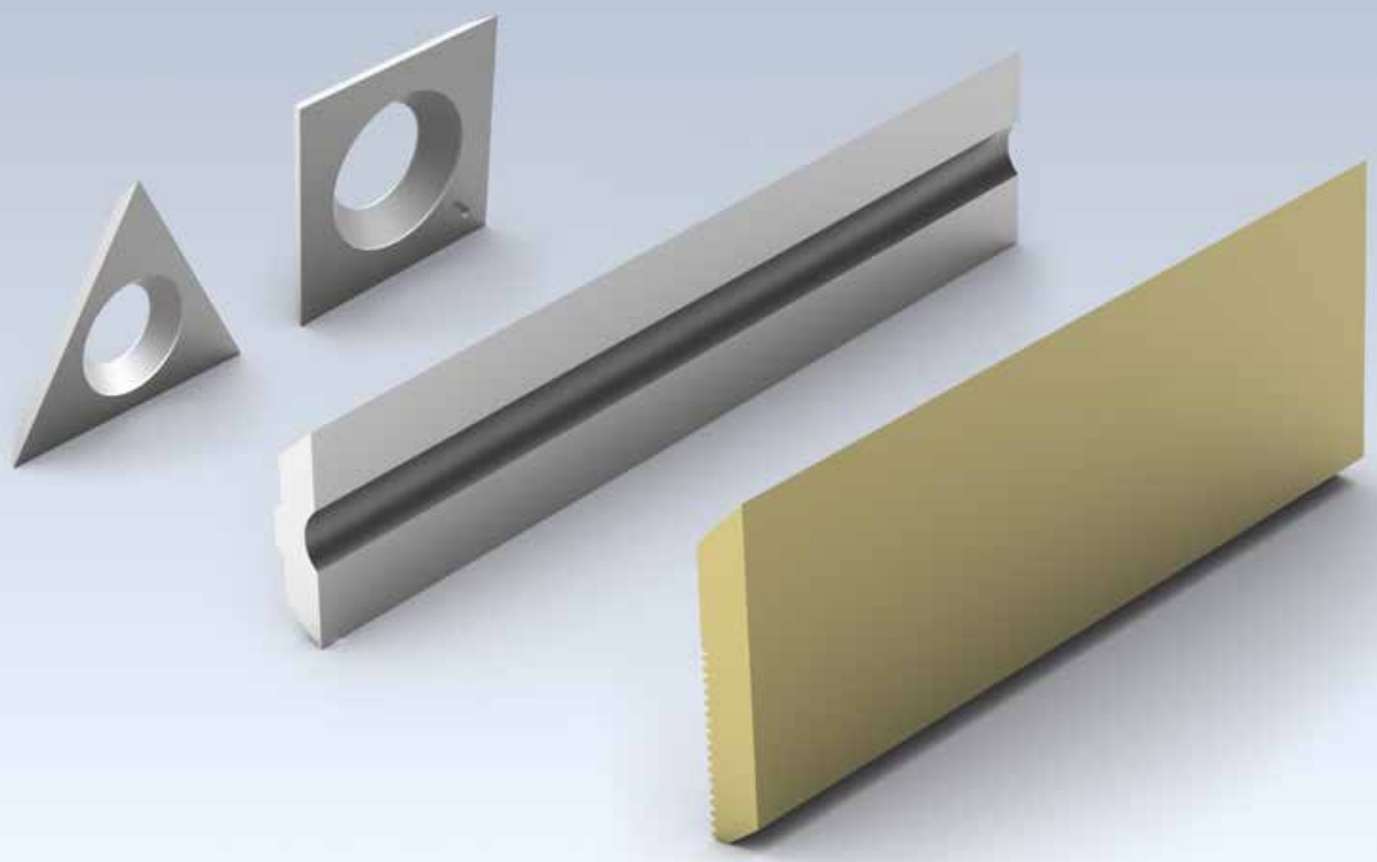
Knives and spare parts

Leitz Lexicon Edition 7

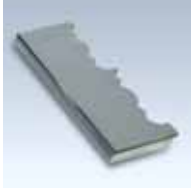


Explanation of abbreviations

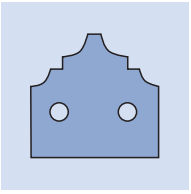
A	=	dimension A
a_e	=	cutting thickness (radial)
a_p	=	cutting depth (axial)
ABM	=	dimension
APL	=	panel raising length
APT	=	panel raising depth
AL	=	working length
AM	=	number of knives
AS	=	anti sound (low noise design)
b	=	overhang
B	=	width
BDD	=	thickness of shoulder
BEM	=	note
BEZ	=	description
BH	=	tipping height
BO	=	bore diameter
CNC	=	Computerized Numerical Control
d	=	diameter
D	=	cutting circle diameter
D0	=	zero diameter
DA	=	outside Diameter
DB	=	diameter of shoulder
DFC	=	Dust Flow Control (optimised chip clearance)
DGL	=	number of links
DIK	=	thickness
DKN	=	double keyway
DP	=	polycrystalline diamond
DRI	=	rotation
FAB	=	width of rebate
FAT	=	depth of rebate
FAW	=	bevel angle
FLD	=	flange diameter
f_z	=	tooth feed
$f_{z\ eff}$	=	effective tooth feed
GEW	=	thread
GL	=	total length
GS	=	Plunging edge
H	=	height
HC	=	tungsten carbide, coated
HD	=	wood thickness (thickness of workpiece)
HL	=	high-alloyed tool steel
HS	=	high-speed steel (HSS)
HW	=	tungsten carbide (TCT)
ID	=	ident number
IV	=	insulation glazing
KBZ	=	abbreviation
KLH	=	clamping height
KM	=	edge breaker
KN	=	single keyway
KNL	=	combination pinhole consists of 2/7/42 2/9/46,35 2/10/60
L	=	length
l	=	clamping length
LD	=	left hand twist
LEN	=	Leitz standard profiles
LL	=	left hand rotation
M	=	metric thread
MBM	=	minimum order quantity
MC	=	multi-purpose steel, coated
MD	=	thickness of knife
min^{-1}	=	revolutions per minute (RPM)
MK	=	morse taper
m min^{-1}	=	metres per minute
m s^{-1}	=	metres per second
n	=	RPM
$n_{max.}$	=	maximum permissible RPM
NAL	=	position of hub
ND	=	thickness of hub
NH	=	zero height
NL	=	cutting length
NLA	=	pinhole dimensions
NT	=	grooving depth
P	=	profile
POS	=	cutter position
PT	=	profile depth
PG	=	profile group
QAL	=	cutting material quality
R	=	radius
RD	=	right hand twist
RL	=	right hand rotation
RP	=	radius of cutter
S	=	shank dimension
SB	=	cutting width
SET	=	set
SLB	=	slotting width
SLL	=	slotting length
SLT	=	slotting depth
SP	=	tool steel
ST	=	Cobalt-basis cast alloys, e.g. Stellit®
STO	=	shank tolerance
SW	=	cutting angle
TD	=	diameter of tool body
TDI	=	thickness of tool
TG	=	pitch
TK	=	reference diameter
UT	=	cutting edges with irregular pitch
V	=	number of spurs
v_c	=	cutting speed
v_f	=	feed speed
VE	=	packing unit
VSB	=	adjustment range
WSS	=	workpiece material
Z	=	number of teeth
ZA	=	number of fingers
ZF	=	tooth shape (cutting edge shape)
ZL	=	finger length

Notes to the Lexicon concerning the diagrams and tables

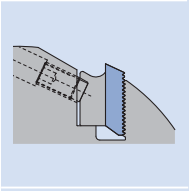
The statements made in the diagrams and tables relate to specific conditions and represent parameters from tests subjected to defined conditions. Variations when using tools in individual case due to special application conditions may be possible. Our support team will provide you with detailed information.



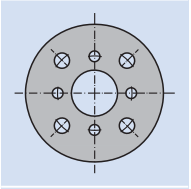
8. Knives and spare parts



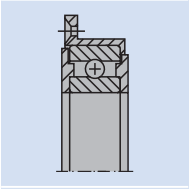
8.1. Knives and blank knives 2
8.1.1 Turnblade knives 2
8.1.2 Spurs 9
8.1.3 Grooving knives / profile grooving knives 10
8.1.4 Edging knives 12
8.1.5 Planer knives 14
8.1.6 Blank knives 25
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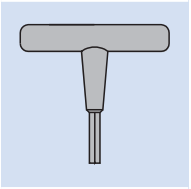
8.2. Spare parts and clamping parts 34
8.2.1 For planer / profile cutterheads 34



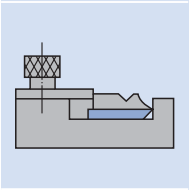
8.3. Spacers 35



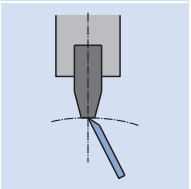
8.4. Ball bearings and guide rings 40



8.5. Keys 41



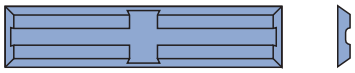
8.6. Setting gauges / mounting devices 43



8.7. Jointing stones 46

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ID index 48



Turnblade knife for router cutter
WL 100 1

Workpiece material:
Softwood and hardwood

Cutting material:
HW

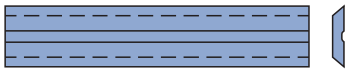
Knife height up to 5.5 mm

HW-05
TM 410 0

SB	H	DIK	KBZ	QAL	VE	ID
mm	mm	mm			PCS	
20	4.1	1.1	WL 100-1	HW-05	10	**005186** ●
20	5.5	1.1	WL 100-1	HW-05	10	**005187** ●
25	5.5	1.1	WL 100-1	HW-05	10	**005188** ●
30	5.5	1.1	WL 100-1	HW-05	10	**005189** ●
40	5.5	1.1	WL 100-1	HW-05	10	**005190** ●
50	5.5	1.1	WL 100-1	HW-05	10	**005191** ●

ID = 1 piece.





Turnblade knife HW

Cutting material recommendation	HW-30F	HW-05
Softwood	♦	◇
Hardwood	◇	♦
Glulam	◇	♦
Chipboard	◇	♦
MDF	◇	♦
Thermoplastics (PE, PP, PVC, etc.)	◇	♦

♦ suitable ◇ partly suitable

Cutting material:
HW fine grain quality/ HW

Knife height 8 mm

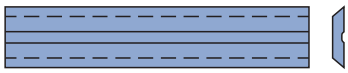
HW-30F / HW-05
TM 410 0

SB	H	DIK	VE	ID	ID
mm	mm	mm	PCS	HW-05	HW-30F
7.7	8	1.5	10	**005053** ●	**005068** ●
9.7	8	1.5	10	**005054** ●	**005197** ●
11.7	8	1.5	10	**005055** ●	**005069** ●
14.7	8	1.5	10	**005056** ●	**005070** ●
19.7	8	1.5	10	**005057** ●	**005071** ●
25	8	1.5	10	**005058** ●	**005198** ●
30	8	1.5	10	**005059** ●	**005072** ●
35	8	1.5	10	**005400** ●	**005073** ●
40	8	1.5	10	**005401** ●	**005074** ●
45	8	1.5		**007681** ●	**007679** □
50	8	1.5	10	**005402** ●	**005075** ●
60	8	1.5	10	**005403** ●	**005076** ●
70	8	1.5		**007682** ●	**007680** □
80	8	1.5	10		**005077** ●
80	8	1.5		**005404** ●	
100	8	1.5		**005405** ●	**005184** ●
120	8	1.5		**005406** ●	**005185** ●

ID = 1 piece.

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





Turnblade knife HW

Cutting material recommendation	HW-30F MC	HW-30F MC Micro
Softwood	♦	♦
Hardwood	◇	♦
Glulam	◇	◇
Chipboard		
MDF		
Thermoplastics (PE, PP, PVC, etc.)	◇	◇
	HW-05 MC	TDC
Softwood	◇	◇
Hardwood	♦	◇
Glulam	♦	♦
Chipboard	♦	♦
MDF	♦	♦
Thermoplastics (PE, PP, PVC, etc.)	♦	♦

♦ suitable ◇ partly suitable

Coating:
Marathon MC (Multi Coating) / Marathon TDC (Tungsten Diamond Coating)

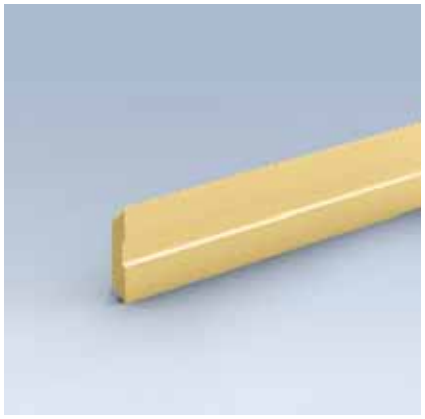
Attention:
HW-30F MC cutting edges with microfinish for high demands on finish quality and cutting performance

Knife height 8 mm Marathon

HW-30F MC / HW-30F MC Micro / HW-05 MC / HW TDC
TM 410 0 50, TM 410 0 70

SB mm	H mm	DIK mm	VE PCS	ID HW-30F MC	ID HW-30F MC Micro	ID HW-05 MC	ID HW TDC
7.7	8	1.5	10	**601600** ●	**601704** ●	**601628** ●	**601416**
9.7	8	1.5	10	**601601** ●	**601705** ●	**601629** ●	**601417**
11.7	8	1.5	10	**601602** ●	**601706** ●	**601630** ●	**601418**
14.7	8	1.5	10	**601603** ●	**601707** ●	**601631** ●	**601419**
19.7	8	1.5	10	**601604** ●	**601708** ●	**601632** ●	**601420**
25	8	1.5	10	**601605** ●	**601709** ●	**601633** ●	**601421**
30	8	1.5	10	**601606** ●	**601710** ●	**601634** ●	**601422**
35	8	1.5	10	**601607** ●	**601711** ●	**601635** ●	**601423**
40	8	1.5	10	**601608** ●	**601712** ●	**601636** ●	**601424**
45	8	1.5		**601609** □	**601713** □	**601637** ●	**601425**
50	8	1.5	10	**601610** ●		**601638** ●	**601426**
50	8	1.5			**601714** ●		
60	8	1.5	10	**601611** ●		**601639** ●	**601427**
60	8	1.5			**601715** ●		
70	8	1.5		**601612** □	**601716** □	**601640** ●	**601428**
80	8	1.5	10	**601613** ●			**601429**
80	8	1.5			**601717** ●	**601641** ●	
100	8	1.5		**601614** ●	**601718** ●	**601642** ●	**601430**
120	8	1.5		**601615** ●	**601719** ●	**601643** ●	**601431**

ID = 1 piece.





One-way knife HW



Workpiece material:
Softwood and hardwood

Cutting material:
HW fine grain quality (HW 30F)
HW (HW-05)

Coating:
Marathon MC (Multi Coating)

RipTec:
Cutting edges with RipTec profile for high surface quality and cutting performance

Changeable knife 8 mm Marathon RipTec for turnblade knife tools Integral

HW-30F MC RipTec
TM 140 0 08

SB mm	H mm	DIK mm	KBZ	QAL	VE PCS	ID
8	8	1.5	EPR 8/8-MC	HW-30F MC	10	**601744**
10	8	1.5	EPR 8/10-MC	HW-30F MC	10	**601745**
12	8	1.5	EPR 8/12-MC	HW-30F MC	10	**601746**
14	8	1.5	EPR 8/15-MC	HW-30F MC	10	**601747**
20	8	1.5	EPR 8/20-MC	HW-30F MC	10	**601748**
24	8	1.5	EPR 8/25-MC	HW-30F MC	10	**601749**
29	8	1.5	EPR 8/30-MC	HW-30F MC	10	**601750**
34	8	1.5	EPR 8/35-MC	HW-30F MC	10	**601751**
39	8	1.5	EPR 8/40-MC	HW-30F MC	10	**601752**
44	8	1.5	EPR 8/45-MC	HW-30F MC		**601753**
49	8	1.5	EPR 8/50-MC	HW-30F MC	10	**601754**
59	8	1.5	EPR 8/60-MC	HW-30F MC	10	**601755**
69	8	1.5	EPR 8/70-MC	HW-30F MC		**601756**
78	8	1.5	EPR 8/80-MC	HW-30F MC	10	**601757**
98	8	1.5	EPR 8/100-MC	HW-30F MC		**601758**
118	8	1.5	EPR 8/120-MC	HW-30F MC		**601759**

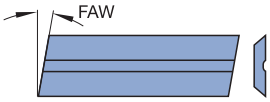
ID = 1 piece.

HW-05 MC RipTec
TM 140 0 08

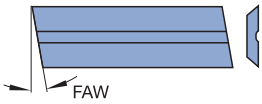
SB mm	H mm	DIK mm	KBZ	QAL	VE PCS	ID
8	8	1.5	EPR 8/8B-MC	HW-05 MC	10	**601760**
10	8	1.5	EPR 8/10B-MC	HW-05 MC	10	**601761**
12	8	1.5	EPR 8/12B-MC	HW-05 MC	10	**601762**
14	8	1.5	EPR 8/15B-MC	HW-05 MC	10	**601763**
20	8	1.5	EPR 8/20B-MC	HW-05 MC	10	**601764**
24	8	1.5	EPR 8/25B-MC	HW-05 MC	10	**601765**
29	8	1.5	EPR 8/30B-MC	HW-05 MC	10	**601766**
34	8	1.5	EPR 8/35B-MC	HW-05 MC	10	**601767**
39	8	1.5	EPR 8/40B-MC	HW-05 MC	10	**601768**
44	8	1.5	EPR 8/45B-MC	HW-05 MC		**601769**
49	8	1.5	EPR 8/50B-MC	HW-05 MC		**601770**
59	8	1.5	EPR 8/60B-MC	HW-05 MC		**601771**
69	8	1.5	EPR 8/70B-MC	HW-05 MC		**601772**
78	8	1.5	EPR 8/80B-MC	HW-05 MC		**601773**
98	8	1.5	EPR 8/100B-MC	HW-05 MC		**601774**
118	8	1.5	EPR 8/120B-MC	HW-05 MC		**601775**

ID = 1 piece.

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Turnblade knife ZM 10/x



Turnblade knife ZM 11/x

Workpiece material:
Softwood and hardwood

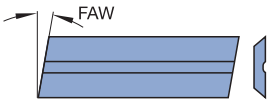
Cutting material:
HW fine grain quality

Knife height 8 mm (bevel/tenoning tools)

HW-F
TM 410 0

SB mm	H mm	DIK mm	FAW °	KBZ	QAL	ID
21	8	1.5	10°	ZM 10/1	HW-F	**005004** ●
15	8	1.5	14°	ZM 10/4	HW-F	**005050** ●
21	8	1.5	10°	ZM 11/1	HW-F	**005006** ●
15	8	1.5	14°	ZM 11/4	HW-F	**005051** ●

ID = 1 piece.



Turnblade knife ZM 10/x



Turnblade knife ZM 11/x

Cutting material recommendation	HW-30F MC	HW-05 MC
Softwood	♦	◇
Hardwood	◇	♦
Glulam	◇	♦
Chipboard		♦
MDF		♦
Thermoplastics (PE, PP, PVC, etc.)	◇	♦

♦ suitable ◇ partly suitable

Coating:
Marathon MC (Multi Coating)

Knife height 8 mm Marathon (bevel/tenoning tools)

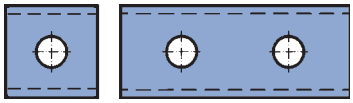
HW-30F MC / HW-05 MC
TM 410 0 50

SB mm	H mm	DIK mm	FAW °	ID HW-05 MC	ID HW-30F MC
15	8	1.5	8°	**601645** ●	**601616** ●
15	8	1.5	8°	**601644** ●	**601617** ●
15	8	1.5	14°	**601647** ●	**601618** ●
15	8	1.5	14°	**601646** ●	**601619** ●
21	8	1.5	10°	**601649** ●	**601620** ●
21	8	1.5	10°	**601648** ●	**601621** ●

ID = 1 piece.



Knife type:
Type 1 Type 2



Turnblade knife

Cutting material recommendation	HW-05F	HW-02 UF
Softwood	♦	◇
Hardwood	◇	♦
Glulam	◇	♦
Chipboard	◇	♦
MDF	◇	♦
Thermoplastics (PE, PP, PVC, etc.)	◇	♦

♦ suitable ◇ partly suitable

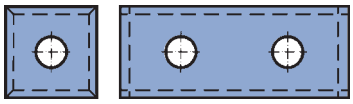
Knife height 12 mm

HW-05F / HW-02UF
TM 405 0

Knife	SB mm	H mm	DIK mm	VE PCS	ID HW-05F	ID HW-02UF
1	7.6	12	1.5	10	**005080** ●	
1	9	12	1.5	10	**005158** ●	
1 *	12	12	1.5	10	**005081** ●	
1	15	12	1.5	10	**005082** ●	
1	20	12	1.5	10	**005083** ●	**602001** ●
2	30	12	1.5	10	**005084** ●	**602002** ●
2	40	12	1.5	10	**005085** ●	**602003** ●
2	50	12	1.5	10	**005086** ●	**602004** ●
2	60	12	1.5	10	**005087** ●	

ID = 1 piece.
* = with 4 cutting edges.

Cutting material:
HW / HW ultra fine grain quality

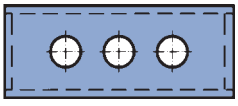


Turnblade knife with 4 cutting edges

Cutting material recommendation	HW-05F	HW-02 UF
Softwood	♦	◇
Hardwood	◇	♦
Glulam	◇	♦
Chipboard	◇	♦
MDF	◇	♦
Thermoplastics (PE, PP, PVC, etc.)	◇	♦

♦ suitable ◇ partly suitable

Cutting material:
HW / HW ultra fine grain quality



Turnblade knife with 4 cutting edges and 3 holes

Knife height 12 mm with 4 cutting edges

HW-05F / HW-02UF
TM 405 0

SB mm	H mm	DIK mm	VE PCS	ID HW-02UF	ID HW-05F
30	12	1.5	10	**602005** ●	**005161** ●
50	12	1.5	10	**602006** ●	**006506** ●

ID = 1 piece.

HW-05F with 3 holes
TM 405 0

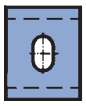
SB mm	H mm	DIK mm	QAL	VE PCS	ID
50	12	1.7	HW-05F	10	**007668** ●

ID = 1 piece.

Workpiece material:
Solid wood, wood derived materials

Cutting material:
HW

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Turnblade knife

Workpiece material:
Softwood and hardwood

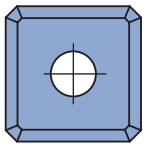
Cutting material:
HW

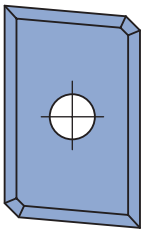
Knife height 12 mm (slotting tools)

HW
TM 405 0

SB mm	H mm	DIK mm	KBZ	QAL	ID
7.6	12	1.5	SM 1/1	HW	**005120** ●
9.6	12	1.5	SM 1/2	HW	**005121** ●
11.6	12	1.5	SM 1/3	HW	**005122** ●

Knife type:
Type 1 Type 2





Turnblade knife

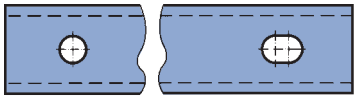
Workpiece material:
Softwood and hardwood

Cutting material:
HW

Knife height 12 mm with bevel

HW
TM 405 0

Knife	SB mm	H mm	DIK mm	FAW °	QAL	ID
1	12	12	1.5	1x45°	HW	**602009** ●
2	19.7	12	1.5	5°	HW	**602010** ●



Turnblade knife

Workpiece material:
Softwood and hardwood

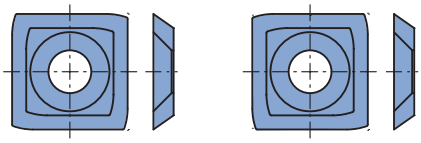
Cutting material:
HW

Knife height 13 mm

HW
TM 405 0

SB mm	H mm	DIK mm	QAL	VE PCS	ID
80	13	2.2	HW	10	**005096** ●
100	13	2.2	HW	10	**005097** ●
120	13	2.2	HW	10	**005098** ●

ID = 1 piece.



Workpiece material:
Softwood and hardwood

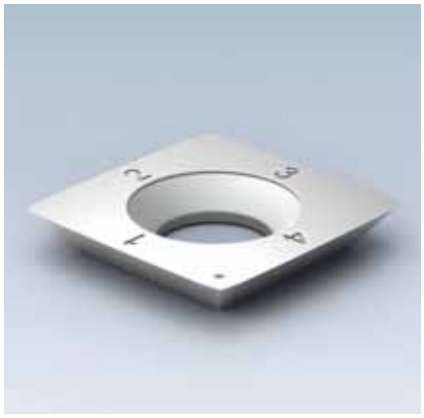
Cutting material:
HW / HW fine grain quality

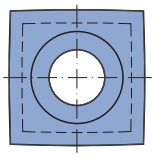
Turnblade knife with radius for calibration moulder System Rotoles

HW
TM 435 0

SB mm	H mm	DIK mm	QAL	VE PCS	ID left	ID right
14.3	14.3	2.5	HW	10	**602525** ●	**602526** ●
14	14	2	HW-10F	10	**602527** ●	**602528** ●

ID = 1 piece.





HW turnblade knife

Workpiece material:
Softwood and hardwood

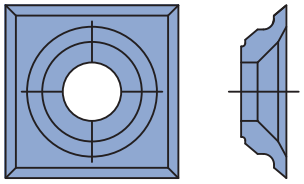
Cutting material:
HW / TDC

Turnblade knives for cutterhead system HeliCut

HW / TDC
TM 135 0, TM 405 0, TM 435 0

BEM	SB mm	H mm	DIK mm	QAL	VE PCS	ID
HeliCut 15	15	15	2.5	HW	10	**009549** ●
HeliCut 15	15	15	2.5	HW-MF	10	**009543** ●
HeliCut 15	15	15	2.5	TDC		**602900** ●
HeliCut 11 (peripheral tip)	11	11	1.5	HW	10	**602515** ●
HeliCut 11 (peripheral tip)	11	11	1.5	TDC		**602904** ●
HeliCut 11 (plunging tip D30)	20.6	12.7	2	HW	10	**602531** ●
HeliCut 11 (plunging tip D40)	22	12.7	2	HW	10	**602516** ●

ID = 1 piece.



Turnblade knife with 4 cutting edges

Workpiece material:
Softwood and hardwood

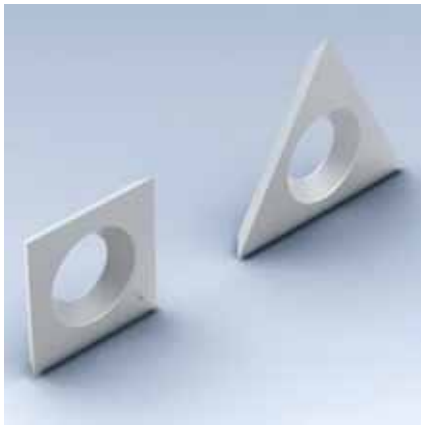
Cutting material:
HW

Knife height 21 mm with 4 cutting edges

HW
TM 410 0

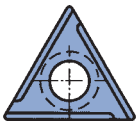
SB mm	H mm	DIK mm	QAL	ID
21	21	5.5	HW	**009527** ●

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





VS 1



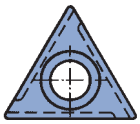
VS 3L



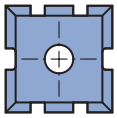
VS 2



VS 4



VS 3R



ID **005100**

Workpiece material:
Solid wood, wood derived materials

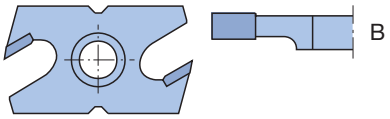
Cutting material:
HW fine grain quality / DP*

Spurs

HW / DP
TM 405 0, TM 480 0

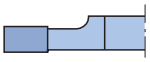
SB mm	H mm	DIK mm	KBZ	QAL	VE PCS	ID
14	14	2	VS 1	HW-F	10	**005099** ●
14	14	1.2	VS 4	HW	10	**005130** ●
14	14	1.2	Holz-Her	HW	10	**602500** ●
15	15	2		HW		**005100** ●
19		2	VS 2	HW-F	10	**005115** ●
19		2	VS 2R*	HW-F	10	**006615** ●
19		2	VS 2L*	HW-F	10	**006616** ●
19		2	VS 2	DP*	2	**006607** ●
19		2	VS 3R	HW-F		**005116** ●
19		2	VS 3L	HW-F		**005159** ●

* = Spurs with reduced slotting depth. Knives can be used alternatively in VS2 knife seating.
DP* = diamond coated.
ID = 1 piece.



Grooving knife

Grooving knife image



Grooving knife mirror image

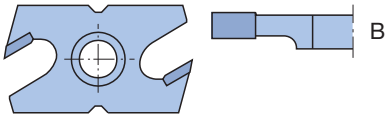
Workpiece material:
Softwood and hardwood

Cutting material:
HW fine grain quality

Grooving knives

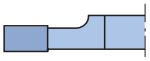
Mechanical feed
TM 460 0

SB mm	KBZ	QAL	ID
3	NA 3B	HW-F	**008315** ●
3	NA 3S	HW-F	**008316** ●
3	NAK 3B*	HW-F	**616002** ●
3	NAK 3S*	HW-F	**616003** ●
4.5	NA 4,5	HW-F	**008333** ●
4	NA 4	HW-F	**008317** ●
5	NA 5	HW-F	**008318** ●
7	NA 7	HW-F	**008319** ●
8	NAN 8	HW-F	**008349** ●
9	NA 9	HW-F	**008320** ●



Grooving knife

Grooving knife image



Grooving knife mirror image

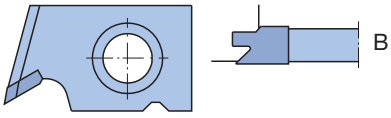
Workpiece material:
Softwood and hardwood

Cutting material:
HW fine grain quality

Manual feed
TM 460 1

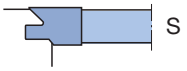
SB mm	KBZ	QAL	ID
3	NB 3B	HW-F	**008321** ●
3	NB 3S	HW-F	**008322** ●
3	NBK 3B*	HW-F	**616000** ●
3	NBK 3S*	HW-F	**616001** ●
4	NB 4	HW-F	**008323** ●
5	NB 5	HW-F	**008324** ●
7	NB 7	HW-F	**008325** ●
8	NBN 8	HW-F	**008348** ●
9	NB 9	HW-F	**008326** ●

* Grooving knife with reduced grooving depth.



Profile grooving knife

Profile grooving knife image



Profile grooving knife mirror image

Workpiece material:
Softwood and hardwood

Cutting material:
HW fine grain quality

Profile grooving knives

For sealing strip
TM 160 0

SB mm	KBZ	QAL	ID
8	NC 1B	HW-F	**008327** ●
8	NC 1S	HW-F	**008328** ●

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Lamello turnblade knives

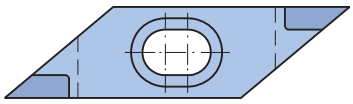
Cutting material:
HW

Lamello turnblade knives

HW
TM 463 0

SB mm	H mm	DIK mm	KBZ	QAL	VE PCS	ID
18	18	1.95	WP 18/1,95	HW	10	**005114** ●
18	18	2.5	WP 18/2,5	HW	10	**005195** ●

ID = 1 piece



Rhomboid turnblade knives

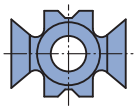
Cutting material:
HW fine grain quality

Rhomboid turnblade knives

HW-F
TM 461 0

L mm	H mm	SB mm	KBZ	QAL	ID
45.416	12	5.6	RMA 5,6	HW-F	**008329** ●
45.416	12	6.6	RMA 6,6	HW-F	**008330** ●





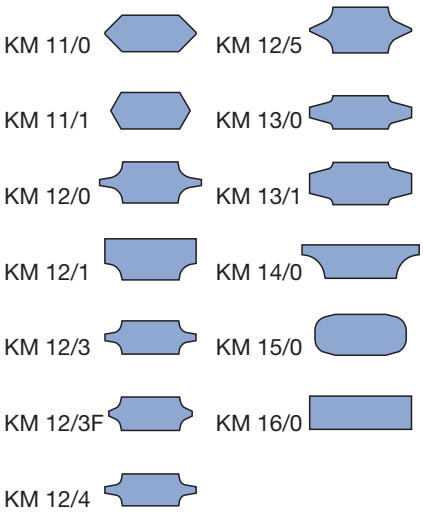
Workpiece material:
Softwood and hardwood

Cutting material:
HW fine grain quality

Mechanical feed

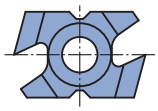
HW-F
TM 462 0

SB mm	H mm	DIK mm	KBZ	QAL	ID
20	15	8	KM 11/0 45°	HW-F	**008268** ●
20	15	7	KM 12/4 R1,5	HW-F	**008272** ●
20	15	7.3	KM 12/3 R2	HW-F	**008307** ●
22.3	15	9	KM 12/0 R3	HW-F	**008270** ●
22	15	9	KM 15/0 R3	HW-F	**008275** ●
20	15	9	KM 12/1 R3	HW-F	**008271** ●
17.5	15	8	KM 11/1 60°	HW-F	**008269** ●
18.3	15	7.3	KM 12/3F R2F	HW-F	**008308** ●
22.3	15	10	KM 12/5 R3F	HW-F	**008273** ●
22.3	15	7.3	KM 13/0 N5	HW-F	**008274** ●
22.3	15	9	KM 13/1 N7	HW-F	**008287** ●
22.3	15	7.3	KM 16/0	HW-F	**008286** ●
22.3	15	7.3	KM 14/0 R5	HW-F	**008347** ●



● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





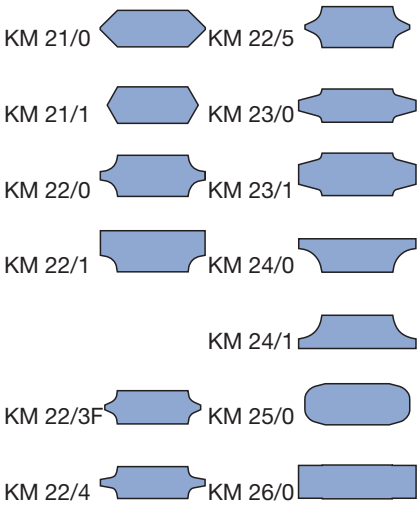
Workpiece material:
Softwood and hardwood

Cutting material:
HW fine grain quality

Manual feed

HW-F
TM 462 1

SB mm	H mm	DIK mm	KBZ	QAL	ID
23	15	7.3	KM 22/3 R2	HW-F	**008309** ●
23	15	8	KM 21/0 45°	HW-F	**008292** ●
23	15	9	KM 22/1 R3	HW-F	**008290** ●
25.7	15	7.3	KM 24/0 R5	HW-F	**008305** ●
23	15	7	KM 22/4 R1,5	HW-F	**008295** ●
23	15	9	KM 25/0 R3	HW-F	**008291** ●
25.7	15	9.3	KM 23/1 N7	HW-F	**008298** ●
25.7	15	7.3	KM 24/1 R5	HW-F	**008306** ●
23	15	9	KM 22/0 R3	HW-F	**008293** ●
20.5	15	8	KM 21/1 60°	HW-F	**008294** ●
21	15	7.3	KM 22/3F R2F	HW-F	**008310** ●
23	15	9	KM 22/5 R3F	HW-F	**008296** ●
25.7	15	7.3	KM 23/0 N5	HW-F	**008297** ●
25.7	15	7.3	KM 26/0	HW-F	**008299** ●





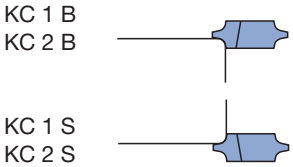
Workpiece material:
Softwood and hardwood

Cutting material:
HW fine grain quality

With shear angle

HW-F
TM 462 0

SB mm	H mm	DIK mm	KBZ	QAL	ID
20	15	8.3	KC 1B (R2)	HW-F	**008334** ●
20	15	10	KC 2B (R3)	HW-F	**008335** ●
20	15	8.3	KC 1S (R2)	HW-F	**008336** ●
20	15	10	KC 2S (R3)	HW-F	**008337** ●





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

♦ suitable ◇ partly suitable



Cross section of planer knife
(HS Classic / HS Premium / MC33)



Cross section of planer knife (HW)

Cutting material:
HS Classic / HS Premium / MC33 / HW
Wedge angle:
40° (HS Classic / HS Premium / MC33)
45° (HW)

Knife height 30 mm

For planerhead wedge-type system WM 200 2 05
TM 100 0, TM 100 0 03, TM 100 0 05

SB mm	H mm	DIK mm	VE PCS	ID HS Classic	ID HS Premium	ID MC33	ID HW
60	30	3	2	**605000**	**027101** ●	**606700** ●	**027277** ●
80	30	3	2	**605001**	**027102** ●	**606701** ●	**027278** ●
100	30	3	2	**605002** ●	**027103** ●	**606702** ●	**027279** ●
110	30	3	2	**605003**	**027104** ●	**606703** ●	**027280** ●
120	30	3	2	**605004**	**027105** ●	**606704** ●	**027281** ●
130	30	3	2	**605005** ●	**027106** ●	**606705** ●	**027282** ●
150	30	3	2	**605006** ●	**027107** ●	**606706** ●	**027283** ●
160	30	3	2	**605045** ●	**027163** ●	**606745** ●	
170	30	3	2	**605007** ●	**027108** ●	**606707** ●	**027284** ●
180	30	3	2	**605008** ●	**027109** ●	**606708** ●	**027285** ●
190	30	3	2	**605009**	**027144** ●	**606709** ●	**027322** ●
210	30	3	2	**605010**	**027110** ●	**606710** ●	**027286** ●
230	30	3	2	**605011** ●	**027111** ●	**606711** ●	**027287** ●
240	30	3	2	**605012** ●	**027134** ●	**606712** ●	**027323** ●
250	30	3	2	**605013**	**027161** ●	**606713** ●	
260	30	3	2	**605014** ●	**027112** ●	**606714** ●	**027288** ●
270	30	3	2	**605015**	**027162** ●	**606715** ●	
310	30	3	2	**605016** ●	**027113** ●	**606716** ●	**027289** ●
320	30	3	2	**605046**	**027164** ●	**606746** ●	
360	30	3	2	**605029**	**027114** ●	**606729** ●	**027292** ●
400	30	3	2	**605030**	**027115** ●	**606730** ●	
410	30	3	2	**605031** ●	**027116** ●	**606731** ●	**027293** ●
460	30	3	2	**605032**	**027130** ●	**606732** □	**027295** ●
500	30	3	2	**605033**	**027117** ●	**606733** □	
510	30	3	2	**605034** ●	**027118** ●	**606734** □	**027296** ●
600	30	3	2	**605035**	**027119** ●	**606735** □	
610	30	3	2	**605036** ●	**027120** ●	**606736** □	**027297** ●
630	30	3	2	**605037**	**027125** ●	**606737** □	**027298** ●
640	30	3	2	**605038** ●	**027121** ●	**606738** □	**027299** ●
710	30	3	2	**605039**	**027122** ●	**606739** □	**027300** ●
810	30	3	2	**605040** ●	**027123** ●	**606740** □	**027302** ●

ID = 1 piece.

Knife height 35 mm

For long planerheads wedge-type system
TM 100 0, TM 100 0 03, TM 100 0 05

SB mm	H mm	DIK mm	VE PCS	ID HS Classic	ID HS Premium	ID MC33	ID HW
60	35	3	2	**605119**	**027387** ●	**606819** ●	
100	35	3	2	**605120**	**027388** ●	**606820** ●	
160	35	3	2	**605121**	**027389** ●	**606821** ●	
230	35	3	2	**605122**	**027390** ●	**606822** ●	
310	35	3	2	**605100**	**027351** ●	**606800** ●	**027303** ●
320	35	3	2	**605101**	**027352** ●	**606801** ●	**027304** □
330	35	3	2	**605102**	**027353** ●	**606802** ●	**027305** □
360	35	3	2	**605103**	**027354** ●	**606803** ●	**027306** □
400	35	3	2	**605104**	**027355** ●	**606804** ●	**027307** □
410	35	3	2	**605105** ●	**027356** ●	**606805** ●	**027308** ●
450	35	3	2	**605106**	**027357** ●	**606806** □	**027309** □
460	35	3	2	**605107**	**027358** ●	**606807** □	**027310** □
500	35	3	2	**605108** ●	**027359** ●	**606808** □	**027311** □
510	35	3	2	**605109** ●	**027360** ●	**606809** □	**027312** ●
600	35	3	2	**605110**	**027361** ●	**606810** □	**027313** □
610	35	3	2	**605111** ●	**027362** ●	**606811** □	**027314** □
630	35	3	2	**605112**	**027363** ●	**606812** □	**027315** ●
635	35	3	2	**605113**	**027364** ●	**606813** □	**027316** ●
640	35	3	2	**605114** ●	**027365** ●	**606814** □	**027317** ●
660	35	3	2		**027371** ●		
700	35	3	2	**605115**	**027366** ●	**606815** □	**027318** □
710	35	3	2	**605116**	**027367** ●	**606816** □	**027319** □
740	35	3	2	**605117**	**027368** ●	**606817** □	**027320** □
810	35	3	2	**605118** ●	**027369** ●	**606818** □	**027321** ●

ID = 1 piece.

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Cutting material recommendation	HS	HW
Solid wood dry	♦	
Solid wood wet	◇	
Hardwood dry		♦
Hardwood wet		♦
Glulam		♦
Chipboard		◇
MDF		◇
Thermoplastics (PE, PP, PVC, etc.)		◇
WPC (Wood-Plastic-Composite)		◇

♦ suitable ◇ partly suitable



Cross section of planer knife
(HS Classic / HS Premium / MC33)



Cross section of planer knife (HW)

Cutting material:
HS / HW

Knives for cassette system

Planer knives 30 mm with threaded bore
TM 105 0

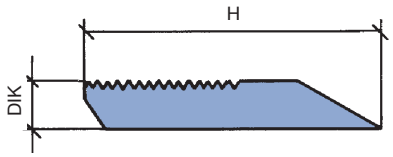
SB mm	H mm	DIK mm	VE PCS	ID HS	ID HW
130	30	3	2	**006825** ●	**006915** ●
150	30	3	2	**006928** ●	**006931** ●
180	30	3	2	**006826** ●	**006916** ●
190	30	3	2	**006929** ●	
230	30	3	2	**006827** ●	**006917** ●
240	30	3	2	**006926** ●	

ID = 1 piece.



Cutting material recommendation	MC 33
Solid wood dry	♦
Solid wood wet	♦
Hardwood dry	♦
Hardwood wet	♦
Glulam	◇
Chipboard	
MDF	
Thermoplastics (PE, PP, PVC, etc.)	♦
WPC (Wood-Plastic-Composite)	♦

♦ suitable ◇ partly suitable



Cutting material:
MC33

Planer knives with 60° back serration

For planerhead with 60° back serrated knife fixture
AT 103 0 29

SB mm	H mm	DIK mm	SET PCS	QAL	ID
150	30	5	2	MC33	**697359** □
230	30	5	2	MC33	**697360** □
310	30	5	2	MC33	**697361** □
320	30	5	2	MC33	**697362** □
330	30	5	2	MC33	**697363** □
40	40	5	2	MC33	**697300** ●
60	40	5	2	MC33	**697301** ●
80	40	5	2	MC33	**697302** ●
100	40	5	2	MC33	**697303** ●
130	40	5	2	MC33	**697304** ●
150	40	5	2	MC33	**697305** ●
170	40	5	2	MC33	**697306** ●
180	40	5	2	MC33	**697307** ●
190	40	5	2	MC33	**697308** ●
210	40	5	2	MC33	**697309** ●
230	40	5	2	MC33	**697310** ●
240	40	5	2	MC33	**697311** ●
270	40	5	2	MC33	**697312** ●
310	40	5	2	MC33	**697313** ●

Set of the same weight.

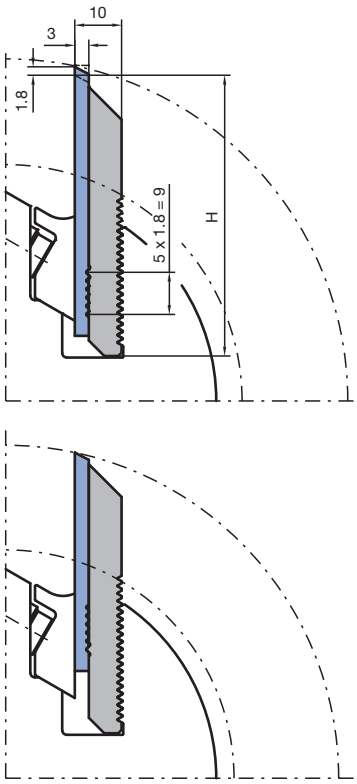
Attention:
Please do not mix new MC33 blank knives with previous MC blank knives in one cutterhead due to weight difference.

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Cutting material recommendation	HW-30F jointable	HW-10F not jointable
Solid wood dry	♦	
Solid wood wet		
Hardwood dry	♦	♦
Hardwood wet		◇
Glulam	◇	♦
Chipboard		♦
MDF	♦	♦
Thermoplastics (PE, PP, PVC, etc.)	♦	♦
WPC (Wood-Plastic-Composite)	♦	♦

♦ suitable ◇ partly suitable



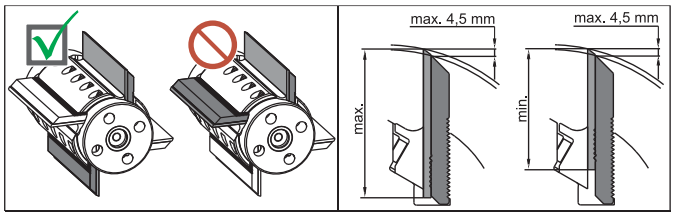
Planer knives Powerknife System PKS®

For planerhead with 60° back serrated knife fixture
AT 103 0 26, AT 107 0 26

SB mm	H mm	DIK mm	SET PCS	QAL	ID Blank knife set	ID Blank knife set with backing plate
40	40	10	2	HW-30F	**696614** □	**697814** □
60	40	10	2	HW-30F	**696615** □	**697815** □
80	40	10	2	HW-30F	**696616** □	**697816** □
100	40	10	2	HW-30F	**696617** □	**697817** □
130	40	10	2	HW-30F	**696618** □	**697818** □
150	40	10	2	HW-30F	**696619** ●	**697819** ●
170	40	10	2	HW-30F	**696620** ●	**697820** ●
180	40	10	2	HW-30F	**696621** □	**697821** □
190	40	10	2	HW-30F	**696622** □	**697822** □
210	40	10	2	HW-30F	**696623** ●	**697823** ●
230	40	10	2	HW-30F	**696624** □	**697824** □
240	40	10	2	HW-30F	**696625** ●	**697825** ●
270	40	10	2	HW-30F	**696626** □	**697826** □
310	40	10	2	HW-30F	**696627** ●	**697827** ●
40	40	10	2	HW-10F	**696600** □	**697800** □
60	40	10	2	HW-10F	**696601** □	**697801** □
80	40	10	2	HW-10F	**696602** □	**697802** □
100	40	10	2	HW-10F	**696603** □	**697803** □
130	40	10	2	HW-10F	**696604** □	**697804** □
150	40	10	2	HW-10F	**696605** ●	**697805** ●
170	40	10	2	HW-10F	**696606** ●	**697806** ●
180	40	10	2	HW-10F	**696607** □	**697807** □
190	40	10	2	HW-10F	**696608** □	**697808** □
210	40	10	2	HW-10F	**696609** ●	**697809** ●
230	40	10	2	HW-10F	**696610** □	**697810** □
240	40	10	2	HW-10F	**696611** ●	**697811** ●
270	40	10	2	HW-10F	**696612** □	**697812** □
310	40	10	2	HW-10F	**696613** ●	**697813** ●

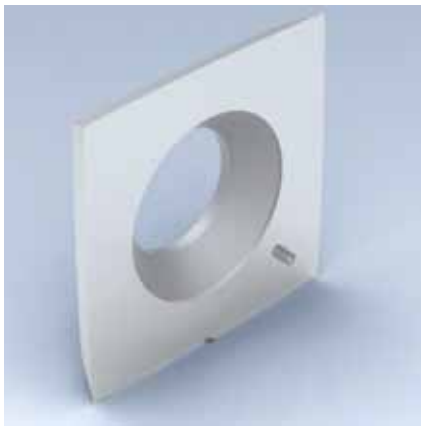
- Blank knives with polished cutting face for high cutting edge quality.
- Solid tungsten carbide - profile knives, adjustable (1.80 mm steps).
- Knives supported by profiled backing plates.
- Resharpening area 10.8 mm at maximum profile depth.

Set of the same weight.



Cutting material:
HW-30F / HW-10F

Attention:
Maximum knife protrusion above the backing plate 4.5 mm. For safety reasons, only mount knives and backing plates of same weight in opposite seatings.

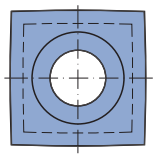


Turnblade planing knives HeliPlan

For cutterhead system HeliPlan
TM 405 0

BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	15x15x2.5	HW	10	**009535** ●
Turnblade knife	15x15x2.5	TDC		**602901** ●

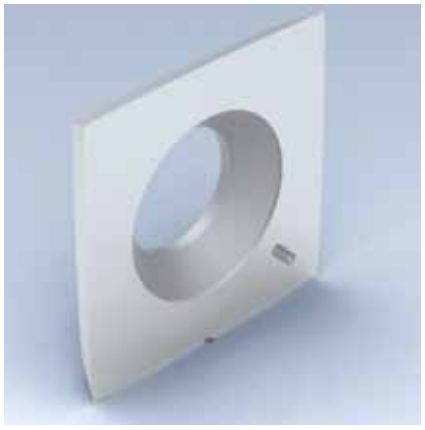
ID = 1 piece.



HW turnblade knife

Workpiece material:
Softwood and hardwood

Cutting material:
HW / TDC

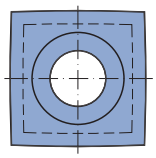


Turnblade planing knives CASTOR

For cutterhead system CASTOR-Finish
TM 405 0

BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	15x15x2.5	HW	10	**009540** ●

ID = 1 piece.



HW turnblade knife

Workpiece material:
Softwood and hardwood

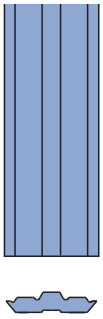
Cutting material:
HW

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



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

♦ suitable ◇ partly suitable



Turnblade knife CentroFix

Cutting material:
HS

Turnblade planing knives CentroStar, CentroFix, QuickFix

For cutterhead system CentroStar, CentroFix, QuickFix - HS
AT 103 0 02, AT 103 0 20

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



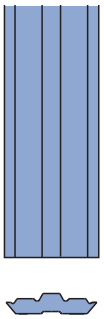
Cutting material recommendation	HS	MC	HW
Solid wood dry	♦	♦	
Solid wood wet	◇	♦	
Hardwood dry		◇	♦
Hardwood wet		♦	♦
Glulam		♦	♦
Clipboard			◇
MDF			◇

♦ suitable ◇ partly suitable

Cutting material:
MC

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

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



Turnblade knife CentroFix

Cutting material:
HW-F

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

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

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

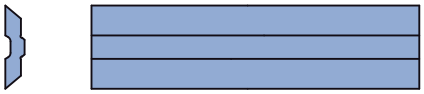


Cutting material recommendation	HS	HW
Solid wood dry	♦	
Solid wood wet	◇	
Hardwood dry		♦
Hardwood wet		♦
Glulam		♦
Clipboard		◇
MDF		◇

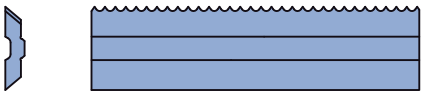
♦ suitable ◇ partly suitable

Cutting material:
HS / HW

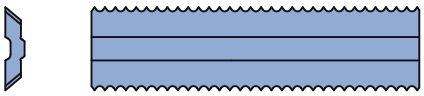
Cutting material:
HW



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



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



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

Turnblade planing knives VariPlan / VariPlan Plus

For cutterhead system VariPlan / VariPlan Plus
AT 103 0 03, AT 103 0 27

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

For cutterhead system VariPlan Plus
AT 103 0 23, AT 103 0 24

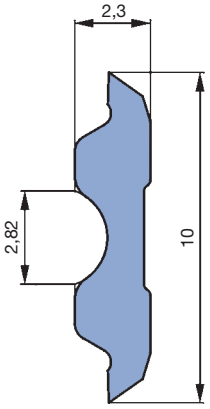
SB mm	H mm	DIK mm	SET PCS	ID Type HW Integral	ID Type HW RipTec
100	16	3.7	2	**611904**	**611204** □
120	16	3.7	2	**611905**	**611205** □
130	16	3.7	2	**611906** ●	**611206** ●
150	16	3.7	2	**611909**	**611209** ●
170	16	3.7	2	**611911** ●	**611211** ●
180	16	3.7	2	**611912** ●	**611212** ●
190	16	3.7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

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



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

♦ suitable ◇ partly suitable



Turnblade knife MicroTec
Turnblade knife TriTec

Workpiece material:
Softwood and hardwood

Cutting material:
HS

Suitable for:
Long planerheads
on surface planers and thickness planing machines with centrifugal force clamping system (e.g. SCM, SAC, Panhans, Martin)
Cutterheads
with centrifugal force clamping system for 4-sided moulders (e.g. Weinig, SCM, Leadermac)

Turnblade planing knives TriTec

For cutterhead system Tersa, HS
AT 103 0 12

SB mm	H mm	DIK mm	QAL	SET PCS	ID
60	10	2.3	HS	4	**610900** □
80	10	2.3	HS	4	**610901** □
100	10	2.3	HS	4	**610902** ●
110	10	2.3	HS	4	**610903** ●
120	10	2.3	HS	4	**610904** ●
130	10	2.3	HS	4	**610905** ●
140	10	2.3	HS	4	**610906** ●
150	10	2.3	HS	4	**610907** ●
170	10	2.3	HS	4	**610908** ●
180	10	2.3	HS	4	**610909** ●
190	10	2.3	HS	4	**610910** ●
200	10	2.3	HS	4	**610911** ●
210	10	2.3	HS	4	**610912** ●
220	10	2.3	HS	4	**610913** ●
230	10	2.3	HS	4	**610914** ●
240	10	2.3	HS	4	**610915** ●
250	10	2.3	HS	4	**610916** ●
260	10	2.3	HS	4	**610917** ●
265	10	2.3	HS	4	**610918** ●
270	10	2.3	HS	4	**610919** ●
300	10	2.3	HS	4	**610920** ●
310	10	2.3	HS	4	**610921** ●
350	10	2.3	HS	4	**610922** ●
360	10	2.3	HS	4	**610923** □
400	10	2.3	HS	4	**610924** ●
410	10	2.3	HS	4	**610925** ●
420	10	2.3	HS	4	**610926** □
430	10	2.3	HS	4	**610927** ●
450	10	2.3	HS	4	**610928** □
460	10	2.3	HS	4	**610929** □
500	10	2.3	HS	4	**610930** ●
510	10	2.3	HS	4	**610931** ●
520	10	2.3	HS	4	**610932** ●
530	10	2.3	HS	4	**610933** ●
600	10	2.3	HS	4	**610934** □
610	10	2.3	HS	4	**610935** ●
630	10	2.3	HS	4	**610936** ●
640	10	2.3	HS	4	**610937** ●
660	10	2.3	HS	4	**610938** ●
710	10	2.3	HS	4	**610939** ●
740	10	2.3	HS	4	**610940** □
810	10	2.3	HS	4	**610941** ●

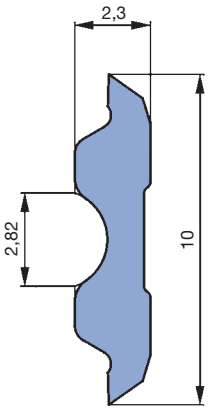
Further dimensions on request.

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



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

♦ suitable ◇ partly suitable



Turnblade knife MicroTec
Turnblade knife TriTec

Cutting material:
HW

Note:
Knives longer than 540 mm are cut into pieces.

Suitable for:
Long planerheads
on surface planers and thickness planing machines with centrifugal force clamping system (e.g. SCM, SAC, Panhans, Martin)
Cutterheads
with centrifugal force clamping system for 4-sided moulders (e.g. Weinig, SCM, Leadermac)

Turnblade planing knives MicroTec

For cutterhead system Tersa, HW
AT 103 0 12

SB mm	H mm	DIK mm	QAL	SET PCS	ID
60	10	2.3	HW	2	**610950** □
80	10	2.3	HW	2	**610951** □
100	10	2.3	HW	2	**610952** □
110	10	2.3	HW	2	**610953** □
120	10	2.3	HW	2	**610954** □
130	10	2.3	HW	2	**610955** □
140	10	2.3	HW	2	**610956** □
150	10	2.3	HW	2	**610957** □
170	10	2.3	HW	2	**610958** □
180	10	2.3	HW	2	**610959** □
190	10	2.3	HW	2	**610960** □
200	10	2.3	HW	2	**610961** □
210	10	2.3	HW	2	**610962** □
220	10	2.3	HW	2	**610963** □
230	10	2.3	HW	2	**610964** □
240	10	2.3	HW	2	**610965** □
250	10	2.3	HW	2	**610966** □
260	10	2.3	HW	2	**610967** □
265	10	2.3	HW	2	**610968** □
270	10	2.3	HW	2	**610969** □
300	10	2.3	HW	2	**610970** □
310	10	2.3	HW	2	**610971** □
350	10	2.3	HW	2	**610972** □
360	10	2.3	HW	2	**610973** □
400	10	2.3	HW	2	**610974** □
410	10	2.3	HW	2	**610975** □
420	10	2.3	HW	2	**610976** □
430	10	2.3	HW	2	**610977** □
450	10	2.3	HW	2	**610978** □
460	10	2.3	HW	2	**610979** □
500	10	2.3	HW	2	**610980** □
510	10	2.3	HW	2	**610981** □
520	10	2.3	HW	2	**610982** □
530	10	2.3	HW	2	**610983** □

Further dimensions on request.



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

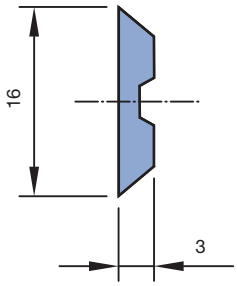
♦ suitable ◇ partly suitable

Cutting material:
HS / MC / HW

Turnblade planing knives Centrolock

For cutterhead system Centrolock / Easylock
AT 103 0 13

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





Cutting material:
HS

Spiral planer knife

Throwaway knife for spiral long planerhead
TM 101 0

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

Resharpenable knife for spiral long planerhead
TM 106 0

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

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

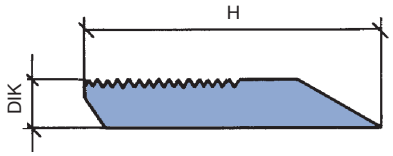


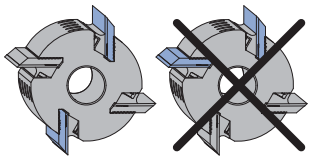
Cutting material recommendation	HS Classic / Premium	MC33	HW
Solid wood dry	♦	♦	◇
Solid wood wet	◇	♦	
Hardwood dry	◇	♦	♦
Hardwood wet	◇	♦	
Glulam		◇	◇
Thermoplastics (PE, PP, PVC, etc.)	♦	♦	◇
WPC (Wood-Plastic-Composite)	◇	♦	◇

♦ suitable ◇ partly suitable

H	PT
mm	mm
50	15
60	20
70	30

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





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

Cutting material:
HS / MC33
The Leitz MC33 cutting material replaces previous design in MC Marathon

Blank knives with 60° back serration

HS and MC33 blank knives, for profile and hydro profile cutterheads
AT 103 0 28, AT 103 0 29

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

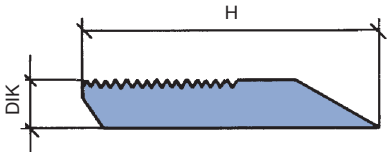
Set of the same weight.

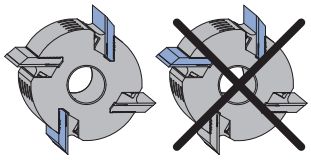
Attention:
Please do not mix new MC33 blank knives with previous MC blank knives in one cutterhead due to weight difference.



Cutting material recommendation	HS	MC 33
Solid wood dry	♦	♦
Solid wood wet	◇	♦
Hardwood dry	◇	♦
Hardwood wet	◇	♦
Glulam		◇
Thermoplastics (PE, PP, PVC, etc.)	♦	♦
WPC (Wood-Plastic-Composite)	◇	♦

♦ suitable ◇ partly suitable





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

Cutting material:
HS / MC33

Blank knives with 60° back serration

HS and MC33 blank knives for cutting to individual cutting width
TC 110 0, TC 110 0 03

SB mm	H mm	DIK mm	PT_{max} mm	ID HS	ID MC33
650	38.1	8	5	**635003** □	**635206** □
650	45	8	10	**635004** □	**635207** □
650	50	8	15	**635000** ●	**635203** □
650	60	8	20	**635001** ●	**635204** □
650	70	8	30	**635002** ●	**635205** □

ID = 1 piece.

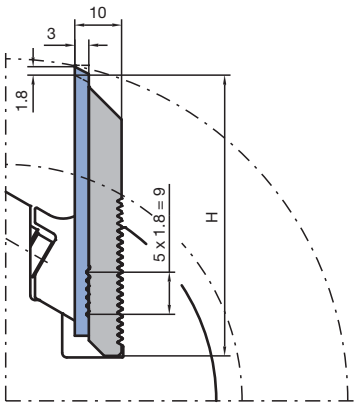
Attention:
Please do not mix new MC33 blank knives with previous MC blank knives in one cutterhead due to weight difference.

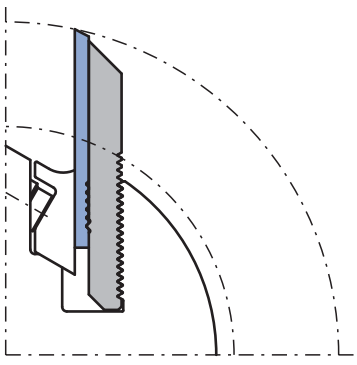
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Cutting material recommendation	HW-30F jointable	HW-10F not jointable
Solid wood dry	♦	
Solid wood wet		
Hardwood dry	♦	♦
Hardwood wet		◇
Glulam	◇	♦
Chipboard		♦
MDF	♦	♦
Thermoplastics (PE, PP, PVC, etc.)	♦	♦
WPC (Wood-Plastic-Composite)	♦	♦

♦ suitable ◇ partly suitable





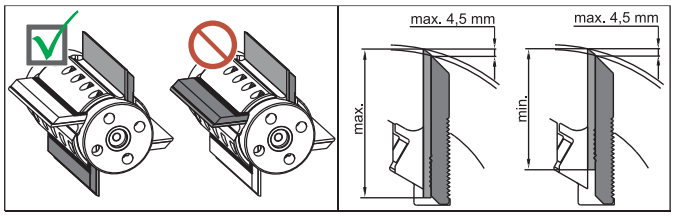
Blank knives / backing plates Powerknife System PKS®

For profile and hydro profile cutterheads, PT 15 mm
AT 103 0 26, AT 107 0 26

SB mm	H mm	DIK mm	PT_{max} mm	SET PCS	QAL	ID Blank knife set	ID Blank knife set with backing plate
40	50	10	15	2	HW-30F	**696642** ●	**697842** ●
60	50	10	15	2	HW-30F	**696643** ●	**697843** ●
80	50	10	15	2	HW-30F	**696644** ●	**697844** ●
100	50	10	15	2	HW-30F	**696645** ●	**697845** ●
130	50	10	15	2	HW-30F	**696646** ●	**697846** ●
150	50	10	15	2	HW-30F	**696647** ●	**697847** ●
170	50	10	15	2	HW-30F	**696648** □	**697848** □
180	50	10	15	2	HW-30F	**696649** □	**697849** □
190	50	10	15	2	HW-30F	**696650** □	**697850** □
210	50	10	15	2	HW-30F	**696651** □	**697851** □
230	50	10	15	2	HW-30F	**696652** □	**697852** □
240	50	10	15	2	HW-30F	**696653** ●	**697853** ●
270	50	10	15	2	HW-30F	**696654** □	**697854** □
310	50	10	15	2	HW-30F	**696655** ●	**697855** ●
40	50	10	15	2	HW-10F	**696628** ●	**697828** ●
60	50	10	15	2	HW-10F	**696629** ●	**697829** ●
80	50	10	15	2	HW-10F	**696630** ●	**697830** ●
100	50	10	15	2	HW-10F	**696631** ●	**697831** ●
130	50	10	15	2	HW-10F	**696632** ●	**697832** ●
150	50	10	15	2	HW-10F	**696633** ●	**697833** ●
170	50	10	15	2	HW-10F	**696634** □	**697834** □
180	50	10	15	2	HW-10F	**696635** □	**697835** □
190	50	10	15	2	HW-10F	**696636** □	**697836** □
210	50	10	15	2	HW-10F	**696637** □	**697837** □
230	50	10	15	2	HW-10F	**696638** □	**697838** □
240	50	10	15	2	HW-10F	**696639** ●	**697839** ●
270	50	10	15	2	HW-10F	**696640** □	**697840** □
310	50	10	15	2	HW-10F	**696641** ●	**697841** ●

The indicated profile depth values should be regarded as standard values for information. The maximum profile depth depends on the tool diameter and cutting angle.

Set of the same weight.
- Blank knives with polished cutting face for high cutting edge quality.
- Solid tungsten carbide - profile knives, adjustable (1.80 mm steps).
- Knives supported by profiled backing plates.
- Resharpening area 10.8 mm at maximum profile depth.



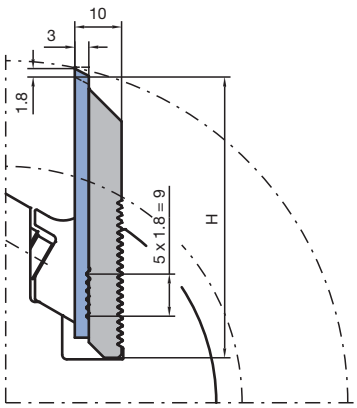
Cutting material:
HW-30F / HW-10F

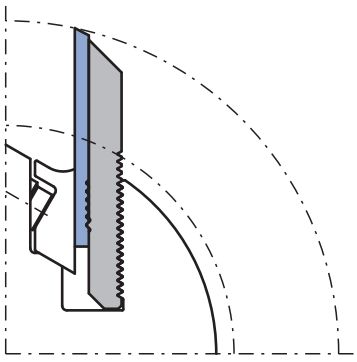
Attention:
Maximum knife protrusion above the backing plate 4.5 mm. For safety reasons, only mount knives and backing plates of same weight in opposite seatings.



Cutting material recommendation	HW-30F jointable	HW-10F not jointable
Solid wood dry	♦	
Solid wood wet		
Hardwood dry	♦	♦
Hardwood wet		◇
Glulam	◇	♦
Chipboard		♦
MDF	♦	♦
Thermoplastics (PE, PP, PVC, etc.)	♦	♦
WPC (Wood-Plastic-Composite)	♦	♦

♦ suitable ◇ partly suitable





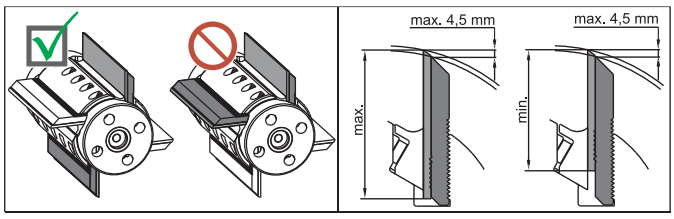
Blank knives / backing plates Powerknife System PKS®

For profile and hydro profile cutterheads, PT 20 mm
AT 103 0 26, AT 107 0 26

SB mm	H mm	DIK mm	PT_{max} mm	SET PCS	QAL	ID Blank knife set	ID Blank knife set with backing plate
40	60	10	20	2	HW-30F	**696670** ●	**697870** ●
60	60	10	20	2	HW-30F	**696671** ●	**697871** ●
80	60	10	20	2	HW-30F	**696672** ●	**697872** ●
100	60	10	20	2	HW-30F	**696673** ●	**697873** ●
130	60	10	20	2	HW-30F	**696674** ●	**697874** ●
150	60	10	20	2	HW-30F	**696675** ●	**697875** ●
170	60	10	20	2	HW-30F	**696676** □	**697876** □
180	60	10	20	2	HW-30F	**696677** □	**697877** □
190	60	10	20	2	HW-30F	**696678** □	**697878** □
210	60	10	20	2	HW-30F	**696679** □	**697879** □
230	60	10	20	2	HW-30F	**696680** □	**697880** □
240	60	10	20	2	HW-30F	**696681** ●	**697881** ●
40	60	10	20	2	HW-10F	**696656** ●	**697856** ●
60	60	10	20	2	HW-10F	**696657** ●	**697857** ●
80	60	10	20	2	HW-10F	**696658** ●	**697858** ●
100	60	10	20	2	HW-10F	**696659** ●	**697859** ●
130	60	10	20	2	HW-10F	**696660** ●	**697860** ●
150	60	10	20	2	HW-10F	**696661** ●	**697861** ●
170	60	10	20	2	HW-10F	**696662** □	**697862** □
180	60	10	20	2	HW-10F	**696663** □	**697863** □
190	60	10	20	2	HW-10F	**696664** □	**697864** □
210	60	10	20	2	HW-10F	**696665** □	**697865** □
230	60	10	20	2	HW-10F	**696666** □	**697866** □
240	60	10	20	2	HW-10F	**696667** ●	**697867** ●

The indicated profile depth values should be regarded as standard values for information. The maximum profile depth depends on the tool diameter and cutting angle.

Set of the same weight.
- Blank knives with polished cutting face for high cutting edge quality.
- Solid tungsten carbide - profile knives, adjustable (1.80 mm steps).
- Knives supported by profiled backing plates.
- Resharpening area 10.8 mm at maximum profile depth.



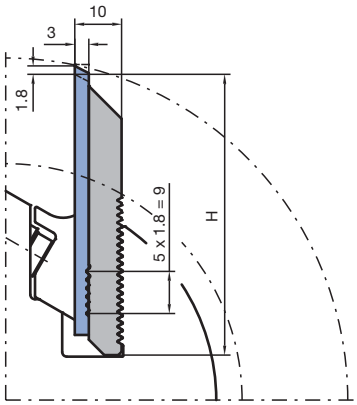
Cutting material:
HW-30F / HW-10F

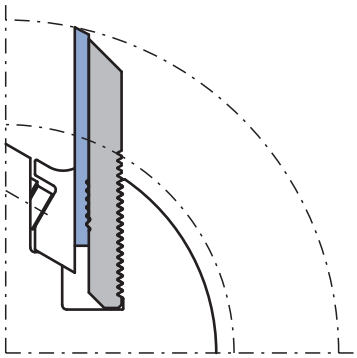
Attention:
Maximum knife protrusion above the backing plate 4.5 mm. For safety reasons, only mount knives and backing plates of same weight in opposite seatings.

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

Cutting material recommendation	HW-30F jointable	HW-10F not jointable
Solid wood dry	♦	
Solid wood wet		
Hardwood dry	♦	♦
Hardwood wet		◇
Glulam	◇	♦
Chipboard		♦
MDF	♦	♦
Thermoplastics (PE, PP, PVC, etc.)	♦	♦
WPC (Wood-Plastic-Composite)	♦	♦

♦ suitable ◇ partly suitable





Cutting material:
HW-30F / HW-10F

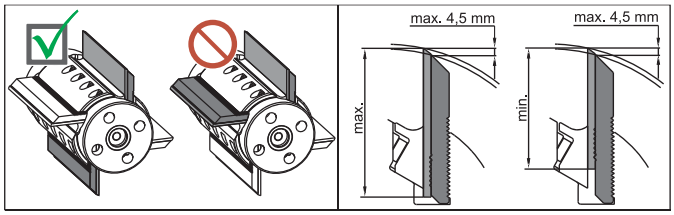
Attention:
Maximum knife protrusion above the backing plate 4.5 mm. For safety reasons, only mount knives and backing plates of same weight in opposite seatings.

For profile and hydro profile cutterheads, PT 30 mm
AT 103 0 26, AT 107 0 26

SB mm	H mm	DIK mm	PT_{max} mm	SET PCS	QAL	ID Blank knife set	ID Blank knife set with backing plate
40	70	10	30	2	HW-30F	**696691** ●	**697891** ●
60	70	10	30	2	HW-30F	**696692** ●	**697892** ●
80	70	10	30	2	HW-30F	**696693** ●	**697893** ●
100	70	10	30	2	HW-30F	**696694** ●	**697894** ●
130	70	10	30	2	HW-30F	**696695** ●	**697895** ●
150	70	10	30	2	HW-30F	**696696** ●	**697896** ●
40	70	10	30	2	HW-10F	**696684** ●	**697884** ●
60	70	10	30	2	HW-10F	**696685** ●	**697885** ●
80	70	10	30	2	HW-10F	**696686** ●	**697886** ●
100	70	10	30	2	HW-10F	**696687** ●	**697887** ●
130	70	10	30	2	HW-10F	**696688** ●	**697888** ●
150	70	10	30	2	HW-10F	**696689** ●	**697889** ●

The indicated profile depth values should be regarded as standard values for information. The maximum profile depth depends on the tool diameter and cutting angle.

Set of the same weight.
- Blank knives with polished cutting face for high cutting edge quality.
- Solid tungsten carbide - profile knives, adjustable (1.80 mm steps).
- Knives supported by profiled backing plates.
- Resharpening area 10.8 mm at maximum profile depth.





Workpiece material:
Softwood

Cutting material:
SP
For multi-purpose profile cutterheads:
WM 502 2
WM 510 1 01
WM 510 1 02
Profiles to scale 1:1 can be found on the Leitz Homepage www.leitz.org

Profile knives for multi-purpose cutterheads

Knives
TM 135 1

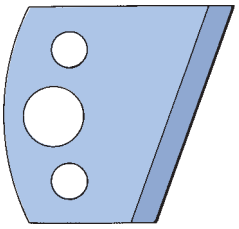
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8	**026108** ●
9	**026109** ●
10	**026110** ●
11	**026111** ●
12	**026112** ●
13	**026113** ●
14	**026114** ●
15	**026115** ●
16	**026116** ●
17	**026117** ●
18	**026118** ●
19	**026119** ●
20	**026120** ●
21	**026121** ●
22	**026122** ●
31	**026131** ●
34	**026134** ●
35	**026135** ●
36	**026136** ●
39	**026177** ●
41	**026179** ●
45	**026183** ●
47	**026185** ●
48	**026186** ●
50	**026188** ●
55	**026193** ●
57	**026195** ●
58	**026196** ●
66	**026254** ●
68	**026256** ●
75	**026263** ●
76	**026264** ●
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97	**690005** ●
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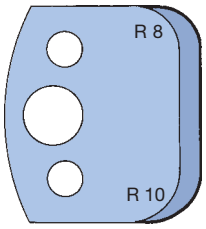
Limitors
TA 300 1

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8	**026308** ●
9	**026309** ●
10	**026310** ●
11	**026311** ●
12	**026312** ●
13	**026313** ●
14	**026314** ●
15	**026315** ●
16	**026316** ●
17	**026317** ●
18	**026318** ●
19	**026319** ●
20	**026320** ●
21	**026321** ●
22	**026322** ●
31	**026331** ●
34	**026334** ●
35	**026335** ●
36	**026336** ●
39	**026384** ●
41	**026386** ●
45	**026390** ●
47	**026392** ●
48	**026393** ●
50	**026395** ●
55	**026400** ●
57	**026402** ●
58	**026403** ●
66	**026411** ●
68	**026413** ●
75	**026420** ●
76	**026421** ●
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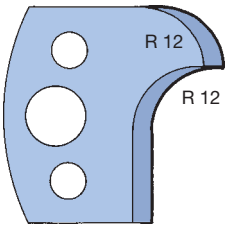
Sold in pairs only.

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

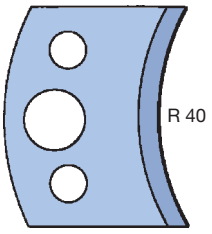

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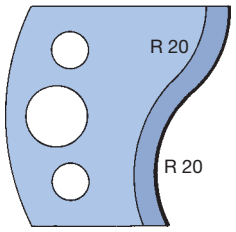
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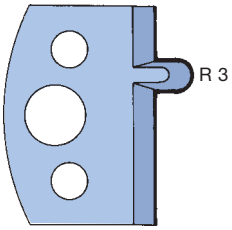
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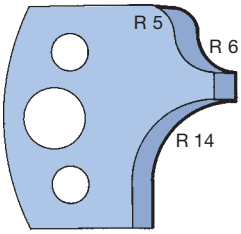
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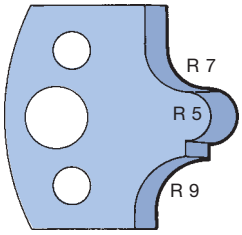
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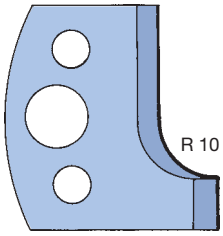
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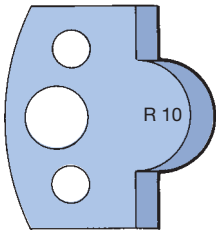
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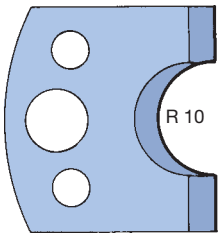
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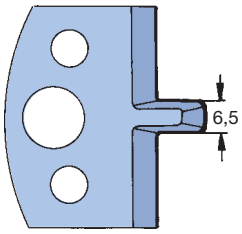
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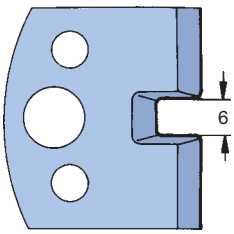
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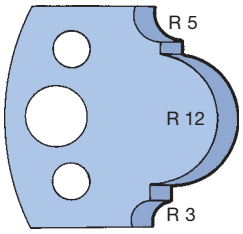
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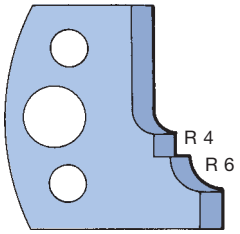
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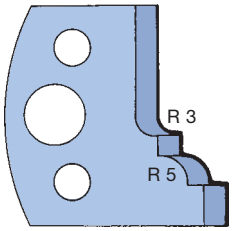
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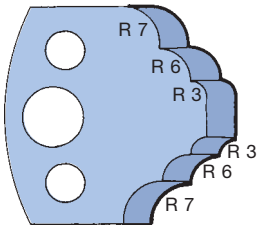
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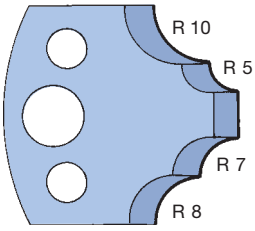
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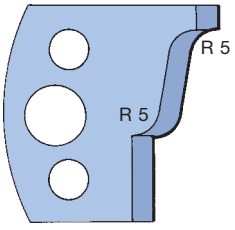
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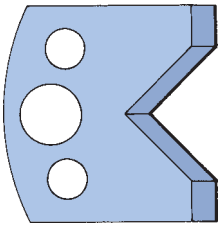
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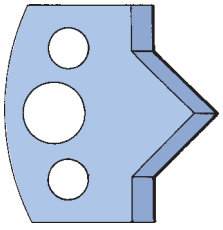


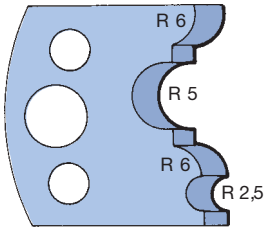
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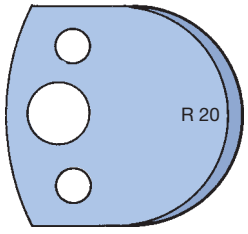
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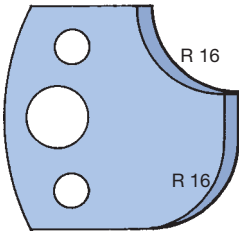

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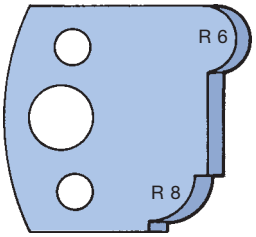
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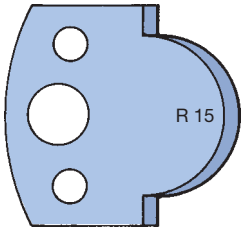
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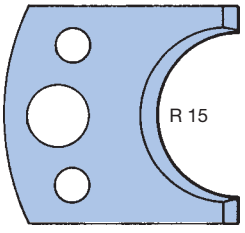
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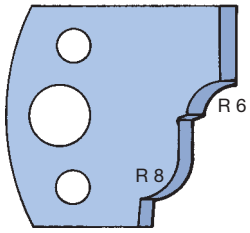
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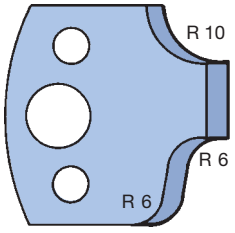
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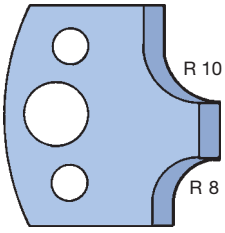
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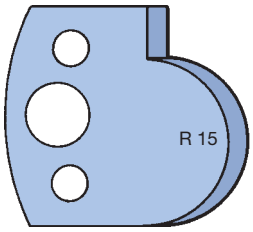
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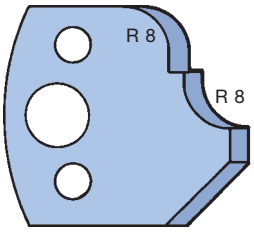
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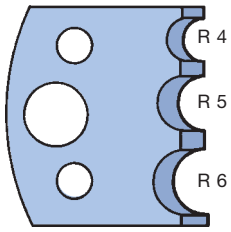
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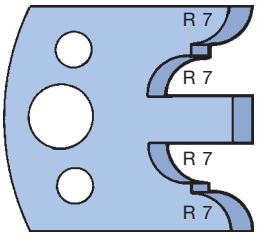
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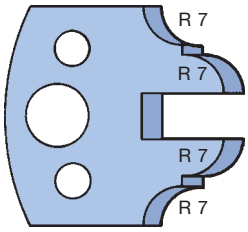
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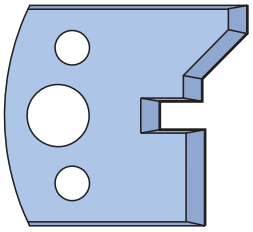
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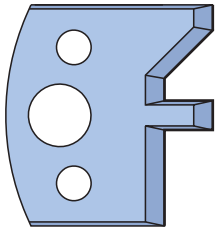


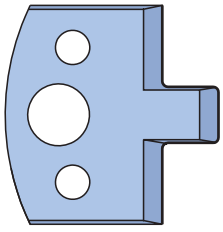
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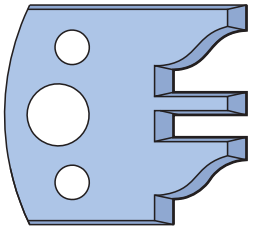


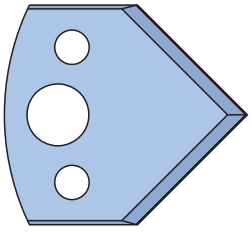
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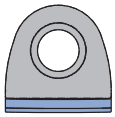

LEN 83


LEN 84


LEN 91


LEN 97


LEN 127



WhisperCut DP-edges for hybrid tools

WhisperCut DP-edges; suitable for the combination with the tool systems ProfilCut, ProFix, turnblade or HeliPlan
TM 160 0 02, TM 160 0 13

BEM	SB mm	R mm	FAW °	QAL	ID
Jointing	14			DP	**091052** ●
Jointing of glued joint*	14			DP	**091056** ●
Radius on bottom	14	1.0		DP	**091057**
Radius on top	14	1.0		DP	**091058**
Radius on bottom	14	1.5		DP	**091059**
Radius on top	14	1.5		DP	**091060**
Radius on bottom	14	2.0		DP	**091061**
Radius on top	14	2.0		DP	**091062**
Bevel on bottom	14		45	DP	**091063**
Bevel on top	14		45	DP	**091064**

* = If the knife mounted has a 0° cutting area bevel, it can be used **preferably for glued joints** due to the crown.

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Turnblade knife

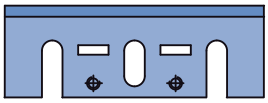
Workpiece material:
Softwood and hardwood, chipboard and fibre materials, glulam

Cutting material:
HW

Planer knives for portable planers

Turnblade knives HW
TM 410 0

Machine	SB mm	H mm	DIK mm	QAL	ID
AEG, Bosch, Festool, Haffner, Holz-Her, Mafell, Metabo, Scheer	75.5	5.5	1.1	HW	**005064** ●
Black & Decker	75.7	5.5	1.2	HW	**005199** ●
Elu	80.5	5.9	1.2	HW	**005131** ●
AEG, Black & Decker, DeWalt, Elu, Mafell, Makita, Metabo	82	5.5	1.1	HW	**005066** ●



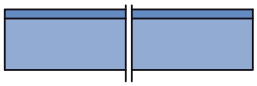
Makita

Cutting material:
HS / HW

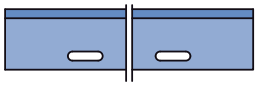
Planer knife HS / HW
TM 105 0

Machine	SB mm	H mm	DIK mm	ID HS	ID HW
Makita	82	29	3	**027530** ●	**027598** ●

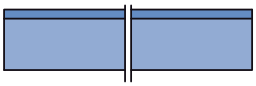
Planer knives for semi-stationary machines



Kity



Metabo



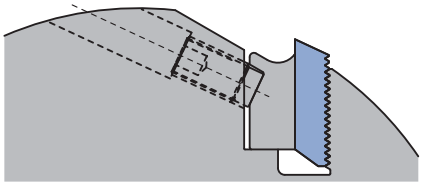
Scheppach

Workpiece material:
Softwood and hardwood, chipboard and fibre materials, glulam

Cutting material:
HS

HS
TM 100 0, TM 105 0

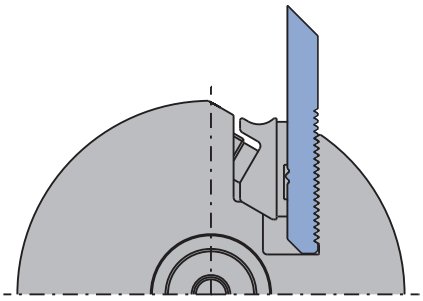
Machine	SB mm	H mm	DIK mm	QAL	ID
Kity	260	20	2.5	HS	**027154** ●
Metabo	263	20	3	HS	**027157** ●
Scheppach	260	18	3	HS	**027158** ●



Back-serrated profile cutterheads

Filler pieces for knife thickness 8 - 10 mm
TD 510 0 05

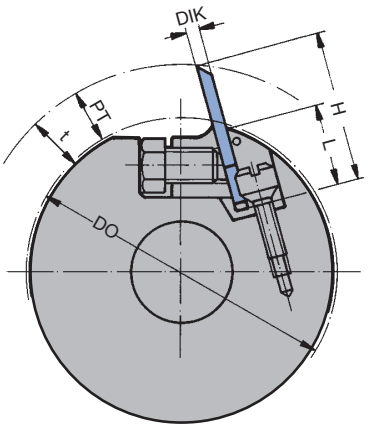
BEZ	for SB mm	ID
Filler piece	40	**005305** ●
Filler piece	60	**005306** ●
Filler piece	80	**005307** ●
Filler piece	100	**005308** ●
Filler piece	120	**005309** ●
Filler piece	130	**005310** ●
Filler piece	150	**005311** ●
Filler piece	170	**620770** ●
Filler piece	180	**005312** ●
Filler piece	190	**620772** ●
Filler piece	210	**620773** ●
Filler piece	230	**005313** ●
Filler piece	240	**620771** ●
Filler piece	270	**620774** ●
Filler piece	310	**620775** ●



Filler pieces for profiling of PKS-system backing plates
TF 200 0

BEZ	for SB mm	ID
Filler piece	40	**008355** □
Filler piece	80	**008356** □
Filler piece	130	**008357** □
Filler piece	170	**008358** □
Filler piece	210	**008359** □
Filler piece	240	**008221** ●

Profile cutterhead
PKS-system



Profile cutterhead WM 502 2

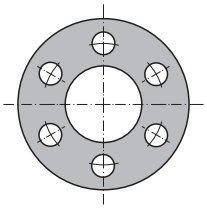
Profile cutterhead WM 502 2
TC 105 0

BEZ	SB mm	QAL	ID
Profile blank knife	40	SP	**007601** ●
Profile blank knife	50	SP	**007602** ●
Profile blank knife	60	SP	**007603** ●
Profile blank knife	40	HS	**007284** ●
Profile blank knife	50	HS	**007285** ●
Profile blank knife	60	HS	**007286** ●

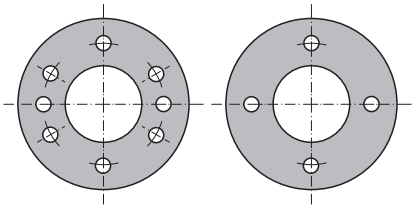
Workpiece material:
Softwood and hardwood

Cutting material:
SP / HS

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Spacers with 6+4 pinholes



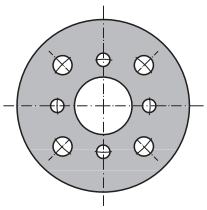
Spacers with 4 pinholes

With pinholes

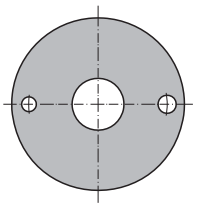
Spacers with 1 pitch
TR 100 0

D mm	B mm	BO mm	NLA mm	ID
45	3	20	4/6/32	**028088** ●
45	5	20	4/6/32	**028089** ●
45	10	20	4/6/32	**028090** ●
45	20	20	4/6/32	**028639** ●
45	0.1	20	4/6/32	**029208** ●
45	0.3	20	4/6/32	**029209** ●
45	0.5	20	4/6/32	**029210** ●
45	1	20	4/6/32	**029211** ●
60	0.1	30	4/7/48 6/7/48	**029237** ●
60	0.1	30	6/7/48	**027914** ●
60	0.3	30	4/7/48 6/7/48	**029238** ●
60	0.3	30	6/7/48	**027915** ●
60	0.5	30	4/7/48 6/7/48	**029239** ●
60	0.5	30	6/7/48	**027916** ●
60	1	30	4/7/48 6/7/48	**029240** ●
60	1	30	6/7/48	**027917** ●
60	3	30	6/7/48	**028580** ●
60	4	30	6/7/48	**028581** ●
60	5	30	6/7/48	**028582** ●
60	6	30	6/7/48	**028583** ●
60	7	30	6/7/48	**028584** ●
60	8	30	6/7/48	**028585** ●
60	10	30	6/7/48	**028586** ●
60	11	30	6/7/48	**028587** ●
60	12	30	6/7/48	**028588** ●
60	15	30	6/7/48	**028589** ●
60	20	30	6/7/48	**028591** ●
70	0.1	30	6/7/58	**027952** ●
70	0.3	30	6/7/58	**027953** ●
70	0.5	30	6/7/58	**027954** ●
70	1	30	6/7/58	**027955** ●
70	3	30	6/7/58	**028599** ●
70	4	30	6/7/58	**028600** ●
70	5	30	6/7/58	**028601** ●
70	10	30	6/7/58	**028605** ●
70	20	30	6/7/58	**028608** ●
60	0.1	35	6/7/48	**027930** ●
60	0.3	35	6/7/48	**027931** ●
60	0.5	35	6/7/48	**027932** ●
60	1	35	6/7/48	**027933** ●
60	3	35	6/7/48	**028592** ●
60	5	35	6/7/48	**028594** ●
60	10	35	6/7/48	**028598** ●
62	0.1	35	4/7/52	**028667** ●
62	0.3	35	4/7/52	**028668** ●
62	0.5	35	4/7/52	**028669** ●
62	1	35	4/7/52	**028670** ●
64	3	35	4/7/52	**028671** ●
64	4	35	4/7/52	**028672** ●
64	5	35	4/7/52	**028673** ●
70	0.1	35	6/7/58	**027966** ●
70	0.3	35	6/7/58	**027967** ●
70	0.5	35	6/7/58	**027968** ●
70	1	35	6/7/58	**027969** ●
70	3	35	6/7/58	**028609** ●
70	5	35	6/7/58	**028611** ●
70	10	35	6/7/58	**028615** ●
70	20	35	6/7/58	**028616** ●
70	0.1	40	6/7/58	**027978** ●
70	0.3	40	6/7/58	**027979** ●
70	0.5	40	6/7/58	**027980** ●
70	1	40	6/7/58	**027981** ●

D mm	B mm	BO mm	NLA mm	ID
70	3	40	6/7/58	**028617** ●
70	4	40	6/7/58	**028618** ●
70	5	40	6/7/58	**028619** ●
70	6	40	6/7/58	**028620** ●
70	7	40	6/7/58	**028621** ●
70	8	40	6/7/58	**028622** ●
70	10	40	6/7/58	**028623** ●
70	12	40	6/7/58	**028624** ●
70	15	40	6/7/58	**028625** ●
70	20	40	6/7/58	**028626** ●
76.5	0.1	50	6/7/65	**028005** ●
76.5	0.3	50	6/7/65	**028006** ●
76.5	0.5	50	6/7/65	**028007** ●
76.5	1	50	6/7/65	**028008** ●
77	3	50	6/7/65	**028627** ●
77	4	50	6/7/65	**028628** ●
77	5	50	6/7/65	**028629** ●
77	6	50	6/7/65	**028630** ●
77	8	50	6/7/65	**028631** ●
77	10	50	6/7/65	**028632** ●
77	20	50	6/7/65	**028633** ●
90	0.1	60	6/9/75	**028020** ●
90	0.3	60	6/9/75	**028021** ●
90	0.5	60	6/9/75	**028022** ●
90	1	60	6/9/75	**028023** ●
90	3	60	6/9/75	**028634** ●
90	4	60	6/9/75	**028635** ●
90	5	60	6/9/75	**028636** ●
90	10	60	6/9/75	**028637** ●
90	20	60	6/9/75	**028638** ●



Spacers with 4+4 pinholes



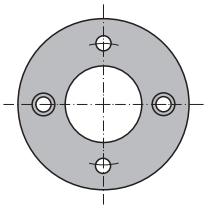
Spacers with 2 pinholes

With pinholes

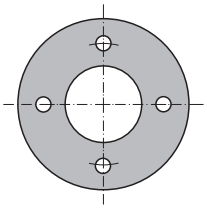
Spacers with different pitches
TR 100 0

D mm	B mm	BO mm	NLA mm	ID
90	0.1	30	4/7/48 4/10/60	**028422** ●
90	0.3	30	4/7/48 4/10/60	**028423** ●
90	0.5	30	4/7/48 4/10/60	**028424** ●
90	1	30	4/7/48 4/10/60	**028425** ●
90	3	30	4/7/48 4/10/60	**028426** ●
90	5	30	4/7/48 4/10/60	**028427** ●
90	10	30	4/7/48 4/10/60	**028428** ●
90	20	30	4/7/48 4/10/60	**028429** ●
100	0.1	30	1/8.5/80 1/10.5/80	**028029** ●
100	0.3	30	1/8.5/80 1/10.5/80	**028030** ●
100	0.5	30	1/8.5/80 1/10.5/80	**028031** ●
100	1	30	1/8.5/80 1/10.5/80	**028032** ●

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Spacers with 4 pinholes (two of them with cylindrical countersink)

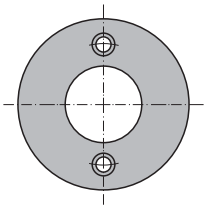


Spacers with 4 pinholes

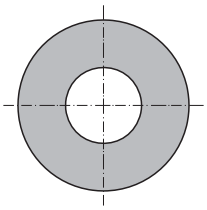
With pinholes, aluminium

Aluminium spacers
TR 100 0

D mm	B mm	BO mm	NLA mm	BEM	ID
60	10	30	2/7/48 2/7/48	2 pinholes with cylindrical countersink	**029244** ●
64	5	35	4/7/52		**029246** ●
64	10	35	4/7/52		**029247** ●
64	10	35	2/7/52	Cylindrical countersink pinholes	**029248** ●
64	20	35	4/7/52		**029249** ●



Spacers with 2 pinholes with cylindrical countersink



Without pinholes

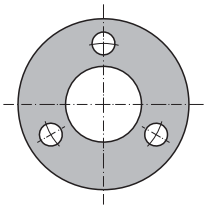
Without pinholes
TR 100 0

D mm	B mm	BO mm	ID
34	0.1	20	**028400** ●
34	0.3	20	**028401** ●
34	0.5	20	**028402** ●
34	1	20	**028403** ●
34	3	20	**028404** ●
34	4	20	**028405** ●
34	5	20	**028406** ●
50	0.1	30	**027901** ●
50	0.3	30	**027902** ●
50	0.5	30	**027903** ●
50	1	30	**027904** ●
50	3	30	**027905** ●
50	4	30	**027906** ●
50	5	30	**027907** ●
50	6	30	**027908** ●
50	7	30	**027909** ●
50	8	30	**027910** ●
50	10	30	**027911** ●
50	14	30	**027912** ●
50	20	30	**027913** ●
60	3	30	**027918** ●
60	4	30	**027919** ●
60	5	30	**027920** ●
60	6	30	**027921** ●
60	7	30	**027922** ●
60	8	30	**027923** ●
60	10	30	**027924** ●
60	11	30	**027925** ●
60	12	30	**027926** ●
60	15	30	**027927** ●
60	17.5	30	**027928** ●
60	20	30	**027929** ●
60	3	35	**027934** ●
60	5	35	**027936** ●
60	6	35	**027937** ●
60	7	35	**027938** ●

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

D mm	B mm	BO mm	ID
60	8	35	**027939** ●
60	10	35	**027940** ●
60	0.1	40	**027941** ●
60	0.3	40	**027942** ●
60	0.5	40	**027943** ●
60	1	40	**027944** ●
60	3	40	**027945** ●
60	4	40	**027946** ●
60	5	40	**027947** ●
60	6	40	**027948** ●
60	7	40	**027949** ●
60	8	40	**027950** ●
60	9	40	**028449** ●
60	10	40	**027951** ●
70	3	30	**027956** ●
70	4	30	**027957** ●
70	5	30	**027958** ●
70	6	30	**027959** ●
70	7	30	**027960** ●
70	8	30	**027961** ●
70	10	30	**027962** ●
70	12	30	**027963** ●
70	15	30	**027964** ●
70	20	30	**027965** ●
70	3	35	**027970** ●
70	4	35	**027971** ●
70	5	35	**027972** ●
70	6	35	**027973** ●
70	7	35	**027974** ●
70	8	35	**027975** ●
70	10	35	**027976** ●
70	20	35	**027977** ●
70	3	40	**027982** ●
70	4	40	**027983** ●
70	5	40	**027984** ●
70	6	40	**027985** ●
70	7	40	**027986** ●
70	8	40	**027987** ●
70	10	40	**027988** ●
70	12	40	**027989** ●
70	15	40	**027990** ●
70	20	40	**027991** ●
70	0.1	50	**027992** ●
70	0.3	50	**027993** ●
70	0.5	50	**027994** ●
70	1	50	**027995** ●
70	3	50	**027996** ●
70	4	50	**027997** ●
70	5	50	**027998** ●
70	6	50	**027999** ●
70	7	50	**028000** ●
70	8	50	**028001** ●
70	10	50	**028002** ●
70	15	50	**028003** ●
70	20	50	**028004** ●
77	3	50	**028009** ●
77	4	50	**028010** ●
77	5	50	**028011** ●
77	6	50	**028012** ●
77	8	50	**028013** ●
77	10	50	**028014** ●
77	20	50	**028015** ●
90	3	60	**028024** ●
90	4	60	**028025** ●
90	5	60	**028026** ●
90	10	60	**028027** ●
90	20	60	**028028** ●
100	4	30	**028033** ●

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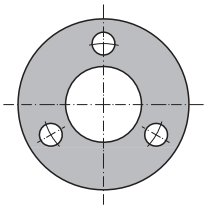


Spacers hardened and high precision for hydro and Hydro-Duo clamping sleeves to fill the clamping length.

Spacers, hardened and high precision for hydro and Hydro-Duo clamping sleeves

Spacers, hardened and high precision for hydro and Hydro-Duo clamping sleeves
TR 100 0

D	B	BO	NLA	ID
mm	mm	mm	mm	
90	10	60	3/9/75	**030684** ●
90	15	60	3/9/75	**030685** ●
90	20	60	3/9/75	**030686** ●

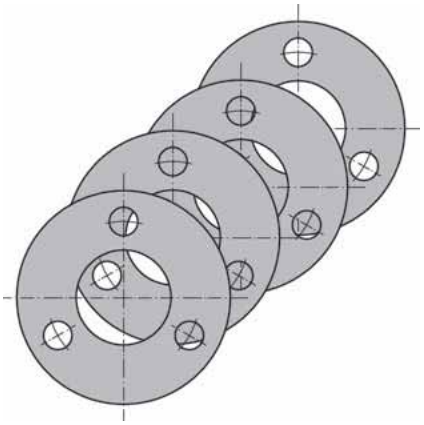


Spacers hardened and high precision for hydro and Hydro-Duo clamping sleeves to fill the clamping length.

High precision spacers for adjusting tongue and groove cuttersets

High precision spacers for adjusting tongue and groove cuttersets
TR 100 0

D	B	BO	NLA	ID
mm	mm	mm	mm	
90	3.1	60	3/9/75	**030687** ●
90	3.3	60	3/9/75	**030688** ●
90	3.5	60	3/9/75	**030689** ●
90	3.7	60	3/9/75	**030690** ●
90	3.9	60	3/9/75	**030691** ●
90	4.1	60	3/9/75	**030692** ●
90	4.3	60	3/9/75	**030693** ●
90	4.5	60	3/9/75	**030694** ●
90	4.7	60	3/9/75	**030695** ●
90	4.9	60	3/9/75	**030696** ●
90	5	60	3/9/75	**030697** ●
90	5.1	60	3/9/75	**030698** ●



AT 100 0 01
8 part spacer set with total clamping length 125 mm, surface ground face parallel, spacers black-finished, to DIN 8837

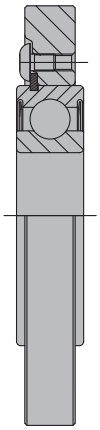
Set consisting of:
2 pieces: B 5.0 mm
2 pieces: B 16.0 mm
1 piece: B 8.0 mm
1 piece: B 10.0 mm
1 piece: B 25.0 mm
1 piece: B 40.0 mm

Spacer sets

Set of standard cutter spindle spacers
AT 100 0 01

D	BO	ID
mm	mm	
50	30	**028381** ●
60	40	**028382** ●





Ball bearings

Ball bearings
TL 510 0

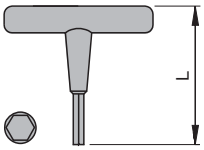
BEZ	Type	D mm	D Ring mm	B mm	BO mm	ID
Ball bearing	A	62	min. 85	16	30	**008114** ●
Ball bearing	A	62	min. 90	16	31.75	**008142**
Ball bearing	B	80	min. 102	18	40	**008116** ●
Ball bearing	C	90	min. 112	20	50	**008117** ●
Ball bearing	D	110	min. 132	22	60	**008118**

Guide rings

Guide rings
TR 500 0

BEZ	Type	D mm	ID
Guide ring	A	85	**027826** ●
Guide ring	A	90	**027799** □
Guide ring	A	100	**027800** ●
Guide ring	A	105	**027801** □
Guide ring	A	110	**027802** ●
Guide ring	A	120	**027803**
Guide ring	A	125	**027804** ●
Guide ring	A	130	**027805** ●
Guide ring	A	140	**027806** ●
Guide ring	A	150	**027807** ●
Guide ring	B	105	**027808**
Guide ring	B	110	**027809**
Guide ring	B	120	**027810**
Guide ring	B	125	**027811**
Guide ring	B	130	**027812**
Guide ring	B	140	**027813**
Guide ring	B	150	**027814**
Guide ring	C	112	**027815**
Guide ring	C	120	**027816**
Guide ring	C	125	**027817**
Guide ring	C	130	**027818**
Guide ring	C	140	**027819**
Guide ring	C	150	**027820**
Guide ring	C	160	**027821**
Guide ring	D	140	**027822**
Guide ring	D	150	**027823**
Guide ring	D	160	**027824**
Guide ring	D	170	**027825**

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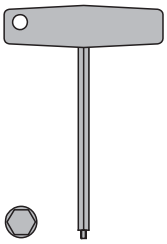
Hexagon key,
L 75 - 100 mm

Hexagon allen keys

T-handle without tenon

TH 500 0

ABM mm	L mm	ID
SW 2.5	100	**005472** ●
SW 3	75	**005444** ●
SW 4	75	**005445** ●
SW 6	100	**005447** ●

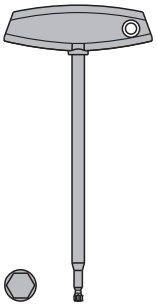


Hexagon key, with
tenon

T-handle with tenon

TH 500 0

ABM mm	ID
SW 5	**005452** ●
SW 6	**005494** ●

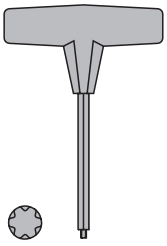


Hexagon key, for
quick-change
sleeve

For quick-change chuck

TH 505 0

ABM mm	L mm	ID
SW 6	240	**117516** ●



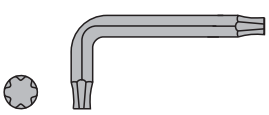
Torx® key with
T-handle

Torx® keys

T-handle

TH 500 0

ABM mm	L mm	ID
Torx® 8		**006093** ●
Torx® 9		**005463** ●
Torx® 15	100	**005466** ●
Torx® 15	130	**117507** ●
Torx® 20	100	**006091** ●
Torx® 20	130	**117503** ●
Torx® 25	100	**005502** ●
Torx® 25	130	**117504** ●



Torx® key, 90° angle

90° angle

TH 500 0

ABM mm	L mm	ID
Torx® 20	140	**117511** ●

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Torque tool set

TorqueVario®-STplus T-handle torque tool set, 11 parts
AT 199 0

BEZ	BEM	ID
TorqueVario-STplus 5-14 Nm	Bitholder 1/4 inch for bits with drive E 6.3 and C 6.3; Bits of series 7045 Torx and 7043 Hexagon in lengths 70 mm; Torx T 15 - T 20 - T 25; Hexagon SW 4 - SW 5 - SW 6 - SW 8	**009103** ●

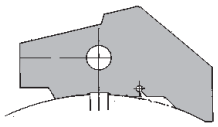
Application:
Controlled tightening with predefined torque for changing knife tool systems

Design:
Model 5-14 Nm. Numeric torque indicator in the window scale. Steplessly controlled torque by control tool Torque Setter (included in delivery).
Comfortable T-handle with soft zones for optimal torque transmission.

Precision:
±6%, based on national standards

Extra:
Delivery in stable metal box, incl. test protocol

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Setting gauge for hydro planerhead / planerhead wedge-type system

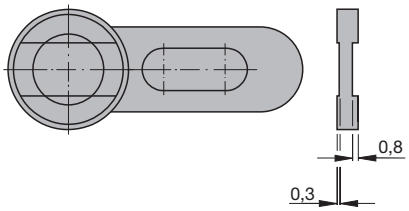
VN 265 0

ABM mm	ID
D143	**007988** ●
D163	**007989** ●
D203	**008002** ●



Setting gauge 0.3/0.8 mm

Setting gauge 1 mm



Magnetic setting gauge 0.3/0.8 mm

Setting gauge for turnblade

VN 230 0

BEZ	ABM mm	ID
Setting gauge for knives	0.3/0.8	**005374** ●
Setting gauge for knives	1.0	**005350** ●
Magnetic setting gauge	0.3/0.8	**005376** ●



Mounting device

VN 799 0

BEZ	BEM	ID
Mounting device for SK 30/BT30 with grooves and notches	Not for Biesse	**079000** ●
Mounting device for SK40		**079001** ●
Mounting device for HSK-F50		**079002** ●
Mounting device for HSK-E63 and HSK-F63		**079003** ●
Mounting device for SCM/Morbidelli ISO30		**079004** ●
Mounting device for CMS ISO30		**079005** ●
Mounting device for Alberti HSK-E 40		**079006** ●

Application:
For the assembly of shank tools in clamping chucks or tools with borehole on arbors with adaptors for automatic tool change

- Reduced risk of injury when mounting tools
- Quick clamping levers and fixing pins secure the clamped taper axially as well as against twisting



Application:
For mounting saws, tools, tool sets and cutterheads

Mounting device

Mounting device for tools with HSK 85 / HSK-F 63 adaptor
VN 799 0

BEZ	Machine	l mm	d mm	ID
Mounting device EASY-Hold HSK 85 WS	Weinig	30 - 310	20 - 50	**079010** ●
Mounting device EASY-Hold HSK-F 63				**079009** ●

For quick and easy mounting of knives or tools on arbors.



Application:
For clamping drills (10 mm shank with clamping flat) when altering the length adjusting screw.

Advantages:
- reduced risk of injury when mounting the tools
- easy and stable tool clamping during mounting

Mounting device

Clamping device for drills with 10 mm shank and clamping flat
VN 799 0

BEZ	ID
Clamping device for drill 10 mm shank	**079020** ●

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Application:
For easy lifting of large circular saw blades by means of magnetic power

Lifting device for large circular saw blades

MagneticGrip Lifting device
VZ 999 0

BEZ	BEM	ID
Lifting device	20 kg load capacity	**119900** ●
Lifting device	45 kg load capacity	**119901** ●

For optimal lifting, 2 pcs. are recommended.

Jointing stones for Leitz Marathon planer knife

FS 100 0, FS 199 0

BEZ	Machine	BEM	ABM mm	ID
Jointing stone (angular)	WACO	Colour: brown	20x15x60	**008238** ●
Jointing stone (round)	Weinig, Leadermac	Colour: grey	12x32	**008237** ●

Grinding wheels suitable for sharpening Marathon planer knives available on request.

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

Key to pictograms


Sawing, multiple cut


Sawing solid transparent plastic


Copy shaping


Slotting


Profiling

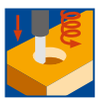

Mechanical knife clamping, adjustable - serrated


Resharpenable cutting face


Sawing, thin kerf


Sawing hollow metal


Rebating


Spiral boring


Profiling joints


Mechanical knife clamping adjustable - plane


Resharpenable clearance face


Sawing, horizontal


Sawing crosscut metal


Bevelling


Non-axial boring


Mortising



Mechanical knife clamping, re-sharpenable and constant diameter



Low noise


Sawing along grain


Scoring, top and bottom


Panel raising


Plug cutting



Mechanical feed


Spindle without twist protection



Optimised chip flow


Sawing across grain


Scoring, hogging


Profiling


Carving



Manual feed


Spindle with anti-twist keyway



Alloyed tool steel


Sawing, universal


Hogging


Profiling joints


Grooving, sizing


Solid metal tool

Spindle with anti-twist hexagon

High-alloyed tool steel

Scoring, sawing

Double hogging

Profiling tongue and groove

Finish sizing

Tipped tool

Hydro clamping system - open

High-speed steel

Scoring and sawing stacks

Hogging, folding

Planing

Grooving, horizontal and vertical

Special body alloy

Hydro clamping system - closed

Stellite

Sawing hollow sections

End trimming

Planing, profiling

Jointing

Light alloy body

Hydro-Duo (bi-directional) clamping

Tungsten carbide

Sawing, honeycomb panels

Edge trimming

Drilling blind holes

Copy shaping

Inter-changeable knives

Hydro clamping arbors

Poly-crystalline diamond (PCD)

Sawing plastic single

Grooving, horizontal and vertical

Drilling, through holes

Rebating

Mechanical knife clamping, reversible

Hydro clamping

Mono-crystalline diamond (MKD)

Sawing plastic stacks

Grooving honeycomb panels

Step drilling

Bevelling

Centrifugal knife clamping, reversible

Shrink-fit clamping

Carbide metal coating

Sawing hollow transparent plastic

Jointing

Counter-sinking

Panel raising

Mechanical knife clamping, non-adjustable

Quick clamping system

Diamond coating

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