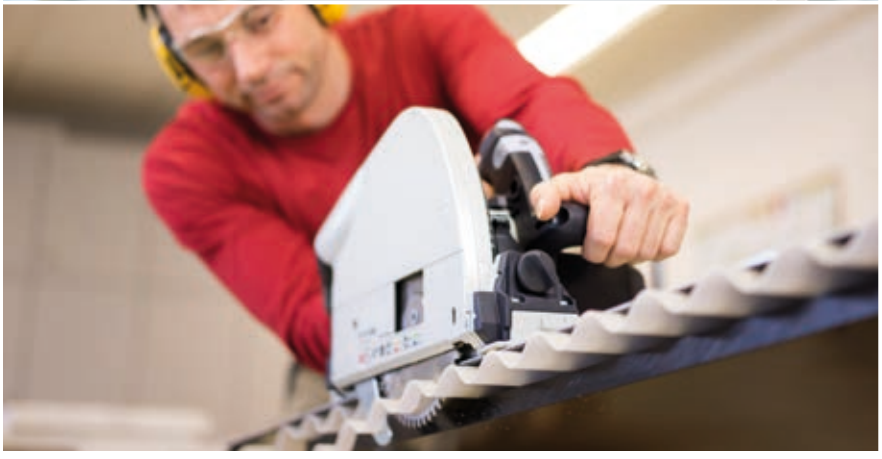
The Leitz circular saw blades

for professional processing of plastic panels

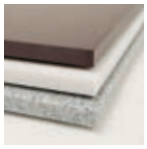



leitz

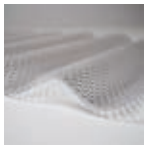




1.4 Foams

1.5 Polymer-compound mineral working material



1.6 Special panels



1.7 Technical information

The Leitz Group

Leitz is the worldwide leader in high-technology engineering and manufacturing of precision tooling and systems for machining wood, plastics and advanced composites. A comprehensive range of tooling solutions is designed and produced in-house for industrial and traditional panel processing. This extensive product offering is complimented by a complete package of consulting and other value-added services – including precision sharpening and reconditioning. The Leitz objective: intelligent machining processes that are technologically innovative, economically sustainable, and environmentally friendly.

Founded in Oberkochen, Southern Germany in 1876, the small, artisan business has become a global enterprise with production, sales and service centers all over the world. Even though Leitz supplies high tech tools to users in more than 150 countries, it remains a family business. With strong roots at the company's headquarters, Leitz maintains long-term partnerships with its customers.

Leitz: Facts and figures

Leitz has more than six production plants in Europe, the USA and Asia, offering a standard program of about 8,000 precision tools as well as customized solutions.

Through a global network of sales organizations in 36 countries and 140 service centers with production plants, Leitz is always near its customers. A total of 2,900 Leitz employees quickly and reliably supply tools from regional stock and guarantee qualified expertise and support as well as quick and safe tool maintenance.

Leitz – A producing service provider

At the company's headquarters in Oberkochen and subsidiaries in Unterschneidheim and Riedau (Austria), Leitz has its own research and development center. Here Leitz engineers work together with customers and leading machine producers to develop and test tooling and processing solutions. Additionally, Leitz closely collaborates with renowned research institutes and universities to be in a position to offer its customers the ideal tooling solution. Cutting-edge material research and coating technology, resource and energy-efficient processing solutions, DFC® (Dust Flow Control) technology and reduced-noise systems as well as Industry 4.0 tooling are the current R&D focuses at Leitz.

Leitz produces a full range of tools for professionally handcrafted and industrial processing of solid wood, wood-derived materials, plastics and non-ferrous metals. Today, these precision tools are used in the craft trade and in all sectors of the wood and plastic processing industry (e.g. window and timber construction, panel and furniture production), proving that Leitz offers the right tool for each application, process and machine.

Leitz sees itself as a system partner and problem solver who offers customers first-class advice, project and process engineering, traditional tool maintenance up to complete tool management with tool supply, management and controlling as well as commissioning and training. Leitz services are individually tailored to give each customer the opportunity to optimize his strengths and core business.

Leitz Service: Tools ”Good as New“

A quality tool only continues to be a quality tool if it is serviced and maintained to original manufacturing specifications during its entire life cycle. Leitz offers service on site where experts oversee precision sharpening and reconditioning of tooling. Fast and safe pick-up and delivery service helps Leitz customers manage logistics and guarantees optimal availability of tools.

From the edge to tool – an all-in-one solution

Each Leitz tool meets the highest standards with respect to processing quality, efficiency and environmental compatibility. Tools such as BrillianceCut circular saw blades for panel sizing machines with finish cut quality on PMMA and Alucobond® or the GlossCut circular saw blades, designed for excellent processing quality and extraordinary performance times on panel saws, embody this triple concept of quality.

For over 135 years we have worked side by side with our customers to make everyone more successful. Find out how Leitz can help shape the future of your business.

1. Sawing

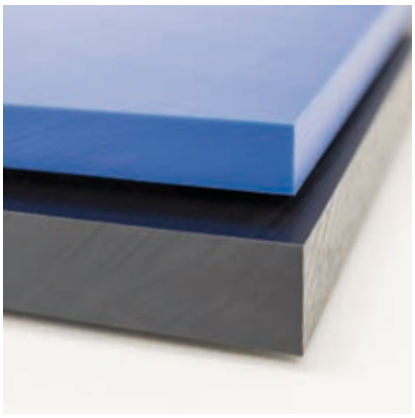
1.1 Thermoplastics

1.1.1 Thermoplastics
ABS, PE, POM, PS, PVC

1.1.2 Easily melting thermoplastics
PP, PA

1.1.3 Hard thermoplastics
PMMA, PC
Double skin panels, twin-wall sheets

1.1.4 Hollow profiles
PVC
PVC fibre reinforced



Application:
For sizing single panels and stacks of panels.

Workpiece material:
ABS, PE, POM, PS, PVC

Application recommendation:

Material	ABS	PE	POM	PS	PVC
f_z (mm)	0,05 - 0,15	0,01 - 0,1	0,05 - 0,1	0,01 - 0,1	0,03 - 0,05
v_c (m/s)	50 - 70	60 - 75	50 - 70	50 - 70	50 - 70

Panel thickness	≤ 25 mm	> 25 mm
ZT	≤ 18	> 15

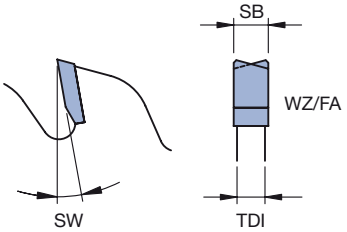
Sizing cuts – Excellent

Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
Special cutting geometry for perfect cut surfaces and tear-free cutting edges. **AS LowNoise foil** design – noise reduction during operation by up to 10 dB(A). Vibration-damping composite construction of the tool body for best possible cutting quality and exceptional performance.

Panel sizing saw blade

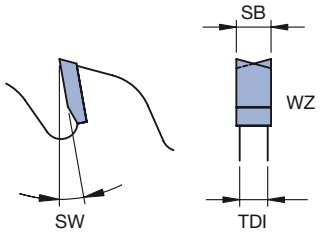




D mm	SB mm	TDI mm	BO mm	NLA mm	Foil	Z	ZF	ZT mm	SW	ID	
300	3,5	2,5	30	2/10/60	rigt	20	WZ/FA	47,10	15°	**065342**	•
300	3,5	2,5	30	2/10/60	rigt	60	WZ/FA	15,70	15°	**065343**	•
350	4,4	3,2	30	2/10/60	rigt	64	WZ/FA	17,17	15°	**065345**	•
380	4,8	3,5	60	2/14/100	left	72	WZ/FA	16,57	15°	**065353**	•
400	4,4	3,2	30	2/10/60	rigt	72	WZ/FA	17,44	15°	**065346**	•

• available ex stock ▫ available at short notice

Panel sizing saw blade

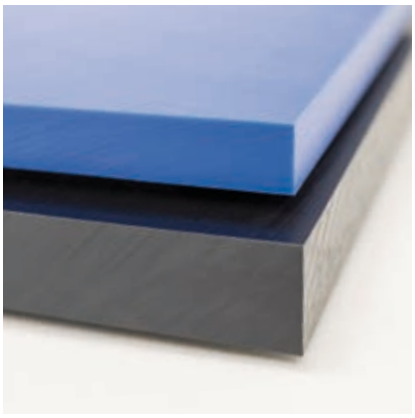


Sizing cuts – Classic

Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
Höfer	300	4,4	3,0	30	KNL	48	WZ	19,63	15°	**059100**	•
Höfer, Schelling	350	4,4	3,2	30	KNL	54	WZ	20,35	15°	**059102**	•
	400	4,4	3,2	30	KNL	72	WZ	17,44	15°	**059185**	•
	450	4,4	3,2	30	KNL	72	WZ	19,63	15°	**059433**	•
	500	5,2	3,5	30	KNL	60	WZ	26,17	15°	**059442**	•



Application:
For sizing panels of various thicknesses.

Workpiece material:
ABS, PE, POM, PS, PVC

Application recommendation:

Material	ABS	PE	POM	PS	PVC
f_z (mm)	0,05 - 0,15	0,01 - 0,1	0,05 - 0,1	0,01 - 0,1	0,03 - 0,05
v_c (m/s)	50 - 70	60 - 75	50 - 70	50 - 70	50 - 70

Panel thickness	≤ 25 mm	> 25 mm
ZT	≤ 18	> 15

Sizing cuts in finish cut quality – Excellent

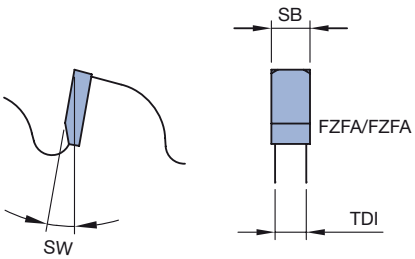
Machine:
Table saw, trimming saw, portable circular saw.

Technical information:
GlossCut design – tool body with vibration-damping laser ornaments and special tooth geometry. Optimized for sizing perfect cut surfaces and tear-free cutting edges. Noise reduction during idling and operation by up to 4 dB(A). Special tool design for significantly improved performance times.

Sizing saw blade/
Portable circular saw blade



HW



D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
160	2,2	1,6	20		48	FZFA/FZFA	10,47	+5°/-5°	**161008**	•
165	2,2	1,6	20		48	FZFA/FZFA	10,79	+5°/-5°	**161009**	•
190	2,4	1,8	20		58	FZFA/FZFA	10,29	+5°/-5°	**161010**	•
210	2,4	1,8	30		68	FZFA/FZFA	9,70	+5°/-5°	**161011**	•
250	2,8	2,2	30	KNL	72	FZFA/FZFA	10,90	+5°/-5°	**161012**	•
300	3,0	2,4	30	KNL	72	FZFA/FZFA	13,08	+5°/-5°	**161005**	•
300	3,0	2,4	30	KNL	96	FZFA/FZFA	9,81	+5°/-5°	**161006**	•
350	3,5	2,8	30	KNL	96	FZFA/FZFA	11,45	+5°/-5°	**161007**	•

• available ex stock ▫ available at short notice

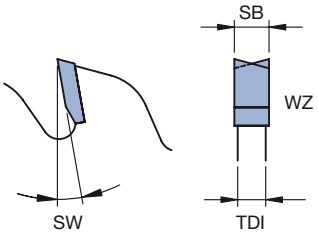
Sizing cuts – Classic

Machine:
Circular sawing machines for sizing, cross cutting, multi-rip saws and table saws.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
300	3,2	2,2	30	KNL	48	WZ	19,63	10°	**058057**	•
300	3,2	2,2	30	KNL	72	WZ	13,08	10°	**058384**	•
300	3,2	2,2	30	KNL	96	WZ	9,81	10°	**058311**	•
350	3,2	2,2	30	KNL	54	WZ	20,35	10°	**058059**	•
350	3,2	2,2	30	KNL	72	WZ	15,26	10°	**058206**	•
350	3,2	2,2	30	KNL	108	WZ	10,18	10°	**058308**	•
400	3,2	2,2	30	KNL	120	WZ	10,47	10°	**058309**	•
400	3,8	2,8	30	KNL	60	WZ	20,93	10°	**058061**	•
400	3,8	2,8	30	KNL	84	WZ	14,95	10°	**058225**	•
450	3,8	2,8	30	KNL	66	WZ	21,41	10°	**058062**	•
500	3,8	2,8	30	KNL	72	WZ	21,81	10°	**058063**	•

Sizing saw blade



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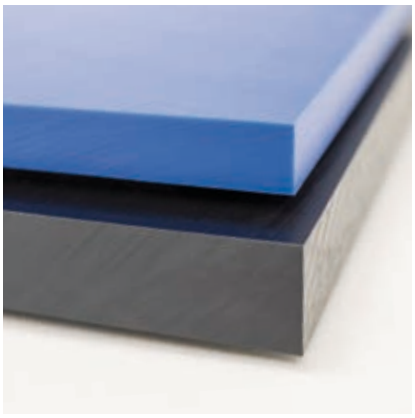


Application:
For sizing panels of various thicknesses.

Workpiece material:
ABS, PE, POM, PS, PVC

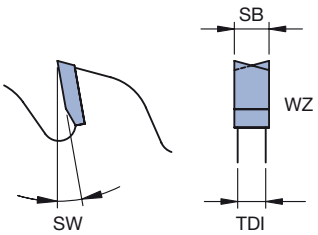
Application recommendation:

Material	ABS	PE	POM	PS	PVC
f_z (mm)	0,05 - 0,15	0,01 - 0,1	0,05 - 0,1	0,01 - 0,1	0,03 - 0,05
v_c (m/s)	50 - 70	60 - 75	50 - 70	50 - 70	50 - 70

Panel thickness	≤ 25 mm	> 25 mm
ZT	≤ 18	> 15

Portable circular saw blade

HW



Multi-purpose cut – Classic

Machine:
Underfloor saws, circular saw benches, trimming saws and portable saws, light sliding table saws.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.

D mm	SB mm	TDI mm	BO mm	Z	ZF	ZT mm	SW	ID	
150	2,8	1,8	20	24	WZ	19,63	10°	**060571**	•
150	2,8	1,8	20	48	WZ	9,81	10°	**060572**	•
160	2,5	1,6	16	24	WZ	20,93	15°	**070081**	•
160	2,5	1,6	20	24	WZ	20,93	15°	**070083**	•
160	2,5	1,6	16	48	WZ	10,47	10°	**070082**	•
160	2,5	1,6	20	48	WZ	10,47	12°	**070037**	•
165	2,5	1,6	20	24	WZ	21,59	15°	**070085**	•
170	2,5	1,6	30	24	WZ	22,24	15°	**070087**	•
170	2,5	1,6	30	48	WZ	11,12	10°	**070049**	•
180	2,5	1,6	16	24	WZ	23,55	15°	**070088**	•
180	2,5	1,6	20	24	WZ	23,55	15°	**070089**	•
180	2,5	1,6	20	48	WZ	11,78	10°	**070090**	•
180	2,5	1,6	30	24	WZ	23,55	15°	**070091**	•
180	2,5	1,6	30	30	WZ	18,84	10°	**070092**	•
180	2,5	1,6	30	58	WZ	9,74	10°	**070093**	•
185	2,5	1,6	20	24	WZ	24,20	15°	**070094**	•
190	2,5	1,8	30	24	WZ	24,86	20°	**070095**	•
190	2,8	1,8	16	24	WZ	24,86	15°	**060606**	•
190	2,8	1,8	16	48	WZ	12,43	10°	**060607**	•
190	2,8	1,8	30	48	WZ	12,43	8°	**070036**	•
190	2,6	1,8	20	24	WZ	24,86	15°	**070096**	•
190	2,6	1,8	20	48	WZ	12,43	10°	**070097**	•
200	3,0	2,0	30	16	WZ	39,25	15°	**070121**	•
200	3,0	2,0	30	34	WZ	18,47	10°	**060627**	•
200	3,0	2,0	30	48	WZ	13,08	10°	**070122**	•

• available ex stock ▫ available at short notice

D mm	SB mm	TDI mm	BO mm	Z	ZF	ZT mm	SW	ID	
200	3,0	1,6	30	64	WZ	9,81	10°	**070123**	•
210	2,4	1,6	30	24	WZ	27,48	15°	**070100**	•
210	2,6	1,8	30	56	WZ	11,78	10°	**070106**	•
210	2,4	1,6	30	64	WZ	10,30	10°	**070104**	•
220	3,2	2,2	30	34	WZ	20,32	15°	**060644**	•
220	3,2	2,2	30	64	WZ	10,79	10°	**060646**	•
225	2,6	1,8	30	48	WZ	14,72	10°	**070113**	•
230	3,2	2,2	30	12	WZ	60,18	15°	**060647**	•
230	3,2	2,2	30	34	WZ	21,24	15°	**060648**	•
235	3,2	2,2	16	24	WZ	30,75	15°	**060649**	•
235	3,2	2,2	30	24	WZ	30,75	15°	**060652**	•
235	3,2	2,2	30	34	WZ	21,70	15°	**060653**	•
240	3,0	2,0	30	34	WZ	22,16	15°	**060656**	•
240	3,0	1,8	30	48	WZ	15,70	10°	**070060**	•
250	3,2	2,2	30	40	WZ	19,63	10°	**058055**	•
250	3,2	2,2	30	60	WZ	13,08	10°	**058382**	•
250	2,8	1,8	30	80	WZ	9,81	10°	**070118**	•
250	3,2	2,2	30	80	WZ	9,81	10°	**058304**	•

Application:
For sizing single panels and stacks of panels.

Workpiece material:
PP, PA

Application recommendation:

Material	PP	PA
f_z (mm)	0,05 - 0,15	0,01 - 0,1
v_c (m/s)	60 - 75	50 - 70

Panel thickness	≤ 15 mm	> 15 mm
ZT	≤ 26	> 24

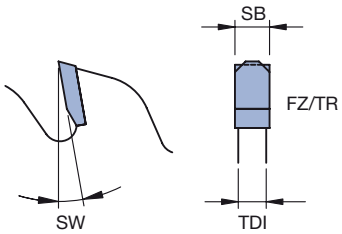
Sizing cuts – Premium

Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
VectorCut design – New innovative tooth shape for maximum efficiency by 30% longer tool life times and up to 15x resharpenable. Lower power consumption, up to 10% energy savings. Innovative gullet design for optimized chip disposal and noise reduction by up to 3 dB(A).

Panel sizing saw blade





Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
	300	4,4	3,2	30	KNL	20	FZ/TR	47,10	15°	**059725**	•
	300	4,4	3,2	30	KNL	60	FZ/TR	15,70	15°	**059726**	•
	350	4,4	3,2	30	KNL	24	FZ/TR	45,79	15°	**059727**	•
Holzma	350	4,4	3,2	60	2/14/100	24	FZ/TR	45,79	15°	**059728**	▫
	350	4,4	3,2	30	KNL	72	FZ/TR	15,26	15°	**059729**	•
Holzma	350	4,4	3,2	60	2/14/100	72	FZ/TR	15,26	15°	**059730**	▫
	370	4,4	3,2	30	KNL	72	FZ/TR	16,13	15°	**059731**	•
Holzma	380	4,8	3,5	60	2/14/100	24	FZ/TR	49,72	15°	**059732**	•
Holzma	380	4,4	3,2	60	2/14/100	72	FZ/TR	16,57	18°	**059719**	•
Holzma	380	4,8	3,5	60	2/14/100	72	FZ/TR	16,57	15°	**059720**	•
	400	4,4	3,2	30	KNL	72	FZ/TR	17,44	15°	**059733**	•
Holzma	420	4,8	3,5	60		84	FZ/TR	15,70	15°	**059722**	•
	450	4,4	3,2	30	KNL	72	FZ/TR	19,62	15°	**059724**	•
Holzma	450	4,8	3,5	60	2/14/125	72	FZ/TR	19,62	15°	**059723**	•

• available ex stock ▫ available at short notice

Application:
For sizing panels in various thicknesses.

Workpiece material:
PP, PA

Application recommendation:

Material	PP	PA
f_z (mm)	0,05 - 0,15	0,01 - 0,1
v_c (m/s)	60 - 75	50 - 70

Panel thickness	≤ 15 mm	> 15 mm
ZT	≤ 26	> 24

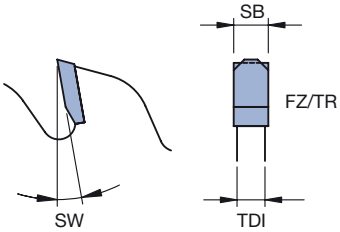
Sizing cuts – Premium

Machine:
Table saws and circular sawing machines for sizing, cross cutting and panel sizing with/without scoring saw.

Technical information:
AS OptiCut design – noise reduction during idling by up to 5 dB(A).
Tool body with vibration damping laser ornaments.

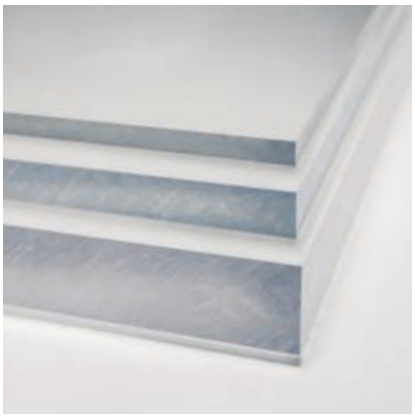
Sizing saw blade





D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
300	3,2	2,2	30	KNL	20	FZ/TR	47,10	10°	**068410**	•
300	3,2	2,2	30	KNL	42	FZ/TR	22,43	10°	**068411**	•
350	3,5	2,5	30	KNL	24	FZ/TR	45,79	10°	**068412**	•
350	3,5	2,5	30	KNL	48	FZ/TR	22,90	10°	**068413**	•
400	3,8	2,5	30	KNL	28	FZ/TR	44,86	10°	**068414**	•
400	3,8	2,5	30	KNL	54	FZ/TR	23,26	10°	**068415**	•
450	4,0	2,8	30	KNL	34	FZ/TR	41,56	10°	**068416**	•
500	4,4	3,0	30	KNL	36	FZ/TR	43,61	10°	**068417**	•

• available ex stock ▫ available at short notice



Application:
For sizing single panels and stacks of panels.

Workpiece material:
PMMA, PC

Application recommendation:

Material	PMMA	PC
f_z (mm)	0,03 - 0,05	0,01 - 0,05
v_c (m/s)	50 - 70	70 - 90

Panel thickness	≤ 25 mm	> 25 mm
ZT	≤ 18	> 15

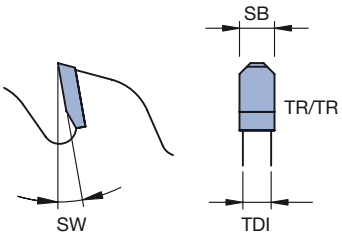
Sizing cuts in finish cut quality – Excellent

Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
BrillianceCut design – tool body with vibration-damping laser ornaments and special tooth geometry. Optimized for sizing perfect cut surfaces and tear-free cutting edges. Machined surfaces can be finished to glossy quality with minimal rework efforts. Noise reduction during idling and operation by up to 4 dB(A). Special tool design for significantly improved performance times. Ideally suited for transparent thermoplastics.

Panel sizing saw blade

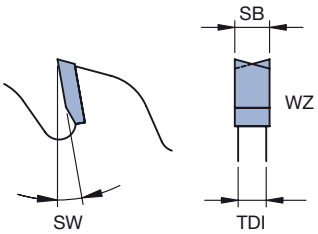
HW



D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
300	3,2	2,2	30	KNL	60	TR/TR	15,70	15°	**161013**	•
350	4,4	3,2	30	KNL	72	TR/TR	15,26	15°	**161014**	•
380	4,8	3,5	60	2/14/100	84	TR/TR	14,20	15°	**161015**	•
400	4,8	3,5	30	KNL	72	TR/TR	17,44	15°	**161016**	•
450	4,8	3,5	30	KNL	72	TR/TR	19,63	15°	**161017**	•

• available ex stock ▫ available at short notice

Panel sizing saw blade

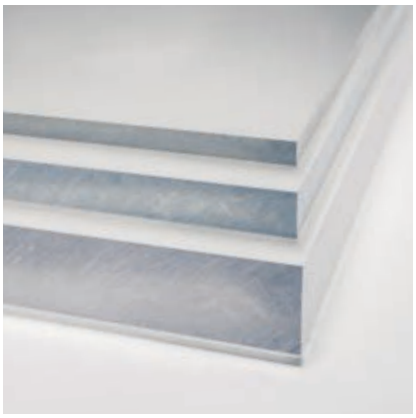


Sizing cuts – Classic

Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
Höfer	300	4,4	3,0	30	KNL	48	WZ	19,63	15°	**059100**	•
Höfer, Schelling	350	4,4	3,2	30	KNL	54	WZ	20,35	15°	**059102**	•
	400	4,4	3,2	30	KNL	72	WZ	17,44	15°	**059185**	•
	450	4,4	3,2	30	KNL	72	WZ	19,63	15°	**059433**	•
	500	5,2	3,5	30	KNL	60	WZ	26,17	15°	**059442**	•



Application:
For sizing panels in various thicknesses.

Workpiece material:
PMMA, PC

Application recommendation:

Material	PMMA	PC
f_z (mm)	0,03 - 0,05	0,01 - 0,05
v_c (m/s)	50 - 70	70 - 90

Panel thickness	≤ 25 mm	> 25 mm
ZT	≤ 18	> 15

Sizing cuts in finish cut quality – Excellent

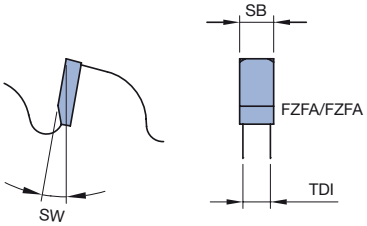
Machine:
Table saw, trimming saw, portable circular saw.

Technical information:
GlossCut design – tool body with vibration-damping laser ornaments and special tooth geometry. Optimized for sizing perfect cut surfaces and tear-free cutting edges. Machined surfaces can be finished to glossy quality with minimal rework efforts. Noise reduction during idling and operation by up to 4 dB(A). Special tool design for significantly improved performance times. Ideally suited for transparent thermoplastics.

Sizing saw blade/
Portable circular saw blade



HW



D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
160	2,2	1,6	20		48	FZFA/FZFA	10,47	+5°/-5°	**161008**	•
165	2,2	1,6	20		48	FZFA/FZFA	10,79	+5°/-5°	**161009**	•
190	2,4	1,8	20		58	FZFA/FZFA	10,29	+5°/-5°	**161010**	•
210	2,4	1,8	30		68	FZFA/FZFA	9,70	+5°/-5°	**161011**	•
250	2,8	2,2	30	KNL	72	FZFA/FZFA	10,90	+5°/-5°	**161012**	•
300	3,0	2,4	30	KNL	72	FZFA/FZFA	13,08	+5°/-5°	**161005**	•
300	3,0	2,4	30	KNL	96	FZFA/FZFA	9,81	+5°/-5°	**161006**	•
350	3,5	2,8	30	KNL	96	FZFA/FZFA	11,45	+5°/-5°	**161007**	•

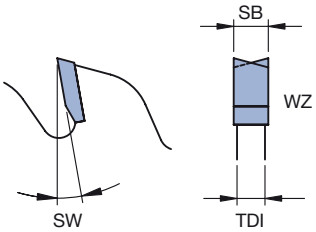
• available ex stock ▫ available at short notice

Sizing cuts – Classic

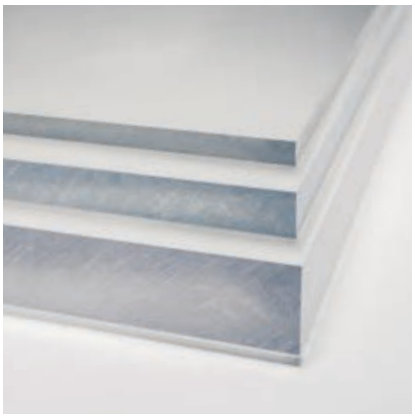
Machine:
Circular sawing machines for sizing, cross cutting, multi-rip saws and table saws.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.

Sizing saw blade



D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID
300	3,2	2,2	30	KNL	48	WZ	19,63	10°	**058057** •
300	3,2	2,2	30	KNL	72	WZ	13,08	10°	**058384** •
300	3,2	2,2	30	KNL	96	WZ	9,81	10°	**058311** •
350	3,2	2,2	30	KNL	54	WZ	20,35	10°	**058059** •
350	3,2	2,2	30	KNL	72	WZ	15,26	10°	**058206** •
350	3,2	2,2	30	KNL	108	WZ	10,18	10°	**058308** •
400	3,2	2,2	30	KNL	120	WZ	10,47	10°	**058309** •
400	3,8	2,8	30	KNL	60	WZ	20,93	10°	**058061** •
400	3,8	2,8	30	KNL	84	WZ	14,95	10°	**058225** •
450	3,8	2,8	30	KNL	66	WZ	21,41	10°	**058062** •
500	3,8	2,8	30	KNL	72	WZ	21,81	10°	**058063** •



Application:
For sizing panels of various thicknesses.

Workpiece material:
PMMA, PC

Application recommendation:

Material	PMMA	PC
f_z (mm)	0,03 - 0,05	0,01 - 0,05
v_c (m/s)	50 - 70	70 - 90

Panel thickness	≤ 25 mm	> 25 mm
ZT	≤ 18	> 15

End trimming cut – Classic

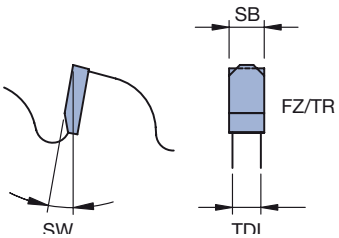
Machine:
Portable saws, trimming-, mitre saws, radial arm saws and table saws.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.

Portable circular saw blade

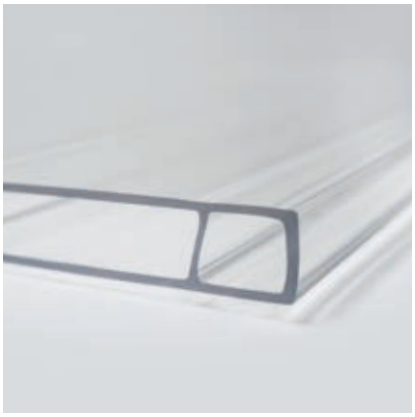


HW



D mm	SB mm	TDI mm	BO mm	Z	ZF	ZT mm	SW	ID	
160	2,5	1,8	20	56	FZ/TR	8,97	-5°	**070047**	•
190	2,6	1,8	20	54	FZ/TR	11,05	-5°	**060707**	•
190	2,8	2,2	30	68	FZ/TR	8,77	-5°	**070054**	•
210	2,8	2,0	30	60	FZ/TR	10,99	-5°	**070067**	•
210	2,4	1,6	30	64	FZ/TR	10,30	-5°	**070105**	•
216	3,0	2,4	30	64	FZ/TR	10,60	-5°	**060686**	•
225	2,6	1,8	30	68	FZ/TR	10,39	-5°	**070041**	•
235	3,2	2,6	25	54	FZ/TR	13,66	-5°	**070732**	•
240	2,8	2,2	30	80	FZ/TR	9,42	-5°	**070062**	•
250	3,4	2,8	30	60	FZ/TR	13,08	-5°	**060134**	•
250	2,8	2,0	30	80	FZ/TR	9,81	-5°	**070119**	•
250	3,2	2,6	30	80	FZ/TR	9,81	-5°	**060250**	•
300	3,2	2,6	30	96	FZ/TR	9,81	-5°	**060252**	•

• available ex stock ▫ available at short notice



Application:
For sizing thin panels and panels with thin-walled bars.

Workpiece material:
PMMA, PC

Application recommendation:

Material	PMMA	PC
f_z (mm)	0,03 - 0,05	0,01 - 0,05
v_c (m/s)	50 - 70	70 - 90

Panel thickness	≤ 2 mm	> 2 mm
ZT	≤ 8,5	> 8

Sizing cuts in finish cut quality – Excellent

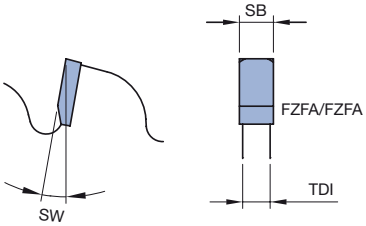
Machine:
Table saw, trimming saw, portable circular saw.

Technical information:
GlossCut design – tool body with vibration-damping laser ornaments and special tooth geometry. Optimized for sizing perfect cut surfaces and tear-free cutting edges. Noise reduction during idling and operation by up to 4 dB(A).
Special tool design for significantly improved performance times.

Sizing saw blade/
Portable circular saw blade

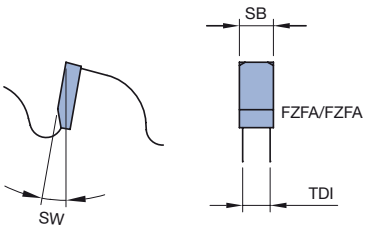


HW



D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
160	2,2	1,6	20		48	FZFA/FZFA	10,47	+5°/-5°	**161008**	•
165	2,2	1,6	20		48	FZFA/FZFA	10,79	+5°/-5°	**161009**	•
190	2,4	1,8	20		58	FZFA/FZFA	10,29	+5°/-5°	**161010**	•
210	2,4	1,8	30		68	FZFA/FZFA	9,70	+5°/-5°	**161011**	•
250	2,8	2,2	30	KNL	72	FZFA/FZFA	10,90	+5°/-5°	**161012**	•
300	3,0	2,4	30	KNL	72	FZFA/FZFA	13,08	+5°/-5°	**161005**	•
300	3,0	2,4	30	KNL	96	FZFA/FZFA	9,81	+5°/-5°	**161006**	•
350	3,5	2,8	30	KNL	96	FZFA/FZFA	11,45	+5°/-5°	**161007**	•

Portable-, sizing-, trimming- and mitre cutting saw blade



Cross- and mitre cut – Classic

Machine:
Cut-off saws, cross cut saws, mitre saws, portable saws and double cut-off saws.

Technical information:
The negative hook angle is suited to cutting from above.
Reduced cutting width and tool body thickness. Noise reduced saw body design.
Tool body with special coating for increased performance.

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID
160	1,6	1,2	20		60	FZFA/FZFA	8,37	-5°	**060277** •
190	1,8	1,4	20		72	FZFA/FZFA	8,29	-5°	**060278** •
200	1,8	1,4	20	KNL	80	FZFA/FZFA	7,85	-5°	**060274** •
250	2,0	1,6	30	KNL	100	FZFA/FZFA	7,85	-5°	**060275** •
300	2,2	1,8	30	KNL	120	FZFA/FZFA	7,85	-5°	**060276** •
350	2,4	2,0	30	KNL	140	FZFA/FZFA	7,85	-5°	**060279** •

• available ex stock ▫ available at short notice

Application:
For splitting and mitre cutting from above.

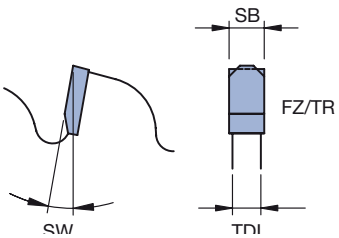
Workpiece material:
PVC

Application recommendation:

Material	PVC
f_z (mm)	0,03 - 0,05
v_c (m/s)	50 - 70

Wall thickness	2-5 mm
ZT	7-16

Portable-, sizing-, trimming- and mitre cutting saw blade



Cross- and mitre cut from above – Classic

Machine:
Cut-off saws, cross cut saws, mitre saws, portable saws and double cut-off saws.

Technical information:
The negative hook angle is suited to cutting from above. Reinforced tool body for higher stiffness when performing dust-cuts. Noise reduced saw body design.

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
Ulmia	160	2,8	2,2	16		42	FZ/TR	11,96	-5°	**060272**	•
AEG, Atlas Copco, Festool, Haffner, Holz Her, Mafell, Narex, Protool, Scheer	160	2,5	1,8	20		56	FZ/TR	8,97	-5°	**070047**	•
	170	2,8	2,2	30		48	FZ/TR	11,12	-5°	**740401**	•
Metabo	190	2,6	1,8	20		54	FZ/TR	11,05	-5°	**060707**	•
	190	2,8	2,2	30		54	FZ/TR	11,05	-5°	**740404**	•
Fezer	200	3,2	2,6	18		80	FZ/TR	7,85	-5°	**060261**	•
Ulmia, Urban, Eisele	200	3,2	2,6	30		60	FZ/TR	10,47	-5°	**060270**	•
Haffner, Reich	220	3,2	2,6	30	2/6/42	72	FZ/TR	9,59	-5°	**060271**	•
Elek. Beckum, Elu/DeWalt, Haffner, Mafell, Metabo, PHM, Scheppach	250	3,2	2,6	30	KNL	80	FZ/TR	9,81	-5°	**060250**	•
Elu/DeWalt, Fezer, Pertici	250	3,2	2,6	32	2/8/45	80	FZ/TR	9,81	-5°	**060251**	•
	275	3,2	2,6	30	KNL	88	FZ/TR	9,81	-5°	**740410**	•

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Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
Elek. Beckum, Elu/DeWalt, Fezer, Lurem, Rapid, Scheppach, Ulmia	300	3,2	2,6	30	KNL	96	FZ/TR	9,81	-5°	**060252**	•
Elu	300	3,2	2,6	32		96	FZ/TR	9,81	-5°	**060253**	•
Haffner	330	3,2	2,6	30	KNL	96	FZ/TR	10,79	-5°	**060268**	•
Elumatec	330	3,2	2,6	32		96	FZ/TR	10,79	-5°	**060259**	•
Haffner, Ulmia	350	3,2	2,6	30	KNL	108	FZ/TR	10,18	-5°	**060255**	•
	350	3,6	3,0	32	2/9/55 4/12/64	108	FZ/TR	10,18	-5°	**760050**	•
Eisele, Graule	350	3,6	3,0	40	2/9/55 4/12/64	108	FZ/TR	10,18	-5°	**060269**	•
Elumatec	380	3,8	3,2	32		110	FZ/TR	10,85	-5°	**760334**	•
Haffner	400	3,8	3,2	30	KNL	108	FZ/TR	11,63	-5°	**760053**	•
	400	3,8	3,2	32	2/11/63	96	FZ/TR	13,08	-5°	**069929**	•
Elu/DeWalt	420	3,8	3,2	30	KNL	108	FZ/TR	12,21	-5°	**060257**	•
	420	3,8	3,2	32		108	FZ/TR	12,21	-5°	**069927**	•
Graule	420	3,8	3,2	40		100	FZ/TR	13,19	-5°	**760055**	•
Rapid	450	3,8	3,2	30	KNL	108	FZ/TR	13,08	-5°	**060258**	•
Elu, Wegoma, Rapid	500	4,4	3,8	30	2/11/63 6/9/100	120	FZ/TR	13,08	-5°	**760057**	•
Rapid	550	4,0	3,4	30		132	FZ/TR	13,08	-6°	**760060**	•
	550	4,4	3,8	32	2/11/63	128	FZ/TR	13,49	-5°	**740424**	•
Stürtz	600	5,2	4,6	30		138	FZ/TR	13,65	-6°	**760061**	•

• available ex stock ▫ available at short notice

Application:
For splitting, mitre cutting and sizing from below.

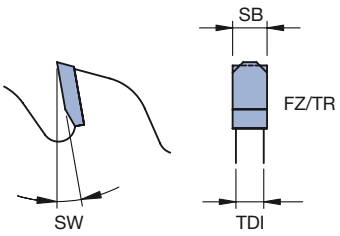
Workpiece material:
PVC

Application recommendation:

Material	PVC
f_z (mm)	0,03 - 0,05
v_c (m/s)	50 - 70

Wall thickness	2-5 mm
ZT	7-16

Portable-, sizing-, trimming- and mitre cutting saw blade



Cross- and mitre cut from below – Classic

Machine:
Cut-off saws, cross cut saws, mitre saws, portable saws, double cut-off saws, sizing saws and panel sizing saws.

Technical information:
The positive hook angle is suited to cutting from below.
Noise reduced saw body design.

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
Pressta-Eisele	200	3,0	2,4	20		64	FZ/TR	9,81	6°	**760048**	•
Emmegi	200	2,8	2,2	20		84	FZ/TR	7,48	5°	**760003**	•
Elek. Beckum, Elu/Dewalt, Haffner, Mafell, Makita, Metabo, PHM, Rapid, Scheppach	250	3,2	2,6	30	KNL	80	FZ/TR	9,81	5°	**059950**	•
Elu, Pressta-Eisele	250	3,2	2,6	32	2/11/63	80	FZ/TR	9,81	6°	**760052**	•
Elumatec	280	3,2	2,6	32		96	FZ/TR	9,16	5°	**762352**	•
	300	3,2	2,6	30	KNL	96	FZ/TR	9,81	5°	**059951**	•
Rapid	320	3,2	2,6	30	KNL	84	FZ/TR	11,96	5°	**059960**	•
Rapid	350	3,2	2,6	30	KNL	108	FZ/TR	10,18	5°	**059952**	•
Rapid	370	3,8	3,2	30	KNL	96	FZ/TR	12,10	5°	**059964**	•
Eisele	400	4,0	3,4	40	2/15/80 4/12/64	120	FZ/TR	10,47	5°	**760196**	•
Rapid	420	3,8	3,2	30	KNL	96	FZ/TR	13,74	5°	**059855**	•
Rapid	430	3,5	2,8	30	KNL	96	FZ/TR	14,06	5°	**059871**	•
	450	3,8	3,2	32	2/11/63	96	FZ/TR	14,72	5°	**059966**	•
Rapid, Elu	500	4,4	3,8	30	KNL	120	FZ/TR	13,08	5°	**059874**	•

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Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
	550	4,4	3,8	30	KNL	120	FZ/TR	14,39	5°	**059891**	•
Pressta-Eisele	550	4,4	3,8	32	2/11/63	128	FZ/TR	13,49	6°	**760202**	•
Stegmaier	600	4,6	4,0	30	2/11/63	140	FZ/TR	13,46	6°	**760204**	•

• available ex stock ▫ available at short notice

Application:
For cutting, mitre cutting and sizing.

Workpiece material:
PVC profiles, laminated and acryl-coated finish, profile with fibre reinforced core and glass fibre reinforced profiles

Application recommendation:

Material	PVC
f_z (mm)	0,03 - 0,05
v_c (m/s)	50 - 70

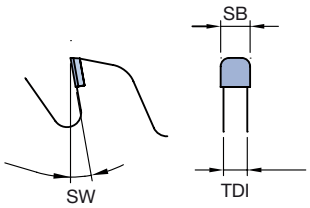
Wall thickness	2-5 mm
ZT	7-16

Cross- and mitre cut – Excellent

Machine:
Cut-off saws, cross cut saws, mitre saws, portable saws, double cut-off saws, sizing saws and panel sizing saws.

Technical information:
DP tipped circular saws in application-optimized design for optimal cutting quality and over-average performance times. Exact separation of profile and seal. Cutting edges are of optimal quality where tool plunges and leaves.

Portable-, sizing-, trimming- and mitre cutting saw blade



D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
300	4,4	3,6	30	KNL	60	P	15,70	5°	**190666**	▫
330	4,4	3,6	30	2/10/70	66	P	15,70	5°	**762338**	▫
350	4,4	3,6	30	KNL	70	P	15,70	5°	**190667**	▫
400	4,4	3,6	30	2/10/70	80	P	15,70	5°	**762339**	▫
420	4,4	3,6	30	KNL	84	P	15,70	5°	**762340**	▫
450	4,4	3,6	30	KNL	90	P	15,70	5°	**190668**	▫
500	4,4	3,6	30	2/10/70	100	P	15,70	5°	**762341**	▫
550	4,4	3,6	30	2/10/70	100	P	17,27	5°	**762342**	▫
600	4,8	3,8	30	2/10/70	120	P	15,70	5°	**762343**	▫

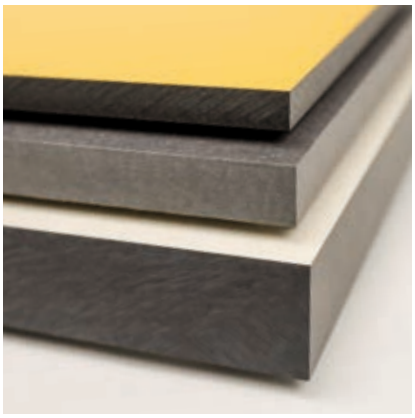
• available ex stock ▫ available at short notice

1. Sawing

1.2 Duroplastics

1.2.1 Duroplastics
HGW, HP, HPL, PUR

1.2.2 Fibre reinforced duroplastics
GFK, CFK



Application:
For sizing single panels and stacks of panels.

Workpiece material:
HGW, HP, HPL, PF, PUR
(Compact laminates)

Application recommendation:

Material	HGW	HP	HPL	PF	PUR
f_z (mm)	0,02 - 0,04	0,01 - 0,03	0,02 - 0,05	0,02 - 0,05	0,05 - 0,1
v_c (m/s)	45 - 65	50 - 70	60 - 75	50 - 60	50 - 70

Panel thickness	≤ 25 mm	> 25 mm
ZT	≤ 18	> 15

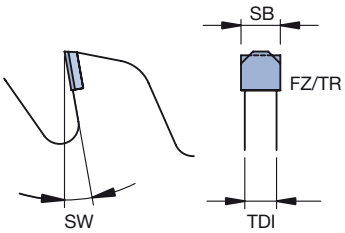
Sizing cuts – Excellent

Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results. **AS LowNoise UT** design – noise reduction during idling by up to 6 dB(A). Tool body with vibration damping irregular tooth pitch. **Diamaster PLUS** design with 6.0 mm tip height.

Panel sizing saw blade

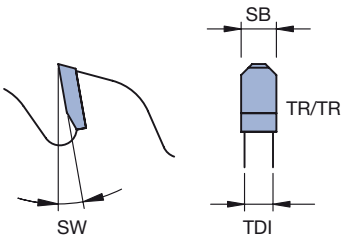




D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
300	4,4	3,2	30	2/10/60	60	FZ/TR	15,70	15°	**190604**	•
350	4,4	3,2	30	2/10/60	72	FZ/TR	15,26	15°	**190606**	•
380	4,8	3,5	60	2/14/100 2/14/125	72	FZ/TR	16,57	15°	**190607**	•
400	4,4	3,2	30	2/10/60	72	FZ/TR	17,44	15°	**190608**	•

• available ex stock ▫ available at short notice

Panel sizing saw blade



Sizing cuts – Excellent

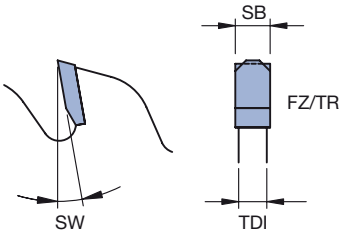
Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
RazorCut design - Special cutting geometry for perfect cut surfaces and tear-free cutting edges. **AS OptiCut UT** design – noise reduction during idling by up to 8 dB(A). Tool body with laser ornaments and irregular tooth pitch. Tool body with special coating for increased performance and less resin.

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
Striebig	250	3,2	2,2	30	KNL	60	TR/TR	13,08	15°	**069100**	•
Höfer, Panhans, Langzauner	300	4,4	3,0	30	2/10/60	60	TR/TR	15,70	15°	**069104**	•
Striebig	300	3,2	2,2	30	KNL	72	TR/TR	13,08	15°	**069102**	•
Höfer, Panhans, Langzauner, Schelling	350	4,4	3,2	30	2/10/60	72	TR/TR	15,26	15°	**069109**	•
Homag	350	4,4	3,2	75		72	TR/TR	15,26	15°	**069110**	•
	370	4,4	3,5	30	2/10/60	72	TR/TR	16,14	15°	**069112**	•
Giben	380	4,4	3,2	50	4/13/80	72	TR/TR	16,57	15°	**069138**	•
	380	4,8	3,5	60	2/14/100	72	TR/TR	16,57	15°	**069114**	•
	400	4,4	3,2	30	2/10/60	72	TR/TR	17,44	15°	**069115**	•
	400	4,4	3,2	75	4/15/105	72	TR/TR	17,44	15°	**069117**	•
	430	4,4	3,2	75	4/15/105	72	TR/TR	18,75	15°	**069120**	•
	430	4,4	3,2	80	2/9/130 4/19/120	72	TR/TR	18,75	15°	**069121**	•
	450	4,4	3,2	30		72	TR/TR	19,63	15°	**069122**	•
	450	4,8	3,6	60	2/14/125	72	TR/TR	19,63	15°	**069125**	
	460	4,4	3,2	30	2/13/94	72	TR/TR	20,06	15°	**069126**	•

Panel sizing saw blade





Sizing cuts – Premium

Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
VectorCut design – New innovative tooth shape for maximum efficiency by 30% longer tool life times and up to 15x resharpenable. Lower power consumption, up to 10% energy savings. Innovative gullet design for optimized chip disposal and noise reduction by up to 3 dB(A).

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
	300	4,4	3,2	30	KNL	60	FZ/TR	47,10	15°	**059726**	•
	350	4,4	3,2	30	KNL	72	FZ/TR	15,26	15°	**059729**	•
Holzma	350	4,4	3,2	60	2/14/100	72	FZ/TR	15,26	15°	**059730**	▫
	370	4,4	3,2	30	KNL	72	FZ/TR	16,13	15°	**059731**	•
Holzma	380	4,4	3,2	60	2/14/100	72	FZ/TR	16,57	15°	**059719**	•
Holzma	380	4,8	3,5	60	2/14/100	72	FZ/TR	16,57	15°	**059720**	•
	400	4,4	3,2	30	KNL	72	FZ/TR	17,44	15°	**059733**	•
Holzma	420	4,8	3,5	60		84	FZ/TR	15,70	15°	**059722**	•
	450	4,4	3,2	30	KNL	72	FZ/TR	19,62	15°	**059724**	•
Holzma	450	4,8	3,5	60	2/14/125	72	FZ/TR	19,62	15°	**059723**	•

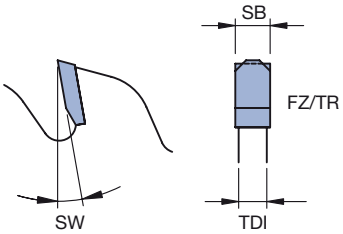
• available ex stock ▫ available at short notice

Sizing cuts – Classic

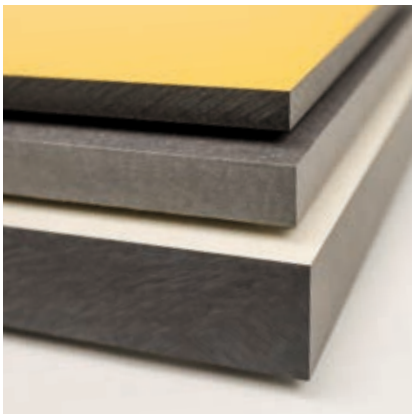
Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.

Panel sizing saw blade



Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
Höfer, Langzauner, Panhans	300	4,4	3,2	30	KNL	60	FZ/TR	15,70	15°	**059250**	•
Höfer, Langzauner, Panhans, Schelling	350	4,4	3,2	30	KNL	72	FZ/TR	15,26	15°	**059252**	•
Holzma	350	4,4	3,2	60	2/14/100	72	FZ/TR	15,26	15°	**059693**	•
Homag	350	4,4	3,2	75		72	FZ/TR	15,26	15°	**059253**	•
Höfer, Panhans, Scher, Schelling	400	4,4	3,2	30	KNL	72	FZ/TR	17,44	15°	**059256**	•
Homag	400	4,4	3,2	75		72	FZ/TR	17,44	15°	**059260**	•
Schelling	430	4,4	3,2	30		72	FZ/TR	18,75	15°	**059551**	•
Diverse	450	4,4	3,2	30		72	FZ/TR	19,63	15°	**059553**	•
Holzma	450	4,8	3,5	60	2/14/125	72	FZ/TR	19,63	15°	**059261**	•



Application:
For sizing panels of various thicknesses.

Workpiece material:
HGW, HP, HPL, PF, PUR
(Compact laminates)

Application recommendation:

Material	HGW	HP	HPL	PF	PUR
f_z (mm)	0,02 - 0,04	0,01 - 0,03	0,02 - 0,05	0,02 - 0,05	0,05 - 0,1
v_c (m/s)	45 - 65	50 - 70	60 - 75	50 - 60	50 - 70

Panel thickness	≤ 25 mm	> 25 mm
ZT	≤ 18	> 15

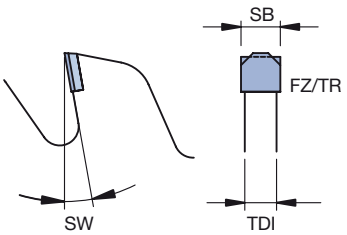
Sizing cuts – Excellent

Machine:
Table saws and circular sawing machines for sizing, cross cutting and panel sizing with scoring saw.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.
Diamaster PRO design.

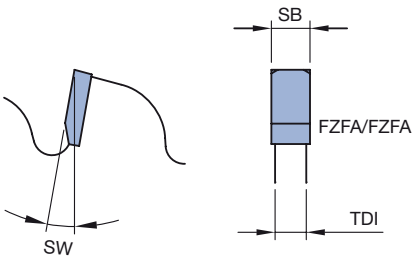
D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
303	3,2	2,2	30	KNL	60	FZ/TR	15,70	10°	**190673**	•
303	3,2	2,2	30	KNL	96	FZ/TR	9,81	10°	**190674**	•

Sizing saw blade



• available ex stock ▫ available at short notice

Sizing saw blade /
Portable circular saw blade



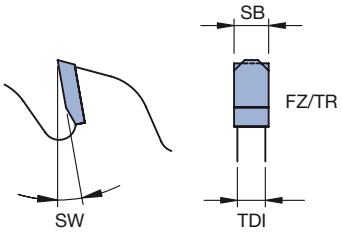
Sizing cuts in finish cut quality – Excellent

Machine:
Table saw, trimming saw, portable circular saw.

Technical information:
GlossCut design – tool body with vibration-damping laser ornaments and special tooth geometry. Optimized for sizing perfect cut surfaces and tear-free cutting edges. Noise reduction during idling and operation by up to 4 dB(A). Special tool design for significantly improved performance times.

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
160	2,2	1,6	20		48	FZFA/FZFA	10,47	+5°/-5°	**161008**	•
165	2,2	1,6	20		48	FZFA/FZFA	10,79	+5°/-5°	**161009**	•
190	2,4	1,8	20		58	FZFA/FZFA	10,29	+5°/-5°	**161010**	•
210	2,4	1,8	30		68	FZFA/FZFA	9,70	+5°/-5°	**161011**	•
250	2,8	2,2	30	KNL	72	FZFA/FZFA	10,90	+5°/-5°	**161012**	•
300	3,0	2,4	30	KNL	72	FZFA/FZFA	13,08	+5°/-5°	**161005**	•
300	3,0	2,4	30	KNL	96	FZFA/FZFA	9,81	+5°/-5°	**161006**	•
350	3,5	2,8	30	KNL	96	FZFA/FZFA	11,45	+5°/-5°	**161007**	•

Sizing saw blade



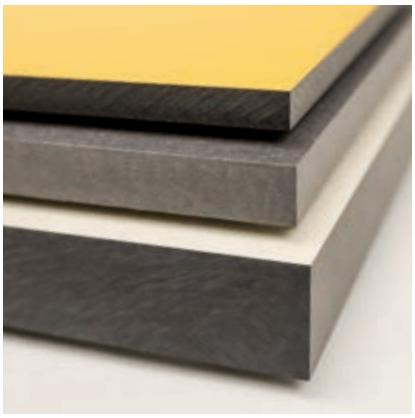
Sizing cuts – Premium

Machine:
Table saws and circular sawing machines for sizing, cross cutting and panel sizing with/without scoring saw.

Technical information:
AS OptiCut design – noise reduction during idling by up to 5 dB(A).
Tool body with vibration damping laser ornaments.

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
220	3,2	2,2	30	2/7/42	64	FZ/TR	10,79	10°	**061375**	•
250	3,2	2,2	30	KNL	72	FZ/TR	10,90	10°	**162000**	•
300	3,2	2,2	30	KNL	42	FZ/TR	22,43	10°	**068411**	•
300	3,2	2,2	30	KNL	72	FZ/TR	13,08	10°	**162001**	•
300	3,2	2,2	30	KNL	96	FZ/TR	9,81	10°	**162002**	•
350	3,5	2,5	30	KNL	48	FZ/TR	22,90	10°	**068413**	•
350	3,2	2,4	30	KNL	108	FZ/TR	10,18	10°	**162003**	•
400	3,8	2,5	30	KNL	54	FZ/TR	23,26	10°	**068415**	•

• available ex stock ▫ available at short notice



Application:
Zum Formatieren von Platten in verschiedenen Dicken.

Workpiece material:
HGW, HP, HPL, PF, PUR
(Compact laminates)

Application recommendation:

Material	HGW	HP	HPL	PF	PUR
f_z (mm)	0,02 - 0,04	0,01 - 0,03	0,02 - 0,05	0,02 - 0,05	0,05 - 0,1
v_c (m/s)	45 - 65	50 - 70	60 - 75	50 - 60	50 - 70

Panel thickness	≤ 25 mm	> 25 mm
ZT	≤ 18	> 15

End trimming cut – Classic

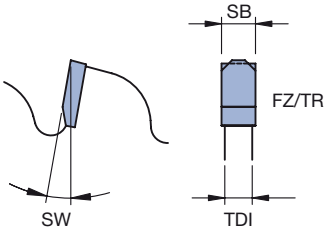
Machine:
Portable saws, trimming-, mitre saws, radial arm saws and table saws.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.

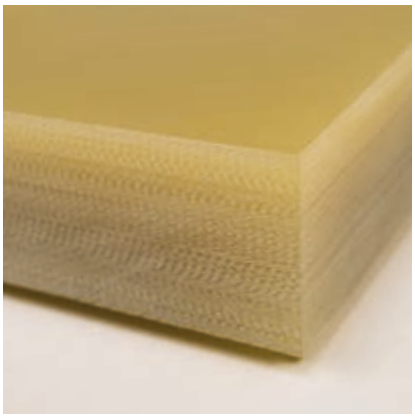
Portable circular saw blade



HW



D mm	SB mm	TDI mm	BO mm	Z	ZF	ZT mm	SW	ID	
160	2,5	1,8	20	56	FZ/TR	8,97	-5°	**070047**	•
190	2,6	1,8	20	54	FZ/TR	11,05	-5°	**060707**	•
190	2,8	2,2	30	68	FZ/TR	8,77	-5°	**070054**	•
210	2,8	2,0	30	60	FZ/TR	10,99	-5°	**070067**	•
210	2,4	1,6	30	64	FZ/TR	10,30	-5°	**070105**	•
216	3,0	2,4	30	64	FZ/TR	10,60	-5°	**060686**	•
225	2,6	1,8	30	68	FZ/TR	10,39	-5°	**070041**	•
235	3,2	2,6	25	54	FZ/TR	13,66	-5°	**070732**	•
240	2,8	2,2	30	80	FZ/TR	9,42	-5°	**070062**	•
250	3,4	2,8	30	60	FZ/TR	13,08	-5°	**060134**	•
250	2,8	2,0	30	80	FZ/TR	9,81	-5°	**070119**	•
250	3,2	2,6	30	80	FZ/TR	9,81	-5°	**060250**	•
300	3,2	2,6	30	96	FZ/TR	9,81	-5°	**060252**	•



Application:
For sizing single panels and stacks of panels.

Workpiece material:
GFK, CFK

Application recommendation:

Material	GFK	CFK
f_z (mm)	0,01 - 0,02	0,01 - 0,02
v_c (m/s)	30 - 60	30 - 60

Panel thickness	≤ 25 mm	> 25 mm
ZT	≤ 16	> 16

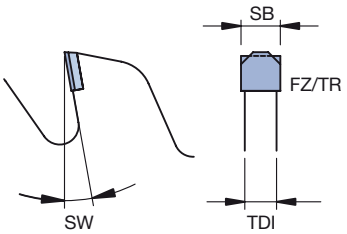
Sizing cuts – Excellent

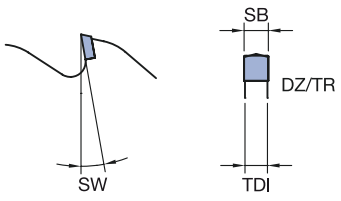
Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results. **AS LowNoise UT** design – noise reduction during idling by up to 6 dB(A). Tool body with vibration damping irregular tooth pitch. **Diamaster PLUS** design with 6.0 mm tip height.

Panel sizing saw blade

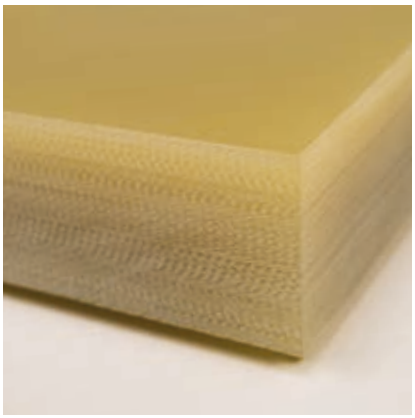






D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
300	4,4	3,2	30	2/10/60	60	FZ/TR	15,70	15°	**190604**	•
350	4,0	3,2	30		48	DZ/TR	22,91	10°	**180000**	•
350	4,4	3,2	30	2/10/60	72	FZ/TR	15,26	15°	**190606**	•
380	4,8	3,5	60	2/14/100 2/14/125	72	FZ/TR	16,57	15°	**190607**	•
400	4,4	3,2	30	2/10/60	72	FZ/TR	17,44	15°	**190608**	•

• available ex stock ▫ available at short notice



Application:
For sizing panels of various thicknesses.

Workpiece material:
GFK, CFK

Application recommendation:

Material	GFK	CFK
f_z (mm)	0,01 - 0,02	0,01 - 0,02
v_c (m/s)	30 - 60	30 - 60

Panel thickness	≤ 25 mm	> 25 mm
ZT	≤ 16	> 16

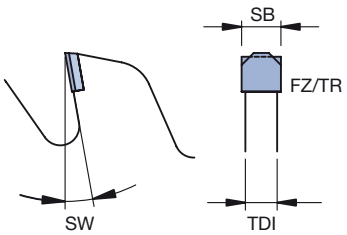
Sizing cuts – Excellent

Machine:
Table saws and circular sawing machines for sizing, cross cutting and panel sizing with scoring saw.

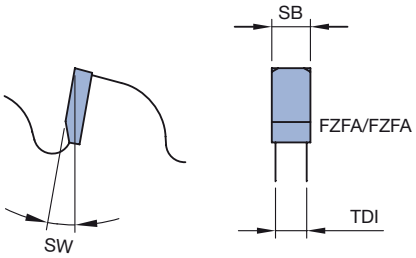
Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.
Diamaster PRO design.

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
303	3,2	2,2	30	KNL	60	FZ/TR	15,7	10°	**190673**	•
303	3,2	2,2	30	KNL	96	FZ/TR	9,81	10°	**190674**	•

Sizing saw blade



Portable-, sizing-, trimming- and mitre cutting saw blade



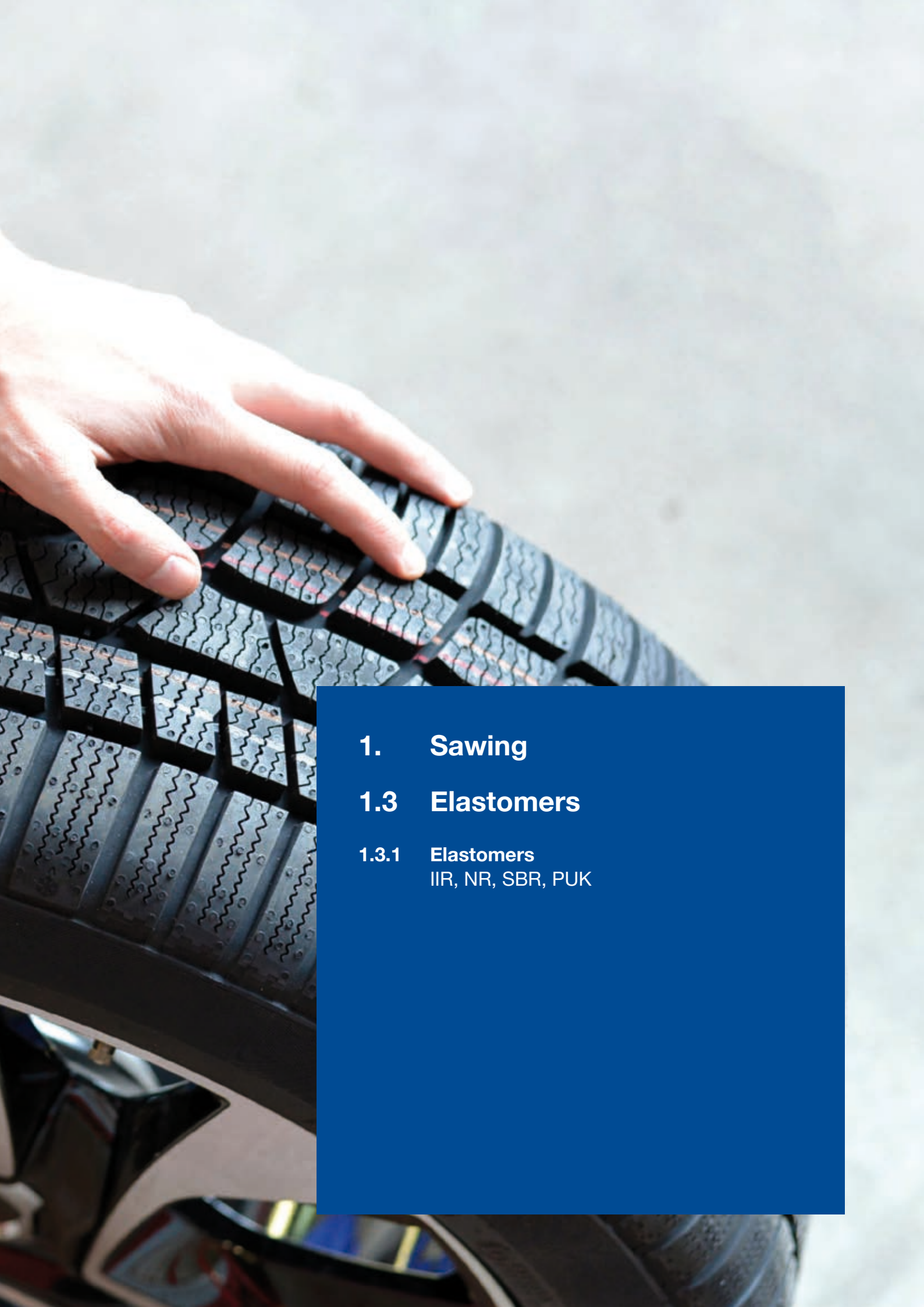
Cross- and mitre cut – Classic

Machine:
Cut-off saws, cross cut saws, mitre saws, portable saws and double cut-off saws.

Technical information:
Especially suited for thin-walled panels and profiles through negative cutting angle and reduced cutting width. Suitable for small batch sizes.

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID
160	1,6	1,2	20		60	FZFA/FZFA	8,37	-5°	**060277** •
190	1,8	1,4	20		72	FZFA/FZFA	8,29	-5°	**060278** •
200	1,8	1,4	20	KNL	80	FZFA/FZFA	7,85	-5°	**060274** •
250	2,0	1,6	30	KNL	100	FZFA/FZFA	7,85	-5°	**060275** •
300	2,2	1,8	30	KNL	120	FZFA/FZFA	7,85	-5°	**060276** •
350	2,4	2,0	30	KNL	140	FZFA/FZFA	7,85	-5°	**060279** •

• available ex stock ▫ available at short notice



1. Sawing

1.3 Elastomers

1.3.1 Elastomers

IIR, NR, SBR, PUK

Application:
For sizing single panels and stacks of panels.

Workpiece material:
IIR, NR, SBR, PUK

Application recommendation:

Material	IIR	NR	SBR	PUK
f_z (mm)	0,03 - 0,06	0,01 - 0,03	0,01 - 0,03	0,01 - 0,03
v_c (m/s)	50 - 70	50 - 70	50 - 70	50 - 70

Panel thickness	≤ 10 mm	> 10 mm
ZT	≤ 12	> 11

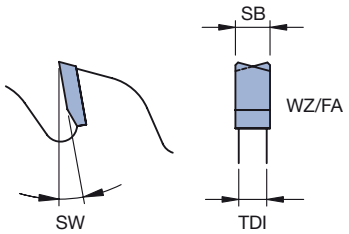
Sizing cuts – Excellent

Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
Special cutting geometry for perfect cut surfaces and tear-free cutting edges.
AS LowNoise foil design – noise reduction during operation by up to 10 dB(A).
Vibration-damping composite construction of the tool body for best possible cutting quality and exceptional performance.

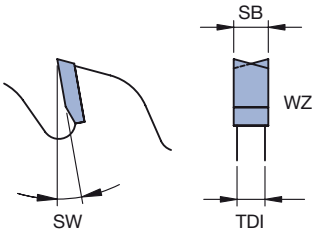
Panel sizing saw blade

D mm	SB mm	TDI mm	BO mm	NLA mm	Foil	Z	ZF	ZT mm	SW	ID
300	3,5	2,5	30	2/10/60	right	20	WZ/FA	47,10	15°	**065342** •
300	3,5	2,5	30	2/10/60	right	60	WZ/FA	15,70	15°	**065343** •
350	4,4	3,2	30	2/10/60	right	64	WZ/FA	17,17	15°	**065345** •
380	4,8	3,5	60	2/14/100	left	72	WZ/FA	16,57	15°	**065353** •
400	4,4	3,2	30	2/10/60	right	72	WZ/FA	17,44	15°	**065346** •



• available ex stock ▫ available at short notice

Panel sizing saw blade



Sizing cuts – Classic

Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID
Höfer	300	4,4	3,0	30	KNL	48	WZ	19,63	15°	**059100** •
Höfer, Schelling	350	4,4	3,2	30	KNL	54	WZ	20,35	15°	**059102** •
	400	4,4	3,2	30	KNL	72	WZ	17,44	15°	**059185** •
	450	4,4	3,2	30	KNL	72	WZ	19,63	15°	**059433** •
	500	5,2	3,5	30	KNL	60	WZ	26,17	15°	**059442** •

Application:
For sizing panels of various thicknesses.

Workpiece material:
IIR, NR, SBR, PUK

Application recommendation:

Material	IIR	NR	SBR	PUK
f_z (mm)	0,03 - 0,06	0,01 - 0,03	0,01 - 0,03	0,01 - 0,03
v_c (m/s)	50 - 70	50 - 70	50 - 70	50 - 70

Panel thickness	≤ 10 mm	> 10 mm
ZT	≤ 12	> 11

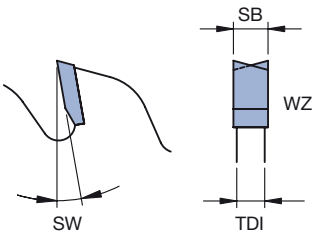
Sizing cuts – Classic

Machine:
Circular sawing machines for sizing, cross cutting, multi-rip saws and table saws.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.

Sizing saw blade

HW



D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID
300	3,2	2,2	30	KNL	48	WZ	19,63	10°	**058057** •
300	3,2	2,2	30	KNL	72	WZ	13,08	10°	**058384** •
300	3,2	2,2	30	KNL	96	WZ	9,81	10°	**058311** •
350	3,2	2,2	30	KNL	54	WZ	20,35	10°	**058059** •
350	3,2	2,2	30	KNL	72	WZ	15,26	10°	**058206** •
350	3,2	2,2	30	KNL	108	WZ	10,18	10°	**058308** •
400	3,2	2,2	30	KNL	120	WZ	10,47	10°	**058309** •
400	3,8	2,8	30	KNL	60	WZ	20,93	10°	**058061** •
400	3,8	2,8	30	KNL	84	WZ	14,95	10°	**058225** •
450	3,8	2,8	30	KNL	66	WZ	21,41	10°	**058062** •
500	3,8	2,8	30	KNL	72	WZ	21,81	10°	**058063** •

• available ex stock ▫ available at short notice

1. Sawing

1.4 Foams

1.4.1 Foams

PUR, XPS, EPS

Application:
For sizing single panels and stacks of panels.

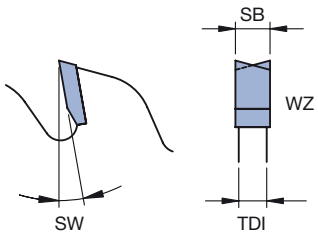
Workpiece material:
PUR, XPS, EPS

Application recommendation:

Material	PUR	XPS	EPS
f_z (mm)	0,4 - 0,6	0,2 - 0,4	0,6 - 0,6
v_c (m/s)	50 - 80	30 - 60	50 - 60

Panel thickness	≤ 25 mm	> 25 mm
ZT	≤ 18	> 15

Panel sizing saw blade



Sizing cuts – Classic

Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
Höfer	300	4,4	3,0	30	KNL	48	WZ	19,63	15°	**059100**	•
Höfer, Schelling	350	4,4	3,2	30	KNL	54	WZ	20,35	15°	**059102**	•
	400	4,4	3,2	30	KNL	72	WZ	17,44	15°	**059185**	•
	450	4,4	3,2	30	KNL	72	WZ	19,63	15°	**059433**	•
	500	5,2	3,5	30	KNL	60	WZ	26,17	15°	**059442**	•

• available ex stock ▫ available at short notice

Application:
For sizing panels of various thicknesses.

Workpiece material:
PUR, XPS, EPS

Application recommendation:

Material	PUR	XPS	EPS
f_z (mm)	0,4 - 0,6	0,2 - 0,4	0,6 - 0,6
v_c (m/s)	50 - 80	30 - 60	50 - 60

Panel thickness	≤ 25 mm	> 25 mm
ZT	≤ 18	> 15

Sizing cuts – Classic

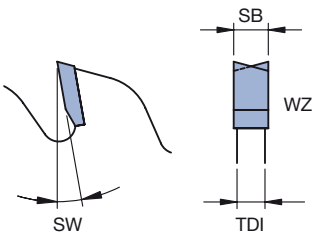
Machine:
Circular sawing machines for sizing, cross cutting, multi-rip saws and table saws.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.

Sizing saw blade



HW



D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID
300	3,2	2,2	30	KNL	48	WZ	19,63	10°	**058057** •
300	3,2	2,2	30	KNL	72	WZ	13,08	10°	**058384** •
300	3,2	2,2	30	KNL	96	WZ	9,81	10°	**058311** •
350	3,2	2,2	30	KNL	54	WZ	20,35	10°	**058059** •
350	3,2	2,2	30	KNL	72	WZ	15,26	10°	**058206** •
350	3,2	2,2	30	KNL	108	WZ	10,18	10°	**058308** •
400	3,2	2,2	30	KNL	120	WZ	10,47	10°	**058309** •
400	3,8	2,8	30	KNL	60	WZ	20,93	10°	**058061** •
400	3,8	2,8	30	KNL	84	WZ	14,95	10°	**058225** •
450	3,8	2,8	30	KNL	66	WZ	21,41	10°	**058062** •
500	3,8	2,8	30	KNL	72	WZ	21,81	10°	**058063** •

Application:
For sizing panels of various thicknesses.

Workpiece material:
PUR, XPS, EPS

Application recommendation:

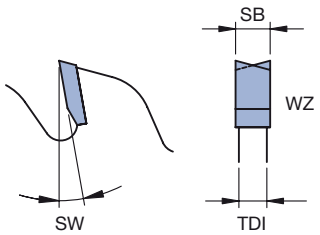
Material	PUR	XPS	EPS
f_z (mm)	0,4 - 0,6	0,2 - 0,4	0,6 - 0,6
v_c (m/s)	50 - 80	30 - 60	50 - 60

Panel thickness	≤ 25 mm	> 25 mm
ZT	≤ 18	> 15

Portable circular saw blade



HW



Multi-purpose cut – Classic

Machine:
Underfloor saws, circular saw benches, trimming saws and portable saws, light sliding table saws.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.

D mm	SB mm	TDI mm	BO mm	Z	ZF	ZT mm	SW	ID
150	2,8	1,8	20	24	WZ	19,63	10°	**060571** •
150	2,8	1,8	20	48	WZ	9,81	10°	**060572** •
160	2,5	1,6	16	24	WZ	20,93	15°	**070081** •
160	2,5	1,6	20	24	WZ	20,93	15°	**070083** •
160	2,5	1,6	16	48	WZ	10,47	10°	**070082** •
160	2,5	1,6	20	48	WZ	10,47	12°	**070037** •
165	2,5	1,6	20	24	WZ	21,59	15°	**070085** •
170	2,5	1,6	30	24	WZ	22,24	15°	**070087** •
170	2,5	1,6	30	48	WZ	11,12	10°	**070049** •
180	2,5	1,6	16	24	WZ	23,55	15°	**070088** •
180	2,5	1,6	20	24	WZ	23,55	15°	**070089** •
180	2,5	1,6	20	48	WZ	11,78	10°	**070090** •
180	2,5	1,6	30	24	WZ	23,55	15°	**070091** •
180	2,5	1,6	30	30	WZ	18,84	10°	**070092** •
180	2,5	1,6	30	58	WZ	9,74	10°	**070093** •
185	2,5	1,6	20	24	WZ	24,20	15°	**070094** •
190	2,8	1,8	16	24	WZ	24,86	15°	**060606** •
190	2,8	1,8	16	48	WZ	12,43	10°	**060607** •
190	2,8	1,8	30	48	WZ	12,43	8°	**070036** •
190	2,6	1,8	20	24	WZ	24,86	15°	**070096** •
190	2,6	1,8	20	48	WZ	12,43	10°	**070097** •
200	3,0	2,0	30	16	WZ	39,25	15°	**070121** •
200	3,0	2,0	30	34	WZ	18,47	10°	**060627** •

• available ex stock ▫ available at short notice

D mm	SB mm	TDI mm	BO mm	Z	ZF	ZT mm	SW	ID
200	3,0	2,0	30	48	WZ	13,08	10°	**070122** •
200	3,0	1,6	30	64	WZ	9,81	10°	**070123** •
210	2,4	1,6	30	24	WZ	27,48	15°	**070100** •
210	2,6	1,8	30	56	WZ	11,78	10°	**070106** •
210	2,4	1,6	30	64	WZ	10,30	10°	**070104** •
220	3,2	2,2	30	34	WZ	20,32	15°	**060644** •
220	3,2	2,2	30	64	WZ	10,79	10°	**060646** •
225	2,6	1,8	30	48	WZ	14,72	10°	**070113** •
230	3,2	2,2	30	12	WZ	60,18	15°	**060647** •
230	3,2	2,2	30	34	WZ	21,24	15°	**060648** •
235	3,2	2,2	16	24	WZ	30,75	15°	**060649** •
235	3,2	2,2	30	24	WZ	30,75	15°	**060652** •
235	3,2	2,2	30	34	WZ	21,70	15°	**060653** •
240	3,0	2,0	30	34	WZ	22,16	15°	**060656** •
240	3,0	1,8	30	48	WZ	15,70	10°	**070060** •
250	3,2	2,2	30	40	WZ	19,63	10°	**058055** •
250	3,2	2,2	30	60	WZ	13,08	10°	**058382** •
250	2,8	1,8	30	80	WZ	9,81	10°	**070118** •
250	3,2	2,2	30	80	WZ	9,81	10°	**058304** •

1. Sawing

1.5 Polymer-compound mineral working material

1.5.1 Polymer-compound mineral working material

Corian®, HI-MACS®, Staron®, GetaCore®, Varicor®, Marlan®

Application:
For sizing single panels and stacks of panels.

Workpiece material:
Corian®, HI-MACS®, Staron®, GetaCore®, Varicor®, Marlan®

Application recommendation:

Material	Corian®	HI-MACS®	Staron®	GetaCore®	Varicor®	Marlan®
f_z (mm)	0,02 - 0,04	0,02 - 0,04	0,02 - 0,04	0,02 - 0,04	0,02 - 0,04	0,02 - 0,04
v_c (m/s)	50 - 70	50 - 70	50 - 70	50 - 70	50 - 70	50 - 70

Panel thickness	≤ 15 mm	> 15 mm
ZT	≤ 20	> 18

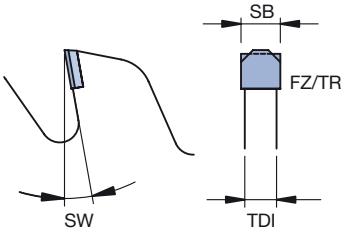
Sizing cuts – Excellent

Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results. **AS LowNoise UT** design – noise reduction during idling by up to 6 dB(A). Tool body with vibration damping irregular tooth pitch. **Diamaster PLUS** design with 6.0 mm tip height.

Panel sizing saw blade

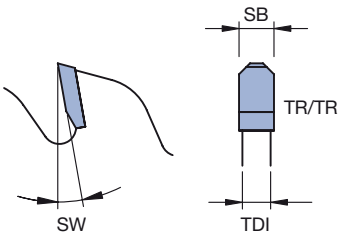




D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
300	4,4	3,2	30	2/10/60	60	FZ/TR	15,70	15°	**190604**	•
350	4,4	3,2	30	2/10/60	72	FZ/TR	15,26	15°	**190606**	•
380	4,8	3,5	60	2/14/100 2/14/125	72	FZ/TR	16,57	15°	**190607**	•
400	4,4	3,2	30	2/10/60	72	FZ/TR	17,44	15°	**190608**	•

• available ex stock ▫ available at short notice

Panel sizing saw blade



Sizing cuts – Excellent

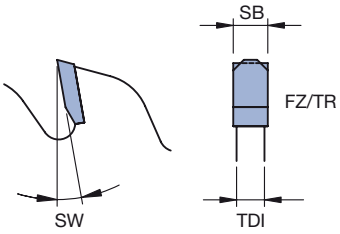
Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
RazorCut design – Special cutting geometry for perfect cut surfaces and tear-free cutting edges. **AS OptiCut UT** design - noise reduction during idling by up to 8 dB(A). Tool body with laser ornaments and irregular tooth pitch. Tool body with special coating for increased performance and less resin.

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
Striebig	250	3,2	2,2	30	KNL	60	TR/TR	13,08	15°	**069100**	•
Höfer, Panhans, Langzauner	300	4,4	3,0	30	2/10/60	60	TR/TR	15,70	15°	**069104**	•
Striebig	300	3,2	2,2	30	KNL	72	TR/TR	13,08	15°	**069102**	•
Höfer, Panhans, Langzauner, Schelling	350	4,4	3,2	30	2/10/60	72	TR/TR	15,26	15°	**069109**	•
Homag	350	4,4	3,2	75		72	TR/TR	15,26	15°	**069110**	•
	370	4,4	3,5	30	2/10/60	72	TR/TR	16,14	15°	**069112**	•
Giben	380	4,4	3,2	50	4/13/80	72	TR/TR	16,57	15°	**069138**	•
	380	4,8	3,5	60	2/14/100	72	TR/TR	16,57	15°	**069114**	•
	400	4,4	3,2	30	2/10/60	72	TR/TR	17,44	15°	**069115**	•
	400	4,4	3,2	75	4/15/105	72	TR/TR	17,44	15°	**069117**	•
	430	4,4	3,2	75	4/15/105	72	TR/TR	18,75	15°	**069120**	•
	430	4,4	3,2	80	2/9/130 4/19/120	72	TR/TR	18,75	15°	**069121**	•
	450	4,4	3,2	30		72	TR/TR	19,63	15°	**069122**	•
	450	4,8	3,6	60	2/14/125	72	TR/TR	19,63	15°	**069125**	•
	460	4,4	3,2	30	2/13/94	72	TR/TR	20,06	15°	**069126**	•

Panel sizing saw blade





Sizing cuts – Premium

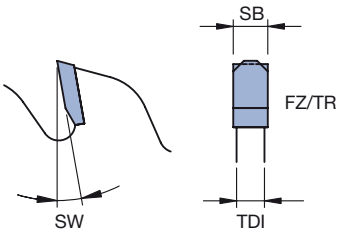
Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
VectorCut design – New innovative tooth shape for maximum efficiency by 30% longer tool life times and up to 15x resharpenable. Lower power consumption, up to 10% energy savings. Innovative gullet design for optimized chip disposal and noise reduction by up to 3 dB(A).

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID
	300	4,4	3,2	30	KNL	20	FZ/TR	15,70	15°	**059725** •
	300	4,4	3,2	30	KNL	60	FZ/TR	47,10	15°	**059726** •
	350	4,4	3,2	30	KNL	24	FZ/TR	45,79	15°	**059727** •
Holzma	350	4,4	3,2	60	2/14/100	24	FZ/TR	45,79	15°	**059728** ▫
	350	4,4	3,2	30	KNL	72	FZ/TR	15,26	15°	**059729** •
Holzma	350	4,4	3,2	60	2/14/100	72	FZ/TR	15,26	15°	**059730** ▫
	370	4,4	3,2	30	KNL	72	FZ/TR	16,13	15°	**059731** •
Holzma	380	4,8	3,5	60	2/14/100	24	FZ/TR	49,72	15°	**059732** •
Holzma	380	4,4	3,2	60	2/14/100	72	FZ/TR	16,57	18°	**059719** •
Holzma	380	4,8	3,5	60	2/14/100	72	FZ/TR	16,57	15°	**059720** •
	400	4,4	3,2	30	KNL	72	FZ/TR	17,44	15°	**059733** •
Holzma	420	4,8	3,5	60		84	FZ/TR	15,70	15°	**059722** •
	450	4,4	3,2	30	KNL	72	FZ/TR	19,62	15°	**059724** •
Holzma	450	4,8	3,5	60	2/14/125	72	FZ/TR	19,62	15°	**059723** •

• available ex stock ▫ available at short notice

Panel sizing saw blade



Sizing cuts – Classic

Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID
Höfer, Langzauner, Panhans	300	4,4	3,2	30	KNL	60	FZ/TR	15,70	15°	**059250** •
Höfer, Langzauner, Panhans, Schelling	350	4,4	3,2	30	KNL	72	FZ/TR	15,26	15°	**059252** •
Holzma	350	4,4	3,2	60	2/14/100	72	FZ/TR	15,26	15°	**059693** •
Homag	350	4,4	3,2	75		72	FZ/TR	15,26	15°	**059253** •
Höfer, Panhans, Scher, Schelling	400	4,4	3,2	30	KNL	72	FZ/TR	17,44	15°	**059256** •
Homag	400	4,4	3,2	75		72	FZ/TR	17,44	15°	**059260** •
Schelling	430	4,4	3,2	30		72	FZ/TR	18,75	15°	**059551** •
Diverse	450	4,4	3,2	30		72	FZ/TR	19,63	15°	**059553** •
Holzma	450	4,8	3,5	60	2/14/125	72	FZ/TR	19,63	15°	**059261** •

Application:
For sizing panels of various thicknesses.

Workpiece material:
Corian®, HI-MACS®, Staron®, GetaCore®, Varicor®, Marlan®

Application recommendation:

Material	Corian®	HI-MACS®	Staron®	GetaCore®	Varicor®	Marlan®
f_z (mm)	0,02 - 0,04	0,02 - 0,04	0,02 - 0,04	0,02 - 0,04	0,02 - 0,04	0,02 - 0,04
v_c (m/s)	50 - 70	50 - 70	50 - 70	50 - 70	50 - 70	50 - 70

Panel thickness	≤ 15 mm	> 15 mm
ZT	≤ 20	> 18

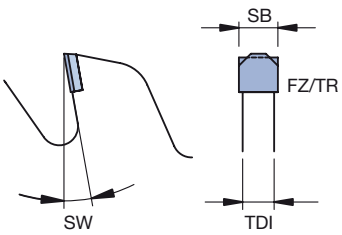
Sizing cuts – Excellent

Machine:
Table saws and circular sawing machines for sizing, cross cutting and panel sizing with scoring saw.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.
Diamaster PRO design.

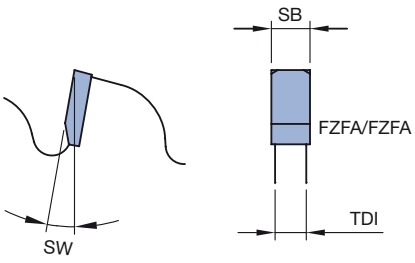
D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID
303	3,2	2,2	30	KNL	60	FZ/TR	15,70	10°	**190673** •
303	3,2	2,2	30	KNL	96	FZ/TR	9,81	10°	**190674** •

Sizing saw blade



• available ex stock ▫ available at short notice

Sizing saw blade/
Portable circular saw blade



Sizing cuts in finish cut quality – Excellent

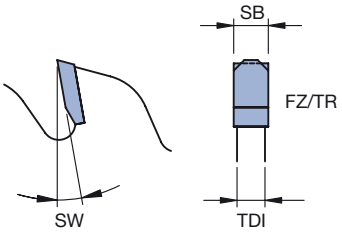
Machine:
Table saw, trimming saw, portable circular saw.

Technical information:
GlossCut design – tool body with vibration-damping laser ornaments and special tooth geometry. Optimized for sizing perfect cut surfaces and tear-free cutting edges. Noise reduction during idling and operation by up to 4 dB(A).
Special tool design for significantly improved performance times.

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
160	2,2	1,6	20		48	FZFA/FZFA	10,47	+5°/-5°	**161008**	•
165	2,2	1,6	20		48	FZFA/FZFA	10,79	+5°/-5°	**161009**	•
190	2,4	1,8	20		58	FZFA/FZFA	10,29	+5°/-5°	**161010**	•
210	2,4	1,8	30		68	FZFA/FZFA	9,70	+5°/-5°	**161011**	•
250	2,8	2,2	30	KNL	72	FZFA/FZFA	10,90	+5°/-5°	**161012**	•
300	3,0	2,4	30	KNL	72	FZFA/FZFA	13,08	+5°/-5°	**161005**	•
300	3,0	2,4	30	KNL	96	FZFA/FZFA	9,81	+5°/-5°	**161006**	•
350	3,5	2,8	30	KNL	96	FZFA/FZFA	11,45	+5°/-5°	**161007**	•

Sizing saw blade





Sizing cuts – Premium

Machine:
Table saws and circular sawing machines for sizing, cross cutting and panel sizing with/without scoring saw.

Technical information:
AS OptiCut design – noise reduction during idling by up to 5 dB(A).
Tool body with vibration damping laser ornaments.

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
220	3,2	2,2	30	2/7/42	64	FZ/TR	10,79	10°	**061375**	•
250	3,2	2,2	30	KNL	72	FZ/TR	10,90	10°	**162000**	•
300	3,2	2,2	30	KNL	42	FZ/TR	22,43	10°	**068411**	•
300	3,2	2,2	30	KNL	72	FZ/TR	13,08	10°	**162001**	•
300	3,2	2,2	30	KNL	96	FZ/TR	9,81	10°	**162002**	•
350	3,5	2,5	30	KNL	48	FZ/TR	22,90	10°	**068413**	•
350	3,2	2,4	30	KNL	108	FZ/TR	10,18	10°	**162003**	•
400	3,8	2,5	30	KNL	54	FZ/TR	23,26	10°	**068415**	•

• available ex stock ▫ available at short notice

Application:
For sizing panels of various thicknesses.

Workpiece material:
Corian®, HI-MACS®, Staron®, GetaCore®, Varicor®, Marlan®

Application recommendation:

Material	Corian®	HI-MACS®	Staron®	GetaCore®	Varicor®	Marlan®
f_z (mm)	0,02 - 0,04	0,02 - 0,04	0,02 - 0,04	0,02 - 0,04	0,02 - 0,04	0,02 - 0,04
v_c (m/s)	50 - 70	50 - 70	50 - 70	50 - 70	50 - 70	50 - 70

Panel thickness	≤ 10 mm	> 10 mm
ZT	≤ 11	> 9

End trimming cut – Classic

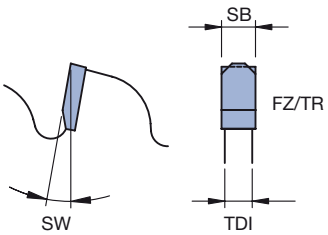
Machine:
Portable saws, trimming-, mitre saws, radial arm saws and table saws

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.

Portable circular saw blade

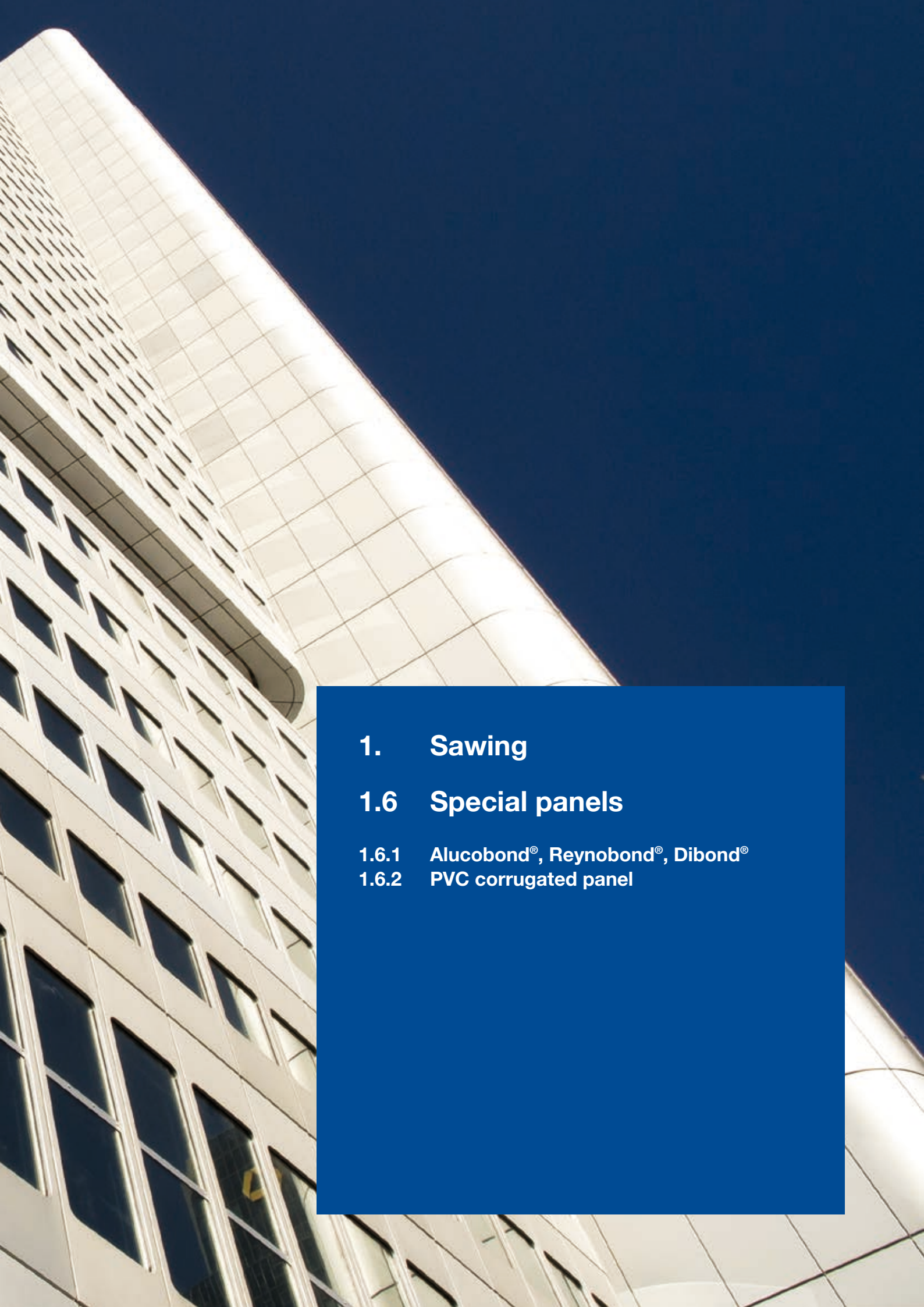


HW



D mm	SB mm	TDI mm	BO mm	Z	ZF	ZT mm	SW	ID
160	2,5	1,8	20	56	FZ/TR	8,97	-5°	**070047** •
190	2,6	1,8	20	54	FZ/TR	11,05	-5°	**060707** •
190	2,8	2,2	30	68	FZ/TR	8,77	-5°	**070054** •
210	2,8	2,0	30	60	FZ/TR	10,99	-5°	**070067** •
210	2,4	1,6	30	64	FZ/TR	10,30	-5°	**070105** •
216	3,0	2,4	30	64	FZ/TR	10,60	-5°	**060686** •
225	2,6	1,8	30	68	FZ/TR	10,39	-5°	**070041** •
235	3,2	2,6	25	54	FZ/TR	13,66	-5°	**070732** •
240	2,8	2,2	30	80	FZ/TR	9,42	-5°	**070062** •
250	3,4	2,8	30	60	FZ/TR	13,08	-5°	**060134** •
250	2,8	2,0	30	80	FZ/TR	9,81	-5°	**070119** •
250	3,2	2,6	30	80	FZ/TR	9,81	-5°	**060250** •
300	3,2	2,6	30	96	FZ/TR	9,81	-5°	**060252** •

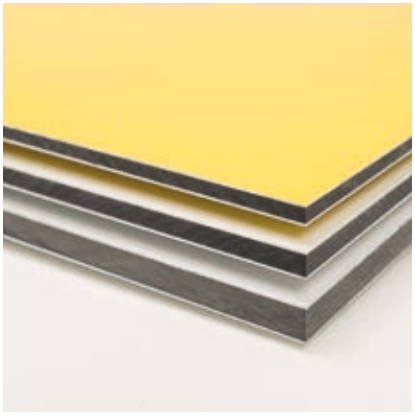
• available ex stock ▫ available at short notice



1. Sawing

1.6 Special panels

1.6.1 Alucobond®, Reynobond®, Dibond®
1.6.2 PVC corrugated panel



Application:
For sizing single panels and stacks of panels.

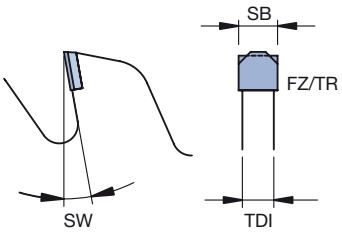
Workpiece material:
Alucobond®, Reynobond®, Dibond®

Application recommendation:

Material	Alucobond®	Reynobond®	Dibond®
f_z (mm)	0,01 - 0,02	0,01 - 0,02	0,01 - 0,02
v_c (m/s)	50 - 70	50 - 70	50 - 70

Panel thickness	≤ 25 mm	> 25 mm
ZT	≤ 18	> 15

Panel sizing saw blade



Sizing cuts – Excellent

Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results. **AS LowNoise UT** design – noise reduction during idling by up to 6 dB(A). Tool body with vibration damping irregular tooth pitch. **Diamaster PLUS** design with 6.0 mm tip height.

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID
300	4,4	3,2	30	2/10/60	60	FZ/TR	15,70	15°	**190604** •
350	4,4	3,2	30	2/10/60	72	FZ/TR	15,26	15°	**190606** •
380	4,8	3,5	60	2/14/100 2/14/125	72	FZ/TR	16,57	15°	**190607** •
400	4,4	3,2	30	2/10/60	72	FZ/TR	17,44	15°	**190608** •

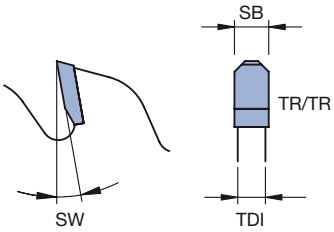
• available ex stock ▫ available at short notice

Sizing cuts in finish cut quality – Excellent

Machine:
Panel sizing systems with scoring saw and pressure beam.

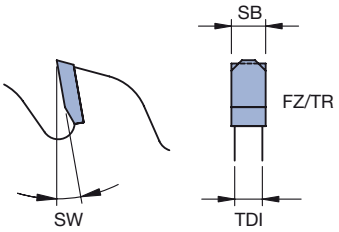
Technical information:
BrillianceCut design – tool body with vibration-damping laser ornaments and special tooth geometry. Optimized for sizing perfect cut surfaces and tear-free cutting edges. Machined surfaces can be finished to glossy quality with minimal rework efforts. Noise reduction during idling and operation by up to 4 dB(A). Special tool design for significantly improved performance times.
Ideally suited for transparent thermoplastics.

Panel sizing saw blade



D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
300	3,2	2,2	30	KNL	60	TR/TR	15,70	15°	**161013**	•
350	4,4	3,2	30	KNL	72	TR/TR	15,26	15°	**161014**	•
380	4,8	3,5	60	2/14/100	84	TR/TR	14,20	15°	**161015**	•
400	4,8	3,5	30	KNL	72	TR/TR	17,44	15°	**161016**	•
450	4,8	3,5	30	KNL	72	TR/TR	19,63	15°	**161017**	•

Panel sizing saw blade



Sizing cuts – Classic

Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
Höfer, Langzauner, Panhans	300	4,4	3,2	30	KNL	60	FZ/TR	15,70	15°	**059250**	•
Höfer, Langzauner, Panhans, Schelling	350	4,4	3,2	30	KNL	72	FZ/TR	15,26	15°	**059252**	•
Holzma	350	4,4	3,2	60	2/14/100	72	FZ/TR	15,26	15°	**059693**	•
Homag	350	4,4	3,2	75		72	FZ/TR	15,26	15°	**059253**	•
Höfer, Panhans, Scher, Schelling	400	4,4	3,2	30	KNL	72	FZ/TR	17,44	15°	**059256**	•
Homag	400	4,4	3,2	75		72	FZ/TR	17,44	15°	**059260**	•
Schelling	430	4,4	3,2	30		72	FZ/TR	18,75	15°	**059551**	•
Diverse	450	4,4	3,2	30		72	FZ/TR	19,63	15°	**059553**	•
Holzma	450	4,8	3,5	60	2/14/125	72	FZ/TR	19,63	15°	**059261**	•

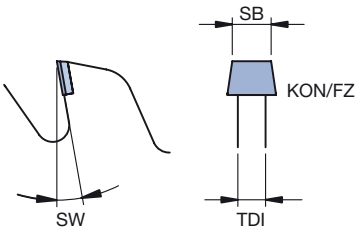
• available ex stock ▫ available at short notice

Scoring – Excellent

Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
The cutting width of the scoring saw blade must be 0.10 mm less than the cutting width of the main saw blade. **AS LowNoise UT** design – noise reduction during idling by up to 3 dB(A). Tool body with irregular tooth pitch.
Diamaster PLUS design with 6.0 mm tip height.

Scoring saw blade



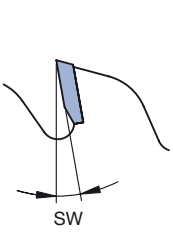
D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
125	3,1	2,5	20		20	KON/FZ	19,63	10°	**190564**	•
125	3,1	2,5	22		20	KON/FZ	19,63	10°	**190614**	▫
150	4,3	3,2	20		24	KON/FZ	19,63	10°	**190577**	•
150	4,3	3,2	30		24	KON/FZ	19,63	10°	**190565**	•
150	4,3	3,2	45		24	KON/FZ	19,63	10°	**190578**	▫
160	4,3	3,5	30		30	KON/FZ	16,75	10°	**190579**	•
160	4,3	3,2	45	3/11/70	30	KON/FZ	16,75	10°	**190580**	
160	4,3	3,5	55	3/7/66	30	KON/FZ	16,75	10°	**190566**	•
180	4,3	3,5	20	2/10/60	30	KON/FZ	18,84	10°	**190581**	•
180	4,3	3,5	30	2/10/60	30	KON/FZ	18,84	10°	**190567**	•
180	4,3	3,5	45		30	KON/FZ	18,84	10°	**190568**	•
180	4,7	3,5	45		30	KON/FZ	18,84	10°	**190569**	•
180	4,3	3,2	50	3/13/80	30	KON/FZ	18,84	10°	**190582**	
200	4,3	3,5	20	2/11/66	30	KON/FZ	20,93	10°	**190570**	•
200	4,3	3,5	30	2/10/60	30	KON/FZ	20,93	10°	**190571**	•
200	4,3	3,5	45	2/9/110 2/9/100 2/14/110	30	KON/FZ	20,93	10°	**190572**	•
200	4,7	3,5	45		30	KON/FZ	20,93	10°	**190573**	•
200	4,3	3,2	50	3/13/80	30	KON/FZ	20,93	10°	**190583**	▫
200	4,3	3,5	65	2/9/100 2/9/110	30	KON/FZ	20,93	10°	**190615**	▫
200	4,7	3,5	65	2/9/110	30	KON/FZ	20,93	10°	**190574**	•
200	4,3	3,5	80	2/9/110 2/9/100 2/14/110	30	KON/FZ	20,93	10°	**190616**	▫
215	4,3	3,2	50	3/15/80	36	KON/FZ	18,75	10°	**190575**	•
250	4,3	3,5	30	2/10/60	36	KON/FZ	21,81	10°	**190576**	•

Further scoring saw blades you can find in the Leitz-Lexicon.

Scoring saw blade

HW

Low Noise



Scoring – Classic

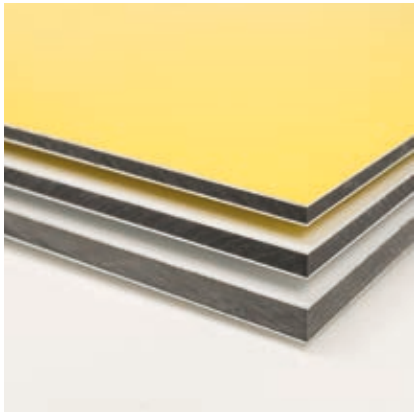
Machine:
Panel sizing systems with scoring saw and pressure beam.

Technical information:
The cutting width of the scoring saw blade must be identical to the cutting width of the main saw blade. If type UT, **AS LowNoise UT** design is used – noise reduction during idling by up to 3 dB(A).
Tool body with irregular tooth pitch.

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
SCM	100	3,2	2,5	20		20	KON/FZ	15,70	5°	**061556**	•
	100	3,2	2,5	22		20	KON/FZ	15,70	5°	**061557**	•
	120	3,2	2,5	20		24	KON/FZ	15,70	5°	**061552**	•
Panhans	125	4,4	3,5	20		24	KON/FZ	16,35	5°	**061516**	•
Holz Her	125	4,4	3,5	45		24	KON/FZ	16,35	5°	**061518**	□
Holz Her	140	4,4	3,5	45	1/8/58	24	KON/FZ	18,31	5°	**061519**	
Panhans, Teutomatic	180	4,4	3,5	30	2/10/60	30	KON/FZ	18,84	5°	**061517**	•
Holzma	180	4,8	3,5	45		36	KON/FZ	15,70	5°	**061526**	•
Holzma	180	3,8	3,5	45		36	KON/FZ	15,70	5°	**061566**	•
Holzma	180	3,8	3,0	45		54	KON/FZ	10,46	5°	**061568**	•
Scheer	200	4,8	3,5	30	2/10/60	36	KON/FZ	17,44	5°	**061561**	•
Holzma	200	4,8	3,5	45		36	KON/FZ	17,44	5°	**061527**	•
SCM	200	4,4	3,5	80	2/14/110	36	KON/FZ	17,44	5°	**061542**	•
Panhans	220	3,2	2,5	30		36	KON/FZ	19,19	5°	**061535**	•
Panhans	250	4,4	3,5	30	2/10/60	42	KON/FZ	18,69	5°	**061537**	•
Panhans	280	4,4	3,0	30	2/10/60	48	KON/FZ	18,31	5°	**061540**	•
Holzma	280	3,8	3,0	45	2/10/60	48	KON/FZ	18,31	5°	**061567**	•

Further scoring saw blades you can find in the Leitz-Lexicon.

• available ex stock □ available at short notice



Application:
For sizing panels of various thicknesses.

Workpiece material:
Alucobond®, Reynobond®, Dibond®

Application recommendation:

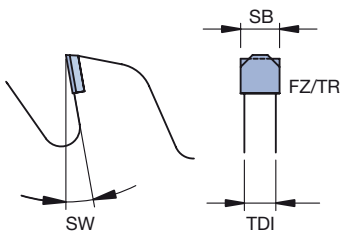
Material	Alucobond®	Reynobond®	Dibond®
f_z (mm)	0,01 - 0,02	0,01 - 0,02	0,01 - 0,02
v_c (m/s)	50 - 70	50 - 70	50 - 70

Panel thickness	≤ 10 mm	> 10 mm
ZT	≤ 12	> 10

Sizing saw blade



DP



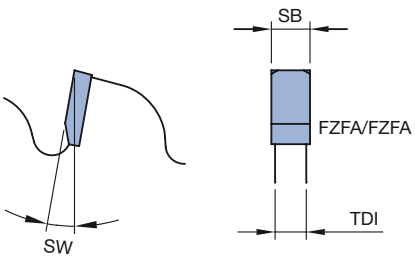
Sizing cuts – Excellent

Machine:
Table saws and circular sawing machines for sizing, cross cutting and panel sizing with scoring saw.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.
Diamaster PRO design.

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID
303	3,2	2,2	30	KNL	60	FZ/TR	15,70	10°	**190673** •
303	3,2	2,2	30	KNL	96	FZ/TR	9,81	10°	**190674** •

Sizing saw blade/
Portable circular saw blade



Sizing cuts in finish cut quality – Excellent

Machine:
Table saw, trimming saw, portable circular saw.

Technical information:
GlossCut design – tool body with vibration-damping laser ornaments and special tooth geometry. Optimized for sizing perfect cut surfaces and tear-free cutting edges. Noise reduction during idling and operation by up to 4 dB(A). Special tool design for significantly improved performance times.

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
160	2,2	1,6	20		48	FZFA/FZFA	10,47	+5°/-5°	**161008**	•
165	2,2	1,6	20		48	FZFA/FZFA	10,79	+5°/-5°	**161009**	•
190	2,4	1,8	20		58	FZFA/FZFA	10,29	+5°/-5°	**161010**	•
210	2,4	1,8	30		68	FZFA/FZFA	9,70	+5°/-5°	**161011**	•
250	2,8	2,2	30	KNL	72	FZFA/FZFA	10,90	+5°/-5°	**161012**	•
300	3,0	2,4	30	KNL	72	FZFA/FZFA	13,08	+5°/-5°	**161005**	•
300	3,0	2,4	30	KNL	96	FZFA/FZFA	9,81	+5°/-5°	**161006**	•
350	3,5	2,8	30	KNL	96	FZFA/FZFA	11,45	+5°/-5°	**161007**	•

• available ex stock ▫ available at short notice

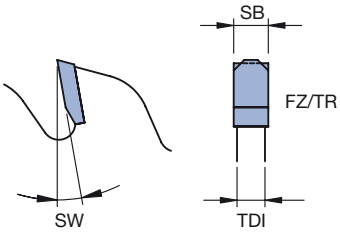
Sizing cuts – Premium

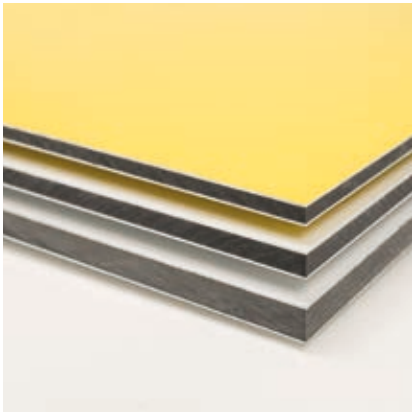
Machine:
Table saws and circular sawing machines for sizing, cross cutting and panel sizing with/without scoring saw.

Technical information:
AS OptiCut design – noise reduction during idling by up to 5 dB(A).
Tool body with vibration damping laser ornaments.

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
220	3,2	2,2	30	2/7/42	64	FZ/TR	10,79	10°	**061375**	•
250	3,2	2,2	30	KNL	72	FZ/TR	10,90	10°	**162000**	•
300	3,2	2,2	30	KNL	42	FZ/TR	22,43	10°	**068411**	•
300	3,2	2,2	30	KNL	72	FZ/TR	13,08	10°	**162001**	•
300	3,2	2,2	30	KNL	96	FZ/TR	9,81	10°	**162002**	•
350	3,5	2,5	30	KNL	48	FZ/TR	22,90	10°	**068413**	•
350	3,2	2,4	30	KNL	108	FZ/TR	10,18	10°	**162003**	•
400	3,8	2,5	30	KNL	54	FZ/TR	23,26	10°	**068415**	•

Sizing saw blade





Application:
For sizing panels of various thicknesses.

Workpiece material:
Alucobond®, Reynobond®, Dibond®

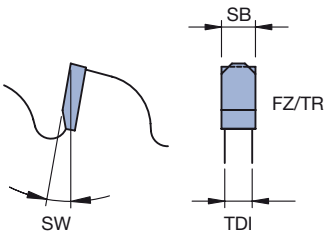
Application recommendation:

Material	Alucobond®	Reynobond®	Dibond®
f_z (mm)	0,01 - 0,02	0,01 - 0,02	0,01 - 0,02
v_c (m/s)	50 - 70	50 - 70	50 - 70

Panel thickness	≤ 25 mm	> 25 mm
ZT	≤ 18	> 15

Portable circular saw blade

HW



End trimming cut – Classic

Machine:
Portable saws, trimming-, mitre saws, radial arm saws and table saws.

Technical information:
Solid saw body and optimized gullet areas for optimal cutting results.

D mm	SB mm	TDI mm	BO mm	Z	ZF	ZT mm	SW	ID
160	2,5	1,8	20	56	FZ/TR	8,97	-5°	**070047** •
190	2,6	1,8	20	54	FZ/TR	11,05	-5°	**060707** •
190	2,8	2,2	30	68	FZ/TR	8,77	-5°	**070054** •
210	2,8	2,0	30	60	FZ/TR	10,99	-5°	**070067** •
210	2,4	1,6	30	64	FZ/TR	10,30	-5°	**070105** •
216	3,0	2,4	30	64	FZ/TR	10,60	-5°	**060686** •
225	2,6	1,8	30	68	FZ/TR	10,39	-5°	**070041** •
235	3,2	2,6	25	54	FZ/TR	13,66	-5°	**070732** •
240	2,8	2,2	30	80	FZ/TR	9,42	-5°	**070062** •
250	3,4	2,8	30	60	FZ/TR	13,08	-5°	**060134** •
250	2,8	2,0	30	80	FZ/TR	9,81	-5°	**070119** •
250	3,2	2,6	30	80	FZ/TR	9,81	-5°	**060250** •
300	3,2	2,6	30	96	FZ/TR	9,81	-5°	**060252** •

• available ex stock ▫ available at short notice

Application:
For sizing panels of various thicknesses.

Workpiece material:
PVC corrugated panel

Application recommendation:

Material	PVC
f_z (mm)	0,03 - 0,04
v_c (m/s)	35 - 40

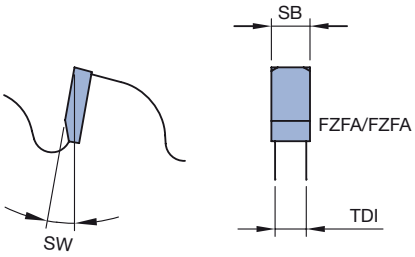
Panel thickness	≤ 5 mm	> 5 mm
ZT	≤ 12	> 10

Sizing cuts in finish cut quality – Excellent

Machine:
Table saw, trimming saw, portable circular saw.

Technical information:
GlossCut design – tool body with vibration-damping laser ornaments and special tooth geometry. Optimized for sizing perfect cut surfaces and tear-free cutting edges. Noise reduction during idling and operation by up to 4 dB(A).
Special tool design for significantly improved performance times.

Sizing saw blade/
Portable circular saw blade

D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID	
160	2,2	1,6	20		48	FZFA/FZFA	10,47	+5°/-5°	**161008**	•
165	2,2	1,6	20		48	FZFA/FZFA	10,79	+5°/-5°	**161009**	•
190	2,4	1,8	20		58	FZFA/FZFA	10,29	+5°/-5°	**161010**	•
210	2,4	1,8	30		68	FZFA/FZFA	9,70	+5°/-5°	**161011**	•
250	2,8	2,2	30	KNL	72	FZFA/FZFA	10,90	+5°/-5°	**161012**	•
300	3,0	2,4	30	KNL	72	FZFA/FZFA	13,08	+5°/-5°	**161005**	•
300	3,0	2,4	30	KNL	96	FZFA/FZFA	9,81	+5°/-5°	**161006**	•
350	3,5	2,8	30	KNL	96	FZFA/FZFA	11,45	+5°/-5°	**161007**	•

Application:
For sizing panels of various thicknesses.

Workpiece material:
PVC corrugated panel

Application recommendation:

Material	PVC
f_z (mm)	0,03 - 0,04
v_c (m/s)	35 - 40

Panel thickness	≤ 2 mm	> 2 mm
ZT	≤ 8,5	> 8

Cross- and mitre cut – Classic

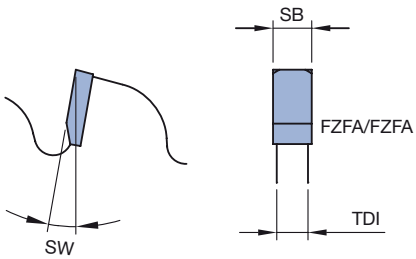
Machine:
Cut-off saws, cross cut saws, mitre saws, portable saws and double cut-off saws.

Technical information:
The negative hook angle is suited to cutting from above.
Reduced cutting width and tool body thickness. Noise reduced saw body design.
Tool body with special coating for increased performance.

Portable-, sizing-, trimming- und mitre cutting saw blade

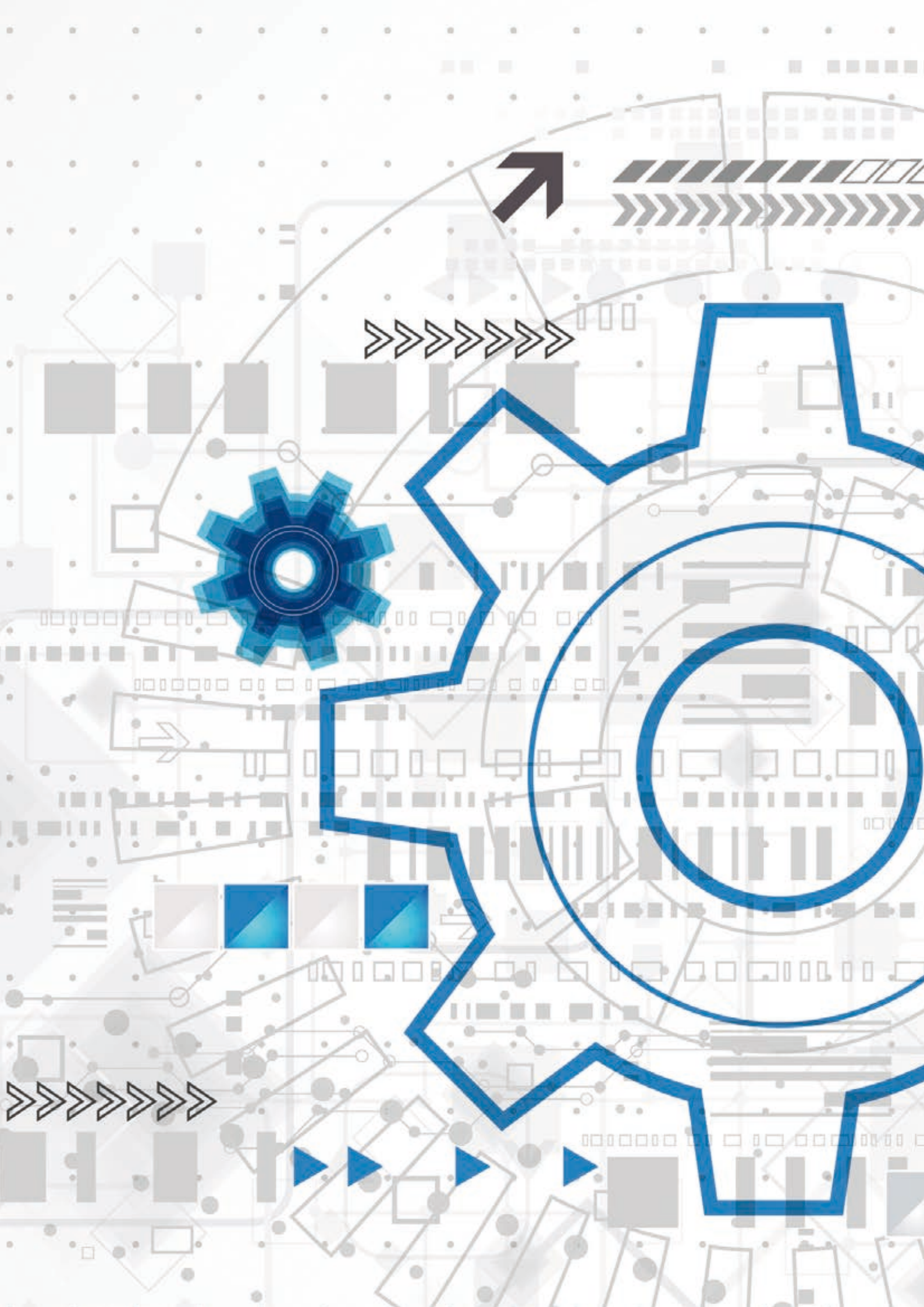


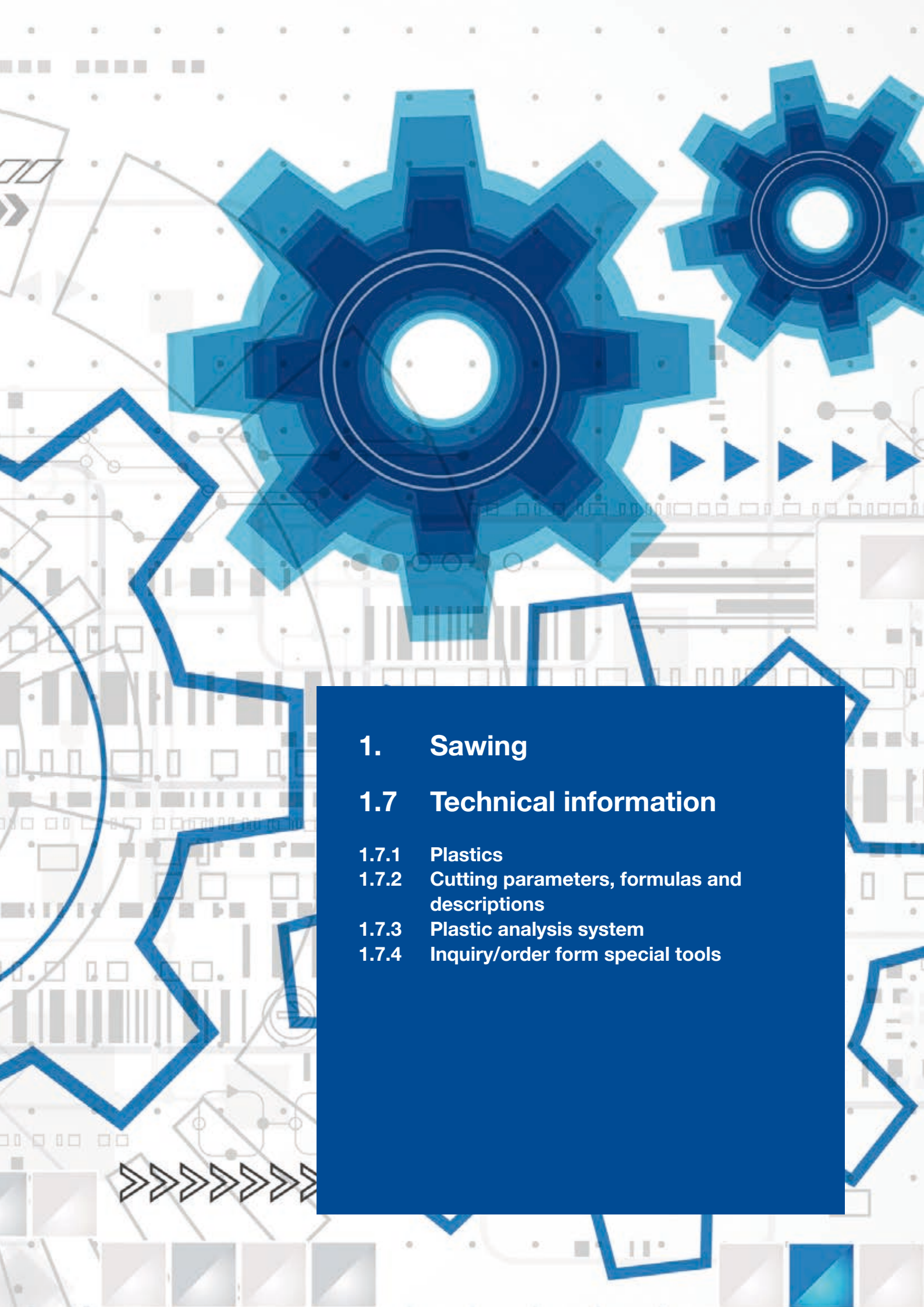
HW



D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	ZT mm	SW	ID
160	1,6	1,2	20		60	FZFA/FZFA	8,37	-5°	**060277** •
190	1,8	1,4	20		72	FZFA/FZFA	8,29	-5°	**060278** •
200	1,8	1,4	20	KNL	80	FZFA/FZFA	7,85	-5°	**060274** •
250	2,0	1,6	30	KNL	100	FZFA/FZFA	7,85	-5°	**060275** •
300	2,2	1,8	30	KNL	120	FZFA/FZFA	7,85	-5°	**060276** •
350	2,4	2,0	30	KNL	140	FZFA/FZFA	7,85	-5°	**060279** •

• available ex stock ▫ available at short notice





1. Sawing

1.7 Technical information

1.7.1 Plastics
1.7.2 Cutting parameters, formulas and descriptions
1.7.3 Plastic analysis system
1.7.4 Inquiry/order form special tools

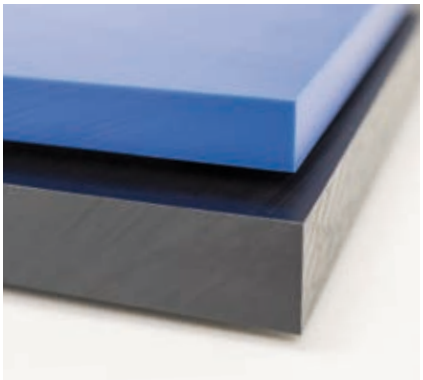
Plastics consist of interwoven molecule chains, polymers, which in turn are composed of repeating structural units called monomers. The type of polymer bond determines the plastics properties. There are three main groups: thermoplastics, thermosets and elastomers.

Two common factors for all plastics are a low density and low thermal conductivity. The different properties of different types of plastics must be taken into account in machining work. High quality, efficiency and production security can only be achieved with tools and machining parameters specially customised to the material.

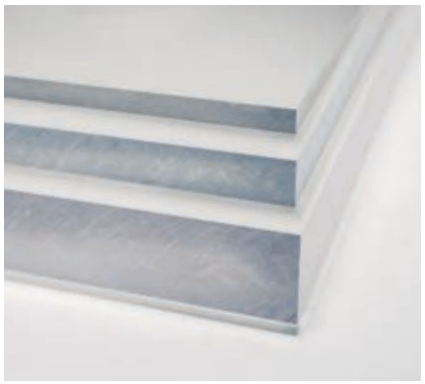
Thermoplastics
In thermoplastics, the molecule chains are crosslinked. A typical characteristic of thermoplastics is that they have **a temperature at which they soften**. Once a thermoplastic is heated above this temperature, it is soft and can be formed and shaped. Below this temperature (specific to a particular thermoplastic) thermoplastics retain their original shape. Thermoplastics can be used in a number of processes – injection moulding, extrusion and press forming.

Polymer clumping in the case of thermoplastics (schematic diagram)

Thermoplastic plastics also can be strengthened by fibres in order to increase density. Normally this involves short fibres so that the extrudabi-lity is continued. This technology for example is used for window profiles so that a reinforcement with steel inserts can be renounced.

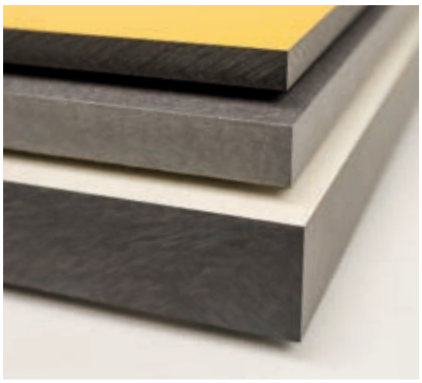


The temperature at which thermoplastic starts to soften is around 60 °C (depending on the specific plastic), a temperature relevant to the machining process. Exceeding the softening temperature during machining is detrimental to the machined quality. The chips melt, the tools become sticky, and both quality and production are no longer consistent. As well as specific tooth geometries and tool chip gullets, selecting the machining parameters is of upmost importance. Permitted cutting speeds are usually lower than those permitted with woodworking.



Transparent thermoplastics such as PC and PMMA require special processes. A transparent cutting surface is often required. This means having a totally smooth cutting edge with no visible cutter marks, a special cutting geometry and, of course, stable machinery with good clamping. A high quality cut can be achieved with polished tungsten carbide cutting tools.

Structure of thermosets
(schematic diagram)



Structure of elastomers
(schematic diagram)

Thermosets
In thermosets, the molecule chains are irreversibly cured at cross linking sites, or nodes, through chemical bonds.

When a thermoset is heated up, the monomers begin to move. The intensity of these oscillations increases as the temperature rises. When the temperature rises above a critical point, the nodes are irreversibly broken. As a consequence, thermosets are destroyed at a temperature specific to the material – the pyrolysis temperature – which is above 150°C. Thermoset materials are usually moulded or, in the case of composites, pressed. They are usually hard and brittle.

To improve the properties of thermosets, **reinforcement materials** in the form of laminated paper, fibreglass, carbon fibre or aramid fibre are incorporated into the thermoset mass. The different combinations of these materials have been given new grade designations such as FR-2, FR-3, FR-4, CEM-1, CEM-3, etc. (for example, FR-4 is glass reinforced epoxy laminate).

Typical examples for duroplastic working materials are for example compact laminate panels or high pressure laminates (HPL laminates) of melamine - or phenolic papers, printed circuit boards (PCB) or PU-foam.

The focus is not on the temperature during the machining process. The cutting speeds are higher than those for thermoplastics. Due to the hard brittle material properties and the abrasive effect of the embedded fibres, tools used in conjunction with thermosets require different geometries and cutting materials than those used to process thermoplastics.

Elastomers
Elastomers are soft plastics, which can be shaped and then go back their original form when released. This particular property is due to the wide meshed structure of the molecule chains. They do not soften when heated. Machining is possible, but rare. The main difficulty is clamping the workpieces.

Abbreviation	Description	Cutting speed	Tooth feed rate
Thermoplastics			
ABS	Acrylonitrile Butadiene Styrene	50 - 70 m/s	0,05 - 0,15 mm
PA	Polyamide	50 - 70 m/s	0,01 - 0,1 mm
PC	Polycarbonate	70 - 90 m/s	0,01 - 0,05 mm
PE	Polyethylene	60- 75 m/s	0,01 - 0,1 mm
PMMA	Polymethyl methacrylate	50 - 70 m/s	0,03 - 0,05 mm
POM	Polyoxymethylene	50 - 70 m/s	0,05 - 0,1 mm
PP	Polypropylene	60 - 75 m/s	0,05 - 0,15 mm
PPO	Polyphenylene Oxide	50 - 70 m/s	0,05 - 0,1 mm
PS	Polystyrene	50 - 70 m/s	0,01 - 0,1 mm
PVC	Polyvinylchloride	50 - 70 m/s	0,03 - 0,05 mm
Duroplastics			
HGW	Laminated Fabric	45 - 65 m/s	0,02 - 0,04 mm
HP	Laminated Paper	50 - 70 m/s	0,01 - 0,03 mm
HPL	High Pressure Laminate	60 - 75 m/s	0,02 - 0,05 mm
PF	Phenol formaldehyde	50 - 60 m/s	0,02 - 0,05 mm
PUR	Polyurethane hard	50 - 70 m/s	0,05 - 0,1 mm
Fibre reinforced plastics (reinforced plastics)			
GFK	Glass-fibre	30 - 60 m/s	0,01 - 0,02 mm
CFK	Carbon-fibre	30 - 60 m/s	0,01 - 0,02 mm
Elastomers			
IIR	Butyl rubber	50 - 70 m/s	0,03 - 0,06 mm
NR	Natural rubber	50 - 70 m/s	0,01 - 0,03 mm
SBR	Styrene Butadiene rubber	50 - 70 m/s	0,01 - 0,03 mm
PUK	Polyurethane rubber	50 - 70 m/s	0,01 - 0,03 mm
Foams			
PUR	Polyurethane foam	50 - 80 m/s	0,4 - 0,6 mm
XPS	Extruded Polystyrene foam	30 - 60 m/s	0,2 - 0,4 mm
EPS	Polystyrene particle foam	50 - 60 m/s	0,4 - 0,6 mm
Polymer-compound mineral working material			
	Corian®, HI-MACS®, Staron®, GetaCore®, Varicor®, Marlan®	50 - 80 m/s	0,02 - 0,04 mm
Special panels			
	Alucobond®, Reynobond®, Dibond®	50 - 70 m/s	0,01 - 0,02 mm
PMMA	Twin-wall sheet	50 - 70 m/s	0,03 - 0,05 mm
PVC	Corrugated panel	35 - 40 m/s	0,03 - 0,04 mm

Cutting speeds (m/s)	$\mathbf{V_c} = \pi \cdot D \cdot n / (1000 \cdot 60)$
RPM (U/min)	$\mathbf{n} = v_c / (\pi \cdot D) \cdot (1000 \cdot 60)$
Feed speed (m/min)	$\mathbf{v_f} = f_z \cdot n \cdot Z / 1000$
Feed rate per tooth (mm)	$\mathbf{f_z} = v_f \cdot 1000 / n \cdot Z$

v_c = Cutting speed (m/s)
n = RPM (U/min)
v_f = Feed speed (m/min)
f_z = Feed rate per tooth (mm)
Z = Number of teeth
D = Saw blade diameter (mm)

These formulas are numerical value equations.
All values have to be used with the scale unit enclosed in brackets.

The Leitz App provides the option to calculate important operating data of your tools.
This is available for download on the Leitz Homepage.
www.leitz.org/leitz-app.html

	Abbreviation	Material name	Density g/cm³	Surface/look	Mechanical properties	Fracture behaviour
Thermoplastics	**PE**	Polyethylene	0,91 - 0,96	cloudy	soft, not scratch-proof	unbreakable
	PP	Polypropylene	0,89 - 0,92	cloudy	flexible, scratch-proof	ductile fracture
	PS	Polystyrene	1,04	transparently - glossy	hard and brittle	brittle fracture
	SAN	Styrene acrylonitrile cop.	1,08	transparently - glossy	rigid	brittle fracture
	ABS	Acrylonitrile-Butadiene-Styrene	1,03 - 1,07	matt - glossy	flexible	stress whitening
	PMMA	Polymethyl methacrylate	1,19	transparently	hard, rigid and brittle	brittle fracture
	PC	Polycarbonate	1,2 - 1,24	transparently	hard	brittle fracture
	PVC-U hart	PVC plasticizer-free	1,38 - 1,55	transparently	hard and rigid	stress whitening
	PVC-P weich	PVC plasticizer	1,2 - 1,35	transparently	soft, elastic	unbreakable
	PA	Polyamide	1,04 - 1,15	cloudy - yellowish	tough, elastic	unbreakable
	POM	Polyoxymethylene	1,41 - 1,43	matt - glossy	very hard	brittle fracture
	PPS	Polyphenylene sulfide	1,34 - 1,90	cloudy	very high stability and rigidity	metallic
	PTFE	Polytetrafluoroethylene	2,14 - 2,20	cloudy	low stability and rigidity	no data
Duroplastics	**EP**	Epoxy resin	1,17 - 1,25	clear, not lightfast	high rigidity, tough - varies widely, depending on the structure	unbreakable
	UP	unsaturated Polyester resin	1,17 - 1,26	nearly crystal clear to yellowish	hard, rigid, brittle – varies widely, depending on the structure	unbreakable
	PF (HP)	Phenoplast	1,3 - 2,0	pale yellow to brown colour	hard, brittle, rigid	unbreakable
	MF (HPL)	Melamine resin	1,45 - 2,00	light-coloured	hard, rigid, brittle - varies widely, depending on the structure	unbreakable
	MP (HPL)	Melamine phenolic resin	1,45 - 2,00	light-coloured	hard, rigid, brittle - varies widely, depending on the structure	unbreakable
	PUR	Polyurethane	1,14 - 1,26	lslightly transparent, mostly brownish	high flexibility	no data

Smell of the vapour	Combustion behaviour			Reaction during heating	Sound test	Buoyancy	Softening temperature	Melting temperature
like paraffin	burns with blue flame, burns down dripping			becomes clear	dull	yes	130 - 180°	190 - 250°
like paraffin	burns with blue flame, burns down dripping			becomes clear	dull	yes	145 - 160°	230 - 270°
sweet	burns well with highly sooting flame, without dripping, yellow			gasifies	metallic	no	110 - 150°	180 - 220°
Hydrogen cyanide	burns with highly sooting flame without dripping, yellow			gasifies	dull	no	ca. 130°	180 - 230°
sweet	burns with sooting flame, without dripping, yellow			gasifies	dull	no	130 - 220°	180 - 230°
fruity	Burns crackling and shining, nearly no residues and without dripping			softens, inflates	dull	no	150 - 180°	180 - 230°
like phenol	Burns shiningly, sooting, self-extinguishing			tough, brown	rattling	no	180 - 220°	230 - 260°
HCl, burnt	sooting, with yellow flame, flammable			softens, becomes dark brown	rattling	no	110 - 180°	170 - 190°
HCl and plasticizer	sooting, with yellow flame, flammable			softens, becomes dark brown	rattling	no	100 - 110°	150 - 200°
burnt horn	Burns bluish with yellow edge, crackling drops, viscous			becomes clear, afterwards brown	dull	no	ca. 200°	230 - 280°
Formaldehyde	Burns with blue flame, pungent smell			gasifies	rattling	no	160 - 170°	180 - 220°
weak styrene, S, H2S	Burns within the flame, extinguishes outside, does not drop			black, white vapour	no data	no	-	300 - 360°
pungent HF	incombustible, carbonizes			does not melt, becomes clear	no data	no	-	-
undefined, depending on the hardener	keeps on burning after lighting, yellow	sooting	hardly flammable, they disintegrate	dark	no data	no	-	-
Styrene, pungent	keeps on burning after lighting, shining yellow	sooting	hardly flammable, they disintegrate	cracks, dark	no data	no	-	-
Phenol	extinguishes outside, sooting	burns within the flame	hardly flammable, they disintegrate	cracks	no data	no	-	-
fishy, burnt milk	extinguishes outside, carbonizes, white edges	burns within the flame	hardly flammable, they disintegrate	cracks	dull	no	-	-
Phenol, burnt milk	Extinguishes outside, carbonizes, white edges	burns within the flame	hardly flammable, they disintegrate	cracks	dull	no	-	-
Isocyanate	keeps on burning after lighting, melts, shining yellow			dark	no data	no	-	-

Customer details: Customer number: (if known) ☐☐☐☐☐☐☐☐ ☐ Inquiry ☐ Order Delivery date: (not binding) ☐☐ CW

Company::

Street:

Post code/place:

Country:

Phone/fax:

Contact person:

Signature:

Date:

Inquiry/order no.:

Tool ID:: (if known)

No. of pieces:

Workpiece material: (for type, quality and machining method, see selection overview

Quality:

Machining method:

Cutting height: mm

Cutting method: ☐ single piece ☐ in stacks

Cutting quality: ☐ rough (rough sawn) ☐ fine (cut to size quality) ☐ ultra fine (finish cut quality)

Solid wood: ☐ along grain ☐ across grain

Panel materials: ☐ sizing ☐ square cutting

Machine

Manufacturer:

Type:

Model:

RPM: min^{-1}

Type of feed: ☐ MAN (Hand) ☐ MEC (Mech)

Feed rate : $m\ min^{-1}$

Flange diameter: mm

Motor power: kW

Cutting direction: ☐ against feed (GGL) ☐ with feed (GLL)

Tool: (must be completed)

Diameter: mm

Cutting width: mm

Bore: mm

Keyway/double keyway: mm

Pinholes:

Use: ☐ Single tool ☐ Tool set

Cutting material: ☐ Stellite ☐ HW (TC) ☐ DP (DIA)

(Complete if sawblade design is known)

Number of teeth:

Shape of teeth:

Tool body thickness: mm

Tool body shape (as per drawing): (enter number)

Additional elements of saw body (as per drawing): (enter number)

Standard design: ☐

Low noise design: ☐ with laser ornaments ☐ UT ☐ with damping foil

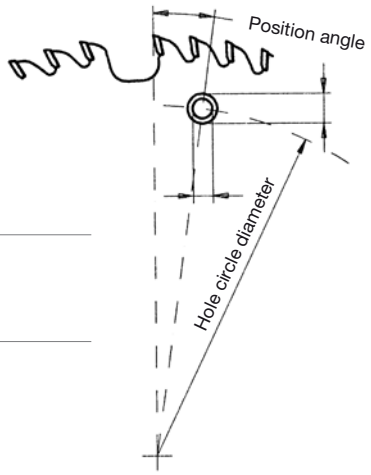
Direction of rotation (as per drawing): ☐ left hand rotation (LL) ☐ right hand rotation (RL)

Recessed tool body: Hub diameter: mm

Hub thickness: mm

Position of hub: ☐ Side 1 ☐ Side 2

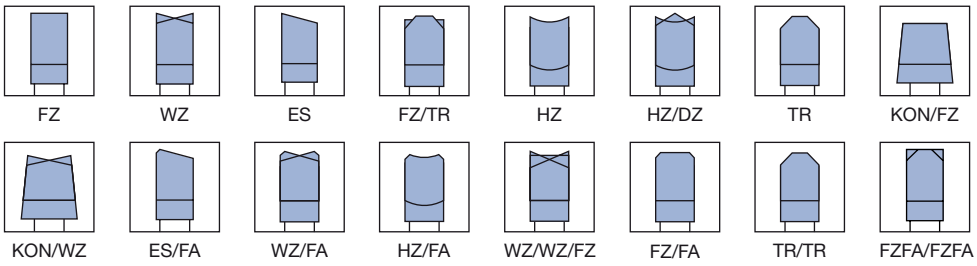
Bore – note on sketch:
Cut out teeth – note on sketch.

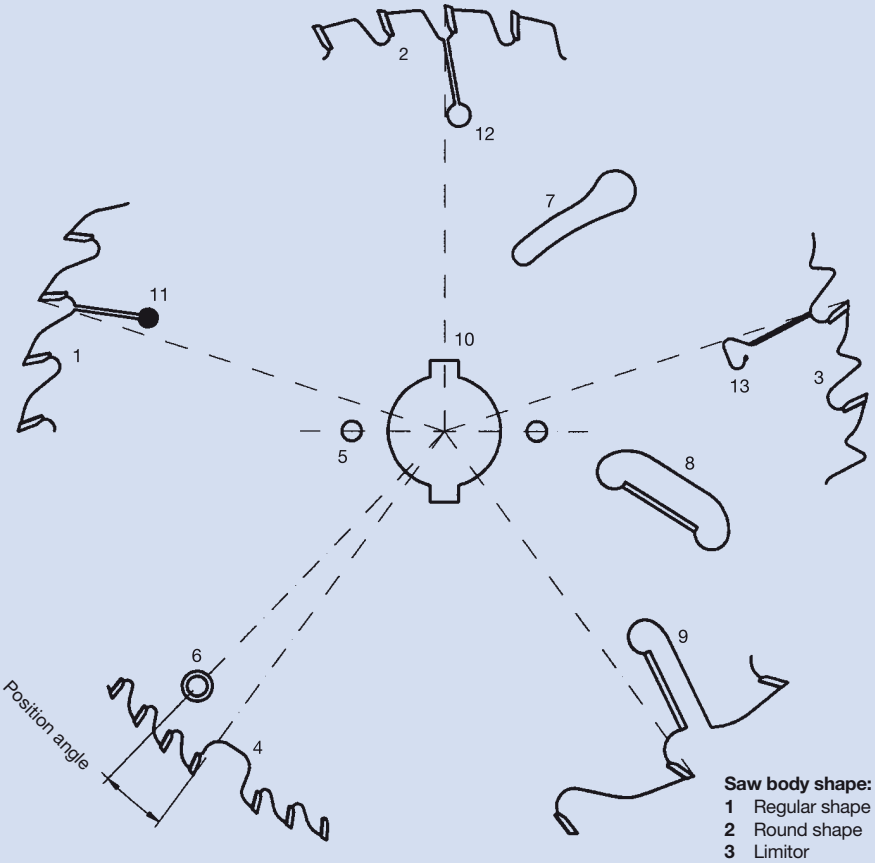


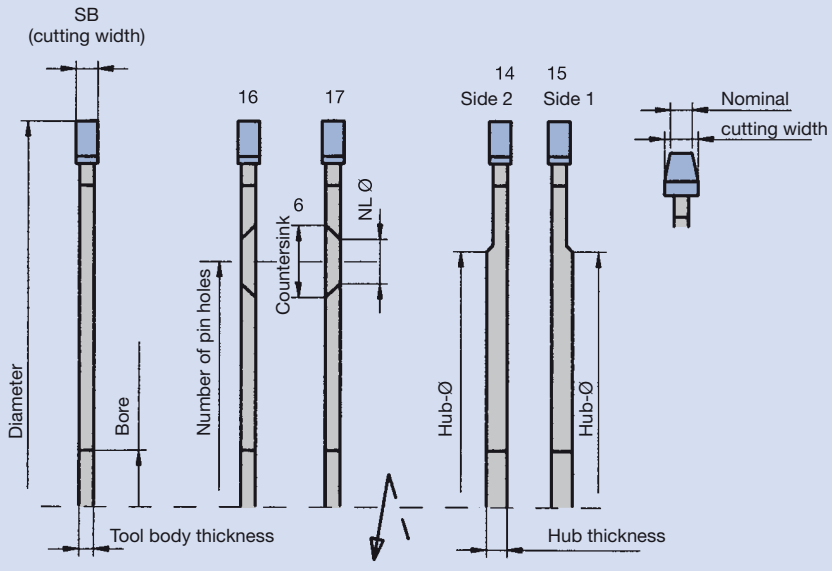
Number of pinholes:

Number of recesses:

Tooth shapes:







Saw body shape:
1 Regular shape
2 Round shape
3 Limitor

Cut out:
4 Tooth cut out

Pinholes:
5 Pinhole
6 Pinhole with countersink

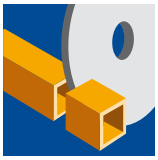
Additional elements in the saw body:
7 Cooling element
8 Wiper slot with HW cutting edge inside
9 Wiper slot with HW cutting edge outside
10 Keyway or double keyway

Expansion slots:
11 Expansion slot shape A, with rivets
12 Expansion slot shape A
13 Expansion slot shape D

Position of hub:
14 Position of hub, side 2
15 Position of hub, side 1

Direction of rotation:
16 Right hand rotation
17 Left hand rotation

Key to pictograms



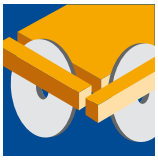
Sawing hollow sections

Scoring and sawing stacks

Tungsten carbide

Tipped tool

Scoring, sawing



Sawing, universal

Poly-crystalline diamond (PKD)

Low noise

Explanation of abbreviations

AS	=	anti sound (low noise design)
BO	=	bore diameter
D	=	cutting circle diameter
DP	=	polycrystalline diamond (PKD)
f_z	=	tooth feed
HW	=	tungsten carbide
ID	=	ident number
n	=	RPM
NLA	=	pinhole dimensions
SB	=	cutting width
SW	=	cutting angle
TDI	=	thickness of tool
UT	=	cutting edges with irregular pitch
v_c	=	cutting speed
v_f	=	feed speed
Z	=	no. of teeth
ZF	=	tooth shape (cutting egde shape)
ZT	=	tooth pitch

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