340	192797 L
450	3,6	2.8	30	130	Combi3		3180	192798 L
500	3,6	2.8	30	145	Combi3 + 2/10/70		2670	192799 L
550	4,0	3.2	30	160	Combi3		2780	192803 L
[mm]	[mm]	[mm]	[mm]				[min-1]	

102340

Sizing saw blades HW thin “G5” - clipping and miter saw blades

Product

Drawing



LEUCO g5 system

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application
- chop and miter saws
- for chip-free clipping and miter cuts in wood-based materials, solid woods and plastics

Design
- tooth configuration: G5
- cutting material: HW HL Board 06

Advantages
- excellent cutting quality for cross cuts
- excellent cutting quality thanks to special tooth geometry

Notes
- pay attention to nmax!!!
- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42

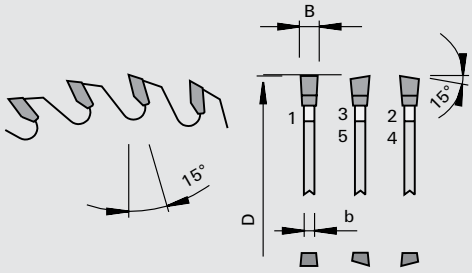
Ø D	B	b	Ø d	Z	NL**	Hook angle	nmax	Ident-No.
216	2,5	1.8	30	60	Combi3	5	7100	80469475 L
260	2,5	1.8	30	80	Combi3	15	5900	80460142 L
[mm]	[mm]	[mm]	[mm]			[°]	[min-1]	

202080

Sizing Saw Blades DP “G5”

Product

Drawing



LEUCO g5 system

LEUCO DIA

Polycrystalline diamond [DP]

LOW

Machine / Application
- table saws
- vertical panel sizing saws
- for chip-free sizing cuts as well as clipping and miter cuts in wood-based panels, and plastics (e.g. plastic profiles)

Design
- resharpening area 3.5 mm
- tooth configuration: G5

Advantages
- excellent cutting quality for cross cuts
- excellent cutting quality thanks to special tooth geometry
- extremely long edge lives
- noise-reduction thanks to laser ornaments

Notes
- pay attention to nmax!!!

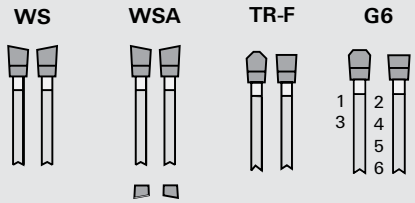
Ø D	B	b	Ø d	Z	NL	Ident-No.
303	3,2	2.2	30	100	2/7/42 + 2/9,5/46,5 + 2/10/60	189633 C
350	3,2	2.2	30	100	2/7/42 + 2/9,5/46,5 + 2/10/60	189634 L
[mm]	[mm]	[mm]	[mm]			

1023...

Sizing Saw Blades HW - LowNoise

Product

Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application

- table saws
- vertical panel sizing saws
- for sizing cuts

Design

- vibration and noise damping ornaments
- additional expansion slots
- cutting material: HL Board 04 plus and HL Board 06

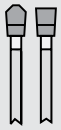
Advantages

- extremely low-noise and smooth running thanks to vibration and noise damping ornaments as well as special expansion slot combinations
- for each application case the correct tooth form

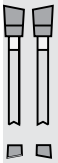
Notes

- Ident-No. 189690: extremely straight steel plate for Striebig panel sizing saws with scoring device
- NL**- Combi2 = 2/7/42 + 2/9/46 + 2/10/60
- NL**- Combi3 = 2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60

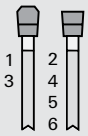
WS
- HW HL Board 04 plus for raw and laminated panels
- HL Board 06 for solid woods in combination with scoring saw blade



TR-F
- for raw and laminated panels
- 10° hook angle in combination with scoring saw blade
- 5° hook angle improved bottom edge even without scoring saw blade



WSA
- universal application
- in combination with scoring saw blade
- diagonal ground front for improvement of cutting quality



G6
- for raw and laminated panels
- in combination with scoring saw blade
- less cutting forces and very long edge lives thanks to innovative tooth group configuration

Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geom-etry	LEUCODUR	Class-No.	Ident-No.	
220	3,2	2.2	30	36	10	2/7/42	WS	HL Board 06	102328	189664	L
250	3,2	2.2	30	40	10	Combi2	WS	HL Board 06	102328	189665	L
250	3,2	2.2	30	48	10	Combi2	WS	HL Board 06	102328	189666	L
300	3,2	2.2	30	48	10	Combi2	WS	HL Board 06	102328	189668	L
300	3,2	2.2	30	60	10	Combi2	WS	HL Board 06	102328	189669	L
300	3,2	2.2	60	48	10		WS	HL Board 06	102320	188185	O
350	3,5	2.5	30	54	10	Combi2	WS	HL Board 06	102328	189670	L
350	3,5	2.5	30	72	10	Combi2	WS	HL Board 06	102328	189671	L
400	3,5	2.5	30	60	10	Combi2	WS	HL Board 06	102328	189672	L
400	3,5	2.5	30	84	10	Combi2	WS	HL Board 06	102328	189673	L
[mm]	[mm]	[mm]	[mm]		[°]						

Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geom-etry	LEUCODUR	Class-No.	Ident-No.	
220	3,2	2.2	30	64	10	2/7/42	WS	HL Board 04 plus	102328	192763	L
250	3,2	2.2	30	60	10	Combi2	WS	HL Board 04 plus	102328	192764	L
250	3,2	2.2	30	80	10	Combi2	WS	HL Board 04 plus	102328	192765	L
300	3,2	2.2	30	72	10	Combi2	WS	HL Board 04 plus	102328	192766	L
300	3,2	2.2	30	96	10	Combi2	WS	HL Board 04 plus	102328	192767	L
350	3,5	2.5	30	84	10	Combi2	WS	HL Board 04 plus	102328	192768	L
350	3,5	2.5	30	108	10	Combi2	WS	HL Board 04 plus	102328	192769	L
350	3,5	2.5	35	84	10	Combi2	WS	HL Board 04 plus	102328	192770	O
400	3,5	2.5	30	96	10	Combi2	WS	HL Board 04 plus	102328	192771	L
400	3,5	2.5	30	120	10	Combi2	WS	HL Board 04 plus	102328	192772	L
450	4,0	2.8	30	132	10	Combi2	WS	HL Board 04 plus	102328	192773	L
[mm]	[mm]	[mm]	[mm]		[°]						

Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geom-etry	LEUCODUR	Class-No.	Ident-No.	
300	3,2	2.2	30	96	10	Combi2	WSA	HL Board 04 plus	102328	192774	L
[mm]	[mm]	[mm]	[mm]		[°]						

Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geom-etry	LEUCODUR	Class-No.	Ident-No.	
220	3,2	2.2	30	64	10	2/7/42	TR-F	HL Board 04 plus	102378	192775	L
250	3,2	2.2	30	60	10	Combi2	TR-F	HL Board 04 plus	102378	192776	L
250	3,2	2.2	30	80	5	Combi3	TR-F	HL Board 04 plus	102378	193196	L
250	3,2	2.2	30	80	10	Combi2	TR-F	HL Board 04 plus	102378	192777	L
300	3,2	2.2	30	72	10	Combi2	TR-F	HL Board 04 plus	102378	192778	L
300	3,2	2.2	30	96	5	Combi3	TR-F	HL Board 04 plus	102378	192779	L
300	3,2	2.2	30	96	10	Combi3	TR-F	HL Board 04 plus	102378	192780	L
350	3,5	2.5	30	84	10	Combi2	TR-F	HL Board 04 plus	102378	192781	L
350	3,5	2.5	30	108	10	Combi2	TR-F	HL Board 04 plus	102378	192782	L
[mm]	[mm]	[mm]	[mm]		[°]						

Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geom-etry	LEUCODUR	Class-No.	Ident-No.	
250	3,2	2.2	30	60	10	Combi2	TR-F-FA	HL Board 04 plus	102378	192785	O
250	3,2	2.2	30	80	10	Combi2	TR-F-FA	HL Board 04 plus	102378	192786	O
300	3,2	2.2	30	72	10	Combi2	TR-F-FA	HL Board 04 plus	102378	192787	O
300	3,2	2.2	30	96	10	Combi2	TR-F-FA	HL Board 04 plus	102378	192788	O
[mm]	[mm]	[mm]	[mm]		[°]						

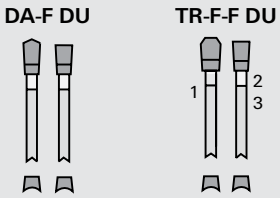
Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geom-etry	LEUCODUR	Class-No.	Ident-No.	
300	3,2	2.2	30	96	5	Combi3	G6	HL Board 04 plus	102378	192783	L
[mm]	[mm]	[mm]	[mm]		[°]						

102338

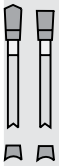
Sizing Saw Blades HW - easyFix - LowNoise

Product

Drawing



Tungsten Carbide [HW]



DA-F DU
- 10° hook angle for raw and laminated panels
- -5° hook angle for sizing cuts in plastic and solid wood profile ledges
- good quality of bottom edge even without scoring saw blade
- excellent cutting quality

TR-F-F DU
- for raw and laminated panels
- good quality of bottom edge even without scoring saw blade
- longer edge life thanks to innovative tooth group configuration and cutting material HL Board 03

Machine / Application
- table saws
- vertical panel sizing saws
- for sizing cuts

Design
- vibration and noise damping ornaments
- cutting material: HL Board 06 and HL Board 03

Advantages
- easyFix: NEW, EASY HANDLING, easy and smooth mounting of the saw blade on the machine despite high-precision bore tolerance
- extremely low-noise and smooth running thanks to vibration and noise damping ornaments as well as special expansion slot combinations

Notes
- Ident-No. 193335: extremely straight steel plate for Striebig panel sizing saws with scoring device
- NL**- Combi3 = 2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60

Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geom-etry	LEUCODUR	Class-No.	Ident-No.	
220	3,2	2.2	30	42	10	2/7/42 + 1/3/52	DA-F DU	HL Board 06	102338	193326	L
250	3,2	2.2	30	48	10	Combi3	DA-F DU	HL Board 06	102338	193327	L
303	3,2	2.2	30	60	10	Combi3	DA-F DU	HL Board 06	102338	193335	L
303	3,2	2.2	30	60	10	Combi3	DA-F DU	HL Board 06	102338	193328	L
350	3,5	2.5	30	72	10	Combi3	DA-F DU	HL Board 06	102338	193329	L
400	3,5	2.5	30	84	10	Combi3	DA-F DU	HL Board 06	102338	193330	L
[mm]	[mm]	[mm]	[mm]		[°]						

Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geom-etry	LEUCODUR	Class-No.	Ident-No.	
250	3,2	2.2	30	48	-6	Combi3	DA-F DU	HL Board 06	102338	193331	L
303	3,2	2.2	30	60	-6	Combi3	DA-F DU	HL Board 06	102338	193332	L
350	3,5	2.5	30	72	-6	Combi3	DA-F DU	HL Board 06	102338	193333	L
[mm]	[mm]	[mm]	[mm]		[°]						

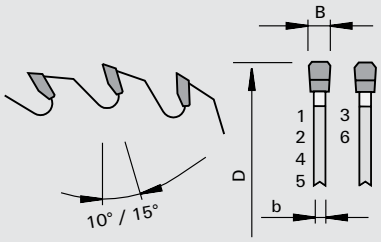
Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geom-etry	LEUCODUR	Class-No.	Ident-No.	
303	3,2	2.2	30	60	10	Combi3	TR-F-F DU	HL Board 03	102338	193334	L
[mm]	[mm]	[mm]	[mm]		[°]						

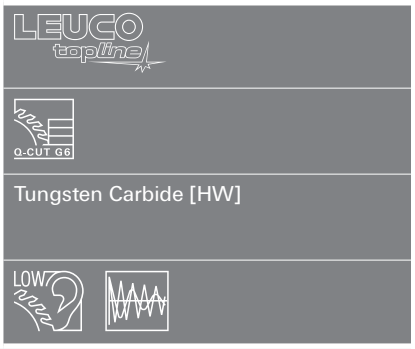
104248

Panel Sizing Saw Blades HW - Q-Cut “G6”

Product

Drawing





Machine / Application

- panel sizing saws
- for finish cuts in veneered, foiled or melamine-laminated panels, in single sheets or in stacks

Design

- vibration and noise damping ornaments
- additional expansion slots
- up to ØD=370, 10 degree hook angle
- from ØD=380, 15 degree hook angle
- tooth configuration: G6
- cutting material: HW HL Board 04 plus

Advantages

- for highest performance demands
- impressive cutting quality thanks to exact and precise cuts
- reduced cutting pressure and optimized cutting geometry G6
- extremely low-noise and smooth running thanks to reinforced body and vibration and noise damping ornaments
- clearly increased edge life thanks to improved HW grade

Notes

- projection: min 20 - 25 mm
- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42
- NL**- Combi5 = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.	
280	3,2	2.2	30	60	Combi3 + 2/13/94	Panhans EURO 5	193136	L
300	4,0	3.0	60	72	Combi7	Homag (Holzma) HPP 230	193370	L
300	4,4	3.3	60	72	Combi7	Homag (Holzma) HPP 230	193137	L
300	4,4	3.0	65	60	2/9/110	Selco EB 70	193138	L
300	4,4	3.0	75	60	2/9/110	Holzma CH03	193139	O
305	4,4	3.0	30	60	Combi3 + 2/13/94	Mayer, Panhans	193140	L
308	3,2	2.4	60	96	Combi7	Homag HPS 320	193141	L
320	4,4	3.3	30	60	Combi3 + 2/13/94	Mayer / Format 4	193142	L
320	4,0	3.0	60	72	Combi7	HOMAG SAWTEQ B-200	193372	L
320	4,4	3.3	60	72	Combi7	HOMAG SAWTEQ B-200	193221	L
320	3,6	2.5	65	60	2/9/110 + 2/9/100	Selco WN 230, Selco SK 230	193301	L
320	4,4	3.3	65	60	2/9/110	Biesse, Selco EB 80	193143	L
330	4,4	3.3	50	60	8/13/80	Giben	193144	S
350	4,25	3.3	30	72	Combi3 + 2/13/94	Scheer	193145	L
350	4,4	3.3	30	72	Combi3 + 2/13/94	SCM, Panhans, Mayer, Schelling, HOLZ-HER	193146	L
350	4,4	3.3	50	72	8/13/80	Giben Smart	193147	O
350	4,0	3.0	60	72	Combi7	Homag (Holzma) 72, HPP 350	193373	L
350	4,4	3.3	60	72	Combi7	Homag (Holzma) 72, HPP 350	193148	L
350	4,4	3.3	75	72		Homag Sawtech, Homag (Holzma) 250	193149	L
355	4,4	3.3	30	72	Combi3 + 2/13/94	Mayer / Format 4	193290	L
350	3,6	2.5	65	72	2/9/110 + 2/9/100	Selco WN 250	193302	L
355	4,4	3.3	75	72		Giben	193150	L
[mm]	[mm]	[mm]	[mm]					

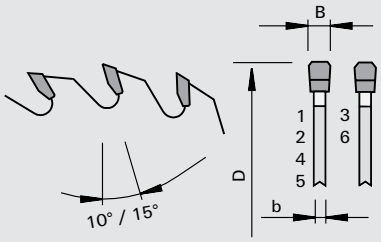
Ø D	B	b	Ø d	Z	NL**		Ident-No.
355	4,4	3.3	80	72	4/8,5/100 + 2/7/110 + 2/14/110	Gabbiani PRIMA, SCM ALPHA	193152 L
360	4,4	3.3	30	72	Combi3 + 2/13/94	Schelling	193153 L
360	4,4	3.3	75	72	4/15/105	Giben	193154 S
370	4,4	3.3	30	72	Combi3 + 2/13/94	Schelling FM	193155 L
380	4,4	3.3	30	72	Combi3 + 2/13/94	HOLZ-HER	193156 L
380	4,4	3.3	50	72	4/13/80	Giben Onyx	193157 L
380	4,0	3.0	60	72	Combi7	Homag (Holzma)	193374 L
380	4,4	3.3	60	72	Combi7	Homag (Holzma)	193158 L
380	4,8	3.6	60	72	Combi7	Homag (Holzma)	193159 L
380	3,6	2.5	65	72	2/9/110 + 2/9/100	Selco WN 610 - WNA 610	193303 L
380	4,4	3.3	65	72	2/9/100 + 2/9/110	Selco WN 610	193283 L
380	4,4	3.3	80	72	Combi5	SCM, Selco	193188 L
380	4,8	3.6	80	72	Combi5	SCM, Selco	193189 L
400	4,25	3.3	30	72	Combi3 + 2/13/94	Scheer	193160 O
400	4,4	3.3	30	72	Combi3 + 2/13/94	HOLZ-HER, Irion, Mayer, Scheer, Schelling	193161 L
400	4,4	3.3	60	72	Combi7	Nanxing	193162 O
400	4,0	3.0	65	72	2/9/110 + 2/9/100	Selco WN 630 - WNA 630, Selco WN 650 - WNA 650	193304 L
400	4,4	3.3	65	72	2/9/100 + 2/9/110	Selco WN 630, WN 650	193284 L
400	4,4	3.3	75	72	4/15/105 + 2/7/110	Giben Prismatic 1, Giben Starmatic, Homag CH08+12	193163 L
400	4,4	3.3	80	72	Combi5	Gabbiani CLASS, SCM DELTA, Selco WN / EB	193164 L
420	4,8	3.6	60	72	Combi7	Homag (Holzma) Typ 92	193165 L
430	4,4	3.3	30	72	Combi3 + 2/13/94	HOLZ-HER	193166 L
430	4,0	3.0	65	72	2/9/110 + 2/9/100	Selco WN 650 - WNA 650	193305 S
430	4,8	3.6	70	72	4/11/130	Selco WN	193169 L
430	4,4	3.3	75	72	4/15/105 + 2/7/110	Giben Prismatic 2 old	193167 L
430	4,4	3.3	80	72	Combi5	Selco WN	193168 L
450	4,4	3.3	30	72	Combi3 + 2/13/94	Irion, Schelling	193170 L
450	4,4	3.3	75	72	2/7/110	Giben	193171 L
450	4,4	3.3	80	72	Combi5	Gabbiani ELITE	193172 O
450	4,65	3.6	30	72	Combi3 + 2/13/94	Scheer	193173 O
450	4,8	3.6	30	72	Combi3 + 2/13/94	Scheer	193174 L
450	4,8	3.6	60	72	Combi7	Homag (Holzma)	193175 L
450	4,8	3.6	80	72	Combi5	Selco WN	193176 O
460	4,4	3.3	30	72	Combi3 + 2/13/94	Schelling FL, FH6	193177 L
470	4,4	3.3	75	72	4/15/105 + 2/19/120	Giben	193178 S
470	4,8	3.6	70	72	4/11/130	Selco WN	193179 S
480	4,4	3.3	30	72	Combi3 + 2/13/94	Schelling FH6 from 2016	193180 L
480	4,8	3.6	60	72	Combi7	Homag (Holzma)	193181 L
480	4,8	3.6	70	72	4/11/130	Selco Series 750	193183 O
480	4,8	3.6	80	72	Combi5	Selco WN	193184 L
500	4,8	3.6	60	72	Combi7	Homag (Holzma) Typ 22	193185 S
520	4,8	3.6	30	72	Combi3 + 2/13/94	Schelling FH8	193186 L
520	4,8	3.6	60	72	Combi7	Homag (Holzma) 23 / 550	193187 L
520	4,8	3.6	70	72	4/11/130	Selco WN	193182 L
[mm]	[mm]	[mm]	[mm]				

104249

Panel Sizing Saw Blades HW - Q-Cut “G6” - nn-System

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- panel sizing saws
- for finish cuts in veneered, foiled or melamine-laminated panels, in single sheets or in stacks up to 60 mm cutting height

Design

- special nn-System gullet geometry
- tooth configuration: G6
- cutting material: HW HL Board 04 plus

Advantages

- especially low noise level
- noise reduction by up to approx. 6 dB(A) when idling
- for highest performance demands
- impressive cutting quality thanks to exact and precise cuts without chippings
- reduced cutting pressure and power consumption thanks to optimized cutting geometry
- clearly increased edge life thanks to improved HW grade

Notes

- projection: min. 20 - 25 mm max. 40 mm
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

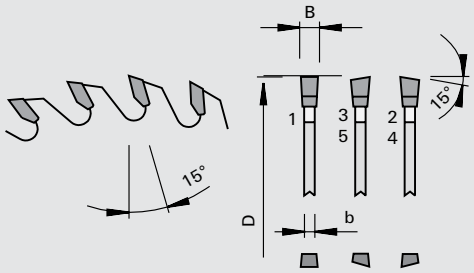
Ø D	B	b	Ø d	Z	NL**		Ident-No.
310	4,0	3.0	60	72	Combi7	Homag (Holzma BR200)	193371 L
310	4,4	3.2	60	72	Combi7	Homag (Holzma BR200)	193190 L
350	4,4	3.2	60	72	Combi7	Homag (Holzma 72, 350, HPP 350)	193191 L
380	4,4	3.2	60	72	Combi7	Homag (Holzma)	193192 L
380	4,8	3.5	60	72	Combi7	Homag (Holzma 82, HPP 82, HPP 83, HPL 380)	193193 L
450	4,8	3.5	60	72	Combi7	Homag (Holzma 11510)	193194 L
[mm]	[mm]	[mm]	[mm]				

104258

Panel Sizing Saw Blades HW - Q-Cut “G5”

Product

Drawing



LEUCO g5 system

Q-CUT G5

Tungsten Carbide [HW]

LOW

Machine / Application

- horizontal panel sizing saws
- for sizing and finish cuts in wood core plywood, plywood boards, veneered or paper-laminated wood-based panels and honeycomb panels

Design

- vibration and noise damping ornaments
- additional expansion slots
- tooth configuration: G5
- cutting material: HW HL Board 04 plus

Advantages

- very low cutting pressure and small power consumption thanks to optimized cutting geometry
- excellent cutting quality in wood-based materials containing fibers
- extremely low-noise and smooth running thanks to vibration and noise damping ornaments as well as special expansion slot combinations

Notes

- Attention: when assigning the appropriate scoring saw blades, please take into account the cutting width reduction of 4 mm!
- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9.5/46.5 + 2/7/42
- NL**- Combi5 = 2/7/110 + 2/9/110 + 2/8.4/130 + 2/14/110 + 4/9/100 + 4/19/120
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

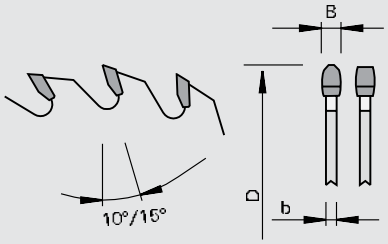
Ø D	B	b	Ø d	Z	NL**		Ident-No.	
300	4,0	3.2	30	100	Combi3	Fimal Concept 350	193312	L
350	4,0	3.2	30	80	Combi3 + 2/13/94	SCM, Panhans, Mayer, Schelling, HOLZ-HER	192813	L
350	4,0	3.2	60	80	Combi7	Homag (Holzma)	192814	L
380	4,0	3.2	60	80	Combi7	Homag (Holzma)	192815	L
400	4,0	3.2	30	85	Combi3 + 2/13/94		192816	L
430	4,0	3.2	30	85	Combi3 + 2/13/94		192817	L
430	4,0	3.2	80	90	Combi5	Selco	192818	S
450	4,0	3.2	60	90	Combi7	Homag (Holzma)	192819	L
460	4,0	3.2	30	90	2/13/94	Schelling	192820	S
[mm]	[mm]	[mm]	[mm]					

104278

Panel Sizing Saw Blades HW - Q-Cut “TR-F K”

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- horizontal panel sizing saws
- for micro cuts in new materials (special surfaces) and plastics

Design

- vibration and noise damping ornaments
- additional expansion slots
- tooth configuration: TR-F K
- cutting material: HW HL Board 04 plus

Advantages

- excellent cutting quality in “anti fingerprint” materials and for conventional plastics
- no scoring on the cutting surface due to convex tooth sides
- no flares on the surface of sensible materials

Notes

- Attention: when assigning the appropriate scoring saw blades, please take into account the cutting width reduction of 4 mm!
- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9.5/46.5 + 2/7/42
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.	
350	4,0	3.2	30	72	Combi3 + 2/13/94	Schelling, SCM, Panhans, Mayer; HOLZ-HER	192974	L
350	4,0	3.2	60	72	Combi7	Homag (Holzma)	192975	L
380	4,0	3.2	60	72	Combi7	Homag (Holzma)	192976	L
400	4,0	3.2	30	72	Combi3 + 2/13/94	Schelling	192977	L
450	4,0	3.2	60	72	Combi7	Homag (Holzma)	192978	L
460	4,0	3.2	30	72	2/13/94	Schelling	192979	S
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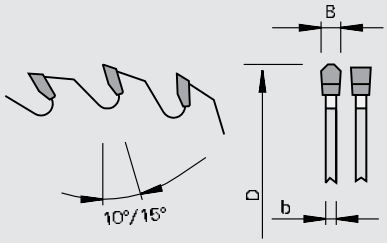
104378

Panel Sizing Saw Blades HW - U-Cut “TR-F”

Product

Drawing



LEUCO topline

U-CUT TR-F

Tungsten Carbide [HW]

LOW

Machine / Application

- panel sizing saws
- for sizing cuts in plastic-laminated panels

Design

- up to ØD=360, 10 degree hook angle
- from ØD=380, 15 degree hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 04 plus

Advantages

- improved cutting quality thanks to optimized cutting geometry
- noise-reduction thanks to laser ornaments

Notes

- specifically for plastic-laminated panels and plywood in single sheets and stacks
- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42
- NL**- Combi5 = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.	
300	4,4	2.8	30	60	Combi3 + 2/13/94	Panhans Euro P8	192901	L
300	4,4	3.2	60	72	Combi7	Homag (Holzma) Typ 130, HPP 230	193299	L
300	4,4	3.0	75	72	2/9/110	Homag Espana	192902	L
300	4,4	3.2	80	72	Combi5	Gabbiani, SCM	193111	L
305	3,2	2.2	30	60	Combi3 + 2/13/94	Scheer FM 16	192903	L
305	4,4	2.8	30	60	Combi3 + 2/13/94	Mayer, Panhans	192904	L
305	4,4	2.8	60	60		Hoggers	192905	L
310	4,4	3.2	60	72	Combi7	Homag (Holzma) Typ 130	193300	L
320	4,4	3.2	60	72	Combi7	Homag Sawtec	80486008	L
320	4,4	3.2	65	60	2/9/110	Biesse, Selco EB 80	192906	L
320	4,4	3.2	75	72	3/13/95	Giben Smart	192907	L
320	4,4	3.2	80	60	Combi5	Gabbiani, SCM	193099	L
320	4,4	3.2	80	72	Combi5	SCM	193110	L
340	4,4	3.2	80	72	Combi5	SCM	193313	L
350	4,4	3.0	30	72	Combi3 + 2/13/94	SCM, Panhans, Mayer, Schelling, HOLZ-HER	192908	L
350	4,4	3.2	60	72	Combi7	Homag (Holzma) 72, HPP 350	192909	L
350	4,4	3.0	75	60		Giben MK Gamma	192910	L
350	4,4	3.2	75	72	2/7/110	KDT	80484667	L
355	4,4	3.2	30	72	Combi3 + 2/13/94	Mayer / Format 4	193289	S
355	4,4	3.2	65	72	2/9/110	Selco EB 95 / EB 100	193098	L
355	4,4	3.0	75	60		Giben Trend, Homag CH06+10	192912	L
355	4,4	3.0	75	72	4/15/105	Giben	192911	L
355	4,4	3.0	80	72	Combi5	Gabbiani PRIMA, SCM ALPHA, S.M.A., hoggers	192913	L
360	4,4	3.2	30	72	Combi3	Schelling FH4	193314	L
360	4,4	3.2	65	72	2/9/110	Selco	192914	L
380	4,4	3.2	60	72	Combi7	Homag (Holzma)	192915	L
[mm]	[mm]	[mm]	[mm]					

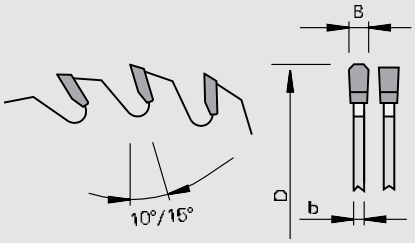
Ø D	B	b	Ø d	Z	NL**		Ident-No.
380	4,8	3.5	60	72	Combi7	Homag (Holzma)	192916 L
380	4,4	3.2	80	72	Combi5	Gabbiani, SCM, Selco	192969 L
380	4,8	3.5	80	72	Combi5	Gabbiani, SCM, Selco	192993 L
400	4,25	3.2	30	72	Combi3 + 2/13/94	Scheer	192917 L
400	4,4	3.2	30	96	Combi3 + 2/13/94		192918 L
400	4,4	3.2	30	72	Combi3 + 2/13/94	Schelling, Mayer, Irion, Scheer, HOLZ-HER	192919 L
400	4,4	3.2	60	72	Combi7	Anthon	192920 L
400	4,8	3.5	60	72	Combi7	Homag (Holzma) Typ 01	192923 L
400	4,4	3.2	75	72	4/15/105 + 2/7/110	Giben Prismatic 1, Giben Starmatic, Homag CH08+12	192921 L
400	4,4	3.2	80	72	Combi5	Selco WN / EB, S.M.A., Irion	192922 L
420	4,8	3.5	60	72	Combi7	Homag (Holzma)	192924 L
430	4,4	3.2	30	72	Combi3		192925 L
430	4,4	3.2	60	72	Combi7		192926 L
430	4,4	3.2	75	96	4/15/105 + 2/7/110	Giben Prismatic 2 old	192927 L
430	4,4	3.2	80	72	Combi5	Selco WN	192928 L
450	4,4	3.2	30	72	Combi3 + 2/13/94	Irion, Schelling	192929 L
450	4,8	3.5	60	72	Combi7	Homag (Holzma)	192931 L
450	4,4	3.2	75	72	2/7/110	KDT	80484668 L
450	4,4	3.2	80	72	Combi5	S.M.A., Irion	192930 L
450	4,8	3.5	80	72	Combi5	Selco WN	192932 L
460	4,4	3.2	30	72	Combi3 + 2/13/94	Schelling FL, FH 6	192933 L
470	4,8	3.5	70	72	4/11/130	Selco WN	192936 L
470	4,4	3.2	75	96	4/15/105 + 2/19/120	Giben Prismatic 3	192934 L
470	4,4	3.2	75	72	4/15/105 + 2/19/120	Giben	192935 L
480	4,4	3.2	30	72	Combi3 + 2/13/94	Schelling FL	192937 L
480	4,8	3.5	60	72	Combi7	Homag (Holzma) 530	192938 L
480	4,8	3.5	80	72	Combi5	Selco WN	192939 L
520	4,4	3.3	30	72	4/13/94	Schelling FH8	193251 L
[mm]	[mm]	[mm]	[mm]				

104378

Panel Sizing Saw Blades HW - U-Cut max “TR-F”

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- panel sizing saws
- for sizing cuts in plastic-laminated panels

Design

- up to ØD=360, 10 degree hook angle
- from ØD=380, 15 degree hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 04 plus

Advantages

- higher edge life thanks to up to 6 times more resharpenings than U-Cut TR-F
- noise reduction thanks to laser ornaments

Notes

- specifically for plastic-laminated panels and plywood in single sheets and stacks
- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

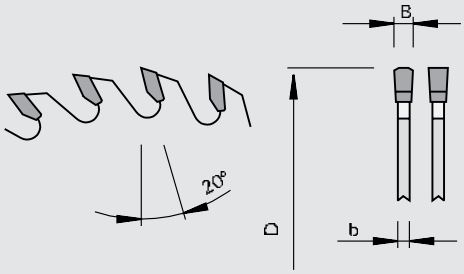
Ø D	B	b	Ø d	Z	NL**		Ident-No.
350	4,4	3.2	30	72	Combi3 + 2/13/94	SCM, Panhans, Mayer, Schelling, HOLZ-HER	193120 S
350	4,4	3.2	60	72	Combi7	Homag (Holzma) 72, HPP 350	193121 L
350	4,4	3.2	75	72		Giben MK Gamma	193122 L
380	4,4	3.2	60	72	Combi7	Homag (Holzma)	193123 L
380	4,8	3.5	60	72	Combi7	Homag (Holzma)	193124 L
380	4,4	3.2	80	72	Combi5	Gabbiani, SCM, Selco	193125 S
380	4,8	3.5	80	72	Combi5	Gabbiani, SCM, Selco	193126 S
400	4,4	3.2	30	72	Combi3 + 2/13/94	Schelling Mayer, Irion, Scheer, HOLZ-HER	193127 S
450	4,4	3.2	30	72	Combi3 + 2/13/94	Irion, Schelling	193128 S
450	4,8	3.5	60	72	Combi7	Homag (Holzma)	193129 L
470	4,8	3.5	70	72	2/11/130	Selco WN	193132 L
470	4,4	3.2	75	72	4/15/105 + 2/19/120	Giben	193130 S
470	4,8	3.5	75	72	4/15/105 + 2/7/110	Giben	193131 S
500	4,4	3.2	30	60	Combi3 + 2/13/94	Schelling, Irion	192940 L
500	4,8	3.5	60	72	Combi7	Homag (Holzma) Typ 22	192941 L
520	4,8	3.5	30	72	Combi3 + 2/13/94	Schelling FH 8	192942 L
520	4,8	3.5	60	72	Combi7	Homag (Holzma) Typ 23	192943 L
560	4,8	3.5	30	72	2/13/94	Schelling	193104 L
600	5,8	4.0	60	72	Combi7	Homag (Holzma) Typ 42	192944 L
650	6,2	4.0	40	72		Schelling	192945 L
[mm]	[mm]	[mm]	[mm]				

104270

Panel Sizing Saw Blades HW - U-Cut speed “TR-F”

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- horizontal panel sizing saws
- for stack cuts in raw and plastic-laminated panels

Design

- vibration and noise damping ornaments
- additional expansion slots
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 04 plus

Advantages

- for highest performance demands
- reduced cutting pressure and power consumption thanks to optimized cutting geometry
- extremely low-noise and smooth running thanks to vibration and noise damping ornaments as well as special expansion slot combinations
- clearly increased edge life thanks to improved HW grade

Notes

- stack height: Ident-No. 192629 up to max. 190 mm / Ident-No. 192631 up to max. 210 mm / Ident-No. 192633 up to max. 215 mm
- recommended projection: 20-30 mm
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

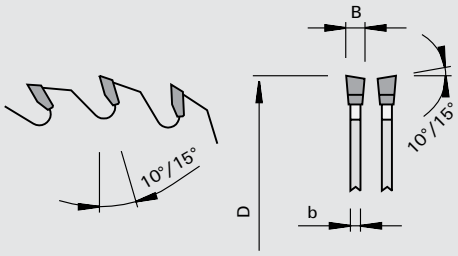
Ø D	B	b	Ø d	Z	NL**		Ident-No.
520	4,8	3.5	60	60	Combi7	Homag (Holzma) Typ 23	192617 S
530	5,0	3.5	30	60		Schelling	192618 S
530	5,8	4.0	60	60	Combi7		192619 L
565	4,8	3.5	80	60	2/8/110		192620 S
565	5,0	3.5	100	60		Giben	192621 S
570	4,8	3.5	60	60	Combi7	Homag (Holzma)	192622 L
575	5,8	4.0	60	60	Combi7	Homag (Holzma)	192664 L
600	5,8	4.0	60	60	Combi7	Homag (Holzma) Typ 42	192624 L
600	5,8	4.0	80	60	2/11/115 + 2/19/120		192625 L
620	6,2	4.0	80	60	4/15/143		192626 S
650	6,2	4.0	40	60		Schelling	192627 S
670	6,0	4.4	60	48	Combi7	Homag (Holzma) 66 (Tandem)	192628 L
680	6,4	4.4	40	60	2/17/140 + 2/13/140	Schelling	192629 L
700	6,4	4.4	80	60	2/17/110	Anthon	192631 L
700	6,8	4.4	80	60	2/17/110		192632 S
720	6,4	4.4	40	60	2/13/114 + 2/13/140	Schelling	192633 L
730	6,4	4.4	60	60	Combi7	Homag (Holzma) 66 (Tandem)	192635 L
730	6,4	4.4	80	60	2/17/110	Anthon LNC	192634 L
750	6,5	4.6	40	72	2/13/140 + 2/13/114		192636 L
[mm]	[mm]	[mm]	[mm]				

104320

Panel Sizing Saw Blades HW - U-Cut “WS”

Product

Drawing



LEUCO topline

U-CUT WS

Tungsten Carbide [HW]

Machine / Application

- panel sizing saws
- double-end tenoners
- for sizing cuts in raw and veneered particleboard, hardboard, MDF panels and high-density plywood in single sheets and stacks

Design

- up to ØD=355, 10 degree hook angle and 15 degree corner angle
- from ØD=400, 15 degree hook angle and 10 degree corner angle
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 04 plus

Advantages

Notes

- on double-end tenoners in combination with large hoggers
- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42
- NL**- Combi5 = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.
305	4,4	2.8	30	48	Combi3 + 2/13/94	Mayer, Panhans	192821 L
305	4,4	2.8	60	48	Combi7		192822 L
320	4,4	3.2	30	50	Combi3	Mayer, Format 4	193215 L
350	4,4	3.0	30	54	Combi3 + 2/13/94	SCM, Panhans, Schelling	192823 L
350	4,4	3.0	60	54	Combi7	Holzma	193095 L
355	4,4	3.0	30	72	Combi3 + 2/13/94	Schelling, Mayer, Irion	192824 L
355	4,4	3.0	60	54	Combi7	Homag (Holzma)	192825 L
355	4,4	3.0	60	72	Combi7		192826 L
355	4,4	3.0	80	54	Combi5	S.M.A.	192827 L
355	4,4	3.0	80	72	Combi5	S.M.A.	192828 L
380	4,8	3.5	60	54	Combi7	S.M.A., Homag (Holzma)	192829 L
380	4,4	3.2	60	72	Combi7	Homag (Holzma)	193340 L
400	4,4	3.2	80	96	Combi5		192830 S
400	4,6	3.2	30	60	Combi3 + 2/13/94	Schelling, Mayer, Irion, HOLZ-HER	192831 L
400	4,6	3.2	30	72	Combi3 + 2/13/94	Schelling, Mayer, Irion, HOLZ-HER	192832 L
400	4,6	3.2	80	72	Combi5	S.M.A.	192834 O
430	4,6	3.2	80	72	Combi5	S.M.A.	192836 S
450	4,6	3.2	30	54	Combi3 + 2/13/94	Panhans, Irion, Schelling	192837 L
450	4,6	3.2	80	72	Combi5	S.M.A., Irion	192838 L
500	4,6	3.2	30	60	Combi3 + 2/13/94	Schelling, Irion	192839 L
500	4,6	3.2	80	60	Combi5	Teutomatic	192840 O
500	4,8	3.5	60	60	Combi7	Homag (Holzma)	192999 S
550	5,0	3.5	80	60	Combi5	Teutomatic	192841 L
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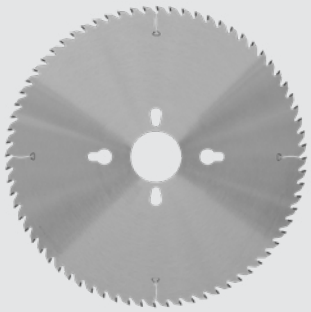
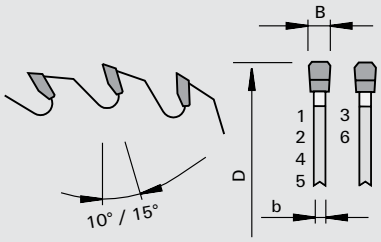
204080

Panel Sizing Saw Blades DP - Q-Cut “G6”

Product



Drawing



Q-CUT G6

Polycrystalline diamond [DP]

Machine / Application

- horizontal panel sizing saws
- for finish cuts in raw and plastic-laminated panels

Design

- vibration-optimized tool body design
- LEUCODIA tipping quality
- G6: for finish cuts in unfinished and plastic-coated composite wood boards individually or in packages up to 80 mm

Advantages

- extremely good vibration damping due to laser ornaments filled with damping material

Notes

- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

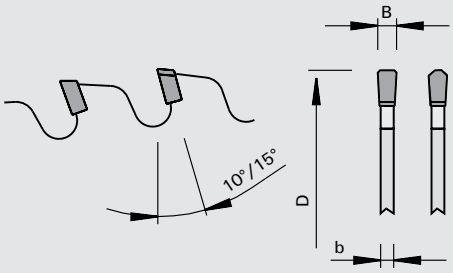
Ø D	B	b	Ø d	Z	NL**		Ident-No.
300	4,4	3.2	30	72			193409 L
300	4,4	3.2	30	72	2/10/60 + 2/13 /94	Panhans, Mayer, SCM, Schelling	80487406 O
300	4,4	3.2	60	72	2/14/110	HOMAG	80487408 O
300	4,4	3.2	65	72	2/9/100 + 2/9/110	Selco	80487409 O
300	4,4	3.2	75	72	2/9/11	HOMAG	80487410 O
300	4,4	3.2	80	72	2/14/110	SCM-Gabbiani	80487411 O
320	4,4	3.2	30	72			193410 L
320	4,4	3.2	50	72	3/15/80	Giben	80487412 O
320	4,4	3.2	60	72	2/14/100	HOMAG Sawtech B 200	80487413 O
320	4,4	3.2	65	72	2/9/100 + 2/9/110	Selco	80487414 O
320	4,4	3.2	75	72		Giben	80487415 O
320	4,4	3.2	80	72	2/14/110	SCM-Gabbiani	80487416 O
350	4,4	3.2	30	72			193412 L
350	4,4	3.2	50	72	4/13/80	Giben	80487418 O
350	4,4	3.2	60	72	Combi7	HOMAG	193411 L
350	4,4	3.2	30	72	2/10/60 + 2/13/94	Panhans, Mayer, SCM, Scheer	80487417 O
350	4,4	3.2	65	72	2/9/110	Selco	80487419 O
350	4,4	3.2	75	72	4/15/105 + 2/7/110	Giben	80487420 O
350	4,4	3.2	80	72	2/14/110	SCM-Gabbiani	80487421 O
380	4,4	3.2	60	72	Combi7	HOMAG	193413 L
400	4,4	3.2	30	72			193414 L
400	4,4	3.2	30	72	2/10/60 + 2/13/94	Panhans, Mayer, SCM, Scheer	80487422 O
400	4,4	3.2	65	72	2/9/110	Selco	80487423 O
400	4,4	3.2	75	72	4/15/105 + 2/7/110	Giben, KDT	80487424 O
400	4,4	3.2	80	72	2/14/110	SCM-Gabbiani	80487425 O
400	4,4	3.2	80	72	2/9/130 + 4/19/120	Selco	80487426 O
430	4,4	3.2	30	72			193415 L
430	4,4	3.2	30	72	2/10/60	Schelling	80487427 O
430	4,4	3.2	65	72	2/9/10	Selco	80487428 O
430	4,4	3.2	70	72	4/11/130	Selco	80487429 O
430	4,4	3.2	75	72	4/15/105 + 2/7/110	Selco	80487430 O
430	4,4	3.2	80	72	2/14/110	SCM-Gabbiani	80487431 O
450	4,8	3.5	60	72	Combi7	HOMAG	193416 L
[mm]	[mm]	[mm]	[mm]				

204080

Panel Sizing Saw Blades DP - U-Cut “TR-F-FA”

Product

Drawing



Polycrystalline diamond [DP]

Machine / Application

- horizontal panel sizing saws
- for sizing cuts in raw and plastic-laminated panels

Design

- Extra sturdy design for universal use
- Tooth configuration: triple chip - flat chamfer “TR-F-FA”
- Cutting material: DP

Advantages

- A larger wedge angle ensures a greater resistance to breakage at the tooth

Notes

- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9.5/46.5 + 2/7/42
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120
- Further dimensions on request

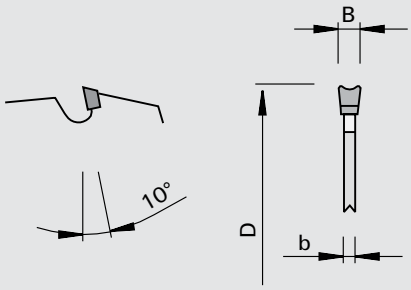
Ø D	B	b	Ø d	Z	NL**		Ident-No.
300	3,2	2.4	30	72	Combi3 + 2/13/94	Schelling LS1	193342 L
308	3,2	2.4	60	84	Combi7	HOMAG SAWTEQ B-320 flexTec	193343 L
350	4,4	3.2	30	72	Combi3 + 2/13/94	HOLZ-HER, Mayer, Panhans, Schelling SCM	193344 L
350	4,4	3.2	60	72	Combi7	HOMAG (HOLZMA), Nanxing	193345 L
350	4,4	3.2	75	72	4/15/105 + 2/7/110	Giben	193346 L
360	4,4	3.2	30	72	Combi3 + 2/13/94	Schelling	80475809 L
380	4,4	3.2	60	72	Combi7	HOMAG (HOLZMA), Nanxing	193347 L
380	4,4	3.2	60	84	Combi7	HOMAG (HOLZMA), Nanxing	193348 L
380	4,8	3.5	60	72	Combi7	HOMAG (HOLZMA), Nanxing	193349 L
400	4,4	3.2	30	72	Combi3 + 2/13/94	HOLZ-HER, Irion, Mayer, Panhans, Scheer, Schelling	193350 L
450	4,8	3.5	60	72	Combi7	HOMAG (HOLZMA), Nanxing	193351 L
460	4,4	3.2	30	72	Combi3 + 2/13/94	Schelling	80494103 L
[mm]	[mm]	[mm]	[mm]				

204180

DIAREX Panel Sizing Saw Blades DP “HR-FA”

Product

Drawing



Polycrystalline diamond [DP]

Machine / Application
- horizontal panel sizing saws
- well suited for magnet bond boards
- very well suited for thin plates made of CFRP and GFRP

Design
- tooth configuration: hollow back with chamfer ”HR-FA”
- cutting material: DP
- resharpenable area 2.0 mm

Advantages
- excellent cut quality thanks to pre-scoring effect and reduced cutting pressure

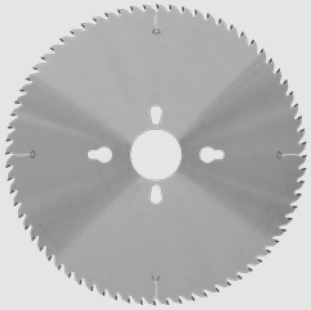
Notes

Ø D	B	b	Ø d	Z	Ident-No.
350	4,4	3.2	30	72	193222 L
[mm]	[mm]	[mm]	[mm]		

204380

Panel Sizing Saw Blades DP “HR-TR” - topcoat

Product



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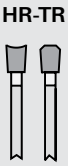


Polycrystalline diamond [DP]

Machine / Application
- horizontal panel sizing saws
- for finish cuts in HPL and solid core materials

Design
- vibration-optimized tool body design
- LEUCODIA tipping quality
- LEUCO topcoat: smooth surfaces for the reduction of deposits and adhesions on the cutting edges

Advantages
- extremely good vibration damping due to laser ornaments filled with damping material
- increased edge lives thanks to topcoat coating

Notes
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.
350	4,4	3.2	60	72	Combi7	Homag (Holzma) 72, HPP 350	193046 L
[mm]	[mm]	[mm]	[mm]				

204389

Panel Sizing Saw Blades DP “TR-F-FA” - nn-System

Product

Drawing

TR-F-FA

LEUCO nn system

DP PANEL

Polycrystalline diamond [DP]

NO

Machine / Application

- panel sizing saws
- for sizing cuts in raw and plastic-laminated panels

Design

- special NoNoise gullet geometry
- diamond cutting edges with polished design
- LEUCODIA tipping quality

Advantages

- especially low noise level
- noise reduction by approx. 6 dB(A) when idling
- for each application case the correct tooth form

Notes

- further dimensions and tooth forms on request

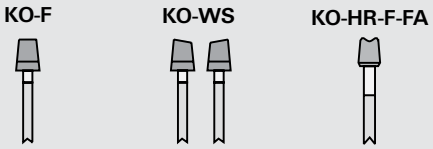
Ø D	B	b	Ø d	Z	Tooth geometry		Ident-No.
308	3,2	2.4	60	96	TR-F-FA	Homag HPS 320	193103 L
[mm]	[mm]	[mm]	[mm]				

205099

Scoring Saw Blades DP - nn-System

Product

Drawing



LEUCO nn system

DP PANEL

Polycrystalline diamond [DP]

NO

Machine / Application

- Panel Sizing Saw Blades with scoring device
- for scoring of plastic-laminated panels

Design

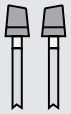
- NoNoise gullet geometry
- LEUCODIA tipping quality

Advantages

- the optimized tooth configuration reduces the repair costs
- the correct tooth configuration for each application case

Notes

KO-F
Universal use in melamine and laminated panels



KO-WS
Veneered panels, reduced motor power

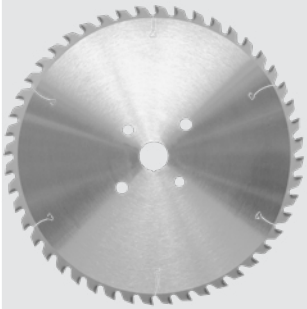
KO-HR-F-FA
Perfect Cutting quality in all different panel materials

Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident-No.	
180	4,4-5,2	3.2	30	30	2/10/60	KO-F	Nanxing, Panhans, HOLZ-HER	193379	L
180	4,4-5,2	3.2	30	30	2/10/60	KO-HR-F-FA	Nanxing, Panhans, HOLZ-HER	193387	L
180	4,4-5,2	3.2	30	30	2/10/60	KO-WS	Nanxing, Panhans, HOLZ-HER	193402	L
180	4,4-5,2	3.2	30	36	2/10/60	KO-HR-F-FA	Nanxing, Panhans, HOLZ-HER	193388	C
180	4,4-5,2	3.2	45	30		KO-F	Homag (Holzma)	193380	L
180	4,4-5,2	3.2	45	30		KO-HR-F-FA	Homag (Holzma)	193389	L
180	4,8-5,6	3.5	45	30		KO-F	Homag (Holzma)	193381	L
180	4,8-5,6	3.5	45	30		KO-HR-F-FA	Homag (Holzma)	193391	L
180	4,8-5,6	3.5	45	30		KO-WS	Homag (Holzma)	193403	L
180	4,0-4,8	3.2	45	36		KO-HR-F-FA	Homag (Holzma)	80505249	L
180	4,4-5,2	3.2	45	36		KO-HR-F-FA	Homag (Holzma)	193390	L
180	4,8-5,6	3.5	45	36		KO-HR-F-FA	Homag (Holzma)	193392	L
200	4,4-5,2	3.2	20	30	2/11/66	KO-HR-F-FA	Schelling	193393	L
200	4,4-5,2	3.2	20	36	2/11/66	KO-HR-F-FA	Schelling	193394	L
200	4,4-5,2	3.2	45	30		KO-F	Homag (Holzma)	193383	L
200	4,4-5,2	3.2	45	30		KO-HR-F-FA	Homag (Holzma)	193395	L
200	4,4-5,2	3.2	45	30		KO-WS	Homag (Holzma)	193404	L
200	4,8-5,6	3.5	45	30		KO-F	Homag (Holzma)	193384	L
200	4,8-5,6	3.5	45	30		KO-HR-F-FA	Homag (Holzma)	193397	L
200	4,4-5,2	3.2	65	30	2/9/100 + 2/9/110	KO-F	Selco, SCM	193385	L
200	4,4-5,2	3.2	65	30	2/9/100 + 2/9/110	KO-HR-F-FA	Selco, SCM	193399	L
200	4,4-5,2	3.2	20	30	2/11/66	KO-F	Schelling	193382	C
200	4,4-5,2	3.2	45	36		KO-HR-F-FA	Homag (Holzma)	193396	C
200	4,8-5,6	3.5	45	36		KO-HR-F-FA	Homag (Holzma)	193398	C
200	4,4-5,2	3.2	65	36	2/9/100 + 2/9/110	KO-HR-F-FA	Selco, SCM	193400	C
[mm]	[mm]	[mm]	[mm]						

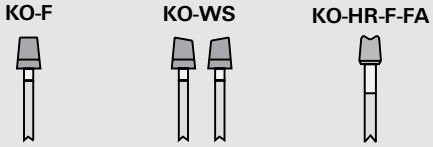
205090

Scoring Saw Blades DP

Product



Drawing



LEUCO topline

LEUCO DIA

Polycrystalline diamond [DP]

Machine / Application

- Panel Sizing Saw Blades with scoring device
- for scoring of plastic-laminated panels

Design

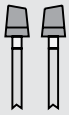
- LEUCODIA tipping quality

Advantages

- the optimized tooth configuration reduces the repair costs
- the correct tooth configuration for each application case

Notes

KO-F
Universal use in melamine and laminated panels



KO-WS
Veneered panels, reduced motor power

KO-HR-F-FA
Perfect Cutting quality in all different panel materials

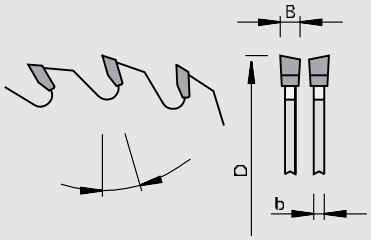
Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident-No.
220	3,4-4,2	2.4	45	60		KO-F	Homag HPS 320	193386 L
300	4,4-5,2	3.2	30	48	2/11/73 + 2/13/94	KO-HR-F-FA	Schelling	193401 L
300	4,4-5,2	3.2	30	48	2/11/73 + 2/13/94	KO-WS	Schelling	193406 L
300	3,2-4,0	2.4	30	72	2/11/73 + 2/13/94	KO-WS	Schelling	193405 L
[mm]	[mm]	[mm]	[mm]					

105320 / 105322

Scoring Saw Blades HW “WS”

Product

Drawing



Tungsten Carbide [HW]

Machine / Application
- panel sizing saws with controllable scoring device
- for scoring of plastic-laminated postforming panels

Design
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 06

Advantages

Notes
- cutting width consistently .2 mm wider than the main saw kerf

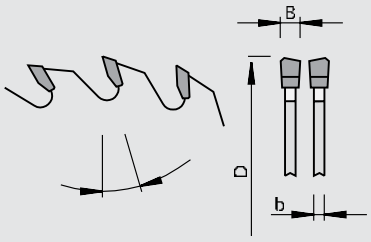
Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁		Ident-No.
180	3,3	2.2	22	36		10	15	Altendorf	192973 S
250	4,55	3.5	30	48	2/10/60	10	15	HOLZ-HER Cut 85	181999 L
250	4,55	3.5	45	48		10	15	Holzma HVP 120	189221 O
280	4,55	3.5	45	84		10	30	Holzma HPP 230+Hpp 250	189324 L
340	5,0	3.5	45	48		10	20	Holzma	188500 S
340	5,0	3.5	45	108		0	20	Holzma	188501 L
[mm]	[mm]	[mm]	[mm]			[°]	[°]		

105320

Scoring Saw Blades HW “WS-FA”

Product

Drawing



Tungsten Carbide [HW]

Machine / Application
- panel sizing saws with controllable scoring device
- for scoring of plastic-laminated postforming panels

Design
- tooth configuration: alternate top bevel with chamfer “WS-FA”
- cutting material: HW HL Board 06

Advantages

Notes
- cutting width consistently .2 mm wider than the main saw kerf

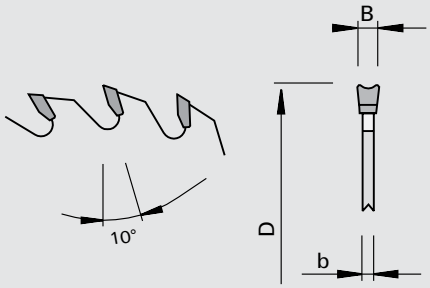
Ø D	B	b	Ø d	Z	NL	Corner◁		Ident-No.
180	4,55	3.2	30	36		15	Schelling	193096 S
300	4,6	3.2	65	72	2/8,4/110 + 2/9/100	5	Selco	188497 L
[mm]	[mm]	[mm]	[mm]			[°]		

105389

Scoring Saw Blades HW “HR-FA” - nn-System

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- panel sizing saws with controllable scoring device

Design

Advantages

Notes

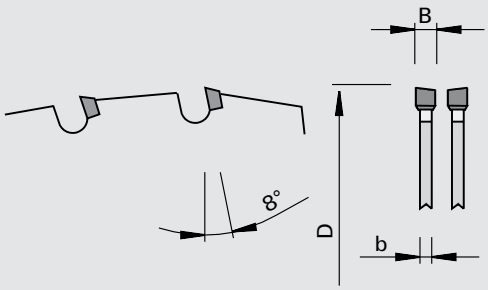
Ø D	B	b	Ø d	Z	Ident-No.
280	5,1	3.5	45	60	80507464 S
[mm]	[mm]	[mm]	[mm]		

205229

Scoring Saw Blades DP “WS” - nn-System DP flex

Product

Drawing



Polycrystalline diamond [DP]

Machine / Application

- sizing saws and table saws
- for chip-free scoring of melamine-, paper- or HPL-laminated panels

Design

- resharpenable up to 2 times
- small gullets
- special cutting edge geometry
- tooth configuration: alternate top bevel “WS”
- cutting material: DP

Advantages

- hardly perceivable noise level
- highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping

Notes

- cutting width consistently 0.1 mm wider than the main saw kerf

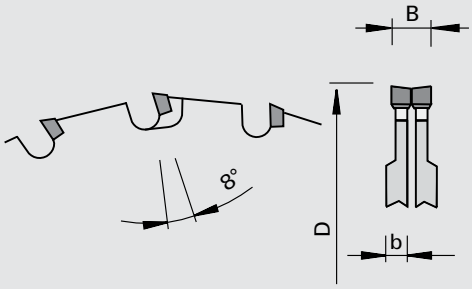
Ø D	B	b	Ø d	Z	Ident-No.
120	2,6	2.0	22	24	192447 L
120	2,6	2.0	20	24	192448 L
125	2,6	2.0	20	24	192449 L
180	2,6	2.0	22	36	192964 S
[mm]	[mm]	[mm]	[mm]		

205288

Scoring Saw Blades DP “WS” - adjustable, nn-System DP flex

Product

Drawing



LEUCO nn system

DP FLEX

Polycrystalline diamond [DP]

Machine / Application
- sizing saws and table saws
- for chip-free scoring of melamine-, paper- or HPL-laminated panels

Design
- resharpenable up to 2 times
- small gullets
- tooth configuration: alternate top bevel “WS”
- cutting material: DP

Advantages
- hardly perceivable noise level
- highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping

Notes
- split version - cutting width adjustable with spacers
- Ident-No. 192452 and 192455 automatic kerf adjustment

Ø D	B	b	Ø d	Z		Ident-No.
120	2,4-3,2	2.2	20	12+12	SCM	192450 L
120	2,4-3,2	2.2	22	12+12	Altendorf, Martin	192451 L
120	2,4-3,2	2.2	50	12+12	Altendorf RAPIDO	192452 L
[mm]	[mm]	[mm]	[mm]			

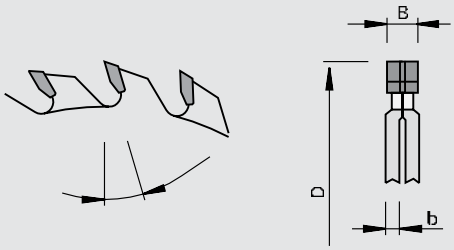
Ø D	B	b	Ø d	Z		Ident-No.
120	2,8-3,6	2.2	20	12+12	SCM	192453 C
120	2,8-3,6	2.2	22	12+12	Altendorf, Martin	192454 L
120	2,8-3,6	2.2	50	12+12	Altendorf RAPIDO	192455 L
[mm]	[mm]	[mm]	[mm]			

105318

Scoring Saw Blades HW - adjustable “F”

Product

Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application
- table saws
- panel sizing saws
- panel sizing saws with controllable scoring device
- for scoring of plastic-laminated panels

Design
- tooth configuration: flat “F”
- cutting material: HW HL Board 03

Advantages
- universally applicable

Notes
- split version - cutting width adjustable with spacers
- X = Orginal Striebig Scoring Saw Blades, cutting width adjustable

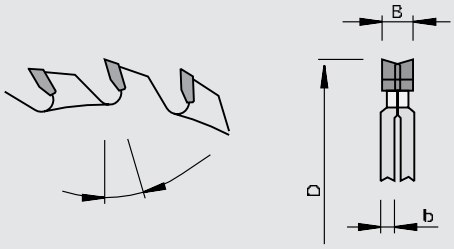
Ø D	B	b	Ø d	Z	NL	Hook angle			Ident-No.
70	2,8-3,6	2.2	20	2x8		12	Putsch		193252 L
80	2,8-3,6	2.2	20	2x6	2/4/34	10	Striebig	X	9201253 L
80	2,8-3,6	2.2	20	2x10		12	Striebig		193253 L
120	2,8-3,6	2.2	20	2x12		12	SCM		193197 L
120	2,8-3,6	2.2	22	2x12		12	Altendorf, Martin		193198 L
125	2,8-3,6	2.2	20	2x12		12	HOLZ-HER, SCM		193199 L
125	2,8-3,6	2.2	22	2x12		12	Altendorf, Martin		193200 L
[mm]	[mm]	[mm]	[mm]			[°]			

105325 / 105328

Scoring Saw Blades HW - adjustable “WS”

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- table saws
- panel sizing saws
- panel sizing saws with controllable scoring device
- for scoring of plastic-laminated panels

Design

- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 03

Advantages

- low motor output thanks to tooth configuration “WS”

Notes

- split version - cutting width adjustable with spacers

Ø D	B	b	Ø d	Z	NL	Hook angle		Class-No.	Ident-No.	
100	2,8-3,6	2.2	20	2x10		12	Schelling	105328	193254	L
100	2,8-3,6	2.2	22	2x10		12	Altendorf, Martin, Panhans, Striebig	105328	193255	L
120	2,8-3,6	2.2	20	2x12		8	SCM	105328	193201	L
120	2,8-3,6	2.2	22	2x12		8	Altendorf, Martin	105328	193202	L
120	2,8-3,6	2.2	22	2x12	2/3,8/42 + 4/4,6/55 + 4/4,6/39	8	Martin NC-adjustment	105328	193203	L
120	2,8-3,6	2.2	50	2x12		12	Altendorf RAPIDO	105328	193256	L
125	4,0-4,8	1.6	45	2x20		12	Giben, Mayer	105325	193257	S
140	2,8-3,6	2.0	36	2x12	2/6,2/51 + 3/ 4,2/55 + 3/9/55	12	Martin T75 PreX	105328	193258	L
160	2,8-3,6	2.2	30	2x16		12	Bäuerle	105328	193259	S
180	2,8-3,6	2.2	30	2x18		10	Koelle	105328	193260	S
300	4,2-4,7	1.8	50	2x32	3/15/80	12	Giben Prismatic + Starmatic	105325	193261	S
340	4,4-5,6	2.5	45	2x24		15	Holzma	105325	193262	S
[mm]	[mm]	[mm]	[mm]			[°]				

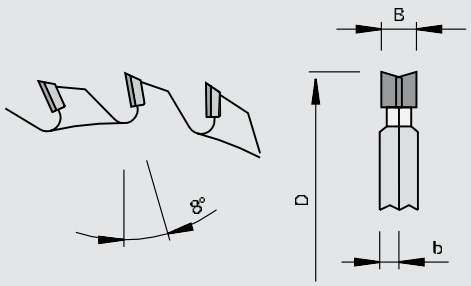
Ø D	B	b	Ø d	Z	Hook angle		Class-No.	Ident-No.	
120	2,8-3,6	2.2	20	2x22	8	SCM	105328	193204	L
120	2,8-3,6	2.2	22	2x22	8	Altendorf, Martin	105328	193205	L
180	2,8-3,6	2.2	22	2x18	12	Altendorf	105328	193263	S
180	3,2-3,8	2.2	50	2x18	12	Altendorf adjustment unit	105328	193264	L
[mm]	[mm]	[mm]	[mm]		[°]				

205088

Scoring Saw Blades DP - adjustable “WS”

Product

Drawing



LEUCO DIA

Polycrystalline diamond [DP]

Machine / Application

- table saws
- for chip-free scoring of melamine-, paper- or HPL-laminated panels

Design

- tooth configuration: alternate top bevel “WS”

Advantages

Notes

- application with feed
- split version - cutting width adjustable with spacers
- Ident-No. 189104 automatic kerf adjustment
- X = for Striebig “Compact”, “Evolution”, “Control”, adjustable by means of spring ring and attachment screw

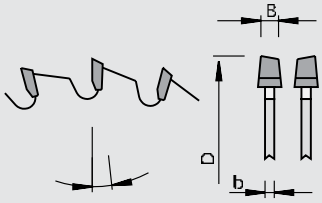
Ø D	B	b	Ø d	Z	NL			Ident-No.
80	2,8-3,6	2.2	20	2x6	2/4/34	Striebig	X	9201163 L
120	2,8-3,6	2.2	20	2x12	2/3,2/42	SCM		192422 L
120	2,8-3,6	2.2	22	2x12	2/3,8/42	Altendorf, Martin		189101 L
120	2,8-3,6	2.0	50	2x12	3/5,5/63 + 3/9/63	for LEUCO adjustment unit		189652 C
120	2,8-3,8	2.2	50	2x12	4/6,2/62	Altendorf adjustment unit		189104 L
[mm]	[mm]	[mm]	[mm]					

105390

Scoring Saw Blades HW “KO-WS”

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- panel sizing saws with scoring device
- for scoring of plastic-laminated panels

Design

- tooth configuration: conical / alternate top bevel “KO-WS”
- cutting material: HW HL Board 04 plus

Advantages

- low motor output thanks to tooth configuration “KO-WS”
- for longer edge lives compared to HL Board 03 plus
- optimum cutting quality thanks to improved runout accuracy
- reduction of the scoring depth

Notes

- height adjustable to kerf of main saw blade
- optimum scoring depth 1.0 - 2.0 mm

Ø D	B	b	Ø d	Z	NL	Hook angle		Ident-No.
100	3,2-4,0	2.2	20	20		8	Schelling	192717 L
120	3,1-3,9	2.2	20	24		8	Lasari	192718 L
120	3,1-3,9	2.2	22	24		8	Altendorf	192719 L
125	4,45-5,25	3.2	20	20		0	Panhans	192723 L
125	4,45-5,25	3.2	22	20		0	Martin	192724 S
125	4,45-5,25	3.2	45	20		0	Giben, Homag CH03	192725 L
125	3,0-3,8	2.2	20	24		8		192721 S
125	3,2-4,0	2.8	20	24		8	SCM, SICAR, Panhans	192722 L
125	3,0-3,8	2.5	22	24		0	Martin, Altendorf	192720 L
125	4,45-5,25	3.2	45	24		8	Homag Espana	192726 L
150	4,45-5,25	3.2	30	24		8	Irion, Mayer	192727 L
150	4,45-5,25	3.2	45	24		8	Homag CH06,08,10,12	192728 L
150	4,45-5,25	3.2	45	28		8	Homag Espana	192729 L
150	4,45-5,25	3.2	45	36		8	Homag Espana, Homag SAWTEC B-130	193310 L
160	4,45-5,25	3.2	45	28	3/11/70	8	Giben Prismatic	192730 L
160	4,45-5,25	3.2	55	36	3/6,5/66	8	Gabbiani	192731 L
180	4,45-5,25	3.2	20	30	2/9/60	8	Schelling, Anthon	192732 L
180	5,8-6,6	4.0	20	30		8	Anthon	192738 L
180	4,45-5,25	3.2	30	30	2/10/60	8	Panhans	192733 L
180	5,2-6,0	3.5	55	30		0	Giben	192737 S
180	4,45-5,25	3.2	45	36		8	Holzma	192734 L
180	4,85-5,65	3.5	45	36		8	Holzma Typ 11	192736 L
180	4,45-5,25	3.2	50	44	3/13/80	10	Giben Smart	192735 L
200	4,35-5,15	6.0	20	24	2/11/66	8	Schelling	192739 L
200	5,0-5,8	3.5	20	34	2/11/66	8	Schelling	192747 S
200	4,85-5,65	3.5	20	34	2/11/66	8	Schelling FH 8	192744 L
200	4,45-5,25	3.5	20	36	2/11/66	8	Schelling	192740 L
200	4,45-5,25	3.2	30	36	2/10/60	8	S.M.A., Panhans, Scheer	192741 L
200	4,85-5,65	3.5	45	36		8	Holzma	192745 L
200	5,9-6,6	4.0	45	36		8	Holzma	192748 L
200	4,4-5,2	3.2	50	42	3/13/80 + 2/7/80	8	Giben Smart	192742 L
[mm]	[mm]	[mm]	[mm]			[°]		

Ø D	B	b	Ø d	Z	NL	Hook angle		Ident-No.
200	4,45-5,25	3.2	65	36	2/9/100 + 2/9/110	8	Selco	192743 L
200	4,85-5,65	3.5	65	36	2/9/110	8	Selco WN / EB	192746 L
200	3,65-4,45	2.5	65	36	2/9/100 + 2/9/110	0	Biesse, Selco	193306 L
215	4,45-5,25	3.2	50	42	3/15/80 + 2/7/80	8	Giben Prismatic + Starmatic	192749 L
280	4,85-5,65	3.5	45	72		8	Holzma	192750 L
300	4,45-5,25	3.2	30	48	2/11/73 + 2/13/94	8	Schelling FX-H 430	192751 L
300	4,45-5,25	3.2	50	48	3/15/80	8	Giben Prismatic	192752 L
300	4,45-5,25	3.2	65	48	2/8,4/100 + 2/8,4/110	8	Selco EB	192753 L
300	4,45-5,25	3.2	80	48	2/14/110	8	Gabbiani	80505097 L
[mm]	[mm]	[mm]	[mm]			[°]		

Suitable for Panel Sizing Saw Blades Q-Cut G5 + Q-Cut TR-F K

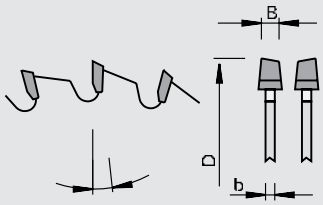
Ø D	B	b	Ø d	Z	NL	Hook angle		Ident-No.
180	4,05-4,85	3.2	20	36		0	Schelling, Anton	192754 S
180	4,05-4,85	3.2	30	36	2/10/60	0	Panhans	192755 S
180	4,05-4,85	3.2	45	36		0	Holzma	192756 L
180	4,05-4,85	3.2	50	36	3/13/80	0	Giben Smart	192757 O
200	4,05-4,85	3.2	20	36	2/11/66	0	Schelling	192758 L
200	4,05-4,85	3.2	30	36	2/10/60	0	S.M.A., Panhans, Scheer	192759 O
200	4,05-4,85	3.2	45	36		0	Holzma	192760 L
200	4,05-4,85	3.2	50	36	3/13/80	0	Giben Smart	192761 O
200	4,05-4,85	3.2	65	36	2/9/100 + 2/9/110	0	Selco	192762 O
[mm]	[mm]	[mm]	[mm]			[°]		

105390

Scoring Saw Blades HW “KO-WS” - LowNoise

Product

Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application
- Table saws
- Panel sizing saws
- Panel sizing saws with controllable scoring device
- for scoring of plastic-laminated panels

Design
- vibration and noise damping ornaments
- tooth configuration: conical / alternate top bevel “KO-WS”
- cutting material: HW HL Board 04 plus

Advantages
- Very quiet when idling and during operation
- Robust tool body thanks to a new design and a thicker tool body

Notes
- height adjustable to kerf of main saw blade
- 1 mm scoring depth = 0.21 mm cutting width
- optimum scoring depth 1.0 - 2.0 mm

Ø D	B	b	Ø d	Z	Hook angle		Ident-No.
120	3,0-3,8	2.5	20	24	8	SCM	193362 L
120	3,0-3,8	2.5	22	24	8	Altendorf, Martin	193363 L
125	3,0-3,8	2.5	20	24	8		193364 L
125	3,0-3,8	2.5	22	24	8	Altendorf, Martin	193365 L
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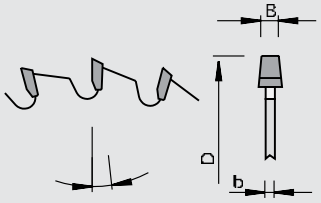
105390

Scoring Saw Blades HW “KO-F”

Product

Drawing



Tungsten Carbide [HW]

Machine / Application
- panel sizing saws with scoring device
- for scoring of plastic-laminated panels

Design
- tooth configuration: conical-flat “KO-F”
- cutting material: HW HL Board 04 plus

Advantages
- quick adjustment
- universally applicable
- optimum cutting quality thanks to improved runout accuracy
- reduction of the scoring depth

Notes
- height adjustable to kerf of main saw blade
- 1 mm scoring depth = 0.17 mm cutting width
- optimum scoring depth 1.0 - 2.0 mm

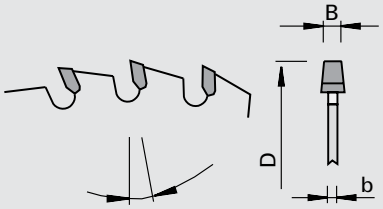
Ø D	B	b	Ø d	Z	NL	Hook angle		Ident-No.
180	6,7-7,5	4.4	20	30		8	Anthon	192713 S
200	6,7-7,5	4.4	20	34	2/11/66	8	Schelling	192714 L
220	6,7-7,5	4.4	20	36	2/11/66	8	Schelling FS-H / AS-H	192716 L
220	3,25-4,0	2.4	45	60		8	Holzma HPS 320	192715 L
[mm]	[mm]	[mm]	[mm]			[°]		

105390

Scoring Saw Blades HW “KO-F” - LowNoise

Product

Drawing



Tungsten Carbide [HW]

Machine / Application
- Table saws
- Panel sizing saws
- Panel sizing saws with controllable scoring device
- for scoring of plastic-laminated panels

Design
- vibration and noise damping ornaments
- tooth configuration: conical-flat “KO-F”
- cutting material: HW HL Board 04 plus

Advantages
- Very quiet when idling and during operation
- Robust tool body thanks to a new design and a thicker tool body

Notes
- height adjustable to kerf of main saw blade
- 1 mm scoring depth = 0.21 mm cutting width
- optimum scoring depth 1.0 - 2.0 mm

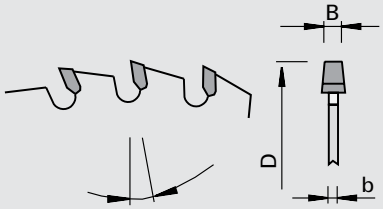
Ø D	B	b	Ø d	Z	Hook angle		Ident-No.
120	3,0-3,8	2.5	20	24	8	SCM	193366 L
120	3,0-3,8	2.5	22	24	8	Altendorf, Martin	193367 L
125	3,0-3,8	2.5	20	24	8	SCM	193368 L
125	3,0-3,8	2.5	22	24	8	Altendorf, Martin	193369 L
[mm]	[mm]	[mm]	[mm]		[°]		

105399

Scoring Saw Blades HW “KO-F” - nn-System

Product

Drawing



LEUCO nn system

LEUCO DUR

Tungsten Carbide [HW]

NO

Machine / Application

- panel sizing saws with scoring device
- for scoring of plastic-laminated panels

Design

- special NoNoise gullet geometry
- tooth configuration: conical-flat “KO-F”
- cutting material: HW HL Board 04 plus

Advantages

- quick adjustment
- universally applicable
- optimum cutting quality thanks to improved runout accuracy
- reduction of the scoring depth
- especially low noise level
- noise reduction by approx. 6 dB(A) when idling
- excellent cutting quality in all common coatings
- long edge lives provide for the necessary productivity and economic efficiency

Notes

- height adjustable to kerf of main saw blade
- 1 mm scoring depth = 0.21 mm cutting width
- optimum scoring depth 1.0 - 2.0 mm

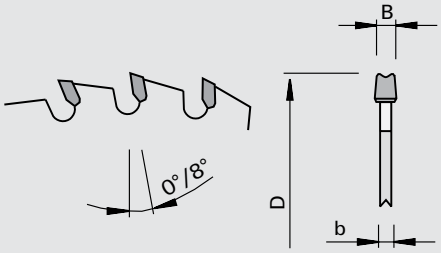
Ø D	B	b	Ø d	Z	NL	Hook angle		Ident-No.
120	3,1-3,9	2.5	20	24		8	SCM	192970 L
120	3,1-3,9	2.5	22	24		8	Altendorf, Martin	192971 L
150	4,45-5,25	3.2	45	28		8	Holzma Typ 130	192699 L
150	4,45-5,25	3.2	45	36		8	Homag Espana, Homag SAWTEC B-130	193309 L
180	4,45-5,25	3.2	30	36	2/10/60	8	HOLZ-HER	192700 L
180	4,45-5,25	3.2	45	36		8	Holzma	192701 L
180	4,85-5,65	3.5	45	36		8	Holzma Typ 11	192702 L
200	4,45-5,25	3.5	20	36	2/11/66	8	Schelling	192703 L
200	4,45-5,25	3.0	45	36		8	Homag Sawtech	192704 L
200	4,85-5,65	3.5	45	36		8	Holzma	192705 L
200	4,45-5,25	3.2	65	36	2/9/100 + 2/9/110	8	Selco	192706 L
200	4,45-5,25	3.5	80	36	2/14/110	8	SCM	192707 L
200	4,85-5,65	3.5	80	36	2/14/110	8	SCM	192708 L
200	3,2-4,0	2.2	30	60		15	Scheer	192709 L
250	4,45-5,25	3.5	30	42	2/10/60	8	Panhans, HOLZ-HER	192710 L
280	4,45-5,25	3.2	30	48	2/10/60 + 2/11/66	8	HOLZ-HER	192711 L
[mm]	[mm]	[mm]	[mm]			[°]		

105399

Scoring Saw Blades HW “KO-HR” - nn-System

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- Panel Sizing Saw Blades with scoring device
- for chip-free scoring of plastic coated, paper laminated as well as veneered panels

Design

- special NoNoise gullet geometry
- cutting material: HW HL Board 04 plus
- tooth configuration: conical hollow back “KO-HR”

Advantages

- especially low noise level
- noise reduction by approx. 6 dB(A) when idling
- excellent cutting quality in all common coatings
- long edge lives provide for the necessary productivity and economic efficiency

Notes

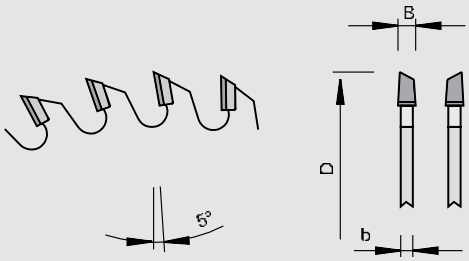
Ø D	B	b	Ø d	Z	NL	Hook angle		Ident-No.
150	4,45-5,25	3.2	20	28		8	Format 4 Kappa Automatic classic	80496548 L
150	4,45-5,25	3.2	30	28		8	Format 4 Kappa Automatic 80	193219 L
150	4,05-4,85	3.2	45	28		8	Homag Espana, Homag SAWTEC B-130	193408 L
150	4,45-5,25	3.2	45	36		8	Homag Espana, Homag SAWTEC B-130	193311 L
160	4,45-5,25	3.2	45	28	3/11/70	8	Giben Prismatic	192686 S
180	4,45-5,25	3.2	30	30	2/10/60	8	Panhans	192687 L
180	4,05-4,85	3.2	45	36		0	Holzma	192688 L
180	4,45-5,25	3.2	45	36		8	Holzma	192689 L
180	4,85-5,65	3.5	45	36	2/9/110	8	Holzma Typ 11	192690 L
200	4,45-5,25	3.5	20	36	2/11/66	8	Schelling	192691 L
200	4,45-5,25	3.2	30	36	2/10/60	8	S.M.A., Panhans, Scheer	192692 L
200	4,05-4,85	3.2	45	36		0	Holzma	192693 L
200	4,45-5,25	3.2	45	36		8	Holzma	192694 L
200	4,85-5,65	3.5	45	36	2/9/110	8	Holzma	192695 L
200	4,45-5,25	3.2	65	36	2/9/100 + 2/9/110	8	Selco	192696 L
200	4,85-5,65	3.5	65	36	2/9/110	8	Selco WN/EB	192697 L
[mm]	[mm]	[mm]	[mm]			[°]		

205091

Scoring Saw Blades DP “KO-WS”

Product

Drawing



Polycrystalline diamond [DP]

Machine / Application

- table saws
- for chip-free scoring of melamine-, paper- or HPL-laminated panels

Design

- tooth configuration: conical / alternate top bevel “KO-WS”

Advantages

Notes

- application with feed
- kerf “B” = kerf of the main saw blade

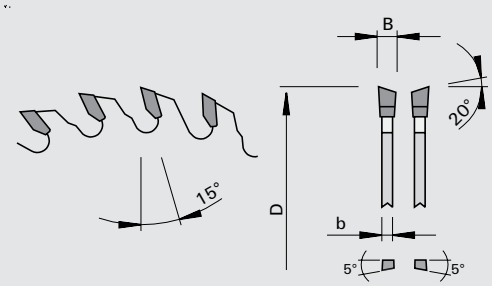
Ø D	B	b	Ø d	Z		Ident-No.
120	3,1-3,9	2.2	22	16	Altendorf, Martin	178766 L
[mm]	[mm]	[mm]	[mm]			

101320

Double Clipping Saw Blades HW with cooling slots “WSA”

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- joinery machines
- double clipping saws
- table saws
- for chop cuts (one-sided, double-sided) for precise lengths of boards, lamellas, etc.

Design

- positive hook angle
- proven asymmetric chip evacuation gap geometry and additional cooling elements
- tooth configuration: alternate top bevel with shear angle “WSA”
- cutting material: HW HL Board 10
- extremely high bending strength and hardness of the teeth

Advantages

- reduced cutting pressure thanks to alternating shear angle
- long edge lives provide for the necessary productivity and economic efficiency

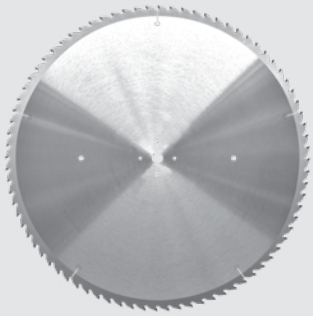
Notes

Ø D	B	b	Ø d	Z	DKN		NL	Ident-No.
350	4,0	2.6	30	54			2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	189788 L
400	4,4	3.0	30	60			2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	189789 L
450	4,4	3.0	30	72			2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	189790 L
500	4,8	3.2	30	72			2/10/80	189792 L
500	4,8	3.2	30	108			2/10/80 + 2/15/63	189794 L
500	4,0	3.2	70	108	20x6			192954 L
550	4,8	3.2	30	72			2/10/80	189795 L
630	5,4	4.0	40	72			2/10/60	189797 S
650	5,6	4.0	30	96			2/10/80 + 2/15/63 + 2/14/100	189798 L
650	5,6	4.0	30	54			2/10/80 + 2/15/63	189799 S
720	6,2	4.4	30	48		Hundegger	2/8,5/90	189800 S
735	6,2	4.4	30	48		Hundegger	2/8,5/90	189802 S
735	6,2	4.4	30	72		Hundegger	2/8,5/90	189803 S
760	6,2	4.4	30	48		Hundegger	2/14/400 + 4/8,5/90	189804 S
760	6,2	4.4	30	72		Hundegger	2/14/400 + 4/8,5/90	189805 S
800	6,2	4.4	30	48		Paul		189807 S
[mm]	[mm]	[mm]	[mm]		[mm]			

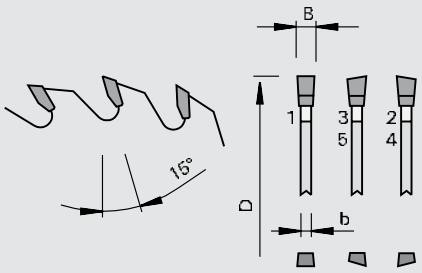
101340 / 101345

Clipping Saw Blades HW - joinery “G5”

Product



Drawing



LEUCO g5 system

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- joinery machines
- for clipping-, crosscut- and shifter cuts in solid wood

Design

- positive hook angle
- tooth configuration: “G5”
- cutting material: HW HL Board 09

Advantages

- excellent cutting quality thanks to special tooth geometry
- extremely quiet during operation due to the low cutting pressure

Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
450	4,4	3.0	30	65	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42		80481000 L
450	5,0	3.5	45	65	2/15/63		80481001 S
500	4,8	3.2	30	110	2/10/80 + 2/15/63		80481002 L
500	4,8	3.2	30	70	2/10/80 + 2/15/63		80481003 L
500	5,6	4.0	30	95	2/10/80		80481004 L
550	4,8	3.2	30	70	2/10/80		80481006 L
550	4,8	3.2	40	70			80481007 O
600	5,4	4.0	30	70	2/10/80 + 2/13/100		80481009 S
600	5,7	4.0	30	95	2/11/60 + 2/13/100		80481010 L
600	5,4	3.8	40	70			80481011 S
650	5,6	4.0	30	95	2/15/63 + 2/10/80 + 2/14/100		80481013 S
650	6,2	4.0	30	60		Krüsi	80481014 S
700	6,0	4.2	30	80	2/11/60 + 2/13/100		80481015 S
720	6,2	4.4	30	70	2/8,5/90	Hundegger	80481016 S
750	6,5	4.5	30	60	2/10,5/60		80481018 S
750	7,0	4.8	60	120		Springer	80481019 S
760	6,2	4.4	30	95	4/8,5/90 + 2/14/400	Hundegger	80481020 S
800	6,5	5.0	30	80	4/9/90 + 2/14/400 + 8/9/160	Hundegger	193097 L
[mm]	[mm]	[mm]	[mm]				

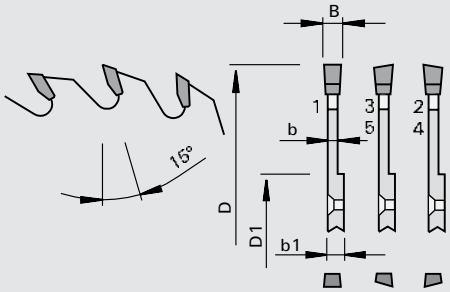
Ø D	B	b	Ø d	Z	NL		Ident-No.
500	4,2	2.8	30	35+2+2		Krüsi	80481005 L
550	4,6	3.2	30	35+2+2+2		Krüsi	80481008 S
640	5,4	3.6	30	40+2+2		Mafell	80481012 S
750	6,5	4.5	40	50+2+2	2/10,5/60	Krüsi, Schneider	80481017 S
[mm]	[mm]	[mm]	[mm]				

101347

Clipping Saw Blades HW with cooling slots - crosscut- and shifter cuts “G5”

Product

Drawing



LEUCO G5 system

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application
- joinery machines
- for clipping-, crosscut- and shifter cuts in solid wood

Design
- positive hook angle
- with cooling elements
- tooth configuration: “G5”
- cutting material: HW HL Board 20

Advantages
- excellent cutting quality thanks to special tooth geometry
- extremely quiet during operation due to the low cutting pressure

Notes

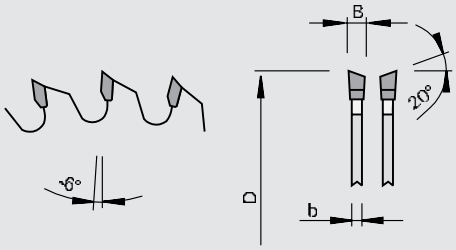
Ø D	B	b	b1	Ø D1	Ø d	Z	NL		Ident-No.
555	5,2	3.6	6.0	115	55	70	6/6,6/75	Weinmann	193220 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]				

101322

Clipping Saw Blades HW “WS”

Product

Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application
- chop and cross-cutting saws
- for cross cuts in solid woods

Design
- negative hook angle
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Solid 15

Advantages

Notes

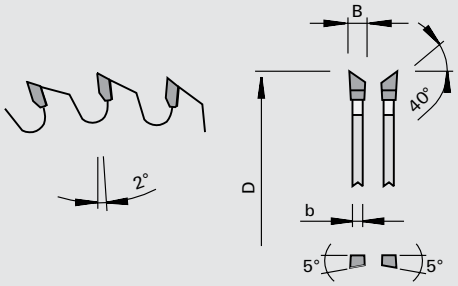
Ø D	B	b	Ø d	Z	Ident-No.
450	4,4	3.2	30	54	188045 L
500	4,4	3.2	30	60	188046 L
[mm]	[mm]	[mm]	[mm]		

101322

Clipping Saw Blades HW for wood optimization “WSA”

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- optimizing chop saws
- undertable cross-cut saws
- push-feed saws
- through-feed saws
- for cross cuts in solid woods

Design

- positive hook angle
- tooth configuration: alternate top bevel with shear angle “WSA”
- cutting material: HW HL Board 06
- extremely high bending strength and hardness of the teeth

Advantages

- reduced cutting pressure thanks to alternating shear angle
- long edge lives provide for the necessary productivity and economic efficiency

Notes

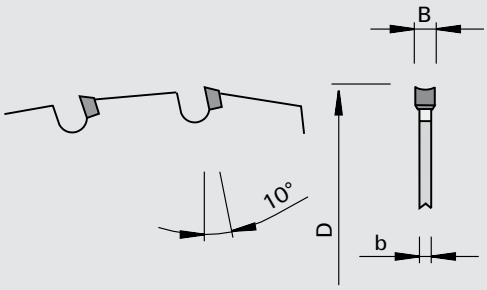
Ø D	B	b	Ø d	Z	NL		Ident-No.
400	3,4	2.8	30	120	2/10/60	DIMTER QUANTUM	189896 L
400	4,6	3.5	30	120	2/10/60	DIMTER	189833 L
450	4,6	3.5	30	132	2/15/63	DIMTER	189834 L
500	4,6	3.5	30	144	2/15/63	DIMTER	189835 L
520	4,6	3.5	30	144	2/15/63		189836 L
600	5,2	3.8	30	172	2/15/63	DIMTER	189838 L
630	5,4	4.0	30	180	2/15/63		189839 L
[mm]	[mm]	[mm]	[mm]				

206289

Chop Saw Blades DP “HR” - nn-System DP flex

Product

Drawing



LEUCO nn system

DP FLEX

Polycrystalline diamond [DP]

NO

Machine / Application

- CNC machining centers and aggregates
- for precise cutting in all common wood-based panels such as raw and laminated particle and MDF boards, plywood boards, HDF, WPC, cement and gypsum fiber boards, mineral composites, Alucobond, ...
- for ripping and cross cuts in solid wood, glued laminated timber, thermotreated wood

Design

- resharpenable up to 2 times
- small gullets
- special cutting edge geometry
- tooth configuration: hollow back tooth “HR”
- cutting material: DP

Advantages

- hardly perceivable noise level
- highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping
- reduced cutting pressure thanks to hollow back tooth geometry

Notes

- it is not recommended to use the saw blades for longitudinal cuts in soft wood and material thicknesses of more than 40 mm
- chip-free cuts can only be guaranteed in combination with a suitable scoring saw blade

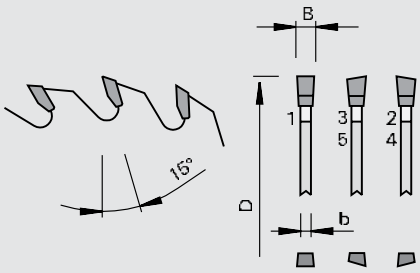
Ø D	B	b	Ø d	Z	NL		Ident-No.	
180	2,5	2.0	30	36	2 x 4/6/52	Homag, Weeke	192432	L
180	2,5	2.0	40	36	8/6/52	Homag, Weeke	193319	L
200	2,5	2.0	30	40	2 x 4/6/52	Homag	192433	L
200	2,5	2.0	30	40	2/6,2/42 + 4/6,6/60	IMA	192434	L
220	2,5	2.0	30	44			192435	L
220	2,5	2.0	40	44	8/6/52	Homag, Weeke	192436	L
225	2,5	2.0	30	44	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	Festool CS 70	80510737	L
240	2,5	2.0	30	50	2 x 4/6/52	Homag	192437	L
240	2,5	2.0	40	50	8/6/52	Homag, Weeke	192438	L
240	2,5	2.0	30	50	2/6,2/42 + 4/6,6/60	IMA	192439	L
[mm]	[mm]	[mm]	[mm]					

102348

Clipping Saw Blades HW “G5”

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- CNC machining centers and aggregates
- for chip-free sizing cuts as well as clipping and mitre cuts in wood-based panels, solid woods and plastics

Design

- tooth configuration: G5
- cutting material: HW HL Board 04 plus

Advantages

- excellent cutting quality for cross cuts
- excellent cutting quality thanks to special tooth geometry
- extremely long edge lives
- noise reduction thanks to laser ornaments

Notes

- pay attention to nmax!!!

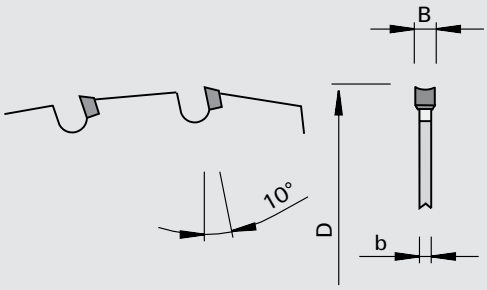
Ø D	B	b	Ø d	Z	NL		Ident-No.
180	3,0	2.2	30	60	2 x 4/6/52	Homag, Weeke	192804 L
180	3,0	2.2	40	60	8/6/52	Homag, Weeke	192805 L
200	3,0	2.2	30	65	2 x 4/6/52	Homag	192806 L
200	3,0	2.2	30	65	2/6,2/42 + 4/6,6/60	IMA	192807 O
220	3,0	2.2	40	70	8/6/52	Homag, Weeke	192808 L
240	3,0	2.2	30	75	2 x 4/6/52	Homag	192809 L
240	3,0	2.2	40	75	8/6/52	Homag, Weeke	192810 L
240	3,0	2.2	30	75	2/6,2/42 + 4/6,6/60	IMA	192811 O
280	3,0	2.2	30	85	2 x 4/6/52	Homag	192812 O
350	3,0	2.2	30	100	8/5,2/90	Homag	80429837 L
[mm]	[mm]	[mm]	[mm]				

206289

Clipping Saw Blades DP for edge trimming “HR” - nn-System DP flex

Product

Drawing



LEUCO nn system

DP FLEX

Polycrystalline diamond [DP]

NO

Machine / Application

- edge banders
- for trimming of plastic-, veneer- and solid wood edges

Design

- small gullets
- special cutting edge geometry
- tooth configuration: hollow back tooth “HR”
- cutting material: DP
- resharpenable up to 2 times

Advantages

- hardly perceivable noise level
- highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping
- reduced cutting pressure thanks to hollow back tooth geometry

Notes

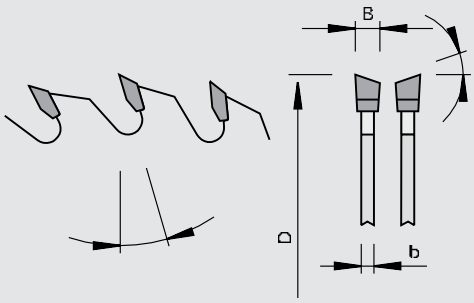
Ø D	B	b	Ø d	Z	NL		Ident-No.
100	2,5	2.0	22	20	2/4/30	Altendorf (EBM/Hebrock), Felder, Lohmeyer	192543 L
100	2,5	2.0	32	30		Homag (Brandt)	192544 C
110	2,5	2.0	22	24		Reich	192551 C
110	2,5	2.0	22	20		Reich	192552 C
120	2,5	2.0	40	24	8/6/52	Homag	192541 C
120	2,5	2.0	40	36	2x4/5,5/52	Homag	192553 C
125	2,5	2.0	30	36	2x4/6,5/48	Homag BAZ	192554 C
125	2,5	2.0	40	24	2x4/5,8/60	Homag (Brandt)	192549 C
140	2,5	2.0	16	36		Ott	192545 C
160	2,5	2.0	22	36		IMA	192546 L
160	2,5	2.0	22	48		IMA	192547 C
160	2,5	2.0	30	24	2/7/42	HOLZ-HER	192555 C
170	2,5	2.0	30	36	4/5,5/52	Homag	192542 L
180	2,5	2.0	22	42		IMA	192550 C
180	2,5	2.0	30	54	4/6/52	Homag BAZ	192556 L
200	2,5	2.0	30	64	4/6,6/60 + 2/6,2/42	IMA	192548 C
[mm]	[mm]	[mm]	[mm]				

106320

Clipping Saw Blades HW for edge trimming “WS” - without countersink

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- edge banders
- edge trimming machines
- for trimming of plastic-, veneer- and solid wood edges

Design

- positive or negative hook angle
- with or without shear angle
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 06

Advantages

Notes

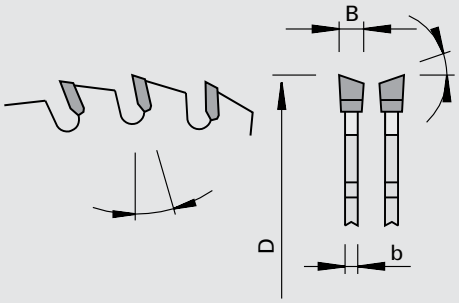
Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁	Shear◁		Ident-No.
120	3,2	2.5	22	20		10	15	0	HolzHer	80446083 L
125	2,4	1.6	32	24		15	30	0	Homag (Brandt)	192900 L
160	3,5	2.5	22	36		-5	15	5	IMA	188662 L
180	3,5	2.5	22	42		-6	15	5	IMA	189996 L
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]		

106329

Clipping Saw Blades HW for edge trimming “WS” - nn-System without countersink

Product

Drawing



LEUCO nn system

LEUCO DUR

Tungsten Carbide [HW]

NO

Machine / Application

- edge banders
- edge trimming machines
- for trimming of plastic-, veneer- and solid wood edges

Design

- special NoNoise gullet geometry
- positive or negative hook angle
- with or without shear angle
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 06

Advantages

- especially low noise level
- noise reduction by approx. 6 dB(A) when idling

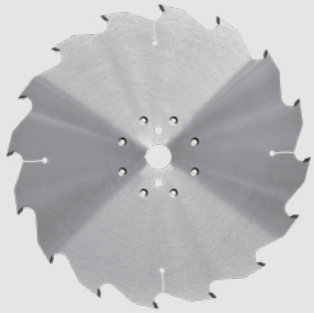
Notes

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁	Shear◁		Ident-No.	
90	3,0	2.0	30	20		8	10	0	Reich	192471	S
100	2,4	1.6	22	12		15	10	5	HOLZ-HER	192472	L
100	2,4	1.6	22	20	2/4/30	-8	10	5	Altendorf (EBM/Hebrock)	193352	L
100	2,4	1.6	22	30	2/4/30	-8	10	5	Altendorf (EBM/Hebrock)	80465377	L
100	3,6	2.2	32	20		8	30	5	Wilmsmeyer	192474	S
100	3,2	2.2	22	20		8	15	0	Felder	192475	L
100	2,4	1.4	22	30		10	15	0	Altendorf (EBM/Hebrock)	80484044	L
100	2,6	1.6	32	30		10	15	5	Homag (Brandt)	192476	L
104	3,0	2.0	22	30		10	15	0	KDT	193353	L
105	3,2	2.5	22	24		10	20	0	Nanxing	80493920	L
110	3,6	2.5	22	20		8	30	5	HOLZ-HER, Reich	192477	L
110	3,6	2.5	32	20		8	30	5	Homag	192478	L
115	3,2	2.2	30	30		10	30	0	SCM Olimpic	80443014	L
115	3,2	2.2	56	30	3/7,1/68 + 3/7,1/68	15	15	0	Biesse Akron 400	192482	S
120	3,2	2.2	32	20		10	10	5	Homag	192483	L
140	3,2	2.2	16	36		10	15	5	Ott	192489	L
140	3,2	2.2	22	36		10	15	5	HOLZ-HER	192488	L
150	3,2	2.2	22	48		10	10	5	IMA	192493	L
160	3,0	2.5	22	36		-5	15	0	IMA	192456	L
160	3,2	2.2	20	48	2/5/32	10	10	5	HOLZ-HER	192497	L
160	3,2	2.2	22	48		-8	10	5	IMA	192498	L
160	3,2	2.2	30	24	2/7/42	15	10	5	HOLZ-HER	192495	L
160	3,2	2.2	40	30	4/5,5/52	-8	20	10	HOLZ-HER	192496	S
170	3,2	2.2	30	36	4/5,5/52	10	20	0	Homag	193354	L
200	3,2	2.2	30	64	4/6,6/60 + 2/6,2/42	10	15	0	IMA	192501	L
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]			

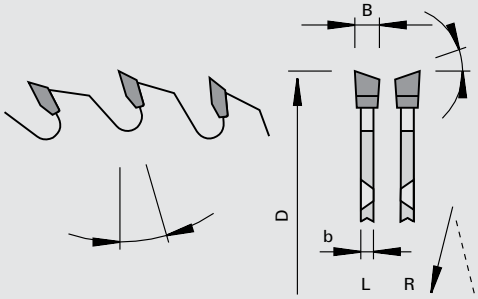
106320

Clipping Saw Blades HW for edge trimming “WS” - with countersink

Product



Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

Machine / Application

- edge trimming machines
- for trimming of plastic-, veneer- and solid wood edges

Design

- positive hook angle
- with or without shear angle
- pin holes with countersink
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 06

Advantages

Notes

- Ident-No. 189259 NL=2/10/60 have no countersink
- sense of rotation according to VDMA 8849

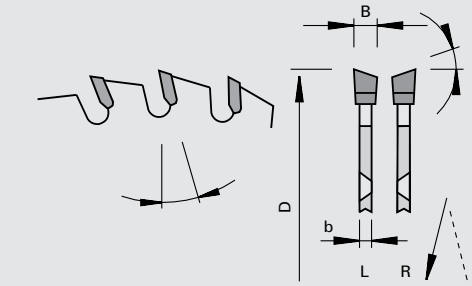
Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁	Shear◁			Ident-No.
350	3,6	2.5	30	16	2/10/60 + 8/6/90	20	10	0	Homag BAZ	R	189259 L
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]			

106329

Clipping Saw Blades HW for edge trimming “WS” - nn-System, with countersink

Product

Drawing



LEUCO nn system

LEUCO DUR

Tungsten Carbide [HW]

NO

Machine / Application

- edge trimming machines
- for trimming of plastic-, veneer- and solid wood edges

Design

- special NoNoise gullet geometry
- positive hook angle
- with or without shear angle
- pin holes with countersink
- tooth configuration: alternate top bevel “WS”
- cutting material: HW HL Board 06

Advantages

- especially low noise level
- noise reduction by approx. 6 dB(A) when idling

Notes

- Ident-No. 192494 NL=4/5,5/52 have no countersink
- sense of rotation according to VDMA 8849

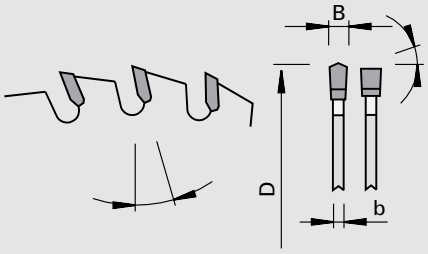
Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁	Shear◁			Ident-No.
110	3,2	2.5	40	20	4/5,5/52	10	45	5	Homag	L	192480 L
110	3,2	2.5	40	20	4/5,5/52	10	45	5	Homag	R	192479 L
110	3,2	2.2	40	30	4/6/52	10	45	0	Homag BAZ	R	192481 S
120	3,6	2.8	40	24	2x4/6/52	8	30	0	Homag	N	189751 L
120	3,2	2.5	40	36	2x4/5,5/52	10	45	5	Homag	N	192484 L
120	3,6	2.8	40	36	2x4/6/52	12	20	0	Homag	N	192485 S
125	2,4	1.6	40	24	2x4/5,8/60	15	30	0	Homag (Brandt)	N	192486 L
125	2,4	1.6	30	36	2x4/6,5/48	10	30	0	Homag BAZ	N	192487 L
140	3,2	2.2	30	36	4/8,6/46	10	15	5	Biesse Akron 600/800	L	192491 O
140	3,2	2.2	30	36	4/8,6/46	10	15	5	Biesse Akron 600/800	R	192490 O
150	3,2	2.2	30	48	4/6/48 + 4/5,5/52	10	15	0	Homag BAZ	R	192494 S
180	3,2	2.2	30	54	4/6/52	10	30	5	Homag BAZ	L	192500 L
240	3,5	2.2	30	54	8/6,1/52	10	20	0	Homag BAZ	L	192502 S
240	3,5	2.2	40	54	8/6,1/52	10	20	0	Homag BAZ Flex 5, Weeke	L	192503 S
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]			

106379

Clipping Saw Blades HW for edge trimming “TR-F” - nn-System

Product

Drawing



Tungsten Carbide [HW]

Machine / Application
- edge banders
- edge trimming machines
- for trimming of plastic-, veneer- and solid wood edges

Design
- special NoNoise gullet geometry
- without shear angle
- positive hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 06, HL Board 04 plus

Advantages
- especially low noise level
- noise reduction by approx. 6 dB(A) when idling

Notes

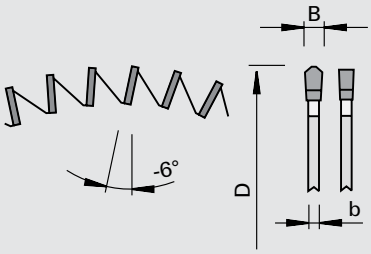
Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁		Ident-No.
110	1,7	1.2	40	30	4/6/52	10	45	Homag BAZ	192504 L
110	2,4	1.8	40	30	4/6/52	10	45	Homag BAZ	80505482 L
[mm]	[mm]	[mm]	[mm]			[°]	[°]		

106370

Clipping Saw Blades HW for edge trimming “TR-F”

Product

Drawing



Tungsten Carbide [HW]

Machine / Application
- edge banders
- edge trimming machines
- for trimming of plastic-, veneer- and solid wood edges

Design
- without shear angle
- negative hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 10

Advantages

Notes

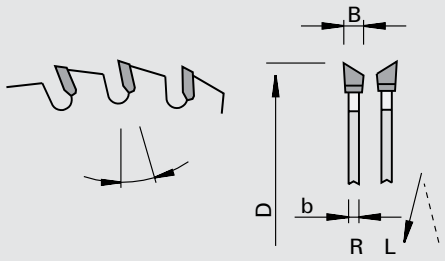
Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁		Ident-No.
140	2,2	2.0	52	70	4/5,5/65	-6	45	IMA	192998 L
[mm]	[mm]	[mm]	[mm]			[°]	[°]		

106359

Clipping Saw Blades HW for edge trimming “ES” - nn-System, without countersink

Product

Drawing



LEUCO nn system

LEUCO DUR

Tungsten Carbide [HW]

NO

Machine / Application

- edge banders
- edge trimming machines
- for trimming of thin plastic-, veneer- and solid wood edges

Design

- special NoNoise gullet geometry
- positive or negative hook angle
- with and without shear angle
- tooth configuration: top bevel “ES (right + left)”
- cutting material: HW HL Board 06

Advantages

- especially low noise level
- noise reduction by approx. 6 dB(A) when idling

Notes

- sense of rotation see drawing

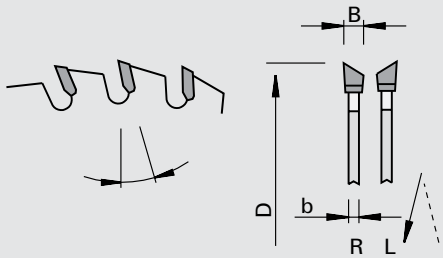
Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁	Shear◁		Ident-No. [L]	Ident-No. [R]
100	3,2	2.2	32	20		-6	30	5	Homag	192507 S	192508 S
100	3,0	2.2	32	20		8	30	5	Wilmsmeyer	192505 L	192506 L
100	2,4	1.6	22	30		-8	10	5	Altendorf (EBM/Hebrock)	80489950 L	80489949 L
100	2,6	2.0	32	30		-10	15	0	Homag (Brandt)	192510 L	192509 L
100	2,6	2.0	32	30		10	15	0	Homag CN	192514 S	192513 S
100	2,6	1.6	32	30		10	10	0	Homag (Brandt)	192511 L	192512 L
125	2,6	1.6	32	30		-8	15	0	Homag (Brandt)	80493154 L	80493155 L
150	3,5	2.2	22	30		-6	15	5	IMA	192521 S	192522 S
150	3,5	2.2	30	30		12	15	5	SCM-IDM	192519 S	192520 S
150	3,5	2.2	30	44	4/5,5/52	-12	45	10	Homag Powerline	192524 L	192523 L
160	3,6	2.5	40	18		8	30	0	HOLZ-HER	192525 S	192526 S
170	3,5	2.2	30	48	4/5,5/52	-12	45	10	Homag Powerline	192528 L	192527 L
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]			

106359

Clipping Saw Blades HW for edge trimming “ES” - nn-System, with countersink

Product

Drawing



LEUCO nn system

LEUCO DUR

Tungsten Carbide [HW]

NO

Machine / Application

- edge banders
- edge trimming machines
- for trimming of thin plastic-, veneer- and solid wood edges

Design

- special NoNoise gullet geometry
- positive or negative hook angle
- with and without shear angle
- pin holes with countersink
- tooth configuration: top bevel “ES (right + left)”
- cutting material: HW HL Board 06

Advantages

- especially low noise level
- noise reduction by approx. 6 dB(A) when idling

Notes

- sense of rotation see drawing

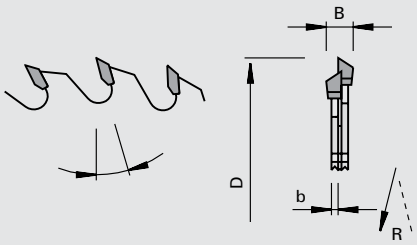
Ø D	B	b	Ø d	Z	NL	Hook angle	Corner◁	Shear◁		Ident-No. [L]	Ident-No. [R]
110	3,2	2.5	40	20	4/6/52	-6	45	5	Homag	192515 S	192516 L
120	3,2	2.5	40	20	4/6/52	-6	45	5	Homag	192517 L	192518 L
130	3,6	2.8	30	20+4	4/7,4/46	10	30	0	Biesse	192530 L	192529 L
140	3,6	2.8	30	20+2	4/7,4/46	-20	30	0	Biesse	192532 S	192531 S
150	3,8	2.5	35	24+6	4/6/50	10	15	0	SCM-Stefani	192534 L	192533 L
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]			

106354

Clipping Saw Blades HW for edge trimming - adjustable “ES”

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- edge banders
- edge trimming machines Homag (Brandt), Raimann, Reich, Ott, SCM-Stefani
- for trimming and chamfering of plastic-, veneer- and solid wood edges

Design

- positive hook angle
- L - left hand bevel “ES-L” / R - right hand bevel “ES-R”
- cutting material: HW HL Board 06

Advantages

Notes

- LEUCODUR HW
- sense of rotation see drawing

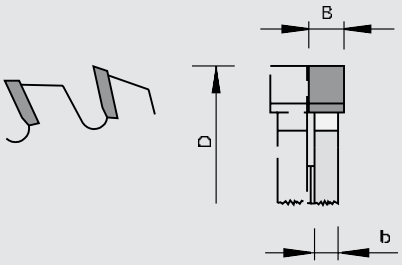
Ø D	B	b	Ø d	Z	NL	Hook angle	Shear◁		Ident-No. [L]	Ident-No. [R]
100	5,8	2.2	32	2x20		8	5		169980 S	169983 S
125	6,2	2.0	30	2x20	2/3,1/42	10	0	SCM-Stefani	189329 L	189332 L
[mm]	[mm]	[mm]	[mm]			[°]	[°]			

109015

Grooving Saw Blades HW - MAN

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- table shapers
- for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

- Application against feed along the grain (solid wood)
- Application with feed only with mechanical feed (wood-based materials)
- other groove widths possible by set combinations, maximum total groove width 10 mm for MAN
- Groove width calculation for tool sets: sum of all "b" + HW overlap left and right + spacer thickness

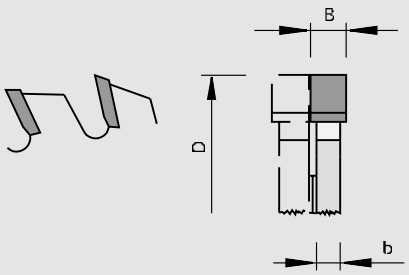
Ø D	B	b	Ø d	Z	nmin-nmax	Ident-No.
125	1,5	0.8	30	12	6100-10500	188359 L
125	1,8	1.0	30	12	6100-10500	188360 L
125	2,0	1.2	30	12	6100-10500	188361 L
125	2,2	1.2	30	12	6100-10500	188362 L
125	2,5	1.4	30	12	6100-10500	188363 L
125	3,0	2.0	30	12	6100-10500	188364 L
125	3,5	2.5	30	12	6100-10500	188365 L
125	4,0	2.5	30	12	6100-10500	188366 L
125	4,5	3.0	30	12	6100-10500	188367 L
125	5,0	4.0	30	12	6100-10500	188368 L
125	6,0	4.0	30	12	6100-10500	188369 L
125	7,0	5.0	30	12	6100-10500	188370 L
125	8,0	5.0	30	12	6100-10500	188371 L
125	10	6.0	30	12	6100-10500	188372 L
150	1,5	0.8	30	12	5200-8800	188373 L
150	2,0	1.2	30	12	5200-8800	188375 L
150	2,2	1.2	30	12	5200-8800	188376 L
150	2,5	1.5	30	12	5200-8800	188377 L
150	3,0	2.0	30	12	5200-8800	188378 L
150	3,5	2.5	30	12	5200-8800	188379 L
150	4,0	3.0	30	12	5200-8800	188380 L
150	4,5	3.5	30	12	5200-8800	188381 L
150	5,0	4.0	30	12	5200-8800	188382 L
150	6,0	4.0	30	12	5200-8800	188383 L
150	7,0	5.0	30	12	5200-8800	188384 L
150	8,0	5.0	30	12	5200-8800	188385 L
150	9,0	6.0	30	12	5200-8800	188386 L
150	10	6.0	30	12	5200-8800	188387 L
[mm]	[mm]	[mm]	[mm]		[min-1]	

109010

Grooving Saw Blades HW

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- molders
- double end tenoners
- for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

- With Z = 12 and Z = 18, other groove widths are possible by combining sets (not possible with groove circular saw blades with DKN).
- Groove width calculation for tool sets: Sum of all "b" + HW projection left and right + spacer thickness

Ø D	B	b	Ø d	Z	DKN	nmax	NL	Ident-No.
150	4,0	3.0	30	12		12700		160802 L
150	5,0	4.0	30	12		12700		001434 L
150	6,0	4.0	30	12		12700		161617 L
150	7,0	5.0	30	12		12700		161619 L
150	8,0	5.0	30	12		12700		161620 L
150	10	6.0	30	12		12700		161622 L
150	5,0	4.0	35	12	10x4	12700		001435 O
150	10	6.0	35	12	10x4	12700		161623 O
150	1,5	0.8	35	18	10x4	10200		001447 L
150	1,8	1.0	35	18	10x4	10200		001448 L
150	2,0	1.2	35	18	10x4	10200		001449 L
150	2,2	1.2	35	18	10x4	10200		001450 S
150	2,5	1.5	35	18	10x4	10200		001451 L
150	3,0	2.0	35	18	10x4	12700		001452 L
150	4,0	3.0	35	18	10x4	12700		001453 L
150	5,0	4.0	35	18	10x4	12700		001454 L
150	6,0	4.0	35	18	10x4	12700		161627 L
150	8,0	5.0	35	18	10x4	12700		161628 L
150	4,0	3.0	30	24		12700		169689 L
150	5,0	4.0	30	24		12700		169688 L
150	6,0	4.0	30	24		12700		169687 L
150	4,0	3.0	30	48 WS		12700		160804 L
180	4,0	3.0	30	12		10600		001442 L
180	5,0	4.0	30	12		10600		001443 L
180	6,0	4.0	30	12		10600		161624 L
180	8,0	5.0	30	12		10600		161625 L
180	10	6.0	30	12		10600		161626 L
180	4,0	3.0	30	18		10600		169685 L
180	5,0	4.0	30	18		10600		169684 L
180	8,0	5.0	30	18		10600		169683 L
180	10	6.0	30	18		10600		169682 L
180	4,0	2.8	65	24		10600	2 x 6/5,5/90	192991 L
180	3,5	2.5	65	24		10600	2 x 6/5,5/90	192990 L
180	3,0	2.2	65	24		10600	2 x 6/5,5/90	192989 S
196	6,0	5.0	30	12 WS		9500		163836 S
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]		

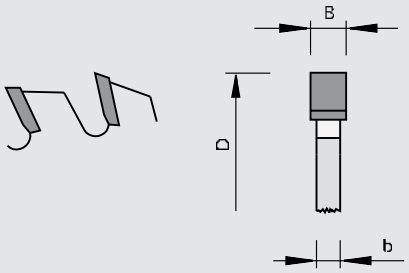
Ø D	B	b	Ø d	Z	DKN	nmax	NL	Ident-No.
200	4,0	2.8	30	24		9500		1527332 S
200	4,5	2.8	30	24		9500		1527333 O
200	5,0	2.8	30	24		9500		1527334 S
200	5,5	2.8	30	24		9500		1527335 O
200	6,0	2.8	30	24		9500		1527336 O
200	6,5	2.8	30	24		9500		1527337 O
200	7,0	5.0	30	24		9500		1527339 O
200	7,5	5.0	30	24		9500		1527340 O
200	8,0	5.0	30	24		9500		1527341 O
200	8,5	5.0	30	24		9500		1527342 O
200	9,0	5.0	30	24		9500		1527343 O
200	9,5	5.0	30	24		9500		1527344 O
200	10	5.0	30	24		9500		1527345 O
220	4,0	3.0	30	30		8700		1521934 O
220	4,5	3.0	30	30		8700		1521935 O
220	5,0	3.0	30	30		8700		1521936 O
220	5,5	3.0	30	30		8700		1521937 O
220	6,0	3.0	30	30		8700		1521938 O
220	6,5	3.0	30	30		8700		1521939 O
220	7,0	5.0	30	30		8700		1521941 O
220	7,5	5.0	30	30		8700		1521942 O
220	8,0	5.0	30	30		8700		1521943 O
220	8,5	5.0	30	30		8700		1521944 O
220	9,0	5.0	30	30		8700		1521945 O
220	9,5	5.0	30	30		8700		1521946 O
220	10	5.0	30	30		8700		1521947 O
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]		

109010

Grooving Saw Blades HW - CNC machining center

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC machining centers
- for chip-free grooving in solid woods and in wood-based panels

Design

- positive hook angle
- without shear angle
- pin holes with countersink
- tooth configuration: flat "F"
- cutting material: HW
- HL Board 06

Advantages

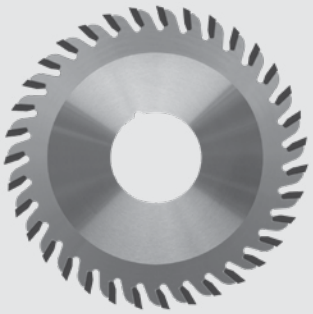
Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
100	3,2	2.2	30	20		Weeke	189571 L
100	4,0	3.0	30	20		Weeke	189647 L
100	5,0	3.0	30	20		Weeke	189260 L
120	4,0	3.0	20	30	6/4,5/35	Biesse, Felder Profit H22	80506018 L
120	4,0	3.0	35	30	4/6/50	Biesse, Felder Profit H22	189262 L
125	3,2	2.2	30	36	2x4/6,1/48	Weeke	189306 L
125	4,0	3.0	30	36	2x4/6,1/48	Weeke	189995 L
250	4,0	3.0	30	60	2/10/60		192470 L
[mm]	[mm]	[mm]	[mm]				

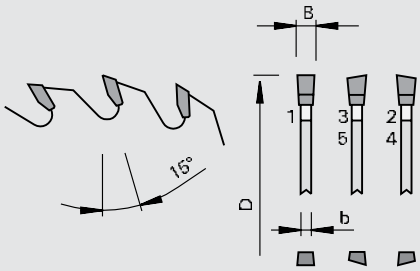
109340/122410

Grooving Saw Blades HW “G5”

Product



Drawing



LEUCO G5 system

LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- Weeke BHX series
- CNC machining centers and aggregates
- for chip-free grooving in solid woods, raw and laminated wood-based panels and plastics

Design

- tooth configuration: G5
- cutting material: HW HL Board 03, HL Board 05

Advantages

- excellent cutting qualtiy
- especially low noise level
- long edge lives also thanks to highly wear-resistant cutting material

Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
100	4,0	2.8	30	35		Weeke BHX Series 050/055	189994 L
100	5,0	4.0	30	35		Weeke BHX Series 050/055	191947 L
100	8,5	3.5	20	30		HOLZ-HER	193135 S
100	8,5	3.5	30	30	2x4/5,5/48	Weeke BHX 050 series, Homag Drillteq V200/500	193134 S
120	4,0	2.8	20	35			191948 L
120	5,0	4.0	20	35			191949 L
120	4,0	2.8	20	35	2x3/4,5/35	SCM / Morbidelli	191950 L
120	5,0	4.0	20	35	2x3/4,5/35	SCM / Morbidelli	191951 O
120	4,0	2.8	35	35	2x4/5,5/50 + 2/6/46+50	Biesse	191952 L
120	5,0	4.0	35	35	2x4/5,5/50 + 2/6/46+50	Biesse	191953 L
125	4,0	2.8	30	35	2x4/5,5/48	Weeke BHX Series 500 and other BAZ, BOF m/c and aggregates	189993 L
125	5,0	4.0	30	35	2x4/5,5/48	Weeke BHX 500 series and other machining centers and aggregates	191946 L
[mm]	[mm]	[mm]	[mm]				

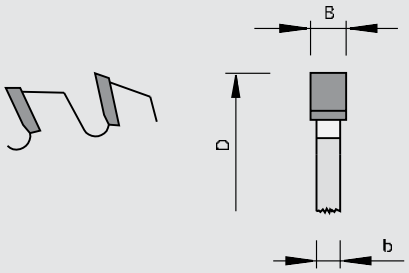
Ø D	B	b	Ø d	Z	NL		Ident-No.
100	4,0	3.2	30	35		Weeke BHX Series 050/055	193315 L
120	4,0	3.2	20	35			193316 L
125	4,0	3.2	30	35	2x4/5,5/48	Weeke BHX Series 500 and other BAZ, BOF m/c and aggregates	193317 L
125	5,0	4.2	30	35	2x4/5,5/48	Weeke BHX Series 500 and other BAZ, BOF m/c and aggregates	193318 L
[mm]	[mm]	[mm]	[mm]				

209010

Grooving Saw Blades DP - machining centers

Product

Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application
- CNC machining centers
- for chip-free grooving in solid woods and in wood-based panels

Design
- positive hook angle
- without shear angle
- pin holes with countersink
- tooth configuration: flat "F"

Advantages

Notes

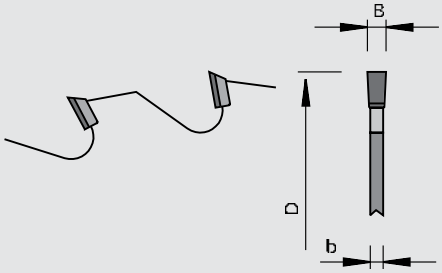
Ø D	B	b	Ø d	Z	NL		Ident-No.
125	3,2	2.2	30	36	4/6,1/48 + 4/6,1/48	Weeke	189649 C
125	4,0	3.0	30	36	4/6,1/48 + 4/6,1/48	Weeke	189648 C
[mm]	[mm]	[mm]	[mm]				

209010

Grooving Saw Blades DP

Product

Drawing



LEUCO DIA

Polycrystalline diamond [DP]

MEC

Machine / Application
- double end tenoners
- edge banding machines
- for chip-free grooving in solid woods and in wood-based panels

Design
- resharpenable area 3.5 mm
- tooth configuration: flat

Advantages

Notes
- application with feed
- number of teeth depends on the feed rate, the material to be cut and the desired cutting quality

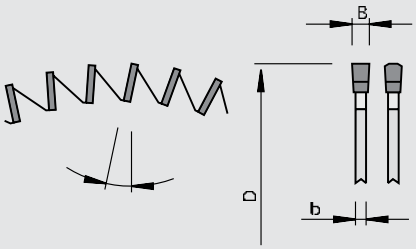
Ø D	B	b	Ø d	Z	DKN	nmax	Ident-No.
180	4,0	3.0	35	12	10x4	10000	178194 C
180	4,0	3.0	35	18	10x4	10000	178195 C
180	4,0	3.0	35	24	10x4	10000	178196 C
180	5,0	4.0	35	18	10x4	10000	178197 C
180	5,0	4.0	35	24	10x4	10000	178198 C
180	6,0	5.0	35	12	10x4	10000	178199 C
180	6,0	5.0	35	18	10x4	10000	178200 C
180	6,0	5.0	35	24	10x4	10000	178201 C
180	8,0	7.0	35	12	10x4	10000	178202 C
180	8,0	7.0	35	18	10x4	10000	178203 C
180	8,0	7.0	35	24	10x4	10000	178204 C
180	5,0	4.0	35	12	10x4	10000	178205 C
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

102370

NF-Chop Saw Blades HW “TR-F”

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- chop and miter saws
- for cross cuts in thin-walled plastic and aluminum profiles

Design

- negative hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 10

Advantages

- smooth running and no chipping of edges of the workpiece thanks to the high number of teeth

Notes

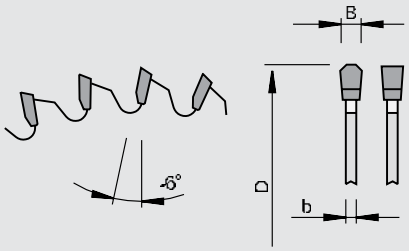
Ø D	B	b	Ø d	Z	Hook angle	Ident-No.
200	2,2	2.0	30	100	-6	188388 L
250	2,2	1.6	30	126	-6	189709 L
[mm]	[mm]	[mm]	[mm]		[°]	

108672

NF-Chop Saw Blades HW - negative hook angle “TR-F” highline

Product

Drawing



LEUCO highline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application

- chop and miter saws
- for clipping and mitre cuts in aluminum and plastic profiles

Design

- negative hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 10

Advantages

- noise-reduction thanks to laser ornaments

Notes

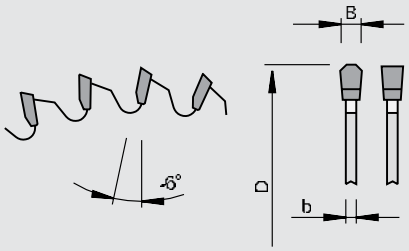
Ø D	B	b	Ø d	Z	NL		Ident-No.
250	3,2	2.5	30	60	2/7/42	DeWALT, ELU, Haffner, Makita	189846 L
250	2,8	2.2	30	80	2/7/42	ELU, Mafell, Metabo, Festo, Haffner, Hitachi	189847 L
250	3,2	2.5	30	80	2/7/42	DeWALT, ELU, Haffner, Makita	189848 L
250	3,2	2.5	32	80	2/7/42 + 2/9/46 + 2/10/60	Kaltenbach TL 250, ELU TGS 71, 171, 172, Baier, Fezer, Ulmia, Trennjäger	189849 O
275	3,2	2.5	40	88	4/12/64 + 2/9/55	Eisele LMS I new, Graule, Trennjäger, Weidmann	189850 L
300	3,2	2.5	30	72	2/7/42 + 2/10/60	DeWALT, Fezer, Schleicher	189851 L
300	3,2	2.5	32	72	2/7/42 + 2/9/46 + 2/10/60	ELU MGS 73, Rapid, Trennjäger, Fezer, Berg&Schmid	189852 O
300	2,8	2.2	30	96	2/7/42 + 2/10/60		189853 L
300	3,2	2.5	30	96	2/7/42 + 2/10/60	DeWALT, Fezer, Schleicher	189854 L
300	3,2	2.5	32	96	2/7/42 + 2/9/46 + 2/10/60	ELU MGS 73, Rapid, Trennjäger, Fezer, Berg&Schmid	189855 O
330	3,2	2.5	30	96	2/10/60 + 2/9/46 + 2/7/42	ELU, Haffner	189856 L
330	3,2	2.5	32	96	2/10/60 + 2/9/46 + 2/7/42	ELU	189857 O
[mm]	[mm]	[mm]	[mm]				

108372

NF-Chop Saw Blades HW - negative hook angle “TR-F” topline

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

- chop and miter saws
- for clipping and mitre cuts in aluminum and plastic profiles

Design

- negative hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 06

Advantages

- noise-reduction thanks to laser ornaments

Notes

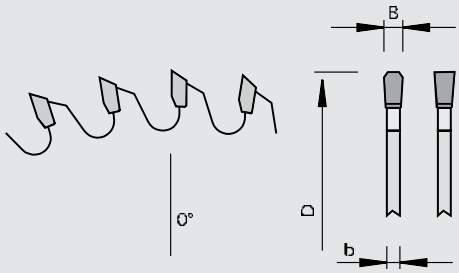
Ø D	B	b	Ø d	Z	NL		Ident-No.
350	3,8	3.2	40	84	4/12/64 + 2/9/55	Eisele LMS II, LMS II - P V, VA - L, Graule, Ulmia, Weidmann	193115 L
350	3,2	2.5	30	90	2/10/60	DeWALT, Haffner, Pfeiffer	193116 L
350	3,2	2.5	30	96	2/10/60		193117 L
350	3,2	2.5	30	108	2/9/55 + 2/10/60 + 4/12/64		193118 L
350	3,2	2.5	40	108	4/12/64 + 2/9/55	Eisele LMS II, LMS II - PV, VA - L, Graule, Ulmia, Weidmann	193119 O
400	3,8	3.2	30	96	2/12/64 + 4/15/80	DeWALT, Haffner	189863 L
400	3,8	3.2	50	96	4/15/80	Kaltenbach TL 400	189864 Q
420	4,0	3.2	30	96		Rapid, ELU	189865 L
450	3,8	3.2	30	96	4/12/64 + 2/12/80	DeWALT, Haffner	189866 L
500	4,0	3.4	30	120	2/10/70	Pfeiffer, Rapid	189867 L
[mm]	[mm]	[mm]	[mm]				

108370

NF-Chop Saw Blades HW - neutral hook angle “TR-F”

Product

Drawing



Tungsten Carbide [HW]

Machine / Application
- chop and miter saws
- table saws
- for clipping and mitre cuts in aluminum profiles

Design
- neutral hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 06

Advantages
- burr-free cuts in profiles with low roughness
- noise-reduction thanks to laser ornaments

Notes
- tight workpiece clamping required
- Kaltenbach as counter-bore type

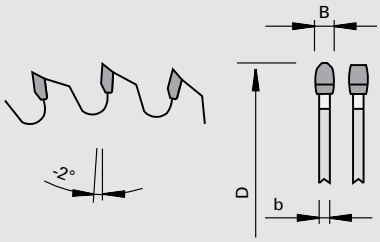
Ø D	B	b	Ø d	Z	NL		Ident-No.
380	3,6	3.0	32	90		Elumatec	189111 S
420	3,8	3.2	30	102	2/10/70	Rapid, Elumatec	189074 S
500	4,0	3.4	30	114	2/10/70	Rapid, Elumatec	189075 L
500	4,0	3.4	32	114	2/12/64	Eisele LMS SCA	189076 L
550	4,4	3.8	30	126	2/10/70	Elumatec, Kaltenbach, Rapid	189113 L
[mm]	[mm]	[mm]	[mm]				

108377

NF-Chop Saw Blades HW - profiles “TR-F K” - easyFix

Product

Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

easyFix

Machine / Application

- clipping and miter saws
- table saws
- for burr-free and very smooth cuts in thin-walled aluminum profiles

Design

- negative hook angle
- tooth configuration: “TR-F K”
- cutting material: HW HL Board 06

Advantages

- easyFix: NEW, EASY HANDLING, easy and smooth mounting of the saw blade on the machine despite high-precision bore tolerance
- very clean cutting surfaces due to convex tooth sides
- very long edge life and economic efficiency

Notes

- secure workpiece clamping required
- wall thickness max. 5 mm (optimum 2-3 mm)

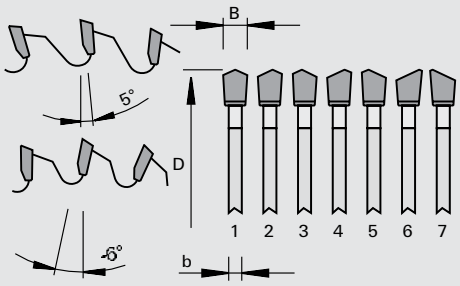
Ø D	B	b	Ø d	Z	Hook angle	NL	Ident-No.
350	3,2	2.5	30	96	-2	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	193291 L
380	3,8	3.2	32	108	-2	2/11/63	193292 L
400	3,8	3.2	30	108	-2	2/10/60 + 2/12/64	193293 L
420	4,0	3.2	30	108	-2	2/10/60 + 2/11/70	193294 L
450	3,8	3.2	30	120	-2	2/10/60 + 2/11/70	193295 L
500	4,0	3.4	30	144	-2	2/10/60 + 2/11/70	193296 L
550	4,0	3.4	30	144	-2	2/11/63 + 2/11/70	193297 L
600	5,0	4.0	30	140	-2	2/11/63 + 2/11/70	193298 L
[mm]	[mm]	[mm]	[mm]		[°]		

108351 / 108352

NF-Chop Saw Blades HW - profiles “G7”

Product

Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

LOW NOISE

Machine / Application

- clipping and miter saws
- table saws
- clipping and miter cuts in PVC profiles
- for burr-free and smooth cuts in aluminum window and façade profiles

Design

- positive or negative hook angle
- tooth configuration: “G7”
- cutting material: HW HL Board 06

Advantages

- reduced cutting pressure thanks to group tooth geometry
- excellent burr-free cuts with low roughness thanks to tooth partition
- extremely noise-reduced thanks to special laser ornaments
- increased edge life compared to chop saw blades with tooth configuration “TR-F”
- increased performance and economic efficiency

Notes

- Secure workpiece clamping required
- Max. wall thickness 5 mm

Ø D	B	b	Ø d	Z	Hook angle	NL		Ident-No.
300	3,2	2.5	30	98	5	2/7/42 + 2/9/46 + 2/10/60 + 2/11/70		192663 L
350	3,2	2.5	30	98	5	2/7/42 + 2/9/46 + 2/10/60		192662 L
400	3,8	3.2	30	98	5	2/7/42 + 2/9/46 + 2/10/60 + 2/15/80 + 4/12/64		192659 L
420	3,8	3.2	30	98	5			192660 L
420	3,8	3.2	32	98	5	2/12/64		193361 L
500	4,0	3.4	30	126	5	2/7/42 + 2/9/46 + 2/10/60 + 2/10/70 + 4/12/64		192661 L
600	4,6	4.0	32	140	5		Schüco	80494197 L
[mm]	[mm]	[mm]	[mm]		[°]			

Ø D	B	b	Ø d	Z	Hook angle	NL		Ident-No.
250	3,2	2.5	30	84	-6	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60		192965 L
300	3,2	2.5	30	98	-6	2/7/42 + 2/9/46 + 2/10/60 + 2/11/70		192568 L
350	3,2	2.5	30	112	-6	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60		192275 L
350	3,2	2.5	32	112	-6	2/12/64	Emmegi	193355 L
350	3,5	2.8	30	98	-6	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	DeWALT, Haffner, Pfeiffer, Rotox	192274 L
350	3,8	3.2	40	84	-6	4/12/64 + 2/9/55	Eisele LSM II, -LSM II-PV, -VA-L, Graule, Ulmia, Weidmann	192273 L
380	3,8	3.2	32	112	-6		Elumatec	192567 L
400	3,8	3.2	30	98	-6	2/10/60 + 2/12/64 + 4/15/80	DeWALT, Haffner	192276 L
400	3,8	3.2	30	126	-6	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 + 2/12/64	Rapid	193356 L
420	4,0	3.2	30	98	-6	2/10/60 + 2/11/70	Rapid, ELU	192277 L
400	3,2	2.5	32	126	-6	2/12/64	Emmegi	193357 L
450	3,8	3.2	30	112	-6	2/12/64 + 4/15/80	DeWALT, Haffner	192278 L
450	3,8	3.2	32	112	-6	2/12/64	Emmegi	193358 L
[mm]	[mm]	[mm]	[mm]		[°]			

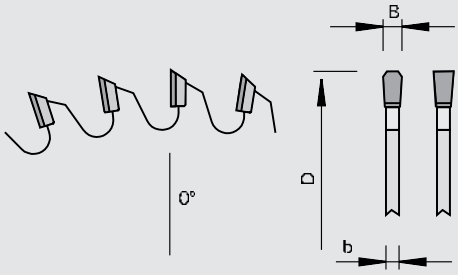
Ø D	B	b	Ø d	Z	Hook angle	NL		Ident-No.
450	3,8	3.2	32	126	-6	2/12/64	Emmegi	193359 L
500	4,0	3.4	30	126	-6	2/11/70 + 2/10/60	Pfeiffer, Rapid	192279 L
500	4,0	3.2	32	126	-6	2/12/64	Emmegi	193360 L
550	4,0	3.4	30	133	-6	2/10/60 + 2/12/64 + 4/15/80	Pfeiffer, Rapid, Elumatec	192392 L
600	4,6	4.0	32	140	-6		Pfeiffer, Rapid	193341 L
[mm]	[mm]	[mm]	[mm]		[°]			

208170

DIAREX NF-Chop Saw Blades DP - Profile “TR-F”

Product

Drawing



Polycrystalline diamond [DP]

Machine / Application
- chop and miter saws
- for clipping and mitre cuts in aluminum profiles

Design
- neutral hook angle
- tooth configuration: triple chip / flat “TR-F”

Advantages
- excellent burr-free cuts with low roughness thanks to special laser ornaments and tooth partition

Notes
- tight workpiece clamping required

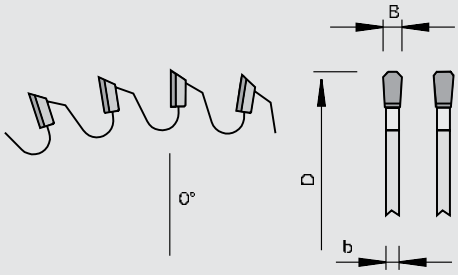
Ø D	B	b	Ø d	Z	NL		Ident-No.
275	3,4	2.8	32	60	4/9/50	Wagner 1994	189868 C
285	3,4	2.8	32	60	4/9/50	Wagner	189869 C
380	3,6	3.0	32	84	4/9/50	Elumatec	189870 C
400	3,8	3.2	40	90	2/12/80	Eisele VA-L 350 NC1	189871 C
500	4,0	3.4	30	114	2/10/70	Elumatec	189872 C
550	4,2	3.6	30	120		Elumatec MGS	189873 C
[mm]	[mm]	[mm]	[mm]				

208180

DIAREX NF-Chop Saw Blades DP - Solid “TR-F-FA”

Product

Drawing



Polycrystalline diamond [DP]

Machine / Application
- chop and miter saws
- for miter cuts in solid aluminum materials

Design
- neutral hook angle
- tooth configuration: inverted-v / flat with chamfer “TR-F-FA”

Advantages
- excellent burr-free cuts with low roughness thanks to special laser ornaments and tooth partition

Notes
- tight workpiece clamping required

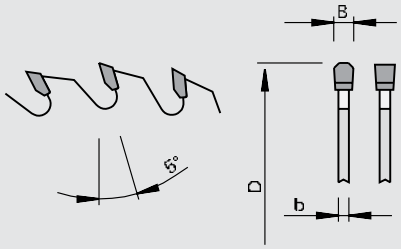
Ø D	B	b	Ø d	Z	NL		Ident-No.
500	4,0	3.4	50	90	4/15/80	Kaltenbach RKL 550	189874 C
500	4,0	3.4	30	90		Elumatec	189875 C
550	4,4	3.8	50	96	4/15/80	Kaltenbach RKL 550	189876 C
[mm]	[mm]	[mm]	[mm]				

108671

NF-Chop Saw Blades HW - positive hook angle “TR-F” highline

Product

Drawing



LEUCO highline

LEUCO DUR

Tungsten Carbide [HW]

LOW NOISE

Machine / Application
- table saws
- for dividing and miter cuts in aluminum and plastic profiles as well as for wood-based panels (Corian®, Noblan, Varicor® and HPL)

Design
- positive hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 10

Advantages
- noise-reduction thanks to laser ornaments

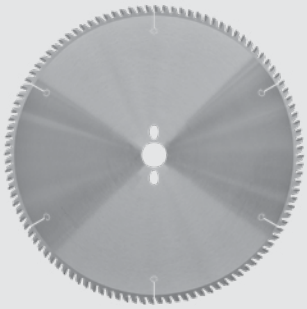
Notes
- tight workpiece clamping required

Ø D	B	b	Ø d	Z	NL		Ident-No.
250	3,2	2.5	30	80	2/7/42 + 2/9/46 + 2/10/60	Haffner, ELU, Makita	189877 L
300	3,2	2.5	30	72	2/7/42 + 2/9/46 + 2/10/60	Fezer, Rapid	189878 L
300	3,2	2.5	30	96	2/7/42 + 2/9/46 + 2/10/60	Fezer, Rapid	189879 L
300	3,2	2.5	32	96			189880 O
[mm]	[mm]	[mm]	[mm]				

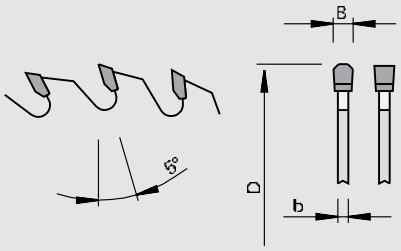
108371

NF-Chop Saw Blades HW - positive hook angle “TR-F” topline

Product



Drawing



Tungsten Carbide [HW]

Machine / Application
- table saws
- for dividing and miter cuts in aluminum and plastic profiles as well as for wood-based panels (Corian®, Noblan, Varicor® and HPL)

Design
- positive hook angle
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 06

Advantages
- noise-reduction thanks to laser ornaments

Notes
- tight workpiece clamping required

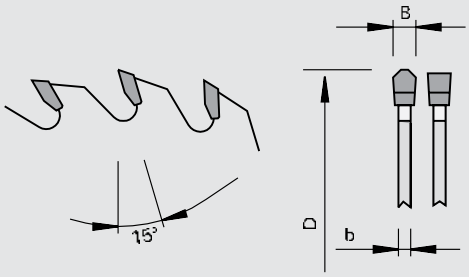
Ø D	B	b	Ø d	Z	NL		Ident-No.
350	3,2	2.5	30	108	2/7/42 + 2/9/46 + 2/10/60	Haffner, Rapid, Pfeffer	193114 L
350	3,2	2.5	32	92	2/12/64		193113 L
350	3,2	2.5	32	108	2/12/64		193112 L
400	3,8	3.2	30	96	4/12/64 + 2/12/80		189882 L
400	3,8	3.2	40	96	4/12/64 + 2/12/80	Eisele LMS II, LMS III	189883 O
420	3,8	3.2	30	96		ELU DG 102, 104, DLG, MGS 105, Rapid SAT	189884 L
450	3,8	3.2	40	108	4/12/64 + 2/12/80	Eisele	189885 L
500	4,0	3.4	30	120	2/10/70 + 2/12/64	Pfeifer, Rapid, BKS	189886 L
[mm]	[mm]	[mm]	[mm]				

108373

NF-Panel Sizing Saw Blades HW - positive hook angle “TR-F”

Product

Drawing



Tungsten Carbide [HW]

Machine / Application
- horizontal panel sizing saws
- for dividing cuts in aluminum block materials

Design
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 09

Advantages
- noise-reduction thanks to laser ornaments

Notes
- for stack heights up to 200 mm (for large saw diameters)

Ø D	B	b	Ø d	Z	NL	H		Ident-No.
450	4,5	3.2	40	60	2/13/114	-100	Schelling	189887 S
[mm]	[mm]	[mm]	[mm]			[mm]		

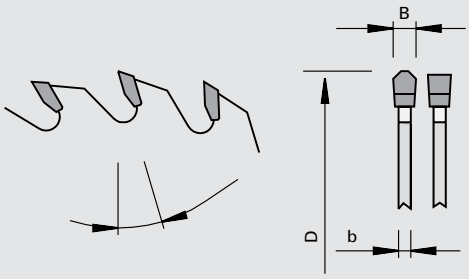
Ø D	B	b	Ø d	Z	NL	H		Ident-No.
450	4,8	3.5	60	60	2/14/125 + 2/19/120	-100	Holzma	189891 S
620	5,5	4.2	40	60	2/13/114	110-160	Schelling	189888 S
680	5,8	4.5	40	60	2/13/114	-200	Schelling	189889 S
720	6,0	4.8	40	60	2/13/114	150-220	Schelling	189890 S
[mm]	[mm]	[mm]	[mm]			[mm]		

108271

NF-Thin-Kerf-Chop Saw Blades HW - positive hook angle “TR-F”

Product

Drawing



LEUCO topline

LEUCO DUR

Tungsten Carbide [HW]

LOW

Machine / Application
- chop saws
- for dividing and trimming of aluminum profiles (bars, tubes, ...)

Design
- with laser ornaments
- tooth configuration: triple chip / flat “TR-F”
- cutting material: HW HL Board 08

Advantages
- less vibration and noise thanks to laser ornaments

Notes

Ø D	B	b	Ø d	Z	Hook angle	NL		Ident-No.
285	2,0	1.6	32	60	5	4/9/50 + 4/11/63	Kasto Speed C9, Kasto WAC-70, Tsune, Nishijima, Rhobi, Everising, I.T.E.C	189655 S
360	3,4	2.6	50	60	5	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15, Kaltenbach KMR-100AP Tsune, Nishijima, Sinico, Endo	189657 S
360	3,4	2.6	50	80	5	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15, Kaltenbach KMR-100AP Tsune, Nishijima, Sinico, Endo	189656 S
425	3,4	2.6	50	50	5	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15	189658 S
425	3,4	2.6	50	60	5	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15	189659 S
460	3,4	2.6	50	50	8	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15, Everising, Noritake	189660 S
460	3,4	2.6	50	60	8	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15, Everising, Noritake	189662 S
460	3,4	2.6	50	80	8	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15, Everising, Noritake	189661 S
[mm]	[mm]	[mm]	[mm]		[°]			

LEUCO

MAGENTIFY WOOD PROCESSING

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