

3. Planing and profiling

3.4 Finger jointing

3.4.1 Minifinger joint cutters

WF 620 2/WF 620 2 06 Minifinger joint cutter



Minifinger joint cutters with straight cut, straight back relief, staggered profile teeth, secured against twisting by design of tool body. Solid and robust cutter design with individually embedded tips.

Table for allowed RPM $n = \text{min}^{-1}$ in relation to finger length ZL and diameter D. Zero-diameter D_0 in relation to finger length for adjustment of the machine spindles.

| ZL mm | D mm | D_0 mm | $n_{\text{max.}}$ min^{-1} |
|----------|---------|-------------|--|
| 10 | 160 | 140 | 9,000 |
| 6 | 160 | 148 | 9,000 |
| 15 | 170 | 140 | 8,500 |
| 20 | 180 | 140 | 8,000 |
| 10 | 250 | 230 | 6,200 |
| 15 | 260 | 230 | 6,000 |
| 20 | 260 | 220 | 6,000 |

Application

For self-locking longitudinal joints for all kinds "in load bearing" components and window blanks with continuous finger joint.

Cutting material

HS, Marathon (MC) and HW.

Resharpener area

12 mm.

Feed rate

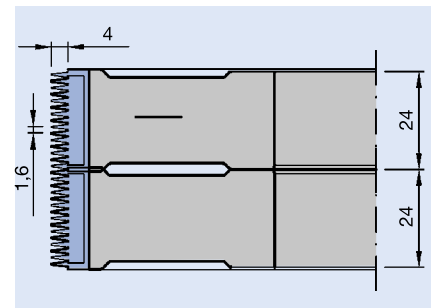
Depending on RPM up to 24 m min^{-1} .

Minifinger joint cutter pitch 1.6 mm

Standard cutting width
Minifinger joint cutter WF 620 2
Finger length = 4 mm
D = 160 mm
Finger pitch 1.6 mm

Table to determine the number of cutters for a given wood thickness and cutting width.

| | |
|----------------|-------------------|
| SB | 25.0 mm |
| Hub | 24.0 mm |
| No. of fingers | Wing row ZA 15 |
| Wood thickness | No. of cutters |
| 23 | 1 |
| 47 | 2 |
| 71 | 3 |
| 95 | 4 |
| 119 | 5 |



Архангельск (8182)63-90-72
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
Калуга (4842)92-23-67
Кемерово (3842)65-04-62
Киров (8332)68-02-04
Краснодар (861)203-40-90
Красноярск (391)204-63-61
Курск (4712)77-13-04
Липецк (4742)52-20-81
Киргизия (996)312-96-26-47

Магнитогорск (3519)55-03-13
Москва (495)268-04-70
Мурманск (8152)59-64-93
Набережные Челны (8552)20-53-41
Нижний Новгород (831)429-08-12
Новокузнецк (3843)20-46-81
Новосибирск (383)227-86-73
Омск (3812)21-46-40
Орел (4862)44-53-42
Оренбург (3532)37-68-04
Пенза (8412)22-31-16
Россия (495)268-04-70

Пермь (342)205-81-47
Ростов-на-Дону (863)308-18-15
Рязань (4912)46-61-64
Самара (846)206-03-16
Санкт-Петербург (812)309-46-40
Саратов (845)249-38-78
Севастополь (8692)22-31-93
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

3.4 Finger jointing 3.4.1 Minifinger joint cutters

Minifinger joint cutter

WF 620 2/WF 620 06

Standard minifinger joint cutter
Finger length 10 mm and 15 mm
D = 160/250 mm 170/260 mm

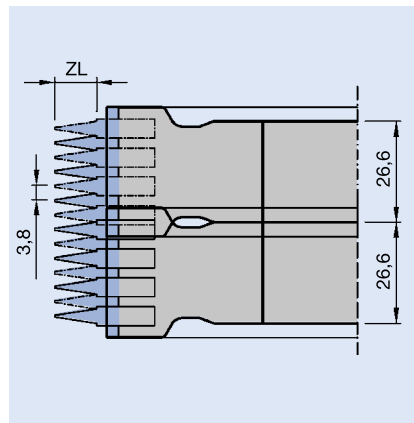
Finger pitch = 3.8 mm

Minifinger joint cutter

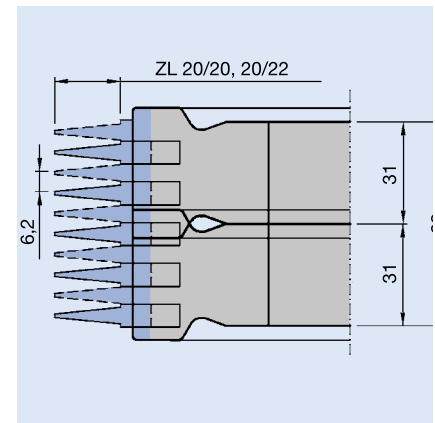
WF 620 2/WF 620 06

Standard minifinger joint cutter
Finger length 20 mm
D = 180/260 mm

Finger pitch = 6.2 mm



Minifinger joint cutter pitch 3.8 mm, finger length 10 or 15 mm.



Minifinger joint cutter pitch 6.2 mm.

Minifinger joint cutter with pitch of 3.8 mm

| | |
|----------------|-------------------|
| SB | 28.6 mm |
| Hub | 26.6 mm |
| ZA | Tooth row ZA 7 |
| Wood thickness | Number of cutters |
| 24 | 1 |
| 51 | 2 |
| 77 | 3 |
| 104 | 4 |
| 131 | 5 |
| 157 | 6 |
| 184 | 7 |
| 210 | 8 |
| 237 | 9 |
| 264 | 10 |
| 290 | 11 |
| 317 | 12 |

Minifinger joint cutter with pitch of 6.2 mm

| | |
|----------------|-------------------|
| SB | 33.0 mm |
| Hub | 31.0 mm |
| ZA | Tooth row ZA 5 |
| Wood thickness | Number of cutters |
| 28 | 1 |
| 59 | 2 |
| 90 | 3 |
| 121 | 4 |
| 152 | 5 |
| 183 | 6 |
| 214 | 7 |
| 245 | 8 |
| 278 | 9 |
| 397 | 10 |
| 338 | 11 |

3. Planing and profiling

3.4 Finger jointing 3.4.1 Minifinger joint cutters



Minifinger joint cutter, HS

Application:

For self-locking longitudinal joints. See section introduction for additional information.

Machine:

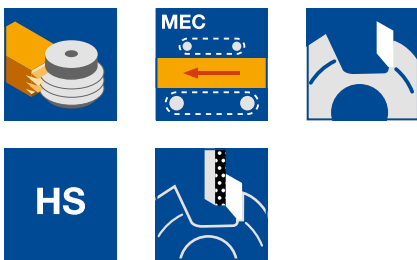
Finger joint machines with/without cut-off saw, continuous machines.

Workpiece material:

Softwood, across grain; limited suitability for hardwood.

Technical information:

Reduced risk of breakage from individually brazed finger cutting edges. Design with enlarged tip gap suitable for PU adhesives and for finger joint machines without cut-off saw and horizontal working spindle. Cutting material HS. Resharpener area 12 mm.



ZL 4 mm, TG 1.6 mm

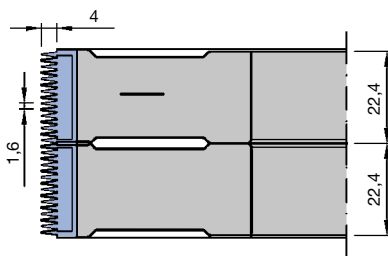
WF 620 2

| D | SB | ND | BO | Z | ZA | QAL | ZL | ID |
|-----|----|------|----|-----|-----|-----|----|-----------------|
| mm | mm | mm | mm | | PCS | | mm | |
| 160 | 25 | 22.4 | 50 | 2/2 | 15 | HS | 4 | 021543 ● |

ZL 10 mm, TG 3.8 mm

WF 620 2

| D | SB | ND | BO | Z | ZA | QAL | ID | ID |
|-----|------|------|----|-----|-----|-----|-----------------|-----------------|
| mm | mm | mm | mm | | PCS | | ZL | ZL |
| | | | | | | | 10/10 | 10/11 |
| 160 | 28.6 | 26.6 | 50 | 2/2 | 7 | HS | 021685 ● | 021689 ● |
| 160 | 28.6 | 26.6 | 50 | 3/3 | 7 | HS | 120313 □ | 021692 ● |
| 250 | 28.6 | 26.6 | 50 | 3/3 | 7 | HS | 021688 □ | 021693 ● |
| 250 | 28.6 | 26.6 | 50 | 4/4 | 7 | HS | 120316 □ | 120318 □ |

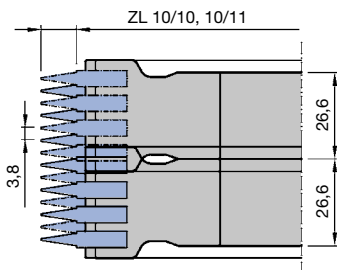


Minifinger joint cutter ZL 4 mm, TG 1.6 mm

ZL 15 mm, TG 3.8 mm

WF 620 2

| D | SB | ND | BO | Z | ZA | QAL | ID | ID |
|-----|------|------|----|-----|-----|-----|-----------------|-----------------|
| mm | mm | mm | mm | | PCS | | ZL | ZL |
| | | | | | | | 15/15 | 15/16.5 |
| 170 | 28.6 | 26.6 | 50 | 2/2 | 7 | HS | 021694 ● | 021696 ● |
| 260 | 28.6 | 26.6 | 50 | 3/3 | 7 | HS | 021695 □ | 021697 ● |
| 260 | 28.6 | 26.6 | 80 | 4/4 | 7 | HS | 120420 | 120422 |

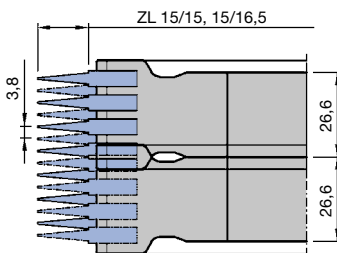


Minifinger joint cutter ZL 10 mm, TG 3.8 mm

ZL 15 mm, TG 3.8 mm, for application with PU glue

WF 620 2

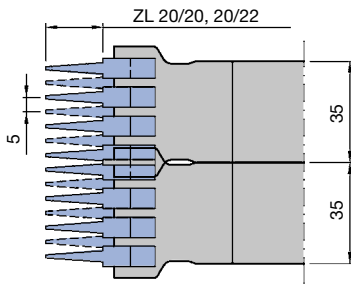
| D | SB | ND | BO | Z | ZA | QAL | ID | ID |
|-----|------|------|----|-----|-----|-----|-----------------|-----------------|
| mm | mm | mm | mm | | PCS | | ZL | ZL |
| | | | | | | | 15/15 | 15/16.5 |
| 170 | 28.6 | 26.6 | 50 | 2/2 | 7 | HS | 120412 ● | 120414 □ |
| 260 | 28.6 | 26.6 | 50 | 3/3 | 7 | HS | 120413 □ | 120415 □ |
| 260 | 28.6 | 26.6 | 80 | 4/4 | 7 | HS | 120421 | 120423 |



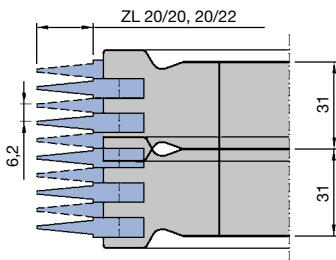
Minifinger joint cutter ZL 15 mm, TG 3.8 mm

3. Planing and profiling

3.4 Finger jointing 3.4.1 Minifinger joint cutters



Minifinger joint cutter ZL 20 mm,
TG 5.0 mm



Minifinger joint cutter ZL 20 mm,
TG 6.2 mm

ZL 20 mm, TG 5.0 mm

WF 620 2

| D mm | SB mm | ND mm | BO mm | Z | ZA PCS | QAL | ID ZL 20/20 | ID ZL 20/22 |
|---------|----------|----------|----------|-----|-----------|-----|-------------------|-------------------|
| 180 | 37 | 35 | 50 | 2/2 | 7 | HS | 021729 ● | 021730 □ |

ZL 20 mm, TG 6.2 mm

WF 620 2

| D mm | SB mm | ND mm | BO mm | Z | ZA PCS | QAL | ID ZL 20/20 | ID ZL 20/22 |
|---------|----------|----------|----------|-----|-----------|-----|-------------------|-------------------|
| 180 | 33 | 31 | 50 | 2/2 | 5 | HS | 021668 ● | 021669 ● |
| 260 | 33 | 31 | 50 | 3/3 | 5 | HS | 021674 □ | 021670 □ |
| 260 | 33 | 31 | 80 | 4/4 | 5 | HS | 120525 | 120527 |

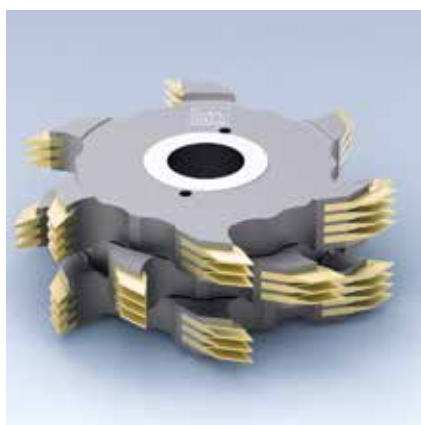
ZL 20 mm, TG 6.2 mm, for application with PU glue

WF 620 2

| D mm | SB mm | ND mm | BO mm | Z | ZA PCS | QAL | ID ZL 20/20 | ID ZL 20/22 |
|---------|----------|----------|----------|-----|-----------|-----|-------------------|-------------------|
| 180 | 33 | 31 | 50 | 2/2 | 5 | HS | 120515 ● | 120516 ● |
| 260 | 33 | 31 | 50 | 3/3 | 5 | HS | 120510 □ | 120511 □ |
| 260 | 33 | 31 | 80 | 4/4 | 5 | HS | 120524 | 120526 |

3. Planing and profiling

3.4 Finger jointing 3.4.1 Minifinger joint cutters



Minifinger joint cutter, Marathon

Application:

For self-locking longitudinal joints. See section introduction for additional information.

Machine:

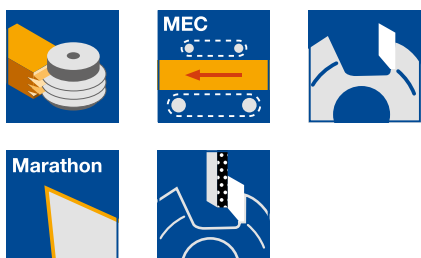
Finger joint machines with/without cut-off saw, continuous machines.

Workpiece material:

Softwood, across grain; also suitable for hardwood.

Technical information:

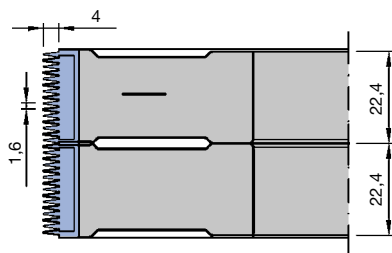
Reduced risk of breakage from individually brazed finger cutting edges. Design with enlarged tip gap suitable for PU adhesives and for finger joint machines without cut-off saws and horizontal working spindle. Marathon coating allows up to 4 times longer tool life compared to HS version. Resharpener area 12 mm (or 6 mm for ID 123005 and 8 mm for ID 123102).



ZL 4/5 mm, TG 1.6 mm

WF 620 2 06

| D | SB | ND | BO | Z | ZA | QAL | ZL | ID |
|-----|----|------|----|-----|-----|-----|-----|-----------------|
| mm | mm | mm | mm | | PCS | | mm | |
| 160 | 25 | 22.4 | 50 | 2/2 | 15 | MC | 4/5 | 123003 |
| 250 | 25 | 22.4 | 50 | 3/3 | 15 | MC | 4/5 | 123004 |
| 250 | 25 | 22.4 | 50 | 6/6 | 15 | MC | 4/5 | 123005 ● |

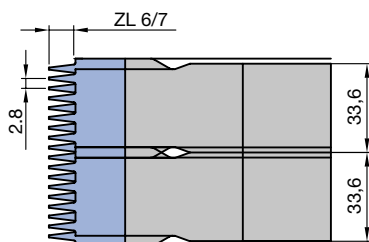


Minifinger joint cutter ZL 4 mm, TG 1.6 mm

ZL 6/7 mm, TG 2.8 mm

WF 620 2 06

| D | SB | ND | BO | Z | ZA | QAL | ZL | ID |
|-----|----|------|----|-----|-----|-----|-----|-----------------|
| mm | mm | mm | mm | | PCS | | mm | |
| 160 | 34 | 33.6 | 50 | 3/3 | 12 | MC | 6/7 | 123100 ● |
| 250 | 34 | 33.6 | 50 | 4/4 | 12 | MC | 6/7 | 123101 ● |
| 250 | 34 | 33.6 | 50 | 6/6 | 12 | MC | 6/7 | 123102 ● |

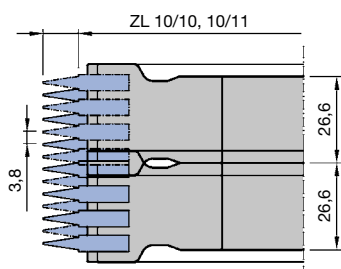


Minifinger joint cutter ZL 6/7 mm, TG 2.8 mm

ZL 10 mm, TG 3.8 mm

WF 620 2 06

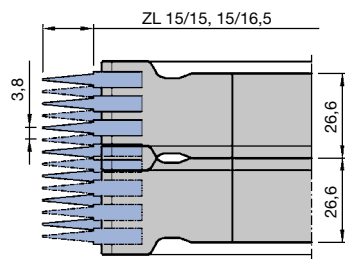
| D | SB | ND | BO | Z | ZA | QAL | ID | ID |
|-----|------|------|----|-----|-----|-----|-----------------|-----------------|
| mm | mm | mm | mm | | PCS | | ZL | ZL |
| | | | | | | | 10/10 | 10/11 |
| 160 | 28.6 | 26.6 | 50 | 2/2 | 7 | MC | 120608 ● | 120612 ● |
| 160 | 28.6 | 26.6 | 50 | 3/3 | 7 | MC | 120616 □ | 120617 □ |
| 250 | 28.6 | 26.6 | 50 | 3/3 | 7 | MC | 120609 □ | 120613 ● |
| 250 | 28.6 | 26.6 | 50 | 4/4 | 7 | MC | 120620 □ | 120622 □ |



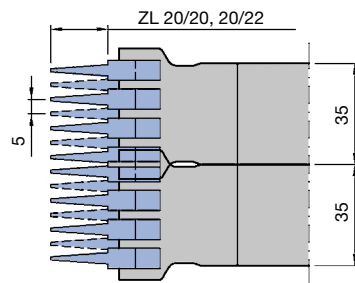
Minifinger joint cutter ZL 10 mm, TG 3.8 mm

3. Planing and profiling

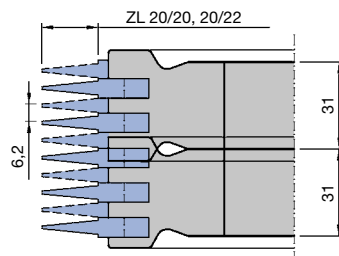
3.4 Finger jointing 3.4.1 Minifinger joint cutters



Minifinger joint cutter ZL 15 mm,
TG 3.8 mm



Minifinger joint cutter ZL 20 mm,
TG 5.0 mm



Minifinger joint cutter ZL 20 mm,
TG 6.2 mm

ZL 15 mm, TG 3.8 mm

WF 620 2 06

| D | SB | ND | BO | Z | ZA | QAL | ID | ID |
|-----|------|------|----|-----|-----|-----|--------|-------------------|
| mm | mm | mm | mm | | PCS | | ZL | ZL |
| 170 | 28.6 | 26.6 | 50 | 2/2 | 7 | MC | 15/15 | 15/16.5 |
| 260 | 28.6 | 26.6 | 50 | 3/3 | 7 | MC | 120710 | 120713 ● 120714 ● |
| 260 | 28.6 | 26.6 | 80 | 4/4 | 7 | MC | 120721 | 120723 |

ZL 15 mm, TG 3.8 mm, for application with PU glue

WF 620 2 06

| D | SB | ND | BO | Z | ZA | QAL | ID | ID |
|-----|------|------|----|-----|-----|-----|----------|----------|
| mm | mm | mm | mm | | PCS | | ZL | ZL |
| 170 | 28.6 | 26.6 | 50 | 2/2 | 7 | MC | 15/15 | 15/16.5 |
| 260 | 28.6 | 26.6 | 50 | 3/3 | 7 | MC | 120711 ● | 120715 □ |
| 260 | 28.6 | 26.6 | 80 | 4/4 | 7 | MC | 120712 □ | 120716 □ |
| 260 | 28.6 | 26.6 | 80 | 4/4 | 7 | MC | 120722 | 120724 |

ZL 20 mm, TG 5.0 mm

WF 620 2 06

| D | SB | ND | BO | Z | ZA | QAL | ID | ID |
|-----|----|----|----|-----|-----|-----|----------|----------|
| mm | mm | mm | mm | | PCS | | ZL | ZL |
| 180 | 37 | 35 | 50 | 2/2 | 7 | MC | 20/20 | 20/22 |
| 260 | 37 | 35 | 50 | 3/3 | 7 | MC | 120818 □ | 120820 □ |
| 260 | 37 | 35 | 50 | 3/3 | 7 | MC | 120819 □ | 120821 □ |

ZL 20 mm, TG 6.2 mm

WF 620 2 06

| D | SB | ND | BO | Z | ZA | QAL | ID | ID |
|-----|----|----|----|-----|-----|-----|----------|----------|
| mm | mm | mm | mm | | PCS | | ZL | ZL |
| 180 | 33 | 31 | 50 | 2/2 | 5 | MC | 20/20 | 20/22 |
| 260 | 33 | 31 | 50 | 3/3 | 5 | MC | 120810 ● | 120814 □ |
| 260 | 33 | 31 | 50 | 3/3 | 5 | MC | 120811 □ | 120815 □ |
| 260 | 33 | 31 | 80 | 4/4 | 5 | MC | 120834 | 120836 |

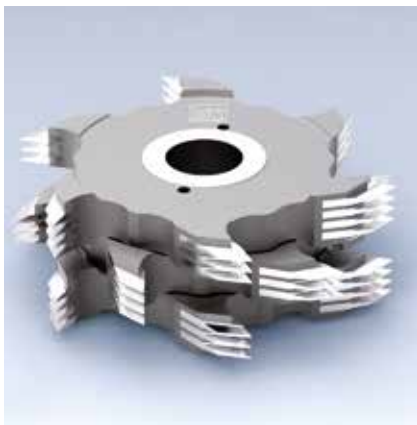
ZL 20 mm, TG 6.2 mm, for application with PU glue

WF 620 2 06

| D | SB | ND | BO | Z | ZA | QAL | ID | ID |
|-----|----|----|----|-----|-----|-----|----------|----------|
| mm | mm | mm | mm | | PCS | | ZL | ZL |
| 180 | 33 | 31 | 50 | 2/2 | 5 | MC | 20/20 | 20/22 |
| 260 | 33 | 31 | 50 | 3/3 | 5 | MC | 120812 ● | 120816 □ |
| 260 | 33 | 31 | 50 | 3/3 | 5 | MC | 120813 □ | 120817 □ |
| 260 | 33 | 31 | 80 | 4/4 | 5 | MC | 120835 | 120837 |

3. Planing and profiling

3.4 Finger jointing 3.4.1 Minifinger joint cutters



Minifinger joint cutter, HW

Application:

For self-locking longitudinal joints. See section introduction for additional information.

Machine:

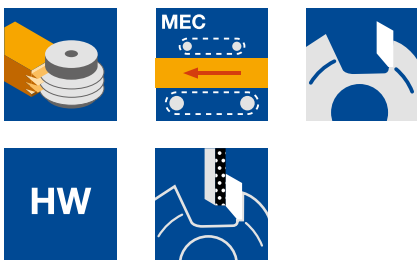
Finger joint machines with/without cut-off saws, continuous machines.

Workpiece material:

Hardwood, across grain.

Technical information:

Reduced risk of breakage from individually brazed finger cutting edges. Cutting material HW. Resharpener area 12 mm.



ZL 10 mm, TG 3.8 mm

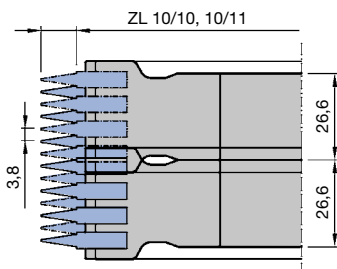
WF 620 2

| D mm | SB mm | BO mm | Z | ZA PCS | QAL | n _{max} min ⁻¹ | ID ZL | ID ZL |
|---------|----------|----------|-----|-----------|-----|---------------------------------------|----------|----------|
| 160 | 28.6 | 50 | 2/2 | 7 | HW | 8000 | 10/10 | 10/11 |
| 160 | 28.6 | 50 | 3/3 | 7 | HW | 8000 | 021604 | 021603 |
| 250 | 28.6 | 50 | 3/3 | 7 | HW | 6000 | 021605 | 021602 |

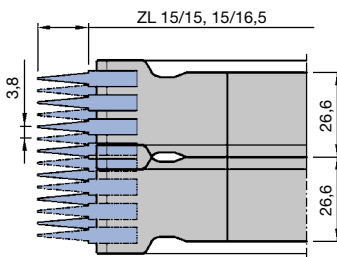
ZL 15 mm, TG 3.8 mm

WF 620 2

| D mm | SB mm | BO mm | Z | ZA PCS | QAL | n _{max} min ⁻¹ | ID ZL | ID ZL |
|---------|----------|----------|-----|-----------|-----|---------------------------------------|----------|----------|
| 170 | 28.6 | 50 | 2/2 | 7 | HW | 8000 | 15/15 | 15/16.5 |
| 260 | 28.6 | 50 | 3/3 | 7 | HW | 6000 | 021644 | 021645 |
| | | | | | | | 021652 | 021648 |



Minifinger joint cutter ZL 10 mm, TG 3.8 mm



Minifinger joint cutter ZL 15 mm, TG 3.8 mm

Table to determine the number of cutters for a given wood thickness.

Finger length 10 and 15 mm;

D = 160/250 mm and 170/260 mm

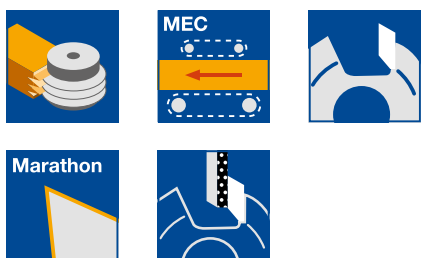
Finger pitch = 3.8 mm

| | |
|----------------|-----------------|
| SB | 28.6 mm |
| Hub | 26.6 mm |
| ZA | Tooth row ZA 7 |
| Wood thickness | Quantity cutter |
| 24 | 1 |
| 51 | 2 |
| 77 | 3 |
| 104 | 4 |
| 131 | 5 |
| 157 | 6 |
| 184 | 7 |
| 210 | 8 |
| 237 | 9 |
| 264 | 10 |
| 290 | 11 |
| 317 | 12 |

3. Planing and profiling

3.4 Finger jointing

3.4.2 High performance minifinger cutters



Minifinger joint cutter, Marathon, real Z 4

Application:

For self-locking longitudinal joints. See section introduction for additional information.

Machine:

High performance finger joint machines with/without cut-off saws.

Workpiece material:

Softwood, across grain; also suitable for hardwood.

Technical information:

High number of teeth tool design, top and bottom final cutters required. Assembly of tool set: see section introduction. Version with enlarged tip gap suitable for PU adhesives and for finger joint machines without cut-off saws for horizontal spindle. Marathon coating allows up to 4 times longer tool life compared to HS version. Resharpener area 12 mm.

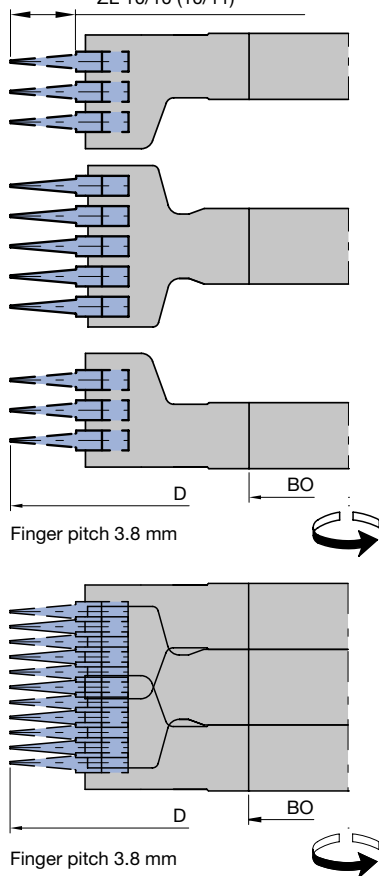
ZL 15 mm, TG 3.8 mm

WF 620 2 06, WF 623 2 06

| Tool Type | D mm | SB mm | ND mm | BO mm | Z | ZA PCS | QAL | ID ZL 15/15 | ID ZL 15/16.5 |
|---------------------|---------|----------|----------|----------|---|-----------|-----|-------------------|---------------------|
| Top final cutter | 170 | 20.2 | 16.6 | 50 | 4 | 3 | MC | 121700 □ | 121704 □ |
| Basic cutter | 170 | 35.4 | 19.0 | 50 | 4 | 5 | MC | 120705 □ | 120707 □ |
| Bottom final cutter | 170 | 20.2 | 16.6 | 50 | 4 | 3 | MC | 121701 □ | 121705 □ |

ZL 15/15 (15/16,5)

ZL 10/10 (10/11)



ZL 15 mm, TG 3.8 mm, for application with PU glue

WF 620 2 06, WF 623 2 06

| Tool Type | D mm | SB mm | ND mm | BO mm | Z | ZA PCS | QAL | ID ZL 15/15 | ID ZL 15/16.5 |
|---------------------|---------|----------|----------|----------|---|-----------|-----|-------------------|---------------------|
| Top final cutter | 170 | 20.2 | 16.6 | 50 | 4 | 3 | MC | 121702 ● | 121706 □ |
| Basic cutter | 170 | 35.4 | 19.0 | 50 | 4 | 5 | MC | 120706 ● | 120708 □ |
| Bottom final cutter | 170 | 20.2 | 16.6 | 50 | 4 | 3 | MC | 121703 ● | 121707 □ |
| Top final cutter | 200 | 20.2 | 16.6 | 60 | 4 | 3 | MC | 121708 | 121710 |
| Basic cutter | 200 | 35.4 | 19 | 60 | 4 | 5 | MC | 120725 | 120726 |
| Bottom final cutter | 200 | 20.2 | 16.6 | 60 | 4 | 3 | MC | 121709 | 121711 |

Finger length 10 and 15 mm

TG: 3,8 mm

Real Z4

| | | Basic cutter | Final cutter top | Final cutter bottom |
|----|-----|--------------------|------------------------|---------------------------|
| ZA | | 5 | 3 | 3 |
| ND | | 19 | 16,6 | 16,6 |
| HD | KLH | Cutter quantity | Cutter quantity | Cutter quantity |
| | 19 | 33,2 | 0 | 1 |
| | 38 | 52,2 | 1 | 1 |
| | 57 | 71,2 | 2 | 1 |
| | 76 | 90,2 | 3 | 1 |
| | 95 | 109,2 | 4 | 1 |
| | 114 | 128,2 | 5 | 1 |
| | 133 | 147,2 | 6 | 1 |
| | 152 | 166,2 | 7 | 1 |
| | 171 | 185,2 | 8 | 1 |
| | 190 | 204,2 | 9 | 1 |
| | 209 | 223,2 | 10 | 1 |
| | 228 | 242,2 | 11 | 1 |
| | 247 | 261,2 | 12 | 1 |
| | 266 | 280,2 | 13 | 1 |
| | 285 | 299,2 | 14 | 1 |
| | 304 | 318,2 | 15 | 1 |
| | 323 | 337,2 | 16 | 1 |

HD = wood thickness
KLH = clamping height

3. Planing and profiling

3.4 Finger jointing

3.4.2 High performance minifinger cutters



Minifinger joint cutter and shoulder cutter, Marathon, real Z 6

Application:

For self-locking longitudinal joints with straight visible joint for horizontal joints, e.g. solid wood panels or finger jointed profile strips. See section introduction for additional information.

Machine:

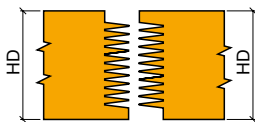
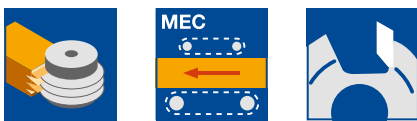
High performance finger joint machines with cut-off saw.

Workpiece material:

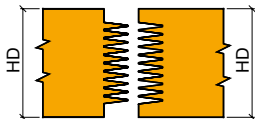
Softwood, across grain; also suitable for hardwood.

Technical information:

High number of teeth tool design. Tool set consists of basic cutter, extension cutter and shoulder cutters for different positions of the visible joint. Cutting width adjusted to wood thickness. Mounted on clamping sleeve. Marathon coating allows up to 4 times longer tool life compared to HS version. Resharpener area 12 mm.



Profile 2



Profile 3

Basic- / extension cutter ZL 10/11 mm, TG 3.8 mm

WF 620 2 06, WF 623 2 06

| Tool Type | D mm | SB mm | ND mm | BO mm | Z | ZA PCS | QAL | DRI | ID |
|------------------|---------|----------|----------|----------|---|-----------|-----|-----|-----------------|
| Basic cutter | 250 | 20.2 | 11.2 | 60 | 6 | 3 | MC | RH | 120624 □ |
| Extension cutter | 250 | 5.0 | 11.2 | 60 | 6 | 1 | MC | LH | 121608 □ |
| Extension cutter | 250 | 5.0 | 11.2 | 60 | 6 | 1 | MC | RH | 121609 □ |
| Extension cutter | 250 | 12.6 | 11.2 | 60 | 6 | 2 | MC | LH | 121610 □ |
| Extension cutter | 250 | 12.6 | 11.2 | 60 | 6 | 2 | MC | RH | 121611 □ |

Shoulder cutter profile 2 and 3 for ZL 10/11 mm, TG 3.8 mm

WF 621 2 06

| D mm | SB mm | BO mm | Z | QAL | ID LH | ID RH |
|---------|----------|----------|---|-----|-----------------|-----------------|
| 249.7 | 12 | 60 | 6 | MC | 122400 □ | 122401 □ |

Clamping sleeve with threaded nut for LH/RH rotation

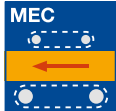
TB 270 0

| D mm | BO mm | NL mm | GL mm | ID |
|---------|----------|----------|----------|-----------------|
| 60 | 50 | 85 | 105 | 029474 ● |
| 60 | 50 | 120 | 140 | 029475 ● |
| 60 | 50 | 150 | 170 | 029476 ● |
| 60 | 50 | 180 | 200 | 029477 ● |
| 60 | 50 | 210 | 230 | 029478 ● |
| 60 | 50 | 240 | 260 | 029479 ● |

Spacer

TR 100 0

| D mm | B mm | BO mm | ID |
|---------|---------|----------|-----------------|
| 90 | 3.8 | 60 | 028447 ● |
| 90 | 11.4 | 60 | 028448 ● |



Minifinger joint cutter, Marathon, real Z 6

Application:

For self-locking longitudinal joints. See section introduction for additional information.

Machine:

High performance finger joint machines with/without cut-off saws.

Workpiece material:

Softwood, across grain; also suitable for hardwood.

Technical information:

High number of teeth tool design, top and bottom final cutters required. Assembly of tool set: see section introduction. Version with enlarged tip gap suitable for PU adhesives and for finger joint machines without cut-off saws for horizontal spindle. Marathon coating allows up to 4 times longer tool life compared to HS version. Resharpener area 12 mm.

ZL 10 mm, TG 3.8 mm

WF 620 2 06, WF 623 2 06

| Tool Type | D mm | SB mm | ND mm | BO mm | Z | ZA PCS | QAL | ZL mm | ID |
|---------------------|---------|----------|----------|----------|---|-----------|-----|----------|-----------------|
| Top final cutter | 250 | 26.6 | 19 | 50 | 6 | 4 | MC | 10/11 | 121012 ● |
| Basic cutter | 250 | 49.4 | 26.6 | 50 | 6 | 7 | MC | 10/11 | 120601 ● |
| Bottom final cutter | 250 | 26.6 | 19 | 50 | 6 | 4 | MC | 10/11 | 121013 ● |

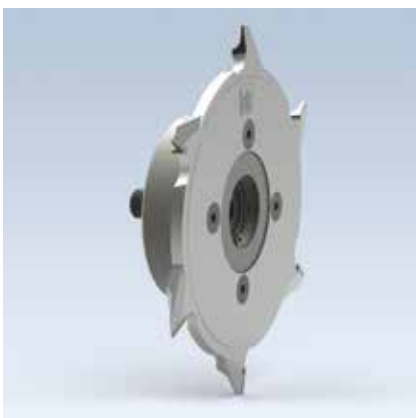
Finger length 10 mm and 15 mm

TG: 3,8 mm

Real Z6

| | | Basic cutter | Final cutter top | Final cutter bottom |
|----|-----|--------------------|------------------------|---------------------------|
| ZA | | 7 | 4 | 4 |
| ND | | 26,6 | 19 | 19 |
| HD | KLH | Cutter quantity | Cutter quantity | Cutter quantity |
| | 27 | 38 | 0 | 1 |
| | 53 | 64,6 | 1 | 1 |
| | 80 | 91,2 | 2 | 1 |
| | 106 | 117,8 | 3 | 1 |
| | 133 | 144,4 | 4 | 1 |
| | 160 | 171 | 5 | 1 |
| | 186 | 197,6 | 6 | 1 |
| | 213 | 224,2 | 7 | 1 |
| | 239 | 250,8 | 8 | 1 |
| | 266 | 277,4 | 9 | 1 |
| | 293 | 304 | 10 | 1 |

HD = wood thickness
KLH = clamping height



Application:

For finish cutting of radii on postforming profiles.

Machine:

Postforming units.

Workpiece material:

HPL, CPL or veneer coated chip and fibre boards (chipboard, MDF etc.).

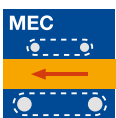
Technical information:

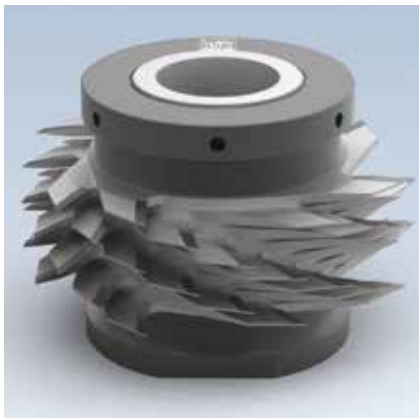
Cutterhead with DP tipped profile knives and HSK 25 R adaptor. Suitable for finish cutting of all radii up to R 14 mm.

7° inclined spindle

WF 556 2

| Machine | D mm | SB mm | BO mm | Z | QAL | n _{max} min ⁻¹ | Spindle angle ° | ID LH | ID RH |
|------------|---------|----------|----------|---|-----|---------------------------------------|--------------------|---------------|---------------|
| Homag, IMA | 125 | 5.1 | HSK 25 R | 6 | DP | 12000 | 7 | 192666 | 192667 |





Minifinger disc cutter, HW, with and without shoulder cutter

Application:

For self-locking longitudinal joints for non-supporting components, e.g. panels and strips.

Machine:

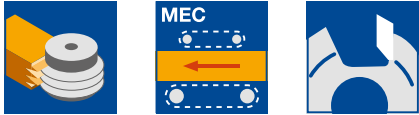
Finger joint machines with cut-off saws.

Workpiece material:

Hardwood and abrasive tropical wood.

Technical information:

HW tipped cutters. Tool body thickness corresponds to finger pitch. Particularly suitable for horizontal joints with and without shoulders. Variable design for defined wood thicknesses from 15 to 80 mm. Suitable for small wood thicknesses. Resharpening area 3.5 mm. Design in DP on request.



HW, ZL 10/11 mm, TG 3.8 mm

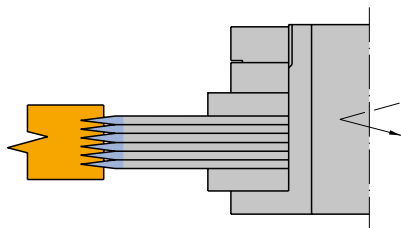
WF 620 2, WF 621 2

| Tool Type | D mm | SB mm | BO mm | Z | n_{\max} min^{-1} | ID |
|-------------------------|---------|----------|----------|---|---------------------------------|-----------------|
| Minifinger joint cutter | 160 | 3.8 | 70 | 2 | 9000 | 022200 ● |
| Minifinger joint cutter | 160 | 3.8 | 70 | 4 | 9000 | 021511 ● |
| Minifinger joint cutter | 250 | 3.8 | 70 | 6 | 6000 | 021513 ● |
| Shoulder cutter | 159.8 | 15.2 | 70 | 4 | 9000 | 021762 ● |
| Shoulder cutter P3 | 249.7 | 15.2 | 70 | 6 | 6000 | 021764 ● |
| Shoulder cutter P5 | 239.7 | 15.2 | 70 | 6 | 6000 | 022153 ● |

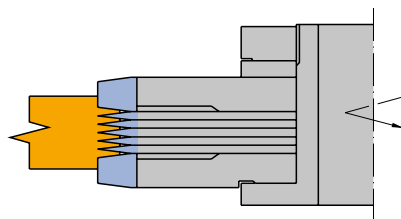
HW, ZL 10/11.5 mm, TG 4.0 mm

WF 620 2, WF 621 2

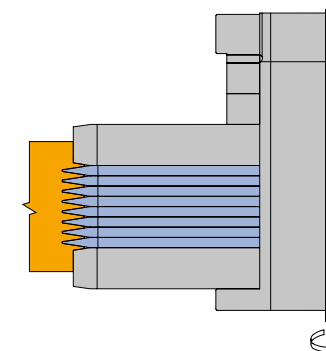
| Tool Type | D mm | SB mm | BO mm | Z | n_{\max} min^{-1} | ID |
|-------------------------|---------|----------|----------|---|---------------------------------|-----------------|
| Minifinger joint cutter | 160 | 4 | 70 | 2 | 9000 | 021509 ● |
| Shoulder cutter | 159.9 | 16 | 70 | 2 | 9000 | 022204 ● |



Minifinger joint cutterset without shoulder cutters



Minifinger joint cutterset with shoulder cutters P3



Clamping element with threaded nut

TB 270 0

| D mm | BO mm | NL mm | GL mm | DRI | ID |
|---------|----------|----------|----------|--------|-----------------|
| 70 | 50 | 116 | 146 | LH, RH | 029695 ● |
| 70 | 50 | 80 | 110 | LH, RH | 029473 ● |

Spare parts:

| BEZ | ABM mm | ID |
|---------------------------|---------------------------------|-----------------|
| Sickle spanner adjustable | D90/155; L290; DIN1816; tenon 6 | 005462 ● |

Spacers

TR 100 0

| D mm | B mm | BO mm | TG | ID |
|---------|---------|----------|-----|-----------------|
| 100 | 3.8 | 70 | 3.8 | 028437 ● |
| 100 | 11.4 | 70 | 3.8 | 028450 ● |
| 100 | 15.2 | 70 | 3.8 | 028439 ● |
| 175 | 11.4 | 70 | 3.8 | 028678 ● |

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