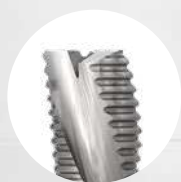


SOLID CARBIDE SPIRAL BITS



Premium class carbide.
Increased tool life.



Dedicated materials.
The variety of hardness of raw materials allows choosing the right tool depending on the processed material.



Possibility of using variety of coatings.
The coating increases the tool life several times and also reduces friction, which significantly reduces heating of the tool during operation.



Ideal for machining wood and wood-based materials.



SA01 series
Z1
finishing
upcut

p. 61



SB01 series
Z2
finishing
upcut

p. 62



SB51 series
Z2
finishing
downcut

p. 64



SC01 series
Z3
finishing
upcut

p. 66



SC51 series
Z3
finishing
downcut

p. 68



SC03 series
Z3
finishing
upcut

p. 70



SC23 series
Z3
finishing
upcut

p. 71



SF01 series
Z3R
roughing
upcut

p. 72



SF01.TR
SF01.XR series
Z3R
roughing
upcut

p. 74



SF05
SF30 series
Z3R
roughing

p. 75



SF51 series
Z3R
roughing
downcut

p. 77



SH01 series
Z4
finishing -
roughing
upcut

p. 79



SL01 **Z1+1**
SM01 **Z2+2**
SN01 **Z3+3**
finishing
roughing
compression

p. 80



X90 PRO
Z2+2, Z3+3
nesting
compression

p. 84



X99 PRO
NEXCUT
Z2+6
nesting
compression

NEW

p. 86



SI01 series
Z2
ball nose

p. 87



SQ29 series
Z2
tapered
ball nose

NEW

p. 88



SY01 series
Z2
finishing
straight

NEW

p. 89



FVI series
Z2
rounding

p. 90



XZ3 series
Z3
straight

NEW

p. 91



VHM Nesting Cutters Handbook

SERIES	Z	WORKING PARAMETERS	MATERIAL	COATING	TOOLS LIFE	PHOTO
SM01 page 80-81	2+2	$\varnothing 8 - 4-6\text{m/min}$ $\varnothing 10 - 6-8\text{m/min}$ $\varnothing 12 - 8-12\text{m/min}$ RPM 18.000-24.000	 		•	
SM01 TiSiN page 82-83	2+2	$\varnothing 8 - 6-8\text{m/min}$ $\varnothing 10 - 8-12\text{m/min}$ $\varnothing 12 - 12-16\text{m/min}$ RPM 18.000-24.000	   	TiSiN	••	
SN01 page 80-81	3+3	$\varnothing 10 - 12-16\text{m/min}$ $\varnothing 12 - 14-20\text{m/min}$ $\varnothing 16 - 16-25\text{m/min}$ RPM 18.000-24.000	 		•	
X90 page 84	2+2	$\varnothing 8 - 8-14\text{m/min}$ $\varnothing 10 - 12-16\text{m/min}$ $\varnothing 12 - 13-18\text{m/min}$ RPM 18.000-24.000	     	PLATINUM	•••	
X90 page 84	3+3	$\varnothing 10 - 13-20\text{m/min}$ $\varnothing 12 - 15-22\text{m/min}$ RPM 18.000-24.000	     	PLATINUM	•••	
X99 page 86 NEXCUT	2+6	$\varnothing 10 15-23\text{m/min}$ $\varnothing 12 17-26\text{m/min}$ $\varnothing 16 18-30\text{m/min}$ RPM 18.000-24.000	     	PLATINUM	•••	

Materials:



SOFT SOLID WOOD



LAMINATED MDF



RAW MDF



LAMINATED CHIPBOARD



RAW CHIPBOARD



PLYWOOD

PROTECTIVE COATING for Solid Carbide Router Bits

PROTECTIVE COATING:

A coating is a layer that covers the surface of an object. Its main function is to protect or improve the mechanical, physical or chemical properties of the tool.

For tribological coatings that are mainly used to optimize friction coefficient, the thickness is usually between 1 to 5 microns.



Advantages of using protective coatings on tools are as follows:

- Tools become more resistant to abrasion
- Friction coefficient is reduced
- Corrosion resistance of the tools is increased
- Tool wear is slowed down, which leads to longer tool life
- Adhesion of the processed material to the surface is reduced
- Operating parameters such as feed and rotational speed can be increased, compared to uncoated tools
- Work optimization is increased by reducing downtime needed for tool replacement.

Coating Specification:

NAME	HARDNESS GPa	HARDNESS HV 0,05	FRICTION COEFFICIENT	COATING THICKNESS µm	INDEX
AlTiN	33	3350	0,5	1-4	.ATR
TiSiN	35	3570	0,5	1-4	.TSR
NaDia	36	3650	0,01-0,05	1-4	.XTR
PLATINUM	30	3000	0,2	1-4	.PR
HC	50-60	5000-6000	0,1-0,2	1-2	.HCR

Application:

MATERIALS	TiSiN	AlTiN	NaDia	PLATINUM	HC
Solid Wood	★	-	★	★	★
Chipboard	★	-	★	★	★
Plywood	★	-	★	★	★
Aluminum	-	★	★	-	★
Plastics	★	★	★	-	★
Composites	-	★	★	-	★

★ – Recommended coating

PROTECTIVE COATING for Solid Carbide Router Bits

PCD & HM TOOLS

SOLID CARBIDE
ROUTER BITS

PCD & VHM TOOLS FOR
COMPOSITES

CHUCKS
& ACCESSORIES

TOOLS FOR EDGEBANDING
MACHINES

CIRCULAR SAW BLADES

DRILL BITS

STRAIGHT
& SYSTEM KNIVES

STARTER KITS

AlTiN Coating



Specification:

- Colour: Anthracite
- Hardness: 5000-6000 [HV 0,05]
- Thickness: 1-2 [μm]
- Friction coefficient: 0,1-0,2
- Index: .HCR/L

Application:

- Automotive industry
- Airline industry
- Production of injection molds

Information:

The HC coating is known for its high hardness, which makes it perfect for processing aluminum alloys and composite materials. It is thinner than standard PVD coatings, resulting in a sharper cutting edge. Moreover, it enhances the heat resistance of the tool by reducing the coefficient of friction and preventing the material being processed from sticking to the tool.

TiSiN Coating



Specification:

- Colour: Copper-like
- Hardness: 3570 [HV 0,05]
- Thickness: 1-4 [μm]
- Friction coefficient: 0,5
- Index: .TSR

Application:

- Solid wood
- Laminated chipboard
- Plywood
- Aluminum
- Plastics

Information:

The coating exhibits excellent wear resistance even at high temperatures, allowing for prolonged tool life and reduced need for replacement.

NaDia Coating



Specification:

- Colour: Black
- Hardness: 3650 [HV 0,05]
- Thickness: 1-4 [µm]
- Friction coefficient: 0.01-0.05
- Index: .XTR

Application:

- Solid wood
- Laminated chipboard
- Plywood
- Aluminum
- Plastics

Information:

The coating has been developed to meet the specific needs of the wood industry. It is highly durable and can also be used in the processing of aluminum and plastics. This coating is unique in that it is applied at low temperatures, resulting in increased hardness and a lower friction coefficient.

PLATINIUM Coating



Specification:

- Colour: Nonuniform (gold, purple, blue)
- Hardness: 3000 [HV 0,05]
- Thickness: 1-4 [µm]
- Friction coefficient: 0.02
- Index: .PR

Application:

- MDF
- Laminated chipboard
- Chipboard
- Plywood

Information:

Introducing an innovative two-layer PVD coating designed specifically for processing hard materials. This unique combination of hard and tribological layers allows for the optimization of the friction coefficient, significantly reducing the sticking of processed materials on the tool surface. By applying this coating, you can extend the life of your tool significantly while achieving the highest quality results after processing.

HC Coating



Specification:

- Colour: Gray
- Hardness: 3350 [HV 0,05]
- Thickness: 1-4 [µm]
- Friction coefficient: 0,5
- Index: .ATR

Application:

- Aluminum
- Plastics
- Composite materials

Info:

Coating with hardness and high player performance. Available in aluminum alloys with a higher admixture of silicon, the additional coating slows down the process of tool use and the sticking of cuttings to the cutting edges.

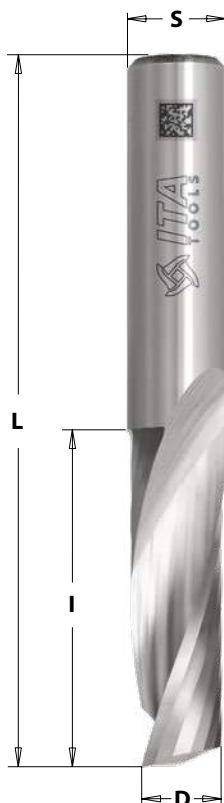
Solid Carbide Finishing Upcut Spiral Bits Z1

SA01 – 198
positive

VHM

Z1

RH



Technical details:

- 1 flute spiral cutter
- Positive – upward chip ejection
- Finishing geometry

Application:



CUTTING



JOINTING

Materials:



SOFT SOLID WOOD
●●●



HARD SOLID WOOD
●●●



RAW MDF
●●○

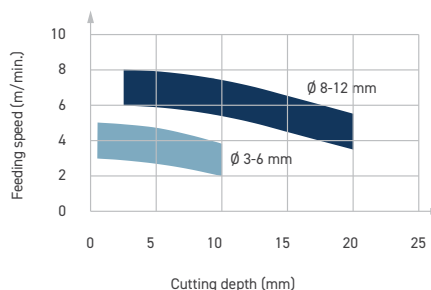


PLYWOOD
●●○



RAW CHIPBOARD
●○○

Ø 3-12 mm | Soft wood



RPM: 18000 - 24000

Correction factor:

- hardwood = 0,9
- milling across fiber = 0,7
- raw chipboard = 1,1

Results shown in this diagram are purely empirical, based merely on informative and hypothetical calculation. Each application may require different parameters in consideration of materials in use and machining conditions.

D mm	I mm	L mm	S mm	ARTICLE
3	12	50	3	SA01.03.012.050.03R
3	32	70	3	SA01.03.032.070.03R
4	15	50	4	SA01.04.015.050.04R
5	17	50	5	SA01.05.017.050.05R
6	22	60	6	SA01.06.022.060.06R
8	22	70	8	SA01.08.022.070.08R
10	32	70	10	SA01.10.032.070.10R
10	42	80	10	SA01.10.042.080.10R
10	52	90	10	SA01.10.052.090.10R
12	32	83	12	SA01.12.032.083.12R

Detailed information on protective coatings can be found on pages: 57-60.



Solid Carbide Finishing Upcut Spiral Bits Z2

SB01 – 191
positive

VHM

Z2

RH

LH

Technical details:

- 2 flute spiral cutter
- Positive – upward chip ejection
- Finishing geometry

Application:



CUTTING



JOINTING

Materials:



SOFT SOLID WOOD



HARD SOLID WOOD



RAW MDF



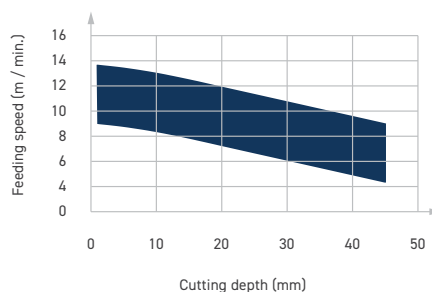
PLYWOOD



RAW CHIPBOARD



Ø 12-20 mm | Soft wood



RPM: 18000

Correction factor:

- hardwood = 0,9
- milling across of fiber = 0,7

Results shown in this diagram are purely empirical, based merely on informative and hypothetical calculation. Each application may require different parameters in consideration of materials in use and machining conditions.

D mm	I mm	L mm	S mm	ARTICLE RH	ARTICLE LH
2	9	50	6	SB01.02.009.050.06R	-
3	12	50	3	SB01.03.012.050.03R	SB01.03.012.050.03L
3	12	60	6	SB01.03.012.060.06R	SB01.03.012.060.06L
3	12	60	8	SB01.03.012.060.08R	SB01.03.012.060.08L
3	22	70	6	SB01.03.022.070.06R	-
4	15	50	4	SB01.04.015.050.04R	SB01.04.015.050.04L
4	15	60	6	SB01.04.015.060.06R	SB01.04.015.060.06L
4	15	60	8	SB01.04.015.060.08R	SB01.04.015.060.08L
4	27	70	6	SB01.04.027.070.06R	-

Table continued on the next page ►

Solid Carbide Finishing Upcut Spiral Bits Z2

D mm	I mm	L mm	S mm	ARTICLE RH	ARTICLE LH
5	17	50	5	SB01.05.017.050.05R	SB01.05.017.050.05L
5	17	60	6	SB01.05.017.060.06R	SB01.05.017.060.06L
5	17	60	8	SB01.05.017.060.08R	SB01.05.017.060.08L
6	22	60	6	SB01.06.022.060.06R	-
6	27	70	6	SB01.06.027.070.06R	SB01.06.027.070.06L
6	27	70	8	SB01.06.027.070.08R	SB01.06.027.070.08L
7	32	80	8	SB01.07.032.080.08R	SB01.07.032.080.08L
8	22	70	8	SB01.08.022.070.08R	-
8	32	80	8	SB01.08.032.080.08R	SB01.08.032.080.08L
8	42	90	8	SB01.08.042.090.08R	SB01.08.042.090.08L
9	32	83	12	SB01.09.032.083.12R	-
10	32	80	8	SB01.10.032.080.08R	-
10	32	80	10	SB01.10.032.080.10R	SB01.10.032.080.10L
10	32	83	12	SB01.10.032.083.12R	-
10	42	90	10	SB01.10.042.090.10R	SB01.10.042.090.10L
10	42	90	12	SB01.10.042.090.12R	-
12	35	83	8	SB01.12.035.083.08R	-
12	35	83	12	SB01.12.035.083.12R	SB01.12.035.083.12L
12	42	90	12	SB01.12.042.090.12R	-
12	52	100	12	SB01.12.052.100.12R	-
16	35	90	16	SB01.16.035.090.16R	-
20	60	120	20	SB01.20.060.120.20R	-

Sizes in inches:

D inch	I inch	L inch	S inch	ARTICLE RH	ARTICLE LH
1/8	1/2	2	1/4	SB01.32.127.508.64R	-
1/4	3/4	2	1/4	SB01.64.191.508.64R	SB01.64.191.508.64L
1/2	1-1/2	3-1/2	1/2	SB01.13.381.889.13R	-

Detailed information on protective coatings can be found on pages: 57-60.

Solid Carbide Finishing Downcut Spiral Bits Z2

SB51 - 192
negative

VHM

Z2

RH

Technical details:

- 2 flute spiral cutter
- Negative - downward chip ejection
- Finishing geometry

Application:



CUTTING



JOINTING



RABBETING



GROOVING

Materials:



SOFT SOLID WOOD
●●●



HARD SOLID WOOD
●●●



RAW MDF
●●○



RAW CHIPBOARD
●●○



PLYWOOD
●●○



LAMINATED MDF
●○○

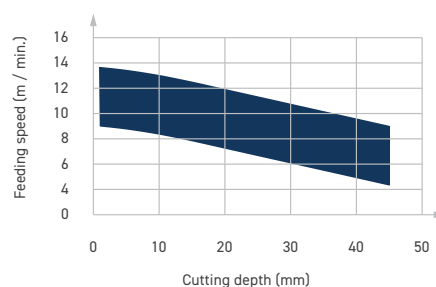


LAMINATED CHIPBOARD
●○○



LAMINATED PLYWOOD
●○○

Ø 12-20 mm | Soft wood



RPM: 18000

Correction factor:

- hardwood = 0,9
- milling across of fiber = 0,7

Results shown in this diagram are purely empirical, based merely on informative and hypothetical calculation. Each application may require different parameters in consideration of materials in use and machining conditions.

D mm	I mm	L mm	S mm	ARTICLE RH
2	8	60	6	SB51.02.008.060.06R
3	12	50	3	SB51.03.012.050.03R
3	12	60	6	SB51.03.012.060.06R
3	12	60	8	SB51.03.012.060.08R
3	23	70	6	SB51.03.023.070.06R

Table continued on the next page ►

Solid Carbide Finishing Downcut Spiral Bits Z2

D mm	I mm	L mm	S mm	ARTICLE RH
4	15	50	4	SB51.04.015.050.04R
4	15	60	6	SB51.04.015.060.06R
4	15	60	8	SB51.04.015.060.08R
5	17	50	5	SB51.05.017.050.05R
5	17	60	6	SB51.05.017.060.06R
5	17	60	8	SB51.05.017.060.08R
6	22	70	6	SB51.06.022.070.06TR
6	27	60	6	SB01.06.027.060.06R
6	27	70	6	SB51.06.027.070.06R
6	27	70	8	SB51.06.027.070.08R
6	32	80	8	SB01.06.032.080.06R
8	22	70	8	SB51.08.022.070.08R
8	32	70	8	SB01.08.032.070.08R
8	32	80	8	SB51.08.032.080.08R
8	42	90	8	SB51.08.042.090.08R
10	32	80	10	SB51.10.032.080.10R
12	35	83	12	SB51.12.035.083.12R

Sizes in inches:

D inch	I inch	L inch	S inch	ARTICLE RH
1/2	1-1/4	3	1/2	SB51.13.318.762.13R
1/2	1-1/2	3-1/2	1/2	SB51.13.381.889.13R
1/8	1/2	2	1/4	SB51.32.127.508.64R
5/32	1/2	2	1/4	SB51.39.127.508.64R

Detailed information on protective coatings can be found on pages: 57-60.

Solid Carbide Finishing Upcut Spiral Bits Z3

SC01 - 193
positive

VHM

Z3

RH

LH

Technical details:

- 3 flute spiral cutter
- Positive – upward chip ejection
- Finishing geometry

Application:



CUTTING



JOINTING

Materials:



SOFT SOLID
WOOD
●●●



HARD SOLID
WOOD
●●●



RAW MDF
●●○

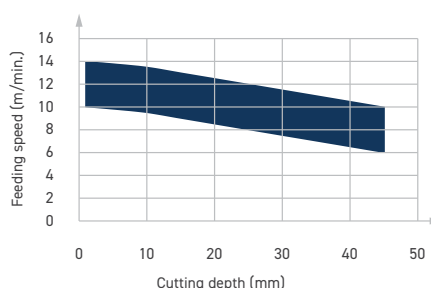


RAW
CHIPBOARD
●●○



PLYWOOD
●●○

Ø 12-20 mm | Soft wood



RPM: 18000

Correction factor:

- hardwood = 0,9
- milling across of fiber = 0,7

Results shown in this diagram are purely empirical, based merely on informative and hypothetical calculation. Each application may require different parameters in consideration of materials in use and machining conditions.

D mm	I mm	L mm	S mm	ARTICLE RH	ARTICLE LH
8	32	80	8	SC01.08.032.080.08R	SC01.08.032.080.08L
8	42	100	8	SC01.08.042.090.08R	-
10	27	70	10	SC01.08.052.100.08R	-
10	32	80	10	SC01.10.032.080.10R	SC01.10.032.080.10L
10	42	90	10	SC01.10.042.090.10R	SC01.10.042.090.10L
10	52	100	10	SC01.10.052.100.10R	-
12	35	83	12	SC01.12.035.083.12R	-
12	35	80	12	SC01.12.035.080.10R	-
12	42	90	12	SC01.12.042.090.12R	SC01.12.042.090.12L

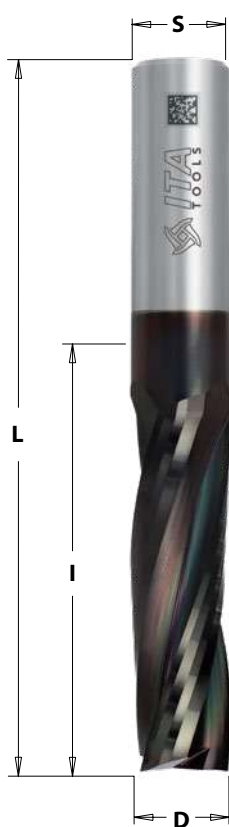
Table continued on the next page ►

Solid Carbide Finishing Upcut Spiral Bits Z3

D mm	I mm	L mm	S mm	ARTICLE RH	ARTICLE LH
12	52	100	12	SC01.12.052.100.12R	SC01.12.052.100.12L
12	70	130	12	SC01.12.070.130.12R	-
16	35	90	16	SC01.16.035.090.16R	SC01.16.035.090.16L
16	55	110	16	SC01.16.055.110.16R	SC01.16.055.110.16L
16	72	120	16	SC01.16.072.120.16R	SC01.16.072.120.16L
18	55	110	18	SC01.18.055.110.18R	SC01.18.055.110.18L
20	60	120	20	SC01.20.060.120.20R	SC01.20.060.120.20L
20	70	120	20	SC01.20.070.120.20R	SC01.20.070.120.20L
20	102	165	20	SC01.20.102.165.20R	SC01.20.102.165.20R

Sizes in inches:

D inch	I inch	L inch	S inch	ARTICLE RH
5/8	2-1/8	4-5/16	5/8	SC01.16.540.110.16R



NaDia Coating Z3:

D mm	I mm	L mm	S mm	ARTICLE RH
16	55	110	16	SC01.16.055.110.16XR

Detailed information on protective coatings can be found on pages: 57-60.

Solid Carbide Finishing Downcut Spiral Bits Z3

SC51 - 194
negative

VHM

Z3

RH

Technical details:

- 3 flute spiral cutter
- Negative – downward chip ejection
- Finishing geometry

Application:



CUTTING



JOINTING

Materials:



SOFT SOLID WOOD
●●●



HARD SOLID WOOD
●●●



RAW MDF
●●○



RAW CHIPBOARD
●●○



PLYWOOD
●●○



LAMINATED MDF
●○○

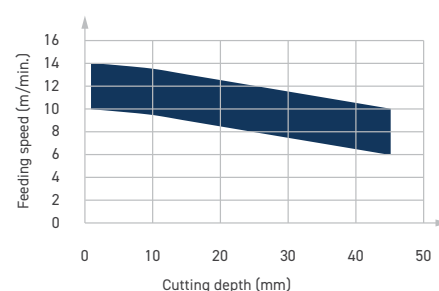


LAMINATED CHIPBOARD
●○○



LAMINATED PLYWOOD
●○○

Ø 12-20 mm | Soft wood



RPM: 18000

Correction factor:

- hardwood = 0,9
- milling across of fiber = 0,7

Results shown in this diagram are purely empirical, based merely on informative and hypothetical calculation. Each application may require different parameters in consideration of materials in use and machining conditions.

D mm	I mm	L mm	S mm	ARTICLE RH
10	32	80	10	SC51.10.032.080.10R
10	42	90	10	SC51.10.042.090.10R
12	35	83	12	SC51.12.035.083.12R
14	50	110	14	SC51.14.050.110.14R

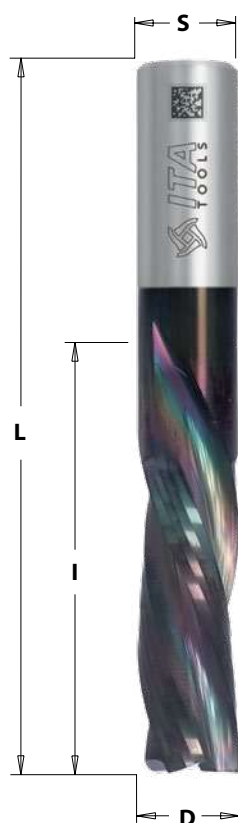
Table continued on the next page ►

Solid Carbide Finishing Downcut Spiral Bits Z3

D mm	I mm	L mm	S mm	ARTICLE RH
16	55	110	16	SC51.16.055.110.16R
16	35	90	16	SC51.16.035.090.16R
18	55	110	18	SC51.18.055.110.18R
20	60	120	20	SC51.20.060.120.20R
20	72	130	20	SC51.20.072.130.20R

Sizes in inches:

D inch	I inch	L inch	S inch	ARTICLE RH
1/2	1-1/2	3-1/2	1/2	SC51.13.381.889.13R



NaDia Coating Z3:

D mm	I mm	L mm	S mm	ARTICLE RH
16	55	110	16	SC51.16.055.110.16XR
16	72	120	16	SC51.16.072.120.16XR
20	70	120	20	SC51.20.070.120.20XR

Detailed information on protective coatings can be found on pages: 57-60.

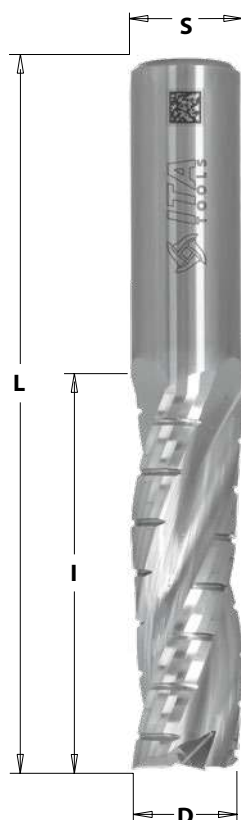
Solid Carbide Finishing Upcut Spiral Bits Z3 with Chipbreaker

SC03 - 193Rn
positive

VHM

Z3R

RH



Technical details:

- 3 flute spiral cutter
- Positive – upward chip ejection
- Semi-finishing geometry
- Chipbreaker

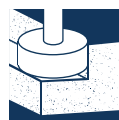
Application:



CUTTING



JOINTING



RABBETING



GROOVING

Materials:



SOFT SOLID
WOOD



HARD SOLID
WOOD



RAW MDF



RAW
CHIPBOARD



PLYWOOD



D mm	I mm	L mm	S mm	ARTICLE RH
6	22	60	6	SC03.06.022.060.06R
8	32	72	8	SC03.08.032.072.08R
10	32	72	10	SC03.10.032.072.10R
10	42	90	10	SC03.10.042.090.10R
10	52	100	10	SC03.10.052.100.10R
12	42	90	12	SC03.12.042.090.12R
12	52	100	12	SC03.12.052.100.12R
14	42	100	14	SC03.14.042.100.14R
16	42	90	16	SC03.16.042.090.16R
16	52	100	16	SC03.16.052.100.16R
16	62	110	16	SC03.16.062.110.16R
16	72	130	16	SC03.16.072.130.16R
18	55	110	18	SC03.18.055.110.18R
20	60	120	20	SC03.20.060.120.20R
20	102	165	20	SC03.20.102.165.20R

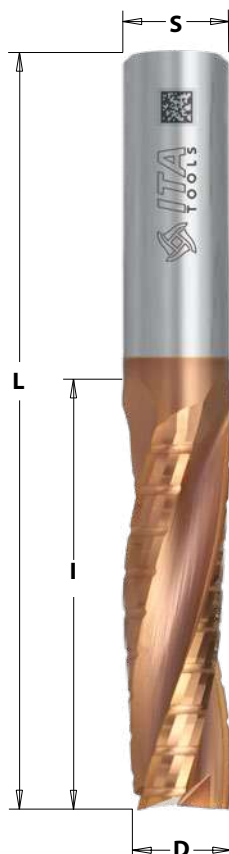
Detailed information on protective coatings can be found on pages: 57-60.

SC23 - 193Rn positive

VHM

Z3R

RH



Technical details:

- 3 flute spiral cutter
- Positive – upward chip ejection
- Semi-finishing geometry
- Chipbreaker
- TiSiN coating

Application:



CUTTING



JOINTING



RABBETING



GROOVING

Materials:



SOFT SOLID
WOOD



HARD SOLID
WOOD



RAW MDF



RAW
CHIPBOARD



PLYWOOD



D mm	I mm	L mm	S mm	ARTICLE RH
8	22	60	8	SC23.08.022.060.08TR
10	25	70	10	SC23.10.025.070.10TR
12	35	80	12	SC23.12.035.080.12TR
16	55	110	16	SC23.16.055.110.16TR
20	60	120	20	SC23.20.060.120.20TR

Detailed information on protective coatings can be found on pages: 57-60.

Solid Carbide Roughing Upcut Spiral Bits Z3

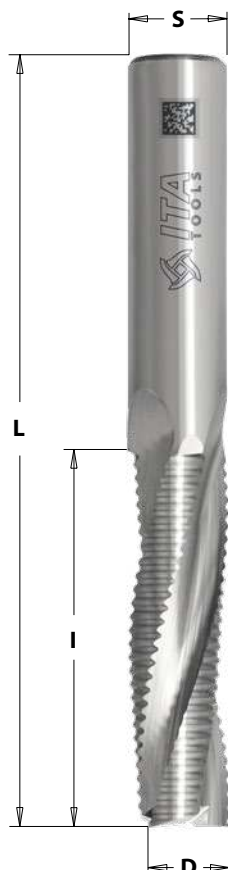
SF01 – 195
positive

VHM

Z3

RH

LH



Technical details:

- 3 flute spiral cutter
- Positive – upward chip ejection
- Roughing geometry

Application:



CUTTING



JOINTING

Materials:



SOFT SOLID WOOD
●●●



HARD SOLID WOOD
●●●



RAW MDF
●●○

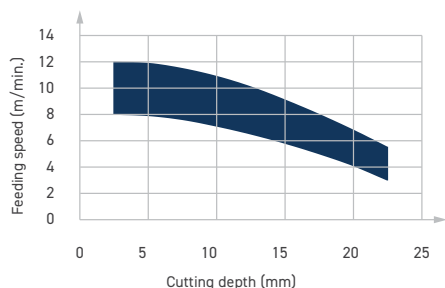


RAW CHIPBOARD
●●○



PLYWOOD
●●○

Ø 8-10 mm | Soft wood

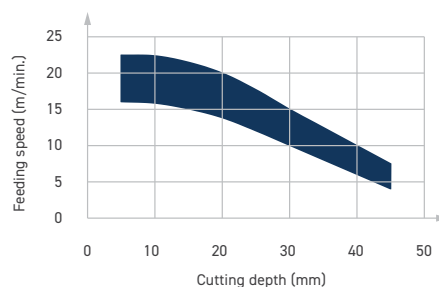


RPM: 18000

Correction factor:

- Hardwood = 0,8
- Chipboard without coating = 1,3

Ø 12-20 mm | Soft wood



RPM: 18000

Correction factor:

- Hardwood = 0,8
- Chipboard without coating = 1,3

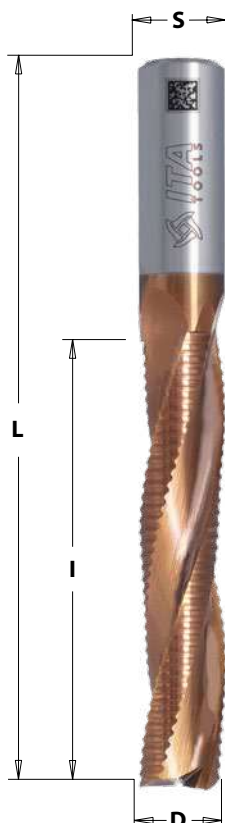
Results shown in this diagram are purely empirical, based merely on informative and hypothetical calculation. Each application may require different parameters in consideration of materials in use and machining conditions.

D mm	I mm	L mm	S mm	ARTICLE RH	ARTICLE LH
6	22	70	6	SF01.06.022.070.06R	-
6	32	70	6	SF01.06.032.070.06R	SF01.06.032.070.06L
8	22	63	8	SF01.08.022.063.08R	SF01.08.022.063.08L
8	32	80	8	SF01.08.032.080.08R	SF01.08.032.080.08L
8	42	90	8	SF01.08.042.090.08R	-

Table continued on the next page ►

Solid Carbide Roughing Upcut Spiral Bits Z3

D mm	I mm	L mm	S mm	ARTICLE RH	ARTICLE LH
10	32	80	10	SF01.10.032.080.10R	SF01.10.032.080.10L
10	42	90	10	SF01.10.042.090.10R	SF01.10.042.090.10L
10	52	100	10	SF01.10.052.100.10R	-
12	35	83	12	SF01.12.035.083.12R	SF01.12.035.083.12L
12	42	90	12	SF01.12.042.090.12R	SF01.12.042.090.12L
12	52	100	12	SF01.12.052.100.12R	SF01.12.052.100.12L
14	58	110	14	SF01.14.058.110.14R	SF01.14.058.110.14L
16	35	90	16	SF01.16.035.090.16R	-
16	42	90	16	SF01.16.042.090.16R	SF01.16.042.090.16L
16	55	110	16	SF01.16.055.110.16R	SF01.16.055.110.16L
16	72	120	16	SF01.16.072.120.16R	SF01.16.072.120.16L
18	55	110	18	SF01.18.055.110.18R	SF01.18.055.110.18L
20	60	120	20	SF01.20.060.120.20R	SF01.20.060.120.20L
20	72	120	20	SF01.20.072.120.20R	-
20	102	165	20	SF01.20.102.165.20R	SF01.20.102.165.20L



Sizes in inches:

D inch	I inch	L inch	S inch	ARTICLE RH
1/2	1-1/4	3	1/2	SF01.13.318.762.13R

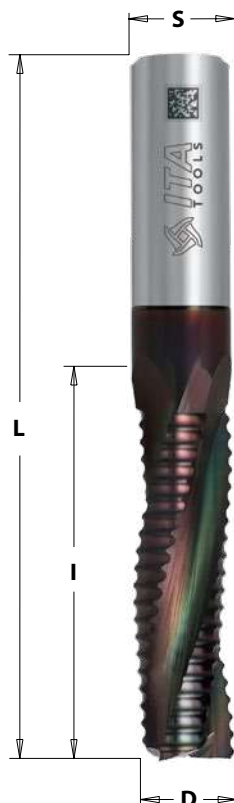
TiSiN Coating Z3:

D mm	I mm	L mm	S mm	ARTICLE RH
10	22	70	10	SF01.10.022.070.10TR
10	35	70	10	SF01.10.035.070.10TR
12	22	70	12	SF01.12.022.070.12TR
12	25	70	12	SF01.12.025.070.12TR
12	35	80	12	SF01.12.035.080.12TR

Detailed information on protective coatings can be found on pages: 57-60.

Solid Carbide Roughing Upcut Spiral Bits Z3

SF01.XR – 195XTR positive

VHM
Z3
RH
LH


Technical details:

- 3 flute spiral cutter
- Positive – upward chip ejection
- Roughing geometry
- NaDia coating

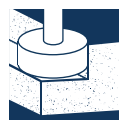
Application:



CUTTING



JOINTING



RABBETING

Materials:



SOFT SOLID
WOOD



HARD SOLID
WOOD



RAW MDF



RAW
CHIPBOARD



PLYWOOD



D mm	I mm	L mm	S mm	ARTICLE RH	ARTICLE LH
8	32	80	8	-	SF01.08.032.080.08XL
8	42	90	8	SF01.08.042.090.08XR	-
10	32	80	10	SF01.10.032.080.10XR	SF01.10.032.080.10XL
10	42	90	10	SF01.10.042.090.10XR	-
12	42	90	12	SF01.12.042.090.12XR	-
16	55	110	16	-	SF01.16.055.110.16XL
16	72	120	16	SF01.16.072.120.16XR	-
20	102	165	20	SF01.20.102.165.20XR	-

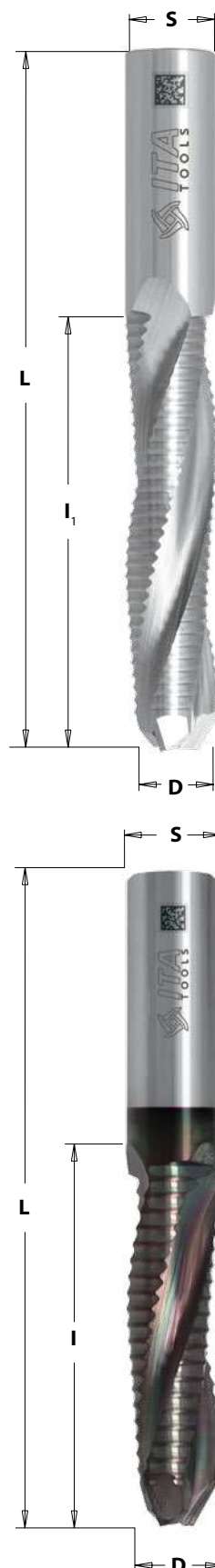
Detailed information on protective coatings can be found on pages: 57-60.

SF05 – 195Rv
positive

VHM

Z3

RH

**Technical details:**

- 3 flute spiral cutter
- Positive – upward chip ejection
- Roughing geometry
- Drilling tip with $A=60^\circ$

Application:DOOR
PEEPHOLE**Materials:**SOFT SOLID
WOODHARD SOLID
WOOD

RAW MDF

RAW
CHIPBOARD

PLYWOOD



D mm	I mm	L mm	S mm	ARTICLE RH
14	58	110	14	SF05.14.058.110.14R
16	55	110	16	SF05.16.055.110.16R

NaDia Coating Z3:

D mm	I mm	L mm	S mm	ARTICLE RH
14	58	110	14	SF05.14.058.110.14XR
16	55	110	16	SF05.16.055.110.16XR

Detailed information on protective coatings can be found on pages: 57-60.

SF30 - 195R positive

VHM

Z3

RH

Technical details:

- 3 flute spiral cutter
- Positive – upward chip ejection
- Roughing geometry
- Extended body with lowering

Application:



DOOR LOCK

Materials:



SOFT SOLID
WOOD



HARD SOLID
WOOD



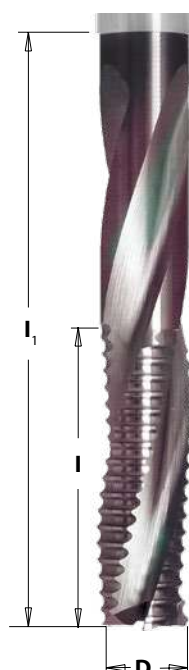
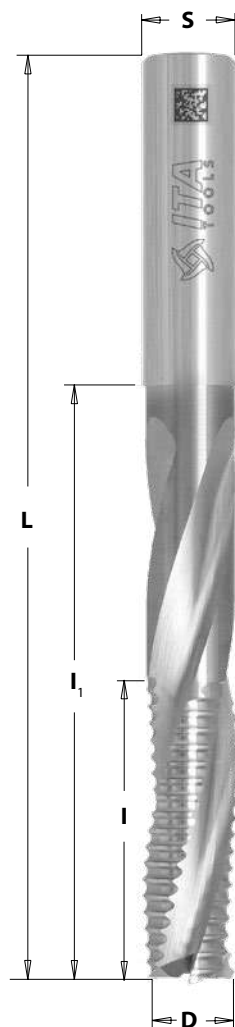
RAW MDF



RAW
CHIPBOARD



PLYWOOD



D mm	I mm	I ₁ mm	L mm	S mm	ARTICLE RH
12	45	95	150	12	SF30.12.095.150.12R
14	45	95	150	14	SF30.14.095.150.14R
14	45	125	170	14	SF30.14.125.170.14R
15	45	95	150	15	SF30.15.095.150.15R
16	45	95	150	16	SF30.16.095.150.16R
16	45	120	170	16	SF30.16.120.170.16R
18	45	95	150	18	SF30.18.095.150.18R
20	45	95	150	20	SF30.20.095.150.20R

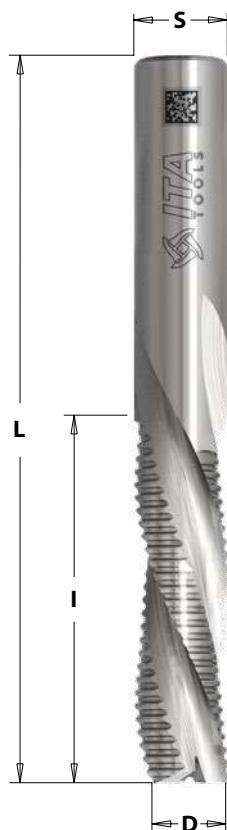
NaDia Coating Z3:

D mm	I mm	I ₁ mm	L mm	S mm	ARTICLE RH
14	45	95	150	14	SF30.14.095.150.14XR
16	45	95	150	16	SF30.16.095.150.16XR
16	50	120	170	16	SF30.16.120.170.16XR

Detailed information on protective coatings can be found on pages: 57-60.

Solid Carbide Roughing Downcut Spiral Bits Z3

SF51 – 196
negative



VHM

Z3

RH

Technical details:

- 3 flute spiral cutter
- Negative – downward chip ejection
- Roughing geometry

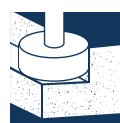
Application:



CUTTING



JOINTING



RABBETING



GROOVING

Materials:



SOFT SOLID WOOD
●●●



HARD SOLID WOOD
●●●



RAW MDF
●●○



RAW CHIPBOARD
●●○



PLYWOOD
●●○



LAMINATED MDF
●○○

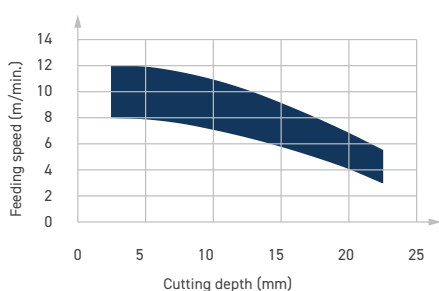


LAMINATED CHIPBOARD
●○○



LAMINATED PLYWOOD
●○○

Ø 8-10 mm | Soft wood

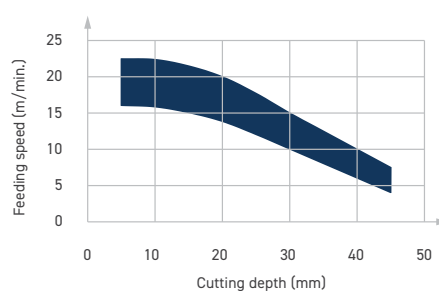


RPM: 18000

Correction factor:

- Hardwood = 0,8
- Chipboard without coating = 1,3

Ø 12-20 mm | Soft wood



RPM: 18000

Correction factor:

- Hardwood = 0,8
- Chipboard without coating = 1,3

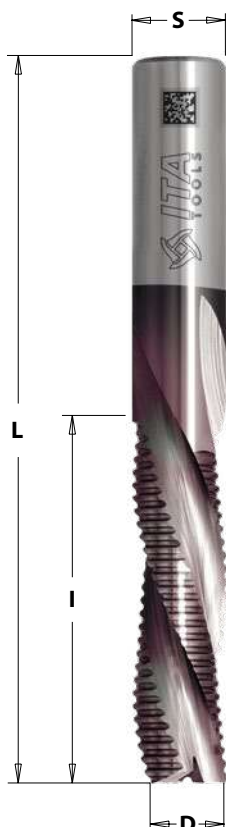
Results shown in this diagram are purely empirical, based merely on informative and hypothetical calculation. Each application may require different parameters in consideration of materials in use and machining conditions.

D mm	I mm	L mm	S mm	ARTICLE RH
8	32	80	8	SF51.08.032.080.08R
10	42	90	10	SF51.10.042.090.10R
12	35	83	12	SF51.12.035.083.12R

Table continued on the next page ►

Solid Carbide Roughing Downcut Spiral Bits Z3

D mm	I mm	L mm	S mm	ARTICLE RH
12	42	90	12	SF51.12.042.090.12R
12	52	100	12	SF51.12.052.100.12R
14	50	110	14	SF51.14.050.110.14R
16	55	110	16	SF51.16.055.110.16R
18	55	110	18	SF51.18.055.110.18R
20	60	120	20	SF51.20.060.120.20R
20	72	120	20	SF51.20.072.120.20R
20	102	165	20	SF51.20.102.165.20R

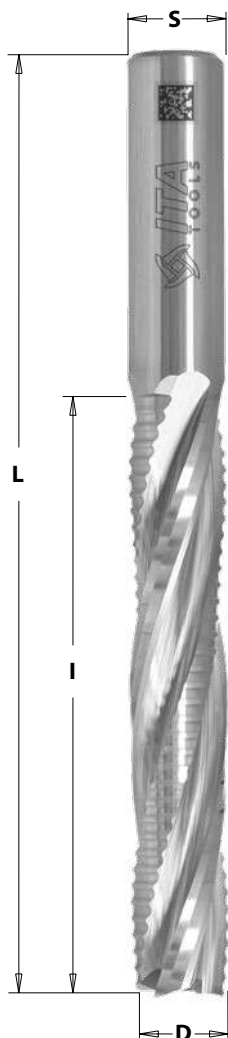


NaDia Coating Z3:

D mm	I mm	L mm	S mm	ARTICLE RH
8	32	80	8	SF51.08.032.080.08XR
10	42	90	10	SF51.10.042.090.10XR
12	35	83	12	SF51.12.035.083.12XR
12	42	90	12	SF51.12.042.090.12XR
12	52	100	12	SF51.12.052.100.12XR
14	50	110	14	SF51.14.050.110.14XR
16	55	110	16	SF51.16.055.110.16XR
18	55	110	18	SF51.18.055.110.18XR
20	60	120	20	SF51.20.060.120.20XR
20	72	120	20	SF51.20.072.120.20XR
20	102	165	20	SF51.20.102.165.20XR

Detailed information on protective coatings can be found on pages: 57-60.

SH01 – 197 positive



VHM

Z4

RH

Technical details:

- 4 flute spiral cutter
- Positive – upward chip ejection
- Finishing + roughing geometry

Application:



CUTTING



JOINTING

Materials:



SOFT SOLID
WOOD
●●●



HARD SOLID
WOOD
●●●



RAW MDF
●●○



RAW
CHIPBOARD
●●○



PLYWOOD
●●○

D mm	I mm	L mm	S mm	ARTICLE RH
8	32	70	8	SH01.08.032.070.08R
10	32	70	10	SH01.10.032.070.10R
12	32	70	12	SH01.12.032.070.12R
12	42	90	12	SH01.12.042.090.12R
14	32	90	14	SH01.14.032.090.14R
16	35	90	16	SH01.16.035.090.16R
16	42	100	16	SH01.16.042.100.16R
16	55	110	16	SH01.16.055.110.16R
20	60	120	20	SH01.20.060.120.20R

NaDia Coating Z4:

D mm	I mm	L mm	S mm	ARTICLE RH
16	55	110	16	SH01.16.055.110.16XR

Detailed information on protective coatings can be found on pages: 57-60.

Solid Carbide Finishing Up & Downcut Spiral Bits

SL01 | SM01 | SN01 – 190
positive-negative

VHM

Z1+1

Z2+2

Z3+3

RH

Technical details:

- 1+1, 2+2 or 3+3 flute spiral cutter
- Compression – upward and downward chip ejection
- Finishing geometry

Application:



CUTTING



NESTING



JOINTING

Materials:



SOFT SOLID WOOD
●●●



HARD SOLID WOOD
●●●



RAW MDF
●●●



RAW CHIPBOARD
●●●



PLYWOOD
●●●



LAMINATED PLYWOOD
●○○

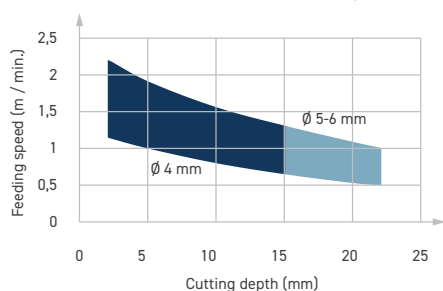


LAMINATED MDF
●○○



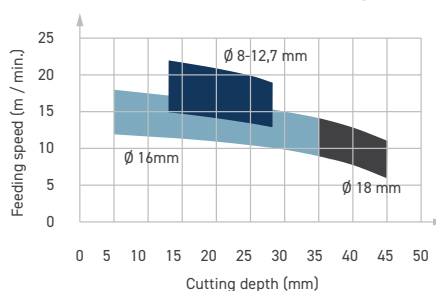
LAMINATED CHIPBOARD
●○○

Ø 4-6 mm | Chipboard without coating



RPM: 24000 Correction factor: MDF = 0,8

Ø 8-18 mm | Chipboard without coating



RPM: 18000 Correction factor: MDF = 0,8

Results shown in this diagram are purely empirical, based merely on informative and hypothetical calculation. Each application may require different parameters in consideration of materials in use and machining conditions.

D mm	I mm	I ₁ mm	L mm	S mm	Z	ARTICLE RH
3	20	5	60	3	1+1	SL01.03.020.060.03R
3	23	5	70	6	1+1	SL01.03.023.070.06R
4	15	5	60	4	1+1	SL01.04.015.050.04R
4	21	5	60	4	1+1	SL01.04.021.060.04R
5	22	8	70	5	1+1	SL01.05.022.070.05R
6	22	5	60	6	1+1	SL01.06.022.060.06R

Solid Carbide Finishing Up & Downcut Spiral Bits

D mm	I mm	I ₁ mm	L mm	S mm	Z	ARTICLE RH
5	22	5	60	5	2+2	SM01.05.022.060.05R
6	22	5	60	6	2+2	SM01.06.022.060.06R
8	22	8	70	8	2+2	SM01.08.022.070.08R
8	32	8	80	8	2+2	SM01.08.032.080.08R
10	22	8	70	10	2+2	SM01.10.022.070.10R
10	32	5	80	10	2+2	SM01.10.032.080.10R
10	42	7	90	10	2+2	SM01.10.042.090.10R
12	25	7	70	12	2+2	SM01.12.025.070.12R
12	42	7	90	12	2+2	SM01.12.042.090.12R
12	52	7	100	12	2+2	SM01.12.052.100.12R
16	42	18	100	16	2+2	SM01.16.042.100.16R
16	55	21	110	16	2+2	SM01.16.055.110.16R
18	55	24	110	18	2+2	SM01.18.055.110.18R

D mm	I mm	I ₁ mm	L mm	S mm	Z	ARTICLE RH
12	25	9	83	12	3+3	SN01.12.025.083.12R
12	35	9	90	12	3+3	SN01.12.035.090.12R
20	100	20	165	20	3+3	SN01.20.100.165.20R

Sizes in inches:

D inch	I inch	I ₁ inch	L inch	S inch	Z	ARTICLE RH
3/8	7/8	3/16	3	3/8	2+2	SM01.95.222.762.95R
1/2	1	15/32	3	1/2	2+2	SM01.13.254.762.13R

Sizes in inches:

D inch	I inch	I ₁ inch	L inch	S inch	Z	ARTICLE RH
3/8	7/8	3/16	3	3/8	3+3	SN01.95.222.762.95R

Detailed information on protective coatings can be found on pages: 57-60.

SL01.TR | SM01.TR | SN01.TR – 190TSR
positive-negative

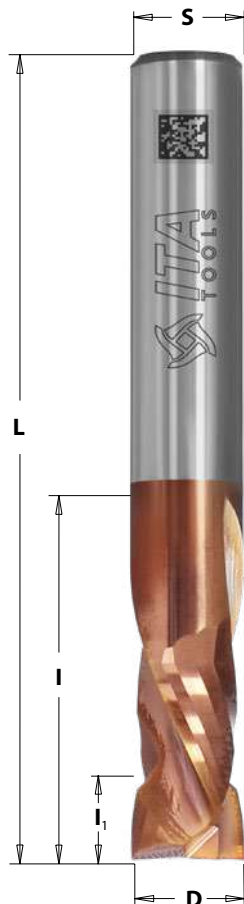
VHM

Z1+1

Z2+2

Z3+3

RH



Technical details:

- 1+1, 2+2 or 3+3 flute spiral cutter
- Compression – upward and downward chip ejection
- Finishing geometry
- TiSiN coating

Application:



CUTTING



NESTING



JOINTING

Materials:



SOFT SOLID
WOOD
● ● ●



HARD SOLID
WOOD
● ● ●



RAW MDF
● ● ●



RAW
CHIPBOARD
● ● ●



PLYWOOD
● ● ●



LAMINATED
PLYWOOD
● ● ●

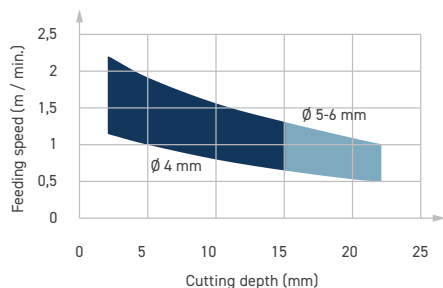


LAMINATED
MDF
● ● ●



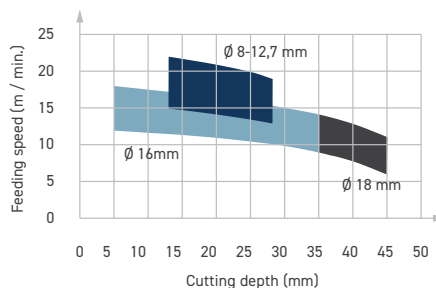
LAMINATED
CHIPBOARD
● ● ●

Ø 4-6 mm | Chipboard without coating



RPM: 24000 Correction factor: MDF = 0,8

Ø 8-18 mm | Chipboard without coating



RPM: 18000 Correction factor: MDF = 0,8

Results shown in this diagram are purely empirical, based merely on informative and hypothetical calculation. Each application may require different parameters in consideration of materials in use and machining conditions.

D mm	I mm	I ₁ mm	L mm	S mm	Z	ARTICLE RH
4	21	5	60	4	1+1	SL01.04.021.060.04TR
5	22	8	70	5	1+1	SL01.05.022.060.05TR
6	22	5	60	6	1+1	SL01.06.022.060.06TR

Solid Carbide Finishing Up & Downcut Spiral Bits

D mm	I mm	I₁ mm	L mm	S mm	Z	ARTICLE RH
6	12	2	60	6	2+2	SM01.06.012.060.06TR
8	18	3	70	8	2+2	SM01.08.018.070.08TR
8	22	8	70	8	2+2	SM01.08.022.070.08TR
10	18	5	70	10	2+2	SM01.10.018.070.10TR
10	22	8	70	10	2+2	SM01.10.022.070.10TR
10	25	6	80	10	2+2	SM01.10.025.080.10TR
12	18	5	70	12	2+2	SM01.12.018.070.12TR

D mm	I mm	I₁ mm	L mm	S mm	Z	ARTICLE RH
12	25	6	83	12	3+3	SN01.12.025.083.12TR
16	55	21	110	16	3+3	SN01.16.055.110.16TR
20	100	20	165	20	3+3	SN01.20.100.165.20TR

Detailed information on protective coatings can be found on pages: 57-60.

Solid Carbide Finishing Up & Downcut Spiral Bits for Nesting

X90 positive-negative

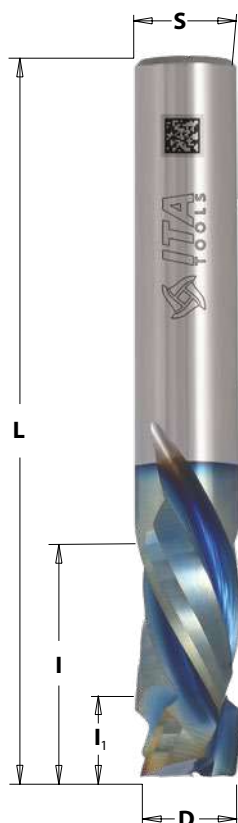
VHM

Z1+1

Z2+2

Z3+3

RH



Technical details:

- 1+1, 2+2 or 3+3 flute spiral cutter
- Compression – upward and downward chip ejection
- Finishing or roughing geometry
- PLATINUM coating
- Special nesting carbide grade

Application:



CUTTING



NESTING



JOINTING

Materials:



RAW MDF



RAW
CHIPBOARD



PLYWOOD



LAMINATED
PLYWOOD



LAMINATED
MDF



LAMINATED
CHIPBOARD



SOFT SOLID
WOOD



HARD SOLID
WOOD



HPL



D mm	I mm	I ₁ mm	L mm	S mm	Z	TYPE	ARTICLE RH
8	35	7	80	8	2+2	Finishing	X90.08.035.080.08PR
9,525 (3/8")	22,225 (7/8")	8,38 (21/64")	76,2 (3")	9,525 (3/8")	2+2	Finishing	X90.95.222.762.95PR
10	22	8	70	10	2+2	Finishing	X90.10.022.070.10PR
10	35	7	80	10	2+2	Finishing	X90.10.035.080.10PR
12	25	7,5	80	12	2+2	Finishing	X90.12.025.080.12PR
12	35	8	80	12	2+2	Finishing	X90.12.035.080.12PR
16	52	9	110	16	2+2	Finishing	X90.16.052.110.16PR

Solid Carbide Finishing Up & Downcut Spiral Bits for Nesting

D mm	I mm	I ₁ mm	L mm	S mm	Z	TYPE	ARTICLE RH
9,525 (3/8")	22,225 (7/8")	8,38 (21/64")	76,2 (3")	9,525(3/8")	3+3	Finishing	X90.95.222.762.95PR3
10	22	8	70	10	3+3	Finishing	X90.10.022.070.10PR3
10	35	7	80	10	3+3	Finishing	X90.10.035.080.10PR3
12	25	8	80	12	3+3	Finishing	X90.12.025.080.12PR3
12	35	8	80	12	3+3	Finishing	X90.12.035.080.12PR3
12	45	8	90	12	3+3	Finishing	X90.12.045.090.12PR3
16	52	9	110	16	3+3	Finishing	X90.16.052.110.16PR3

D mm	I mm	I ₁ mm	L mm	S mm	Z	TYPE	ARTICLE RH
8	35	7	80	8	2+2	Roughing	X90.08.035.080.08PRz
10	35	7	80	10	2+2	Roughing	X90.10.035.080.10PRz
12	35	8	80	12	2+2	Roughing	X90.12.035.080.12PRz
16	52	9	110	16	2+2	Roughing	X90.16.052.110.16PRz

Detailed information on protective coatings can be found on pages: 57-60.

Solid Carbide Finishing Up & Downcut Spiral Bits for Nesting

X99 NEXCUT
positive-negative

NEW

NEW

VHM

Z2+6

RH

Technical details:

- 2+6 flute spiral cutter
- Compression – upward and downward chip ejection
- Finishing geometry
- PLATINUM coating
- Special nesting carbide grade

Application:



CUTTING



NESTING



JOINTING

Materials:



SOFT SOLID WOOD

● ● ●



HARD SOLID WOOD

● ● ●



RAW MDF

● ● ●



RAW CHIPBOARD

● ● ●



PLYWOOD

● ● ●



LAMINATED PLYWOOD

● ● ●



LAMINATED MDF

● ● ●



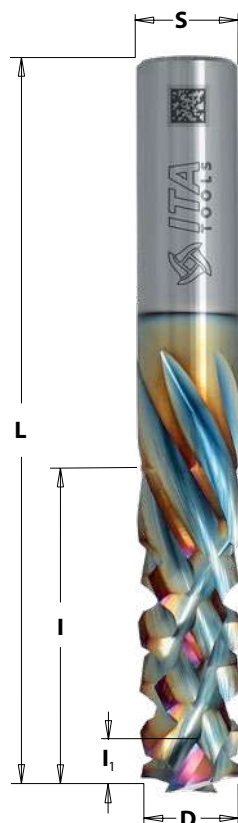
LAMINATED CHIPBOARD

● ● ●



HPL

● ● ●



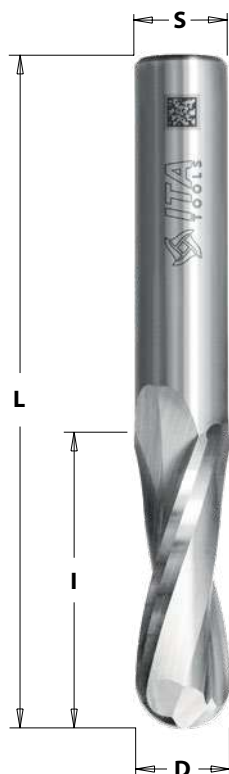
D mm	I mm	I ₁ mm	L mm	S mm	Z	TYPE	ARTICLE RH
6	22	3	70	6	2+6	Finishing	X99.06.022.070.06PR
8	22	4,2	70	8	2+6	Finishing	X99.08.022.070.08PR
10	25	4,5	80	10	6+2	Finishing	X99.10.025.080.10PR
10	35	4,5	80	10	6+2	Finishing	X99.10.035.080.10PR
12	25	5,5	80	12	6+2	Finishing	X99.12.025.080.12PR
12	35	5,5	80	12	6+2	Finishing	X99.12.035.080.12PR
16	35	7,5	90	16	6+2	Finishing	X99.16.035.090.16PR
9,52	25,4	4,3	76,2	9,52	6+2	Finishing	X99.95.254.762.95PR
12,7	25,4	5,8	76,2	12,7	6+2	Finishing	X99.13.254.762.13PR
12,7	38,1	5,8	88,9	12,7	6+2	Finishing	X99.13.381.889.13PR

D	Feed rate RPM
3/8"	15-23 m/min 18000-24000
10"	15-23 m/min 18000-24000
12"	17-26 m/min 18000-24000
12,7"	17-26 m/min 18000-24000
16"	18-36 m/min 18000-24000

Detailed information on protective coatings can be found on pages: 57-60.

Round Nose Solid Carbide Finishing Upcut Spiral Bits Z2

SI01 - 199
positive



VHM

Z2

RH

Technical details:

- 2 flute spiral cutter
- Positive – upward chip ejection
- Finishing geometry
- Round nose

Application:



CUTTING



JOINTING



3D

3D MODELS

Materials:



SOFT SOLID
WOOD
● ● ●



HARD SOLID
WOOD
● ● ●



RAW MDF
● ● ○



RAW
CHIPBOARD
● ● ○



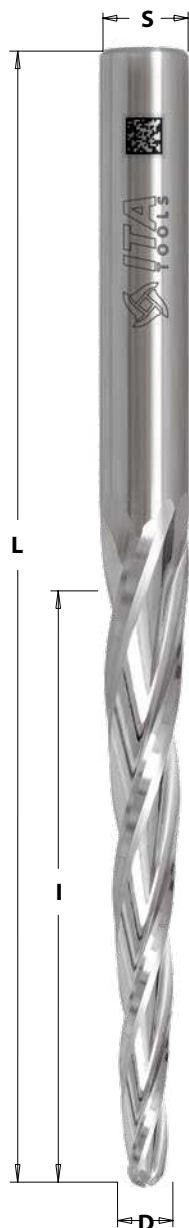
PLYWOOD
● ● ○

D mm	R mm	I mm	L mm	S mm	Z	ARTICLE RH
2	1	10	50	3	2	SI01.02.010.050.03R
6	3	27	70	6	2	SI01.06.027.070.06R
8	4	32	80	8	2	SI01.08.032.080.08R
10	5	32	80	10	2	SI01.10.032.080.10R
12	6	35	80	12	2	SI01.12.035.080.12R
16	8	55	110	16	2	SI01.16.055.110.16R

Detailed information on protective coatings can be found on pages: 57-60.

Tapered Ball Nose Solid Carbide Upcut Spiral Bits for 3D Models

SQ29
positive
NEW



VHM

Z2

RH

Technical details:

- 2 flute spiral cutter
- Positive – upward chip ejection
- Finishing geometry
- Tapered round nose

Application:



3D MODELS



3D MODELS

Materials:



SOFT SOLID
WOOD
● ● ●



HARD SOLID
WOOD
● ● ●



RAW MDF
● ● ○



RAW
CHIPBOARD
● ● ○



PLYWOOD
● ● ○



PLASTICS
● ● ○



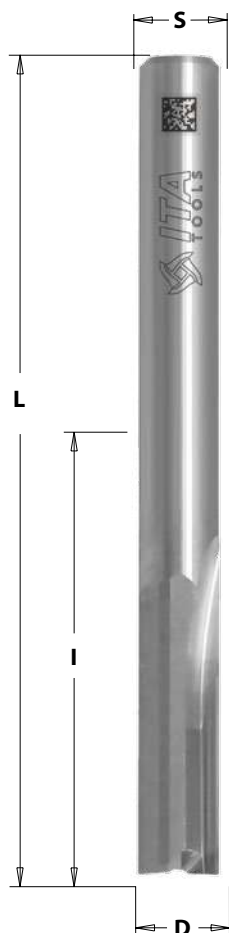
ALUMINUM
● ● ○

D mm	I mm	L mm	S mm	R mm	α	ARTICLE
0,8	25	70	6	0,4	5,5°	SQ29.01.025.070.06R
1,6	25	70	6	0,8	4,5°	SQ29.02.025.070.06R
1,6	50	80	6,35	0,8	5,5°	SQ29.02.050.080.64R
1,6	30	80	8	0,8	5,5°	SQ29.02.030.080.08R
2	80	120	12	1	3°	SQ29.02.080.120.12R
3,2	25,4	80	6	1,6	3,6°	SQ29.03.025.080.06R
3,2	80	80	6,35	1,6	3,6°	SQ29.03.080.080.64R
3,2	50	90	8	1,6	2,5°	SQ29.03.050.090.08R
6	50,8	110	12	3	3,2°	SQ29.06.051.110.12R
12	85	150	12	6	3°	SQ29.12.085.150.12R

Detailed information on protective coatings can be found on pages: 57-60.

SY01 - 912
straight

NEW



VHM

Z2

RH

Technical details:

- Two straight blade cutter
- Straight-chip ejection to the side

Application:



CUTTING



NESTING



GROOVING

Materials:



SOFT SOLID WOOD



HARD SOLID WOOD



RAW MDF



RAW CHIPBOARD



PLYWOOD



LAMINATED MDF



D mm	I mm	L mm	S mm	ARTICLE RH
3	10	60	6	SY01.03.010.060.06R
4	15	60	6	SY01.04.015.060.06R
5	15	60	6	SY01.05.015.060.06R
6	20	60	6	SY01.06.020.060.06R
6	25	60	6	SY01.06.025.060.06R
8	25	70	8	SY01.08.025.070.08R
8	30	70	8	SY01.08.030.070.08R
10	21	70	12	SY01.10.021.070.12R
10	32	80	12	SY01.10.032.080.12R

Detailed information on protective coatings can be found on pages: 57-60.

FVI - FHI

VHM

Z2

RH

Technical details:

- Special type of carbide – increased tool life
- Radius cutters
- Possibility of using variety of coatings

Application:



GROOVING



CHAMFERING

Materials:



SOFT SOLID WOOD
●●○



HARD SOLID WOOD
●●○



RAW MDF
●●○



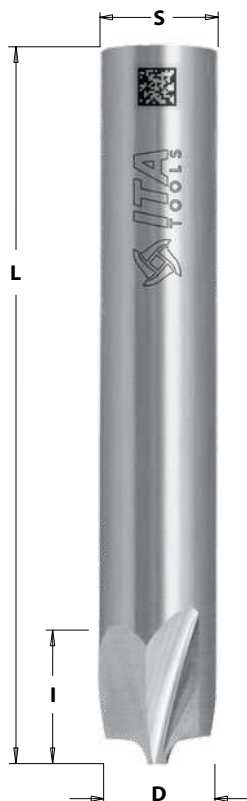
RAW CHIPBOARD
●●○



PLYWOOD
●●○



LAMINATED MDF
●●○



D mm	I mm	L mm	S mm	R mm	ARTICLE
6	18,3	70	12	3	FVI.06.018.070.12R
8	18,3	70	14	3	FVI.08.018.070.14R
8	2	70	8	2	FVI.08.002.070.08R2
10	2	60	10	2	FVI.10.002.060.10R2
10	3	70	10	3	FVI.10.003.070.10R3
12	4	70	12	4	FVI.12.004.070.12R4
18	6	83	18	3	FVI.06.018.083.12R
18	8	83	18	3	FVI.08.018.083.14R
19	6	83	19	3	FVI.06.019.083.12R
8	2	70	8	2	FHI.08.002.070.08R2
10	3	70	10	3	FHI.10.003.070.10R3
12	4	70	12	4	FHI.12.004.070.12R4
16	5	70	16	5	FHI.16.005.070.16R5
16	6	70	16	6	FHI.16.006.070.16R6
20	6	70	20	8	FHI.20.006.070.20R8

Detailed information on protective coatings can be found on pages: 57-60.

XZ3 - 912

straight

NEW



VHM

Z3

RH

Technical details:

- Three straight carbide blade cutter
- Straight-chip ejection to the side
- 3 straight blades – chip discharge sideways
- Body made with steel > 28 HRC
- Perfect finish on both sides of material

Application:



CUTTING



NESTING

Materials:



RAW MDF



RAW
CHIPBOARD



PLYWOOD



LAMINATED
PLYWOOD



LAMINATED
CHIPBOARD



LAMINATED
MDF

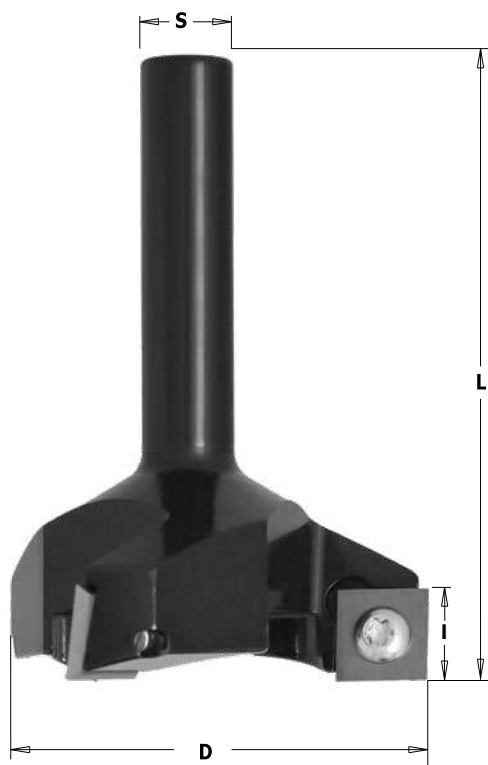


D mm	I mm	L mm	S mm	ARTICLE RH
6	22	76	12	XZ3.06.022.076.12R
6	22*	76	12	XZ3.06.022.076.12Rz
8	32	80	12	XZ3.08.032.080.12R
10	32	80	12	XZ3.10.032.080.12R

* with chipbreaker

Detailed information on protective coatings can be found on pages: 57-60.

FWP



HM

Z3

Z2

RH



Technical details:

- Body made from stainless steel > 28 HRC
- Two [Z2] / Three [Z3] cutting edges with exchangeable HM knives

Application:



PLANNING

Materials:



RAW MDF



LAMINATED MDF



RAW CHIPBOARD



LAMINATED CHIPBOARD



D mm	I mm	L mm	S mm	Z	ARTICLE RH
35	10	60	8x40	3	FWP.035.010.08.0SR
38	12	60	12x40	3	FWP.038.012.12.0SR
60	12	80	12x50	3	FWP.060.012.12.0SR
80	12	90	20x50	3	FWP.080.012.20.0SR

Spare parts:

	GRADE	
105105	MG18	SM4.6.8.T15.01
412124	SMG02	SM4.6.8.T15.02

D mm	I mm	L mm	S mm	Z	ARTICLE RH
58	12	85	20x50	2	FWP.058.012.20.0SR

Spare parts:

	GRADE	
330124	MG06	SM3.8

Profile Router Cutters with Insert Knives for Chamfering

FWH
NEW



VHM

Z1

Z2

RH

EXCHANGEABLE PLATES



Technical details:

- One or two changeable knives
- Body made from stainless steel

Application:



CHAMFERING

Materials:



SOFT SOLID WOOD



HARD SOLID WOOD



RAW MDF



PLYWOOD



RAW CHIPBOARD



D mm	I mm	L mm	S mm	Z	α	ARTICLE RH		Knife Q-ty		Screw Q-ty
22,8	24,5	65	12	1	50°	FWH.022.024.065.12R	KDR.052.30	1	SP.M3,5x4,8	1
31	22,1	66	12	1	70°	FWH.031.022.066.12R	KDR.052.30	1	SP.M3,5x4,8	1
38,4	19	76,5	12	1	91°	FWH.038.019.076.12R	KDR.050.03	1	SP.M3,5x4,8	2
41,2	17,3	81	12	1	100°	FWH.041.017.081.12R	KDR.050.03	1	SP.M3,5x4,8	2
44,2	15,5	81	12	1	110°	FWH.044.015.081.12R	KDR.050.03	1	SP.M3,5x4,8	2
50	44,6	111	20	1	60°	FWH.050.044.111.20R	KDR.050.02	1	SP.M4x6	2
51,6	14,7	77,7	12	2	120°	FWH.051.014.077.12R	KDR.050.06	2	SP.M4x5,6	4
54	12,7	77	12	2	130°	FWH.054.012.077.12R	KDR.050.06	2	SP.M4x5,6	4
57,6	7,6	75	12	2	150°	FWH.057.007.075.12R	KDR.050.05	2	SP.M4x5,6	4
58,7	5	70,7	12	2	160°	FWH.058.005.070.12R	KDR.050.06	2	SP.M4x5,6.1	4
66	33	97	20	1	90°	FWH.066.033.097.20R	KDR.050.01	1	SP.M4x6	2
67	33	97	20	1	91°	FWH.067.033.097.20R	KDR.050.01	1	SP.M4x6	2
86,6	25	97,5	20	2	120°	FWH.086.025.097.20R	KDR.050.04	2	SP.M4x5,6.1	4
90,6	20,8	99	20	2	130°	FWH.090.020.099.20R	KDR.050.04	2	SP.M4x5,6.1	4



SPIRAL BITS FOR COMPOSITES



Processing of composite materials, plastics, aluminum.



Tool personalization,
wide range of
geometries and sizes.



High stock of standard
dimensions – available 24/7.

Chapter

VHM & Diamond Tools for Composites, PVC & ALU



PCD & HM TOOLS

SOLID CARBIDE
ROUTER BITS

PCD & VHM TOOLS FOR
COMPOSITES

CHUCKS
& ACCESSORIES

TOOLS FOR EDGEBANDING
MACHINES

CIRCULAR SAW BLADES

DRILL BITS

STRAIGHT
& SYSTEM KNIVES

STARTER KITS

ST01 series
Z1
finishing
upcut



p. 94

ST51 series
Z1
finishing
downcut



p. 96

ST28 series
Z1
finishing
upcut



p. 97

ST36 series
Z1
super finish
finishing
upcut



p. 99

SP01 series
Z1
finishing
upcut



p. 100

SP02 series
Z2
finishing
upcut



NEW
p. 103

SP15 series
Z1
finishing
upcut



p. 104

SQ01 series
Z2
finishing
upcut



p. 105

SQ02 series
Z2
finishing
upcut



p. 107

SQ31 series
Z2
finishing
upcut



p. 108

SR01 series
Z3
finishing
upcut



p. 110

SR33 series
Z3
roughing
upcut



p. 111

CPS, CPU,
CSS, CVS,
CNS, CNV,
CNR, CNU
series
Multi-edge



p. 112

SQ32 series
Z2
finishing
upcut



p. 118

SR34 series
Z3
roughing
upcut



p. 120

SR02 series
Z3
finishing
upcut



p. 121

FVH series
bending



p. 122

SY26 series
Z2
finishing
straight



p. 123

FVI
series
Z2, Z4
chamfering
rounding



p. 125

SW03 series
Z3, Z4
upcut



NEW
p. 126

FDT, FDH series
Z2
bending



p. 127

DT1/2/3/5
series
**Z1, Z2, Z3,
Z4, Z5**



p. 128

Knives for Cutting
Plotters



p. 129



For more tool dimensions, log in to our B2B System b2b-itatools.pl

ST01 - 198RP positive

VHM

Z1



Technical details:

- 1 flute spiral cutter
- Positive – upward chip ejection
- Finishing geometry
- Polished spiral prevents material sticking

Application:



CUTTING



JOINTING

Materials:



PLEXI



PLASTICS



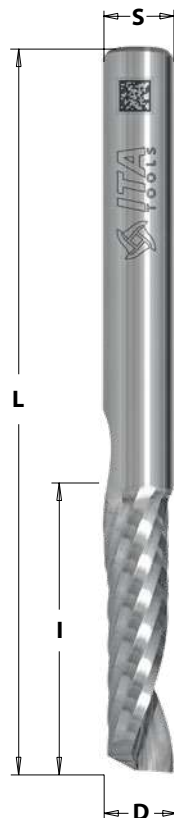
ALUCOBOND®



ALUCOBOND®
A2



CORIAN®
/ HPL



D mm	I mm	L mm	S mm	ARTICLE
2	6	60	6	ST01.02.006.060.06R
3	6	60	3	ST01.03.006.060.03R
3	6	60	6	ST01.03.006.060.06R
3	10	60	6	ST01.03.010.060.06R
3	12	60	3	ST01.03.012.060.03R
3	22	60	3	ST01.03.022.060.03R
3	22	60	6	ST01.03.022.060.06R
4	8	60	4	ST01.04.008.060.04R
4	8	60	6	ST01.04.008.060.06R
4	12	60	4	ST01.04.012.060.04R
4	12	60	6	ST01.04.012.060.06R
4	15	60	4	ST01.04.015.060.04R

Table continued on the next page ►

Solid Carbide Finishing Upcut Spiral Bits Z1 for PLEXI and Plastics

D mm	I mm	L mm	S mm	ARTICLE
4	15	60	6	ST01.04.015.060.06R
4	22	60	6	ST01.04.022.060.06R
5	12	60	6	ST01.05.012.060.06R ▲
5	15	60	5	ST01.05.015.060.05R
5	15	60	6	ST01.05.015.060.06R
5	40	100	8	ST01.05.040.100.08R
6	12	60	6	ST01.06.012.060.06R
6	22	60	6	ST01.06.022.060.06R
6	32	70	6	ST01.06.032.070.06R
8	22	60	8	ST01.08.022.060.08R
8	32	80	8	ST01.08.032.080.08R
10	35	80	10	ST01.10.035.080.10R
10	42	80	10	ST01.10.042.080.10R
10	55	100	10	ST01.10.055.100.10R
12	35	80	12	ST01.12.035.080.12R
12	42	90	12	ST01.12.042.090.12R

Detailed information on protective coatings can be found on pages: 57-60.

Solid Carbide Finishing Downcut Spiral Bits Z1 for PLEXI and Plastics

ST51 - 198RPn
negative

VHM

Z1

RH



Technical details:

- 1 flute spiral cutter
- Negative – downward chip ejection
- Finishing geometry
- Polished spiral prevents material sticking

Application:



CUTTING



JOINTING



RABBETING



GROOVING

Materials:



PLEXI



PLASTICS



ALUCOBOND®



ALUCOBOND®
A2



CORIAN®
/ HPL



D mm	I mm	L mm	S mm	ARTICLE
2	6	60	6	ST51.02.006.060.06R
3	6	60	3	ST51.03.006.060.03R
3	6	60	6	ST51.03.006.060.06R
3	12	60	3	ST51.03.012.060.03R
3	12	60	6	ST51.03.012.060.06R
4	8	60	4	ST51.04.008.060.04R
4	8	60	6	ST51.04.008.060.06R
4	12	60	4	ST51.04.012.060.04R
4	12	60	6	ST51.04.012.060.06R
5	15	60	5	ST51.05.015.060.05R
5	15	60	6	ST51.05.015.060.06R
6	12	60	6	ST51.06.012.060.06R

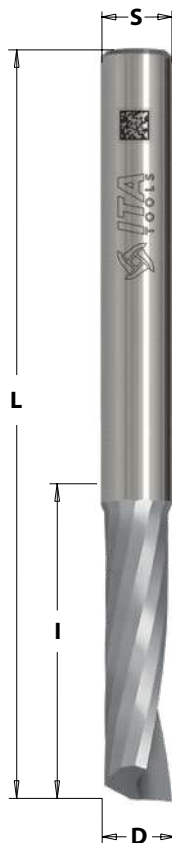
Detailed information on protective coatings can be found on pages: 57-60.

ST28 – 198RPs positive

VHM

Z1

RH



Technical details:

- 1 flute spiral cutter
- Positive – upward chip ejection
- Finishing geometry
- Polished spiral prevents material sticking
- Low helix prevents lifting material
- Perfect for thin materials from 1mm to 8mm

Application:



CUTTING



JOINTING

Materials:



PLEXI



PLASTICS



ALUCOBOND®



ALUCOBOND®
A2



CORIAN®
/HPL



D mm	I mm	L mm	S mm	ARTICLE
2	6	60	3	ST28.02.006.060.03R
3	8	60	3	ST28.03.008.060.03R
3	12	60	3	ST28.03.012.060.03R
3	12	60	6	ST28.03.012.060.06R
4	8	60	4	ST28.04.008.060.04R
4	12	60	4	ST28.04.012.060.04R
4	12	60	6	ST28.04.012.060.06R
4	22	60	6	ST28.04.022.060.06R
5	8	60	5	ST28.05.008.060.05R
5	12	60	6	ST28.05.012.060.06R
6	12	60	6	ST28.06.012.060.06R
6	22	60	6	ST28.06.022.060.06R
8	12	60	8	ST28.08.012.060.08R
10	22	60	10	ST28.10.022.060.10R

Table continued on the next page ►

Solid Carbide Finishing Upcut Spiral Bits Z1 for PLEXI and Plastics

Sizes in inches:

D inch	I inch	L inch	S inch	ARTICLE
1/8	5/16	2 1/2	1/8	ST28.32.794.635.32R
3/16	5/16	2 1/2	3/16	ST28.48.794.635.48R
3/16	5/8	2 1/2	3/16	ST28.48.159.635.48R
1/4	1/2	2 1/2	1/4	ST28.64.127.635.64R
1/4	1	2 1/2	1/4	ST28.64.254.635.64R
3/8	1	2 1/2	3/8	ST28.95.254.635.95R

Detailed information on protective coatings can be found on pages: 57-60.

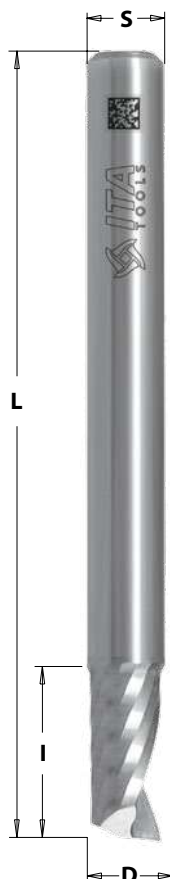
ST36 – 198RPf Super Finish positive

NEW

VHM

Z1

RH



Technical details:

- 1 flute spiral cutter
- Positive – upward chip ejection
- Finishing geometry
- Polished spiral prevents material sticking
- Special geometry for mirror-like finish

Application:



CUTTING



JOINTING

Materials:



PLEXI



PLASTICS



ALUCOBOND®



ALUCOBOND®
A2



CORIAN®
/ HPL



D mm	I mm	L mm	S mm	ARTICLE
2	7	60	6	ST36.02.007.060.06R
3	7	60	6	ST36.03.007.060.06R
3	12	60	6	ST36.03.012.060.06R
4	8	60	6	ST36.04.008.060.06R
4	13	60	6	ST36.04.013.060.06R
5	15	60	6	ST36.05.015.060.06R
6	12	60	6	ST36.06.012.060.06R
6	22	60	6	ST36.06.022.060.06R
8	32	80	8	ST36.08.032.080.08R

Detailed information on protective coatings can be found on pages: 57-60.

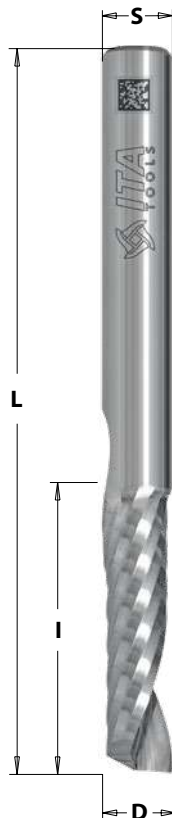
Solid Carbide Finishing Upcut Spiral Bits Z1 for Aluminum

SP01 – 198Ra
positive

VHM

Z1

RH



Technical details:

- 1 flute spiral cutter
- Positive – upward chip ejection
- Finishing geometry
- Polished spiral prevents material sticking

Application:



CUTTING



JOINTING

Materials:



ALUMINUM

●●●



ALUCOBOND®

●●●



ALUCOBOND®
A2

●●●



PLASTICS

●●○



CORIAN®
/HPL

●○○

D mm	I mm	L mm	S mm	ARTICLE
3	6	60	3	SP01.03.006.060.03R
3	6	60	6	SP01.03.006.060.06R
3	12	60	3	SP01.03.012.060.03R
3	12	60	6	SP01.03.012.060.06R
3	22	60	6	SP01.03.022.060.06R
4	8	60	4	SP01.04.008.060.04R
4	8	60	6	SP01.04.008.060.06R
4	12	60	4	SP01.04.012.060.04R
4	12	60	6	SP01.04.012.060.06R
4	15	60	6	SP01.04.015.060.06R
4	22	60	6	SP01.04.022.060.06R
5	15	60	5	SP01.05.015.060.05R
5	15	60	6	SP01.05.015.060.06R

Table continued on the next page ►

Solid Carbide Finishing Upcut Spiral Bits Z1 for Aluminum

D mm	I mm	L mm	S mm	ARTICLE
6	12	60	6	SP01.06.012.060.06R
6	22	60	6	SP01.06.022.060.06R
8	22	60	8	SP01.08.022.060.08R
8	22	70	8	SP01.08.022.070.08R
8	32	80	8	SP01.08.032.080.08R
8	45	100	8	SP01.08.045.100.08R
10	22	60	10	SP01.10.022.060.10R
10	35	80	10	SP01.10.035.080.10R
10	42	80	10	SP01.10.042.080.10R
10	55	100	10	SP01.10.055.100.10R
12	35	80	12	SP01.12.035.080.12R
12	42	90	12	SP01.12.042.090.12R

Sizes in inches:

D inch	I inch	L inch	S inch	ARTICLE
1/8	1/4	2 1/2	1/8	SP01.32.635.635.32R
1/8	1/2	2 1/2	1/8	SP01.32.127.635.32R
3/16	5/16	2 1/2	3/16	SP01.48.794.635.48R
3/16	5/8	2 1/2	3/16	SP01.48.159.635.48R
1/4	1/2	2 1/2	1/4	SP01.64.127.635.64R
1/4	1	2 1/2	1/4	SP01.64.254.635.64R
3/8	1	2 1/2	3/8	SP01.95.254.635.95R
1/2	1 1/2	3 1/2	1/2	SP01.13.381.889.13R

Detailed information on protective coatings can be found on pages: 57-60.

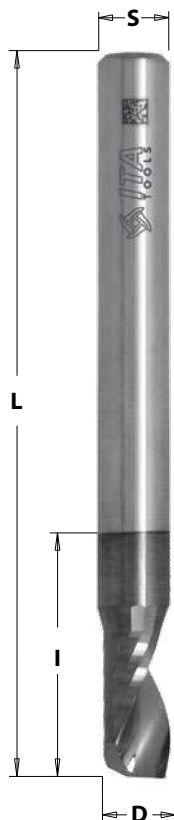
Solid Carbide Finishing Upcut Spiral Bits Z1 for Aluminum

SP01 – 198Ra
positive

VHM

Z1

RH



Technical details:

- 1 flute spiral cutter
- Positive – upward chip ejection
- Finishing geometry
- Polished spiral prevents material sticking

Application:



CUTTING



JOINTING

Materials:



ALUMINUM



ALUCOBOND®



ALUCOBOND®
A2



PLASTICS

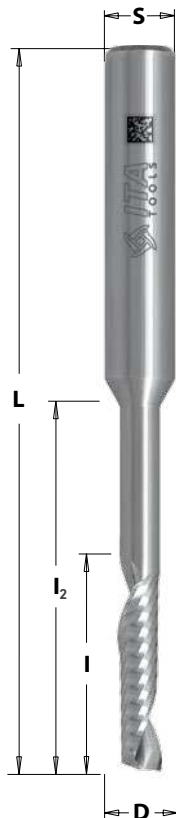


CORIAN®
/HPL



D mm	I mm	L mm	S mm	Z	ARTICLE
2	6	60	6	1	SP01.02.006.060.06HR
3	6	60	6	1	SP01.03.006.060.06HR
3	12	60	6	1	SP01.03.012.060.06HR
4	8	60	6	1	SP01.04.008.060.06HR
4	12	60	6	1	SP01.04.012.060.06HR
5	8	60	6	1	SP01.05.008.060.06HR
5	15	60	6	1	SP01.05.015.060.06HR
6	12	60	6	1	SP01.06.012.060.06HR
6	22	60	6	1	SP01.06.022.060.06HR
8	12	60	8	1	SP01.08.012.060.08HR
8	22	60	8	1	SP01.08.022.060.08HR
8	32	80	8	1	SP01.08.032.080.08HR
10	15	60	10	1	SP01.10.015.060.10HR
10	35	80	8	1	SP01.10.035.080.08HR
10	35	80	10	1	SP01.10.035.080.10HR
10	45	100	10	1	SP01.10.045.100.10HR
12	35	80	8	1	SP01.12.035.080.08HR

SP02
positive
NEW



NEW

VHM

Z1

RH



Technical details:

- Single blade cutter, positive with lowering
- Perfect finishing of cutting edge – the polished chip groove
- Chip discharge upward
- Special type of carbide – increased tool life
- Possibility of using variety of coatings
- Cutting, grooving
- Spiral angle 30°

Application:



CUTTING



JOINTING

Materials:



ALUMINUM



ALUCOBOND®



ALUCOBOND®
A2



PLASTICS



ALU / PVC
PROFILES



D mm	I mm	I ₂ mm	L mm	S mm	Z	ARTICLE
3	16	40	80	8	1	SP02.03.016.080.08R
3	16	40	80	8	1	SP02.03.016.080.08R1
4	16	40	80	8	1	SP02.04.016.080.08R
4	16	40	80	8	1	SP02.04.016.080.08R1
5	20	40	80	8	1	SP02.05.020.080.08R
5	20	40	80	8	1	SP02.05.020.080.08R1
6	22	40	80	8	1	SP02.06.022.080.08R
8	25	45	100	8	1	SP02.08.025.100.08R
10	20	40	80	10	1	SP02.10.020.080.10R
10	15	60	100	10	1	SP02.10.015.100.10R
10	22	80	120	10	1	SP02.10.022.120.10R

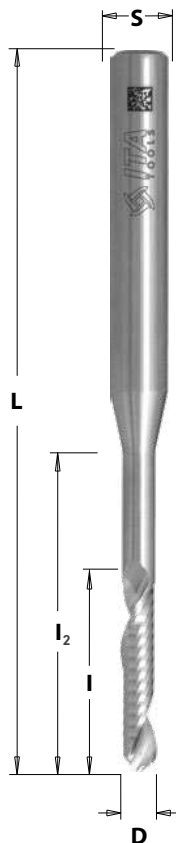
Detailed information on protective coatings can be found on pages: 57-60.

SP15 positive

VHM

Z1

RH



Technical details:

- 1 flute spiral cutter
- Positive with drilling V-point 90°
- Finishing geometry
- Polished spiral prevents material sticking

Application:



CUTTING



JOINTING



RABBETING



GROOVING

Materials:



ALUMINUM



ALUCOBOND®



ALUCOBOND®
A2



PLASTICS



CORIAN®
/ HPL



PVC & ALUMINUM
PROFILES



D mm	I mm	I ₂ mm	L mm	S mm	Z	ARTICLE
5	25	35	80	8	1	SP15.05.025.080.08R
5	25	45	100	8	1	SP15.05.025.100.08R
5	35	55	100	8	1	SP15.05.035.100.08R
6	25	45	80	8	1	SP15.06.025.080.08R

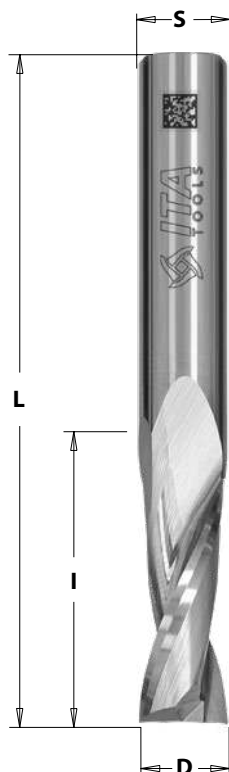
Detailed information on protective coatings can be found on pages: 57-60.

SQ01 – 186Ra positive

VHM

Z2

RH



Technical details:

- 2 flute spiral cutter
- Positive – upward chip ejection
- Finishing geometry
- Polished spiral prevents material sticking

Application:



CUTTING



JOINTING

Materials:



ALUMINUM



CORIAN®
/ HPL



PLASTICS



D mm	I mm	L mm	S mm	ARTICLE
3	10	60	3	SQ01.03.010.060.03R
3	12	60	6	SQ01.03.012.060.06R
4	10	60	4	SQ01.04.010.060.04R
4	12	60	6	SQ01.04.012.060.06R
5	12	60	5	SQ01.05.012.060.05R
5	22	60	5	SQ01.05.022.060.05R
6	12	60	6	SQ01.06.012.060.06R
6	22	60	6	SQ01.06.022.060.06R
6	40	120	6	SQ01.06.040.120.06R
8	22	60	8	SQ01.08.022.060.08R
8	35	80	8	SQ01.08.035.080.08R
8	40	100	8	SQ01.08.040.100.08R
10	22	60	10	SQ01.10.022.060.10R
10	35	80	10	SQ01.10.035.080.10R
10	45	100	10	SQ01.10.045.100.10R

Table continued on the next page ►

Solid Carbide Finishing Upcut Spiral Bits Z2 for Aluminum and Plastics

D mm	I mm	L mm	S mm	ARTICLE
12	25	70	12	SQ01.12.025.070.12R
12	42	90	12	SQ01.12.042.090.12R
12	45	90	12	SQ01.12.045.090.12R
16	35	80	16	SQ01.16.035.080.16R
16	55	110	16	SQ01.16.055.110.16R
20	45	90	20	SQ01.20.045.090.20R

PCD & HM TOOLS

SOLID CARBIDE
ROUTER BITSPCD & VHM TOOLS FOR
COMPOSITESCHUCKS
& ACCESSORIESTOOLS FOR EDGEBANDING
MACHINES

CIRCULAR SAW BLADES

DRILL BITS

STRAIGHT
& SYSTEM KNIVES

STARTER KITS

SQ02 positive

VHM

Z2

RH



Technical details:

- 2 flute spiral cutter with lowering
- Positive – upward chip ejection
- Finishing geometry
- Polished spiral prevents material sticking

Application:



CUTTING



JOINTING

Materials:



ALUMINUM



ALU / PVC
PROFILES



PLASTICS



CORIAN®
/ HPL



Work parameters:

ALUMINUM

- RPM 10 000-18 000
- feed 0,8-2 m/min

PLASTICS

- RPM 16 000-24 000
- feed 2-6 m/min

D mm	I mm	I ₂ mm	L mm	S mm	Z	ARTICLE
6	22	45	80	6	2	SQ02.06.022.080.06R
7	22	42	100	8	2	SQ02.07.022.100.08R
8	20	45	80	8	2	SQ02.08.020.080.08R
8	22	65	105	8	2	SQ02.08.022.105.08R
10	25	50	90	10	2	SQ02.10.025.090.10R
10	25	50	100	10	2	SQ02.10.025.100.10R
10	25	80	100	10	2	SQ02.10.025.120.10R
11	15	65	110	12	2	SQ02.11.015.110.12R
12	25	65	105	12	2	SQ02.12.025.105.12R
12	25	85	120	12	2	SQ02.12.025.120.12R

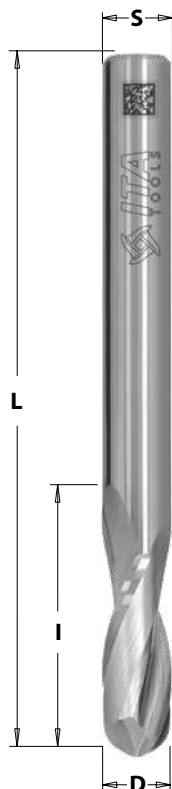
Detailed information on protective coatings can be found on pages: 57-60.

SQ31 – 199Ra positive

VHM

Z2

RH



Technical details:

- 2 flute spiral cutter
- Positive – upward chip ejection
- Finishing geometry
- Polished spiral prevents material sticking
- Round nose

Application:



CUTTING



JOINTING

Materials:



ALUMINUM



PLASTICS



CORIAN®
/ HPL



D mm	I mm	L mm	S mm	R mm	ARTICLE
3	10	60	3	1,5	SQ31.03.010.060.03R
3	10	60	6	1,5	SQ31.03.010.060.06R
4	10	60	4	2	SQ31.04.010.060.04R
4	12	60	6	2	SQ31.04.012.060.06R
5	12	60	5	2,5	SQ31.05.012.060.05R
6	22	60	6	3	SQ31.06.022.060.06R
8	22	60	8	4	SQ31.08.022.060.08R
10	22	60	10	5	SQ31.10.022.060.10R
10	45	100	10	5	SQ31.10.045.100.10R
12	25	70	12	6	SQ31.12.025.070.12R
12	42	90	12	6	SQ31.12.042.090.12R
16	35	90	16	8	SQ31.16.035.090.16R

Sizes in inches:

D inch	I inch	L inch	S inch	R inch	ARTICLE
1/8	1/2	2 1/2	1/8	1/16	SQ31.32.953.635.32R
3/16	5/8	2 1/2	3/16	3/32	SQ31.48.159.635.48R
1/4	1	2 1/2	1/4	1/8	SQ31.64.254.635.64R
1/2	1	3 1/4	1/2	1/4	SQ31.13.254.826.13R
5/8	1 1/2	3 1/2	5/8	5/16	SQ31.16.381.889.16R
3/4	1 3/4	3 1/2	3/4	3/8	SQ31.19.445.889.19R

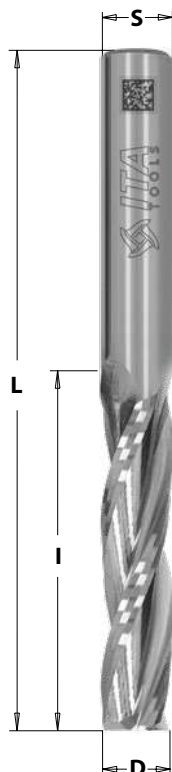
Detailed information on protective coatings can be found on pages: 57-60.

SR01 – 193Ra positive

VHM

Z3

RH



Technical details:

- 3 flute spiral cutter
- Positive – upward chip ejection
- Finishing geometry
- Polished spiral prevents material sticking

Application:



CUTTING



JOINTING

Materials:



ALUMINUM



PLASTICS



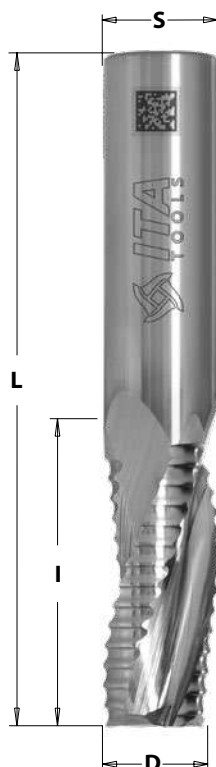
CORIAN®
/ HPL



D mm	I mm	L mm	S mm	ARTICLE
4	12	60	4	SR01.04.012.060.04R
6	22	60	6	SR01.06.022.060.06R
8	35	80	8	SR01.08.035.080.08R
10	32	80	10	SR01.10.032.080.10R
12	32	90	12	SR01.12.032.090.12R
16	55	110	16	SR01.16.055.110.16R
20	60	120	20	SR01.20.060.120.20R

Detailed information on protective coatings can be found on pages: 57-60.

SR33 – 195Ra positive



VHM

Z3

RH



Technical details:

- 3 flute spiral cutter
- Positive – upward chip ejection
- Roughing geometry
- Polished spiral prevents material sticking

Application:



CUTTING



JOINTING

Materials:



ALUMINUM



CORIAN®
/ HPL



PLASTICS



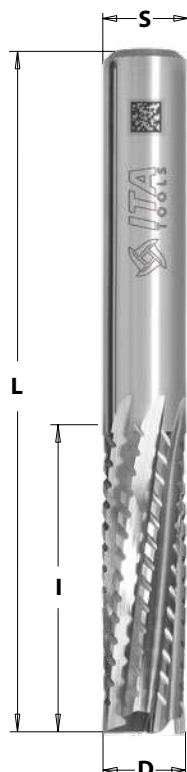
D mm	I mm	L mm	S mm	ARTICLE
6	22	60	6	SR33.06.022.060.06R
8	32	70	8	SR33.08.032.070.08R
10	32	80	10	SR33.10.032.080.10R
10	65	115	10	SR33.10.065.115.10R
12	32	80	12	SR33.12.032.080.12R
16	32	90	16	SR33.16.032.090.16R
16	55	110	16	SR33.16.055.110.16R
20	32	80	20	SR33.20.032.080.20R
20	60	120	20	SR33.20.060.120.20R
25	35	80	25	SR33.25.035.080.20R

Detailed information on protective coatings can be found on pages: 57-60.

CPS
positive

VHM

RH



Technical details:

- Multi-edge geometry
- Positive – upward chip ejection
- Geometry adapted to the processing of composites, preventing delamination and pulling out of glass and carbon fibers

Application:



CUTTING



JOINTING

Materials:



CARBON
FIBER



GLASS FIBER



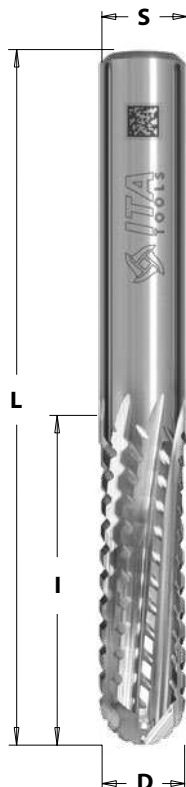
CORIAN®
/ HPL



D mm	I mm	L mm	S mm	ARTICLE
3	10	45	3	CPS.03.010.045.03R
4	15	60	4	CPS.04.015.060.04R
4	15	60	6	CPS.04.015.060.06R
6	25	70	6	CPS.06.025.070.06R
8	30	80	8	CPS.08.030.080.08R
10	35	80	10	CPS.10.035.080.10R
12	40	90	12	CPS.12.040.090.12R

Detailed information on protective coatings can be found on pages: 57-60.

CPU
positive



VHM

RH

Technical details:

- Multi-edge geometry
- Positive – upward chip ejection
- Geometry adapted to the processing of composites, preventing delamination and pulling out of glass and carbon fibers
- Round nose

Application:



CUTTING



JOINTING

Materials:



CARBON
FIBER



GLASS FIBER



CORIAN®
/ HPL



D mm	I mm	L mm	S mm	R	ARTICLE
3	10	45	3	1,5	CPU.03.010.045.03R
4	15	60	4	2	CPU.04.015.060.04R
8	30	80	8	4	CPU.08.030.080.08R
10	35	80	10	5	CPU.10.035.080.10R
12	40	90	12	6	CPU.12.040.090.12R

Detailed information on protective coatings can be found on pages: 57-60.

Solid Carbide Finishing Straight Multi-edge Spiral Bits for Composites

CSS
straight

VHM

RH



Technical details:

- Multi-edge geometry
- Straight- chip ejection to the side
- Geometry adapted to the processing of composites, preventing delamination and pulling out of glass and carbon fibers

Application:



CUTTING



JOINTING



GROOVING

Materials:



CARBON
FIBER



GLASS FIBER



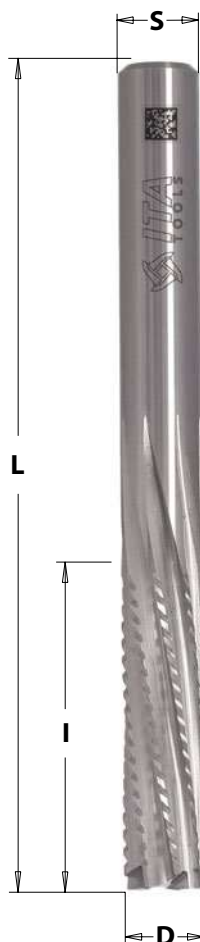
CORIAN®
/ HPL



D mm	I mm	L mm	S mm	ARTICLE
3	10	45	3	CSS.03.010.045.03R
4	15	60	4	CSS.04.015.060.04R
4	15	60	6	CSS.04.015.060.06R
6	20	60	6	CSS.06.020.060.06R
8	30	80	8	CSS.08.030.080.08R
10	35	80	10	CSS.10.035.080.10R
12	40	90	12	CSS.12.040.090.12R

Detailed information on protective coatings can be found on pages: 57-60.

CVS
negative



VHM

RH

Technical details:

- Multi-edge geometry
- Negative – downward chip ejection
- Geometry adapted to the processing of composites, preventing delamination and pulling out of glass and carbon fibers

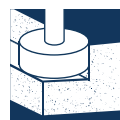
Application:



CUTTING



JOINTING



RABBETING



GROOVING

Materials:



CARBON
FIBER



GLASS FIBER



CORIAN®
/ HPL



D mm	I mm	L mm	S mm	ARTICLE
3	10	45	3	CVS.03.010.045.03R
3	10	60	6	CVS.03.010.060.06R
4	15	60	4	CVS.04.015.060.04R
5	15	60	5	CVS.05.015.060.05R
6	20	70	6	CVS.06.020.070.06R
8	30	80	8	CVS.08.030.080.08R
10	35	80	10	CVS.10.035.080.10R
12	40	90	12	CVS.12.040.090.12R

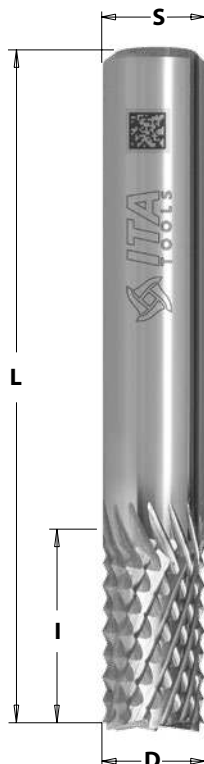
Detailed information on protective coatings can be found on pages: 57-60.

Solid Carbide Roughing Multi-edge Spiral Bits for Composites

CNS / CNV / CNR / CNU
positive-negative

VHM

RH



Technical details:

- Multi-edge geometry
- Straight- chip ejection to the side
- Geometry adapted to the processing of composites, preventing delamination and pulling out of glass and carbon fibers
- 3 versions of the tip:
 - CNS – standard
 - CNR – rosette
 - CNV – drilling
 - CNU – ball nose



CNS



CNR



CNV



CNU

Application:



CUTTING



JOINTING

Materials:



CARBON FIBER



GLASS FIBER



CORIAN® / HPL



PLYWOOD



D mm	I mm	L mm	S mm	ARTICLE ROSETTE TIP
3	10	45	3	CNR.03.010.045.03R
3	10	60	6	CNR.03.010.060.06R
4	18	60	4	CNR.04.018.060.04R
4	22	60	5	CNR.04.022.060.05R
4	22	60	6	CNR.04.022.060.06R
6	15	60	6	CNR.06.015.060.06R
6	24	60	6	CNR.06.024.060.06R
6	25	70	6	CNR.06.025.070.06R
6	30	70	6	CNR.06.030.070.06R
8	25	80	8	CNR.08.025.080.08R

Solid Carbide Roughing Multi-edge Spiral Bits for Composites

D mm	I mm	L mm	S mm	ARTICLE ROSETTE TIP
8	35	80	8	CNR.08.035.080.08R
8	30	80	8	CNR.08.030.080.08R
10	30	90	10	CNR.10.030.090.10R
10	35	80	10	CNR.10.035.080.10R
12	30	90	12	CNR.12.030.090.12R
16	45	100	16	CNR.16.045.100.16R

Changing the version of the tip changes the article index.

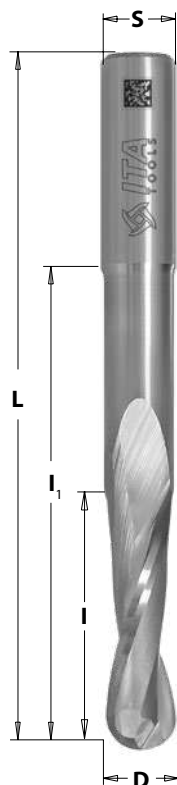
Detailed information on protective coatings can be found on pages: 57-60.

SQ32 - 199Rm positive

VHM

Z2

RH



Technical details:

- 2 flute spiral cutter
- Positive – upward chip ejection
- Finishing geometry
- Polished spiral prevents material sticking
- Extended body with lowering
- Round nose

Application:



CUTTING



JOINTING



3D MODELS

Materials:



ALUMINUM



CORIAN®
/ HPL



D mm	I mm	I ₁ mm	L mm	S mm	R mm	ARTICLE
4	10	25	60	6	2	SQ32.04.010.060.06R
6	22	45	80	6	3	SQ32.06.022.080.06R
8	22	65	100	8	4	SQ32.08.022.100.08R
8	22	85	120	8	4	SQ32.08.022.120.08R
10	20	75	110	10	5	SQ32.10.020.110.10R
10	30	100	150	10	5	SQ32.10.030.150.10R
12	30	80	120	12	6	SQ32.12.030.120.12R
12	30	120	160	12	6	SQ32.12.030.160.12R
16	40	100	150	16	8	SQ32.16.040.150.16R
16	40	150	200	16	8	SQ32.16.040.200.16R
20	40	100	150	20	10	SQ32.20.040.150.20R
20	40	150	200	20	10	SQ32.20.040.200.20R
20	40	200	250	20	10	SQ32.20.040.250.20R

Sizes in inches:

D inch	I inch	I ₁ inch	L inch	S inch	R inch	ARTICLE
3/16	5/8	1	2 1/2	3/16	3/32	SQ32.48.159.635.48R
1/4	1	1 3/4	3 1/4	1/4	1/8	SQ32.64.254.826.64R
3/8	1	2 1/2	4	3/8	3/19	SQ32.95.254.102.95R
1/2	1 1/4	3 1/4	5	1/2	1/4	SQ32.13.318.127.13R
5/8	1 3/4	4	6	5/8	5/16	SQ32.16.445.152.16R
3/4	1 3/4	6	8	3/4	3/8	SQ32.19.445.203.19R

Detailed information on protective coatings can be found on pages: 57-60.

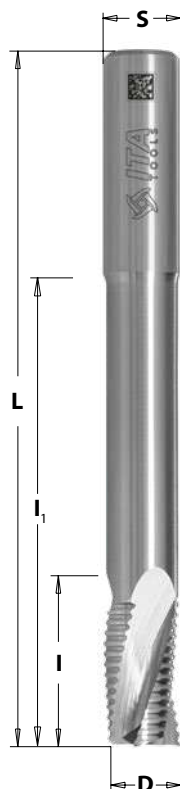
Solid Carbide Roughing Upcut Spiral Bits Z3 for 3D Models

SR34 – 195Rm
positive

VHM

Z3

RH



Technical details:

- 3 flute spiral cutter
- Positive – upward chip ejection
- Roughing geometry
- Polished spiral prevents material sticking
- Extended body with lowering

Application:



CUTTING



JOINTING



3D MODELS

Materials:



ALUMINUM



CORIAN®
/ HPL



D mm	I mm	I ₁ mm	L mm	S mm	ARTICLE
16	40	100	150	16	SR34.16.040.150.16R
16	40	150	200	16	SR34.16.040.200.16R
20	40	200	250	20	SR34.20.040.250.20R
25	40	200	250	25	SR34.25.040.250.25R

Sizes in inches:

D inch	I inch	I ₁ inch	L inch	S inch	ARTICLE
5/8	1 3/4	4	6	5/8	SR34.16.445.152.16R
3/4	1 3/4	6	8	3/4	SR34.19.445.203.19R

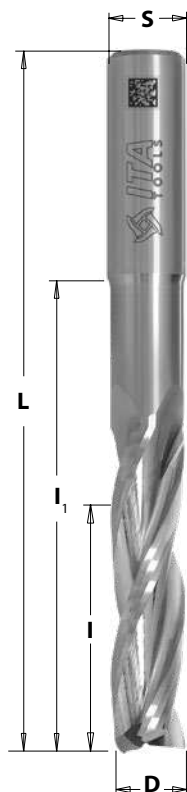
Detailed information on protective coatings can be found on pages: 57-60.

SR02 – 193Rm
positive

VHM

RH

Z3



Technical details:

- 3 flute spiral cutter
- Positive – upward chip ejection
- Finishing geometry
- Polished spiral prevents material sticking
- Extended body with lowering
- Round nose

Application:



CUTTING



JOINTING



3D MODELS

Materials:



ALUMINUM



CORIAN®
/ HPL



D mm	I mm	I ₁ mm	L mm	S mm	ARTICLE
16	40	100	150	16	SR02.16.040.150.16R
16	40	150	200	16	SR02.16.040.200.16R
20	40	150	200	20	SR02.20.040.200.20R

Detailed information on protective coatings can be found on pages: 57-60.

FVH - 915Ra

VHM

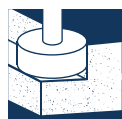
RH



Technical details:

- Dibond bend cutter, 4 different types: V-90, V-108, V-135, 1,8mm

Application:



RABBETING



BENDING

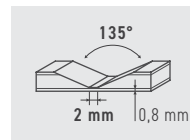
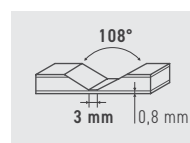
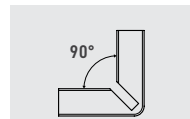
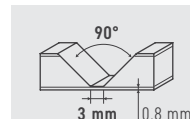
Materials:



ALUCOBOND®



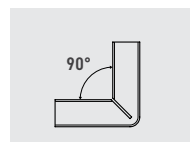
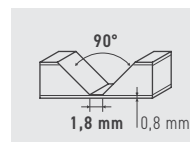
ALUCOBOND® A2



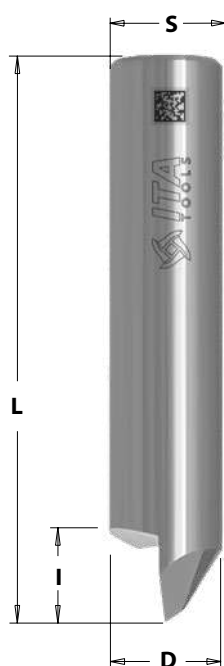
D mm	I mm	L mm	S mm	α	ARTICLE
16	15	60	10	90°	FVH.16.015.060.10Ra1
16	15	60	12	90°	FVH.16.015.060.12Ra1
16	15	60	12	108°	FVH.16.015.060.12Ra2
18	15	60	12	135°	FVH.18.015.060.12Ra3

Dibond bend cutter Z1, 1,8 mm:

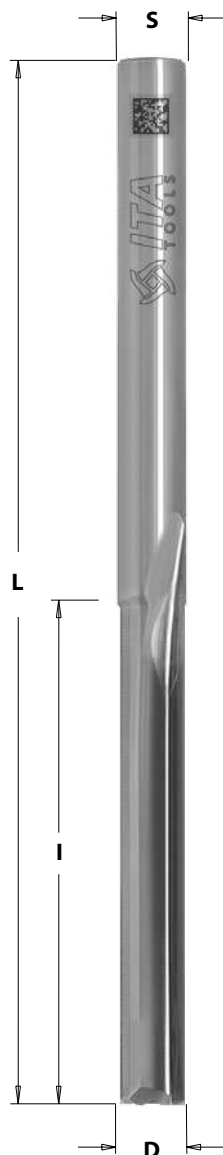
D mm	I mm	L mm	S mm	α	ARTICLE
10	4,12	50	10	90°	FVH.10.004.050.10Ra1



Detailed information on protective coatings can be found on pages: 57-60.



SY26 - 912Rpi straight



VHM

RH

Z2



Technical details:

- 2 straight blades cutter
- Straight-chip ejection to the side
- Polished spiral prevent material sticking

Application:



CUTTING



JOINTING



GROOVING

Materials:



FOAM



CORIAN® / HPL



PLASTICS



D mm	I mm	L mm	S mm	ARTICLE
3	15	60	3	SY26.03.015.060.03R
4	15	60	4	SY26.04.015.060.04R
4	15	75	4	SY26.04.015.075.04R
5	15	75	5	SY26.05.015.075.05R
6	20	70	6	SY26.06.020.070.06R
6	25	60	6	SY26.06.025.060.06R
6	42	90	6	SY26.06.042.090.06R
8	70	120	8	SY26.08.070.120.08R
12	20	100	12	SY26.12.020.100.12R
12	50	140	12	SY26.12.050.140.12R
12	70	140	12	SY26.12.070.140.12R
16	40	160	16	SY26.16.040.160.16R
20	30	273	20	SY26.20.030.273.20R

Detailed information on protective coatings can be found on pages: 57-60.

SY26.XR – 912XRi straight

VHM

RH

Z2



Technical details:

- 2 straight blades cutter
- Straight-chip ejection to the side
- Polished spiral prevents material sticking
- NaDia coating

Application:



CUTTING



JOINTING



GROOVING

Materials:



CORIAN®
/ HPL



PLASTICS



D mm	I mm	L mm	S mm	ARTICLE
4	15	60	4	SY26.04.015.060.04XR
6	15	60	6	SY26.06.015.060.06XR
8	15	60	8	SY26.08.015.060.08XR
10	15	60	10	SY26.10.015.060.10XR

Detailed information on protective coatings can be found on pages: 57-60.

FVI – 915Rs

VHM

RH

Z2

Z4



Technical details:

- Chamfer cutter, 3 different types: V-22,5°, V-30°, V-45°
- Special type of carbide – increased tool life
- R2 and R3 radius cutters
- Possibility of using variety of coatings

Application:



CHAMFERING

Materials:



ALUCOBOND®

ALUCOBOND®
A2

PLASTICS



Z2 for Rounding:

D mm	D ₁ mm	I mm	L mm	S mm	R mm	ARTICLE
10	2	2	60	10	2	FVI.10.002.060.10R2
10	2	3	60	10	3	FVI.10.003.060.10R3

Detailed information on protective coatings can be found on pages: 57-60.

SW03 - S93
positive

NEW

VHM

Z3

Z4

RH

LH

Technical details:

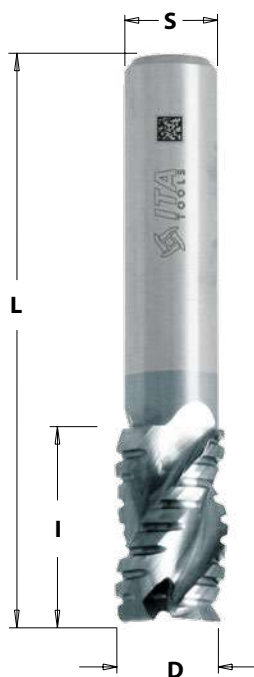
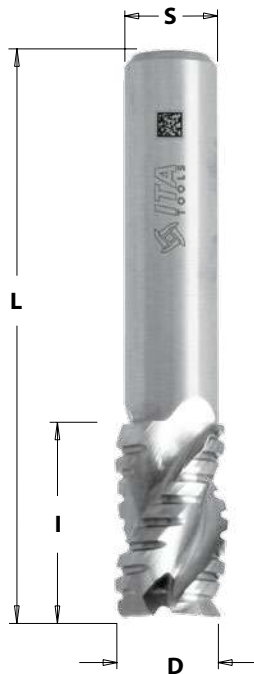
- Three flute router bit with chip breaker
- Right and left rotating cutter
- Polished chip flute prevents material sticking
- Upward chip ejection
- Special type of carbide with increased tool life
- Coating possible

Application:

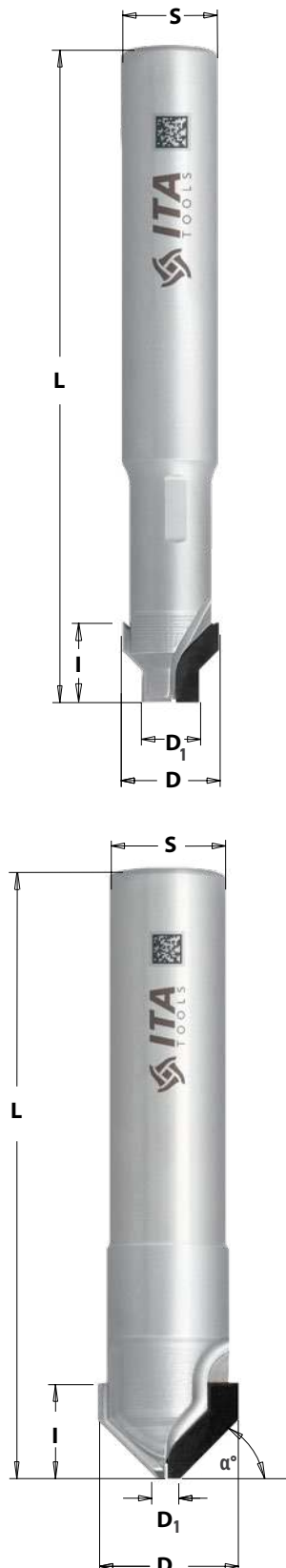
For milling cross-sections of PVC profiles in machines for shaped, flashless joining of profiles. Designed for use on GRAF SYNERGY® machines.

D mm	I mm	L mm	S mm	ARTICLE
6	10	30	5	SW03.06.010.030.05HR
6	10	30	5	SW03.06.010.030.05HL

Detailed information on protective coatings can be found on pages: 57-60.



FDT | FDH



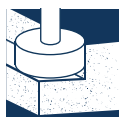
Technical details:

- Full double PCD tips,
- Body made from stainless steel > 28 HRC
- Approval class of shank H6
- The shank surface roughness $Ra \leq 0,3 \mu m$
- Height of PCD tip 4 mm
- Can be resharpened (3-4 times)

Advantages:

Excellent finish of machining elements, quiet work.

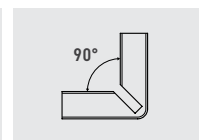
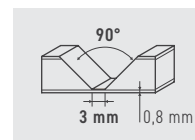
Application:



RABBETING



BENDING



Materials:



ALUCOBOND®



ALUCOBOND®
A2

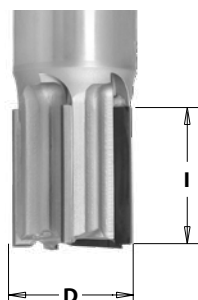
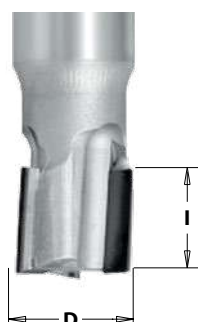
FDT for Cutting:

D mm	D ₁ mm	I mm	L mm	S mm	α	ARTICLE
12	7	6,5	80	12	45°	FDT.12.006.12.0SR
12	6	6,5	80	12	45°	FDT.12.006.12.1SR

FDH for Bending:

D mm	D ₁ mm	I mm	L mm	S mm	α	ARTICLE
12	2	6	55	12	45°	FDH.12.006.12.0SR
18	3	7,75	50	16	45°	FDH.18.007.16.0SR

DT1/2/3/R/5



Technical details:

- PCD tips,
- Body made from stainless steel > 28 HRC + HM + DENSIMET
- Approval class of shank H6
- The shank surface roughness Ra ≤ 0,3 μm
- Can be resharpened (3-4 times)

Application:

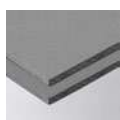


CUTTING



GROOVING

Materials:



FIBER
CEMENT



GLASS FIBER/
CARBON FIBER



CORIAN®
/HPL



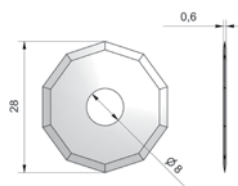
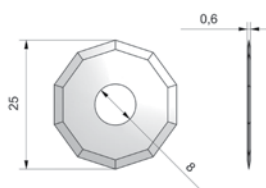
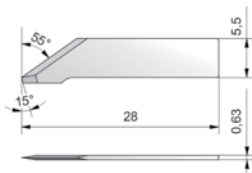
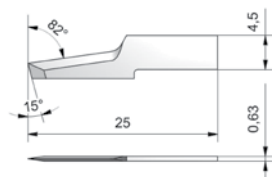
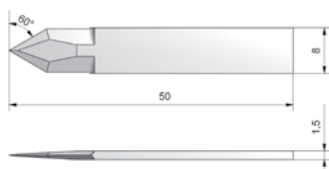
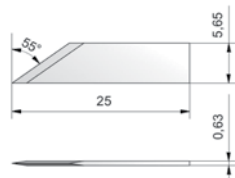
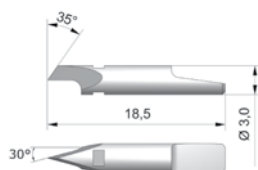
ALUMINUM



D mm	I mm	L mm	S mm	Z	PCD H mm	BODY	ARTICLE
6	5	50	6	1	3	HM	DT1.06.005.06.0MR
6	11	50	6	1	3	HM	DT1.06.011.06.0MR
12	5	55	12	2	2,5	STAINLESS STEEL	DT2.12.005.12.0SR
12	15	85	12	3	3	STAINLESS STEEL	DT3.12.015.12.0SR
12	15	70	12	3	3,5	DENSIMET®	DT3.12.015.12.0DR
12	15	70	12	4	3	DENSIMET®	DTR.12.015.12.1DR*
16	10	130	16	5	3	STAINLESS STEEL	DT5.16.010.16.2SR
18	22	100	20	5	3	STAINLESS STEEL	DT5.18.022.20.0SR
20	22	80	20	5	3	STAINLESS STEEL	DT5.20.022.20.0SR

*with chipbreaker

NEW



ARTICLE	MACHINE	TECHNICAL DETAILS	
ITA.2	Zünd Z2 Esko BLD-KC102 (i-102)	Type*	R, Z, K
		Pre-cut	1,43 x Tm
		Post-cut	---
		Max. cut depth	1,00 mm

ARTICLE	MACHINE	TECHNICAL DETAILS	
ITA.16	Zünd Z16 Esko BLD-SF216 (i-216) Bullmer B16	Type*	F, Z, O
		Pre-cut	0,73 x Tm
		Post-cut	---
		Max. cut depth	7,40 mm

ARTICLE	MACHINE	TECHNICAL DETAILS	
ITA.44	Zünd Z44	Type*	F, Z
		Pre-cut	0,58 x Tm
		Post-cut	0,58 x Tm
		Max. cut depth	14,00 mm

ARTICLE	MACHINE	TECHNICAL DETAILS	
ITA.41	Zünd Z41	Type*	F, O
		Pre-cut	0,8 + 0,18 x Tm
		Post-cut	1,20 mm
		Max. cut depth	11,30 mm

ARTICLE	MACHINE	TECHNICAL DETAILS	
ITA.42	Zünd Z42 Bullmer 107506	Type*	F, O
		Pre-cut	0,05 + 0,7 x Tm
		Post-cut	0,80 mm
		Max. cut depth	7,80 mm

ARTICLE	MACHINE	TECHNICAL DETAILS	
ITA.50	Zünd Z50 Esko BLD-RC110	Type*	Rot
		Max. cut depth	3,50 mm

ARTICLE	MACHINE	TECHNICAL DETAILS	
ITA.51	Zünd Z51	Type*	Rot
		Max. cut depth	5,00 mm

LEGEND | Types of knives

F - Flat
R - Arbor
Z - Drag knife

O - Oscillating
Rot - Rotary
Round - Round blade

P - Passe-partout
K - Kiss-Cut
T - Tangent

Chapter

CNC Router Cutters, Chucks & Accessories

HSK63F
series

p. 131



HSK63F
series
with Bearing
Nut

p. 131



HSK63F
HYDRO

p. 132



HSK63F
SHRINK-FIT

p. 132



H6FPDX
SHRINK-FIT
SLIM

p. 133



ISO30
DIN 69871

p. 134



Assembly
supports for
ISO chucks

p. 135



HSK.63F/ISO.30

p. 135



HSK63F
DIN 69893

p. 136



Extension for Precision
Collets

p. 137



Fixing Nuts for Chucks
ISO/ HSK Standard
DIN 6499

p. 137



Precision Collets

p. 138-139



HSK63F
SBA.H6F

p. 140



SBA.S20 Saw Blade
Arbor with
Parallel Shank

p. 140



Spanners

p. 141



Tool Holder
Clamp CNC

p. 141



DUST
Kinetic Dust
Extractor

NEW

s. 142



EPDM
Rope of Cellular
Rubber Round

p. 142



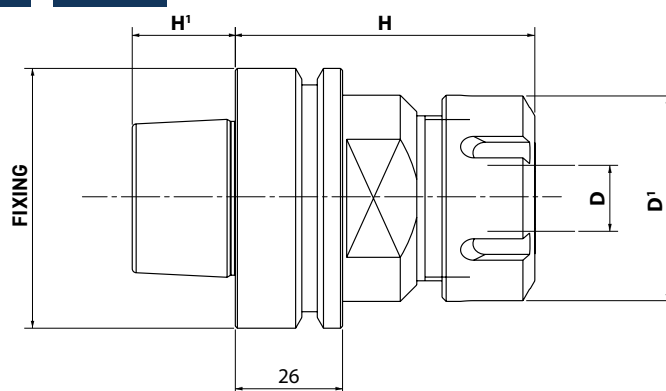
Chuck HSK-63 for CNC machines

HSK63F DIN 69893



RH

LH



Application:

For machines type: BIESSE®, EIMA®, HOMAG®, SCM®, IMA® (from 9/94), WEEKE®, DUBUS®, BUSELLATO®.

FIXING	SLEEVES	D mm		D' mm	H mm	H' mm	ROTATION	ARTICLE
		min.	max.					
HSK63F	ER32	3	20	50	73	25	RH	H6FPDX20 *
HSK63F	ER40	4	30	63	80	25	RH	H6FPDX26 *
HSK50F	ER32	3	20	50	65	20	RH	H5FPDX20BS

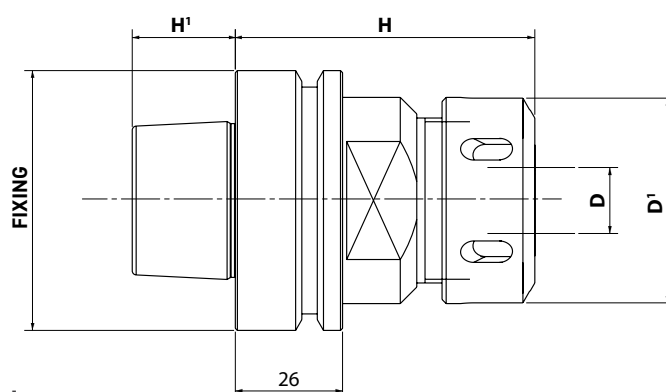
* blind hole

HSK63F with Bearing Nut



RH

LH



Application:

For machines type: BIESSE®, EIMA®, HOMAG®, SCM®, IMA® (from 9/94), WEEKE®, DUBUS®, BUSELLATO®.

FIXING	SLEEVES	D mm		D' mm	H mm	H' mm	ROTATION	ARTICLE
		min.	max.					
HSK63F	ER32	3	20	50	73	25	RH	H6FPDX20.BN *
HSK63F	ER40	4	30	63	80	25	RH	H6FPDX26.BN *
HSK63F	EOC25	2	25	60	80	25	RH	H6FPDX25.BN *
HSK63F	EOC25	2	25	60	80	25	RH	H6FPDX25

* blind hole

Chuck HSK-63 for CNC machines

HSK63F HYDRO

RH

LH



Advantages:

- Highest quality of fixing provides evenly work all knives together
- Lack of collets and fixing nuts are minimizing vibrations

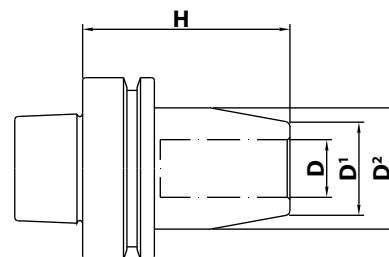
Application:

Precise HYDRO chuck offer exceptional precision and clamping stability, resulting in improved machining quality, reduced tool runout, and extended tool and spindle life. Additionally, their quick and easy clamping system helps to save time during machine setup and tool changes.

D ¹ mm	D ² mm	D ³ mm	H ¹ mm	H ² mm	H ³ mm	H ⁴ mm	ARTICLE
12	22	43,5	75	49	18	40	H6FPDXHYDRO12
16	26	48	75	49	28	50	H6FPDXHYDRO16
20	30	52	75	49	30	52	H6FPDXHYDRO20

HSK63F SHRINK-FIT

RH
LH



Advantages:

- Highest quality of fixing provides evenly work all knives together
- Lack of collets and fixing nuts are minimizing vibrations
- The power of clamp around 1300 Nm

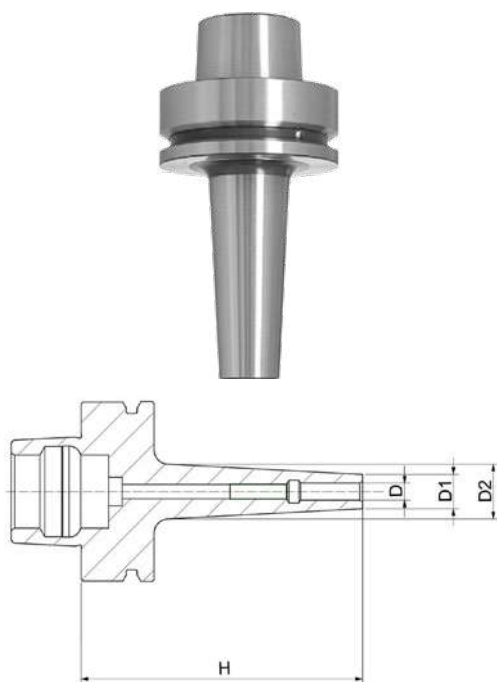
Application:

SHRINK-FIT tool holders provide high clamping force and excellent concentricity, which ensures vibration-free machining, precise cutting performance, and longer tool. Slimlim and balanced design also makes them ideal for hard-to-reach areas. To perform the tool replacement independently, dedicated equipment is required.

FIXING	D mm	D ¹ mm	D ² mm	H mm	ROTATION	ARTICLE
HSK63F	6	21	29	76	RH/LH	H6FPDXTH06
HSK63F	8	21	29	76	RH/LH	H6FPDXTH008
HSK63F	10	24	32	76	RH/LH	H6FPDXTH10
HSK63F	12	24	32	76	RH/LH	H6FPDXTH12
HSK63F	16	27	34	76	RH/LH	H6FPDXTH16
HSK63F	20	33	42	76	RH/LH	H6FPDXTH020
HSK63F	25	44	53	76	RH/LH	H6FPDXTH025

Chuck SHRINK-FIT SLIM extended body for CNC machines

H6FPDX SHRINK-FIT SLIM



RH

LH

Advantages:

- Highest quality of fixing provides evenly work all knives together
- Lack of collets and fixing nuts are minimizing vibrations
- The power of clamp around 1300 Nm

Application:

SHRINK-FIT tool holders provide high clamping force and excellent concentricity, which ensures vibration-free machining, precise cutting performance, and longer tool life. To perform the tool replacement independently, dedicated equipment is required.

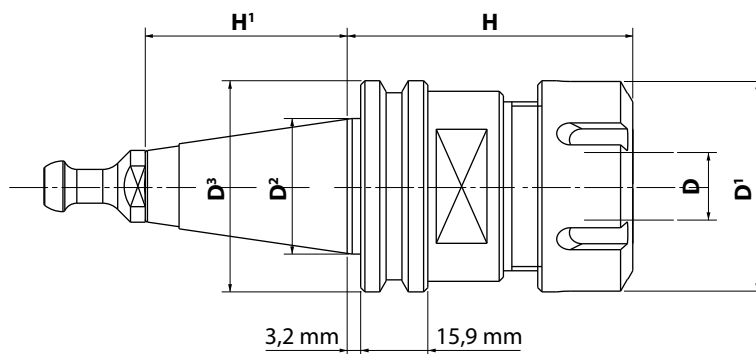
FIXING	D ¹ mm	D ² mm	D ³ mm	H mm	ROTATION	ARTICLE
HSK63F	6	12	19,3	100	RH/LH	H6FPDXTH06.A100M
HSK63F	6	12	24,8	150	RH/LH	H6FPDXTH06.A150M
HSK63F	6	12	29,7	200	RH/LH	H6FPDXTH06.A200M
HSK63F	8	21	28,3	100	RH/LH	H6FPDXTH08.A100M
HSK63F	8	21	33,5	150	RH/LH	H6FPDXTH08.A150M
HSK63F	8	21	38,7	200	RH/LH	H6FPDXTH08.A200M
HSK63F	10	16	23,2	100	RH/LH	H6FPDXTH10.A100M
HSK63F	10	16	28,5	150	RH/LH	H6FPDXTH10.A150M
HSK63F	10	16	33,7	200	RH/LH	H6FPDXTH10.A200M
HSK63F	12	18	25,3	100	RH/LH	H6FPDXTH12.A100M
HSK63F	12	18	30,5	150	RH/LH	H6FPDXTH12.A150M
HSK63F	12	18	35,7	200	RH/LH	H6FPDXTH12.A200M
HSK63F	16	22	29,26	100	RH/LH	H6FPDXTH16.A100M
HSK63F	16	22	34,2	150	RH/LH	H6FPDXTH16.A150M
HSK63F	16	22	35	200	RH/LH	H6FPDXTH16.A200M
HSK63F	20	26	32,9	100	RH/LH	H6FPDXTH20.A100M
HSK63F	20	26	38,2	150	RH/LH	H6FPDXTH20.A150M
HSK63F	20	26	43,5	200	RH/LH	H6FPDXTH20.A200M
HSK63F	25	31	38,56	100	RH/LH	H6FPDXTH25.A100M
HSK63F	25	31	43,7	150	RH/LH	H6FPDXTH25.A150M
HSK63F	25	31	46	200	RH/LH	H6FPDXTH25.A200M

Chuck ISO-30 for CNC machines

ISO30
DIN 69871

RH

LH



Application:

For CNC machines: BIESSE®, COSMEC®, MASTERWOOD®.

FIXING	COLLET	D mm		D ¹ mm	D ² mm	D ³ mm	H mm	H ¹ mm	ROTATION	ARTICLE
		min.	max.							
ISO 30	ER32	3	20	50	31,75	50	50	47,8	RH	B30PDX20
ISO 30	ER32	3	20	50	31,75	50	50	47,8	RH	B30PDX20N
ISO 30	ER40	4	30	63	31,75	50	57	47,8	RH	B30PDX26

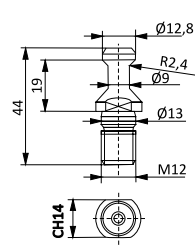
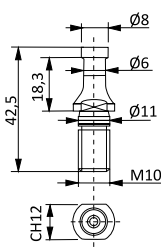
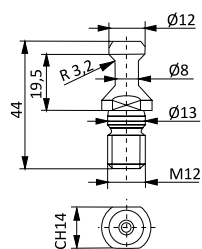
Application:

For CNC machines: MORBIDELLI®, EIMA®, DUBUS®, WEEKE®.

FIXING	COLLET	D mm		D ¹ mm	D ² mm	D ³ mm	H mm	H ¹ mm	ROTATION	ARTICLE
		min.	max.							
ISO 30	ER32	3	20	50	31,75	50	68	47,8	RH	I30PDX20
ISO 30	ER32	3	20	50	31,75	50	68	47,8	LH	I30PSX20
ISO 30	ER40	4	30	63	31,75	50	68	47,8	RH	I30PDX26
ISO 30	ER40	4	30	63	31,75	50	68	47,8	LH	I30PSX26
ISO 30	EOC25	2	25	60	31,75	50	70	47,8	RH	I30PDX25
ISO 30	EOC25	2	25	60	31,75	50	70	47,8	LH	I30PSX25

CDM/930

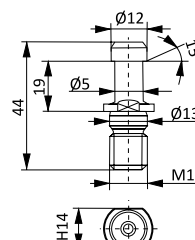
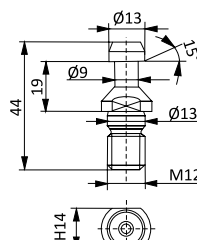
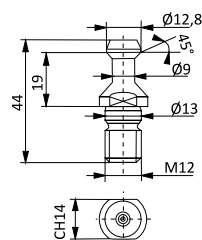
Pull Studs for ISO Chucks



MACHINE TYPE	ARTICLE
BIESSE®, MASTERWOOD®, COSMEC®, ELETTROMANDRINI HSD®	CDM12BIE

MACHINE TYPE	ARTICLE
SCM®, MORBIDELLI®	CDM10SCM

MACHINE TYPE	ARTICLE
CMS®	CDM12CMS



MACHINE TYPE	ARTICLE
ALBERTI®, MASTERWOOD®, ELETTROMANDRINI G®, COLOMBO®	CDM12ALB

MACHINE TYPE	ARTICLE
IMA®, MAKI®, WEEKE®, BULLERI®, REICHENBACHER®, BUSELLATO®, ESSETEAM®, ELETTROMANDRINI ELTE®	CDM10SCM

MACHINE TYPE	ARTICLE
ISO30DIN 7388/2A	930TIR11

HSK.63F/ISO.30

Universal Assembly Supports for Chucks



INFO	D mm	ARTICLE
Universal assembly supports for chucks HSK-F63	63	HSK.63F.Support
Universal assembly support for chucks ISO30	50	ISO.30.Support

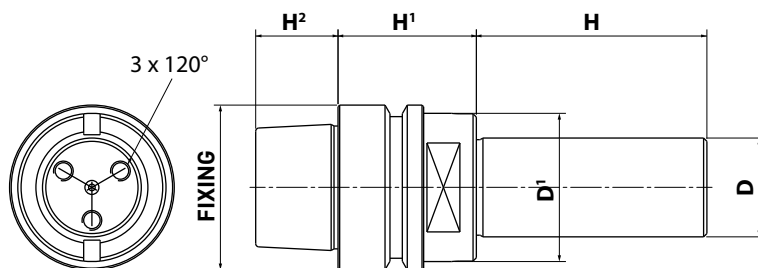
Application:

Universal assembly supports for HSK-63F and ISO30 chucks.

Thanks to the bi-directional roller bearings, which clamp the left-hand rotation to the flange, the system offers the highest protection to the tool taper and clamps are no longer needed.

HSK63F DIN 69893

RH
LH



Application:

For machines type: BIESSE, EIMA, HOMAG, SCM, IMA (from 9/94), WEEKE, DUBUS, BUSELLATO, MASTERWOOD®.

FIXING	D mm	D' mm	H mm	H' mm	H² mm	ARTICLE
HSK63F	30	45	70	42	25	H6FAPF30.70
HSK63F	30	45	80	42	25	H6FAPF30.80
HSK63F	30	45	100	42	25	H6FAPF30.100
HSK63F	30	45	150	42	25	H6FAPF30.150

Spacer rings:

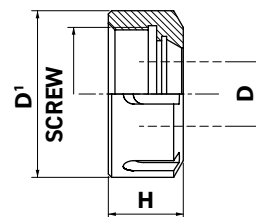
D mm	F mm	I mm	ARTICLE
50	30	0,2	TUL.50.30.002
50	30	0,5	TUL.50.30.005
50	30	1	TUL.50.30.01
50	30	2	TUL.50.30.02
50	30	3	TUL.50.30.03
50	30	5	TUL.50.30.05
50	30	6	TUL.50.30.06

Extension for Precision Collets



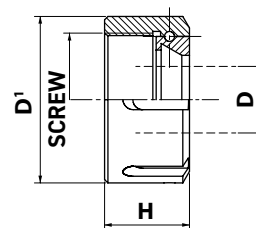
FIXING	D mm	L mm	ARTICLE
ER32	20	160	183.ER32.S20.160
ER25M	25	160	183.ER25.S25.L160
ER25M	20	200	183.ER25.S20.L200
ER25M	20	160	183.ER25.S20.L160
ER25M	20	100	183.ER25.S20.L100
ER20	20	160	183.ER20.S20.L160
ER16M	25	130	183.ER16.S25.L130
ER16M	25	100	183.ER16.S25.L100
ER16M	20	270	183.ER16.S20.L270
ER16M	20	200	183.ER16.S20.L200
ER16M	20	160	183.ER16.S20.L160
ER16M	16	130	183.ER16.S16.L130
ER16M	16	100	183.ER16.S16.L100
ER11M	16	160	183.ER11.S16.L160
ER11M	16	130	183.ER11.S16.L130

Fixing Nuts for Chucks ISO/ HSK Standard DIN 6499



COLLET	D mm		D ¹ mm	H mm	SCREW	ROTATION	ARTICLE
	min.	max.					
ER32	3	20	50	22,5	M40x1,5	RH	932GHCOD
ER32	3	20	50	22,5	M40x1,5	LH	932GHCOS

Fixing Nuts for Chucks ISO/ HSK with bearing



COLLET	D mm		D ¹ mm	H mm	SCREW	ROTATION	ARTICLE
	min.	max.					
ER32	3	3	50	26	M40x1,5	RH	932GHRSD
ER32	3	3	50	26	M40x1,5	LH	932GHRSS

Precision Collets

EOC16 DIN6388



L mm	D mm	F mm	ARTICLE
40	25,5	2	EOC16D02
40	25,5	3	EOC16D03
40	25,5	4	EOC16D04
40	25,5	5	EOC16D05
40	25,5	6	EOC16D06
40	25,5	7	EOC16D07
40	25,5	8	EOC16D08
40	25,5	10	EOC16D10
40	25,5	12	EOC16D12
40	25,5	14	EOC16D14
40	25,5	16	EOC16D16

EOC25 DIN6388



L mm	D mm	F mm	ARTICLE
52	35	3	EOC25D03
52	35	6	EOC25D06
52	35	8	EOC25D08
52	35	10	EOC25D10
52	35	12	EOC25D12
52	35	16	EOC25D16
52	35	20	EOC25D20
52	35	25	EOC25D25

ER11 DIN6499



L mm	D mm	F mm	ARTICLE
18	11,5	2	ER11D02
18	11,5	3	ER11D03
18	11,5	4	ER11D04
18	11,5	5	ER11D05
18	11,5	6	ER11D06

ER16 DIN6499



L mm	D mm	F mm	ARTICLE
28	17	2	ER16D02
28	17	3	ER16D03
28	17	4	ER16D04
28	17	5	ER16D05
28	17	6	ER16D06
28	17	7	ER16D07
28	17	8	ER16D08
28	17	9	ER16D09
28	17	10	ER16D10

Precision Collets

ER20

DIN6499



L mm	D mm	F mm	ARTICLE
32	21	2	ER20D02
32	21	3	ER20D03
32	21	4	ER20D04
32	21	5	ER20D05
32	21	6	ER20D06
32	21	7	ER20D07
32	21	8	ER20D08
32	21	9	ER20D09
32	21	10	ER20D10
32	21	11	ER20D11
32	21	12	ER20D12
32	21	13	ER20D13

PCD & HM TOOLS

SOLID CARBIDE
ROUTER BITS

PCD & VHM TOOLS FOR
COMPOSITES

ER25

DIN6499



L mm	D mm	F mm	ARTICLE
34	26	10	ER25D10
34	26	12	ER25D12
34	26	16	ER25D16

CHUCKS
& ACCESSORIES

TOOLS FOR EDGEBANDING
MACHINES

ER32

DIN6499



L mm	D mm	F mm	ARTICLE
40	33	3	ER32D03
40	33	4	ER32D04
40	33	6	ER32D06
40	33	8	ER32D08
40	33	10	ER32D10
40	33	12	ER32D12
40	33	14	ER32D14
40	33	16	ER32D16
40	33	20	ER32D20

CIRCULAR SAW BLADES

DRILL BITS

STRAIGHT
& SYSTEM KNIVES

ER40

DIN6499



L mm	D mm	F mm	ARTICLE
46	41	6	ER40D06
46	41	10	ER40D10
46	41	12	ER40D12
46	41	20	ER40D20
46	41	25	ER40D25

STARTER KITS

Chucks for CNC machines

HSK63F SBA.H6F



RH
LH

Advantages:

- High precision, extreme reliability and perfect tool centering
- Made of very high strength special steel, precision ground on all mating surfaces
- Very high transmissible power

Application:

Precise HSK Chuck for grooving blade specifically designed for right or left-hand rotation with self-locking antagonist threads.

FIXING	D mm	B mm	L mm	PH	ARTICLE	MAX SAW BLADE DIAMETER mm
HSK63F	59	30	78	4/M6/48	SBA.H6F.30.250	250
HSK63F	98	30	94	6/M6/80	SBA.H6F.30.300	300
HSK63F	110	30	40	6/M6/80	SBA.H6F.30.350	350

SBA.S20

Saw Blade Arbor with Parallel Shank

RH

LH



Advantages:

- Extreme precision and reliability
- Perfect tool centering and defect-free rotation
- Made from extremely high resistant steel
- Precision grinding on all jointed parts
- Extreme high rotation performance > 15 HP – 20.000 RPM
- For very efficient sizing on extreme unprecedented high feed speed
- Excellent finishing quality on the workpiece and longer tool life
- Sturdy design with reduced height to increase the work space between the machine and the piece.
- Interchangeable collet clamps with radial grooves for secure parallel tool clamping and wide clamping tolerance (-0.7mm)

Application:

Saw blade arbor with parallel shank for machining centres, point-to-point machines and CNC routers.

Safety tips:

The TW-006 TORQUE SCREWDRIVER is recommended for the proper fastening of screws.

S mm	D mm	B mm	L mm	PH	ARTICLE	MAX SAW BLADE DIAMETER mm
20	59	30	97,5	4/M6/48	SBA.S20.30.250	250

Spare parts:

990.116.00 – SCREWS M6x8.7x12 TSPEI

991.064.00 – SPANNER 4mm

Spanners

991 CNC Spanners



INFO	W	ARTICLE
C-SPANNERS	45 – 50	991.123.00
C-SPANNERS	58 – 62 – 65	991.283.00

993/940 CNC Spanners



ER/ETS	ARTICLE
32	932CHVST
40	940CHVST

925 CNC Spanners



EOC	ARTICLE
25	925CHVOC

940 Dynamometric spanners



MOCOWANIE	ARTICLE
ER40/ETS	940CHVST.DYN
ER32/ETS	932CHVST.DYN
ER25/ETC	925CHVST.DYN
EOC25	925CHVOC.DYN.M

I30.CNC.BIE Tool Holder Clamp CNC



Application:

Tool holder clamp for BIESSE machines.

INFO	ARTICLE
Tool Holder Clamp SK30 BIESSE machines	I30.CNC.BIE

DUST

Kinetic Dust Extractor with Precision Collets



RH

Advantages:

- Fixing collet made of steel
- The unique arrangement and geometry of the blades cause the chip to be thrown upwards directly into the extraction unit
- The shape of the blades reduces the noise generated during operation
- Very easy to use
- Increases tool life and reduces production costs
- Recommended for nesting and routing operations
- Replaces the standard clamping nut
- Suitable for any collet chucks with standard router bits
- Available for: ER32, ER40, EOC25 collets

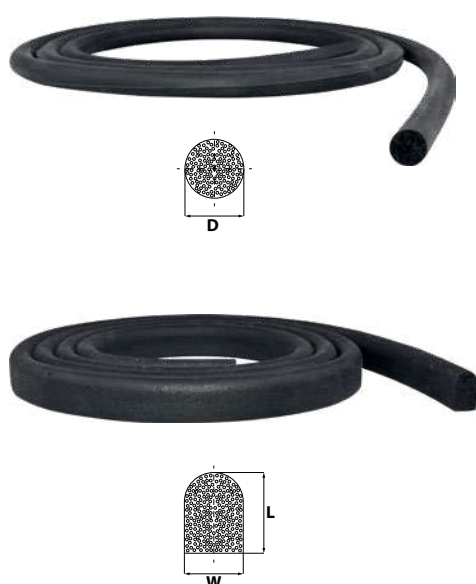
INFO	ARTICLE
Kinetic dust extractor – collet EOC25	EOC25.DUST
Kinetic dust extractor – collet ER40	ER40.DUST
Kinetic dust extractor – collet ER32	ER32.DUST

Spare parts:

WR.DUST – CNC SPANNER

EPDM

Rope of Cellular Rubber Round



Application:

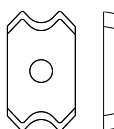
For template production, sealing grid tables, seals in machines with console tables.

D mm	ARTICLE
6	EPDM06
7	EPDM07
8	EPDM08

W x L mm	ARTICLE
6 x 10	EPDM6X10
6 x 8	EPDM6X8
6 x 10	EPDM6X10

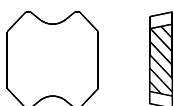
Knives for Edgebanding Machines

PCD & HM TOOLS



L mm	W mm	T mm	R	MACHINE	ARTICLE
20,0	12,0	2,0	1,0	SCM®, FELDER®, BRANDT®, HOLZ-HER®, IMA®, HOMAG®	K15.20122R01
20,0	12,0	2,0	1,5		K15.20122R01s
20,0	12,0	2,0	2,0		K15.20122R02
20,0	12,0	2,0	3,0		K15.20122R03

SOLID CARBIDE
ROUTER BITS



L mm	W mm	T mm	R	MACHINE	ARTICLE
12,7	12,7	3,0	2	SCM®, BIESSE®	K13.12123R02
12,7	12,7	3,18	1,5	SCM®	K13.12123R15
12,7	12,7	3,18	1	SCM®	K13.12123R01

PCD & VHM TOOLS FOR
COMPOSITES



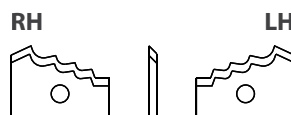
L mm	W mm	T mm	R	MACHINE	ARTICLE RH	ARTICLE LH
22,32	14,0	2,0	2,0	BRANDT®	K25.22142R02R	K25.22142R02L
22,32	14,0	2,0	2,5	BRANDT®	K25.22142R02Rs	K25.22142R02Ls
22,32	14,0	2,0	3,0	BRANDT®	K25.22142R03R	K25.22142R03L

CHUCKS
& ACCESSORIES



L mm	W mm	T mm	R	MACHINE	ARTICLE RH	ARTICLE LH
16,00	17,0	2,0	2,0	FELDER® G200	KKC.16172.1R2RS	KKC.16172.1R2LS
16,00	17,0	2,0	2,0	FELDER® G500	KKC.16172.2R2RS	KKC.16172.2R2LS
16,00	17,0	2,0	2,0	FELDER® G400 / G560	KKC.16172.3R2RS	KKC.16172.3R2LS
16,00	17,0	2,0	2,0	FELDER® G360	KKC.16172.R02R	KKC.16172.R02L
16,30	16,3	2,0	2,0	FELDER® TEMPORA	K26.16162R02R	K26.16162R02L
18,00	16,0	2,0	2,0	FELDER® TEMPORA	K26.18162R02R	K26.18162R02L

TOOLS FOR EDGEBANDING
MACHINES



L mm	W mm	T mm	R	MACHINE	ARTICLE RH	ARTICLE LH
25,00	18,7	2,0	1,5 / 2,0 / 3,0	BIESSE®	KKG.25182.R	KKG.25182.L
25,00	18,7	2,0	1,0 / 1,5 / 2,0	BIESSE®	KKG.25182.R1	KKG.25182.L1
25,00	19,0	2,0	1,0 / 1,5 / 2,0	BIESSE®	KKG.251902.MPR	KKG.251902.MPL

CIRCULAR SAW BLADES

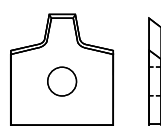


L mm	W mm	T mm	R	MACHINE	ARTICLE RH	ARTICLE LH
16,0	17,5	2,0	2,0	FELDER®	KKJ.16172.R02R	KKJ.16172.R02L
12,7	12,7	2,0	1,0/2,0	SCM®	KKN.121202.R1R2R	KKN.121202.R1R2L

DRILL BITS

L mm	W mm	T mm	R	MACHINE	ARTICLE RH	ARTICLE LH
18,0	16,0	2,0	2,0	FELDER® TEMPORA	KPR.18.16.02R	KPR.18.16.02L

STRAIGHT
& SYSTEM KNIVES



L mm	W mm	T mm	R	MACHINE	ARTICLE
16,0	14,0	2,0	1,0	SCM® STEFANI	KKE.16142.D01
16,0	14,0	2,0	2,0	SCM® STEFANI	KKE.16142.D02
16,0	15,0	2,0	1,0	SCM® STEFANI EVO	K23.16152R01
16,0	16,0	2,0	1,5	BIESSE®	K01.161602.R15
16,0	16,0	2,0	2,0	BIESSE®	K01.161602.R2
16,0	13,5	2,0	2,0	BIMATIC®	K161352
16,0	14,0	2,0	3,0	BIMATIC®	K161403

STARTER KITS



DRILLING PROCESS





BBXV series

p. 206



TBV2 series

p. 207



BBV5, BBV6 series

p. 208



BBX5, BBX6 series

p. 209



TBX2 series

p. 210



BBH3 series

p. 211



BBH5 series

p. 212



BBH4 series

p. 213



BBH6 series

p. 214



BBH7 series

p. 215



BBH8, BBH9 series

p. 216



BBH1, BBH2 series

p. 217



TBH1, TBH2 series

p. 218



TBH3, TBH5 series

p. 219



Countersinks BBC1, BBC2 series

p. 220



HBX1, HBX2 series

p. 221



HBH1 series

p. 222



HBH2 series

p. 223



DWA, DWB series

p. 224

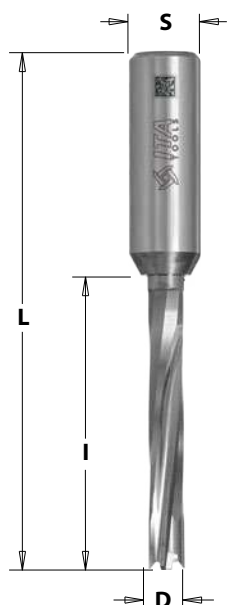


Adapters

p. 225



BBXV



VHM

Z2

V2

RH

LH

Technical details:

- Premium quality super strength steel shank for improved resistance and durability
- Flute length in premium quality HWM
- 2 cutting edges [Z2] + 2 curved ground spurs [V2]
- 2 spiral flutes
- Parallel shank with driving flat and adjustable screw length
- Recommended feed speed $1 \div 4 \text{ m/minute}$ – RPM 6000

Application:

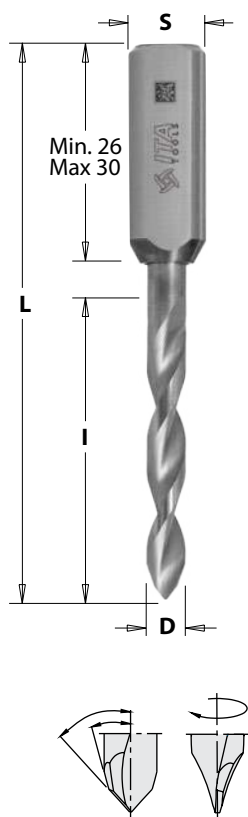
Ideal for chipboard, MDF, HDF and laminates. No center-point or spurs means perfect bores in low-thickness panels. For use on boring machines equipped with adaptors and/or with chucks.

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
5	30	70	10x27	BBXV.050.030.070.02R	BBXV.050.030.070.02L
6	30	70	10x27	BBXV.060.030.070.02R	BBXV.060.030.070.02L
7	30	70	10x27	BBXV.070.030.070.02R	BBXV.070.030.070.02L
8	30	70	10x24	BBXV.080.030.070.02R	BBXV.080.030.070.02L
10	30	70	10x26	BBXV.100.030.070.02R	BBXV.100.030.070.02L

Spare parts:

BBS1.M5.10	BBS1.M5.11

TBV2



VHM

Z2

RH

LH

Technical details:

- Premium quality super-strength steel shank
- High quality HWM body
- 2 precision ground cutting edges [Z2] - double angle
- 2 spiral flutes
- Parallel shank with driving flat and adjustable screw length

Application:

For drilling through holes in solid wood, wood derivatives and laminates.

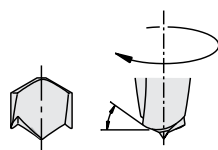
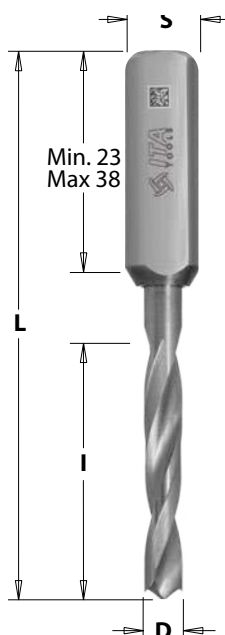
For use on boring machine centres equipped with adaptors and/or chucks.

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
3	27	70	10x30	TBV2.030.027.070.02R	TBV2.030.027.070.02L
4	35	70	10x26	TBV2.040.035.070.01R	TBV2.040.035.070.01L
5	35	70	10x26	TBV2.050.035.070.01R	TBV2.050.035.070.01L
6	35	70	10x26	TBV2.060.035.070.01R	TBV2.060.035.070.01L
8	35	70	10x26	TBV2.080.035.070.01R	TBV2.080.035.070.01L
10	35	70	10x27	TBV2.100.035.070.01R	TBV2.100.035.070.01L

Spare parts:

	
BBS1.M5.08	BBS1.M5.11

BBV5 | BBV6



VHM

Z2

V2

RH

LH

Technical details:

- Premium quality super-strength steel shank
- High quality HWM body
- Centre point
- 2 cutting edges [Z2]
- 2 spiral flutes
- 2 curved, negatively ground spurs [V2]
- Parallel shank with driving flat and adjustable screw length

Application:

For drilling blind holes in solid wood, wood derivatives and laminates.
For use on boring machines equipped with adaptors and/or with chucks.

BBV5

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
2	12	57,5	10x27	BBV5.020.012.057.01R	BBV5.020.012.057.01L
3	18	57,5	10x25	BBV5.030.018.057.01R	BBV5.030.018.057.01L
4	20	57,5	10x25	BBV5.040.020.057.01R	BBV5.040.020.057.01L
5	22	57,5	10x23	BBV5.050.022.057.01R	BBV5.050.022.057.01L
6	22	57,5	10x25	BBV5.060.022.057.01R	BBV5.060.022.057.01L
8	22	57,5	10x25	BBV5.080.022.057.01R	BBV5.080.022.057.01L
10	22	57,5	10x25	BBV5.100.022.057.01R	BBV5.100.022.057.01L

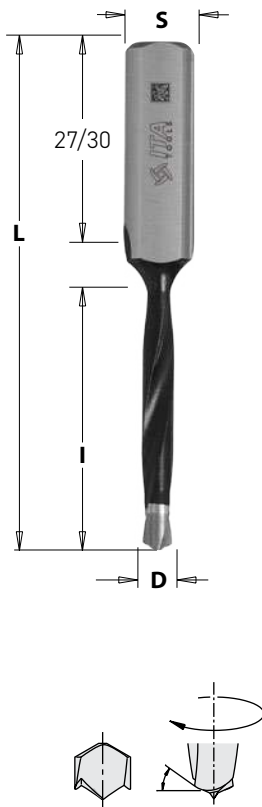
BBV6

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
2	12	70	10x39	BBV6.020.012.070.03R	BBV6.020.012.070.03L
3	18	70	10x38	BBV6.030.018.070.03R	BBV6.030.018.070.03L
4	27	70	10x30	BBV6.040.027.070.02R	BBV6.040.027.070.02L
5	30	70	10x28	BBV6.050.030.070.02R	BBV6.050.030.070.02L
6	30	70	10x29	BBV6.060.030.070.02R	BBV6.060.030.070.02L
8	35	70	10x22	BBV6.080.035.070.01R	BBV6.080.035.070.01L
10	35	70	10x25	BBV6.100.035.070.01R	BBV6.100.035.070.01L

Spare parts:

BBS1.M5.10	BBS1.M5.11

BBX5 | BBX6



HM

Z2

V2

RH

LH

Technical details:

- Premium quality super-strength steel
- Orange or black P.T.F.E. coating
- High quality extra-fine micrograin carbide body
- 2 cutting edges [Z2] - double angle
- 2 spiral flutes
- 2 curved, negatively ground spurs [V2]
- Parallel shank with driving flat and adjustable screw length

Application:

For drilling blind holes in solid wood, wood derivatives and laminates.
For use on boring machines equipped with adaptors and/or chucks.

BBX5

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
5	27	57,5	10x27	BBX5.050.027.057.01R	BBX5.050.027.057.01L
6	27	57,5	10x27	BBX5.060.027.057.01R	BBX5.060.027.057.01L
7	27	57,5	10x27	BBX5.070.027.057.01R	BBX5.070.027.057.01L
8	27	57,5	10x27	BBX5.080.027.057.01R	BBX5.080.027.057.01L
9	27	57,5	10x27	BBX5.090.027.057.01R	BBX5.090.027.057.01L
10	27	57,5	10x27	BBX5.100.027.057.01R	BBX5.100.027.057.01L

Spare parts:

	
BBS1.M5.10	BBS1.M5.11

BBX6

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
5	35	70	10x30	BBX6.050.035.070.02R	BBX6.050.035.070.02L
6	35	70	10x30	BBX6.060.035.070.02R	BBX6.060.035.070.02L
7	35	70	10x30	BBX6.070.035.070.02R	BBX6.070.035.070.02L
8	35	70	10x30	BBX6.080.035.070.02R	BBX6.080.035.070.02L
9	35	70	10x30	BBX6.090.035.070.02R	BBX6.090.035.070.02L
10	35	70	10x30	BBX6.100.035.070.02R	BBX6.100.035.070.02L

Spare parts:

	
BBS1.M5.10	BBS1.M5.11

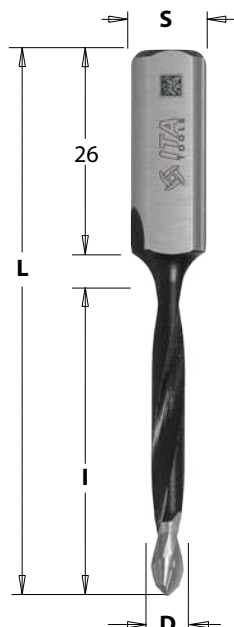
TBX2

HM

Z2

RH

LH



Technical details:

- Super-strength steel
- Spiral portion coated with orange or black P.T.F.E.
- Extra-fine micrograin carbide spiral portion with centre point
- HW head with precision balanced centre point
- 2 precision ground cutting edges [Z2]
- Double angle
- 2 spiral flutes
- Parallel shank with driving flat and length adjusting screw

Application:

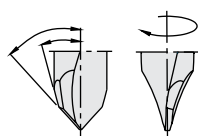
For drilling through holes in solid wood, wood derivatives and laminates.
For use on boring machines equipped with adaptors and/or chucks.

TBX2

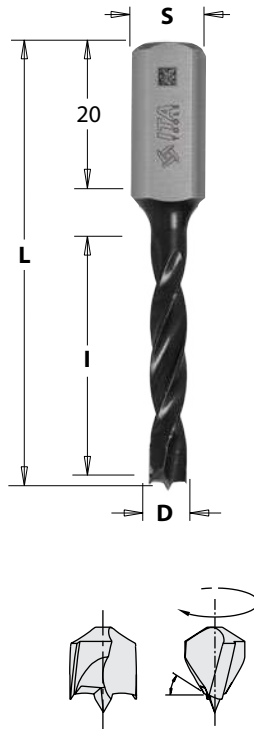
D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
5	35	70	10x26	TBX2.050.035.070.01R	TBX2.050.035.070.01L
6	35	70	10x26	TBX2.060.035.070.01R	TBX2.060.035.070.01L
7	35	70	10x26	TBX2.070.035.070.01R	TBX2.070.035.070.01L
8	35	70	10x26	TBX2.080.035.070.01R	TBX2.080.035.070.01L
10	35	70	10x26	TBX2.100.035.070.01R	TBX2.100.035.070.01L

Spare parts:

BBS1.M5.10	BBS1.M5.11



BBH3



HM

Z2

V2

RH

LH

Technical details:

- Super-strength steel
- Cutter portion coated with black or orange P.T.F.E.
- HW head with precision balanced centre point
- 2 HW precision ground cutting edges [Z2]
- Negatively ground spurs [V2]
- 4 spiral flutes
- Parallel shank with driving flat and length adjusting screw

Application:

Used on boring machines equipped with adapters or chucks.

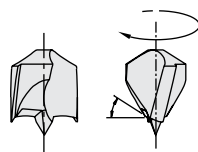
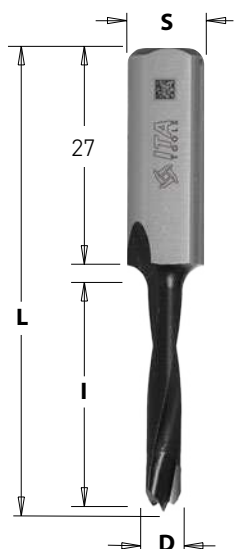
Used to drill blind holes in solid wood, wood composites, plastic and laminated materials.

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
4	27	57,5	10x20	BBH3.040.026.057.00R	BBH3.040.026.057.00L
5	27	57,5	10x20	BBH3.050.030.057.00R	BBH3.050.030.057.00L
6	27	57,5	10x20	BBH3.060.030.057.00R	BBH3.060.030.057.00L
6,4	27	57,5	10x20	BBH3.064.030.057.00R	BBH3.064.030.057.00L
7	27	57,5	10x20	BBH3.070.030.057.00R	BBH3.070.030.057.00L
8	27	57,5	10x20	BBH3.080.030.057.00R	BBH3.080.030.057.00L
9	27	57,5	10x20	BBH3.090.030.057.00R	BBH3.090.030.057.00L
9,5	27	57,5	10x20	BBH3.095.030.057.00R	BBH3.095.030.057.00L
10	27	57,5	10x20	BBH3.100.030.057.00R	BBH3.100.030.057.00L

Spare parts:

BBS1.M5.10	BBS1.M5.11

BBH5



HM

Z2

V2

RH

LH

Technical details:

- Super-strength steel
- Cutter portion coated with black or orange P.T.F.E.
- HW head with precision balanced centre point
- 2 HW precision ground cutting edges [Z2]
- Negatively ground spurs [V2]
- 2 spiral flutes
- Parallel shank with driving flat and length adjusting screw

Application:

Used on boring machines equipped with adapters or chucks.

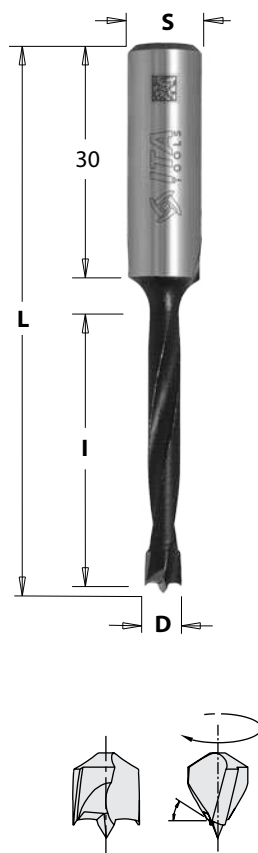
Used to drill blind holes in solid wood, wood composites, plastic and laminated materials.

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
4	27	57,5	10x27	BBH5.040.027.057.01R	BBH5.040.027.057.01L
4,5	27	57,5	10x27	BBH5.045.027.057.01R	BBH5.045.027.057.01L
4,7	27	57,5	10x27	BBH5.047.027.057.01R	BBH5.047.027.057.01L
5	27	57,5	10x27	BBH5.050.027.057.01R	BBH5.050.027.057.01L
5,1	27	57,5	10x27	BBH5.051.027.057.01R	BBH5.051.027.057.01L
5,2	27	57,5	10x27	BBH5.052.027.057.01R	BBH5.052.027.057.01L
5,5	27	57,5	10x27	BBH5.055.027.057.01R	BBH5.055.027.057.01L
6	27	57,5	10x27	BBH5.060.027.057.01R	BBH5.060.027.057.01L
6,4	27	57,5	10x27	BBH5.064.027.057.01R	BBH5.064.027.057.01L
6,5	27	57,5	10x27	BBH5.065.027.057.01R	BBH5.065.027.057.01L
7	27	57,5	10x27	BBH5.070.027.057.01R	BBH5.070.027.057.01L
8	27	57,5	10x27	BBH5.080.027.057.01R	BBH5.080.027.057.01L
8,2	27	57,5	10x27	BBH5.082.027.057.01R	BBH5.082.027.057.01L
9	27	57,5	10x27	BBH5.090.027.057.01R	BBH5.090.027.057.01L
9,5	27	57,5	10x27	BBH5.095.027.057.01R	BBH5.095.027.057.01L
10	27	57,5	10x27	BBH5.100.027.057.01R	BBH5.100.027.057.01L
11	27	57,5	10x27	BBH5.110.027.057.01R	BBH5.110.027.057.01L
12	27	57,5	10x27	BBH5.120.027.057.01R	BBH5.120.027.057.01L
12,7	27	57,5	10x27	BBH5.127.027.057.01R	BBH5.127.027.057.01L
13	27	57,5	10x27	BBH5.130.027.057.01R	BBH5.130.027.057.01L
14	27	57,5	10x27	BBH5.140.027.057.01R	BBH5.140.027.057.01L
15	27	57,5	10x27	BBH5.150.027.057.01R	BBH5.150.027.057.01L
16	27	57,5	10x27	BBH5.160.027.057.01R	BBH5.160.027.057.01L

Spare parts:

BBS1.M5.10	BBS1.M5.11

BBH4



HM

Z2

V2

RH

LH

Technical details:

- Super-strength steel
- Cutter portion coated with black or orange P.T.F.E.
- HW head with precision balanced centre point
- 2 HW precision ground cutting edges [Z2]
- Negatively ground spurs [V2]
- 4 spiral flutes
- Parallel shank with driving flat and length adjusting screw

Application:

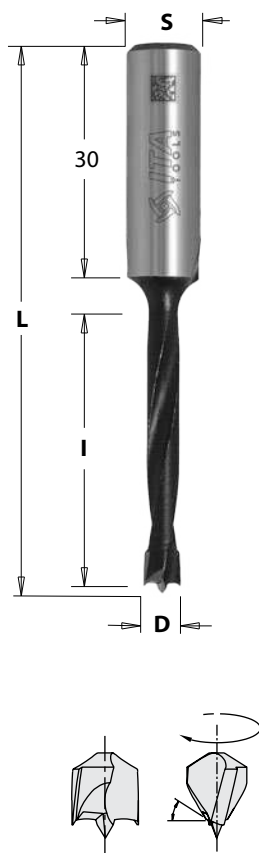
Used on boring machines equipped with adapters or chucks.
Used to drill blind holes in solid wood, wood composites, plastic and laminated materials.

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
4	43	70	10x20	BBH4.040.043.070.00R	BBH4.040.043.070.00L
5	43	70	10x20	BBH4.050.043.070.00R	BBH4.050.043.070.00L
6	43	70	10x20	BBH4.060.043.070.00R	BBH4.060.043.070.00L
6,4	43	70	10x20	BBH4.064.043.070.00R	BBH4.064.043.070.00L
7	43	70	10x20	BBH4.070.043.070.00R	BBH4.070.043.070.00L
7,5	43	70	10x20	BBH4.075.043.070.00R	BBH4.075.043.070.00L
8	43	70	10x20	BBH4.080.043.070.00R	BBH4.080.043.070.00L
9	43	70	10x20	BBH4.090.043.070.00R	BBH4.090.043.070.00L
9,5	43	70	10x20	BBH4.095.043.070.00R	BBH4.095.043.070.00L
10	43	70	10x20	BBH4.100.043.070.00R	BBH4.100.043.070.00L
11	43	70	10x20	BBH4.110.043.070.00R	BBH4.110.043.070.00L
12	43	70	10x20	BBH4.120.043.070.00R	BBH4.120.043.070.00L
12,7	43	70	10x20	BBH4.127.043.070.00R	BBH4.127.043.070.00L
13	43	70	10x20	BBH4.130.043.070.00R	BBH4.130.043.070.00L
14	43	70	10x20	BBH4.140.043.070.00R	BBH4.140.043.070.00L
15	43	70	10x20	BBH4.150.043.070.00R	BBH4.150.043.070.00L
16	43	70	10x20	BBH4.160.043.070.00R	BBH4.160.043.070.00L

Spare parts:

BBS1.M5.10	BBS1.M5.11

BBH6



HM

Z2

V2

RH

LH

Technical details:

- Super-strength steel
- Cutter portion coated with black or orange P.T.F.E.
- HW head with precision balanced centre point
- 2 HW precision ground cutting edges [Z2]
- Negatively ground spurs [V2]
- 2 spiral flutes
- Parallel shank with driving flat and length adjusting screw

Application:

Used on boring machines equipped with adapters or chucks.

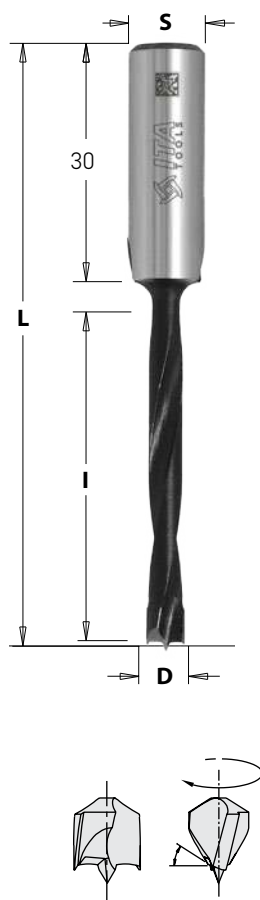
Used to drill blind holes in solid wood, wood composites, plastic and laminated materials.

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
4	35	70	10x30	BBH6.040.035.070.02R	BBH6.040.035.070.02L
4,5	35	70	10x30	BBH6.045.035.070.02R	BBH6.045.035.070.02L
4,7	35	70	10x30	BBH6.047.035.070.02R	BBH6.047.035.070.02L
5	35	70	10x30	BBH6.050.035.070.02R	BBH6.050.035.070.02L
5,1	35	70	10x30	BBH6.051.035.070.02R	BBH6.051.035.070.02L
5,2	35	70	10x30	BBH6.052.035.070.02R	BBH6.052.035.070.02L
5,5	35	70	10x30	BBH6.055.035.070.02R	BBH6.055.035.070.02L
6	35	70	10x30	BBH6.060.035.070.02R	BBH6.060.035.070.02L
6,4	35	70	10x30	BBH6.064.035.070.02R	BBH6.064.035.070.02L
6,5	35	70	10x30	BBH6.065.035.070.02R	BBH6.065.035.070.02L
7	35	70	10x30	BBH6.070.035.070.02R	BBH6.070.035.070.02L
8	35	70	10x30	BBH6.080.035.070.02R	BBH6.080.035.070.02L
8,2	35	70	10x30	BBH6.082.035.070.02R	BBH6.082.035.070.02L
9	35	70	10x30	BBH6.090.035.070.02R	BBH6.090.035.070.02L
9,5	35	70	10x30	BBH6.095.035.070.02R	BBH6.095.035.070.02L
10	35	70	10x30	BBH6.100.035.070.02R	BBH6.100.035.070.02L
11	35	70	10x30	BBH6.110.035.070.02R	BBH6.110.035.070.02L
11,1	35	70	10x30	BBH6.111.035.070.02R	BBH6.111.035.070.02L
12	35	70	10x30	BBH6.120.035.070.02R	BBH6.120.035.070.02L
12,7	35	70	10x30	BBH6.127.035.070.02R	BBH6.127.035.070.02L
13	35	70	10x30	BBH6.130.035.070.02R	BBH6.130.035.070.02L
14	35	70	10x30	BBH6.140.035.070.02R	BBH6.140.035.070.02L
15	35	70	10x30	BBH6.150.035.070.02R	BBH6.150.035.070.02L
16	35	70	10x30	BBH6.160.035.070.02R	BBH6.160.035.070.02L

Spare parts:

BBS1.M5.10	BBS1.M5.11

BBH7



HM

Z2

V2

RH

LH

Technical details:

- Super-strength steel
- Spiral portion coated with orange or black P.T.F.E.
- HW head with precision balanced centre point
- 2 HW precision ground cutting edges [Z2]
- 2 negatively ground spurs [V2]
- 2 spiral flutes
- Parallel shank with driving flat and length adjusting screw

Application:

Used on boring machines equipped with adapters or chucks.

Used to drill blind holes in solid wood, wood composites, plastic and laminated materials.

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
5	44	77	10x30	BBH7.050.044.077.02R	BBH7.050.044.077.02L
6	44	77	10x30	BBH7.060.044.077.02R	BBH7.060.044.077.02L
7	44	77	10x30	BBH7.070.044.077.02R	BBH7.070.044.077.02L
8	44	77	10x30	BBH7.080.044.077.02R	BBH7.080.044.077.02L
10	44	77	10x30	BBH7.100.044.077.02R	BBH7.100.044.077.02L
12	44	77	10x30	BBH7.120.044.077.02R	BBH7.120.044.077.02L

Spare parts:

BBS1.M5.10	BBS1.M5.11

4 Flute Dowel Drills

BBH8 | BBH9



HM

Z2

V2

RH

LH

Technical details:

- Super-strength steel
- Cutter portion coated with black or orange P.T.F.E.
- HW head with precision balanced centre point
- 2 HW precision ground cutting edges [Z2]
- Negatively ground spurs [V2]
- 4 spiral flutes
- Parallel shank with driving flat and length adjusting screw

Application:

Used on boring machines equipped with adapters or chucks.

Used to drill blind holes in solid wood, wood composites, plastic and laminated materials.

BBH8

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
5	65	105	10x30	BBH8.050.065.105.12R	BBH8.050.065.105.12L
6	65	105	10x30	BBH8.060.065.105.12R	BBH8.060.065.105.12L
7	65	105	10x30	BBH8.070.065.105.12R	BBH8.070.065.105.12L
8	65	105	10x30	BBH8.080.065.105.12R	BBH8.080.065.105.12L
10	65	105	10x30	BBH8.100.065.105.12R	BBH8.100.065.105.12L
12	65	105	10x30	BBH8.120.065.105.12R	BBH8.120.065.105.12L

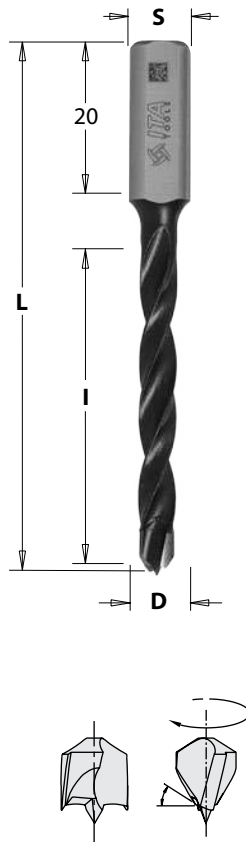
BBH9

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
5	50	85	10x27	BBH9.050.050.085.11R	BBH9.050.050.085.11L
6	50	85	10x27	BBH9.060.050.085.11R	BBH9.060.050.085.11L
7	50	85	10x27	BBH9.070.050.085.11R	BBH9.070.050.085.11L
8	50	85	10x27	BBH9.080.050.085.11R	BBH9.080.050.085.11L
10	50	85	10x27	BBH9.100.050.085.11R	BBH9.100.050.085.11L
12	50	85	10x27	BBH9.120.050.085.11R	BBH9.120.050.085.11L

Spare parts:

BBS1.M5.10	BBS1.M5.11

BBH1 | BBH2



HM

Z2

V2

RH

LH

Technical details:

- Super-strength steel
- Cutter portion coated with black or orange P.T.F.E.
- HW head with precision balanced centre point
- 2 HW precision ground cutting edges [Z2]
- Negatively ground spurs [V2]
- 4 spiral flutes
- Parallel shank with driving flat and length adjusting screw

Application:

Used on boring machines equipped with adapters or chucks.

Used to drill blind holes in solid wood, wood composites, plastic and laminated materials.

BBH1

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
5	30	55,5	8x20	BBH1.050.030.055.14R	BBH1.050.030.055.14L
5,5	30	55,5	8x20	BBH1.055.030.055.14R	BBH1.055.030.055.14L
6	30	55,5	8x20	BBH1.060.030.055.14R	BBH1.060.030.055.14L
6,4	30	55,5	8x20	BBH1.064.030.055.14R	BBH1.064.030.055.14L
7	30	55,5	8x20	BBH1.070.030.055.14R	BBH1.070.030.055.14L
8	30	55,5	8x20	BBH1.080.030.055.14R	BBH1.080.030.055.14L
9	30	55,5	8x20	BBH1.090.030.055.14R	BBH1.090.030.055.14L
10	30	55,5	8x20	BBH1.100.030.055.14R	BBH1.100.030.055.14L
12	30	55,5	8x20	BBH1.120.030.055.14R	BBH1.120.030.055.14L

BBH2

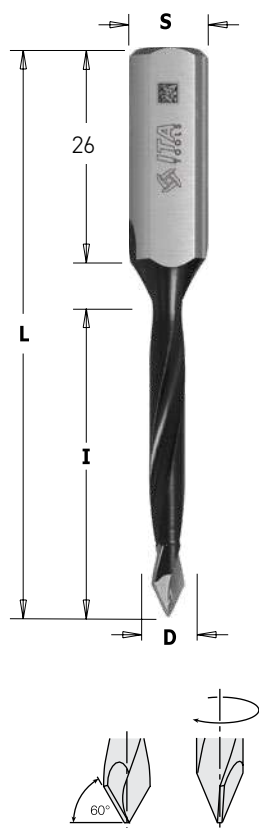
D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
5	40	67	8x20	BBH2.050.040.067.14R	BBH2.050.040.067.14L
5,5	40	67	8x20	BBH2.055.040.067.14R	BBH2.055.040.067.14L
6	40	67	8x20	BBH2.060.040.067.14R	BBH2.060.040.067.14L
6,4	40	67	8x20	BBH2.064.040.067.14R	BBH2.064.040.067.14L
7	40	67	8x20	BBH2.070.040.067.14R	BBH2.070.040.067.14L
8	40	67	8x20	BBH2.080.040.067.14R	BBH2.080.040.067.14L
9	40	67	8x20	BBH2.090.040.067.14R	BBH2.090.040.067.14L
10	40	67	8x20	BBH2.100.040.067.14R	BBH2.100.040.067.14L
12	40	67	8x20	BBH2.120.040.067.14R	BBH2.120.040.067.14L

Spare parts:

	
BBS1.M5.10	BBS1.M5.11

2 Flute Dowel Drills for Through Holes

TBH1 | TBH2



HM

Z2

RH

LH

Technical details:

- Super-strength steel
- Spiral portion coated with orange or black P.T.F.E.
- HW head with precision balanced centre point
- 2 precision ground cutting edges [Z2]
- 2 spiral flutes
- Parallel shank with driving flat and length adjusting screw

Application:

Used on boring machines and dowel drilling devices.

Use for drilling through holes in solid wood, wood composites, plastic and laminated materials.

TBH1

for panels with maximum **20 mm** in thickness

D mm	I mm	L mm	S mm	ARTICLE RH	ARTICLE LH
5	27	57,5	10x26	TBH1.050.027.057.01R	TBH1.050.027.057.01L
6	27	57,5	10x26	TBH1.060.027.057.01R	TBH1.060.027.057.01L
8	27	57,5	10x26	TBH1.080.027.057.01R	TBH1.080.027.057.01L
10	27	57,5	10x26	TBH1.100.027.057.01R	TBH1.100.027.057.01L

TBH2

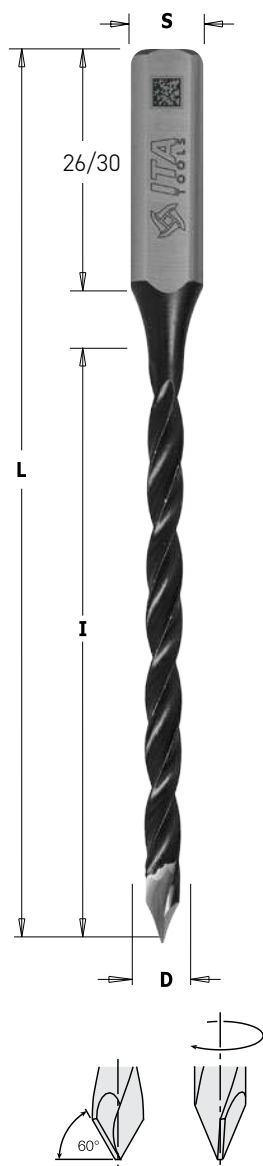
for panels with maximum **25-30 mm** in thickness

D mm	I mm	L mm	S mm	ARTICLE RH	ARTICLE LH
4	30	70	10x26	TBH2.040.030.070.01R	TBH2.040.030.070.01L
4,7	35	70	10x26	TBH2.047.030.070.01R	TBH2.047.030.070.01L
5	35	70	10x26	TBH2.050.030.070.01R	TBH2.050.030.070.01L
5,5	35	70	10x26	TBH2.055.030.070.01R	TBH2.055.030.070.01L
6	35	70	10x26	TBH2.060.030.070.01R	TBH2.060.030.070.01L
6,4	35	70	10x26	TBH2.064.030.070.01R	TBH2.064.030.070.01L
7	35	70	10x26	TBH2.070.030.070.01R	TBH2.070.030.070.01L
8	35	70	10x26	TBH2.080.030.070.01R	TBH2.080.030.070.01L
9	35	70	10x26	TBH2.090.030.070.01R	TBH2.090.030.070.01L
9,5	35	70	10x26	TBH2.095.030.070.01R	TBH2.095.030.070.01L
10	35	70	10x26	TBH2.100.030.070.01R	TBH2.100.030.070.01L
12	35	70	10x26	TBH2.120.030.070.01R	TBH2.120.030.070.01L
12,7	35	70	10x26	TBH2.127.030.070.01R	TBH2.127.030.070.01L

Spare parts:

BBS1.M5.10	BBS1.M5.11

TBH3 | TBH5


HM
Z2
RH
LH

Technical details:

- Super-strength steel
- Spiral portion coated with orange or black P.T.F.E.
- HW head with precision balanced centre point
- 2 precision ground cutting edges [Z2]
- 2 spiral flutes
- Parallel shank with driving flat and length adjusting screw

Application:

Used on boring machines and dowel drilling devices.

Use for drilling through holes in solid wood, wood composites, plastic and laminated materials.

TBH3

for panels with maximum **40 mm** in thickness

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
5	44	77	10x26	TBH3.050.044.077.01R	TBH3.050.044.077.01L
6	44	77	10x26	TBH3.060.044.077.01R	TBH3.060.044.077.01L
8	44	77	10x26	TBH3.080.044.077.01R	TBH3.080.044.077.01L
10	44	77	10x26	TBH3.100.044.077.01R	TBH3.100.044.077.01L
12	44	77	10x26	TBH3.120.044.077.01R	TBH3.120.044.077.01L

TBH5

for panels with maximum **60-65 mm** in thickness

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
5	70	115	10x30	TBH5.050.070.115.12R	TBH5.050.070.115.12L
6	70	115	10x30	TBH5.060.070.115.12R	TBH5.060.070.115.12L
8	70	115	10x30	TBH5.080.070.115.12R	TBH5.080.070.115.12L
10	70	115	10x30	TBH5.100.070.115.12R	TBH5.100.070.115.12L

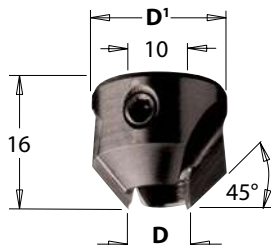
Spare parts:

BBS1.M5.10	BBS1.M5.11

Countersinks for 2 Flutes Dowel Drills

BBC1

Direct clamp on the shank of the drills



HM

Z2

RH

LH

Technical details:

- Super-strength steel
- 2 precision ground carbide tipped cutting edges [Z2].

Application:

Used for chamfering and drilling in solid wood, wood composites, plastic and laminated materials.

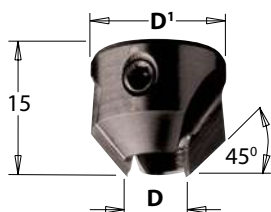
D mm	D ¹ mm	ARTICLE RH	ARTICLE LH
5 - 10	20	BBC1.050.20.01R	BBC1.050.20.01L
11 - 12	22	BBC1.110.20.01R	BBC1.110.20.01L

Spare parts:

BBS1.M5.05	991.062.00

BBC2

Countersinks for 4 Flutes Dowel Drills



D mm	D ¹ mm	ARTICLE RH	ARTICLE LH
3	16	BBC2.030.016.01R	BBC2.030.016.01L
3,5	16	BBC2.035.016.01R	BBC2.035.016.01L
4	16	BBC2.040.016.01R	BBC2.040.016.01L
5	16	BBC2.050.016.01R	BBC2.050.016.01L
6	16	BBC2.060.016.01R	BBC2.060.016.01L
7	16	BBC2.070.016.01R	BBC2.070.016.01L
8	18	BBC2.080.016.01R	BBC2.080.016.01L
9	18	BBC2.090.016.01R	BBC2.090.016.01L
10	20	BBC2.100.016.01R	BBC2.100.016.01L
12	20	BBC2.120.016.01R	BBC2.120.016.01L

Spare parts:

990.006.00	991.062.00

HBX1 | HBX2



HM

Z2

V2

RH

LH

Technical details:

- Super-strength steel
- Cutter portion coated with orange or black P.T.F.E.
- HW head with precision balanced centre point
- 2 HW precision ground cutting edges [Z2]
- 2 negatively ground spurs [V2]
- Parallel shank with driving flat and length adjusting screw

Application:

Ideal for hinges. Use on boring machines equipped with adapters or chucks. Use for drilling accurate and cleancut blind holes in solid wood, wood composites, plastic and laminated materials.

HBX1

D mm	L mm	S mm	ARTICLE RH	ARTICLE LH
15	57,5	10x26	HBX1.150.057.1R	HBX1.150.057.1L
18	57,5	10x26	HBX1.180.057.1R	HBX1.180.057.1L
20	57,5	10x26	HBX1.200.057.1R	HBX1.200.057.1L
25	57,5	10x26	HBX1.250.057.1R	HBX1.250.057.1L
26	57,5	10x26	HBX1.260.057.1R	HBX1.260.057.1L
35	57,5	10x26	HBX1.350.057.1R	HBX1.350.057.1L

HBX2

D mm	L mm	S mm	ARTICLE RH	ARTICLE LH
15	70	10x26	HBX2.150.070.1R	HBX2.150.070.1L
18	70	10x26	HBX2.180.070.1R	HBX2.180.070.1L
20	70	10x26	HBX2.200.070.1R	HBX2.200.070.1L
25	70	10x26	HBX2.250.070.1R	HBX2.250.070.1L
26	70	10x26	HBX2.260.070.1R	HBX2.260.070.1L
35	70	10x26	HBX2.350.070.1R	HBX2.350.070.1L

Spare parts:

BBS1.M5.10	BBS1.M5.11

HBH1

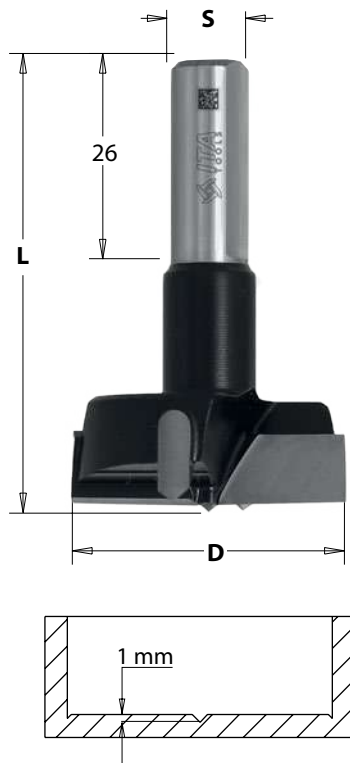
HM

Z2

V2

RH

LH



Technical details:

- Super-strength steel
- Cutter portion coated with orange or black P.T.F.E.
- HW head with precision balanced centre point
- HW precision ground cutting edges [Z2]
- 2 negatively ground spurs [V2]
- Parallel shank with driving flat and length adjusting screw

Application:

Ideal for hinges. Use on boring machines equipped with adapters or chucks. Use for drilling accurate and clean-cut blind holes in solid wood, wood composites, plastic and laminated materials.

D mm	L mm	S mm	ARTICLE RH	ARTICLE LH
14	57,5	10x26	HBH1.140.057.1R	HBH1.140.057.1L
15	57,5	10x26	HBH1.150.057.1R	HBH1.150.057.1L
16	57,5	10x26	HBH1.160.057.1R	HBH1.160.057.1L
17	57,5	10x26	HBH1.170.057.1R	HBH1.170.057.1L
18	57,5	10x26	HBH1.180.057.1R	HBH1.180.057.1L
19	57,5	10x26	HBH1.190.057.1R	HBH1.190.057.1L
20	57,5	10x26	HBH1.200.057.1R	HBH1.200.057.1L
22	57,5	10x26	HBH1.220.057.1R	HBH1.220.057.1L
24	57,5	10x26	HBH1.240.057.1R	HBH1.240.057.1L
25	57,5	10x26	HBH1.250.057.1R	HBH1.250.057.1L
26	57,5	10x26	HBH1.260.057.1R	HBH1.260.057.1L
28	57,5	10x26	HBH1.280.057.1R	HBH1.280.057.1L
30	57,5	10x26	HBH1.300.057.1R	HBH1.300.057.1L
32	57,5	10x26	HBH1.320.057.1R	HBH1.320.057.1L
34	57,5	10x26	HBH1.340.057.1R	HBH1.340.057.1L
35	57,5	10x26	HBH1.350.057.1R	HBH1.350.057.1L
38	57,5	10x26	HBH1.380.057.1R	HBH1.380.057.1L
40	57,5	10x26	HBH1.400.057.1R	HBH1.400.057.1L
42	57,5	10x26	HBH1.420.057.1R	HBH1.420.057.1L
45	57,5	10x26	HBH1.450.057.1R	HBH1.450.057.1L
50	57,5	10x26	HBH1.500.057.1R	HBH1.500.057.1L
55	57,5	10x26	HBH1.550.057.1R	HBH1.550.057.1L
60	57,5	10x26	HBH1.600.057.1R	HBH1.600.057.1L

Spare parts:

BBS1.M5.10	BBS1.M5.11

HBH2


HM
Z2
V2
RH
LH

Technical details:

- Super-strength steel
- Cutter portion coated with orange or black P.T.F.E.
- HW head with precision balanced centre point
- 2 HW precision ground cutting edges [Z2]
- 2 negatively ground spurs [V2]
- Parallel shank with driving flat and length adjusting screw

Application:

Ideal for hinges. Use on boring machines equipped with adapters or chucks. Use for drilling accurate and clean-cut blind holes in solid wood, wood composites, plastic and laminated materials.

D mm	L mm	S mm	ARTICLE RH	ARTICLE LH
15	70	10x26	HBH2.150.070.1R	HBH2.150.070.1L
16	70	10x26	HBH2.160.070.1R	HBH2.160.070.1L
18	70	10x26	HBH2.180.070.1R	HBH2.180.070.1L
20	70	10x26	HBH2.200.070.1R	HBH2.200.070.1L
22	70	10x26	HBH2.220.070.1R	HBH2.220.070.1L
25	70	10x26	HBH2.250.070.1R	HBH2.250.070.1L
26	70	10x26	HBH2.260.070.1R	HBH2.260.070.1L
30	70	10x26	HBH2.300.070.1R	HBH2.300.070.1L
35	70	10x26	HBH2.350.070.1R	HBH2.350.070.1L
40	70	10x26	HBH2.400.070.1R	HBH2.400.070.1L
45	70	10x26	HBH2.450.070.1R	HBH2.450.070.1L
50	70	10x26	HBH2.500.070.1R	HBH2.500.070.1L
55	70	10x26	HBH2.550.070.1R	HBH2.550.070.1L
60	70	10x26	HBH2.600.070.1R	HBH2.600.070.1L

Spare parts:

	
BBS1.M5.10	BBS1.M5.11

DWA | DWB



Z2

RH

LH



Technical details:

- Body made of durable steel
- Diamond blades with a precisely centered central point
- 2 PCD cutting edges (Z2)
- 2 PCD scoring blades (V2)
- Cylindrical shank with milling for easier assembly in the holder

Application:

Perfect for drilling hinge holes on multi-spindles drilling machines with suitable quick couplings. For making sockets in hardwood, wood-based materials, plastic and laminated materials. Thanks to the use of PCD blades, the service life of these drill bits is several dozen times greater than conventional drill bits with HM blades.

Note: Other dimensions on request.

DWA

D mm	L mm	S mm	ARTICLE RH	ARTICLE LH
12	57,5	10	DWA.012RH	DWA.012LH
14	57,5	10	DWA.014RH	DWA.014LH
15	57,5	10	DWA.015RH	DWA.015LH
20	57,5	10	DWA.020RH	DWA.020LH
25	57,5	10	DWA.025RH	DWA.025LH
26	57,5	10	DWA.026RH	DWA.026LH
30	57,5	10	DWA.030RH	DWA.030LH
35	57,5	10	DWA.035RH	DWA.035LH
40	57,5	10	DWA.040RH	DWA.040LH

DWB

D mm	L mm	S mm	ARTICLE RH	ARTICLE LH
12	70	10	DWB.012RH	DWB.012LH
14	70	10	DWB.014RH	DWB.014LH
15	70	10	DWB.015RH	DWB.015LH
20	70	10	DWB.020RH	DWB.020LH
25	70	10	DWB.025RH	DWB.025LH
26	70	10	DWB.026RH	DWB.026LH
30	70	10	DWB.030RH	DWB.030LH
35	70	10	DWB.035RH	DWB.035LH
40	70	10	DWB.040RH	DWB.040LH

Spare parts:

BBS1.M5.10	BBS1.M5.11

WS1.018.012.042.001


RH
LH
Technical details:

For use on the machines: VITAP®

D mm	D' mm	ARTICLE
10	18	WS1.018.012.042.001

Spare parts:

BBS1.M5.04	991.062.00

PCD & HM TOOLS

SOLID CARBIDE
ROUTER BITSPCD & VHM TOOLS FOR
COMPOSITESCHUCKS
& ACCESSORIESTOOLS FOR EDGEBANDING
MACHINES

CIRCULAR SAW BLADES

DRILL BITS

STRAIGHT
& SYSTEM KNIVES

STARTER KITS

WS1.020.010.043.001


RH
LH
Technical details:

For use on the machines: MORBIDELLI®

D mm	D' mm	ARTICLE
10	19,25	WS1.020.010.043.001

Spare parts:

BBS1.M5.04	991.062.00

WS1.020.014.040.001


RH
LH
Technical details:

For use on the machines: Masterwood®, Felder®, SCM®

D mm	D' mm	ARTICLE
10	19,4	WS1.020.014.040.001

Spare parts:

BBS1.M6.05	991.067.00

Adapters

WS1.020.017.046.001



RH
LH

Technical details:

For use on the machines: WEEKE®

D mm	D' mm	ARTICLE
10	20	WS1.020.017.046.001

Spare parts:

BBS1.M6.05	991.067.00

INFO	ARTICLE
Retaining screw for WEEKE®	BBS1.M5.11

WS1.020.015.037.001



RH

LH

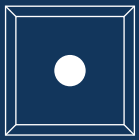
Technical details:

For use on the machines: BIESSE®

D mm	D' mm	ARTICLE RH	ARTICLE LH
10	20	WS1.020.015.037.001	WS1.020.015.037.002

Spare parts:

BBS1.M6.06	991.067.00

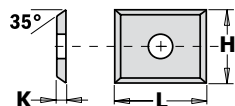
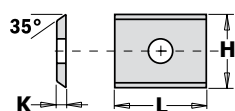


STRAIGHT AND SYSTEM KNIVES



Reversible HM Knives

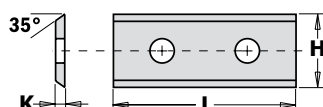
PCD & HM TOOLS



L mm	H mm	K mm	α	HC05	MG06	SMG02	UMG04
7,5	12	1,5	35°	75122	375122		
7,65	12	1,5	35°	76122			
9,6	12	1,5	35°	96122	396122	496122	
15	12	1,5	35°	15122	315122	415122	
19,5	12	1,5	4/35°	19122			
20	12	1,5	35°	20122	320122	420122	220122

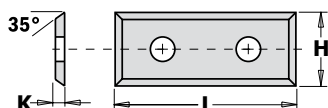
SOLID CARBIDE
ROUTER BITS

PCD & VHM TOOLS FOR
COMPOSITES



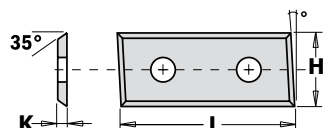
L mm	H mm	K mm	α	HC05	MG06	SMG02	UMG04
24,7	12	1,5	35°	125122			
30	12	1,5	35°	30122	330122	430122	230122
30	12	1,5	45°		630122		
40	12	1,5	35°	40122	340122	440122	240122
50	12	1,5	35°	50122	350122	450122	250122
60	12	1,5	35°	60122	360122	460122	

CHUCKS
& ACCESSORIES



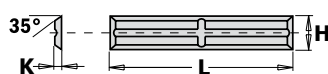
L mm	H mm	K mm	α	HC05	MG06	SMG02	UMG04
29,5	9	1,5	35°	3094	33094		
29,5	12	1,5	35°	30124	330124		
39,5	9	1,5	35°	4094			
49,5	9	1,5	35°	5094	35094		
49,5	12	1,5	35°	50124	350124	450124	250124

TOOLS FOR EDGEBANDING
MACHINES



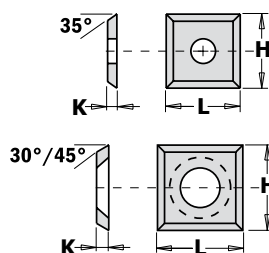
L mm	H mm	K mm	α	HC05	MG06	SMG02	UMG04
28,3	12	1,5	35°	283127			
48,3	12	1,5	35°	483127			

CIRCULAR SAW BLADES



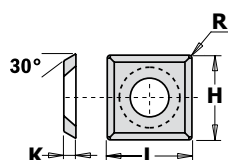
L mm	H mm	K mm	α	HC05	MG06	SMG02	UMG04
20	4,1	1,1	35°	220414	520414		
30	5,5	1,1	35°	230554	530554		
50	5,5	1,1	35°	250554	550554		

DRILL BITS



L mm	H mm	K mm	α	HC05	MG06	SMG02	UMG04
12	12	1,5	35°	12124	312124	412124	
13,6	13,6	2	30°	136204			
14	14	1,2	30°	14124			
14	14	2	30°	814204		414204	
14	14	2	45°		614204		

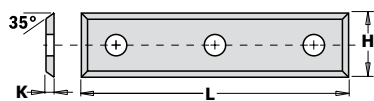
STRAIGHT
& SYSTEM KNIVES



L mm	H mm	K mm	α	HC05	MG06	SMG02	UMG04
14	14	2	R/30°	14244			

STARTER KITS

Reversible HM Knives



L mm	H mm	K mm	α	HC05	MG06	SMG02	UMG04
50	9	1,5	35°	5093			
50	12	1,7	35°	50123	150123	450123	

PCD & HM TOOLS

SOLID CARBIDE
ROUTER BITS

PCD & VHM TOOLS FOR
COMPOSITES

CHUCKS
& ACCESSORIES

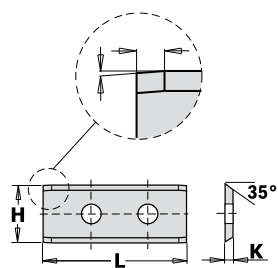
TOOLS FOR EDGEBANDING
MACHINES

CIRCULAR SAW BLADES

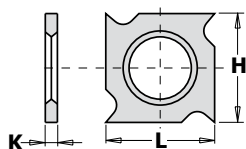
DRILL BITS

STRAIGHT
& SYSTEM KNIVES

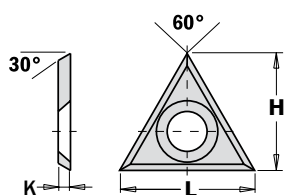
STARTER KITS



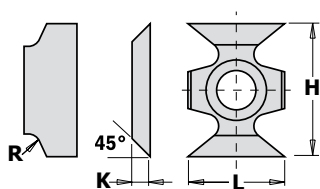
L mm	H mm	K mm	α	HC05	MG06	SMG02	UMG04
20	12	1,5	35°	20129			
30	12	1,5	35°	30129			
50	12	1,5	35°	50129			



L mm	H mm	K mm	α	HC05	MG06	SMG02	UMG04
18	18	1,95		181954			
18	18	2,45		182454			



L mm	H mm	K mm	α	HC05	MG06	SMG02	UMG04
22	19	2	30°		220201		



L mm	H mm	K mm	R mm	α	HC05	MG06	SMG02	UMG04
16	22	5	1,5		162215			
16	22	5	2		162220			
16	22	5	3		162230			
16	22	5		45°	162245			

KS1-KS2-KS3

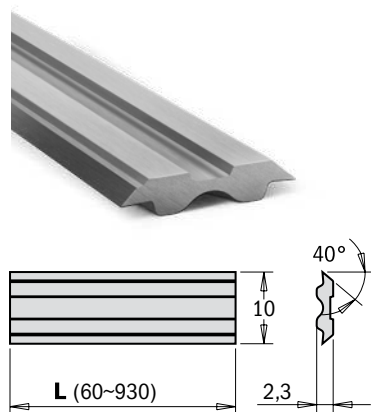
HSS

HM

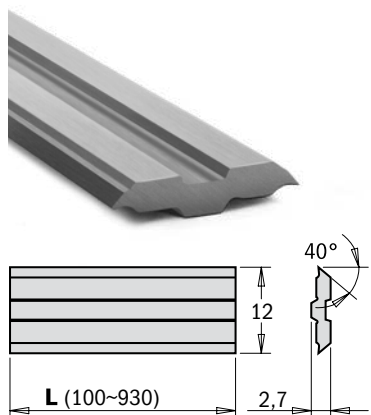
Note:

Other dimensions on request.

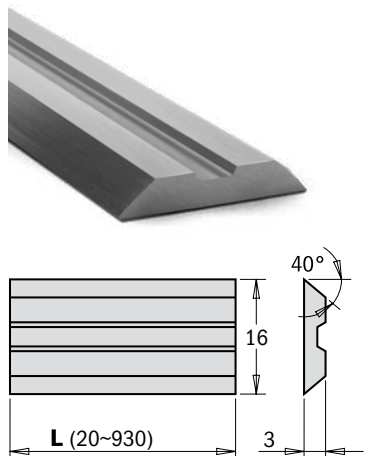
TERSA



CENTROSTAR CENTROFIX QUICKFIX



CENTROLOCK



TERSA

L mm	H mm	K mm	ARTICLE
60	10	2,3	KS1.060.01
80	10	2,3	KS1.080.01
100	10	2,3	KS1.100.01
110	10	2,3	KS1.110.01
120	10	2,3	KS1.120.01
130	10	2,3	KS1.130.01
140	10	2,3	KS1.140.01
150	10	2,3	KS1.150.01
160	10	2,3	KS1.160.01
170	10	2,3	KS1.170.01
180	10	2,3	KS1.180.01
190	10	2,3	KS1.190.01
200	10	2,3	KS1.200.01
210	10	2,3	KS1.210.01
220	10	2,3	KS1.220.01
230	10	2,3	KS1.230.01
235	10	2,3	KS1.235.01
240	10	2,3	KS1.240.01
250	10	2,3	KS1.250.01
260	10	2,3	KS1.260.01
270	10	2,3	KS1.270.01
280	10	2,3	KS1.280.01
300	10	2,3	KS1.300.01
310	10	2,3	KS1.310.01
330	10	2,3	KS1.330.01
350	10	2,3	KS1.350.01
360	10	2,3	KS1.360.01
400	10	2,3	KS1.400.01
410	10	2,3	KS1.410.01
420	10	2,3	KS1.420.01
430	10	2,3	KS1.430.01
450	10	2,3	KS1.450.01
460	10	2,3	KS1.460.01
480	10	2,3	KS1.480.01
500	10	2,3	KS1.500.01
510	10	2,3	KS1.510.01
520	10	2,3	KS1.520.01
530	10	2,3	KS1.530.01
540	10	2,3	KS1.540.01
610	10	2,3	KS1.610.01
620	10	2,3	KS1.620.01
630	10	2,3	KS1.630.01
635	10	2,3	KS1.635.01
640	10	2,3	KS1.640.01
650	10	2,3	KS1.650.01
710	10	2,3	KS1.710.01
810	10	2,3	KS1.810.01
860	10	2,3	KS1.860.01
910	10	2,3	KS1.910.01
930	10	2,3	KS1.930.01

CENTROSTAR, CENTROFIX, QUICKFIX

L mm	H mm	K mm	ARTICLE
60	12	2,7	KS2.060.01
80	12	2,7	KS2.080.01
100	12	2,7	KS2.100.01
110	12	2,7	KS2.110.01
120	12	2,7	KS2.120.01
130	12	2,7	KS2.130.01
140	12	2,7	KS2.140.01
150	12	2,7	KS2.150.01
160	12	2,7	KS2.160.01
170	12	2,7	KS2.170.01
180	12	2,7	KS2.180.01
190	12	2,7	KS2.190.01
200	12	2,7	KS2.200.01
210	12	2,7	KS2.210.01
220	12	2,7	KS2.220.01
230	12	2,7	KS2.230.01
240	12	2,7	KS2.240.01
250	12	2,7	KS2.250.01
260	12	2,7	KS2.260.01
270	12	2,7	KS2.270.01
280	12	2,7	KS2.280.01
300	12	2,7	KS2.300.01
310	12	2,7	KS2.310.01
350	12	2,7	KS2.350.01
360	12	2,7	KS2.360.01
400	12	2,7	KS2.400.01
410	12	2,7	KS2.410.01
420	12	2,7	KS2.420.01
430	12	2,7	KS2.430.01
450	12	2,7	KS2.450.01
480	12	2,7	KS2.480.01
510	12	2,7	KS2.510.01
520	12	2,7	KS2.520.01
530	12	2,7	KS2.530.01
610	12	2,7	KS2.610.01
620	12	2,7	KS2.620.01
630	12	2,7	KS2.630.01
640	12	2,7	KS2.640.01
650	12	2,7	KS2.650.01
710	12	2,7	KS2.710.01
810	12	2,7	KS2.810.01
930	12	2,7	KS2.930.01

CENTROLOCK

L mm	H mm	K mm	ARTICLE
60	16	3	KS3.060.01
80	16	3	KS3.080.01
100	16	3	KS3.100.01
130	16	3	KS3.130.01
150	16	3	KS3.150.01
170	16	3	KS3.170.01
180	16	3	KS3.180.01
190	16	3	KS3.190.01
230	16	3	KS3.230.01
240	16	3	KS3.240.01
270	16	3	KS3.270.01
460	16	3	KS3.460.01
930	16	3	KS3.930.01