

5. Cutter heads

Cutter heads

Planer and pre-planer cutter heads with high speed steel knives (HSS) designed for professional machining of solid soft wood and with carbide (HM) knives designed for professional machining of solid soft and hard wood, glued wood and other wood-based materials. The other type of cutter heads for machining shape surfaces with profile knives (HSS) and carbide shape knives as exchangeable inserts. Knives for cutter heads are made from the highest quality high speed cutting steel in special heat treatment technology, in vacuum heater, which has been properly selected for the type of work, parameters and conditions prevailing during the machining, in order to guarantee proper work of the tool, both in standard and extreme conditions.

The *Cutters heads* chapter includes only example types and models of cutter heads and sets of cutter heads with basic dimensions. Big part of our offer are cutter heads on client's special request, meeting buyer's specific demands. Before we start the designing and production process we take into consideration many issues connected with client's requirements such as expected machining quality, type and parameters of the machine, workpiece material and many others. We also offer special tools with sheer angle, optimized chip flow and hydro clamping, designed for professional, very precise machining of solid wood and other wood-based materials with feed speed up to 200 m/min. Our cutter heads are produced with various clamping types, however, we put special focus on hydro clamping or all types of clamping on HSK shank and HSK 85 clamping. The clamping construction guarantees run-out tolerance reduced to minimum. Thanks to hydro system and HSK 85 which allows for perfect balancing of the tool, we obtain very high surface quality and ability to work with high cutting and feed speed.

Time of design and production process of cutter heads and sets of cutter heads on client's special request usually doesn't exceed 10 working days after agreeing all the details. Standard cutter heads dimensions range withing $D_{max} = 400$ mm and $B_{max} = 350$ mm, except spiral cutter heads type G309 and G509, for which $B_{max} = 250$ mm. In case of machining wider elements, we design and produce sets of cutter heads consisting of several heads.

All types of cutter heads are manufactured on modern CNC machines of world-renowned producers, which guarantee high accuracy and precision of the produced tools. Interoperational and final control verifies tools production and guarantees that every tool sent to the client is manufactured according to technical documentation and standards. The construction and production remains in accordance with all points of safety standard EN/PN-847-1 concerning tools for mechanical woodworking.

Orders should include:

- outer diameter (D) or diameters range,
- bore diameter (d),
- number of teeth (z) or spindle rotation speed and feed speed,
- type of machined material,
- profile drawing with dimensions or profile sample,
- other information relevant for designing and production process.

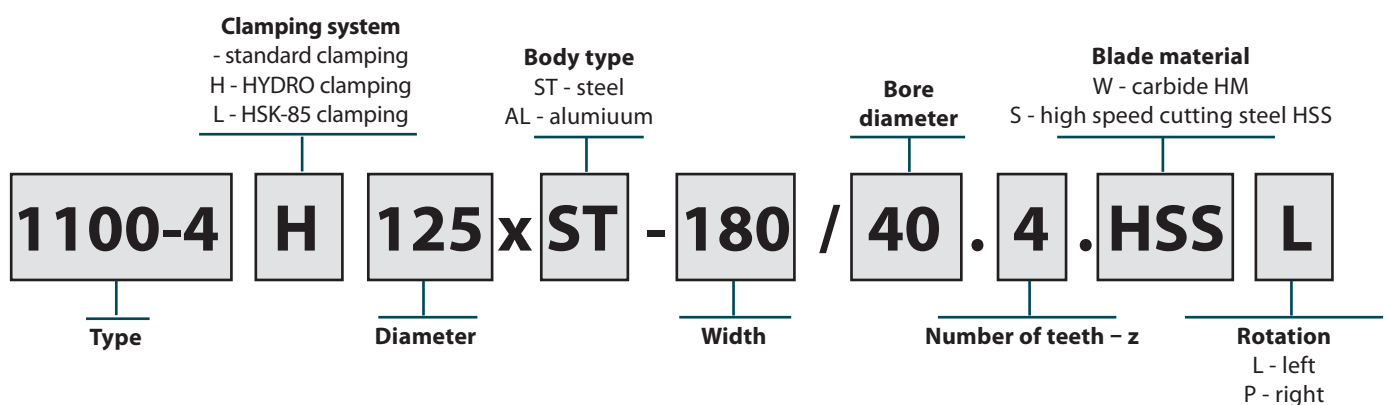


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Cutter heads coding system



Pictograms



solid dry softwood



solid dry hardwood



chipboard



glued wood



MDF



plastics



carbide



high-speed cutting steel



hydro clamping



HSK 85 clamping



steel or aluminium body



flat surfaces



rebating



grooving



edge machining



profiling



chip breaking



mechanical feed



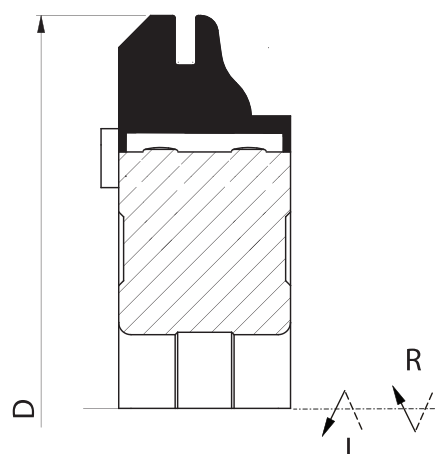
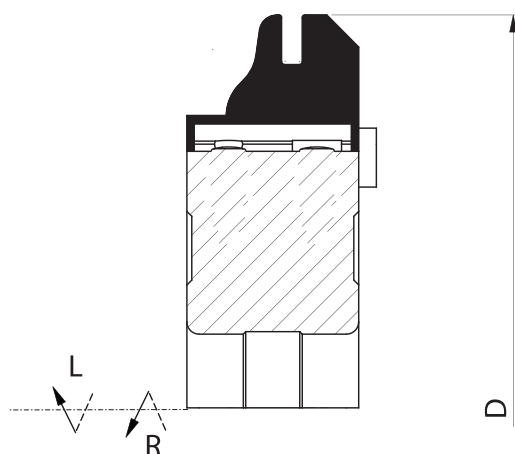
manual feed



quiet and steady work

- available / stock product
- + production time 9–15 working days.

Rotation direction

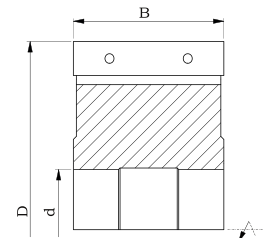
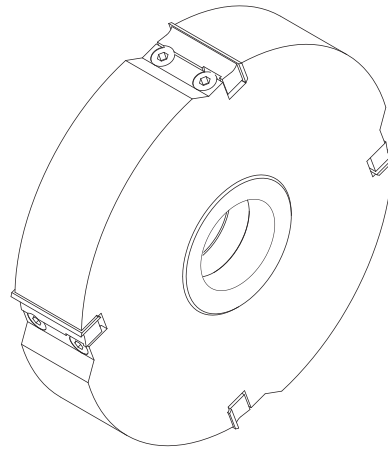


Carbide planer head, type **1100-1** with suitable number of cutting teeth, designed for professional machining of wood and wood-based materials such as chipboard, MDF and others. The cutter head is designed for pre-planing and planing. The body is made from steel or aluminum.

Type of work: pre-planing and planing.

Material: hard wood, glued wood, chipboard, MDF

1100-1



$D_{\max} = 400 \text{ mm}$, $B_{\max} = 120 \text{ mm}$



5

D n ^{max} d ^{max} z	80 12000 30 2-6		100 9000 30 2-6		125 9000 40 2-6		140 6000 40 2-6		160 6000 40 2-6		180 6000 40 2-6	
B mm	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL
20	+	+	+	+	+	+	+	+	+	+	+	+
25	+	+	+	+	+	+	+	+	+	+	+	+
30	+	+	+	+	+	+	+	+	+	+	+	+
40	+	+	+	+	+	+	+	+	+	+	+	+
50	+	+	+	+	+	+	+	+	+	+	+	+
60	+	+	+	+	+	+	+	+	+	+	+	+
80	+	+	+	+	+	+	+	+	+	+	+	+
100	+	+	+	+	+	+	+	+	+	+	+	+

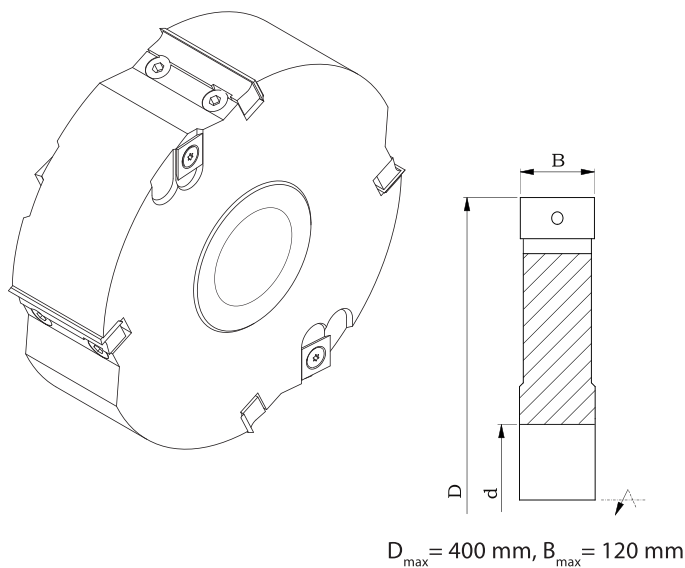
Catalogue number	Type	Body	D mm	B mm	d mm	z		
G101-080-2504-0	1100-1	ST	80	50	30	4	HM	•
G101-080-2604-0	1100-1	ST	80	60	30	4	HM	+
G101-100-2304-2	1100-1	ST	100	30	30	4	HM	+
G101-100-2504-2	1100-1	ST	100	50	30	4	HM	+
G101-100A2504-2	1100-1	AL	100	50	30	4	HM	+
G101-125-4504-2	1100-1	ST	125	50	40	4	HM	+
G101-125-4506-2	1100-1	ST	125	50	40	6	HM	+
G101-125-4604-3	1100-1	ST	125	60	40	4	HM	+
G101-125A4604-4	1100-1	AL	125	60	40	4	HM	+
G101-160-6406-2	1100-1	ST	160	40	50	6	HM	+

Spare parts for cutter heads 1100-1

Cat. nr	Name	Dimensions		
	Knife	B x 12 x 1,5		•
	Clamping wedge	B-3 x 10,5 x 9		•

Cat. nr	Name	Dimensions		
WHAS00011	Screw TOR 1011	M7x20		•

1100-3



Grooving head, type **1100-3** with suitable number of cutting teeth and left and right spurs, designed for professional machining of wood and wood-based materials such as chipboard, MDF and others. The cutter head is used for precise grooving and rebating. The dimension of machined profiles is equal to cutter's width. The body is made from steel or aluminum.

Type of work: precise grooving and rebating.

Material: hard wood, glued wood, chipboard, MDF, plastics



D n _{max} d _{max} z	125 9000 40						140 6000 60						160 6000 60						180 6000 60					
	2 v2+2		3 v3+3		4 v2+2		2 v2+2		3 v3+3		4 v2+2		2 v2+2		3 v3+3		4 v2+2		2 v2+2		3 v3+3		4 v2+2	
Bmm	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL
20	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+
25	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+
30	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+
40	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+
50	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+
60	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+
80	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+
100	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+

Catalogue number	Type	Body	D mm	B mm	d mm	z		
G103-125-2202-2	1100-3	ST	125	20	30	2 v2+2	HM	+
G103-125A2204-2	1100-3	AL	125	20	30	4 v2+2	HM	+
G103-125-2302-2	1100-3	ST	125	30	30	2 v2+2	HM	+
G103-125-2404-4	1100-3	ST	125	40	30	4 v2+2	HM	+
G103-125A2404-4	1100-3	AL	125	40	30	4 v2+2	HM	+
G103-125-2504-4	1100-3	ST	125	50	30	4 v2+2	HM	+
G103-125A2504-4	1100-3	AL	125	50	30	4 v2+2	HM	+
G103-160-2404-0	1100-3	ST	160	40	30	4 v2+2	HM	+

Spare parts for cutter heads 1100-3

Cat. nr	Name	Dimensions		
	Knife	B-0,4 x 12 x 1,5		•
N0000818	Knife	14x14x2		•
	Clamping wedge	B-2 x 10,5 x 9		•

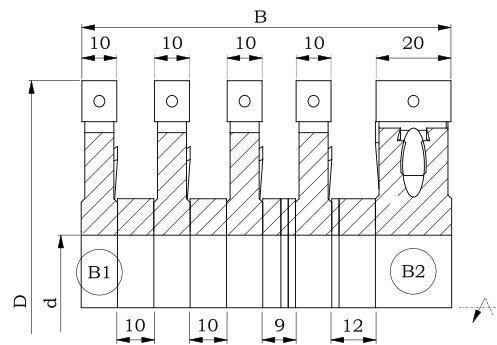
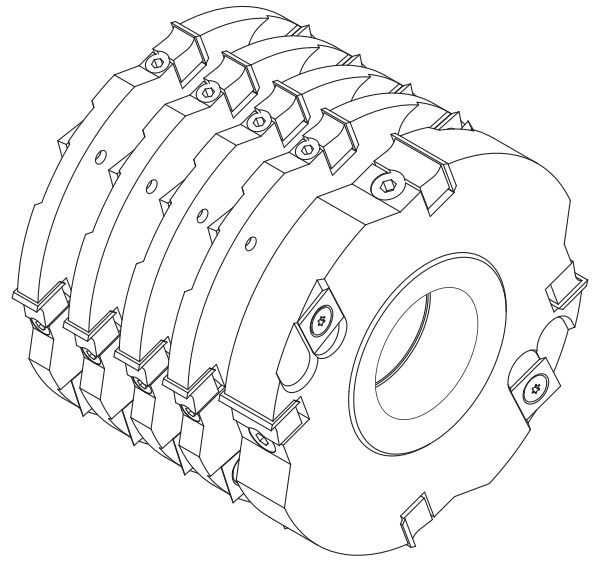
Cat. nr	Name	Dimensions		
WHAS00011	Screw TOR 1011	M7 x 20		•
WHAS00008	Screw TOR 1064	M5 x 6,5		•

Set of grooving heads type **1100-3**, with suitable number of cutting teeth and left and right spurs, designed for professional machining of solid wood. The set is used for machining guide grooves for precise transportation of short and curved elements on the machine bed. The body is made from steel or aluminum.

Type of work: machining guide grooves.

Material: solid wood, hard and soft

1100-3 set



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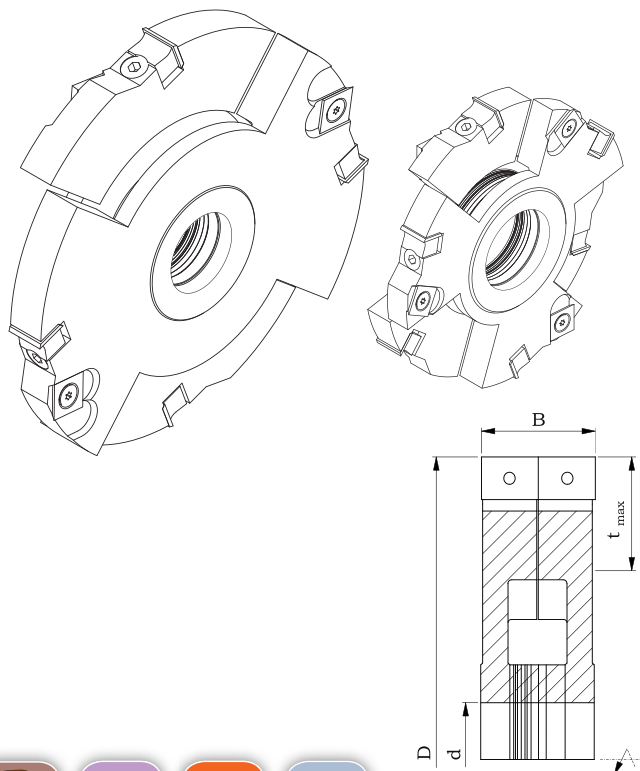
D n _{max} d _{max} z	125 9000 40						140 9000 40					
	2 v2+2		3 v3+3		4 v2+2		2 v2+2		3 v3+3		4 v2+2	
Bmm	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL
80	+	+	+	+	+	+	+	+	+	+	+	+
100	+	+	+	+	+	+	+	+	+	+	+	+
120	+	+	+	+	+	+	+	+	+	+	+	+
140	+	+	+	+	+	+	+	+	+	+	+	+
170	+	+	+	+	+	+	+	+	+	+	+	+

Spate parts for set of cutter heads

Cat. nr	Name	Dimensions		
N0000802	Knife	9,6x12x1,5		•
N0000594	Knife	20,6x12x1,5		•
N0000818	Knife	14x14x2		•
WHAK00025	Clamping wedge	8x10x9		•

Cat. nr	Name	Dimensions		
WHAK00010	Support block	18x10x9		•
WHAS00011	Screw TOR 1011	M7x20		•
WHAS00007	Screw TOR 1262	M5x23		•
WHAS00008	Screw TOR 1064	M5 x 6,5		•

GR set of 2 heads



Set of adjustable grooving heads type **GR** with suitable number of cutting teeth and left and right spurs, designed for professional machining of wood and wood-based materials such as chipboard, MDF and others. The set of heads is used for grooving and rebating. Width is regulated with spacer rings (in increments of 0,1 mm) included in the set. The body is made from steel or aluminum.

Type of work: precise grooving and rebating.

Material: hard wood, glued wood, veneered wood, chipboard, MDF



D n _{max} d _{max} z t _{max}	125 9000 40 2+2 v2+2 20		140 6000 60 2+2 v2+2 25		140 6000 60 3+3 v3+3 25		160 6000 60 2+2 v2+2 30		160 6000 60 3+3 v3+3 30		180 6000 60 2+2 v2+2 35		180 6000 60 4+4 v4+4 35		
	B mm	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL
8÷15		+	+	+	+	+	+	+	+	+	+	+	+	+	+
10÷19		+	+	+	+	+	+	+	+	+	+	+	+	+	+
12÷22,50		+	+	+	+	+	+	+	+	+	+	+	+	+	+
12,50÷24		+	+	+	+	+	+	+	+	+	+	+	+	+	+
15,50÷30		+	+	+	+	+	+	+	+	+	+	+	+	+	+
20,50÷40		+	+	+	+	+	+	+	+	+	+	+	+	+	+
25÷49		+	+	+	+	+	+	+	+	+	+	+	+	+	+
30,50÷60		+	+	+	+	+	+	+	+	+	+	+	+	+	+
40,50÷80		+	+	+	+	+	+	+	+	+	+	+	+	+	+
50,50÷100		+	+	+	+	+	+	+	+	+	+	+	+	+	+
60,50÷120		+	+	+	+	+	+	+	+	+	+	+	+	+	+

Spate parts for set of cutter heads

Cat. nr	Name	Dimensions	
	Knife	(B/2+0,5)x12x1,5	
N0000818	Spur	14x14x2	
	Clamping wedge	(B/2-2,5)x12,5x9	

Cat. nr	Name	Dimensions	
WHAS00007	Screw	M5x23	
WHAS00011	Screw TOR 1011	M7x20	

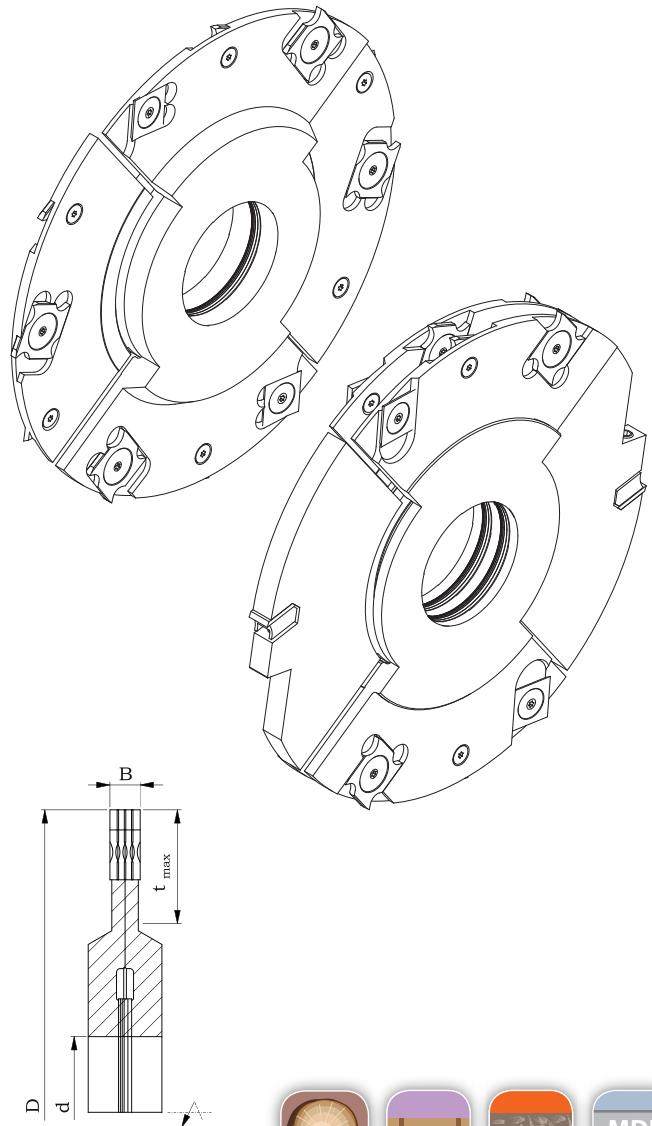
On special request, we offer the set consisting of 3 cutter heads.

Set of adjustable grooving heads, type **GR** with two cutting teeth and two left and two right spurs ($z=2\ v2+2$), designed for professional machining of wood and wood-based materials such as chipboard, MDF and others. The set of heads is used for precise grooving and rebating. Width is regulated with spacer rings (in increments of 0,1 mm) included in the set. Width $B=4-7,5$ mm when working with 2-element set, $B=4-15$ mm when working with 3-element set.

Type of work: precise grooving and rebating.

Material: hard wood, glued wood, veneered wood, chipboard, MDF.

GR set B 4-15




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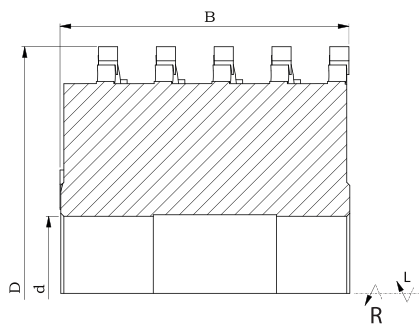
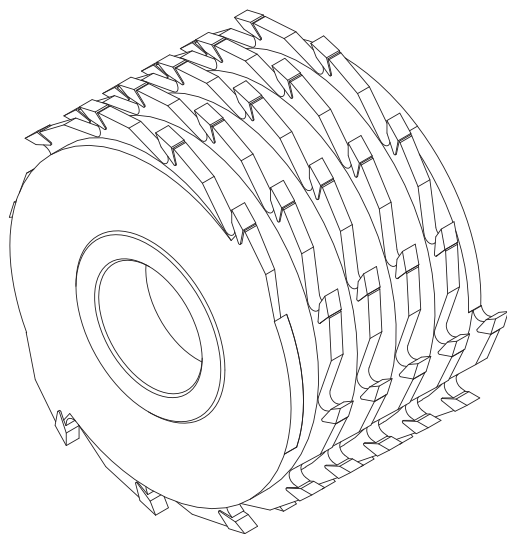


D n _{max} d _{max} z t _{max}	120 9000 35 2 v2+2 20	125 9000 40 2 v2+2 20	130 6000 40 2 v2+2 25	150 6000 50 2 v2+2 30	160 6000 60 2 v2+2 30	180 6000 60 2 v2+2 35
B mm						
4-7,5	+	+	+	+	+	+
4-15	+	+	+	+	+	+

Spate parts for set of cutter heads

Cat. nr	Name	Dimensions		Cat. nr	Name	Dimensions	
N0000801	Knife	7,5x12x1,5		WHAS00054	Screw 1402	M4x0,5	
N0000706	Knife	18x18x1,95		WHAS00056	Nut with washer	M4x0,5	
N0000817	Spur	14x14x1,2		WHAW00004	Screw DIN915	M6x16	
WHAK00348	Clamping wedge	7,5x11,5x5,8					

FS-01 P or L



Spiral brazed cutter, type **FS-01** with increased number of cutting teeth, designed for professional machining of wood and wood-based materials such as chipboard and others. The cutter is used for machining flat surfaces with big number of knags and multidirectional fiber system. The cutter is adapted to machining materials with allowance up to 4 mm.

Type of work: finishing flat surfaces with big number of knags and multidirectional fibre system.

Material: solid hard wood, chipboard, MDF.



D n d _{max} z _{max}	100 9000 30 12	125 9000 40 12	140 6000 40 12	160 6000 60 12	180 6000 60 12
B mm					
40	+	+	+	+	+
60	+	+	+	+	+
80	+	+	+	+	+
100	+	+	+	+	+
120	+	+	+	+	+
160	+	+	+	+	+
180	+	+	+	+	+
200	+	+	+	+	+
240	+	+	+	+	+

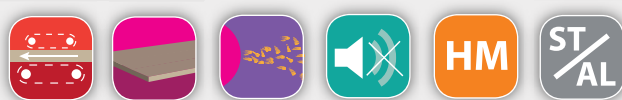
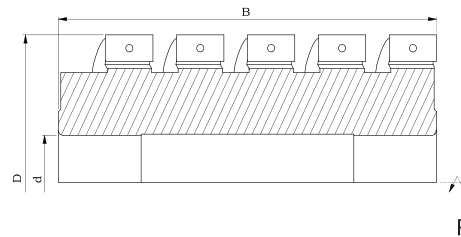
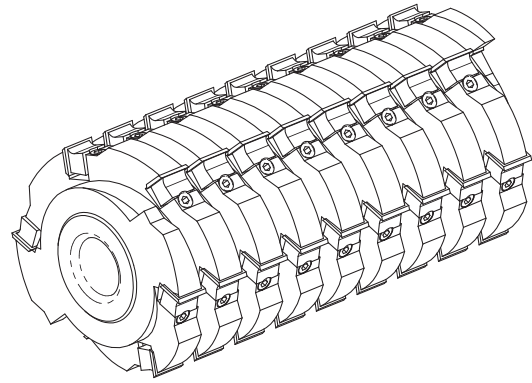
Catalogue number right	Catalogue number left	Type	D mm	B mm	d mm	z		
FS01W100P0002	FS01W100L0002	FS-01	100	56,25	30	12 (36)	HM	+
FS01W100P0031	FS01W100L0031	FS-01	100	160	35	12 (96)	HM	+
FS01W125P0006	FS01W125L0006	FS-01	125	100	40	12 (60)	HM	+
FS01W140P0018	FS01W140L0018	FS-01	140	80	35	12 (48)	HM	+
FS01W140P0020	FS01W140L0020	FS-01	140	120	35	12 (72)	HM	+

Spiral inserted cutter head, type **G1115** with six cutting teeth, designed for professional machining of wood and wood-based materials such as chipboard and others. The cutter head is used for pre-cutting flat surfaces with multi-directional fibre system. The cutter head is adapted to machining materials with allowance up to 8 mm. The body is made from steel or aluminum.

Type of work: pre-cutting flat surfaces with multidirectional fibre system.

Material: hard wood, veneered board, chipboard, MDF

G1115



D n _{max} d _{max} z	B mm	Number of knives	100 9000 30 2+2		125 9000 40 2+2		140 6000 40 2+2	
			ST	AL	ST	AL	ST	AL
	40	6	+	+	+	+	+	+
	60	10	+	+	+	+	+	+
	80	14	+	+	+	+	+	+
	100	18	+	+	+	+	+	+
	120	22	+	+	+	+	+	+
	160	30	+	+	+	+	+	+
	180	34	+	+	+	+	+	+
	200	38	+	+	+	+	+	+
	250	48	+	+	+	+	+	+

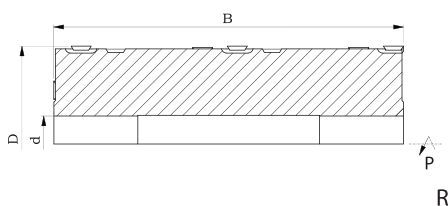
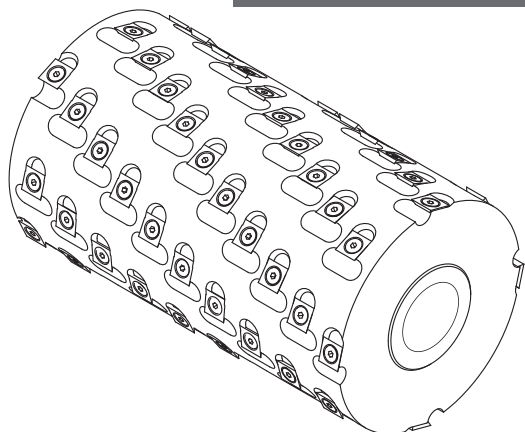
Catalogue number	Type	Body	D mm	B mm	d mm	z			
G1115-100-2126-0	G1115	ST	100	120	30	2+2 (22)	HM	R	+
G1115-100A2126-0	G1115	AL	100	120	30	2+2 (22)	HM	R	+
G1115-125-2106-0	G1115	ST	125	100	30	2+2 (18)	HM	R	+
G1115-125A4106-0	G1115	AL	125	100	40	2+2 (18)	HM	R	+
G1115-125-2126-2	G1115	ST	125	120	30	2+2 (22)	HM	R	+
G1115-125A4126-0	G1115	AL	125	120	40	2+2 (22)	HM	R	+
G1115-140-4126-0	G1115	ST	140	120	40	2+2 (22)	HM	R	+
G1115-140A4166-0	G1115	AL	140	160	40	2+2 (30)	HM	R	+
G1115-140-4236-0	G1115	ST	140	230	40	2+2 (44)	HM	R	+

Spare parts for cutter heads G1115

Cat. nr	Name	Dimensions		
N0000805	Knife	20 x 12 x 1,5		•
WHAK00034	Clamping wedge	17 x 10,5 x 9		•

Cat. nr	Name	Dimensions		
WHAS00011	Screw TOR 1011	M7x20		•

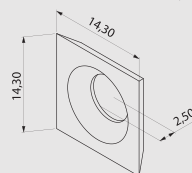
G109



Spiral inserted planer head, type **G109** with four cutting teeth, designed for professional machining of solid wood. The cutter head is used for pre-planing. Spiral head design and big number of cutting teeth allow for higher feed speed and guarantee optimal workload of the machine spindle. The cutter head is adapted to machining materials with allowance up to 10 mm. The body is made from steel or aluminum.

Type of work: pre-planing.

Material: solid wood, hard and soft.




Cutting blade dimensions.




D n _{max} d _{max} z	100 9000 40 4+4		125 9000 50 4+4		140 6000 60 4+4	
	B mm	Number of knives	ST	AL	ST	AL
	60	20	+	+	+	+
	80	24	+	+	+	+
	100	32	+	+	+	+
	120	40	+	+	+	+
	150	48	+	+	+	+
	200	64	+	+	+	+
	250	80	+	+	+	+

Catalogue number	Type	Body	D mm	B mm	d mm	z			
G109-100-202P-0	G109	ST	100	60	30	4+4 (20)	HM	R	+
G109-100A202P-0	G109	AL	100	60	30	4+4 (20)	HM	R	+
G109-100-208P-0	G109	ST	100	100	30	4+4 (32)	HM	R	+
G109-125-203P-0	G109	ST	125	120	30	4+4 (40)	HM	R	+
G109-125A203P-0	G109	AL	125	120	30	4+4 (40)	HM	R	+
G109-125-402P-0	G109	ST	125	230	40	4+4 (72)	HM	R	+
G109-140A405P-0	G109	AL	140	60	40	4+4 (20)	HM	R	+
G109-140-403P-0	G109	ST	140	100	40	4+4 (32)	HM	R	+
G109-140-406P-0	G109	ST	140	200	40	4+4 (64)	HM	R	+
G109-160A403P-0	G109	AL	160	80	40	4+4 (24)	HM	R	+
G109-160-501P-0	G109	ST	160	180	45	4+4 (56)	HM	R	+
G109-160-402P-0	G109	ST	160	230	50	4+4 (72)	HM	R	+

Spare parts for cutter heads G109

Cat. nr	Name	Dimensions	
N0000839	Knife	14,3 x 14,3 x 2,5	

Cat. nr	Name	Dimensions	
WHAS00006	Screw TOR 1128	M6x10	

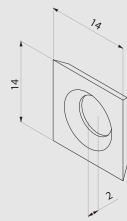
Above diameter D=140 mm, hydro clamping (d=50 mm) can be offered.

G209

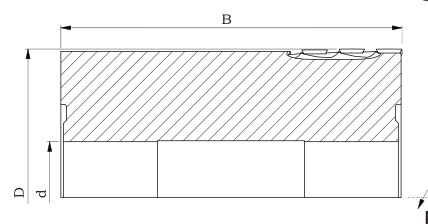
Spiral inserted planer head, type **G209** with four cutting teeth, designed for professional machining of solid wood. The cutter head is used for pre-planing. Spiral head design and big number of cutting teeth allow for higher feed speed and guarantee optimal workload of the machine spindle. The cutter head is adapted to machining materials with allowance up to 10 mm. The body is made from steel or aluminum.

Type of work: pre-planing.

Material: solid hard wood.



Cutting blade dimensions.



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D n _{max} d _{max} z	B mm	Number of knives	100 9000 40 4+4		125 9000 50 4+4		140 6000 60 4+4	
			ST	AL	ST	AL	ST	AL
60	20		+	+	+	+	+	+
80	28		+	+	+	+	+	+
100	36		+	+	+	+	+	+
120	44		+	+	+	+	+	+
150	52		+	+	+	+	+	+
200	72		+	+	+	+	+	+
250	88		+	+	+	+	+	+

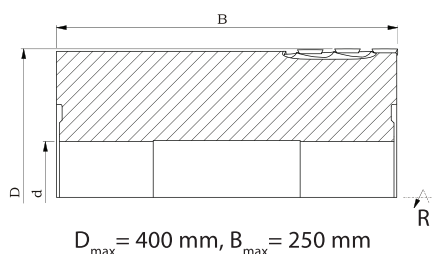
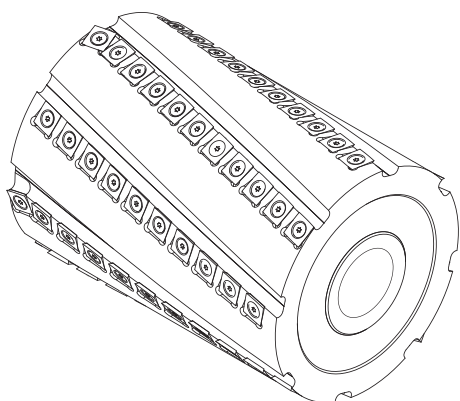
Catalogue number	Type	Body	D mm	B mm	d mm	z			
G209-100A2084-2	G209	AL	100	80	30	4+4 (28)	HM	R	+
G209-100-2084-0	G209	ST	100	80	30	4+4 (28)	HM	R	+
G209-100-2104-0	G209	ST	100	100	30	4+4 (36)	HM	R	+
G209-100A4104-0	G209	AL	100	100	40	4+4 (36)	HM	R	+
G209-125-4124-0	G209	ST	125	120	40	4+4 (44)	HM	R	+
G209-125A4124-0	G209	AL	125	120	40	4+4 (44)	HM	R	+
G209-125-4234-0	G209	ST	125	230	40	4+4 (84)	HM	R	+
G209-125A4234-0	G209	AL	125	230	40	4+4 (84)	HM	R	+
G209-140-4104-0	G209	ST	140	100	40	4+4 (36)	HM	R	+
G209-140A4104-0	G209	AL	140	100	40	4+4 (36)	HM	R	+
G209-140-4204-0	G209	ST	140	200	40	4+4 (72)	HM	R	+

Spare parts for cutter heads G209

Cat. nr	Name	Dimensions		Cat. nr	Name	Dimensions	
N0000818	Knife	14 x 14 x 2,0		WHAS00015	Screw TOR 1064	M5x10	

Above diameter D=140 mm, hydro clamping (d=50 mm) can be offered.

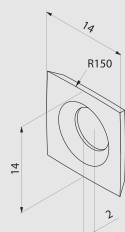
G309



Spiral inserted planer head, type **G309** with four cutting teeth, designed for professional machining of solid wood. The cutter head is used for finishing flat surfaces. Spiral head design and big number of cutting teeth allow for higher feed speed and guarantee optimal workload of the machine spindle. Special profile inserts allow to obtain high quality of the machined surface. The cutter head is adapted to finishing materials with allowance up to 10mm. The body is made from steel or aluminum.

Type of work: planing.

Material: solid hard wood.



Cutting blade dimensions.




D n _{max} d _{max} z	B mm	Number of knives	100 9000 40 4+4		125 9000 50 4+4		140 6000 60 4+4	
			ST	AL	ST	AL	ST	AL
60	24		+	+	+	+	+	+
80	32		+	+	+	+	+	+
100	40		+	+	+	+	+	+
120	48		+	+	+	+	+	+
150	60		+	+	+	+	+	+
200	84		+	+	+	+	+	+
250	108		+	+	+	+	+	+

Catalogue number	Type	Body	D mm	B mm	d mm	z			
G309-100-4104-B	G309	ST	100	100	40	4+4 (40)	HM	R	+
G309-100A4104-B	G309	AL	100	100	40	4+4 (40)	HM	R	+
G309-125-4124-B	G309	ST	125	120	40	4+4 (48)	HM	R	+
G309-125A4124-B	G309	AL	125	120	40	4+4 (48)	HM	R	+
G309-125-4234-B	G309	ST	125	230	40	4+4 (100)	HM	R	+
G309-140-4104-B	G309	ST	140	100	40	4+4 (40)	HM	R	+
G309-140A4204-B	G309	AL	140	200	40	4+4 (84)	HM	R	+
G309-140-6204-B	G309	ST	140	200	50	4+4 (84)	HM	R	+

Spare parts for cutter heads G309

Cat. nr	Name	Dimensions	
N00000710	Knife	14 x 14 x 2,0	

Cat. nr	Name	Dimensions	
WHAS00015	Screw TOR 1064	M5x10	

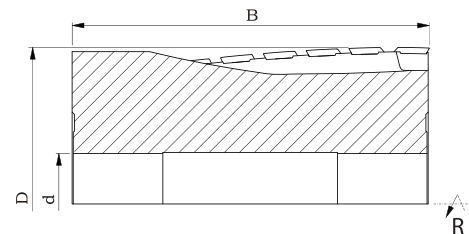
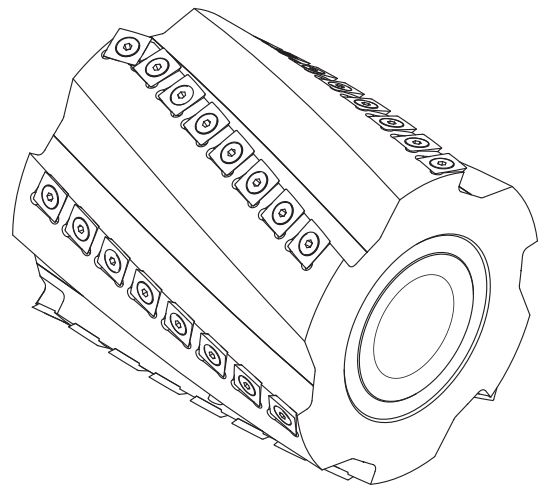
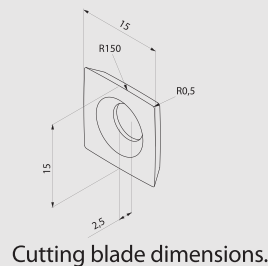
Above diameter D=140 mm, hydro clamping (d=50 mm) can be offered.

G509

Spiral inserted planer head, type **G509** with three cutting teeth, designed for professional machining of solid wood. The cutter head is used for finishing flat surfaces. Spiral head design and big number of cutting teeth allow for higher feed speed and guarantee optimal workload of the machine spindle. Special profile inserts allow to obtain high quality of the machined surface. The cutter head is adapted to machining materials with allowance up to 10 mm. The body is made from steel or aluminum.

Type of work: planing.

Material: solid hard wood.



$D_{\max} = 400 \text{ mm}$, $B_{\max} = 250 \text{ mm}$

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D n _{max} d _{max} z	B mm	Number of knives	100 9000 40 2+2		125 9000 50 2+2		140 6000 60 2+2	
			ST	AL	ST	AL	ST	AL
	100	18	+	+	+	+	+	+
	125	28	+	+	+	+	+	+

D n _{max} d _{max} z	B mm	Number of knives	100 9000 40 3+3		125 9000 50 3+3		140 6000 60 3+3	
			ST	AL	ST	AL	ST	AL
	100	27	+	+	+	+	+	+
	125	42	+	+	+	+	+	+
	160	48	+	+	+	+	+	+
	240	72	+	+	+	+	+	+

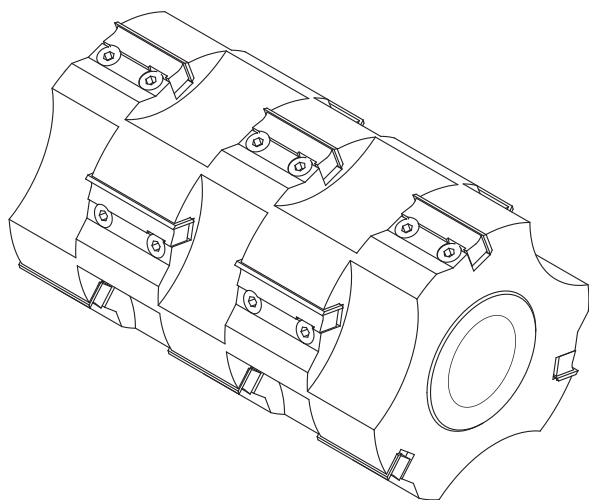
Catalogue number	Type	Body	D mm	B mm	d mm	z			
G509-080-2102P-B	G509	ST	80	100	30	2+2 (18)	HM	R	+
G509-100-0001P-B	G509	ST	100	125	40	2+2 (28)	HM	R	+
G509-125-4242P-B	G509	ST	125	240	40	2+2 (46)	HM	R	+
G509-140-5163P-B	G509	ST	140	160	45	3+3 (48)	HM	R	+

Spare parts for cutter heads G509

Cat. nr	Name	Dimensions		Cat. nr	Name	Dimensions	
N0000733	Knife	15 x 15 x 2,5		WHAS00006	Screw	M6 x 10	

Above diameter D=140 mm, hydro clamping (d=50 mm) can be offered.

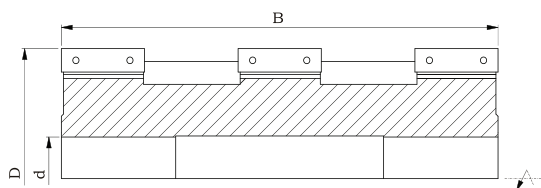
1100-14



Monolithic inserted planer head, type **1100-14** with suitable number of cutting teeth, designed for professional machining of solid wood. The cutter head is used for pre-planing. Regular insert size is 50x12x1,5 mm, but to increase cutter head size range it is possible to use inserts 40x12x1,5 mm and 60x12x1,5 mm. The body is made from steel or aluminum.

Type of work: pre-planing.

Material: solid hard wood.




D n _{max} d _{max} z	125 9000 50 2		125 9000 50 3		125 9000 50 4	
	B mm	ST AL	ST AL	ST AL	ST AL	ST AL
98		+ +	+ +	+ +	+ +	+ +
146		+ +	+ +	+ +	+ +	+ +
194		+ +	+ +	+ +	+ +	+ +
242		+ +	+ +	+ +	+ +	+ +

Catalogue number	Type	Body	D mm	B mm	d mm	z		
G114-125-4128-0	1100-14	ST	125	120	40	4	HM	+
G114-125-4014-0	1100-14	ST	125	146	40	2	HM	+
G114-125-4216-0	1100-14	ST	125	210	40	3	HM	+

Spare parts for cutter heads 1100-14

Cat. nr	Name	Dimensions	
N0000810	Knife	50x12x1,5	

Cat. nr	Name	Dimensions	
WHAK00043	Clamping wedge	47x10,5x9	

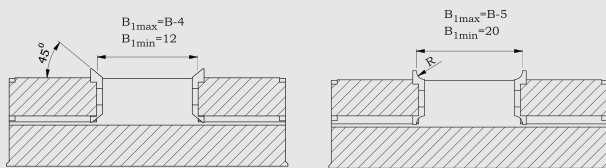
WHAS00011	Screw TOR 1011	M7x20	
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Planer head, type **1100-4** with suitable number of cutting teeth and additional grooving, rounding and beveling knives, designed for professional machining of solid wood. The cutter head is used for finishing flat surfaces and edge profiling of the machined material at the same time. The adjustment of knives height is made with springs. Optionally, the head can be equipped with knives FKB-45° and FKB-R. The body is made from steel or aluminum.

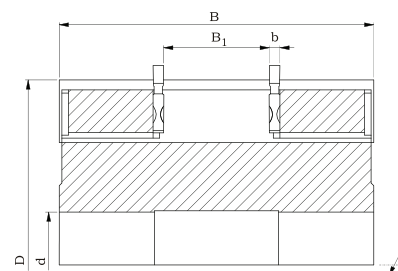
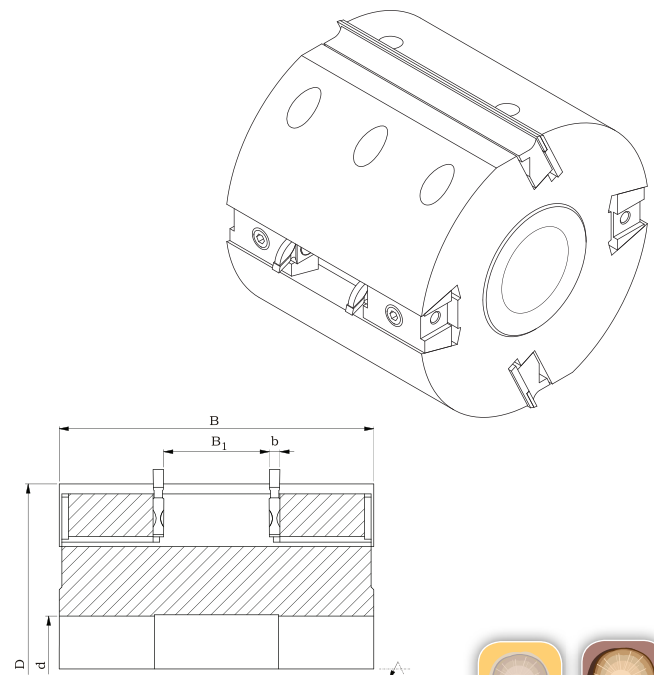
Type of work: pre-planing and planing with edge profiling.

Material: solid hard and soft wood.

1100-4 with profile knives



Optional solutions.












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D n _{max} d _{max} z	125 9000 40 4 s2+2		135 9000 40 2 s4+4		135 9000 40 3 s3+3		140 6000 40 3 s3+3		150 6000 50 3 s3+3		160 6000 60 4 s4+4	
B mm	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL
60	+	+	+	+	+	+	+	+	+	+	+	+
80	+	+	+	+	+	+	+	+	+	+	+	+
100	+	+	+	+	+	+	+	+	+	+	+	+
130	+	+	+	+	+	+	+	+	+	+	+	+
150	+	+	+	+	+	+	+	+	+	+	+	+
180	+	+	+	+	+	+	+	+	+	+	+	+
230	+	+	+	+	+	+	+	+	+	+	+	+

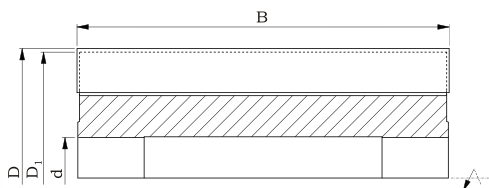
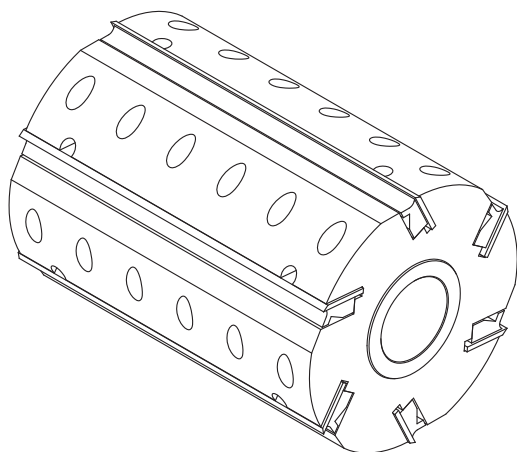
Catalogue number (without knives)	Type	Body	D mm	B mm	B ₁ mm	d mm	z	
G01-0735-3	1100-4	ST	140	130	10-130	40	2+2	+
G01-0382-3	1100-4	AL	140	130	10-140	40	2+2	+

Spare parts for cutter heads 1100-4

Cat. nr	Name	Dimensions		Cat. nr	Name	Dimensions	
	Knife	B x 30 x 3		WHAK00277	Clamping wedge	37 x 29 x 16	
	Hook knife	24 x 13 x b		WHAK00358	Clamping wedge FKB	37 x 29 x 16	
N0000870	Knife FKB-45°	16 x 22 x 5		WHAW00007	Nut DIN 915M	M10 x 20	
	Knife FKB-R	16 x 22 x 5		WHA100001	Spring	9,5 x 40	
	Clamping wedge	B-3 x 23 x 11					

Please give type of profile knives (page 8.11) and straight knives (page 8.6-8.7) with the order.

1100-4



Inserted planer head, type **1100-4** with suitable number of cutting teeth, designed for professional machining of solid wood. The cutter head is used for finishing flat surfaces. The adjustment of knives height is made with springs. The head 1100-4 is adapted to pre-planing materials with allowance up to 5 mm and planing materials with allowance up to 0,8 mm. The body is made from steel or aluminum.

Type of work: pre-planing and planing.

Material:

HSS solid soft wood

HM solid hard wood



D D ₁ n d _{max} z b (knife)	100 97 9000 30 3 3	125 122 9000 40 4 3	140 137 6000 50 4 3	160 157 6000 60 4 3	160 157 6000 60 6 3	180 177 6000 60 4 3	180 177 6000 60 6 3	180 177 6000 60 8 3
B mm	ST	AL	ST	AL	ST	AL	ST	AL
60	+	+	+	+	+	+	+	+
80	+	+	+	+	+	+	+	+
100	+	+	+	+	+	+	+	+
130	+	+	+	+	+	+	+	+
150	+	+	+	+	+	+	+	+
160	+	+	+	+	+	+	+	+
180	+	+	+	+	+	+	+	+
200	+	+	+	+	+	+	+	+
230	+	+	+	+	+	+	+	+

Catalogue number (without knives)	Type	Body	D mm	B mm	d mm	z
A104-122-4104-0	1100-4	ST	125	100	40	4
A104-122-4134-0	1100-4	ST	125	130	40	4
A104-122A4134-0	1100-4	AL	125	130	40	4
A104-122-4184-0	1100-4	ST	125	180	40	4
A104-122-4234-0	1100-4	ST	125	230	40	4
A104-122A4234-0	1100-4	AL	125	230	40	4

Spare parts for cutter heads 1100-4

Cat. nr	Name	Dimensions
	Knife	B x 30 x 3
	Clamping wedge	B-3 x 24 x 11

Cat. nr	Name	Dimensions
WHAW00007	Clamping screw	M10 x 20

Please, give knives type with the order - catalogue page 8.6 - 8.7.

Multi-teeth planer head, type **1100-5** with suitable number of cutting teeth, designed for professional machining of solid wood. The cutter head is used for pre-planing and planing. The adjustment of knives height is made with springs. Increased number of cutting teeth allows for higher feed speed, within the range of 80-180 m/min. and guarantees optimal workload of the machine spindle. The head 1100-5 is adapted to pre-planing materials with allowance up to 5 mm and planing materials with allowance up to 0,8 mm. The body is made from steel or aluminum.

Type of work: pre-planing and planing.

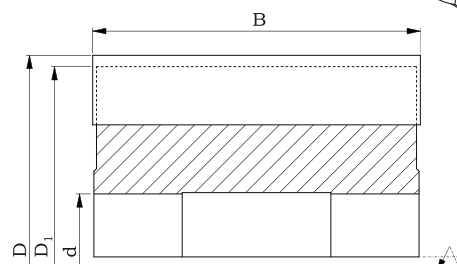
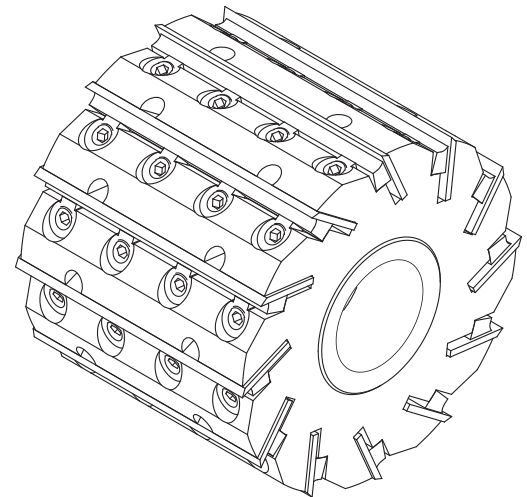
Material:

HSS solid soft wood

HM solid hard wood



1100-5



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D D ₁ n _{max} d _{max} z b (knife)	140		140		160		180		180		200		200	
	137		137		157		157		177		197		197	
	6000		6000		6000		6000		6000		6000		6000	
	50		50		60		60		60		60		60	
	8		10		10		10		12		14		16	
	3		3		3		3		3		3		3	
B mm	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL
60	+	+	+	+	+	+	+	+	+	+	+	+	+	+
80	+	+	+	+	+	+	+	+	+	+	+	+	+	+
100	+	+	+	+	+	+	+	+	+	+	+	+	+	+
130	+	+	+	+	+	+	+	+	+	+	+	+	+	+
150	+	+	+	+	+	+	+	+	+	+	+	+	+	+
160	+	+	+	+	+	+	+	+	+	+	+	+	+	+
180	+	+	+	+	+	+	+	+	+	+	+	+	+	+
200	+	+	+	+	+	+	+	+	+	+	+	+	+	+
230	+	+	+	+	+	+	+	+	+	+	+	+	+	+

Catalogue number (without knives)	Type	Body	D mm	B mm	d mm	z
A105-137-4158-0	1100-5	ST	140	150	40	8
A105-157-6131-0	1100-5	ST	160	130	50	10
A105-177-6135-0	1100-5	ST	180	130	50	12

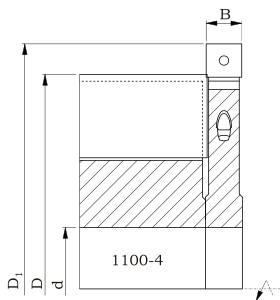
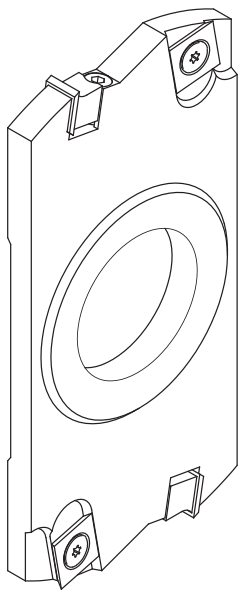
Spare parts for cutter heads 1100-5

Cat. nr	Name	Dimensions
	Knife	B x 30 x 3
	Clamping wedge	B-3 x 24 x 11

Cat. nr	Name	Dimensions
WHAS00046	Screw	M10 P/L x 22
WHA101398	Nut	Ø15 x 15,5 x 13

Please, give knives type with the order - catalogue page 8.6 - 8.7.

G103



Inserted cutter head, type **G103** with two cutting teeth and two left or two right spurs ($z=2 \text{ v}2$), designed for professional machining of solid wood. The cutter head is used for edge formatting. Special body design enables the head to work together with planer heads type 1100-4. The body is made from steel or aluminum.

Type of work: edge formatting.

Material: solid hard wood, solid soft wood.

D1 d _{max} n _{max} z	145 40 9000 2 v2		165 50 6000 2 v2	
	B mm	ST	AL	AL
12,2	+	+	+	+
15,2	+	+	+	+



Catalogue number	Type	Body	D1 mm	D mm	B mm	d mm	z		
G103-145-0003L-0	G103	ST	145	140	12,2	40	2 v2	HM	+
G103-165-0003L-0	G103	ST	165	160	12,2	40	2 v2	HM	+
G103-165-0004L-0	G103	ST	165	160	15,2	40	2 v2	HM	+

Spare parts for cutter heads G103

Cat. nr	Name	Dimensions		
	Knife	B-0,4 x 12 x 1,5		•
N0000818	Knife	14 x 14 x 2		•
	Clamping wedge	B-2 x 10 x 9		•

Cat. nr	Name	Dimensions		
WHAS00007	Screw TOR 1262	M5x23		•
WHAS00008	Screw TOR 1064	M5x6,5		•

GP-01

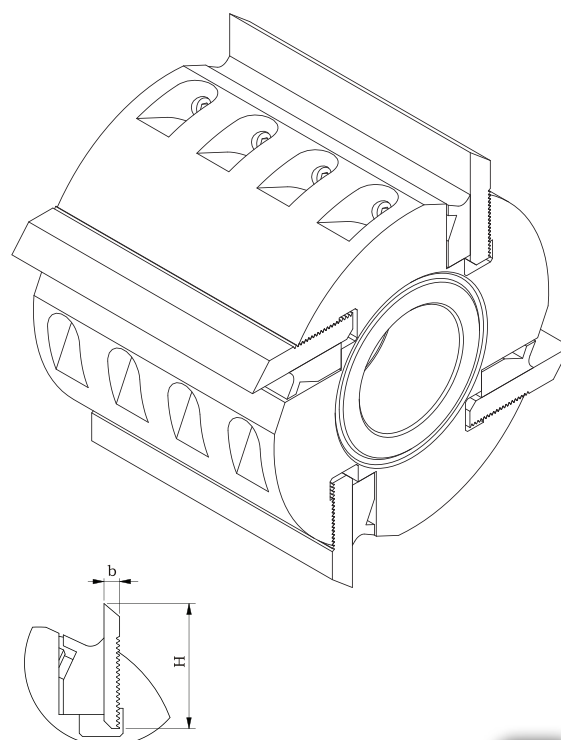
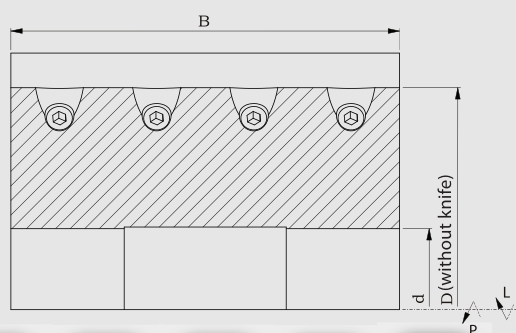
Profile serrated head, type **GP-01** with suitable number of cutting teeth, designed for professional machining of solid wood. The cutter head is used for surface profiling. The adjustment of knives height is made with precise serration. The head GP-01 work with knives with thickness 4, 5, 8 or 10 mm. The body is made from steel or aluminum.

Type of work: profiling.

Material:

HSS solid soft wood

HM solid hard wood



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D n ^{max} d ^{max} z	122 9000 40 2		122 9000 40 4		122 9000 40 6		137 6000 40 2		137 6000 40 4		
	B mm	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL
40		+	+	+	+	+	+	+	+	+	+
50		+	+	+	+	+	+	+	+	+	+
60		+	+	+	+	+	+	+	+	+	+
80		+	+	+	+	+	+	+	+	+	+
100		+	+	+	+	+	+	+	+	+	+
120		+	+	+	+	+	+	+	+	+	+
150		+	+	+	+	+	+	+	+	+	+
160		+	+	+	+	+	+	+	+	+	+
180		+	+	+	+	+	+	+	+	+	+
200		+	+	+	+	+	+	+	+	+	+

Catalogue number (without knives)	Type	Body	D mm	B mm	d mm	z
GP01-122-4064-A	GP-01	ST	122	60	40	4 •
GP01-122-4084-A	GP-01	ST	122	80	40	4 •
GP01-122-4104-A	GP-01	ST	122	100	40	4 •

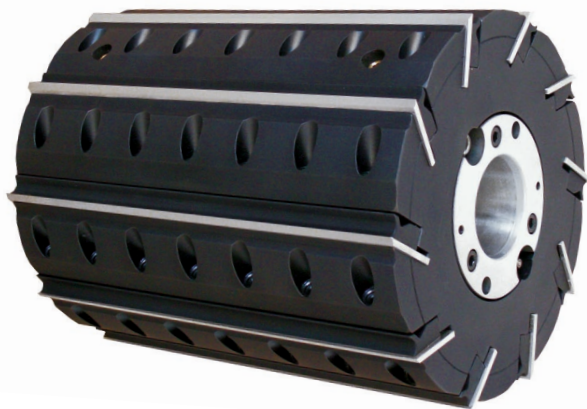
Spare parts for cutter heads GP-01

Cat. nr	Name	Dimensions
	Knife	B x 50 x b •
	Clamping wedge	B x 25,5 x 13 •

Cat. nr	Name	Dimensions
WHAW00007	Screw DIN 915	M10x20 •

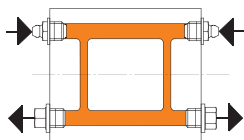
Please, give type and thickness of cutting knives with the order. Knives can be found on page 8.4 (HSS knives) and 8.5 (knives with HM insret) of the catalogue.

Hydro cutter heads



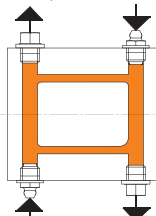
Hydro cutter heads pressure filling systems

System A



Standard

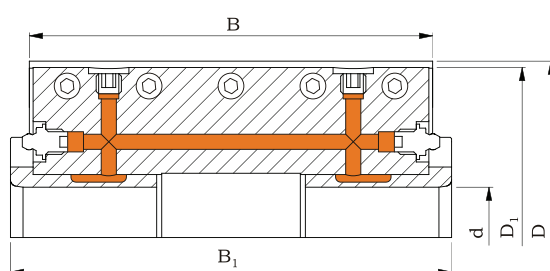
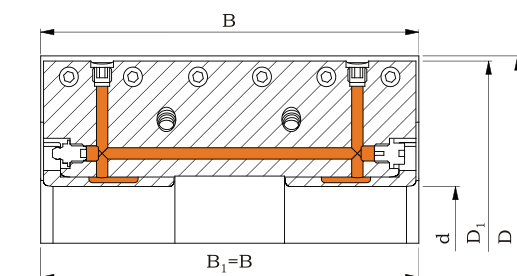
System B



On request

Construction specification of hydro cutter heads

for	B_1 mm
$D < 160$	-
$D \geq 160$ $B \leq 130$	$B + 15$
$D \geq 160$ $B > 130$	B



Hydro cutter heads are cutter heads with hydraulic clamping system designed for professional, very precise machining of solid wood. The tools mounted on hydro sleeve have been used for precise cutting of flat surfaces as well as for profiling. The construction of tools with hydro clamping guarantees tolerance of radial run-out reduced to minimum as fitting tolerance after installing the system on the machine spindle (developing pressure 300 bar) equals to zero. This automatically results in very precise positioning of the tool on the machine spindle. The hydro system which also allows for perfect balancing of the tools, apart from very high machined surface quality, enables working with high cutting and feed speed. Even wear of all the blades guarantees significantly increased life of the tool.

Hydro cutter heads are used for finishing (allowance up to 0,8 mm) and pre-planing (allowance up to 5 mm).

As standard, hydro cutter heads are offered according to pressure filling system type A. On client's request, we offer hydro system according to pressure filling system type B.

Hydro cutter heads chapter includes only example positions of straight (1100-4H and 1100-5H) and profile (GP-01H) cutter heads. We offer also spiral cutter heads in hydro version. On request, we can suggest and manufacture a proper cutter head for the required type of work, material, parameters and conditions during machining.

Maximum dimensions of hydro cutter heads:

$$D_{\max} = 400 \text{ mm}, B_{\max} = 400 \text{ mm}$$

Advantages:

- precise mounting of the tool on the machine spindle,
- narrowed radial run-out tolerance,
- very high quality of machined material surface,
- increased life of the tool,
- perfect balancing of the tool,
- low vibration level,
- quiet and steady running of the tool,
- ability to work with high speed cutting and feed speed up to 200 m/min.

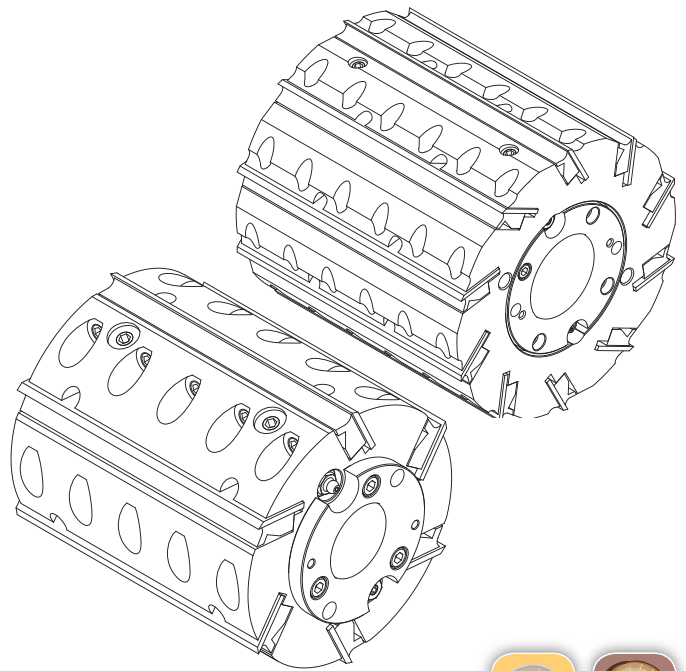
Hydro-planer head, type **1100-4H** with suitable number of cutting teeth, designed for professional machining of solid wood. The cutter head is used for very precise planing of flat surfaces. The adjusting of knives height is made with springs. The head 1100-4H is adapted to pre-planing materials with allowance up to 5 mm and finish planing materials with allowance up to 0,8 mm. Special geometry, hydro system and very precise balancing of the head allows for higher feed speed, up to 100 m/min and guarantees optimal workload of the machine spindle.

Type of work: pre-planing and precise planing.

Material:

- HSS** solid soft wood
HM solid hard wood

1100-4 H



5

D D ₁ n d _{max} z b (knife)	140/143 135 9000 40 4 3	160/163 155 9000 50 4 3	160/163 155 6000 50 6 3	180/183 175 6000 50 4 3	180/183 175 6000 50 6 3	180/183 175 6000 50 8 3	200/203 195 6000 50 8 3	200/203 195 6000 50 10 3	200/203 195 6000 50 12 3
B mm	ST	ST	ST	ST	ST	ST	ST	ST	ST
60	+	+	+	+	+	+	+	+	+
80	+	+	+	+	+	+	+	+	+
100	+	+	+	+	+	+	+	+	+
130	+	+	+	+	+	+	+	+	+
150	+	+	+	+	+	+	+	+	+
160	+	+	+	+	+	+	+	+	+
180	+	+	+	+	+	+	+	+	+
200	+	+	+	+	+	+	+	+	+
230	+	+	+	+	+	+	+	+	+

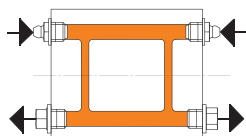
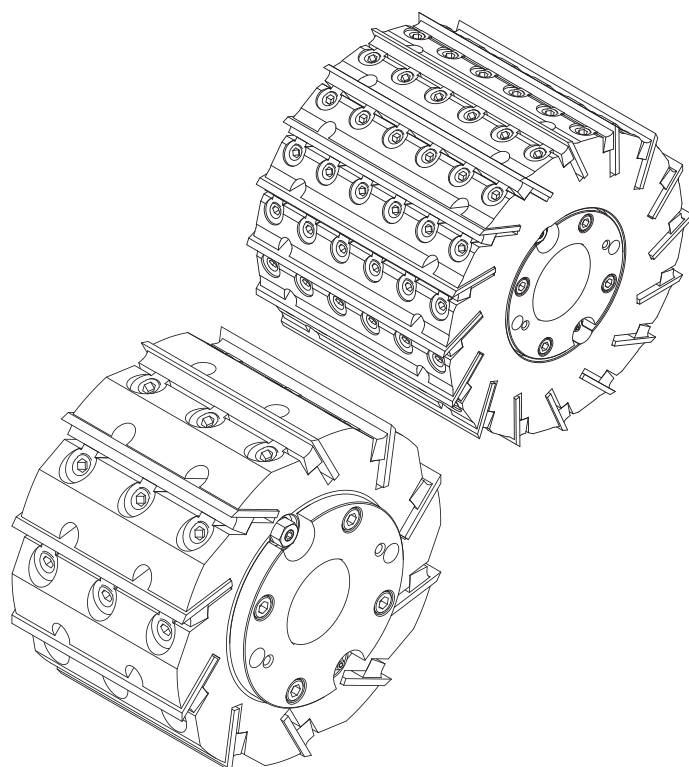
Catalogue number (without knives)	Type	Body	D mm	B mm	d mm	z	
A104-155S6106-0	1100-4 H	ST	160	100	50	6	+
A104-155S6136-0	1100-4 H	ST	160	130	50	6	+
A104-155S6166-0	1100-4 H	ST	160	160	50	6	+
A104-155S6186-0	1100-4 H	ST	160	180	50	6	+
A104-155S6234-0	1100-4 H	ST	160	230	50	4	+

Spare parts for cutter heads 1100-4H

Cat. nr	Name	Dimensions		Cat. nr	Name	Dimensions	
	Knife	B x 30 x 3		WHAW00012	Screw	M10 x 1 x 20	
	Clamping wedge	B-3 x 24 x 11					

Please, give type of knives with the order - catalogue page 8.7.

1100-5 H





1100-5H are offered with standard pressure filling system type A only.

Multi-teeth hydro-planer head, type **1100-5H** with suitable number of cutting teeth, designed for professional machining of solid wood. The cutter head is used for very precise planing of flat surfaces. The adjustment of knives height is made with springs. Increased number of cutting teeth, hydro system and very precise balancing of head allows for higher feed speed, within the range 80-200 m/min and guarantees optimal workload of the machine spindle. The head 1100-5H is adapted to pre-planing materials with allowance up to 5 mm and planing materials with allowance up to 0,8 mm.

Type of work: pre-planing and precise planing.

Material:

-  solid soft wood
-  solid hard wood

D	160/163	180/183	200/203
D ₁	155	175	195
n _{max}	6000	6000	6000
d _{max}	50	50	50
z	10	12	16
b (knife)	3	3	3
B mm	ST	ST	ST
60	+	+	+
80	+	+	+
100	+	+	+
130	+	+	+
150	+	+	+
160	+	+	+
180	+	+	+
200	+	+	+
230	+	+	+



Catalogue number (without knives)	Type	Body	D mm	B mm	d mm	z
A105-155S4101-0	1100-5 H	ST	160	100	40	10
A105-155S6151-0	1100-5 H	ST	160	150	50	10
A105-155S6231-0	1100-5 H	ST	160	230	50	10
A105-195S6169-0	1100-5 H	ST	200	160	50	16

Spare parts for cutter heads 1100-5H

Cat. nr	Name	Dimensions
	Knife	B x 30 x 3
	Clamping wedge	B-3 x 24 x 11

Cat. nr	Name	Dimensions
WHAS00046	Screw	M10 P/L x 22
WHA101398	Nut	Ø15 x 15,5 x 13

Please, give type of knives with the order - catalogue page 8.7.

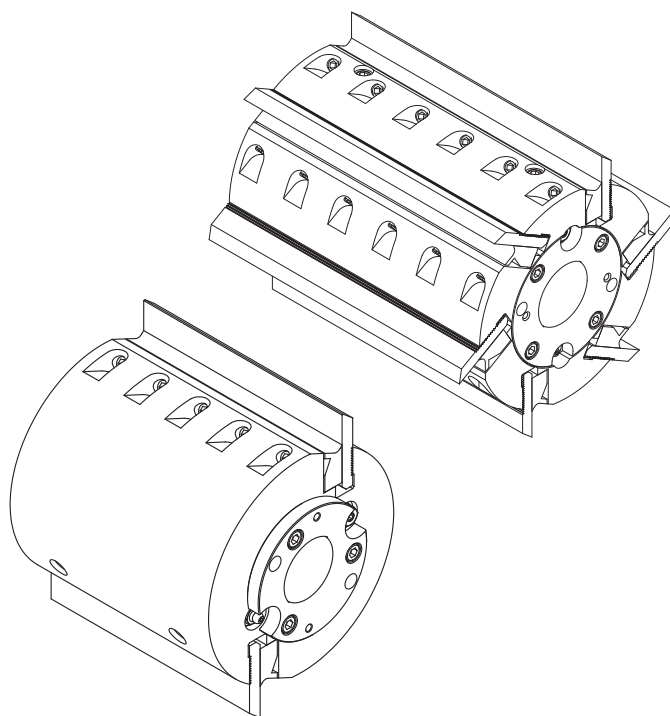
Hydro-serrated head, type **GP-01H** with suitable number of cutting teeth, designed for professional machining of solid wood. The cutter head is used for very precise profiling of flat surfaces. The adjustment of knives height is made with precise serration. The head GP-01 works with the knives with thickness 4, 5, 8 or 10 mm. Special geometry, hydro system and very precise balancing of the head allow for higher feed speed and guarantee optimal workload of the machine spindle.

Type of work: profiling.

Material:

- HSS** solid soft wood
HM solid hard wood

GP-01 H





5




D n _{max} d _{max} z	150 6000 40 4	150 6000 40 6	150 6000 40 8	160 6000 50 4	160 6000 50 6	160 6000 50 8	170 6000 50 8	180 6000 50 8
B mm	ST	ST	ST	ST	ST	ST	ST	ST
60	+	+	+	+	+	+	+	+
80	+	+	+	+	+	+	+	+
100	+	+	+	+	+	+	+	+
150	+	+	+	+	+	+	+	+
160	+	+	+	+	+	+	+	+
200	+	+	+	+	+	+	+	+
230	+	+	+	+	+	+	+	+

Catalogue number (without knives)	Type	Body	D mm	B mm	d mm	z	
GP01-150S6066-A	GP-01 H	ST	150	60	50	6	+
GP01-150S6104-A	GP-01 H	ST	150	100	50	4	+
GP01-160S6066-A	GP-01 H	ST	160	60	50	6	+
GP01-160S6106-A	GP-01 H	ST	160	100	50	6	+
GP01-160S6158-A	GP-01 H	ST	160	150	50	8	+

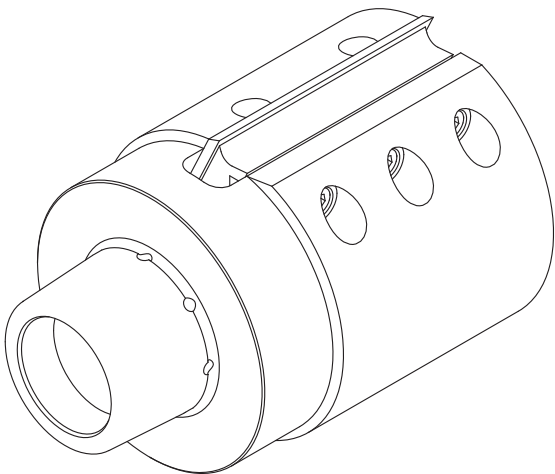
Spare parts for cutter heads GP-01 H

Cat. nr	Name	Dimensions	
	Knife	B x 50 x 8	
	Clamping wedge	B x 25,5 x 13	

Cat. nr	Name	Dimensions	
WHAW00012	Screw DIN 915	M10 x 1 x 20	

Please, give type and thickness of cutting knives with the order. Knives can be found on page 8.4 (HSS knives) and 8.5 (knives with HM insret) of the catalogue.

1100-4 L



Planer head with HSK-85WS clamping, type **1100-4 L** with suitable number of cutting teeth, used for professional machining of solid wood. The cutter head is designed for very precise planing of flat surfaces. The adjustment of knives height is made with springs. Precise HSK 85 WS clamping and very precise balancing of head allows for higher feed speed and higher rotation speed, up to 12 000 rpm.

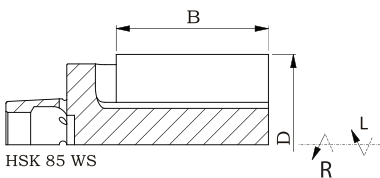
Type of work: pre-planing and precise planing.

Material:

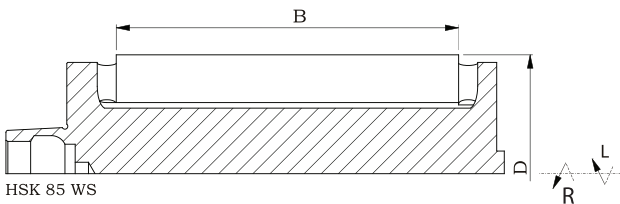
- HSS** solid soft wood
- HM** solid hard wood

5

B<100 mm




B≥100 mm



D z	95 2	95 4	125 2	125 4
B mm	ST	ST	ST	ST
60	+	+	+	+
80	+	+	+	+
100	+	+	+	+
130	+	+	+	+
150	+	+	+	+
180	+	+	+	+
200	+	+	+	+
230	+	+	+	+



Spare parts for cutter heads 1100-4

Cat. nr	Name	Dimensions	
	Knife	B x 30 x 3	 •
	Clamping wedge	B-3 x 24 x 11	 •

Cat. nr	Name	Dimensions	
WHAW00012	Screw	M10 x 1 x 20	 •

Please, give type of knives with the order - catalogue page 8.7.

Serrated head with HSK 85 WS clamping, type **GPL-01** with suitable number of cutting teeth, designed for professional machining of solid wood. The cutter head is used for very precise profiling. The adjustment of knives height is made with precise serration. The head GP-01 works with knives with thickness 8 or 10 mm. Precise HSK 85 WS clamping increased accuracy of rotation movement and very precise balancing of the head allows for higher feed speed and higher rotation speed, up to 12 000 rpm.

Type of work: precise profiling.

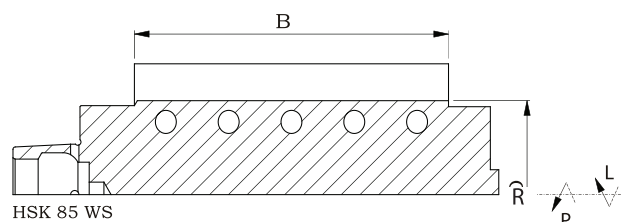
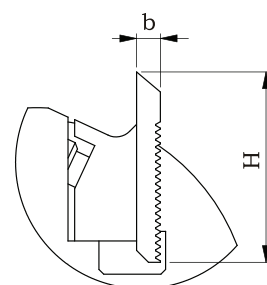
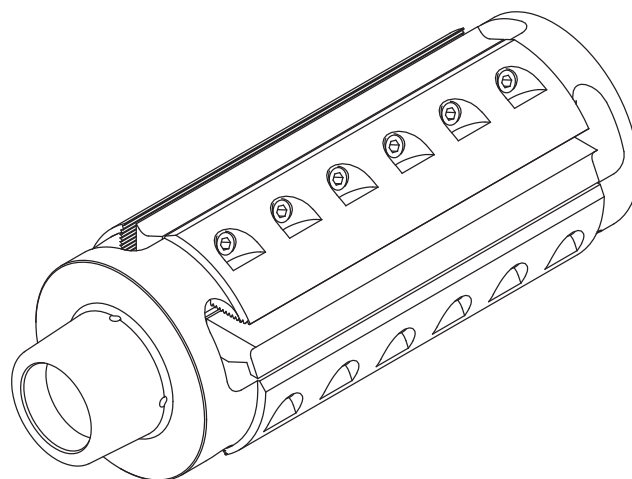
Material:

- HSS** solid soft wood
HM solid hard wood

D z	90 2	90 4
B mm	ST	ST
60	+	+
80	+	+
100	+	+
130	+	+
150	+	+
180	+	+
200	+	+
230	+	+






GPL-01



Catalogue number (without knives)		Typ	D mm	B mm		z	
right	left						
GPL01-090-064P-B	GPL01-090-064L-B	GPL-01	90	60	HSK 85	4	+
GPL01-090-084P-B	GPL01-090-084L-B	GPL-01	90	80	HSK 85	4	+
GPL01-090-104P-B	GPL01-090-104L-B	GPL-01	90	100	HSK 85	4	+
GPL01-090-134P-B	GPL01-090-134L-B	GPL-01	90	130	HSK 85	4	+
GPL01-090-154P-B	GPL01-090-154L-B	GPL-01	90	150	HSK 85	4	+
GPL01-090-184P-B	GPL01-090-184L-B	GPL-01	90	180	HSK 85	4	+
GPL01-090-234P-B	GPL01-090-234L-B	GPL-01	90	230	HSK 85	4	+

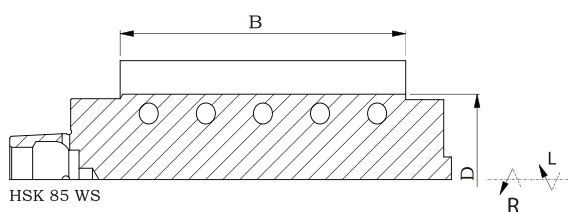
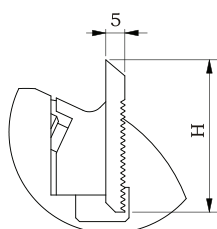
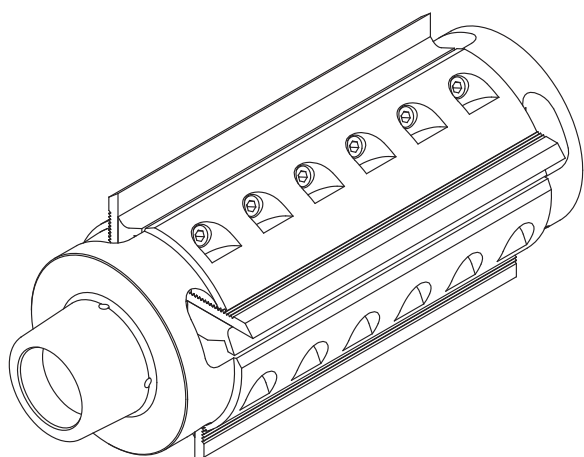
Spare parts for cutter heads GPL-01

Cat. nr	Name	Dimensions	
	Knife	B x 50 x 8	
	Clamping wedge	B x 25,5 x 13	

Cat. nr	Name	Dimensions	
WHAW00012	Screw DIN 915	M10 x 1 x 20	

Please, give type and thickness of cutting knives with the order. Knives can be found on page 8.4 (HSS knives) and 8.5 (knives with HM insret) of the catalogue.

GPL-03



Serrated head with HSK 85 WS clamping, type **GPL-03** with suitable number of cutting teeth, designed for professional machining of solid wood. The cutter head is used for very precise surface profiling. The adjustment of knives height is made with precise serration. The head GP-01 works with knives with thickness 5 mm. Precise HSK 85 WS clamping and very precise balancing of the head allows for higher feed speed and higher rotation speed, up to 12 000 rpm.

Type of work: precise profiling.

Material:

HSS solid soft wood

HM solid hard wood

D z	90 2	90 4
B mm		
60	+	+
80	+	+
130	+	+
170	+	+
230	+	+
240	+	+



Catalogue number (without knives)		Typ	D mm	B mm		z	
right	left						
GPL03-090-064P-A	GPL03-090-064L-A	GPL-03	90	60	HSK 85	4	+
GPL03-090-084P-B	GPL03-090-084L-B	GPL-03	90	80	HSK 85	4	+
GPL03-090-134P-B	GPL03-090-134L-B	GPL-03	90	130	HSK 85	4	+
GPL03-090-174P-B	GPL03-090-174L-B	GPL-03	90	170	HSK 85	4	+
GPL03-090-234P-B	GPL03-090-234L-B	GPL-03	90	230	HSK 85	4	+
GPL03-090-244P-B	GPL03-090-244L-B	GPL-03	90	240	HSK 85	4	+

Spare parts for cutter heads GPL-03

Cat. nr	Name	Dimensions		
	Knife	B x 40 x 5		•
	Clamping wedge	B x 25,5 x 13		•

Cat. nr	Name	Dimensions		
WHAW00012	Screw	M10 x 1 x 20		•

Please, give type and thickness of cutting knives with the order. Knives can be found on page 8.4 (HSS knives) and 8.5 (knives with HM insret) of the catalogue.

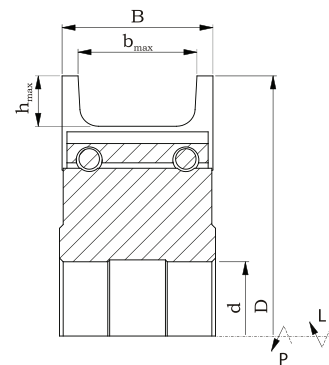
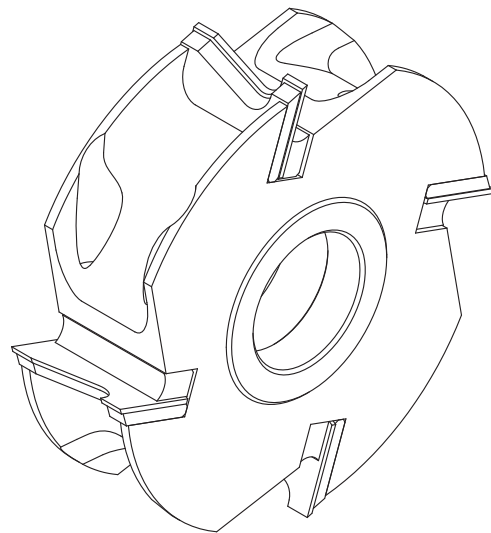
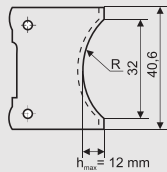
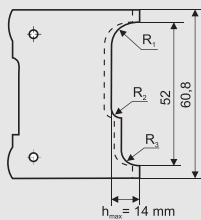
GPU-01

Universal profile inserted head, type **GPU-01** with suitable number of cutting teeth, designed for professional machining of wood and wood-based materials such as chipboard, MDF and others. The cutter head is used for profiling. The profiles are manufactured according to individual customer request and their dimensions have to be adapted to the sizes of insert, which are shown on the drawing below. Design of universal head, except profile knives, contains also support-inserts with shape adapted to the profile knives. The body is made from steel or aluminum.

Type of work: profiling.

Material: solid hard wood, chipboard, MDF.

Maximum dimensions of blades profile for width 60 mm and 40 mm.



D n d ^{max} b ^{max} z	125 9000 40 32-52 2-6		150 9000 60 32-52 2-6		180 6000 60 32-52 4		200 6000 60 32-52 4	
B mm	ST AL		ST AL		ST AL		ST AL	
40	+	+	+	+	+	+	+	+
60	+	+	+	+	+	+	+	+

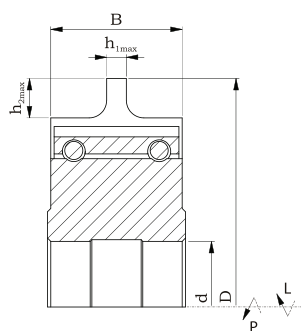
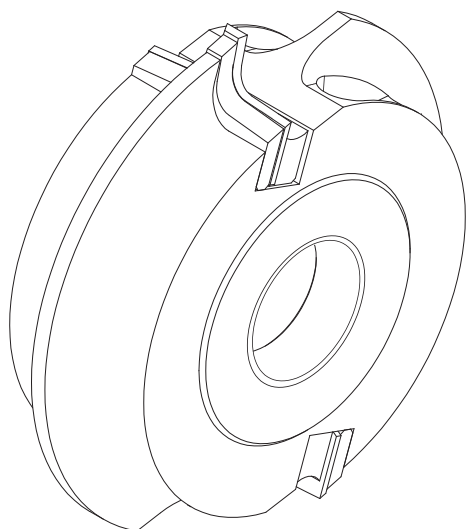
Catalogue number (without inserts)	Type	Body	D mm	B mm	b _{max} mm	d mm	z		
GU01-125-4404P-0	GPU-01	ST	125	40	32	40	4	HM	+
GU01-125-4604P-0	GPU-01	ST	125	60	52	40	4	HM	+
GU01-140-4404P-0	GPU-01	ST	140	40	32	40	4	HM	+
GU01-180-4404P-0	GPU-01	ST	180	40	32	40	4	HM	+
GU01-180-4604P-0	GPU-01	ST	180	60	52	40	4	HM	+

Spare parts for cutter heads GPU-01, B=60

Cat. nr	Name	Dimensions		
	Knife	B x 30 x 1,5		•
	Clamping wedge	B-2x12x8		•

Cat. nr	Name	Dimensions		
	Support insert	60,8 x 28 x 4		•
WHAW00005	Screw DIN 915	M8x16		•

GPU-02



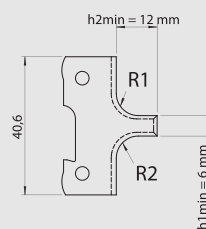
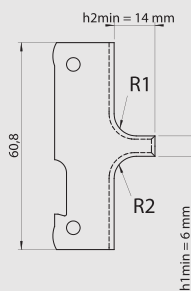
Universal profile inserted head, type **GPU-02** with two, three or four cutting teeth, designed for professional machining of wood and wood-based materials such as chipboard, MDF and others. The cutter head is used for profiling. The profiles are manufactured according to individual customer request and their dimensions have to be adapted to the sizes of insert, which are shown on the drawing below. Design of universal head, except profile knives, contains also support-inserts with shape adapted to the profile knives. The body is made from steel or aluminum.

Type of work: profiling.

Material: solid hard wood, glued wood, chipboard, MDF.

D	125		150		180		200	
n	9000		9000		6000		6000	
d ^{max}	35		60		60		60	
z	2		3		3		4	
B mm	ST	AL	ST	AL	ST	AL	ST	AL
40	+	+	+	+	+	+	+	+
60	+	+	+	+	+	+	+	+

Maximum dimensions of blades profile for width 60 mm and 40 mm.



Catalogue number (without inserts)	Type	Body	D mm	B mm	d mm	z		
GU02-125-3402P-0	GPU-02	ST	125	40	35	2	HM	+
GU02-150-2403P-0	GPU-02	ST	150	40	30	3	HM	+

Spare parts for cutter heads GPU-02

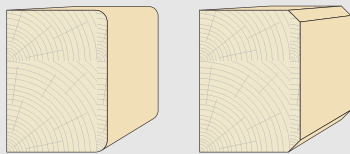
Cat. nr	Name	Dimensions		
	Knife	Bx27,5x1,5		•
	Clamping wedge	B-2x12x8		•

Cat. nr	Name	Dimensions		
WHAW00004	Screw DIN 915	M6x16		•

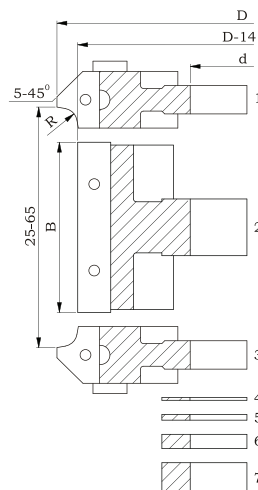
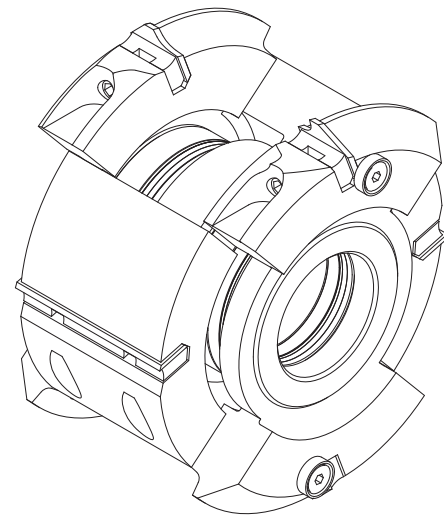
Set of adjustable inserted heads, type **GFP-06** with suitable number of cutting teeth, designed for professional machining of wood and wood-based materials such as chipboard, MDF and others. The set is used for edge rounding and beveling of the machined elements Increased regulation range. Width is regulated with spacer rings included in the set.

Type of work: edge profiling, rounding, beveling.

Material: solid wood, chipboard, MDF.



Nr	D mm	B mm	d _{max} mm	Rmm/°	n _{max}	↗	
1.	134	20	50	5/45°	9000	L	+
2.	120	60	50	5/45°	9000		+
3.	134	20	50	5/45°	9000	R	+
4.	70	1	50	Distance ring 1 pc.			+
5.	70	2	50	Distance ring 2 pcs.			+
6.	70	5	50	Distance ring 3 pcs.			+
7.	70	10	50	Distance ring 2 pcs.			+



D	114		125		134		134		140		160		160		180		180	
n	9000		9000		9000		9000		6000		6000		6000		6000		6000	
d	35		40		50		50		50		50		50		50		50	
max																		
z	2		2		2		3		4		3		4		4		6	
B mm	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL	ST	AL
25-65	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+

Catalogue number	Type	Body	D mm	d mm	R mm/°	z		
GF06-0263-00	GFP-06	ST	114	35	5/45°	2	HM	+
GF06-0006-00	GFP-06	ST	134	35	5/45°	2	HM	+
GF06-0003-00	GFP-06	ST	134	40	5/45°	2	HM	+

Spare parts for set of cutter heads GFP-06

Cat. nr	Name	Dimensions		Cat. nr	Name	Dimensions	
N0000811	Straight knife	60x12x1,5		WHAT00358	Weating sleeve	12x6,5x2,5	
N0000902 N0000903	Profile knife P/L	20x20x2		WHAS00006	Screw TOR 1128	M6x10	
WHAK00033	Support block	16x10x9		WHAS00011	Screw TOR 1011	M7x20	
WHAK00159	Support block	58x11,5x5,8		WHAW00004	Push screw	M6x16	