

6. Shank tools

Shank tools

Shank tools offered as cutters with brazed HSS or HM tips, cutter heads with exchangeable inserts and spiral monolithic cutters. Shank cutters with tips from high speed steel (HSS) designed for professional machining of solid soft wood and with carbide (HM) tips designed for professional machining of solid soft and hard wood, glued wood and other wood-based materials. They are used for through and dowel drilling, grooving, rebating, edge profiling and nesting.

Shank cutters and cutter heads are made from the highest quality high speed cutting steel in special heat treatment technology, 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. Monolithic spiral cutters are made entirely from carbide in advanced profile sharpening technology.

The tools are designed and produced with or without shear angle and optimized chip flow as well as geometry guaranteeing chip flow up or down, depending on needs, in case of monolithic shank cutters. Very precise balancing of the tools allows for working with rotation speed up to 24 000 r.p.m. All shank tools are designed mostly for CNC machines.

All types of cutters and cutter heads are manufactured on modern CNC machines of world-renowned producers, which guarantee high accuracy and precision of the produced tools. The construction and production remains in accordance with all points of safety standard EN/PN-847-1 concerning tools for mechanical woodworking.

The *Shank tools* chapter includes only example types of cutters and cutter heads and sets of cutter heads with basic dimensions. On request, we can suggest, design and manufacture a proper tool for the required type of work, material, parameters and conditions during machining. The production time of catalogue cutters or sets indicated with "+" as well as special tools made on client's request, in most cases does not take more than 10-15 working days.

Orders should include:

- outer diameter (D) or diameters range,
- shank diameter (d),
- shank length (s),
- 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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Pictograms



solid dry softwood



solid dry hardwood



chipboard



glued wood



MDF



plastics



grooving



edge machining



profiling



rebating



finishing



formatting



engraving



through drilling



dowel drilling



step drilling



counterboring



chip breaking



mechanical feed



manual feed



high-speed cutting steel



carbide



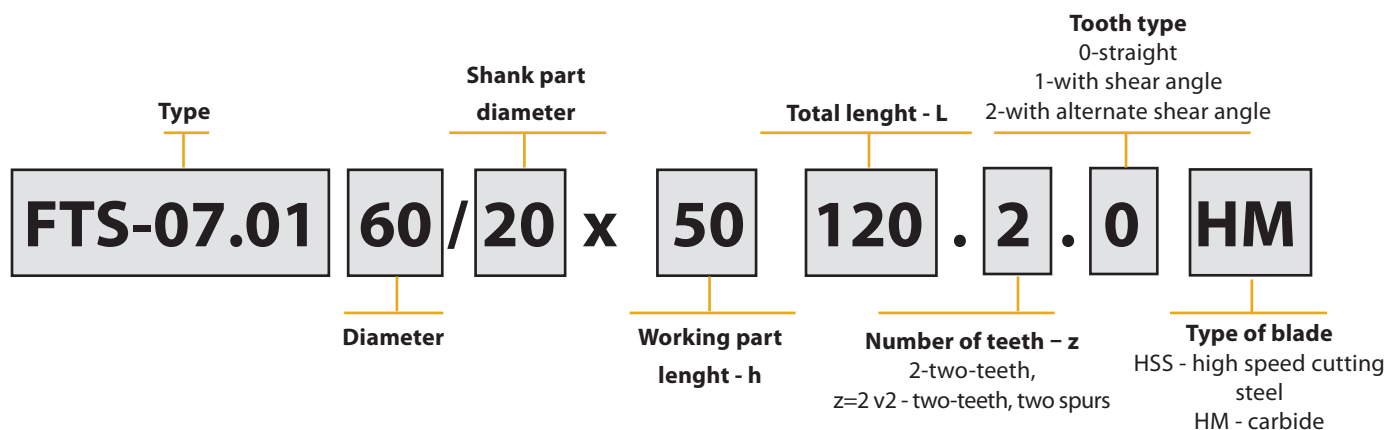
carbide monolith



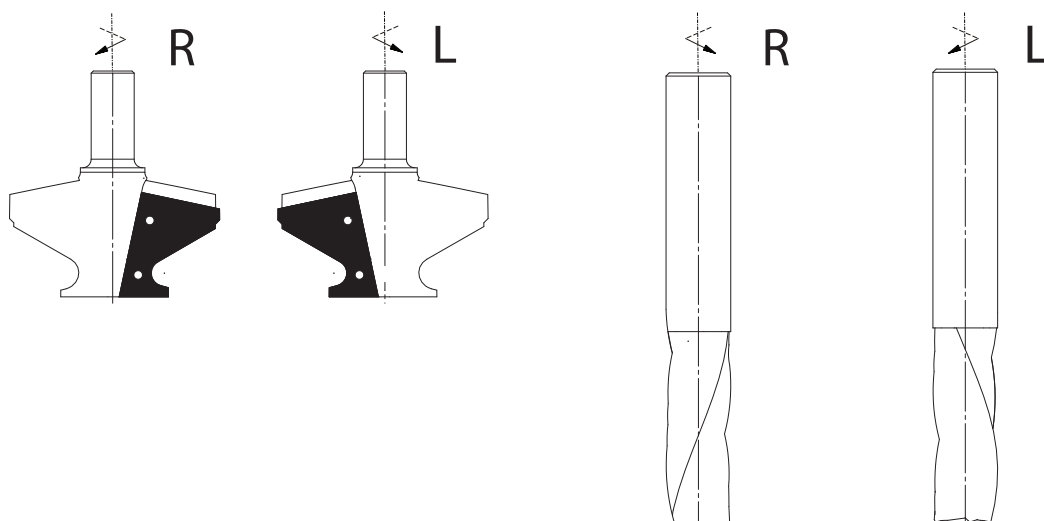
CNC

- available / stock product
 - + production time 10–15 working days.
- Minimum order for shank cutters and cutter heads - 1 pc.
Minimum order for THM - 3 pcs.

Shank tools coding system



Rotation direction



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Basic cutting parameters

Cutting speed V_c

$$V_c = \frac{D \times n \times \pi}{60\,000} \text{ [m/s]}$$

D - tool diameter [mm]

n - rotation speed [1/min]

p_z - feed per tooth [mm]

p_{\min} - feed per minute [m/min]

z - number of teeth

$\pi = 3,14$

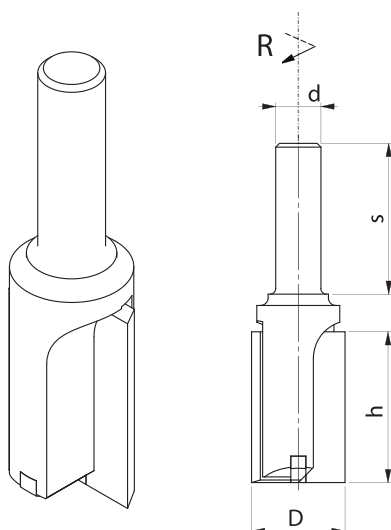
Feed p_{\min} / p_z

$$p_{\min} \text{ [m/min]} \longleftrightarrow p_z \text{ [mm/tooth]}$$

$$p_{\min} = \frac{p_z \times n \times z}{1\,000}$$

$$p_z = \frac{p_{\min} \times 1\,000}{n \times z}$$

TW-01-2



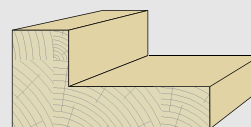
Straight shank cutter, type **TW-01-2** with two cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for longitudinal cutting – formatting or rebating.

Type of work: formatting, rebating.

Material:

HSS solid softwood

HM solid hardwood, glued wood, chipboard, MDF



| D n d ^{max} z | 12 24000 25 2 | | 14 24000 25 2 | | 16 24000 25 2 | | 18 24000 25 2 | | 20 24000 25 2 | | 25 24000 25 2 | | 30 24000 25 2 | | 40 24000 25 2 | |
|---------------------------------|------------------------|-----|------------------------|-----|------------------------|-----|------------------------|-----|------------------------|-----|------------------------|-----|------------------------|-----|------------------------|--|
| | h mm | HSS | HM | HSS | HM | HSS | HM | HSS | HM | HSS | HM | HSS | HM | HSS | HM | |
| 10 | + | + | + | + | + | + | + | + | + | + | + | + | + | + | + | |
| 15 | + | + | + | + | + | + | + | + | + | + | + | + | + | + | + | |
| 20 | + | + | + | + | + | + | + | + | + | + | + | + | + | + | + | |
| 25 | + | + | + | + | + | + | + | + | + | + | + | + | + | + | + | |
| 30 | + | + | + | + | + | + | + | + | + | + | + | + | + | + | + | |
| 40 | + | + | + | + | + | + | + | + | + | + | + | + | + | + | + | |
| 50 | | | + | + | + | + | + | + | + | + | + | + | + | + | + | |
| 60 | | | + | + | + | + | + | + | + | + | + | + | + | + | + | |

| Catalogue number | Type | D mm | dxs mm | h mm | L mm | z | |
|------------------|---------|------|--------|------|------|---|--------|
| TW.01-2.18/003 | TW-01-2 | 12 | 12x30 | 30 | 65 | 2 | HM R + |
| TW.01-2.38/001 | TW-01-2 | 14 | 12x30 | 30 | 60 | 2 | HM R + |
| TW.01-2.20/002 | TW-01-2 | 16 | 12x30 | 30 | 65 | 2 | HM R + |
| TW.01-2.45/002 | TW-01-2 | 18 | 12x30 | 30 | 65 | 2 | HM R + |
| TW.01-2.21/001 | TW-01-2 | 20 | 12x30 | 30 | 65 | 2 | HM R + |
| TW.01-2.23/001 | TW-01-2 | 25 | 12x30 | 30 | 65 | 2 | HM R + |
| TW.01-2.02/001 | TW-01-2 | 30 | 12x30 | 30 | 65 | 2 | HM R + |

TW-07

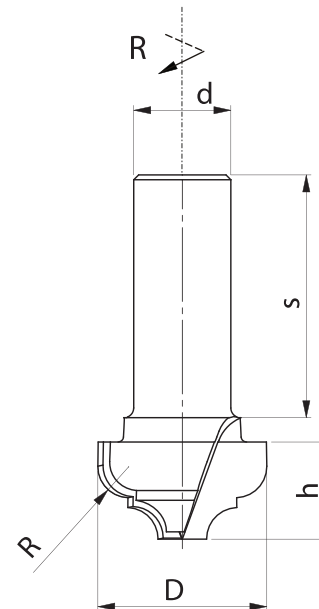
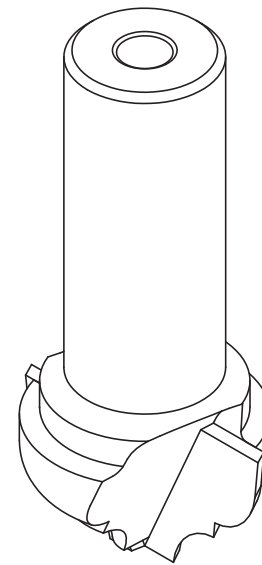
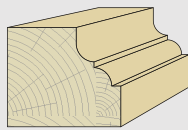
Profile shank cutter, type **TW-07** with two cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for surface profiling. Special blade geometry allows for dowel drilling.

Type of work: profiling, dowel drilling.

Material:

HSS solid softwood

HM hard wood, glued wood, chipboard, MDF

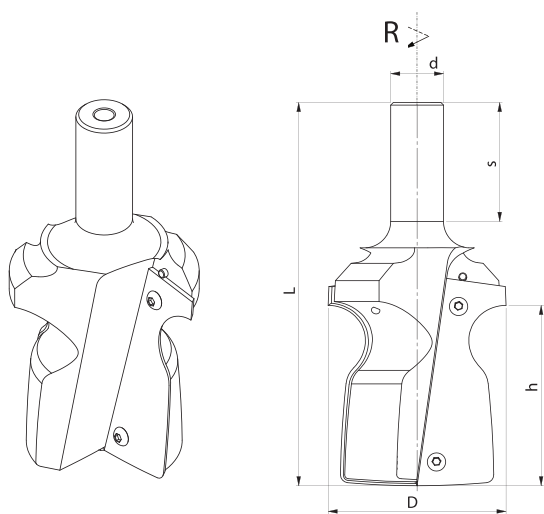


| D n _{max} d _{max} z | 35 24000 25 2 | | 40 24000 25 2 | | 55 24000 25 2 | | 70 24000 25 2 | |
|--|------------------------|-------|------------------------|-------|------------------------|-------|------------------------|---|
| | B mm | HSSHM | HSSHM | HSSHM | HSSHM | HSSHM | | |
| 20 | + | + | + | + | + | + | + | + |
| 25 | + | + | + | + | + | + | + | + |
| 30 | + | + | + | + | + | + | + | + |
| 35 | | | + | + | + | + | + | + |
| 40 | | | | | + | + | + | + |

| Catalogue number | Type | D mm | dxs mm | h mm | L mm | R mm | z | | | |
|------------------|-------|------|--------|------|------|-------|---|----|---|---|
| TW.07.01/001 | TW-07 | 35 | 10x30 | 20 | 55 | 2x6,5 | 2 | HM | R | + |
| TW.07.01/002 | TW-07 | 35 | 12x30 | 20 | 55 | 2x6,5 | 2 | HM | R | + |

Profile shank cutter head, type **FTS-01** or **FTS-10** with suitable number of cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head with body working with given blade profile (HM inserts). Cutter heads FTS-01 and FTS-10 are designed and produced only on client's individual request.

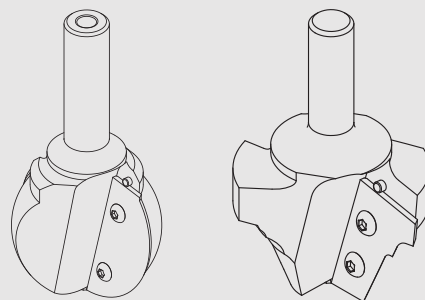
FTS-01 R or L



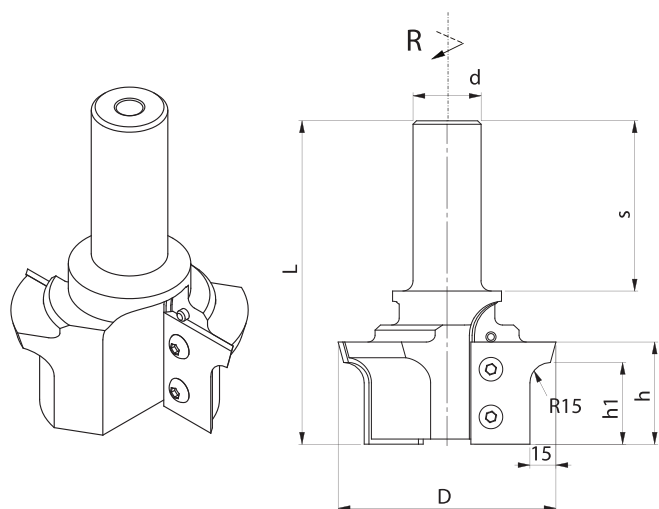
Cutter head **FTS-01** designed for surface profiling. Special blade geometry allows for dowel drilling.

Type of work: profiling, dowel drilling.

Material: solid hardwood, glued wood, chipboard, MDF and others.



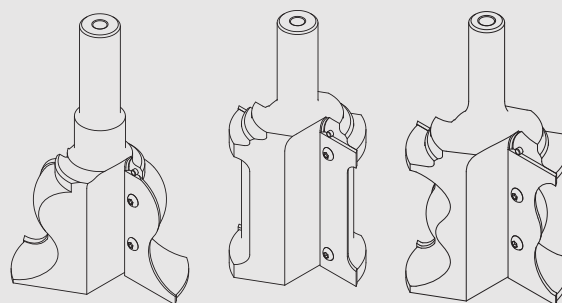
FTS-10 R or L



Cutter head **FTS-10** designed for surface profiling without dowel drilling ability.

Type of work: profiling without dowel drilling ability.

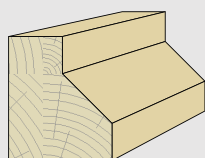
Material: solid hardwood, glued wood, chipboard, MDF and others.



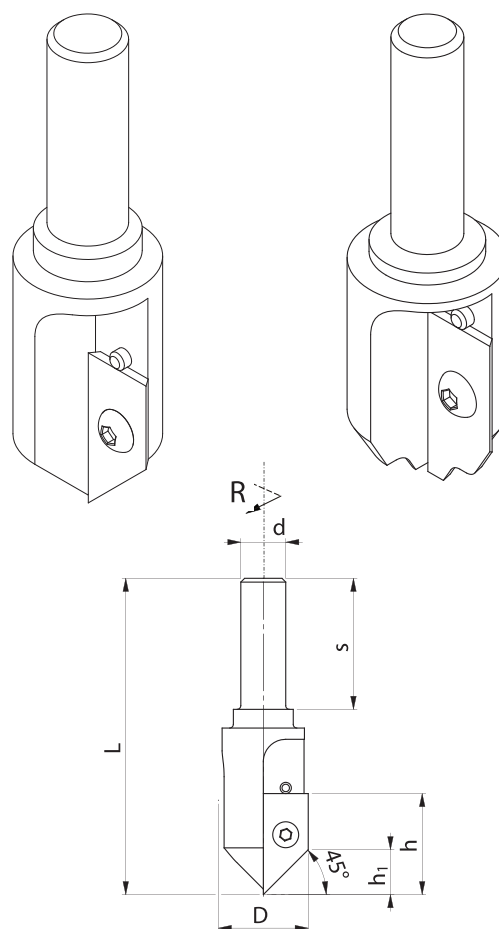
Profile shank cutter head, type **FTS-02** with one cutting tooth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head with body working with given blade profile (HM inserts) is used for surface profiling. Cutter heads FTS-02 are designed and produced only on client's individual request, within the range of $h_1=12$ mm.

Type of work: profiling, dowel drilling.

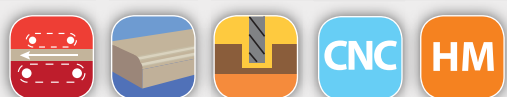
Material: solid hardwood, glued wood, chipboard, MDF and others.



FTS-02 R or L



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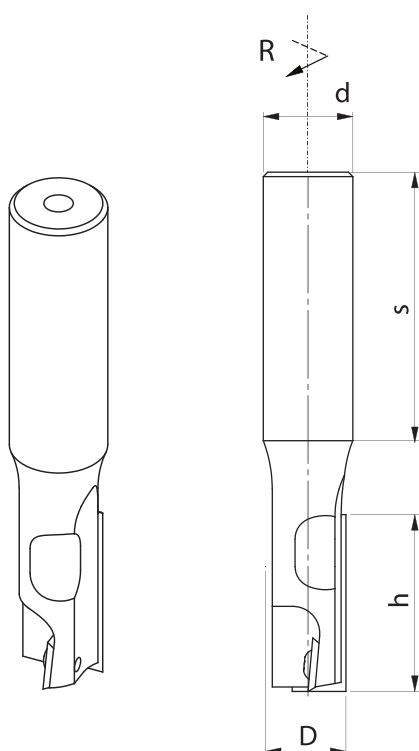
| | | | |
|------------------|-------|-------|-------|
| D | 20 | 22 | 24 |
| n _{max} | 24000 | 24000 | 24000 |
| d _{max} | 25 | 25 | 25 |
| z | 1 | 1 | 1 |
| h mm | | | |
| 27 | + | + | + |

| Catalogue number | Type | D mm | dxs mm | h mm | h ₁ mm | L mm | ∠ | z | | ↗ | |
|------------------|--------|------|--------|------|-------------------|------|-----|---|----|---|---|
| FTS.02.01/001 | FTS-02 | 24 | 12 | 27 | 12 | 83 | 45° | 1 | HM | R | + |
| FTS.02.01/002 | FTS-02 | 24 | 25 | 27 | 12 | 113 | 45° | 1 | HM | R | + |

Spare parts for cutter heads FTS-02

| Cat. nr | Name | Dimensions | | | Cat. nr | Name | Dimensions | | |
|----------|-------|---------------|--|---|-----------|-----------------|------------|--|---|
| N0000910 | Knife | 27x12x1,5 - P | | • | WHAS00004 | Screw STAMPF 94 | M4x6 | | |
| N0000911 | Knife | 27x12x1,5 - L | | • | WHA100003 | Locating pin | 3x6 | | • |
| | Knife | 27x12x1,5 | | + | | | | | |

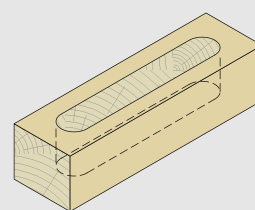
FTS-03 R or L



Straight shank cutter head, type **FTS-03** with one cutting tooth and one drilling blade designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head is used for rebating and grooving with drilling ability.

Type of work: rebating, grooving, drilling, formatting.

Material: solid hardwood, glued wood, chipboard, MDF and others.



| D n _{max} d _{max} z | 18 24000 25 1+1 | 20 24000 25 1+1 | 25 24000 25 1+1 | 30 24000 25 1+1 |
|--|--------------------------|--------------------------|--------------------------|--------------------------|
| h mm | | | | |
| 12 | + | + | + | + |
| 29,5 | + | + | + | + |
| 39,5 | + | + | + | + |
| 49,5 | + | + | + | + |

| Catalogue number | Type | D mm | dxs mm | h mm | L mm | z | | | |
|------------------|--------|---------|-----------|---------|---------|-----|----|---|---|
| FTS.03P1853.01 | FTS-03 | 18 | 25x60 | 29,5 | 106 | 1+1 | HM | R | + |
| FTS.03P2053.01 | FTS-03 | 20 | 25x60 | 29,5 | 106 | 1+1 | HM | R | + |
| FTS.03P2553.01 | FTS-03 | 25 | 25x55 | 29,5 | 100 | 1+1 | HM | R | + |
| FTS.03P3053.01 | FTS-03 | 30 | 25x56 | 29,5 | 100 | 1+1 | HM | R | + |

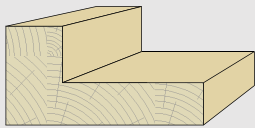
Spare parts for cutter heads FTS-03

| Cat. nr | Name | Dimensions | | Cat. nr | Name | Dimensions | |
|----------|-------|-----------------------------|---|-----------|-----------------|----------------------------|---|
| N0000801 | Knife | 7,5 x 12 x 1,5 for D=18; 20 | • | N0000813 | Knife | 12 x 12 x 1,5 for D=25; 30 | • |
| N0000814 | Knife | 29,5 x 12 x 1,5 | • | WHAS00004 | Screw STAMPF 94 | M4x6 | • |

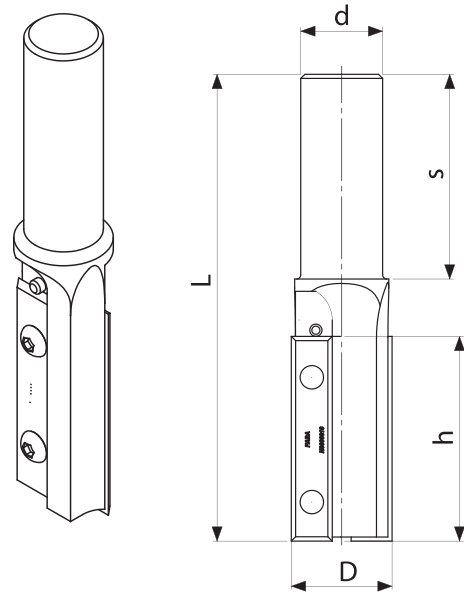
Straight shank cutter head, type **FTS-06** with two cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head is used for rebating and formatting.

Type of work: formatting, rebating.

Material: solid hardwood, glued wood, chipboard, MDF and others.



FTS-06 R or L



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| D n d _{max} z | 18 24000 25 2 | 20 24000 25 2 | 25 24000 25 2 | 27 24000 25 2 |
|---------------------------------|------------------------|------------------------|------------------------|------------------------|
| h mm | | | | |
| 29,5 | + | + | + | + |
| 39,5 | + | + | + | + |
| 49,5 | + | + | + | + |

| Catalogue number | Type | D mm | dxs mm | h mm | L mm | z | | | |
|------------------|--------|---------|-----------|---------|---------|---|----|---|---|
| FTS.06P1843.01 | FTS-06 | 18 | 20x45 | 29,5 | 95 | 2 | HM | R | + |
| FTS.06P1845.01 | FTS-06 | 18 | 20x45 | 49,5 | 110 | 2 | HM | R | + |
| FTS.06P2043.01 | FTS-06 | 20 | 20x60 | 29,5 | 95 | 2 | HM | R | + |
| FTS.06P2045.01 | FTS-06 | 20 | 20x60 | 49,5 | 125 | 2 | HM | R | + |
| FTS.06P2253.01 | FTS-06 | 22 | 25x60 | 29,5 | 105 | 2 | HM | R | + |
| FTS.06P2255.01 | FTS-06 | 22 | 25x60 | 49,5 | 125 | 2 | HM | R | + |
| FTS.06P2553.01 | FTS-06 | 25 | 25x55 | 29,5 | 105 | 2 | HM | R | + |
| FTS.06P2555.01 | FTS-06 | 25 | 25x60 | 49,5 | 125 | 2 | HM | R | + |
| FTS.06P2753.01 | FTS-06 | 27 | 25x60 | 29,5 | 105 | 2 | HM | R | + |
| FTS.06P2755.01 | FTS-06 | 27 | 25x60 | 49,5 | 125 | 2 | HM | R | + |

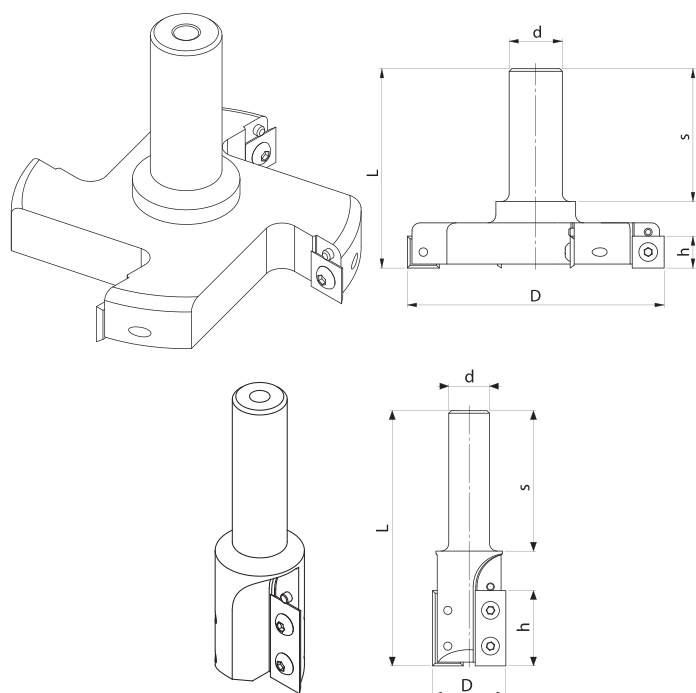
Spare parts for cutter heads FTS-06

| Cat. nr | Name | Dimensions | |
|----------|-------|-----------------|--|
| N0000814 | Knife | 29,5 x 12 x 1,5 | |
| N0000816 | Knife | 49,5 x 12 x 1,5 | |

| Cat. nr | Name | Dimensions | |
|-----------|-----------------|------------|--|
| WHAS00004 | Screw STAMPF 94 | M4x6 | |

On request, we offer cutter head FTS-06 with drilling ability (brazed drilling tip).

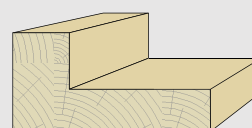
FTS-07.01 R or L



Straight shank cutter head, type **FTS-07.01** with suitable number of cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head is used for rebating and formatting.

Type of work: formatting, rebating.

Material: solid hardwood, glued wood, chipboard, MDF and others.



| D | 30 | 35 | 40 | 45 | 50 | 60 | 70 | 80 | 90 |
|------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| n _{max} | 18000 | 18000 | 18000 | 18000 | 18000 | 18000 | 18000 | 18000 | 18000 |
| d _{max} | 25 | 25 | 25 | 25 | 25 | 25 | 25 | 25 | 25 |
| z | 2 | 2 | 2 | 3 | 3 | 4 | 4 | 4 | 4 |
| h mm | | | | | | | | | |
| 12 | + | + | + | + | + | + | + | + | + |
| 29,5 | + | + | + | + | + | + | + | + | + |
| 39,5 | + | + | + | + | + | + | + | + | + |
| 49,5 | + | + | + | + | + | + | + | + | + |
| 59,5 | + | + | + | + | + | + | + | + | + |

| Catalogue number right | Catalogue number left | Type | D mm | dxs mm | h mm | L mm | z | | |
|------------------------|-----------------------|-----------|------|--------|------|------|---|----|---|
| FTS.07P3011.01 | FTS.07L3011.01 | FTS.07.01 | 30 | 10x40 | 12 | 70 | 2 | HM | + |
| FTS.07P4053.01 | FTS.07L4053.01 | FTS.07.01 | 40 | 25x60 | 29,5 | 105 | 2 | HM | + |
| FTS.07P5045.01 | FTS.07L5045.01 | FTS.07.01 | 50 | 20x64 | 49,5 | 120 | 2 | HM | + |
| FTS.07P8051.01 | FTS.07L8051.01 | FTS.07.01 | 80 | 25x60 | 12 | 85 | 4 | HM | + |

Spare parts for cutter heads FTS-07.01

| Cat. nr | Name | Dimensions |
|---------|-------|--------------|
| | Knife | B x 12 x 1,5 |



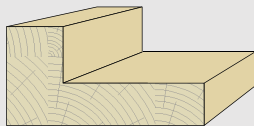
| Cat. nr | Name | Dimensions |
|-----------|-----------------|------------|
| WHAS00004 | Screw STAMPF 94 | M4x6 |
| WHAI00003 | Locating pin | 3x6 |



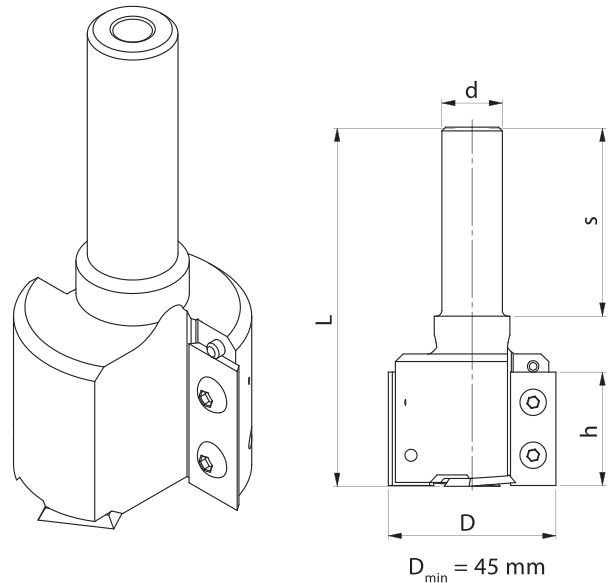
Straight shank cutter head, type **FTS-07.02** with two cutting teeth and two spurs, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head is used for precise rebating and formatting.

Type of work: precise formatting, rebating.

Material: solid hardwood, glued wood, chipboard, MDF and others.



FTS-07.02 R or L








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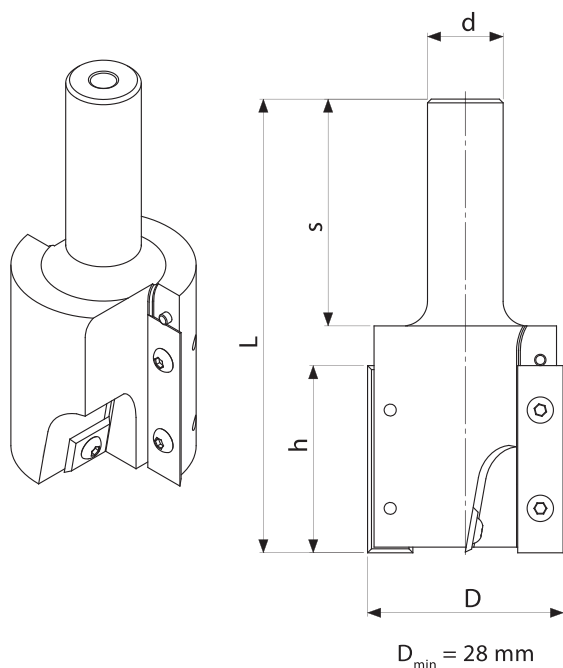


| Catalogue number right | Catalogue number left | Type | D mm | dxs mm | h mm | L mm | z | | |
|------------------------|-----------------------|-----------|------|--------|------|------|------|----|---|
| FTS.07P4533.02 | FTS.07L4533.02 | FTS.07.02 | 45 | 16x60 | 30 | 95 | 2 v2 | HM | + |
| FTS.07P5041.01 | FTS.07L5041.01 | FTS.07.02 | 50 | 20x50 | 12 | 80 | 2 v2 | HM | + |
| FTS.07P6045.01 | FTS.07L6045.01 | FTS.07.02 | 60 | 20x60 | 50 | 120 | 2 v2 | HM | + |
| FTS.07P6046.02 | FTS.07L6046.02 | FTS.07.02 | 60 | 25x55 | 60 | 125 | 2 v2 | HM | + |

Spare parts for cutter heads FTS-07.02

| Cat. nr | Name | Dimensions | | Cat. nr | Name | Dimensions | |
|----------|-------|---------------|---|-----------|-----------------|------------|---|
| | Knife | B x 12 x 1,5 |  | WHAS00004 | Screw STAMPF 94 | M4x6 |  |
| N0000818 | Knife | 14 x 14 x 1,5 |  | WHAS00008 | Screw TOR 1064 | M5x6,5 |  |
| | | | | WHA100003 | Locating pin | 3x6 |  |

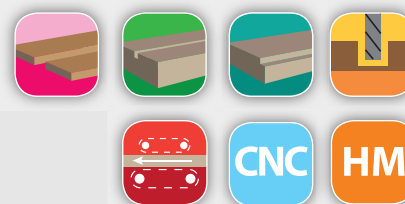
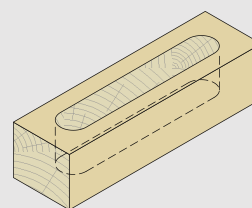
FTS-07.03 R or L



Straight shank cutter head, type **FTS-07.03** with two cutting teeth and one drilling blade, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head is used for rebating and grooving with drilling ability.

Type of work: rebating, grooving, drilling, formatting.



Material: solid hardwood, glued wood, chipboard, MDF and others.





| D n _{max} d _{max} z | 28 18000 25 2+1 | 30 18000 25 2+1 | 35 18000 25 2+1 | 40 18000 25 2+1 | 50 18000 25 2+1 |
|--|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|
| h mm | | | | | |
| 12 | + | + | + | + | + |
| 29,5 | + | + | + | + | + |
| 39,5 | + | + | + | + | + |
| 49,5 | + | + | + | + | + |
| 59,5 | + | + | + | + | + |

| Catalogue number right | Catalogue number left | Type | D mm | dxs mm | h mm | L mm | z | | |
|------------------------|-----------------------|-----------|------|--------|------|------|-----|----|---|
| FTS.07P2813.01 | FTS.07L2813.01 | FTS.07.03 | 28 | 12x49 | 29,5 | 85 | 2+1 | HM | + |
| FTS.07P3045.01 | FTS.07L3045.01 | FTS.07.03 | 30 | 20x62 | 49,5 | 118 | 2+1 | HM | + |
| FTS.07P3545.01 | FTS.07L3545.01 | FTS.07.03 | 35 | 20x62 | 49,5 | 118 | 2+1 | HM | + |
| FTS.07P4056.02 | FTS.07L4056.02 | FTS.07.03 | 40 | 25x55 | 59,5 | 120 | 2+1 | HM | + |
| FTS.07P4033.02 | FTS.07L4033.02 | FTS.07.03 | 40 | 16x55 | 29,5 | 90 | 2+1 | HM | + |

Spare parts for cutter heads FTS-07.03

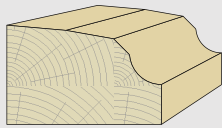
| Cat. nr | Name | Dimensions | |
|----------|-------|--------------|---|
| N0000813 | Knife | 12x12x1,5 |  |
| | Knife | B x 12 x 1,5 |  |

| Cat. nr | Name | Dimensions | |
|-----------|-----------------|------------|---|
| WHAS00004 | Screw STAMPF 94 | M4x6 |  |
| WHAI00003 | Locating pin | 3x6 |  |

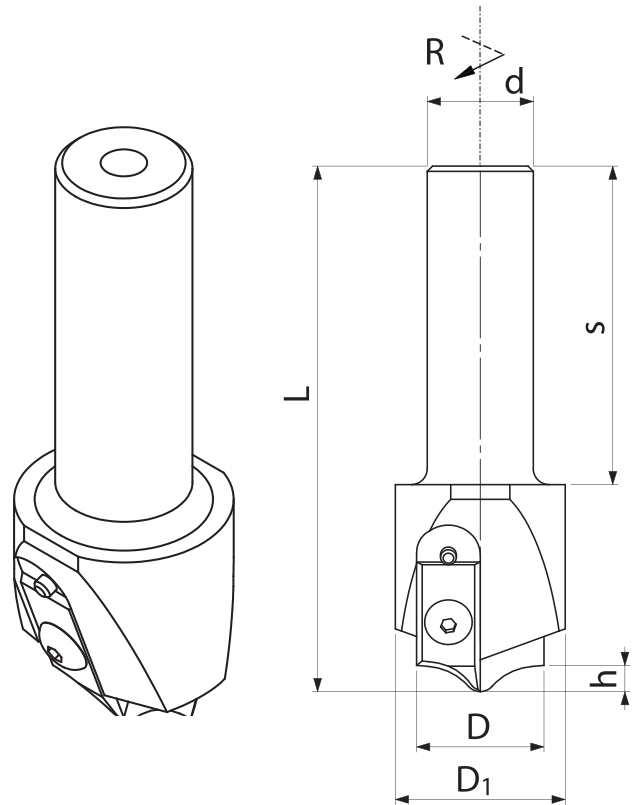
Universal profile cutter head, type **FTS-11** with two cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head used for surface profiling. Insert profile, which shape must remain within dimensions shown in the drawing ($h_{\max} = 8 \text{ mm}$), is made only according to individual order. The cutter head body is universal, special blade geometry allows for dowel drilling.

Type of work: profiling, dowel drilling.

Material: solid hardwood, glued wood, chipboard, MDF and others.



FTS-11



6



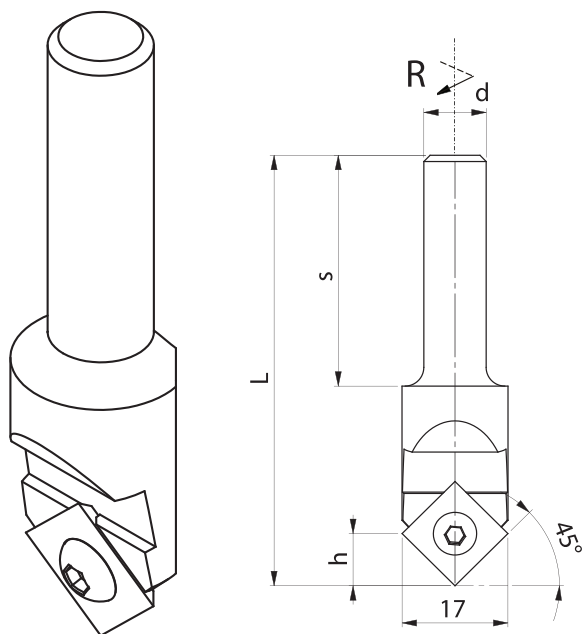
| Catalogue number (without knives) | Type | D ₁ mm | D mm | dxs mm | h mm | L mm | z | | |
|--------------------------------------|--------|----------------------|---------|-----------|---------|---------|---|----|-----|
| FTS.11.01.K | FTS-11 | 32 | 24 | 25x40 | 8 | 89 | 2 | HM | R + |

Spare parts for cutter heads FTS-11

| Cat. nr | Name | Dimensions | |
|-----------|-----------------|--------------|--|
| | Knife | Bx12x1,5 P/L | |
| WHAS00004 | Screw STAMPF 94 | M4x6 | |

| Cat. nr | Name | Dimensions | |
|-----------|--------------|------------|--|
| WHA100003 | Locating pin | 3x6 | |

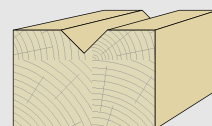
FTS-11-B



Universal profile cutter head, type **FTS-11-B** with one cutting tooth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head is used for grooving and edge beveling of the machined elements.

Type of work: grooving, edge beveling, dowel drilling.

Material: solid hardwood, glued wood, chipboard, MDF and others.



| Catalogue number | Type | D mm | dxs mm | h mm | L mm | z | | | |
|------------------|----------|---------|-----------|---------|---------|---|----|---|---|
| FTS.11.10.00 | FTS-11-B | 17 | 10x20 | 8 | 48 | 1 | HM | R | + |
| FTS.11.08.00 | FTS-11-B | 17 | 10x37 | 8 | 70 | 1 | HM | R | + |
| FTS.11.11.00 | FTS-11-B | 17 | 12x47 | 8 | 80 | 1 | HM | R | + |
| FTS.11.09.00 | FTS-11-B | 17 | 16x47 | 8 | 80 | 1 | HM | R | + |
| FTS.11.12.00 | FTS-11-B | 17 | 25x52 | 8 | 80 | 1 | HM | R | + |
| FTS.11.07.00 | FTS-11-B | 17 | 12x100 | 8 | 133 | 1 | HM | R | + |

Spare parts for cutter heads FTS-11-B

| Cat. nr | Name | Dimensions | |
|----------|-------|---------------|---|
| N0000854 | Knife | 12 x 12 x 1,5 | • |

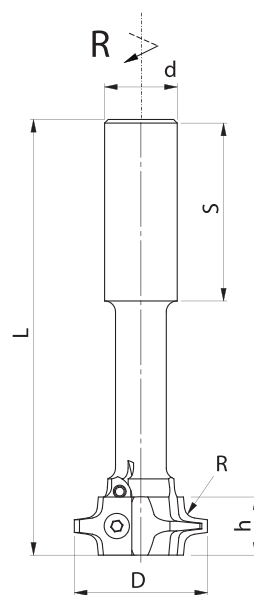
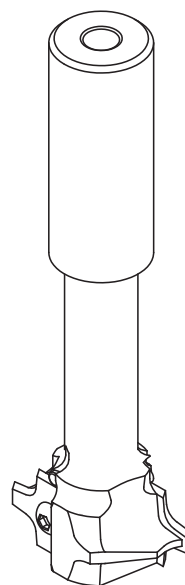
| Cat. nr | Name | Dimensions | |
|-----------|-----------------|------------|---|
| WHAS00004 | Screw STAMPF 94 | M4x6 | • |

Universal profile cutter head, type **FTS-13** with two cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. Cutter head with universal body, used for edge rounding with radius from R2 to R5. Parallel cutting blades. Cutter head working with high rotation speed.

Type of work: edge rounding with radius R.

Material: solid hardwood, glued wood, chipboard, MDF and others.

FTS-13 R or L



| Catalogue number | Type | D mm | dxs mm | h mm | L mm | R mm | z | | | |
|------------------|--------|---------|-----------|---------|---------|---------|---|----|---|---|
| FTS.13.18.00 | FTS-13 | 38 | 16x40 | 16 | 90 | 2 | 2 | HM | R | + |
| FTS.13.22.00 | FTS-13 | 38 | 20x50 | 16 | 100 | 3 | 2 | HM | R | + |
| FTS.13.14.00 | FTS-13 | 38 | 25x50 | 16 | 100 | 5 | 2 | HM | R | + |

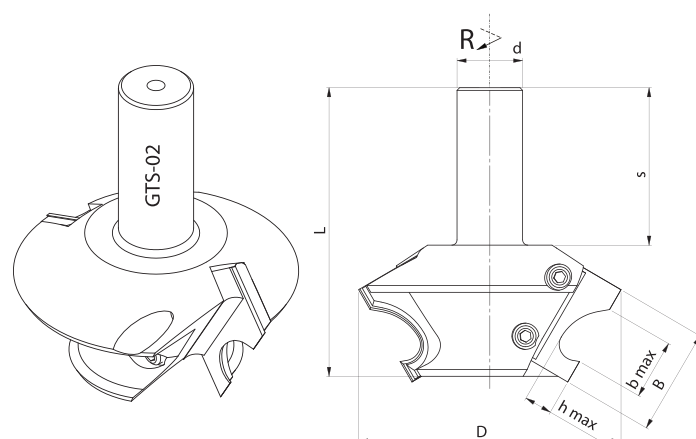
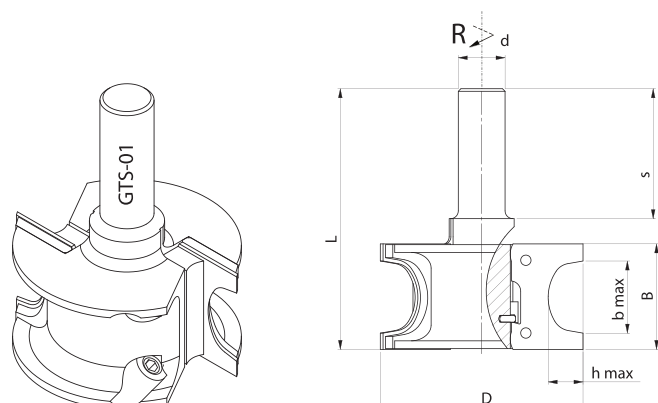
Spare parts for cutter heads FTS-13

| Cat. nr | Name | Dimensions | |
|-----------|-----------------|-------------|--|
| | Profile knife | 16x17,5x2 R | |
| WHAS00004 | Screw STAMPF 94 | M4x6 | |

| Cat. nr | Name | Dimensions | |
|-----------|--------------|------------|--|
| WHAI00003 | Locating pin | 3x6 | |

GTS-01 R or L

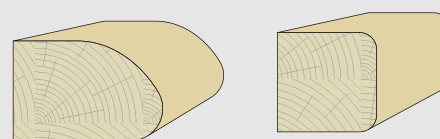
GTS-02 R or L



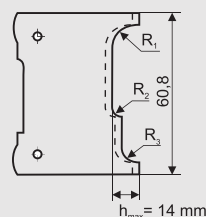
Universal profile cutter head, type **GTS-01** and **GTS-02** with two cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter head is used for surface profiling. Profile, which shape should remain within dimensions shown in the drawing is made only according to individual order. Universal cutter head, apart from cutting knife, includes also clamping wedges with shape matching the profile insert.

Type of work: profiling

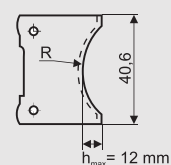
Material: solid hardwood, glued wood, chipboard, MDF and others.



Example of profile for shank cutter head GTS-01.02



Example of profile for shank cutter head GTS-01.01



Maximum depth of profile knives for width 60 mm and 40 mm.





| D | 82 | 86 | 100 |
|------------------|-----------|-----------|--------|
| n _{max} | 12000 | 12000 | 12000 |
| d _{max} | 25 | 25 | 25 |
| z | 2 | 2 | 2 |
| B mm | GTS.01.01 | GTS.01.02 | GTS.02 |
| 40 | + | | + |
| 60 | | + | |

| Catalogue number (without inserts) | Type | D mm | dxs mm | b _{max} mm | h _{max} mm | z | | | |
|------------------------------------|-----------|------|--------|---------------------|---------------------|---|----|---|---|
| GTS.01.01.K | GTS-01.01 | 82 | 25x55 | 32 | 12 | 2 | HM | R | + |
| GTS.01.02.K | GTS-01.02 | 86 | 25x60 | 52 | 14 | 2 | HM | R | + |

Spare parts for cutter heads GTS-01 i GTS-02

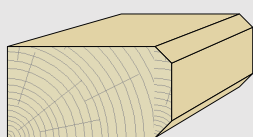
| Cat. nr | Name | Dimensions | |
|---------|----------------|--------------|---|
| | Knife | B x 30 x 1,5 |  • |
| | Support insert | B x 28 x 1,5 |  • |

| Cat. nr | Name | Dimensions | |
|-----------|----------------|--------------|---|
| | Clamping block | B-2 x 12 x 8 |  • |
| WHAW00005 | Screw | M8x16 |  • |

Set of cutter heads on shank, type **GTZ-01** with suitable number of cutting teeth designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The set is used for edge beveling of the machined elements. Width is regulated with spacer rings included in the set.

Type of work: edge profiling, rounding, beveling.

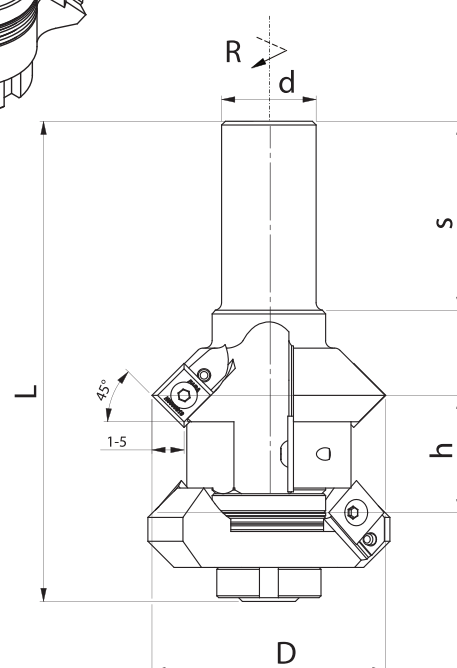
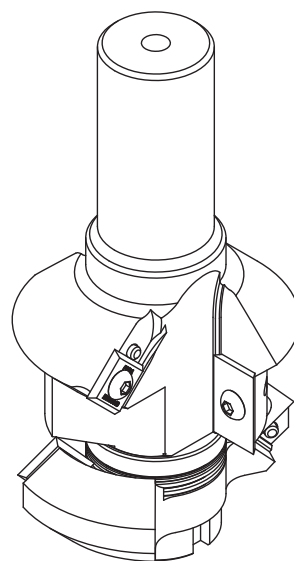
Material: solid hardwood, glued wood, chipboard, MDF and others.



| | |
|------------------------|-------|
| D | 65 |
| n_{max} | 12000 |
| d_{max} | 25 |
| z | 2+2 |
| h mm | |
| 10-22 | + |
| 20-32 | + |
| 30-42 | + |



GTZ-01 R or L



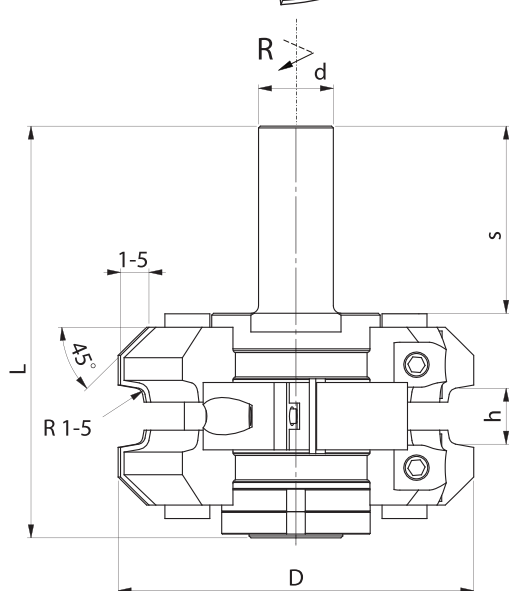
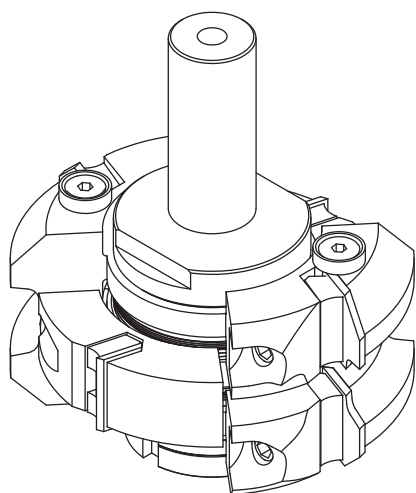
6

| Catalogue number | Type | D mm | dxs mm | h mm | L mm | z | | | |
|------------------|--------|------|--------|-------|------|---|----|---|---|
| GTZ.01.07 | GTZ-01 | 65 | 20x50 | 10-22 | 127 | 2 | HM | R | + |
| GTZ.01.01 | GTZ-01 | 65 | 25x50 | 10-22 | 127 | 2 | HM | R | + |
| GTZ.01.05 | GTZ-01 | 65 | 25x50 | 20-32 | 137 | 2 | HM | R | + |
| GTZ.01.03 | GTZ-01 | 65 | 25x50 | 30-42 | 150 | 2 | HM | R | + |

Spare parts for cutter heads GTZ-01

| Cat. nr | Name | Dimensions | | Cat. nr | Name | Dimensions | |
|----------|-------|---------------|--|-----------|-----------------|---------------|--|
| N0000805 | Knife | 20 x 12 x 1,5 | | N0000809 | Knife | 40 x 12 x 1,5 | |
| N0000813 | Knife | 12 x 12 x 1,5 | | WHAS00004 | Screw STAMPF 94 | M4x6 | |
| N0000808 | Knife | 30 x 12 x 1,5 | | WHAI00003 | Locating pin | 3x6 | |

GTZ-06 R or L

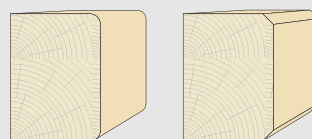


MDF

Set of cutter heads on shank, type **GTZ-06** with suitable number of cutting teeth designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The set is used for rounding and edge 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 hard wood, glued wood, chipboard, MDF and others.



| D mm | 65 |
|------------------|-------|
| n _{max} | 12000 |
| d _{max} | 25 |
| z _{max} | 2+2 |
| h mm | |
| 10-30 | + |
| 16-40 | + |
| 16-50 | + |
| 20-55 | + |



CNC

HM

| Catalogue number | Type | D mm | dxs mm | h mm | R mm | L mm | z | | | |
|------------------|--------|------|--------|-------|------|------|---|----|---|---|
| GTZ.06.15.00 | GTZ-06 | 95 | 25x50 | 10-30 | 5 | 120 | 2 | HM | R | + |
| GTZ.06.03.00 | GTZ-06 | 95 | 25x50 | 16-40 | 5 | 130 | 2 | HM | R | + |
| GTZ.06.01.00 | GTZ-06 | 95 | 25x50 | 16-50 | 5 | 140 | 2 | HM | R | + |

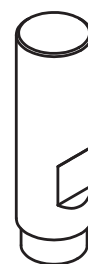
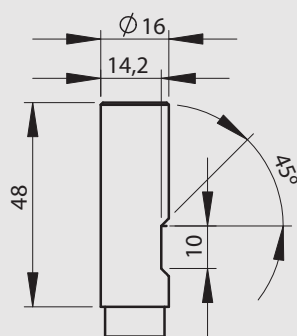
Spare parts for cutter heads GTZ-06

| Cat. nr | Name | Dimensions | |
|----------|-------------------|---------------|--|
| | Profile knife P/L | 20x20x2 R | |
| N0000810 | Knife | 50 x 12 x 1,5 | |
| N0000808 | Knife | 30 x 12 x 1,5 | |
| N0000809 | Knife | 40 x 12 x 1,5 | |

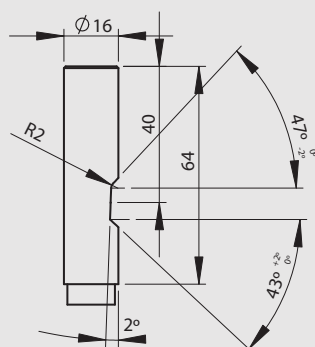
| Cat. nr | Name | Dimensions | |
|-----------|-----------------|------------|--|
| WHAT00044 | Weating sleeve | 12x6,5x3,6 | |
| WHAS00004 | Screw STAMPF 94 | M4x6 | |
| WHAW00004 | Screw DIN 915 | M6x16 | |
| WHAW00005 | Screw DIN 915 | M8x16 | |
| WHAS00006 | Screw TOR 1128 | M6x10 | |

Radius R and edge beveling angle should be given with the order.

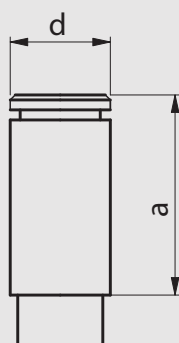
Weldon



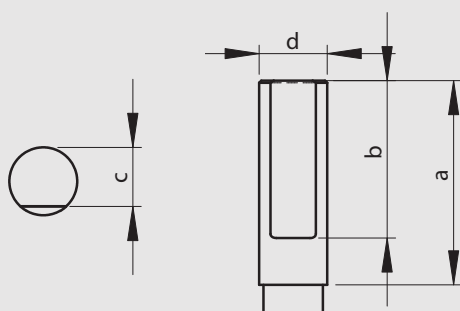
Homag i Weeke



Seeger

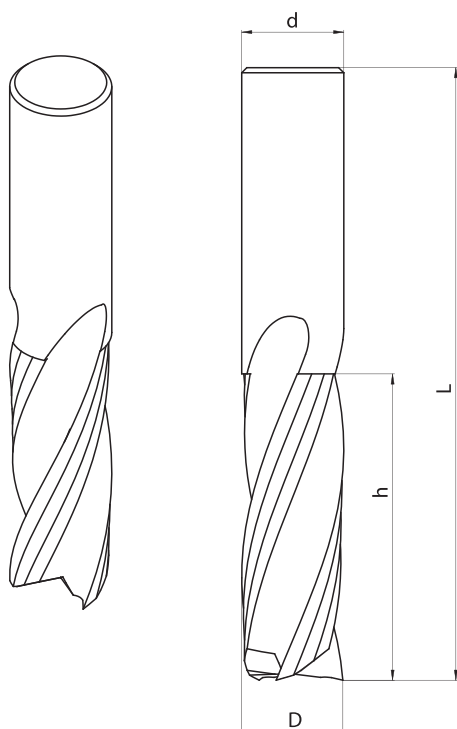


With flat part



When ordering shank tools with non-standard clamping, type of shank part and necessary dimensions should be given.

THM-01 R



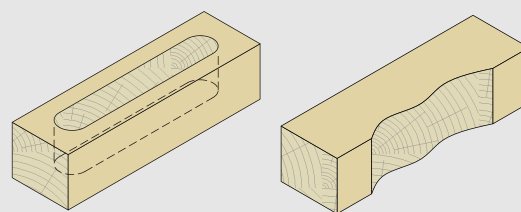
Shank cutter, type **THM-01** with two or three cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for groove finishing, formatting and nesting. Special geometry guarantees chip flow up.

Type of work: precise grooving, formatting.

Material:

HSS solid softwood, plastics

HM MONOLIT solid hard wood, glued wood, chipboard, MDF and others



| Catalogue number | Type | D mm | h mm | L mm | z | n _{max} | | |
|------------------|--------|------|------|------|---|------------------|----|---|
| THM.01.09/022 | THM-01 | 6 | 25 | 60 | 2 | 24000 | HM | • |
| THM.01.09/023* | THM-01 | 6 | 25 | 70 | 2 | 24000 | HM | • |
| THM.01.09/024 | THM-01 | 6 | 30 | 70 | 2 | 24000 | HM | • |
| THM.01.07/017 | THM-01 | 8 | 25 | 70 | 2 | 24000 | HM | • |
| THM.01.06/025 | THM-01 | 10 | 30 | 70 | 2 | 24000 | HM | • |
| THM.01.06/001 | THM-01 | 10 | 30 | 70 | 3 | 24000 | HM | • |
| THM.01.06/026 | THM-01 | 10 | 45 | 100 | 2 | 24000 | HM | • |
| THM.01.01/001 | THM-01 | 12 | 30 | 80 | 3 | 24000 | HM | • |
| THM.01.01/003 | THM-01 | 12 | 50 | 100 | 3 | 24000 | HM | • |
| THM.01.02/001 | THM-01 | 14 | 30 | 80 | 3 | 24000 | HM | • |
| THM.01.02/005 | THM-01 | 14 | 55 | 110 | 3 | 24000 | HM | • |
| THM.01.03/001 | THM-01 | 16 | 35 | 90 | 3 | 24000 | HM | • |
| THM.01.03/026 | THM-01 | 16 | 60 | 110 | 3 | 24000 | HM | • |
| THM.01.04/001 | THM-01 | 18 | 50 | 100 | 3 | 24000 | HM | • |
| THM.01.05/001 | THM-01 | 20 | 55 | 120 | 3 | 24000 | HM | • |
| THM.01.05/002 | THM-01 | 20 | 70 | 120 | 3 | 24000 | HM | • |

* THM.01.09/023 - shank part d=8 mm

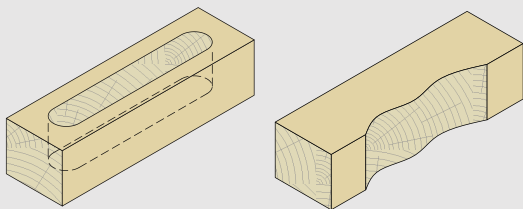
Shank cutter, type **THM-02 L** with two or three cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for groove finishing, formatting and nesting. Special geometry guarantees chip flow up.

Type of work: precise grooving, formatting.

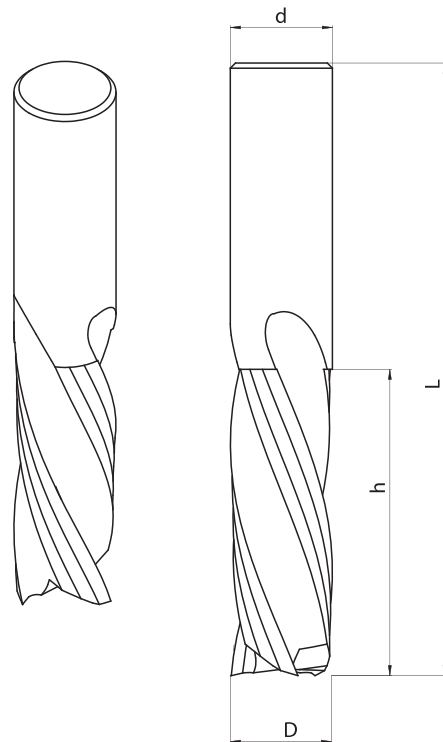
Material:

HSS solid softwood, plastics

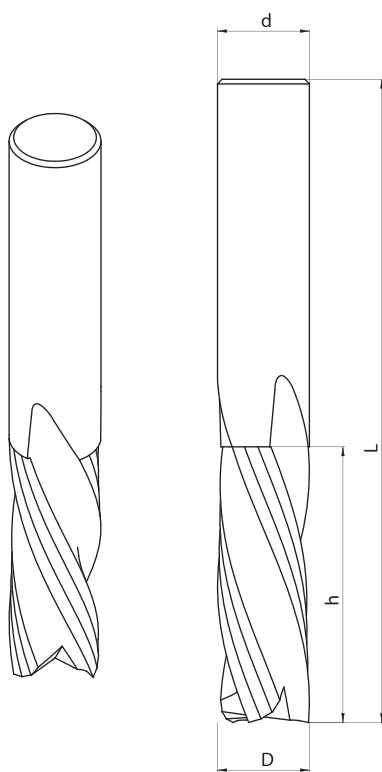
HM solid hard wood, glued wood, chipboard, MDF and others



THM-02 L



| Catalogue number | Type | D mm | h mm | L mm | z | n _{max} | | |
|------------------|--------|---------|---------|---------|---|------------------|----|---|
| THM.02.07/002 | THM-02 | 8 | 25 | 70 | 2 | 24000 | HM | • |
| THM.02.06/002 | THM-02 | 10 | 30 | 70 | 2 | 24000 | HM | • |
| THM.02.01/001 | THM-02 | 12 | 30 | 80 | 3 | 24000 | HM | + |
| THM.02.02/001 | THM-02 | 14 | 30 | 80 | 3 | 24000 | HM | + |
| THM.02.03/001 | THM-02 | 16 | 35 | 90 | 3 | 24000 | HM | + |
| THM.02.04/001 | THM-02 | 18 | 50 | 100 | 3 | 24000 | HM | + |
| THM.02.05/001 | THM-02 | 20 | 55 | 120 | 3 | 24000 | HM | + |



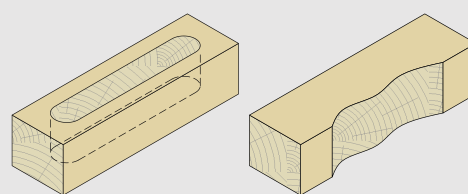
Shank cutter, type **THM-03** or **THM-04** with two or three cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for groove finishing, formatting and nesting. Special geometry guarantees chip flow down. Increased chip flow efficiency.

Type of work: precise grooving, formatting.

Material:

HSS solid softwood, plastics

HM MONOLIT solid hard wood, glued wood, chipboard, MDF and others



THM-03 R

| Catalogue number | Type | D mm | h mm | L mm | z | n _{max} | | |
|------------------|--------|---------|---------|---------|---|------------------|----|---|
| THM.03.09/001 | THM-03 | 6 | 20 | 60 | 2 | 24000 | HM | + |
| THM.03.07/006 | THM-03 | 8 | 25 | 70 | 2 | 24000 | HM | + |
| THM.03.06/001 | THM-03 | 10 | 30 | 70 | 3 | 24000 | HM | + |
| THM.03.01.013 | THM-03 | 12 | 30 | 80 | 3 | 24000 | HM | + |
| THM.03.02/001 | THM-03 | 14 | 30 | 80 | 3 | 24000 | HM | + |
| THM.03.03/003 | THM-03 | 16 | 35 | 90 | 3 | 24000 | HM | + |
| THM.03.05.002 | THM-03 | 20 | 55 | 110 | 3 | 24000 | HM | + |

THM-04 L

| Catalogue number | Type | D mm | h mm | L mm | z | n _{max} | | |
|------------------|--------|---------|---------|---------|---|------------------|----|---|
| THM.04.07/002 | THM-04 | 8 | 25 | 70 | 2 | 24000 | HM | + |
| THM.04.06/001 | THM-04 | 10 | 30 | 70 | 3 | 24000 | HM | + |
| THM.04.01/001 | THM-04 | 12 | 30 | 80 | 3 | 24000 | HM | + |
| THM.04.02/001 | THM-04 | 14 | 30 | 80 | 3 | 24000 | HM | + |
| THM.04.03/001 | THM-04 | 16 | 35 | 90 | 3 | 24000 | HM | + |
| THM.04.05.001 | THM-04 | 20 | 55 | 110 | 3 | 24000 | HM | + |

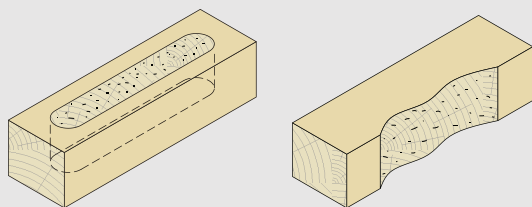
Shank cutter, type **THM-05** with two or three cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for roughing. Special geometry guarantees chip flow up. The cutter working with increased machining parameters.

Type of work: pre-grooving, pre-formatting.

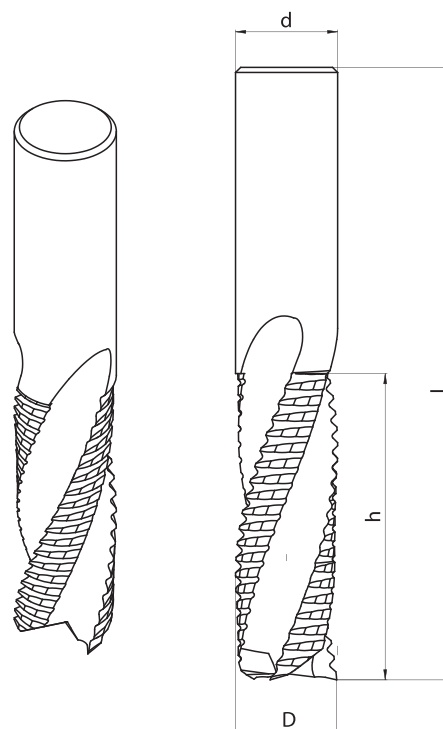
Material:

HSS solid softwood, plastics

HM solid hard wood, glued wood, chipboard, MDF and others

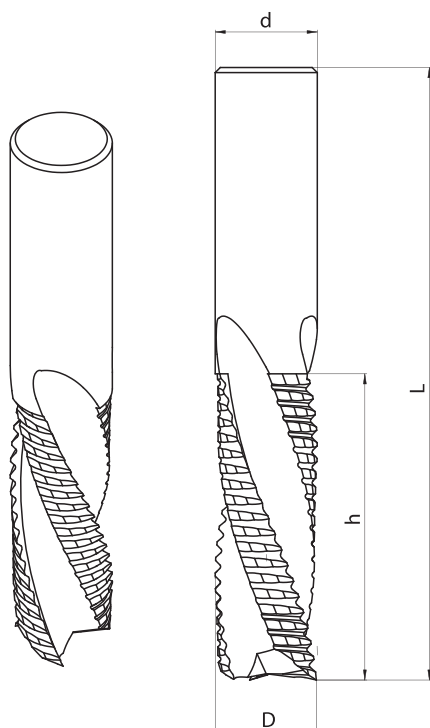


THM-05 R



| Catalogue number | Type | D mm | h mm | L mm | z | n _{max} | | |
|------------------|--------|---------|---------|---------|---|------------------|----|---|
| THM.05.09/006 | THM-05 | 6 | 30 | 70 | 2 | 24000 | HM | • |
| THM.05.07/010 | THM-05 | 8 | 25 | 70 | 2 | 24000 | HM | • |
| THM.05.06/024 | THM-05 | 10 | 30 | 70 | 2 | 24000 | HM | • |
| THM.05.06/001 | THM-05 | 10 | 30 | 70 | 3 | 24000 | HM | • |
| THM.05.06/025 | THM-05 | 10 | 45 | 100 | 2 | 24000 | HM | • |
| THM.05.01/001 | THM-05 | 12 | 30 | 80 | 3 | 24000 | HM | • |
| THM.05.01/008 | THM-05 | 12 | 50 | 100 | 3 | 24000 | HM | • |
| THM.05.02/001 | THM-05 | 14 | 30 | 80 | 3 | 24000 | HM | • |
| THM.05.02/024 | THM-05 | 14 | 55 | 110 | 3 | 24000 | HM | + |
| THM.05.03/001 | THM-05 | 16 | 35 | 90 | 3 | 24000 | HM | • |
| THM.05.03/057 | THM-05 | 16 | 60 | 110 | 3 | 24000 | HM | • |
| THM.05.04/001 | THM-05 | 18 | 50 | 100 | 3 | 24000 | HM | • |
| THM.05.05/001 | THM-05 | 20 | 55 | 120 | 3 | 24000 | HM | • |
| THM.05.05/005 | THM-05 | 20 | 70 | 120 | 3 | 24000 | HM | • |

THM-06 L



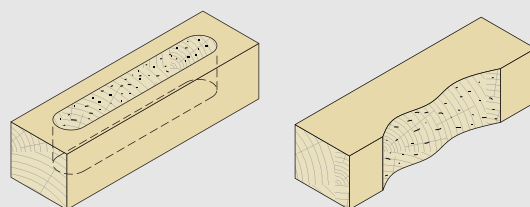
Shank cutter, type **THM-06** with two or three cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for pre-grooving. Special geometry guarantees chip flow up. The cutter working with increased machining parameters.

Type of work: pre-grooving, pre-formatting.

Material:

HSS solid softwood, plastics

HM solid hard wood, glued wood, chipboard, MDF and others



| Catalogue number | Type | D mm | h mm | L mm | z | n _{max} | | |
|------------------|--------|---------|---------|---------|---|------------------|----|---|
| THM.06.07/002 | THM-06 | 8 | 25 | 70 | 2 | 24000 | HM | • |
| THM.06.06/003 | THM-06 | 10 | 30 | 70 | 2 | 24000 | HM | • |
| THM.06.01/001 | THM-06 | 12 | 30 | 80 | 3 | 24000 | HM | + |
| THM.06.02/001 | THM-06 | 14 | 30 | 80 | 3 | 24000 | HM | + |
| THM.06.03/001 | THM-06 | 16 | 35 | 90 | 3 | 24000 | HM | + |
| THM.06.04/001 | THM-06 | 18 | 50 | 100 | 3 | 24000 | HM | + |
| THM.06.05/001 | THM-06 | 20 | 55 | 120 | 3 | 24000 | HM | + |

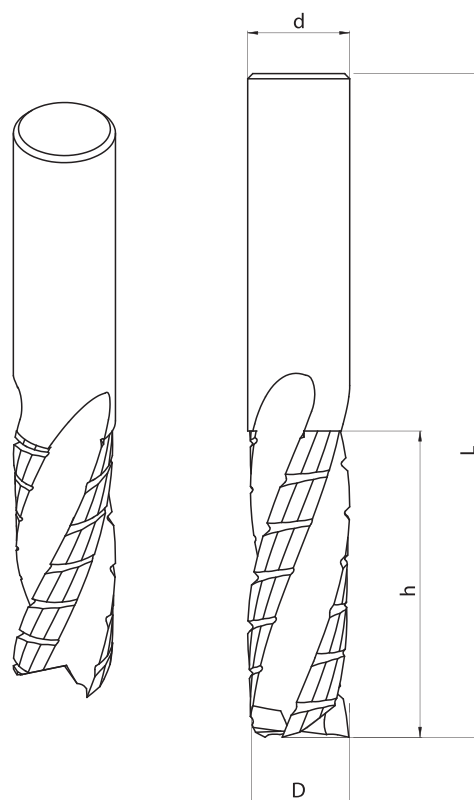
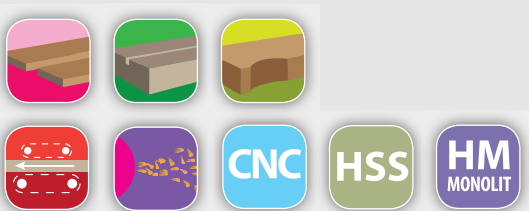
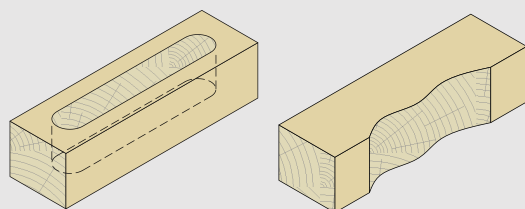
Shank cutter, type **THM-07** or **THM-08** with three cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for pre-grooving, grooving, formatting and nesting. Special geometry guarantees chip flow up. Additional chip breakers allow for better chip fragmentation. Increased chip flow efficiency. The cutter working with increased machining parameters.

Type of work: grooving, pre-formatting and precise formatting.

Material:

HSS solid softwood, plastics

HM solid hard wood, glued wood, chipboard, MDF and others



6

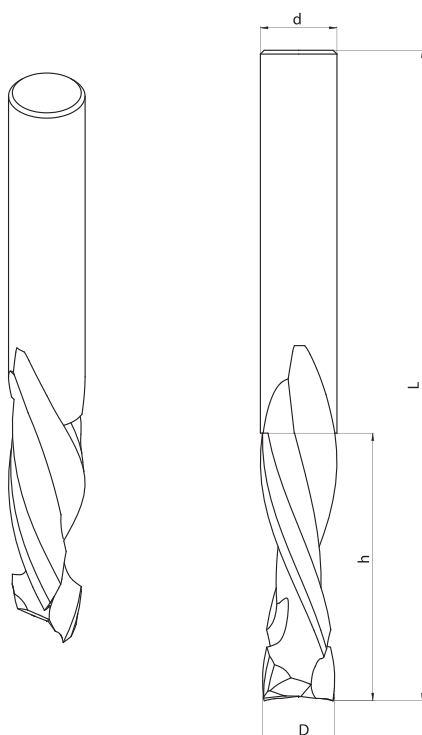
THM-07 R

| Catalogue number | Type | D mm | h mm | L mm | z | n _{max} | | |
|------------------|--------|---------|---------|---------|---|------------------|----|---|
| THM.07.06/001 | THM-07 | 10 | 25 | 70 | 3 | 24000 | HM | + |
| THM.07.01/001 | THM-07 | 12 | 30 | 80 | 3 | 24000 | HM | + |
| THM.07.03/001 | THM-07 | 16 | 50 | 110 | 3 | 24000 | HM | + |
| THM.07.05/001 | THM-07 | 20 | 55 | 120 | 3 | 24000 | HM | + |

THM-08 L

| Catalogue number | Type | D mm | h mm | L mm | z | n _{max} | | |
|------------------|--------|---------|---------|---------|---|------------------|----|---|
| THM.08.06/001 | THM-08 | 10 | 25 | 70 | 3 | 24000 | HM | + |
| THM.08.01/001 | THM-08 | 12 | 30 | 80 | 3 | 24000 | HM | + |
| THM.08.03/001 | THM-08 | 16 | 50 | 110 | 3 | 24000 | HM | + |
| THM.08.05/001 | THM-08 | 20 | 55 | 120 | 3 | 24000 | HM | + |

THM-09 R



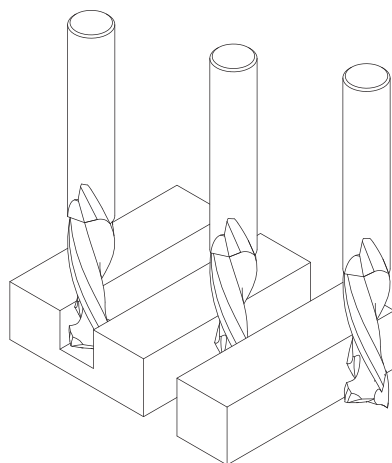
Shank cutter, type **THM-09** with two cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for precise formatting of two-sided veneered board. No veneer ripping thanks to alternative direction of turbo-type spiral cutting line. The cutter working with increased machining parameters. Lower cutting resistance. Multiple sharpening possibility.

Type of work: finishing.

Material:

HSS solid softwood, plastics

HM MONOLIT solid hard wood, glued wood, chipboard, MDF and others



| Catalogue number | Type | D mm | h mm | L mm | z | n _{max} | | |
|------------------|--------|---------|---------|---------|-----|------------------|----|---|
| THM.09.06/001 | THM-09 | 10 | 30 | 80 | 2+2 | 24000 | HM | + |
| THM.09.01/001 | THM-09 | 12 | 40 | 90 | 2+2 | 24000 | HM | + |
| THM.09.02/001 | THM-09 | 14 | 50 | 110 | 2+2 | 24000 | HM | + |
| THM.09.03/001 | THM-09 | 16 | 50 | 110 | 2+2 | 24000 | HM | + |
| THM.09.05/001 | THM-09 | 20 | 50 | 110 | 2+2 | 24000 | HM | + |

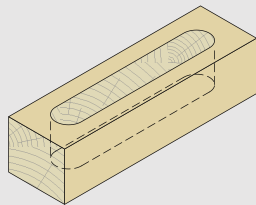
Shank cutter, type **THM-10** with three cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for pre-cutting holes for door locks. Cutting depth up to 95 mm with chip flow. The cutter working with increased machining parameters.

Type of work: deep pre-cutting.

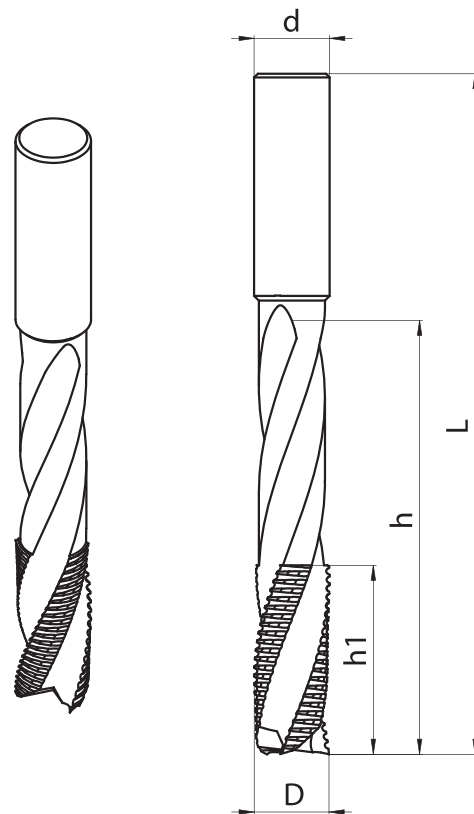
Material:

HSS solid softwood, plastics

HM solid hard wood, glued wood, chipboard, MDF and others



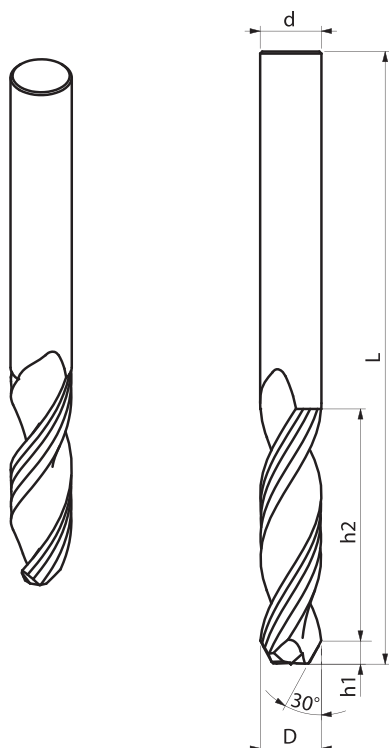
THM-10 R



6



| Catalogue number | Type | D mm | d mm | h ₁ mm | h mm | L mm | z | n _{max} | | |
|------------------|--------|---------|---------|----------------------|---------|---------|---|------------------|----|---|
| THM.10.03/001 | THM-10 | 16 | 16 | 60 | 100 | 150 | 3 | 24000 | HM | • |
| THM.10.03/002 | THM-10 | 16,5 | 18 | 60 | 100 | 160 | 3 | 24000 | HM | + |



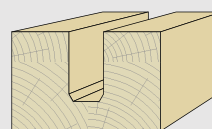
Shank cutter, type **THM-11** or **THM-12** with three cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for groove finishing, formatting, drilling as well as dowel and through drilling. Additional 30° bevel increases edge quality after cutting. Special geometry guarantees chip flow up.

Type of work: grooving, formatting, finishing, drilling.

Material:

HSS solid softwood, plastics

HM solid hard wood, glued wood, chipboard, MDF and others



THM-11 R

| Catalogue number | Type | D mm | h ₂ mm | h ₁ mm | L mm | z | n _{max} | | |
|------------------|--------|---------|----------------------|----------------------|---------|---|------------------|----|---|
| THM.11.01/001 | THM-11 | 12 | 45 | 9 | 110 | 3 | 24000 | HM | + |
| THM.11.02/001 | THM-11 | 14 | 40 | 9 | 100 | 3 | 24000 | HM | + |
| THM.11.03/001 | THM-11 | 16 | 50 | 9 | 120 | 3 | 24000 | HM | + |

THM-12 L

| Catalogue number | Type | D mm | h ₂ mm | h ₁ mm | L mm | z | n _{max} | | |
|------------------|--------|---------|----------------------|----------------------|---------|---|------------------|----|---|
| THM.12.01/001 | THM-12 | 12 | 45 | 9 | 110 | 3 | 24000 | HM | + |
| THM.12.02/001 | THM-12 | 14 | 40 | 9 | 100 | 3 | 24000 | HM | + |
| THM.12.03/001 | THM-12 | 16 | 50 | 9 | 120 | 3 | 24000 | HM | + |

Monolith shank cutter, type **THM-13** with two cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for engraving as well as beveling and counterboring.

Type of work: engraving, beveling, counterboring.

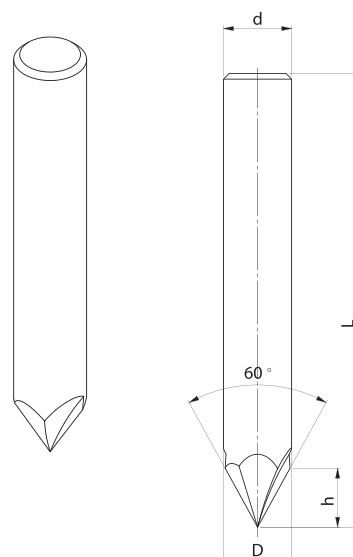
Material:

HSS solid soft wood, plastics

HM MONOLIT solid hard wood, glued wood, chipboard, MDF and others



THM-13 R



| Catalogue number | Type | D mm | h mm | L mm | z | n _{max} | | |
|------------------|--------|------|------|------|---|------------------|----|---|
| THM.13.07/001 | THM-13 | 8 | 7 | 70 | 2 | 24000 | HM | + |
| THM.13.01/001 | THM-13 | 12 | 9 | 80 | 2 | 24000 | HM | + |

6

Monolith shank cutter, type **THM-14** with two cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for engraving and shape grooving.

Type of work: engraving, shape-grooving.

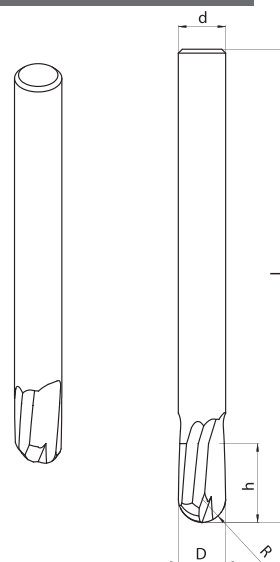
Material:

HSS solid soft wood, plastics

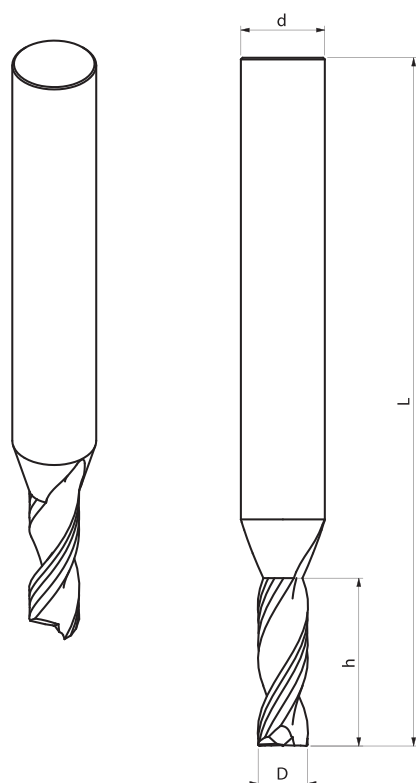
HM MONOLIT solid hard wood, glued wood, chipboard, MDF and others



THM-14 R



| Catalogue number | Type | D mm | h mm | L mm | R mm | z | n _{max} | | |
|------------------|--------|------|------|------|------|---|------------------|----|---|
| THM.14.09/001 | THM-14 | 6 | 9 | 60 | 3 | 2 | 24000 | HM | + |
| THM.14.07/001 | THM-14 | 8 | 11 | 70 | 4 | 2 | 24000 | HM | + |
| THM.14.06/002 | THM-14 | 10 | 13 | 80 | 5 | 2 | 24000 | HM | + |



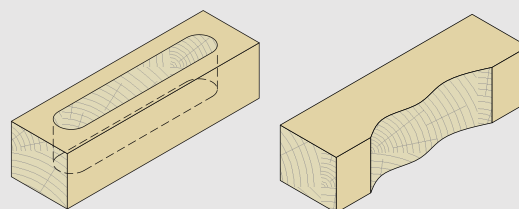
Monolith shank cutter, type **THM-15** or **THM-16** with two or three cutting teeth, designed for professional machining of solid wood and wood-based materials such as chipboard, MDF and others. The cutter is used for groove finishing, formatting and nesting. Special geometry guarantees chip flow up. Thicker shank part.

Type of work: grooving, finishing.

Material:

HSS solid softwood, plastics

HM MONOLIT solid hard wood, glued wood, chipboard, MDF and others



THM-15 R

| Catalogue number | Type | D mm | d mm | h mm | L mm | z | n _{max} | | |
|------------------|--------|------|------|------|------|---|------------------|----|---|
| THM.15.12/001 | THM-15 | 5 | 6 | 15 | 60 | 2 | 24000 | HM | + |
| THM.15.09/001 | THM-15 | 6 | 8 | 20 | 70 | 2 | 24000 | HM | + |
| THM.15.08/001 | THM-15 | 7 | 8 | 20 | 70 | 2 | 24000 | HM | + |
| THM.15.07/001 | THM-15 | 8 | 10 | 30 | 80 | 2 | 24000 | HM | + |
| THM.15.17/001 | THM-15 | 9 | 10 | 30 | 80 | 2 | 24000 | HM | + |
| THM.15.06/001 | THM-15 | 10 | 12 | 30 | 80 | 2 | 24000 | HM | + |

THM-16 L

| Catalogue number | Type | D mm | d mm | h mm | L mm | z | n _{max} | | |
|------------------|--------|------|------|------|------|---|------------------|----|---|
| THM.16.12/001 | THM-16 | 5 | 6 | 15 | 60 | 2 | 24000 | HM | + |
| THM.16.09/001 | THM-16 | 6 | 8 | 20 | 70 | 2 | 24000 | HM | + |
| THM.16.07/001 | THM-16 | 8 | 10 | 30 | 80 | 2 | 24000 | HM | + |

Step drills **THM-01** are produced only on client's individual request.

Step and profile shank cutters are offered with positive and negative helix line.

Optionally, the tool can be produced with a different profile.

Advantages of using stepped and profile THM:

- possibility of performing a couple of operations with one tool,
- eliminating machining runout by using only one mounting of the tool,
- faster completion of the operation compared to working with a few tools,
- smaller quantity of holders on the machine,
- increased life and cutting quality,
- lower energy costs,
- lower costs of discrete manufacturing.

Material:

HSS solid softwood, plastics

HM solid hard wood, glued wood, chipboard, MDF and others

Order should include all dimensions shown in the drawing.

THM-01 step

