

3. Planing and profiling

3.2 Planing

3.2.2 Cutterheads for pre and finish planing



Planerhead VariPlan Plus

Application:

Multi-purpose planing tool:
For pre-planing with RipTec turnblades.
For finish planing with microfinish turnblades.

Machine:

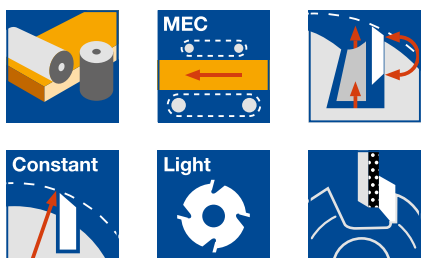
Four-sided moulders and multi spindle planing machines.

Workpiece material:

Softwood and hardwood, thermoplastics (partly suitable).

Technical information:

Resharpenable and constant diameter planerhead system.
Self-positioning and centrifugal force supported knife clamping. Lightweight aluminium tool body. Resharpener the knives on the cutting face means one sharpening operation gives two additional lives.



Lightweight aluminium tool body

WW 240 2 05

D	SB	ND	BO	n_{max}	Z	ID	ID
mm	mm	mm	mm	min ⁻¹		HS	HW-MF
125	130	136	40	12000	2	134250 □	134200 ●
125	150	156	40	12000	2	134251	134201
125	166	172	40	12000	2	134252 □	134202 ●
125	180	186	40	12000	2	134253	134203
125	210	216	40	12000	2	134254	134204
125	236	242	40	12000	2	134255 □	134205 ●
125	256	262	40	12000	2	134258	134208
125	270	276	40	10500	2	134256	134206
125	130	136	40	12000	4	134450 □	134400 ●
125	150	156	40	12000	4	134451	134401
125	166	172	40	12000	4	134452 □	134402 ●
125	180	186	40	12000	4	134453	134403
125	210	216	40	12000	4	134454	134404
125	236	242	40	12000	4	134455 □	134405 ●
125	256	262	40	12000	4	134458	134408 ●
125	270	276	40	10500	4	134456	134406

Further dimensions and inch dimensions on request.

Spare knives (HS/HW-MF/HW-RipTec) see section Knives and Spare Parts.

Spare knives:

SB	H	DIK	SET	ID	ID
mm	mm	mm	PCS	HS	HW-MF
130	16	3.7	2	610506 ●	617106 ●
150	16	3.7	2	610509 ●	617109 ●
166	16	3.7	2	610571 □	617171 ●
180	16	3.7	2	610512 ●	617112 ●
210	16	3.7	2	610515 ●	617115 ●
236	16	3.7	2	610569 □	617169 ●
256	16	3.7	2	610572 □	617172 ●
270	16	3.7	2		617165 ●

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3. Planing and profiling

3.2 Planing

3.2.2 Cutterheads for pre and finish planing



Planerhead VariPlan Plus

Application:

Multi-purpose planing tool:
For pre-planing with RipTec turnblades.
For finish planing with microfinish turnblades.

Machine:

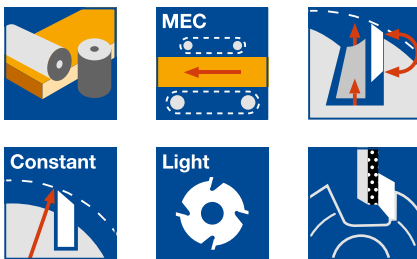
Four-sided moulders and multi spindle moulders with HSK 85 WS interfaces.

Workpiece material:

Softwood and hardwood, thermoplastics (partly suitable).

Technical information:

Resharpenable and constant diameter planerhead system. Self-positioning and centrifugal force supported knife clamping. Lightweight aluminium tool body. Resharpener the knives on the cutting face means one sharpening operation gives two additional lives. Tool body and HSK arbor are shrunk fit together.



Lightweight aluminium tool body on HSK 85 WS

WP 240 2 05

D mm	SB mm	A mm	n_{max} min ⁻¹	Z	QAL	ID LH / bottom	ID RH / top
125	130	26	12000	2	HW-MF	134500 □	134501 □
125	150	26	12000	2	HW-MF	134502	134503
125	166	26	12000	2	HW-MF	134504 □	134505 □
125	180	26	12000	2	HW-MF	134506	134507
125	210	26	12000	2	HW-MF	134508	134509
125	236	26	12000	2	HW-MF	134510 □	134511 □
125	270	26	8000	2	HW-MF	134512	134513
125	310	26	8000	2	HW-MF	134514	134515
125	130	26	12000	4	HW-MF	134600 □	134601 □
125	150	26	12000	4	HW-MF	134602	134603
125	166	26	12000	4	HW-MF	134604 □	134605 □
125	180	26	12000	4	HW-MF	134606	134607
125	210	26	12000	4	HW-MF	134608	134609
125	236	26	12000	4	HW-MF	134610 □	134611 □
125	270	26	8000	4	HW-MF	134612	134613
125	310	26	8000	4	HW-MF	134614	134615

Further dimensions and inch dimensions on request.

Spare knives (HS/HW-MF/HW-RipTec) see section Knives and Spare Parts.

Spare knives:

SB mm	H mm	DIK mm	SET PCS	ID HS	ID HW-MF
130	16	3.7	2	610506 ●	617106 ●
150	16	3.7	2	610509 ●	617109 ●
166	16	3.7	2	610571 □	617171 ●
180	16	3.7	2	610512 ●	617112 ●
210	16	3.7	2	610515 ●	617115 ●
236	16	3.7	2	610569 □	617169 ●
270	16	3.7	2		617165 ●
310	16	3.7	2	610522 ●	617122 ●

3. Planing and profiling

3.2 Planing

3.2.4 Combination tools for planing and profiling



Planerhead VariPlan Plus/ProFix F system PF 25

Application:

For planing and profiling (chamfering) e.g. grooving, bevelling, rounding or profiling in common.

Machine:

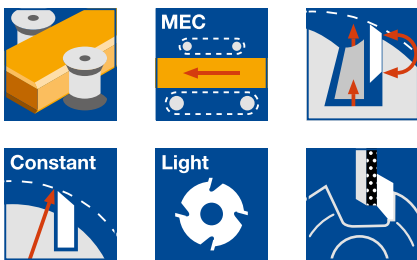
Four-sided moulders.

Workpiece material:

Softwood and hardwood.

Technical information:

Resharpenable cutterhead system with constant diameter and constant profile. VariPlan Plus planerhead with knife seatings for ProFix F profile knives (PF 25) and HW microfinish turnblade knives. Profile knives: PT_{max} 25 mm, SB_{max} 100 mm. Lightweight aluminium tool body.

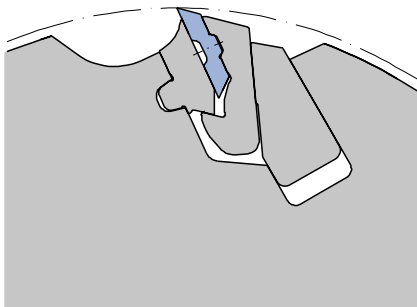


Bore 40 mm

WW 240 2 07

D	SB	ND	BO	QAL	n_{max}	Z	ID
mm	mm	mm	mm		min^{-1}		
125	130	136	40	HW	10200	2+2	131060 ●
125	166	172	40	HW	10200	2+2	131058 ●
125	236	242	40	HW	10200	2+2	131059 ●

Further knife types, dimensions and inch dimensions on request. Servicing with spare parts only by the manufacturer. VariPlan Plus spare knives in section Knives and Spare Parts.



Spare knives:

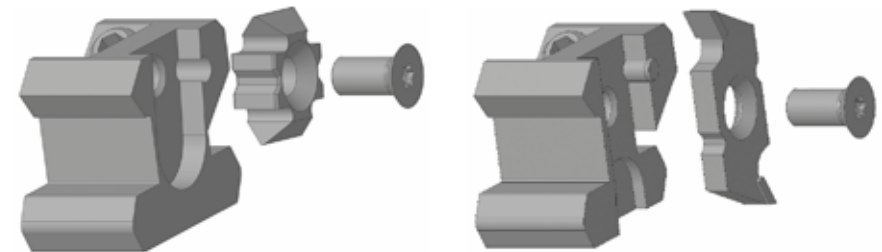
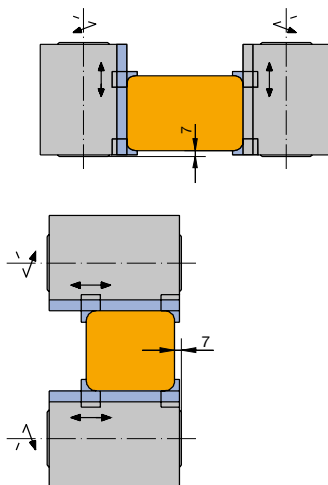
BEZ	SB	ABM	QAL	ID	ID
	mm	mm		LH	RH
ProFix F knife PF 25 R=3	25	R=3	HW	011041 ●	011042 ●
ProFix F knife PF 25 R=5	25	R=5	HW	011043 ●	011044 ●
ProFix F knife PF 25 R=10	25	R=10	HW	011047 ●	011048 ●
ProFix F knife PF 25 Bevel 45°	25	Bevel 45°	HW	011051 ●	011052 ●

Further profile knives on request.

Spare parts:

BEZ	ABM	ID	ID
	mm	LH	RH
Knife holder for edge knives	D=125, SW=20°	011301 ●	011300 ●
Knife holder for grooving knives	D=125, SW=20°, NT=6	011303 ●	011302 ●
Allen key	SW 4		005445 ●
Allen key	SW 5		005452 ●

Lightweight aluminium tool body with steel chip breaker



Knife holder to adapt edge knives.

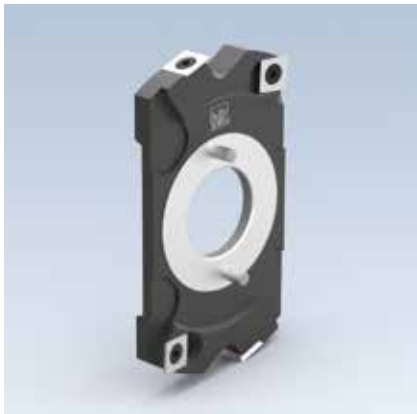
Knife holder to adapt grooving knives.

Use on vertical or horizontal spindles

$HD = SB - 40 \text{ mm}$

3. Planing and profiling

3.2 Planing 3.2.1 Cutterheads for pre-planing



Reference cutterhead

Application:

For cutting a side reference rebate when surface planing on the first bottom spindle in combination with a planer cutterhead.

Machine:

Four-sided moulders with fence.

Workpiece material:

Softwood and hardwood.

Technical information:

Steel tool body with HW turnblade knives, can be combined with pre-planing and finish planing cutterheads on the first bottom spindle.

D 145 for planerheads D 125.

D 160 for planerheads D 140.



For wedge-type system, build-up system, CentroStar

WW 410 2

D	SB	BO	Z	V	QAL	n _{max} min ⁻¹	ID
mm	mm	mm					
145	15	40	2	2	HW	12000	132077 ●
160	15	50	2	2	HW	11000	132078 ●

For HeliPlan, VariPlan Plus

WW 410 2

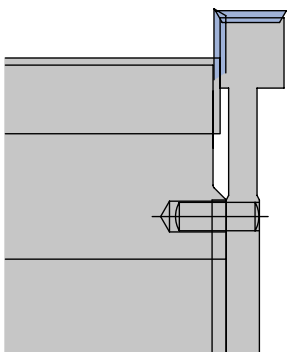
D	SB	BO	Z	V	QAL	n _{max} min ⁻¹	ID
mm	mm	mm					
145	15	40	2	2	HW	12000	132075 ●
160	15	50	2	2	HW	11000	132076 ●

Spare knives:

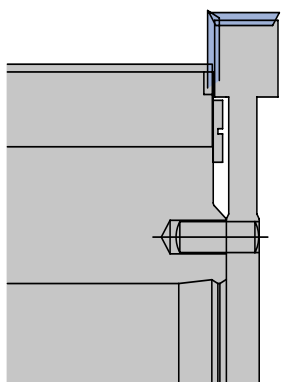
BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	15x15x2.5	HW	10	009535 ●

Spare parts:

BEZ	ABM mm	ID
Spacer	70x3x40,DTK58	028617 ●
Countersink screw, Torx® 20	M5x14.2-8.8	007394 ●
Pin	6x20	008617 ●



Combination with wedge-type system, build up system and CentroStar. For planerheads without boss, mounted with spacers.



Combination with HeliPlan and VariPlan Plus cutterhead. Mounting without spacer.

4. Manual feed

4.2 Jointing, rebating and bevelling

4.2.3 Rebating cutterheads



Rebating cutterhead

Application:

For jointing, rebating and grooving.

Machine:

Spindle moulders (running against feed), double-end tenoners, edgebanding machines etc. (running with feed or against feed e.g. jump cutting). Stationary routers with/without CNC control.

Workpiece material:

Softwood and hardwood, glulam, plastics etc.

Technical information:

Cutterhead with alternate shear angle and triangular spurs.



Turnblade rebating cutterhead

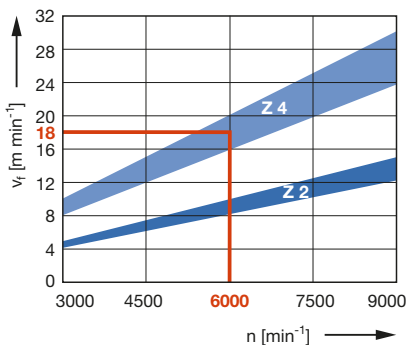
WW 420 1, WW 420 1 02

D	SB	BO	BO _{max}	Z	V	n _{max}	ID
mm	mm	mm	mm			min ⁻¹	
85	51	30	40	2	4	20200	024555
100	51	30	40	2	4	17100	024568
125	41	30	40	2	4	13700	024546 ●
125	51	30	50	2	4	13800	024569 ●
125	51	40	50	2	4	13800	024570 □
125	51	50	50	2	4	13800	024571 □
125	81	30	50	2	4	13700	024723 ●
150	51	30	40	2	4	11400	024548 ●
150	61	30	50	4	4	11400	024543 ●

Spare knives:

Part-no.	BEZ	ABM	QAL	VE	ID
		mm		PCS	
1	Turnblade knife	40x8x1.5	HW-30F	10	005074 ●
1	Turnblade knife	50x8x1.5	HW-30F	10	005075 ●
1	Turnblade knife	60x8x1.5	HW-30F	10	005076 ●
1	Turnblade knife	80x8x1.5	HW-30F	10	601613 ●
2	Turnblade spur VS2	19x19x2	HW-F	10	005115 ●

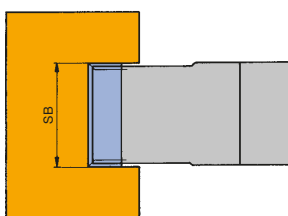
Alternative turnblade knife qualities see section Knives and Spare Parts



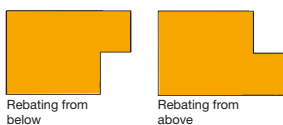
Feed speed v_f depending on the number of teeth Z and speed n for solid wood along grain

Example:

$n = 6000 \text{ min}^{-1}$, $Z 4$: $v_f = 18 \text{ m min}^{-1}$



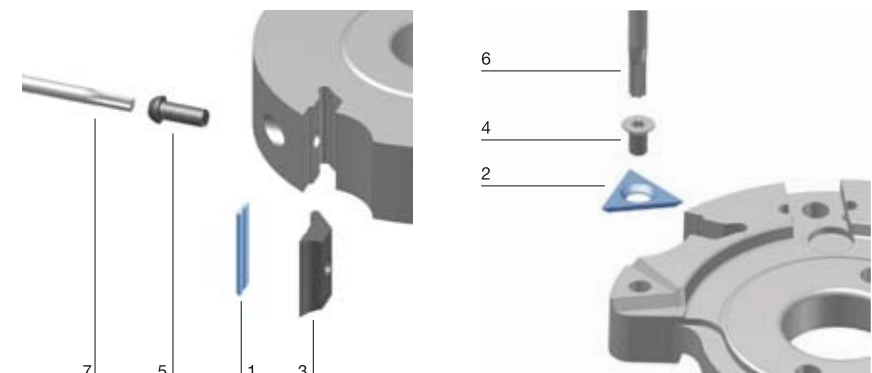
Tool set



Grooving

Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
3	Clamping wedge	38x18.75x8.27	009675 ●
3	Clamping wedge	48x18.75x8.27	009677 ●
3	Clamping wedge	58x18.75x8.27	009678 ●
3	Clamping wedge	78x18.75x8.27	009680 ●
4	Countersink screw, Torx® 20	M5x8.5	007808 ●
5	Clamping screw w. disc, Torx® 25	M6x18.5	007442 ●
6	Torx® key	Torx® 20	117503 ●
7	Torx® key	Torx® 25	117504 ●
	Setting gauge for knives	0.3/0.8	005374 ●



3. Planing and profiling

3.5 Grooving, jointing, rebating (kerving)

3.5.1 Rebating cutterheads for multi-purpose processing



Rebating cutterhead for joinery machines - HeliCut 15

Application:

For cutting grooves, rebate grooves, V-grooves as well as for jointing longitudinal and crosscut wood with large hogging depths in the wood construction.

Machine:

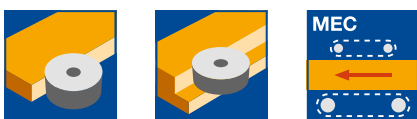
CNC-controlled joinery machines, as well as special machines for general wood construction with machine-specific adaptors.

Workpiece material:

Solid wood, preferably softwood for wood construction, hardwood (oak, ash etc.).

Technical information:

Carrier body constructed from high strength lightweight aluminium alloy. With 4-times turnable, spiral-shaped assembled HW turnblades. Application of the same knives as peripheral knives and spurs. The cutting bevels of the HW knives are numbered. No clamping wedges, direct tangential knife clamping. Easy handling of knife change without further mounting aid.



Aluminium tool body

WW 430 2 05

D	SB	BO	Z	V	ID
mm	mm	mm			
250	60	30	4x6	2 x 4+4	132538
250	80	30	4x8	2 x 4+4	132539
250	100	30	4x10	2 x 4+4	132540
300	20	30	4x2	2 x 4+4	132541
300	40	30	4x4	2 x 4+4	132542
300	60	30	4x6	2 x 4+4	132543
300	80	30	4x8	2 x 4+4	132544
300	100	30	4x10	2 x 4+4	132545
350	20	30	4x2	2 x 4+4	132546
350	40	30	4x4	2 x 4+4	132547
350	60	30	4x6	2 x 4+4	132548
350	80	30	4x8	2 x 4+4	132549
350	100	30	4x10	2 x 4+4	132550
400	20	30	4x2	2 x 4+4	132551
400	40	30	4x4	2 x 4+4	132552
400	60	30	4x6	2 x 4+4	132553
400	80	30	4x8	2 x 4+4	132554
400	100	30	4x10	2 x 4+4	132555

More dimensions on request.

Spare knives:

BEZ	ABM	QAL	BEM	VE	ID
	mm			PCS	
Turnblade knife	15x15x2.5	HW	HeliCut 15	10	009549 ●
Turnblade knife	15x15x2.5	HW-MF	HeliCut 15	10	009543 ●
Turnblade knife	15x15x2.5	TDC	HeliCut 15		602900 ●

Spare parts:

BEZ	ABM	ID
	mm	
Countersink screw, Torx® 20	M5x18	114030 ●
Torx® key	Torx® 20	006091 ●

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