

Grooving cutterhead set adjustable with spacers



Application:
For cutting different groove widths.

Machine:
Spindle moulders, moulders, edgebanding machines and stationary routers with/without CNC control, double-end tenoners.

Workpiece material:
Solid wood along grain and across grain; uncoated, coated and veneered wood derived materials in top layer and middle layer.

Technical information:
Adjustment of cutting widths with spacers (adjustment 0.10 mm).



2 part; SB 4.0 - 7.5 mm
SW 501 1 01

D	SB	BO	BO _{max}	NT	Z	n	ID
mm	mm	mm	mm	mm		min ⁻¹	
150	4.0 - 7.5	30	50	20	2/2	5200 - 10100	128100 ●
180	4.0 - 7.5	30	50	35	2/2	4300 - 8400	128101 ●

Extension parts SB 3.8 mm
WW 200 1 NN

D	SB	BO	BO _{max}	Z	n	ID
mm	mm	mm	mm		min ⁻¹	
150	3.8	30	50	2	5200 - 10100	128130
180	3.8	30	50	2	4300 - 8400	128131

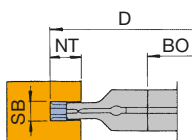
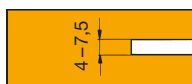
Each extension part increases the cutting widths by 3.6 mm.

Spare knives:

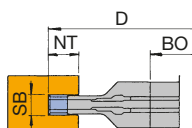
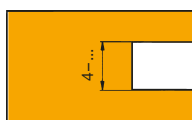
Part-no.	BEZ	ABM	QAL	VE	ID
		mm		PCS	
1	Turnblade knife	18x18x1.95	HW	10	005114 ●
2	Turnblade spur VS4	14x14x1.2	HW	10	005130 ●

Spare parts:

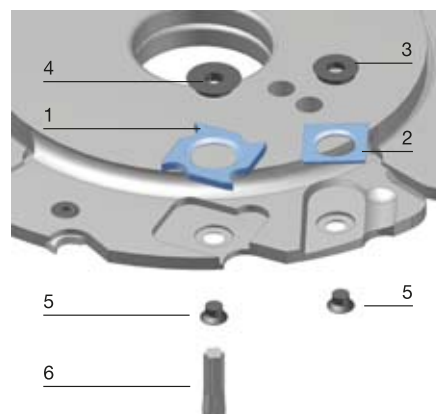
Part-no.	BEZ	ABM	ID
		mm	
3	Special nut for VS	M9.9/1.60	005654 ●
4	Special nut for WPL	M11.9/2.20	005653 ●
5	Countersink screw, Torx® 9	M4x0.5x3.2	006057 ●
6	Torx® key	Torx® 9	005463 ●
	Setting gauge for knives	0.3/0.8	005374 ●



Grooving cutterhead set, 2 part design



Grooving cutterhead set, multi part design



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Волгоград (844)278-03-48
Вологда (8172)26-41-59
Воронеж (473)204-51-73
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Иваново (4932)77-34-06

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Череповец (8202)49-02-64
Ярославль (4852)69-52-93

4. Manual feed

4.1 Grooving

4.1.2 Grooving cutterheads



Grooving cutterhead set adjustable with spacers

Application:

For cutting different groove widths.

Machine:

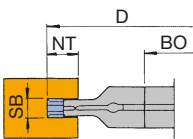
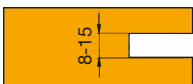
Spindle moulders, moulders, edgbanding machines and stationary routers with/without CNC control, double-end tenoners.

Workpiece material:

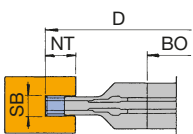
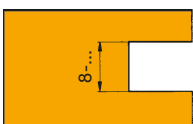
Solid wood along grain and across grain; uncoated, coated and veneered wood derived materials.

Technical information:

Adjustment of cutting widths with spacers (adj. range 0.1 mm). Multi part design.



Grooving cutterhead set, 2 part design



Grooving cutterhead set, multi part design

Multi part; SB 8.0 - 30.0 mm

SW 501 1, SW 501 1 01

D	SB	BO	NT	Z	n	ID
mm	mm	mm	mm		min ⁻¹	
150	8.0 - 15.4	30	20	2/2	5200 - 10100	128104 ●
180	8.0 - 15.4	30	35	2/2	4300 - 8400	128105 ●
200	8.0 - 15.4	30	45	2/2	3900 - 7600	128106 ●
220	8.0 - 30.0	30	58	2/2	3500 - 6000	024663 ●

Extension part

SW 501 1, WW 200 1 NN

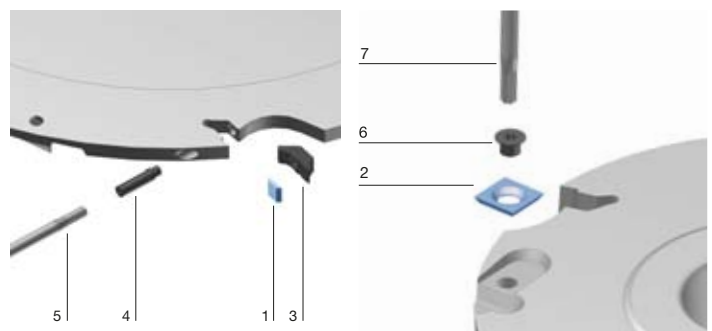
D	SB	BO	BO _{max}	Z	n	ID
mm	mm	mm	mm		min ⁻¹	
150	7.7	30	50	2	5200 - 10100	128134
180	7.7	30	50	2	4300 - 8400	128135 ●
200	7.7	30	50	2	3900 - 7600	128136 ●
220	15	30	45	2	3500 - 6000	024666 ●

Spare knives:

Part-no.	BEZ	ABM	QAL	VE	ID
		mm		PCS	
1	Turnblade knife	7.7x8x1.5	HW-05	10	005053 ●
1	Turnblade knife	14.7x8x1.5	HW-05	10	005056 ●
2	Turnblade spur VS1	14x14x2	HW-F	10	005099 ●
2	Turnblade spur VS2	19x19x2	HW-F	10	005115 ●

Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
3	Clamping wedge	7x18.75x8.27	009763 ●
3	Clamping wedge	13x18.75x8.27	009670 ●
4	Allen screw with shank, Torx® 15	M5x20	007380 ●
4	Clamping screw w. disc, Torx® 25	M6x18.5	007442 ●
5	Torx® key	Torx® 15	117507 ●
5	Torx® key	Torx® 25	117504 ●
6	Countersink screw, Torx® 20	M6x0.5x4.9	006243 ●
7	Torx® key	Torx® 20	117503 ●
	Setting gauge for knives	0.3/0.8	005374 ●



4. Manual feed

4.1 Grooving

4.1.2 Grooving cutterheads



Grooving cutterhead - steplessly adjustable

Application:

For cutting different groove widths.

Machine:

Spindle moulders, moulders, edgbanding machines and double-end tenoners.

Workpiece material:

Solid wood; uncoated, coated and veneered wood derived materials.

Technical information:

Stepless adjustment of cutting width possible when installed on machine.
2 part design.



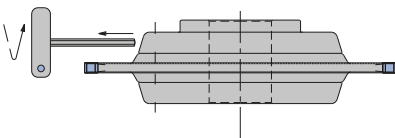
Mounted on sleeve; SB 4.0 - 15.0 mm

SW 502 1 01

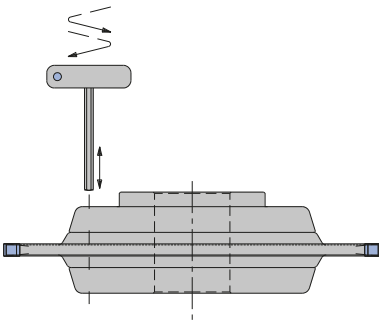
D	SB	BO	BO _{max}	NT	Z	n	ID
mm	mm	mm	mm	mm		min ⁻¹	
180	4.0 - 7.5	30	35	40	2/2	4300 - 8400	128154 ●
180	8.0 - 15.0	30	35	40	2/2	4300 - 8400	128155 ●
180	4.0 - 7.8	40	50	35	2/2	4300 - 8400	128156 ●
180	8.0 - 15.0	40	50	35	2/2	4300 - 8400	128157 ●

Spare knives:

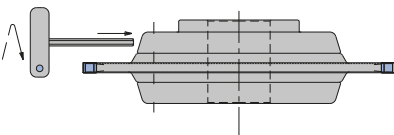
Part-no.	BEZ	ABM	QAL	VE	ID
		mm		PCS	
1	Turnblade knife	18x18x1.95	HW	10	005114 ●
2	Turnblade knife	7.7x8x1.5	HW-05	10	005053 ●
3	Turnblade spur VS4	14x14x1.2	HW	10	005130 ●
4	Turnblade spur VS2	19x19x2	HW-F	10	005115 ●



Opening the clamping system



Adjustment: SB larger „+“,
SB smaller „-“

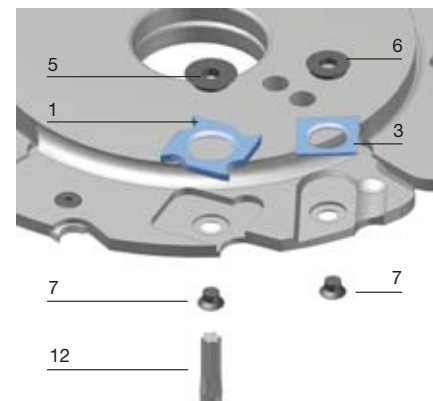
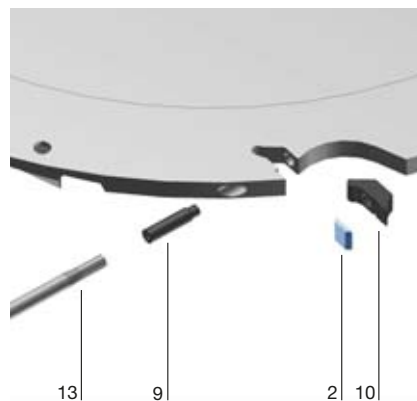


Closing the clamping system

After the tool is mounted on the spindle it can be adjusted and clamped using a hexagon key

Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
5	Special nut for WPL	M11.9/2.20	005653 ●
6	Special nut for VS	M9.9/1.60	005654 ●
7	Countersink screw, Torx® 9	M4x0.5x3.2	006057 ●
8	Countersink screw, Torx® 20	M6x0.5x4.9	006243 ●
9	Allen screw with shank, Torx® 15	M5x20	007380 ●
10	Clamping wedge	7x18.75x8.27	009763 ●
11	Torx® key	Torx® 20	117503 ●
12	Torx® key	Torx® 9	005463 ●
13	Torx® key	Torx® 15	117507 ●
	Setting gauge for knives	0.3/0.8	005374 ●



5. Routing

5.2 Jointing, rebating and bevelling

5.2.1 Jointing and rebating tools



Turnblade jointing / rebating cutterhead

Application:

Optimized for rebating, jointing and grooving with and against feed.

Machine:

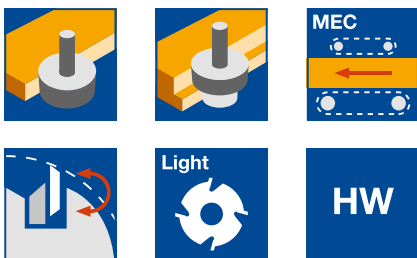
Stationary routers with/without CNC control, CNC machining centres.

Workpiece material:

Softwood and hardwood, compound materials of solid wood and wood derived materials, uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

Technical information:

Cutterhead with turnblades and alternate shear angle, righthand rotation. Tool body in lightweight aluminium for a better dynamic situation.



HW, Z 2 / V 2

SL 199 2, SW 500 2

Tool Type	QAL	Z	V	ID
Cutterhead with spacers	HW	2	2	126039 ●
Cutterhead mounted on arbor	HW	2	2	426080 □

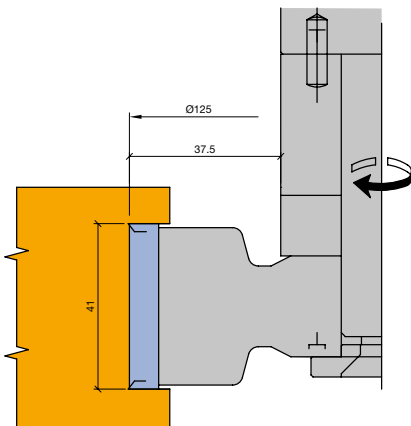
RPM: $n_{max} = 13700 \text{ min}^{-1}$

Spare knives:

BEZ	ABM	ID
	mm	
Turnblade knife	40x8x1.5	005074 ●
Turnblade spur VS2	19x19x2	005115 ●

Spare parts:

BEZ	ABM	ID
	mm	
Clamping wedge	38x18.75x8.27	009675 ●
Countersink screw, Torx® 20	M5x8.5	007808 ●
Clamping screw w. disc, Torx® 25	M6x18.5	007442 ●
Cylindrical screw with ISK	M5x80	007097 ●
Torx® key	Torx® 20	117503 ●
Torx® key	Torx® 25	117504 ●
Allen key	SW 4, L 100	005451 ●



Order example:

Tool set ID **426080** mounted on arbor

ID **042847**, HSK-F 63 (A = 80 mm).

When ordering choose arbors with

d = 20 mm and clamping length 70 mm.

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