

8. Knives and spare parts

8.1 Knives and blank knives

8.1.5 Planer knives



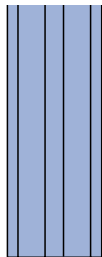
Turnblade planing knives CentroStar, CentroFix, QuickFix

For cutterhead system CentroStar, CentroFix, QuickFix - HS

AT 103 0 02, AT 103 0 20

Cutting material recommendation	HS	MC	HW
Solid wood dry	◆	◆	
Solid wood wet	◇	◆	
Hardwood dry		◇	◆
Hardwood wet		◆	◆
Glulam		◆	◆
Clipboard			◇
MDF			◇

◆ suitable ◇ partly suitable



SB	H	DIK	SET	QAL	ID
mm	mm	mm	PCS		
100	12	2.7	4	HS	610203 ●
120	12	2.7	4	HS	610204 ●
124.6	12	2.7	4	HS	610244 ●
130	12	2.7	4	HS	610205 ●
136	12	2.7	4	HS	610206 ●
150	12	2.7	4	HS	610208 ●
166	12	2.7	4	HS	610286 ●
170	12	2.7	4	HS	610210 ●
180	12	2.7	4	HS	610211 ●
186	12	2.7	3	HS	610247 ●
190	12	2.7	4	HS	610212 ●
210	12	2.7	4	HS	610213 ●
230	12	2.7	4	HS	610214 ●
236	12	2.7	4	HS	610287 ●
240	12	2.7	4	HS	610215 ●
256	12	2.7	4	HS	610288 ●
260	12	2.7	4	HS	610017 ●
310	12	2.7	4	HS	610018 ●
400	12	2.7	4	HS	610022 ●
410	12	2.7	4	HS	610023 ●
410	12	2.7	3	HS	610043 ●
420	12	2.7	4	HS	610024 ●
430	12	2.7	4	HS	610025 ●
500	12	2.7	4	HS	610028 ●
510	12	2.7	4	HS	610029 ●
520	12	2.7	4	HS	610030 ●
530	12	2.7	4	HS	610031 ●
540	12	2.7	4	HS	610032 ●
610	12	2.7	4	HS	610034 ●
630	12	2.7	4	HS	610036 ●
640	12	2.7	4	HS	610038 ●
710	12	2.7	4	HS	610040 ●
810	12	2.7	4	HS	610042 ●

Turnblade knife CentroFix

Cutting material:

HS

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
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Симферополь (3652)67-13-56
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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

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8.1 Knives and blank knives

8.1.5 Planer knives



For cutterhead system CentroStar, CentroFix, QuickFix - MC
AT 103 0 20

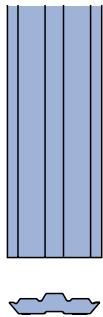
SB	H	DIK	SET	QAL	ID
mm	mm	mm	PCS		
100	12	2.7	4	MC	610278 ●
120	12	2.7	4	MC	610279
130	12	2.7	4	MC	610280 ●
150	12	2.7	4	MC	610281
180	12	2.7	4	MC	610282 ●
230	12	2.7	4	MC	610283 ●
240	12	2.7	4	MC	610284 ●
310	12	2.7	4	MC	610285

Cutting material recommendation	HS	MC	HW
Solid wood dry	◆	◆	
Solid wood wet	◇	◆	
Hardwood dry		◇	◆
Hardwood wet		◆	◆
Glulam		◆	◆
Clipboard			◇
MDF			◇

◆ suitable ◇ partly suitable

Cutting material:

MC



Turnblade knife CentroFix

Cutting material:

HW-F

For cutterhead system CentroStar, CentroFix, QuickFix - HW-F
AT 103 0 20, TM 410 0 02

SB	H	DIK	SET	QAL	ID
mm	mm	mm	PCS		
100	12	2.7	2	HW-F	610606 ●
120	12	2.7	2	HW-F	610610 ●
130	12	2.7	2	HW-F	610612 ●
136	12	2.7	2	HW-F	610614 ●
150	12	2.7	2	HW-F	610616 ●
166	12	2.7	2	HW-F	610680 ●
170	12	2.7	2	HW-F	610620 ●
180	12	2.7	2	HW-F	610621 ●
190	12	2.7	2	HW-F	610625 ●
210	12	2.7	2	HW-F	610627 ●
230	12	2.7	2	HW-F	610629 ●
236	12	2.7	2	HW-F	610679 ●
240	12	2.7	2	HW-F	610631 ●
256	12	2.7	2	HW-F	610681
400	12	2.7	1	HW-F	612016 ●
410	12	2.7	1	HW-F	612017 ●
420	12	2.7	1	HW-F	612018 ●
430	12	2.7	1	HW-F	612019 ●
500	12	2.7	1	HW-F	612022 ●
510	12	2.7	1	HW-F	612023 ●
520	12	2.7	1	HW-F	612024 ●
530	12	2.7	1	HW-F	612025 ●
540	12	2.7	1	HW-F	612026 ●

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Cutting material recommendation	HS	HW
Solid wood dry	◆	
Solid wood wet	◇	
Hardwood dry		◆
Hardwood wet		◆
Glulam		◆
Clipboard		◇
MDF		◇

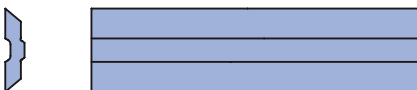
◆ suitable ◇ partly suitable

Cutting material:

HS / HW

Cutting material:

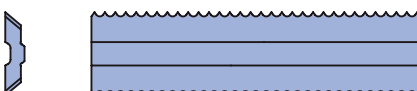
HW



Turnblade knife VariPlan HS / HW
resharpenable, for finish cutting of
softwood and hardwood



Turnblade knife VariPlan HW Integral
resharpenable, for pre and finish cutting
softwood and hardwood



Turnblade knife VariPlan HW RipTec
resharpenable, for pre-cutting softwood
and hardwood

Turnblade planing knives VariPlan / VariPlan Plus

For cutterhead system VariPlan / VariPlan Plus

AT 103 0 03, AT 103 0 27

SB mm	H mm	DIK mm	SET PCS	ID Type HS	ID Type HW Microfinish
50	16	3.7	2	610500 □	617100 □
60	16	3.7	2	610501 □	617101 □
80	16	3.7	2	610502 □	617102 □
100	16	3.7	2	610504 ●	617104 □
120	16	3.7	2	610505 ●	617105 □
130	16	3.7	2	610506 ●	617106 ●
150	16	3.7	2	610509 ●	617109 ●
166	16	3.7	2	610571 □	617171 ●
170	16	3.7	2	610511 ●	617111 ●
180	16	3.7	2	610512 ●	617112 ●
190	16	3.7	2	610514 ●	617114 ●
210	16	3.7	2	610515 ●	617115 ●
230	16	3.7	2	610516 ●	617116 ●
236	16	3.7	2	610569 □	617169 ●
240	16	3.7	2	610518 ●	617118 ●
256	16	3.7	2	610572 □	617172 ●
270	16	3.7	2		617165 ●
310	16	3.7	2	610522 ●	617122 ●
330	16	3.7	2		617124 □
360	16	3.7	2		617125 □
400	16	3.7	2	610526 □	617126 □
410	16	3.7	2	610527 ●	617127 □
410	16	3.7	3	610528 □	
420	16	3.7	2	610529 □	617129 □
430	16	3.7	2	610530 □	617130 □
500	16	3.7	2	610533 ●	617133 □
510	16	3.7	4	610562 □	617162 □
520	16	3.7	4	610563 □	617163 □
530	16	3.7	2	610536 □	617136 □
540	16	3.7	2	610537 □	617137 □
600	16	3.7	2	610538 ●	617138 □
610	16	3.7	2	610539 □	617139 □
630	16	3.7	2	610541 ●	617141 □
640	16	3.7	4	610564 □	617164 □

For cutterhead system VariPlan Plus

AT 103 0 23, AT 103 0 24

SB mm	H mm	DIK mm	SET PCS	ID Type HW	ID Type HW
				Integral	RipTec
100	16	3.7	2	611904	611204 □
120	16	3.7	2	611905	611205 □
130	16	3.7	2	611906 ●	611206 ●
150	16	3.7	2	611909	611209 ●
166	16	3.7	2		611271 ●
170	16	3.7	2	611911 ●	611211 ●
180	16	3.7	2	611912 ●	611212 ●
190	16	3.7	2	611914	611214 ●
210	16	3.7	2	611915	611215 ●
230	16	3.7	2	611916	611216 ●
236	16	3.7	2		611269 ●
240	16	3.7	2	611918 ●	611218 ●
270	16	3.7	2	611965	611265 ●
310	16	3.7	2	611922	611222 ●

8. Knives and spare parts

8.1 Knives and blank knives

8.1.5 Planer knives



Turnblade planing knives Centrolock

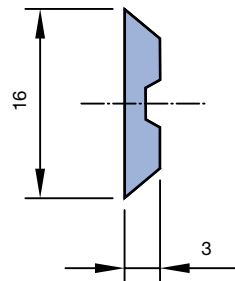
For cutterhead system Centrolock / Easylock

AT 103 0 13

SB	H	DIK	SET	ID	ID	ID
mm	mm	mm	PCS	HS	HW	MC
60	16	3	2	611801 ●	611861 ●	611831 ●
80	16	3	2	611802 ●	611862 ●	611832 ●
100	16	3	2	611803 ●	611863 ●	611833 ●
130	16	3	2	611804 ●	611864 ●	611834 ●
150	16	3	2	611805 ●	611865 ●	611835 ●
170	16	3	2	611806 ●	611866 ●	611836 ●
180	16	3	2	611807 ●	611867 ●	611837 ●
190	16	3	2	611808 ●	611868 ●	611838 ●
230	16	3	2	611809 ●	611869 ●	611839 ●
240	16	3	2	611810 ●	611870 ●	611840 ●
260	16	3	2	611811 ●	611871 ●	611841 ●
270	16	3	2	611812 ●	611872 ●	611842 ●
285	16	3	2	611817 ●	611877 ●	611847 ●
310	16	3	2	611813 ●	611873 ●	611843 ●
460	16	3	2	611814 ●		

Cutting material recommendation	HS	MC	HW
Solid wood dry	◆	◆	
Solid wood wet	◇	◆	
Hardwood dry		◇	◆
Hardwood wet		◆	◆
Glulam		◆	◆
Clipboard			◇
MDF			◇

◆ suitable ◇ partly suitable



Cutting material:

HS / MC / HW



Spiral planer knife

One-way knife for spiral long planerhead

TM 101 0

BEZ	SB	QAL	ID
	mm		
HS-Spiral knife, one-way	410	HS	006841 ●
HS-Spiral knife, one-way	420	HS	006910
HS-Spiral knife, one-way	510	HS	006842 ●
HS-Spiral knife, one-way	520	HS	006911 ●
HS-Spiral knife, one-way	610	HS	006843 ●
HS-Spiral knife, one-way	630	HS	006912 ●
HS-Spiral knife, one-way	640	HS	006844 ●

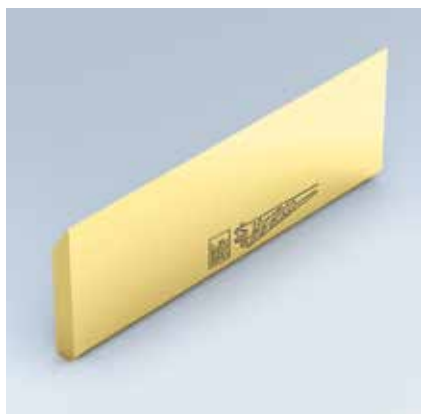
Resharpenable knife for spiral long planerhead

TM 106 0

BEZ	SB	QAL	ID
	mm		
HS-Spiral knife, resharpenable	410	HS	006828 ●
HS-Spiral knife, resharpenable	420	HS	006907
HS-Spiral knife, resharpenable	510	HS	006829 ●
HS-Spiral knife, resharpenable	520	HS	006908
HS-Spiral knife, resharpenable	610	HS	006830 ●
HS-Spiral knife, resharpenable	630	HS	006909 ●
HS-Spiral knife, resharpenable	640	HS	006831 ●

Cutting material:

HS



Blank knives with 60° back serration

HS and MC33 blank knives, for profile and hydro profile cutterheads

AT 103 0 28, AT 103 0 29

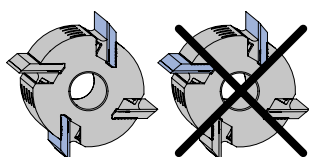
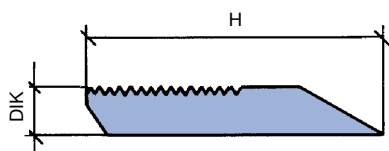
SB	H	DIK	PT _{max}	SET	ID	ID
mm	mm	mm	mm	PCS	HS	MC33
40	50	8	15	2	697500	697314
60	50	8	15	2	697501	697315
80	50	8	15	2	697502	697316
100	50	8	15	2	697503	697317
130	50	8	15	2	697504	697318
150	50	8	15	2	697505	697319
170	50	8	15	2	697506	697320
180	50	8	15	2	697507	697321
190	50	8	15	2	697508	697322
210	50	8	15	2	697509	697323
230	50	8	15	2	697510	697324
240	50	8	15	2	697511	697325
260	50	8	15	2	697512	697326
270	50	8	15	2	697513	697327
310	50	8	15	2	697514	697328
40	60	8	20	2	697515	697329
60	60	8	20	2	697516	697330
80	60	8	20	2	697517	697331
100	60	8	20	2	697518	697332
130	60	8	20	2	697519	697333
150	60	8	20	2	697520	697334
170	60	8	20	2	697521	697335
180	60	8	20	2	697522	697336
190	60	8	20	2	697523	697337
210	60	8	20	2	697524	697338
230	60	8	20	2	697525	697339
240	60	8	20	2	697526	697340
260	60	8	20	2	697527	697341
270	60	8	20	2	697528	697342
310	60	8	20	2	697529	697343
40	70	8	30	2	697530	697344
60	70	8	30	2	697531	697345
80	70	8	30	2	697532	697346
100	70	8	30	2	697533	697347
130	70	8	30	2	697534	697348
150	70	8	30	2	697535	697349
170	70	8	30	2	697536	697350
180	70	8	30	2	697537	697351
190	70	8	30	2	697538	697352
210	70	8	30	2	697539	697353
230	70	8	30	2	697540	697354
240	70	8	30	2	697541	697355
260	70	8	30	2	697542	697356
270	70	8	30	2	697543	697357
310	70	8	30	2	697544	697358

Cutting material recommendation	HS Classic / Premium	MC33	HW
Solid wood dry	◆	◆	◇
Solid wood wet	◇	◆	
Hardwood dry	◇	◆	◆
Hardwood wet	◇	◆	
Glulam		◇	◇
Thermoplastics (PE, PP, PVC, etc.)	◆	◆	◇
WPC (Wood-Plastic-Composite)	◇	◆	◇

◆ suitable ◇ partly suitable

H	PT
mm	mm
50	15
60	20
70	30

Table to determine maximum profile depth. The profile depth figures are to be regarded as standard values. The maximum profile depth depends on the tool diameter and cutting angle.



Attention:

For safety reasons, always mount knives of the same weight in opposite seatings

Cutting material:

HS / MC33

The Leitz MC33 cutting material replaces previous design in MC Marathon

Set of the same weight.

Attention:

Please do not mix new MC33 blank knives with previous MC blank knives in one cutterhead due to weight difference.

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
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 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
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 Орел (4862)44-53-42
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 Ставрополь (8652)20-65-13
 Казахстан (772)734-952-31

Сургут (3462)77-98-35
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 Тюмень (3452)66-21-18
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 Череповец (8202)49-02-64
 Ярославль (4852)69-52-93