



## Dovetail cutter

### Application:

Routers for dovetail joints.

### Machine:

Portable routers.

### Workpiece material:

Softwood and hardwood, laminated veneer lumber (plywood, multiplex plywood etc.).

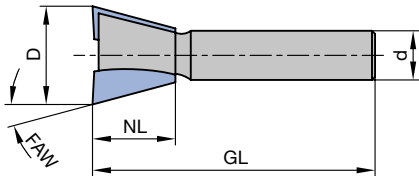
### Technical information:

Cutting edges with shear angle. Design with spurs for increased cutting quality.

### HS/HW, Z 2, shank 8 mm, without spurs

WO 610 1, WO 612 1

D	GL	NL	S	FAW	QAL	DRI	ID
mm	mm	mm	mm	°			
13.8	46	13.5	8x30	15°	HS	RH	072757 □
20	49	17	8x30	15°	HS	RH	072411 □
13.8	46	13.5	8x30	15°	HW	RH	072758 □
16	46	13.5	8x30	15°	HW	RH	072045 □
20	49	17	8x30	15°	HW	RH	072417 □
14.3	50	16	8x30	10°	HW	RH	072585 □
20	58	26	8x30	10°	HW	RH	072583 □



Dovetail cutter without spurs

### HS/HW, Z 2, shank 8 mm, with spurs

WO 612 1

D	GL	NL	S	FAW	QAL	DRI	ID
mm	mm	mm	mm	°			
14.3	46	13.5	8x30	15°	HW	RH	070361 □

RPM: n = 18000 - 27000 min<sup>-1</sup>

## Glue joint cutter

### Application:

Routers for cutting glue joint profiles.

### Machine:

Portable routers.

### Workpiece material:

Softwood and hardwood, laminated veneer lumber (plywood, multiplex plywood etc.).

### Technical information:

Straight cut. Guide by side stop or guide rail system.

### HW, Z 2

WO 631 1

D	GL	NL	HD	S	QAL	DRI	ID
mm	mm	mm	mm	mm			
34	62	32	30	8x30	HW	RH	072197 □

RPM: n = 18000 - 27000 min<sup>-1</sup>



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Симферополь (3652)67-13-56  
Смоленск (4812)29-41-54  
Сочи (862)225-72-31  
Ставрополь (8652)20-65-13  
Казахстан (772)734-952-31

Сургут (3462)77-98-35  
Тверь (4822)63-31-35  
Томск (3822)98-41-53  
Тула (4872)74-02-29  
Тюмень (3452)66-21-18  
Ульяновск (8422)24-23-59  
Уфа (347)229-48-12  
Хабаровск (4212)92-98-04  
Челябинск (351)202-03-61  
Череповец (8202)49-02-64  
Ярославль (4852)69-52-93

### 3. Planing and profiling

### 3.2 Planing

#### 3.2.3 Cutterheads for finish planing



#### Planerhead with HSK 85 WS and serrated back HS Marathon planer knives

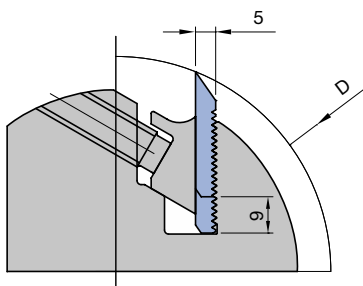
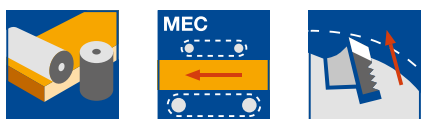
**Application:**  
Finish planing.

**Machine:**  
Four-sided moulders with HSK 85 WS interface.

**Workpiece material:**  
Cutting angle 20° for softwood and hardwood in general.  
Cutting angle 12° for materials likely to splinter such as oak, Douglas fir, merbau and wood fibre materials, e.g. MDF.

**Technical information:**

Finish planing cutterhead in mono block design DTK 90 mm with serrated back planer knives SB x 40 x 5 mm ground to cutting circle. Jointable by specific jointing stone. Steel tool body. High balance quality by assembly with parts of the same weight.



**Cutting angle 20°**

WP 210 2 01

D	SB	A	QAL	Z	n <sub>max</sub>	ID	ID
mm	mm	mm			min <sup>-1</sup>	LH / bottom	RH / top
106	130	26	MC33	2	12000	140322 ●	140323 ●
106	170	26	MC33	2	12000	140324 ●	140325 ●
106	240	26	MC33	2	12000	140326 ●	140327 ●
106	80	26	MC33	4	12000	140330 ●	140331 ●
106	130	26	MC33	4	12000	140332 ●	140333 ●
106	170	26	MC33	4	12000	140334 ●	140335 ●
106	240	26	MC33	4	12000	140336 ●	140337 ●
128	80	26	MC33	6	10000	140346 ●	140347 ●
128	130	26	MC33	6	10000	140348 ●	140349 ●
128	170	26	MC33	6	10000	140350 ●	140351 ●
128	240	26	MC33	6	8000	140352 ●	140353 ●

**Cutting angle 12°**

WP 210 2 01

D	SB	A	QAL	Z	n <sub>max</sub>	ID	ID
mm	mm	mm			min <sup>-1</sup>	LH / bottom	RH / top
106	130	26	MC33	2	12000	140302 ●	140303 ●
106	170	26	MC33	2	12000	140304 ●	140305 ●
106	240	26	MC33	2	12000	140306 ●	140307 ●
106	130	26	MC33	4	12000	140312 ●	140313 ●
106	170	26	MC33	4	12000	140314 ●	140315 ●
128	80	26	MC33	6	10000	140340 ●	140341 ●
128	130	26	MC33	6	10000	140342 ●	140343 ●
128	170	26	MC33	6	10000	140344 ●	140345 ●

**Spare knives:**

SB	H	DIK	QAL	VE	ID
mm	mm	mm		PCS	
80	40	5	MC33	2	697302 ●
130	40	5	MC33	2	697304 ●
170	40	5	MC33	2	697306 ●
240	40	5	MC33	2	697311 ●

**Spare parts:**

BEZ	ABM	for SB	ID
	mm	mm	
Clamping wedge	78x25.3x10.8	80	620702 ●
Clamping wedge	128x25.3x10.8	130	620705 ●
Clamping wedge	168x25.3x10.8	170	620707 □
Clamping wedge	238x25.3x10.8	240	620710 □
Allen screw	M10x1x20		007396 ●
Allen key	SW 5		117509 ●

### 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:

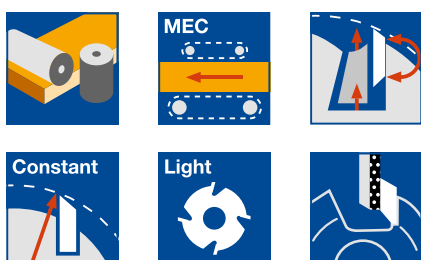
Four-sided moulders and multi spindle moulders with HSK 85 WS interfaces.

##### 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 <sup>-1</sup>	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 ●



## WhisperCut jointing and rebating cutterhead

### Application:

For tear-free and low noise jointing of the cutting surface.

### Machine:

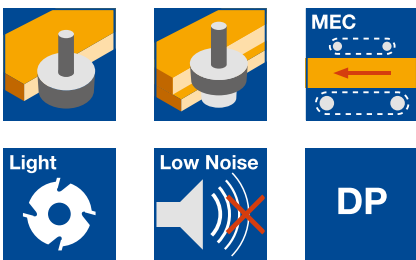
Stationary routers with/without CNC control, machining centres.

### Workpiece material:

Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, paper coated, fibre reinforced plastics (GFRP, CFRP etc.).

### Technical information:

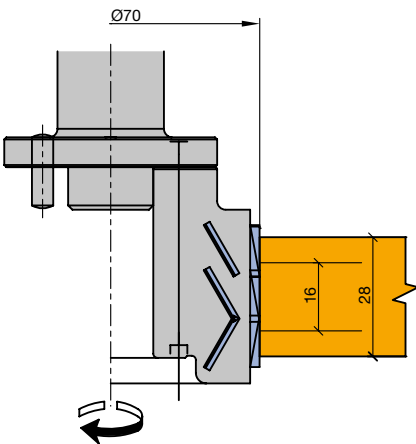
Cutterhead with DP knives with alternate shear angle for tear-free jointing edges and cutting surfaces. Noise reduced design with noise reduction of up to 5 dB(A) and highly efficient chip collection (>95%) by DFC. Significant weight reduction through lightweight aluminium tool body. Several times applicable through exchangeable knives. 0.6 mm reshaping area.



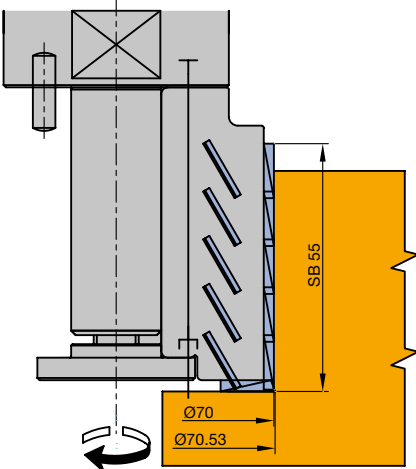
### Diamaster WhisperCut jointing cutterhead

WM 230 2 01, WP 299 2

Tool Type	ABM mm	QAL	Z	ID
Cutterhead	70x33x20	DP	2/2/2	<b>192273</b> ●
Cutterhead mounted on arbor	1-part/HD28	DP	2/2/2	<b>192274</b> □



Diamaster WhisperCut jointing cutterhead



Diamaster WhisperCut rebating cutterhead

### Application:

For tear-free and low noise rebating of the cutting surface.

### Technical information:

Cutterhead with DP knives. For Tear-free rebates due to optimised knife arrangement with shear angle and separate bottom tip (spurs). Not suitable for jointing. Several times applicable through exchangeable knives. Noise reduced design with noise reduction of up to 5 dB(A) and highly efficient chip collection (>95%) by DFC. Significant weight reduction through lightweight aluminium tool body.

### Diamaster WhisperCut rebating cutterhead

WM 430 2 01, WP 499 2

Tool Type	ABM mm	QAL	Z	ID
Cutterhead	70.53x55x20	DP	3x5	<b>192275</b> ●
Cutterhead mounted on arbor	D70.53/SB55	DP	3x5	<b>192276</b> □

Unless stated otherwise, tools are right hand rotation.

Cutter arbor see section Clamping Systems.

### Order example:

Tool set ID **192274** mounted on arbor  
ID **041126**, shank 25x60 mm.

In case of order select arbors with  
d = 20 mm and biggest clamping length  
of the respective type.

## 5. Routing

## 5.2 Jointing, rebating and bevelling

### 5.2.2 Bevelling tools



### Variable angle cutterhead - turnblade design

**Application:**

For jointing and bevelling with adjustable bevel angle.

**Machine:**

Stationary routers with/without CNC control, machining centres.

**Workpiece material:**

Softwood and hardwood, laminated veneer lumber, plastomers, limited suitable for MDF and chipboard (uncoated or coated).

**Technical information:**

Knife holder swivelling adjustable from 0 - 90°. Quick and easy angle adjustment of common angles (15°, 30°, 45°, 60°) by additional locking positions in 15° steps. Free of marks cutting result due to 1-part, continuous cutting edge. Economical due to changeable tungsten carbide turnblades with two cutting edges. Optimized gullet design for improved chip removal.



**Turnblade, adjustable bevel angle**

WP 341 1 01

D	SB	S	DRI	ID
mm	mm	mm		
120	50	25x60	RH	<b>042864 ●</b>
120	50	20x50	RH	<b>042865 □</b>

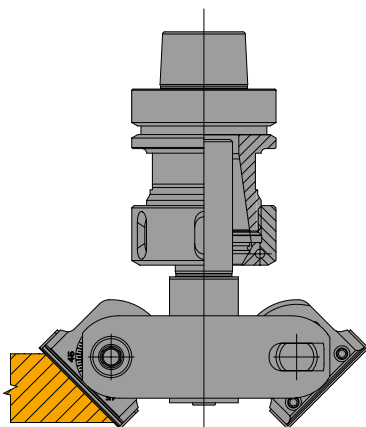
**RPM:**  $n_{\max} = 11000 \text{ min}^{-1}$

**Spare knives:**

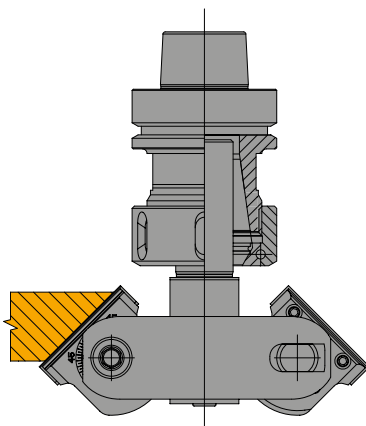
Part-no.	BEZ	ABM	QAL	VE	ID
		mm		PCS	
1	Turnblade knife	50x12x1.5	HW-05F	10	<b>005086 ●</b>

**Spare parts:**

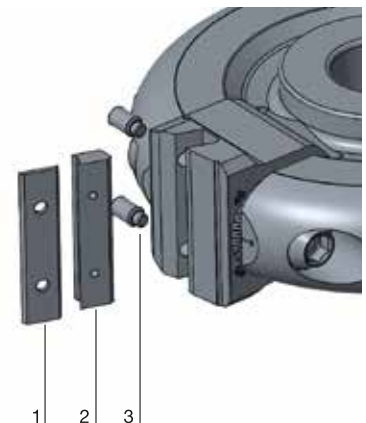
Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge with pin	48x10.88x6	<b>009766 ●</b>
3	Allen screw	M6x12	<b>006035 ●</b>
	Allen key	SW 3	<b>005433 ●</b>
	Allen key	SW 8, L 100	<b>005437 ●</b>
	Setting gauge for knives	80x12x9.5	<b>005352 ●</b>



Bevelling from above



Bevelling from below



## 5. Routing

## 5.2 Jointing, rebating and bevelling

### 5.2.2 Bevelling tools



#### Variable angle cutterhead - HeliCut

**Application:**

For jointing and bevelling with adjustable bevel angle.

**Machine:**

Stationary routers with/without CNC control, machining centres.

**Workpiece material:**

Softwood and hardwood, laminated veneer lumber, plastomers, technical foams (XPS, PU), limited suitable for MDF and chipboard (uncoated or coated).

**Technical information:**

Knife holder swivelling adjustable from 0 - 65°. Quick and easy angle adjustment of common angles (15°, 30°, 45°, 60°) by additional locking positions in 15° steps. Workpiece edges tear-free on both sides due to alternative shear angles. Economical due to partial change of tungsten carbide turnblades with four cutting edges. Cutting edges with particularly sleek geometry and polishing for perfect surface quality and long performance time. Noise reduced design with split cutting edges and optimized gullet design for improved chip removal.



**HeliCut, adjustable bevel angle**

WP 341 1 01

D	SB	S	DRI	ID
mm	mm	mm		
120	55	25x60	RH	042859 ●
120	55	20x50	RH	042863 □

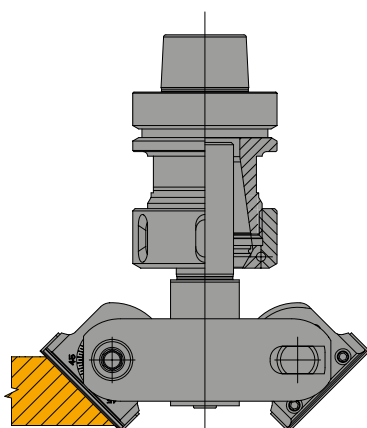
**RPM:**  $n_{max} = 11000 \text{ min}^{-1}$

**Spare knives:**

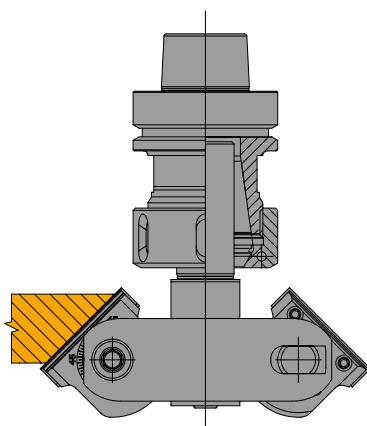
Part-no.	BEZ	ABM	ID
		mm	
1	Turnblade knife	15x15x2.5	009543 ●

**Spare parts:**

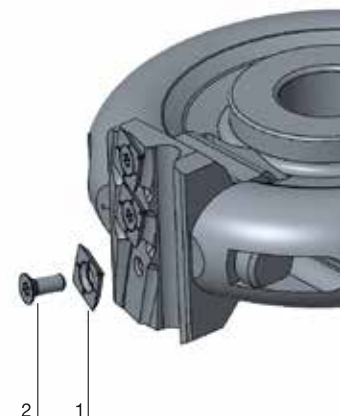
Part-no.	BEZ	ABM	ID
2	Countersink screw, Torx® 20	M5x12	007898 ●
	Torx® key	Torx® 20	006091 ●
	Allen key	SW 8, L 100	005437 ●



Bevelling from above



Bevelling from below



## 5. Routing

## 5.2 Jointing, rebating and bevelling

### 5.2.2 Bevelling tools



### Variable angle cutterhead - WhisperCut

**Application:**

For jointing and bevelling with adjustable bevel angle.

**Machine:**

Stationary routers with/without CNC control, machining centres.

**Workpiece material:**

Hardwood, chip and fibre board (chipboard, MDF, HDF etc.), plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), solid surface material (Corian, Varicor etc.), fibre reinforced plastics (GRP, CFRP).

**Technical information:**

Knife holder swivelling adjustable from 0 - 65°. Quick and easy angle adjustment of common angles (15°, 30°, 45°, 60°) by additional locking positions in 15° steps. Workpiece edges tear-free on both sides due to alternatinv shear angles. Economical due to partial change of diamond cutting edges. Noice reduced design with optimized gullet design for improved chip removal.



**WhisperCut, adjustable bevel angle**

WP 341 1 01

D	SB	S	DRI	ID
mm	mm	mm		
120	55	25x60	RH	<b>042860</b> ●
120	55	20x50	RH	<b>042866</b> □

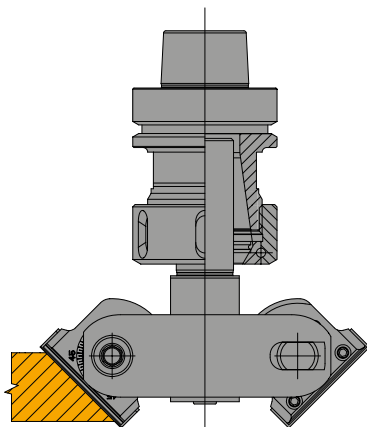
**RPM:**  $n_{max} = 11000 \text{ min}^{-1}$

**Spare knives:**

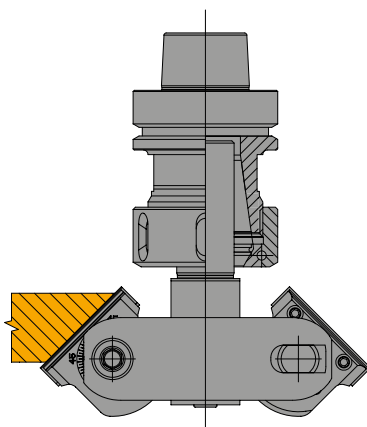
Part-no.	BEZ	ABM	ID
1	WhisperCut-knife SB14	mm 14x14.2x4.3	<b>091074</b> ●

**Spare parts:**

Part-no.	BEZ	ABM	ID
2	Countersink screw, Torx® 20/59° Torx® key Allen key	mm M5x11.5 Torx® 20 SW 8, L 100	<b>007899</b> ● <b>006091</b> ● <b>005437</b> ●



Bevelling from above



Bevelling from below



### 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:**

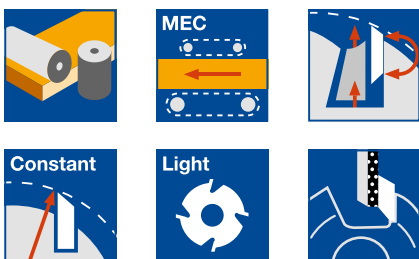
Four-sided moulders and multi spindle moulders with HSK 85 WS interfaces.

**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 with reference cutterhead Z2 / V2**

WP 240 2 08

D	SB	A	n <sub>max</sub>	Z	QAL	DRI	ID
mm	mm	mm	min <sup>-1</sup>				
125	236	26	12000	2	HW-MF	LH / bottom	<b>134581</b> □
125	236	26	12000	4	HW-MF	LH / bottom	<b>134681</b> □

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	<b>610506</b> ●	<b>617106</b> ●
150	16	3.7	2	<b>610509</b> ●	<b>617109</b> ●
166	16	3.7	2	<b>610571</b> □	<b>617171</b> ●
180	16	3.7	2	<b>610512</b> ●	<b>617112</b> ●
210	16	3.7	2	<b>610515</b> ●	<b>617115</b> ●
236	16	3.7	2	<b>610569</b> □	<b>617169</b> ●
270	16	3.7	2		<b>617165</b> ●
310	16	3.7	2	<b>610522</b> ●	<b>617122</b> ●

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Астана (7172)727-132  
Астрахань (8512)99-46-04  
Барнаул (3852)73-04-60  
Белгород (4722)40-23-64  
Брянск (4832)59-03-52  
Владивосток (423)249-28-31  
Волгоград (844)278-03-48  
Вологда (8172)26-41-59  
Воронеж (473)204-51-73  
Екатеринбург (343)384-55-89  
Иваново (4932)77-34-06

Ижевск (3412)26-03-58  
Иркутск (395)279-98-46  
Казань (843)206-01-48  
Калининград (4012)72-03-81  
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