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POWERLOCK, PLANING, FINGER JOINTING



PowerLock

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Planing cutterheads

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Finger jointing cutters

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Hydro-programme

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Tool system PowerLock for planing- and moulding machines

Conventional, Hydro or PowerLock, OERTLI offers for each desirable performance the optimum tool

Tools with conventional clamping are put onto the spindle and mechanically clamped with a spindle nut. The play between tool bore and spindle causes a concentric running inaccuracy of a few $\frac{1}{100}$ mm in such a way that all tool cutting knives are in operation, but only the one with the furthest projection determines the wave-undulation on the wood surface. The feed rates are limited by the one knife undulation. As an alternative to the conventional tool, tools with Hydro-locking may be used, which can be clamped on the spindle without play. Tools with Hydro-locking can be profiled or re-ground on a precision grinding machine with a concentric running accuracy of less than $\frac{1}{1000}$ mm, thereby achieving a multiple knife undulation allowing any desirable feed rate.

An alternative to tools with or without Hydro-locking is the OERTLI PowerLock tool system

PowerLock tools are not clamped conventionally on a machine spindle, but are directly set onto the drive unit as single-part tool with the HSK-shank. With this play-free, centric clamping a very precise concentric running accuracy is achieved resulting in an outstanding surface quality. In order to achieve a multi knife undulation, it is necessary that the tools are jointed. The minimum rest tolerances are thereby eliminated and all cutting knives are brought into a uniform cutting circle.

Higher performance by higher speeds (RPM)

For planing and profiling with PowerLock, machining speeds are between 8000 to 12000 RPM. The OERTLI PowerLock system allows speeds up to 12000 RPM. High RPM allow using tools with small diameters and still operating at optimized cutting speeds. These facts are important for a perfect undulation and an excellent surface quality. With PowerLock, according to the RPM, the feed rate can be doubled compared to a conventional tool.

Optimized tool solution for each application

The OERTLI PowerLock programme comprises of various Monobloc planing cutterheads, Profile cutterheads with serrated back knives and HW cutters for custom-made profiles as well as for many further special- and standard tools with reversible- or profile knives. Besides, OERTLI supplies adaptor spindles for existing- or new tools with bore.

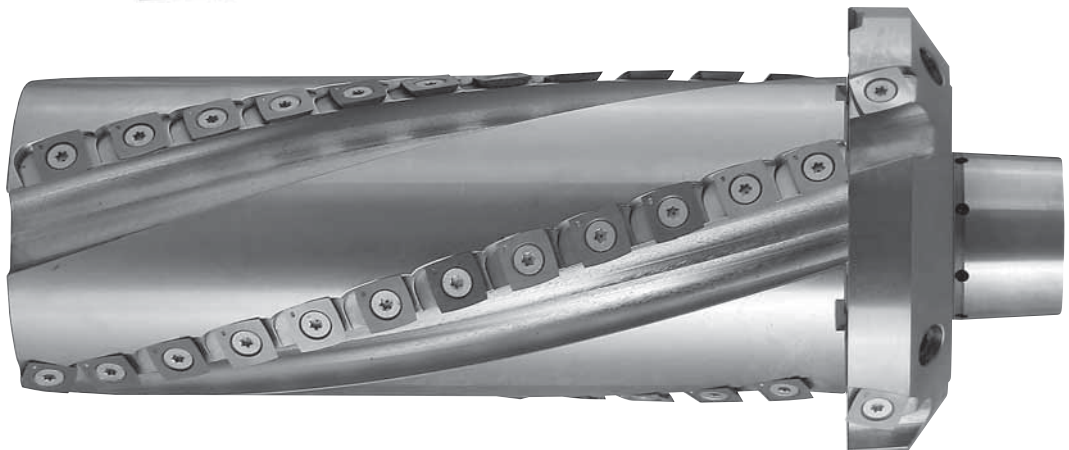
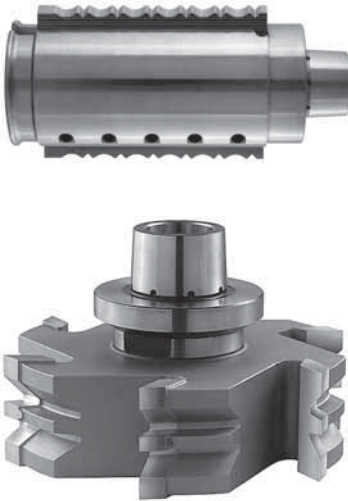




Fig. 1

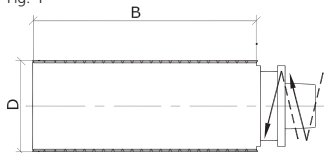


Fig. 2



Fig. 3

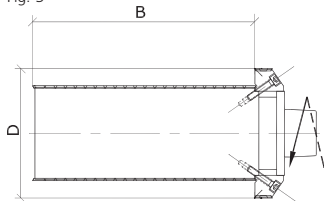


Fig. 4

Spiral cutterheads with reversible knives CASTOR-FINISH Monobloc

Application: For planing of solid wood • Four-sided moulding machines

Design: Tungsten carbide reversible knives • 4 cutting edges and spirally arranged with divided cut and shear cut angle for easy chipping • For finish cut without marking of knives • Tool body in steel • MEC (mechanical feed)

Spiral cutterheads CASTOR-FINISH Monobloc

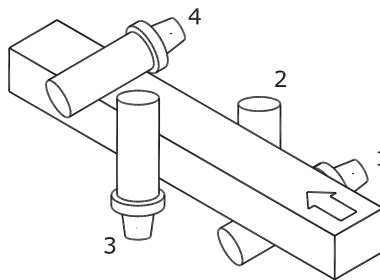
Art. Nr.	D	B	S	Z	Pos.	n max.	Fig.	Index
470800	96	237	HSK-P	4 (2+2)	1	12'000	1, 2	1
470801	96	307	HSK-P	4 (2+2)	1	8'000	1, 2	2
470802	96	237	HSK-P	4 (2+2)	4	12'000	1, 2	3
470803	96	307	HSK-P	4 (2+2)	4	8'000	1, 2	4
470804	96	237	HSK-P	6 (3+3)	1	12'000	1, 2	5
470805	96	307	HSK-P	6 (3+3)	1	8'000	1, 2	6
470806	96	237	HSK-P	6 (3+3)	4	12'000	1, 2	7
470807	96	307	HSK-P	6 (3+3)	4	8'000	1, 2	8

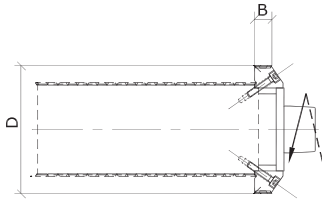
Spiral cutterheads CASTOR-FINISH Monobloc with jointing cutter

Art. Nr.	D	B	S	Z	Pos.	n max.	Fig.	Index
470809	131/96	235	HSK-P	4 (2+2)	1	12'000	3, 4	9
470810	131/96	305	HSK-P	4 (2+2)	1	8'000	3, 4	10
470811	131/96	235	HSK-P	6 (3+3)	1	12'000	3, 4	11
470812	131/96	305	HSK-P	6 (3+3)	1	8'000	3, 4	12

Spare parts

Art.Nr.		Index
216009	Reversible knives OERTLI, Format, B=14.0 h=14.0 a=2.0 Qual=HW	9-12
216571	Reversible knives OERTLI, Format, B=15 h=15 a=2.5 R=50 Typ=ECOLINE Qual=HW	1-12
216672	Reversible knives OERTLI, Format, B=15 h=15 a=2.5 R=50 Typ=H8 Qual=HW	1-12
216672H6	Reversible knives OERTLI, Format, B=15 h=15 a=2.5 R=50 Typ=H6 Qual=HW	1-12
851039	Screws, M=5 D=8.4 L=12 Typ=Torx 20	9-12
851040	Screws, M=5 D=8.5 L=15.5 Typ=Torx 20	1-12





Jointing cutters with reversible knives for spiral cutterheads CASTOR-FINISH Monobloc

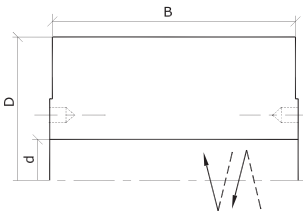
Application: Four-sided moulding machines

Design: Tungsten carbide reversible knives • 4 cutting edges and spirally arranged with divided cut and shear cut angle for easy chipping • Spur- and raker knives separately arranged • Tool body in steel • MEC (mechanical feed)

Art. Nr.	D	B	d	Z	n max.
470808	131	18	85	6 (2+2+2)	12'000

Spare parts

Art.Nr.	
216009	Reversible knives OERTLI, Format, B=14.0 h=14.0 a=2.0 Qual=HW
216571	Reversible knives OERTLI, Format, B=15 h=15 a=2.5 R=50 Typ=ECOLine Qual=HW
216672	Reversible knives OERTLI, Format, B=15 h=15 a=2.5 R=50 Typ=H8 Qual=HW
216672H6	Reversible knives OERTLI, Format, B=15 h=15 a=2.5 R=50 Typ=H6 Qual=HW
851039	Screws, M=5 D=8.4 L=12 Typ=Torx 20
851040	Screws, M=5 D=8.5 L=15.5 Typ=Torx 20



Spiral cutterheads with reversible knives CASTOR-FINISH

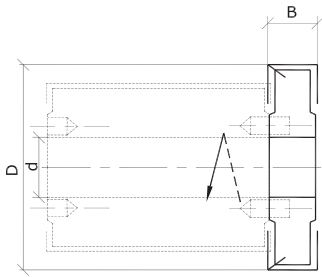
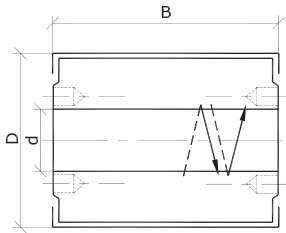
Application: For planing of solid wood • Four-sided moulding machines

Design: Tungsten carbide reversible knives • 4 cutting edges and spirally arranged with divided cut and shear cut angle for easy chipping • For finish cut without marking of knives • Tool body in aluminium • MEC (mechanical feed)

Art. Nr.	D	B	d	Z	n max.	Index
459184	125	100	40	4 (2+2)	12'000	1
459182	125	180	40	4 (2+2)	12'000	2
459183	125	210	40	4 (2+2)	12'000	3
459186	125	230	40	4 (2+2)	12'000	4

Spare parts

Art.Nr.		Index
216571	Reversible knives OERTLI, Format, B=15 h=15 a=2.5 R=50 Typ=ECOLine Qual=HW	1-4
216672	Reversible knives OERTLI, Format, B=15 h=15 a=2.5 R=50 Typ=H8 Qual=HW	1-4
216672H6	Reversible knives OERTLI, Format, B=15 h=15 a=2.5 R=50 Typ=H6 Qual=HW	1-4
851040	Screws, M=5 D=8.5 L=15.5 Typ=Torx 20	1-4



Planing cutterheads SINUS

Application: For planing of solid wood • Four-sided moulding machines

Design: HS-TRI • Tungsten carbide (HW) • Tungsten carbide polished • 2 cutting edges, straight cut • Quick knife change thanks to clamping by centrifugal forces without clamping screws and without time-consuming knife setting • Tempered precision chip limiter to incontestable positioning of reversible knives • Holding of reversible knives before clamping by spring balls • Economical use of knives thanks to regrinding possibilities • Basic equipment with built-in HS-TRI reversible knives • Tool body in aluminium • MEC (mechanical feed)

Art. Nr.	D	B	d	Z	n max.
469228	125	100	40	2	8'500
469229	125	100	40	4	8'500
469230	125	150	40	4	8'500
469227	125	180	40	2	8'500
469225	125	210	40	2	8'500
469226	125	230	40	2	8'500
469231	125	240	40	2	8'500

Jointing cutters with reversible knives

Application: Four-sided moulding machines

Design: Tungsten carbide reversible knives • Spur- and raker knives separately arranged • With one-sided shear cut angle • Tool body in steel • MEC (mechanical feed)

Art. Nr.	D	B	d	Z	n max.
32220	160	15	40	4 (2+2)	10'000

Spare parts

Art.Nr.

216013 Reversible knives OERTLI, Format, B=16.0 h=16.0 a=3.0 Qual=HW

217015 Reversible knives OERTLI, straight, B=15 h=8 a=1.5 Qual=HW

950905 Gib, L=12.1 Typ=+15°

851032 Screws, M=5 D=8.5 L=11 Typ=Torx 20

851059 Screws, M=5 D=6.8 L=23 Typ=Torx 20



Fig. 1

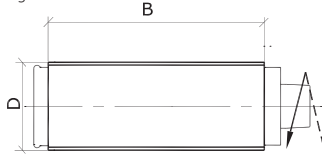


Fig. 2



Fig. 3

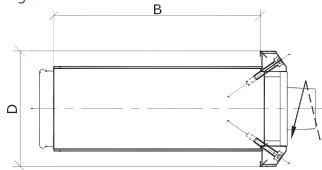


Fig. 4

Planing cutterheads Monobloc for planing knives with back serration

Application: For planing of solid wood • Four-sided moulding machines

Design: High-speed steel (HS) • Tungsten carbide (HW) • Tool body in steel • MEC (mechanical feed)

Planing cutterheads Monobloc with HS planing knives

Art. Nr.	D	B	S	Z	Pos.	n max.	Fig.	Index
460250	96	80	HSK-P	2	3/1	12'000	1, 2	1
460251	96	130	HSK-P	2	3/1	12'000	1, 2	2
460252	96	180	HSK-P	2	1	12'000	1, 2	3
460253	96	210	HSK-P	2	1	12'000	1, 2	4
460254	96	240	HSK-P	2	1	12'000	1, 2	5
460255	96	80	HSK-P	2	2/4	12'000	1, 2	6
460256	96	130	HSK-P	2	2/4	12'000	1, 2	7
460257	96	180	HSK-P	2	4	12'000	1, 2	8
460258	96	210	HSK-P	2	4	12'000	1, 2	9
460259	96	240	HSK-P	2	4	12'000	1, 2	10
460260	96	80	HSK-P	4	3/1	12'000	1, 2	11
460261	96	130	HSK-P	4	3/1	12'000	1, 2	12
460262	96	180	HSK-P	4	1	12'000	1, 2	13
460263	96	210	HSK-P	4	1	12'000	1, 2	14
460264	96	240	HSK-P	4	1	12'000	1, 2	15
460265	96	80	HSK-P	4	2/4	12'000	1, 2	16
460266	96	130	HSK-P	4	2/4	12'000	1, 2	17
460267	96	180	HSK-P	4	4	12'000	1, 2	18
460268	96	210	HSK-P	4	4	12'000	1, 2	19
460269	96	240	HSK-P	4	4	12'000	1, 2	20

Planing cutterheads Monobloc with HW planing knives

Art. Nr.	D	B	S	Z	Pos.	n max.	Fig.	Index
460270	96	80	HSK-P	2	3/1	12'000	1, 2	21
460271	96	130	HSK-P	2	3/1	12'000	1, 2	22
460272	96	180	HSK-P	2	1	12'000	1, 2	23
460273	96	210	HSK-P	2	1	12'000	1, 2	24
460274	96	240	HSK-P	2	1	12'000	1, 2	25
460275	96	80	HSK-P	2	2/4	12'000	1, 2	26
460276	96	130	HSK-P	2	2/4	12'000	1, 2	27
460277	96	180	HSK-P	2	4	12'000	1, 2	28
460278	96	210	HSK-P	2	4	12'000	1, 2	29
460279	96	240	HSK-P	2	4	12'000	1, 2	30
460280	96	80	HSK-P	4	3/1	12'000	1, 2	31
460281	96	130	HSK-P	4	3/1	12'000	1, 2	32
460282	96	180	HSK-P	4	1	12'000	1, 2	33
460283	96	210	HSK-P	4	1	12'000	1, 2	34
460284	96	240	HSK-P	4	1	12'000	1, 2	35
460285	96	80	HSK-P	4	2/4	12'000	1, 2	36
460286	96	130	HSK-P	4	2/4	12'000	1, 2	37
460287	96	180	HSK-P	4	4	12'000	1, 2	38
460288	96	210	HSK-P	4	4	12'000	1, 2	39
460289	96	240	HSK-P	4	4	12'000	1, 2	40

Planing cutterheads Monobloc with HS planing knives and jointing cutter

Art. Nr.	D	B	S	Z	Pos.	n max.	Fig.	Index
460290	131/96	80	HSK-P	2	1	12'000	3, 4	41
460291	131/96	130	HSK-P	2	1	12'000	3, 4	42
460292	131/96	180	HSK-P	2	1	12'000	3, 4	43
460293	131/96	210	HSK-P	2	1	12'000	3, 4	44
460294	131/96	240	HSK-P	2	1	12'000	3, 4	45
460295	131/96	80	HSK-P	4	1	12'000	3, 4	46

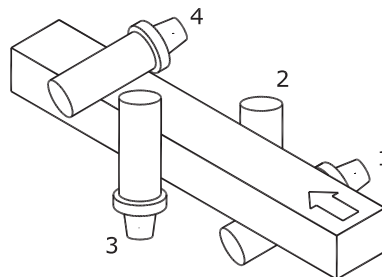
Art. Nr.	D	B	S	Z	Pos.	n max.	Fig.	Index
460296	131/96	130	HSK-P	4	1	12'000	3, 4	47
460297	131/96	180	HSK-P	4	1	12'000	3, 4	48
460298	131/96	210	HSK-P	4	1	12'000	3, 4	49
460299	131/96	240	HSK-P	4	1	12'000	3, 4	50

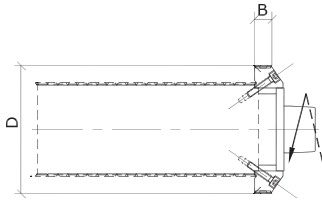
Planing cutterheads Monobloc with HW planing knives and jointing cutter

Art. Nr.	D	B	S	Z	Pos.	n max.	Fig.	Index
460300	131/96	80	HSK-P	2	1	12'000	3, 4	51
460301	131/96	130	HSK-P	2	1	12'000	3, 4	52
460302	131/96	180	HSK-P	2	1	12'000	3, 4	53
460303	131/96	210	HSK-P	2	1	12'000	3, 4	54
460304	131/96	240	HSK-P	2	1	12'000	3, 4	55
460305	131/96	80	HSK-P	4	1	12'000	3, 4	56
460306	131/96	130	HSK-P	4	1	12'000	3, 4	57
460307	131/96	180	HSK-P	4	1	12'000	3, 4	58
460308	131/96	210	HSK-P	4	1	12'000	3, 4	59
460309	131/96	240	HSK-P	4	1	12'000	3, 4	60

Spare parts

Art.Nr.		Index
216009	Reversible knives OERTLI, Format, B=14.0 h=14.0 a=2.0 Qual=HW	41-60
216571	Reversible knives OERTLI, Format, B=15 h=15 a=2.5 R=50 Typ=ECOline Qual=HW	41-60
216672	Reversible knives OERTLI, Format, B=15 h=15 a=2.5 R=50 Typ=H8 Qual=HW	41-52, 54-60
216672H6	Reversible knives OERTLI, Format, B=15 h=15 a=2.5 R=50 Typ=H6 Qual=HW	41-60
951012	Gib, L=80	1, 6, 11, 16, 21, 26, 31, 36, 41, 46, 51, 56
951013	Gib, L=130	2, 7, 12, 17, 22, 27, 32, 37, 42, 47, 52, 57
951014	Gib, L=180	3, 8, 13, 18, 23, 28, 33, 38, 43, 48, 53, 58
951015	Gib, L=210	4, 9, 14, 19, 24, 29, 34, 39, 44, 49, 54, 59
951016	Gib, L=240	5, 10, 15, 20, 25, 30, 35, 40, 45, 50, 55, 60
851039	Screws, M=5 D=8.4 L=12 Typ=Torx 20	41-60
851040	Screws, M=5 D=8.5 L=15.5 Typ=Torx 20	41-60
851493	Set screws, M=10 L=20 Typ=ISK 5	1-60





Jointing cutters with reversible knives for planing cutterheads Monobloc

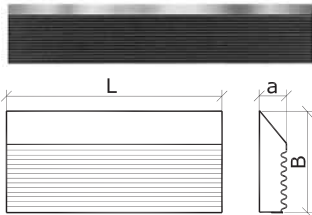
Application: Four-sided moulding machines

Design: Tungsten carbide reversible knives • Spur- and raker knives separately arranged • 4 cutting edges and spirally arranged with divided cut and shear cut angle for easy chipping • Tool body in steel • MEC (mechanical feed)

Art. Nr.	D	B	d	Z	n max.
470808	131	18	85	6 (2+2+2)	12'000

Spare parts

Art.Nr.	
216009	Reversible knives OERTLI, Format, B=14.0 h=14.0 a=2.0 Qual=HW
216571	Reversible knives OERTLI, Format, B=15 h=15 a=2.5 R=50 Typ=EColine Qual=HW
216672	Reversible knives OERTLI, Format, B=15 h=15 a=2.5 R=50 Typ=H8 Qual=HW
216672H6	Reversible knives OERTLI, Format, B=15 h=15 a=2.5 R=50 Typ=H6 Qual=HW
851039	Screws, M=5 D=8.4 L=12 Typ=Torx 20
851040	Screws, M=5 D=8.5 L=15.5 Typ=Torx 20



Planing knives with back serration

High-speed steel (HS)

Art. Nr.	L	B	a
450800	80	30	4
450801	130	30	4
450802	180	30	4
450803	210	30	4
450804	240	30	4

Tungsten carbide (HW)

Art. Nr.	L	B	a
450810	80	30	4
450811	130	30	4
450812	180	30	4
450813	210	30	4
450814	240	30	4

Clamping system ConeXX with HSK adaptor for moulding machines

The OERTLI ConeXX clamping technique has mainly been developed for HS, HW or DP tipped high performance tools which are used on modern moulding machines with PowerLock adaptors. The ConeXX clamping technique comprises of an ultra-precise, hardened and ground double hollow taper shank. One side of the hollow shank is the adaptor for the machine spindle; the other side is the adaptor for play-free mounting of the tool body. With the ConeXX clamping system and with small diameter tools, it is in fact possible to achieve a high precision concentric running accuracy and an extraordinary high balancing classification, which normally is only possible with expensive double-sided clamping Hydro sleeves.

A first-class planing quality is thereby achieved by a fast and simple tool change. Further, unexpected possibilities are opened with this system on working with machines equipped with PowerLock adaptors.

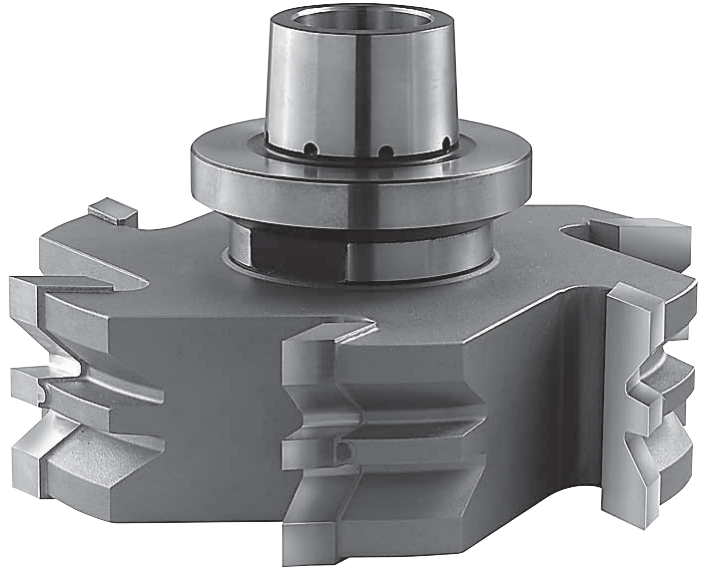




Fig. 1

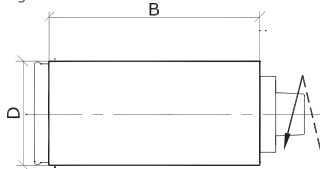


Fig. 2

Profile cutterheads Monobloc for knife blanks with back serration

Application: Universal tool for profiling of solid wood • Four-sided moulding machines

Design: High-speed steel (HS) • Tungsten carbide (HW) • Profile knife, one-sided profileable, straight cut • Knife clamping with high precision serration • Knives regrindable and adjustable • Basic equipment without knives • Tool body in steel • MEC (mechanical feed)

Art. Nr.	D1	B	S	Z	Pos.	n max.	Fig.	Index
460220	90	40	HSK-P	2	3/1	12'000	1, 2	1
460221	90	60	HSK-P	2	3/1	12'000	1, 2	2
460222	90	80	HSK-P	2	3/1	12'000	1, 2	3
460223	90	130	HSK-P	2	3/1	12'000	1, 2	4
460224	90	180	HSK-P	2	1	12'000	1, 2	5
460225	90	210	HSK-P	2	1	12'000	1, 2	6
460226	90	240	HSK-P	2	1	12'000	1, 2	7
460227	90	40	HSK-P	2	2/4	12'000	1, 2	8
460228	90	60	HSK-P	2	2/4	12'000	1, 2	9
460229	90	80	HSK-P	2	2/4	12'000	1, 2	10
460230	90	130	HSK-P	2	2/4	12'000	1, 2	11
460231	90	180	HSK-P	2	4	12'000	1, 2	12
460232	90	210	HSK-P	2	4	12'000	1, 2	13
460233	90	240	HSK-P	2	4	12'000	1, 2	14
460234	90	40	HSK-P	4	3/1	12'000	1, 2	15
460235	90	60	HSK-P	4	3/1	12'000	1, 2	16
460236	90	80	HSK-P	4	3/1	12'000	1, 2	17
460237	90	130	HSK-P	4	3/1	12'000	1, 2	18
460238	90	180	HSK-P	4	1	12'000	1, 2	19
460239	90	210	HSK-P	4	1	12'000	1, 2	20
460240	90	240	HSK-P	4	1	12'000	1, 2	21
460241	90	40	HSK-P	4	2/4	12'000	1, 2	22
460242	90	60	HSK-P	4	2/4	12'000	1, 2	23
460243	90	80	HSK-P	4	2/4	12'000	1, 2	24
460244	90	130	HSK-P	4	2/4	12'000	1, 2	25
460245	90	180	HSK-P	4	4	12'000	1, 2	26
460246	90	210	HSK-P	4	4	12'000	1, 2	27
460247	90	240	HSK-P	4	4	12'000	1, 2	28

Spare parts

Art.Nr.		Index
951010	Gib, L=40	1, 8, 15, 22
951011	Gib, L=60	2, 9, 16, 23
951012	Gib, L=80	3, 10, 17, 24
951013	Gib, L=130	4, 11, 18, 25
951014	Gib, L=180	5, 12, 19, 26
951015	Gib, L=210	6, 13, 20, 27
951016	Gib, L=240	7, 14, 21, 28
851493	Set screws, M=10 L=20 Typ=ISK 5	1-28

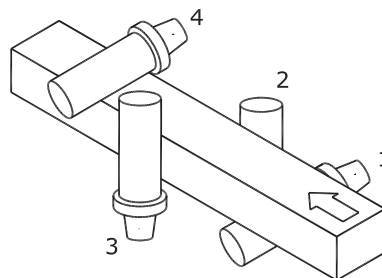




Fig. 1

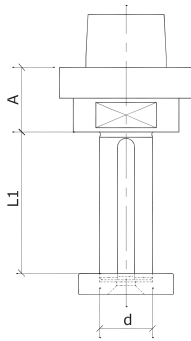


Fig. 2



Fig. 3

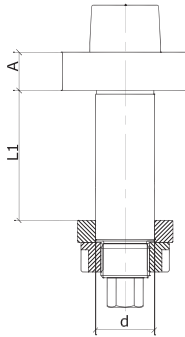


Fig. 4



Fig. 5

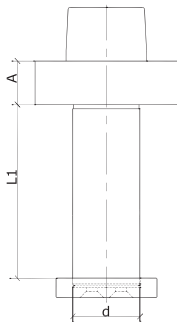


Fig. 6

Clamping shafts HSK-P

Design: Hardened and ground precision manufacture

Art. Nr.	d	A	L1	Typ	n max.	Fig.	Index
206902	30+DKN	26	108	HSK-P	12'000	1, 2	1
206903	30+DKN	26	164	HSK-P	12'000	1, 2	2
206904	40	26	77	HSK-P	12'000	3, 4	3
206905	40	26	107	HSK-P	12'000	3, 4	4
206908	40	26	137	HSK-P	12'000	3, 4	5
206906	40	26	177	HSK-P	12'000	3, 4	6
206907	40	26	247	HSK-P	12'000	3, 4	7
206930	40	26	77	HSK-P	12'000	5, 6	8
206931	40	26	107	HSK-P	12'000	5, 6	9
206932	40	26	137	HSK-P	12'000	5, 6	10
206933	40	26	177	HSK-P	12'000	5, 6	11
206934	40	26	247	HSK-P	12'000	5, 6	12
206935	40	26	312	HSK-P	8'000	5, 6	13

Spare parts

Art.Nr.		Index
206915	Clamping ring, D=65 B=15 d=35	3-7
206916	Clamping nut, M=33x1.5 D=40 B=20	3-7
207457	Keys for clamping shafts, B=8/7 L1=100 L=93	1
207487	Keys for clamping shafts, B=8/7 L1=160 L=153	2
206914	Catch ring, cranked, D=95 B=25 d=35	3-7
206922	Catch ring, D=95 B=10 d=40	8-13
207450	Covers for clamping shafts, D=50 B=10 d=30+DKN	1, 2
207594	Catch ring, D=90 B=10 d=30	1, 2
851347	Screws, M=6 D=9.5 L=20 Typ=Torx 20	8-13
851498	Special screws, d6=M8x20	1, 2

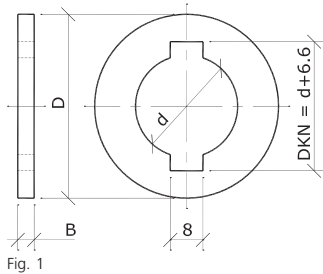


Fig. 1



Fig. 2

Spacers for clamping shafts

Art. Nr.	d	B	D	Fig.
207460	30+DKN	0.05	50	1
207461	30+DKN	0.10	50	1
207462	30+DKN	0.20	50	1
207463	30+DKN	0.50	50	1
207464	30+DKN	1.00	50	1
207469	30+DKN	2.00	50	1
207465	30+DKN	4.00	50	1
207466	30+DKN	5.00	50	1
207467	30+DKN	10.00	50	1
207486	30+DKN	20.00	50	1
207482	30+DKN	50.00	50	1
629814	40	0.05	65	2
629816	40	0.10	65	2
629818	40	0.20	65	2
629820	40	0.50	65	2
629822	40	1.00	65	2
629824	40	2.00	65	2
629826	40	3.00	65	2
629830	40	4.00	65	2
629832	40	5.00	65	2
629831	40	10.00	65	2
629833	40	20.00	65	2
629863	40	30.00	65	2
629867	40	40.00	65	2
629869	40	50.00	65	2

Tool installation device, pivotable

Application: As working aid by tool assembly as well as for inserted knife change

Design: With quick clamping lever • Pivotable

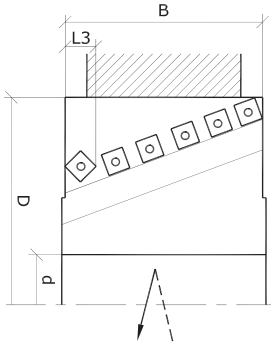
Art. Nr.	Typ
676831	HSK-P

Spare parts

Art.Nr.

206903	Clamping shafts HSK-P, d=30+DKN A=26 L1=164 Typ=HSK-P n max=12'000
629330	Spacers, d=30 B=1.00 D=55 NL=2/7.0/45
629332	Spacers, d=30 B=2.00 D=55 NL=2/7.0/45
629337	Spacers, d=30 B=10.00 D=55 NL=2/6.5/45
629338	Spacers, d=30 B=5.00 D=55 NL=2/6.5/45
629339	Spacers, d=30 B=20.00 D=55 NL=2/6.5/45
640220	Reducing sleeves with rim, d=30 D=40 B=10 b=6 D1=60
640257	Reducing sleeves with rim, d=30 D=50 B=15 b=6 D1=68
640259	Reducing sleeves with rim, d=30 D=65 B=15 b=6 D1=83





Spiral cutterheads with reversible knives CASTOR-FINISH

Application: For planing of solid wood • Four-sided moulding machines

Design: Tungsten carbide reversible knives • 4 cutting edges and spirally arranged with divided cut and shear cut angle for easy chipping • For finish cut without marking of knives • Tool body in aluminium • MEC (mechanical feed)

Bore 30

Art. Nr.	D	B	d	Z	n max.	Index
459041	100	125	30	4 (2+2)	14'500	1
459042	100	190	30	4 (2+2)	14'500	2

Bore 35

Art. Nr.	D	B	d	Z	n max.	Index
459040	100	125	35	4 (2+2)	14'500	3
459039	100	190	35	4 (2+2)	14'500	4

Bore 40

Art. Nr.	D	B	d	Z	n max.	Index
459034	120	125	40	4 (2+2)	12'000	5
459035	120	190	40	4 (2+2)	12'000	6
459036	120	240	40	4 (2+2)	12'000	7
459156	125	130	40	4 (2+2)	11'600	8
459157	125	180	40	4 (2+2)	11'600	9
459037	125	190	40	4 (2+2)	11'600	10
459158	125	230	40	4 (2+2)	11'600	11
459159	125	236	40	4 (2+2)	11'600	12
459038	125	240	40	4 (2+2)	11'600	13
459162	125	310	40	4 (2+2)	11'600	14

Bore 50

Art. Nr.	D	B	d	Z	n max.	Index
459031	120	125	50	4 (2+2)	12'000	15
459032	120	190	50	4 (2+2)	12'000	16
459033	120	240	50	4 (2+2)	12'000	17

Spare parts

Art.Nr.	Index
216571 Reversible knives OERTLI, Format, B=15 h=15 a=2.5 R=50 Typ=ECOLine Qual=HW	1-17
216672 Reversible knives OERTLI, Format, B=15 h=15 a=2.5 R=50 Typ=H8 Qual=HW	1-17
216672H6 Reversible knives OERTLI, Format, B=15 h=15 a=2.5 R=50 Typ=H6 Qual=HW	1-17
851040 Screws, M=5 D=8.5 L=15.5 Typ=Torx 20	1-17

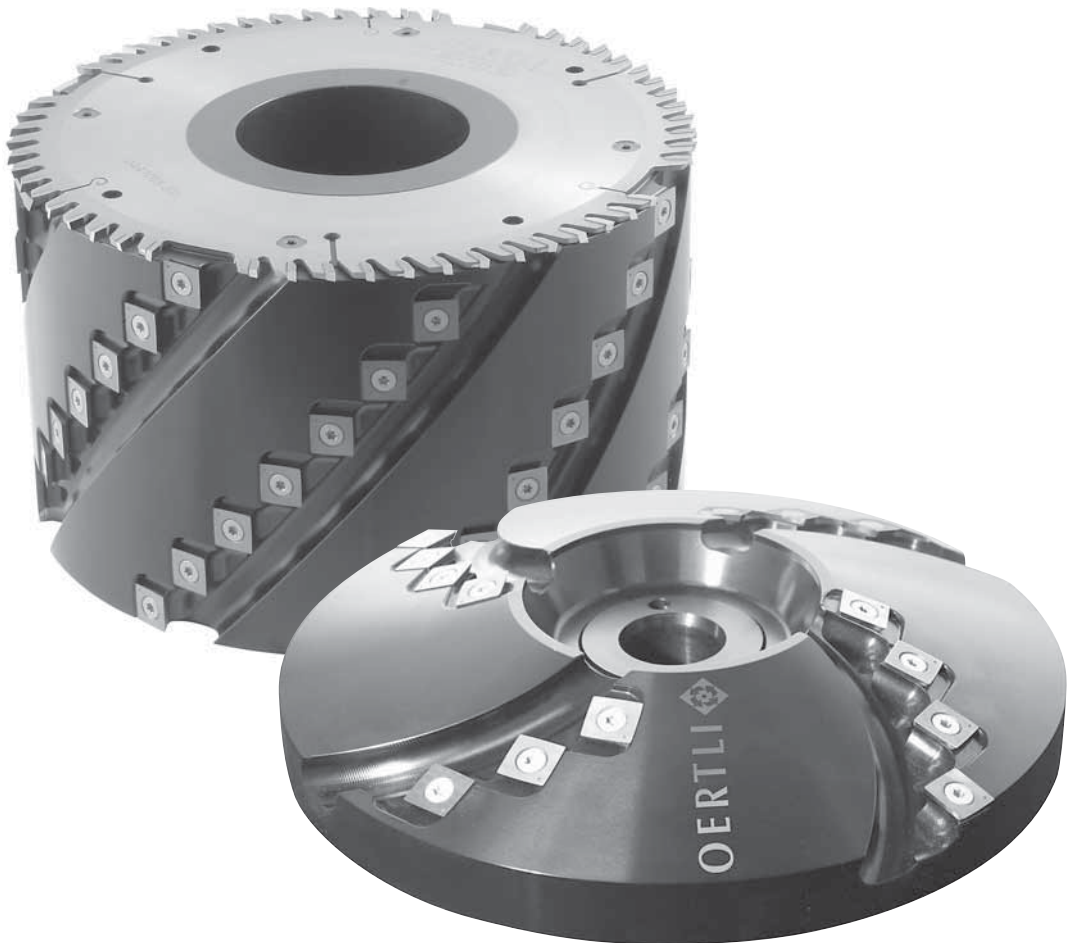
Tool system CASTOR Classic and CASTOR Conic

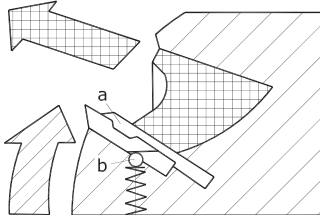
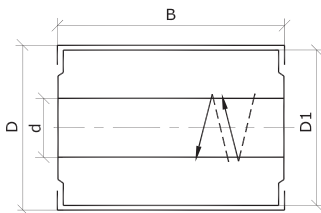
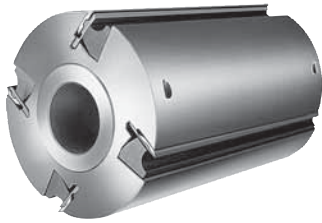
CASTOR Classic

Machining across grain takes place with the type «CASTOR Classic». The reversible knives are arranged spirally, but without shear cut angle. The cutterhead is used as tenoning head for pre-cutting and finish-cutting applications, for all applications working across grain, for cutting against the fibres or in wild-grown woods. Especially important is herewith the easy chipping at smallest cutting pressure.

CASTOR Conic

For slope-machining applications, the «CASTOR Conic» is available. This type can be realized with a slope on the tool body of 1° to 80° and it is designed with spirally arranged reversible knives and shear cut angle. It is suitable for slope-cutting in solid wood and in many plastic materials and it may be used on all machines including CNC machining centres.





Planing cutterheads SINUS

Application: For planing of solid wood • Four-sided moulding machines

Design: HS-TRI • Tungsten carbide polished • 2 cutting edges, straight cut • Quick knife change thanks to clamping by centrifugal forces without clamping screws and without time-consuming knife setting • Tempered precision chip limiter to incontestable positioning of reversible knives • Holding of reversible knives before clamping by spring balls • Economical use of knives thanks to regrinding possibilities • Basic equipment with built-in HS-TRI reversible knives • Tool body in steel • Tool body in aluminium • MEC (mechanical feed)

Tool body in steel, bore 30

Art. Nr.	D	B	d	Z	n max.
469105	100	120	30	3	10'000

Tool body in steel, bore 40

Art. Nr.	D	B	d	Z	n max.
469113	120	130	40	4	9'000
469115	120	180	40	4	9'000
469116	120	230	40	4	9'000
469117	125	80	40	4	9'000
469121	125	100	40	4	9'000
469122	125	120	40	4	9'000
469159	125	130	40	2	9'000
469108	125	130	40	4	9'000
469162	125	180	40	2	9'000
469112	125	180	40	4	9'000
469212	125	190	40	2	9'000
469209	125	190	40	4	9'000
469163	125	230	40	2	9'000
469110	125	230	40	4	9'000
469164	125	240	40	2	9'000
469128	125	240	40	4	9'000

Tool body in steel, bore 50

Art. Nr.	D	B	d	Z	n max.
469195	140	130	50	4	9'000
469210	140	180	50	4	9'000
469197	140	230	50	4	9'000
469211	140	240	50	4	9'000

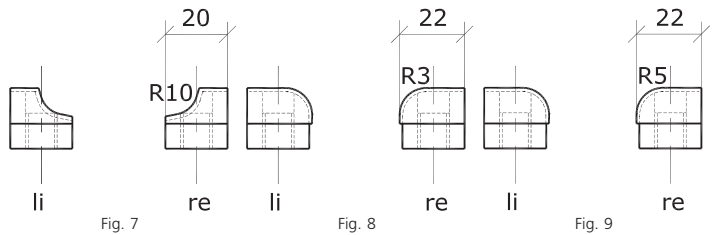
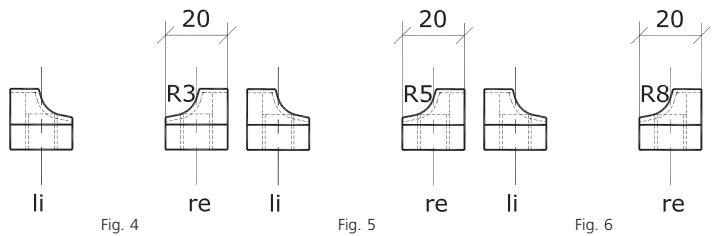
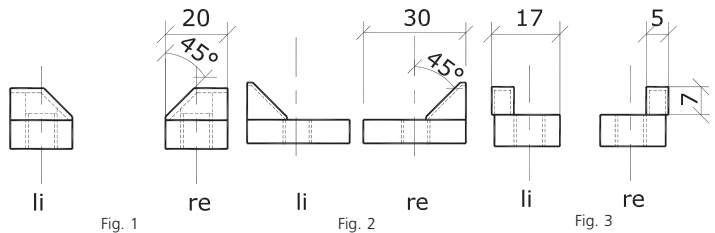
Tool body in aluminium, bore 40

Art. Nr.	D	B	d	Z	n max.
469223	125	130	40	2	8'500
469219	125	130	40	4	8'500
469218	125	180	40	2	8'500
469220	125	180	40	4	8'500
469222	125	230	40	4	8'500
469221	125	240	40	4	8'500
469224	125	310	40	4	8'500

Profile knives for planing cutterheads SINUS

Design: Tungsten carbide tipped • Profiled on one side, straight cut • Extra knife grooves are required for knife installation

Art. Nr.	Pos.	Fig.
469020	re.	1
469021	li.	1
469022	re.	2
469023	li.	2
469024	re.	3
469025	li.	3
469026	re.	4
469027	li.	4
469028	re.	5
469029	li.	5
469030	re.	6
469031	li.	6
469032	re.	7
469033	li.	7
469034	re.	8
469035	li.	8
469036	re.	9
469037	li.	9
469038	re.	10
469039	li.	10
469040	re.	11
469041	li.	11
469042	re./li.	12



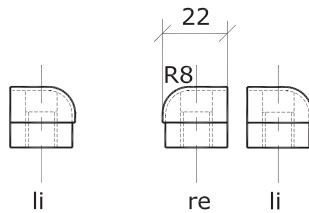


Fig. 10

Fig. 11

Fig. 12

Reversible knives for planing cutterheads SINUS

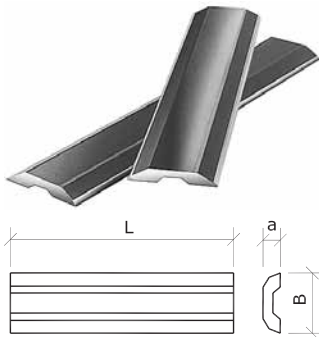
Design: HS-TRI • Tungsten carbide polished • 2 cutting edges, regrindable

HS-TRI

Art. Nr.	L	B	a
469707	60	16.0	2.5
469708	80	16.0	2.5
469710	100	16.0	2.5
469712	120	16.0	2.5
469713	130	16.0	2.5
469736	136	16.0	2.5
469714	140	16.0	2.5
469715	150	16.0	2.5
469716	160	16.0	2.5
469718	180	16.0	2.5
469786	186	16.0	2.5
469719	190	16.0	2.5
469720	200	16.0	2.5
469721	210	16.0	2.5
469722	220	16.0	2.5
469723	230	16.0	2.5
469724	240	16.0	2.5
469725	250	16.0	2.5
469726	260	16.0	2.5
469730	300	16.0	2.5
469731	310	16.0	2.5
469740	400	16.0	2.5
469741	410	16.0	2.5
469743	430	16.0	2.5
469750	500	16.0	2.5
469751	510	16.0	2.5
469761	610	16.0	2.5
469763	630	16.0	2.5
469764	640	16.0	2.5
469771	710	16.0	2.5
469798	1'350	16.0	2.5

Tungsten carbide polished

Art. Nr.	L	B	a
469950	80	16.3	2.5
469951	100	16.3	2.5
469952	120	16.3	2.5
469953	130	16.3	2.5
469954	140	16.3	2.5
469955	150	16.3	2.5
469956	160	16.3	2.5
469957	180	16.3	2.5
469958	200	16.3	2.5
469959	210	16.3	2.5
469960	220	16.3	2.5
469961	230	16.3	2.5



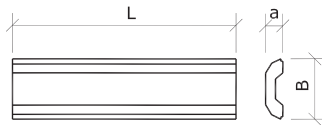
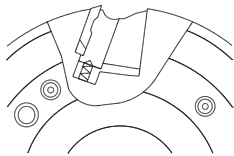
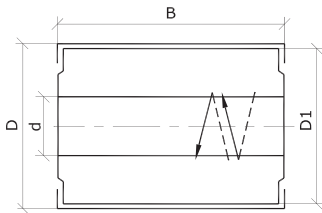
Art. Nr.	L	B	a
469962	240	16.3	2.5
469963	250	16.3	2.5
469964	260	16.3	2.5
469965	300	16.3	2.5

Planing cutterheads

Application: For ultra-fine planing of solid wood • Four-sided moulding machines

Design: HS coated • Tungsten carbide coated • Polished planing knives with 2 cutting edges, straight cut • Basic equipment with built-in HS reversible knives • Tool body in aluminium • MEC (mechanical feed)

Art. Nr.	D	B	d	Z	n max.
466600	125	130	40	4	8'000
466601	125	180	40	4	8'000
466602	125	230	40	4	8'000



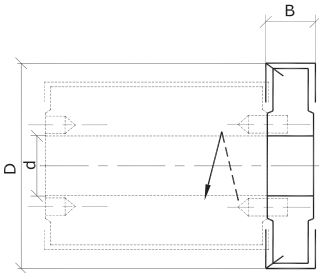
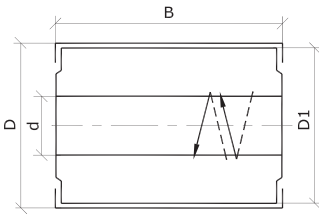
Reversible knives for planing cutterheads

HS coated

Art. Nr.	L	B	a
466629	115	12.0	2.6
466630	130	12.0	2.6
466631	180	12.0	2.6
466632	230	12.0	2.6

Tungsten carbide polished

Art. Nr.	L	B	a
466640	130	12.7	2.6
466641	180	12.7	2.6
466642	230	12.7	2.6



Planing cutterheads with Allen screw clamping system

Application: For planing of solid wood • Four-sided moulding machines

Design: High-speed steel (HS) • HS Super-Rapid • Tungsten carbide tipped • Straight cut • Cutterhead with grinding rebate and regrindable planing knives 30x3mm • Basic equipment without knives • Gibs with spring balls for simple setting of planing knives • Tool body in steel • MEC (mechanical feed)

Art. Nr.	D	D1	B	d	Z	n max.	Index
462097	125	119	130	40	4	9'000	1
462101	125	119	180	40	4	9'000	2
462098	125	119	230	40	4	9'000	3

Spare parts

Art.Nr.	Index
950446 Gib, L=174	2
950454 Gib, L=124	1
950460 Gib, L=224	3
851208 Screws, M=10 D=14 L=16.5 Typ=SW14	1-3

Jointing cutters with reversible knives

Application: Four-sided moulding machines

Design: Tungsten carbide reversible knives • Spur- and raker knives separately arranged • With one-sided shear cut angle • Tool body in steel • MEC (mechanical feed)

Jointing- / Rebating cutters with pins for tool body in aluminum

Art. Nr.	D	B	d	Z	n max.	Index
32222	145	12	40	4 (2+2)	11'100	1
32224	150	12	40	4 (2+2)	10'800	2
32220	160	15	40	4 (2+2)	10'000	3

Jointing- / Rebating cutters without pins for tool body in steel

Art. Nr.	D	B	d	Z	n max.	Index
32223	145	12	40	4 (2+2)	11'100	4
32225	150	12	40	4 (2+2)	10'800	5
32221	160	15	40	4 (2+2)	10'000	6

Spare parts

Art.Nr.	Index
216009 Reversible knives OERTLI, Format, B=14.0 h=14.0 a=2.0 Qual=HW	1, 2, 4, 5
216013 Reversible knives OERTLI, Format, B=16.0 h=16.0 a=3.0 Qual=HW	3, 6
217012 Reversible knives OERTLI, straight, B=12 h=8 a=1.5 Qual=HW	1, 2, 4, 5
217015 Reversible knives OERTLI, straight, B=15 h=8 a=1.5 Qual=HW	3, 6
950902 Gib, L=10.1 Typ=+10°	1, 2, 4, 5
950905 Gib, L=12.1 Typ=+15°	3, 6
851032 Screws, M=5 D=8.5 L=11 Typ=Torx 20	3, 6
851038 Screws, M=5 D=8 L=6.3 Typ=Torx 20	1, 2, 4, 5
851059 Screws, M=5 D=6.8 L=23 Typ=Torx 20	1-6



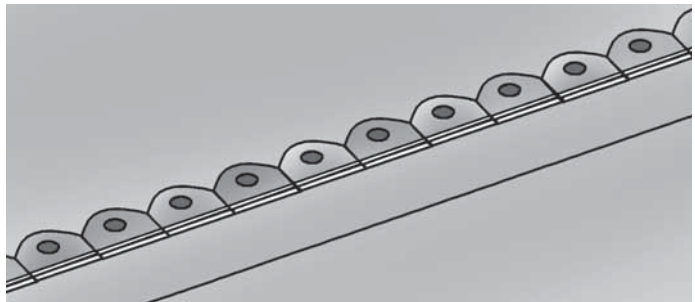
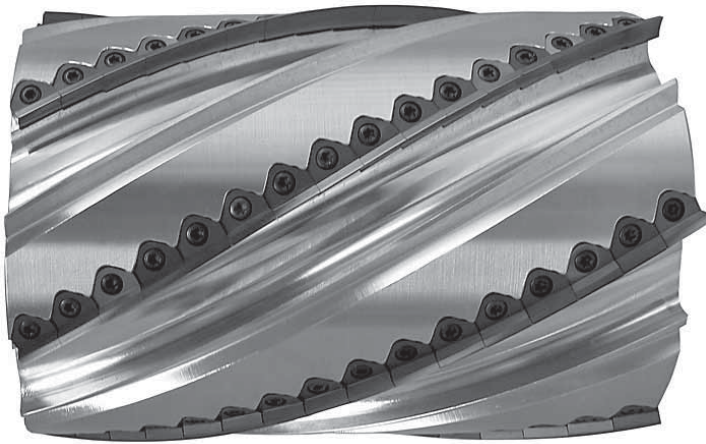
Knife setting device for planing cutterheads

Art. Nr.

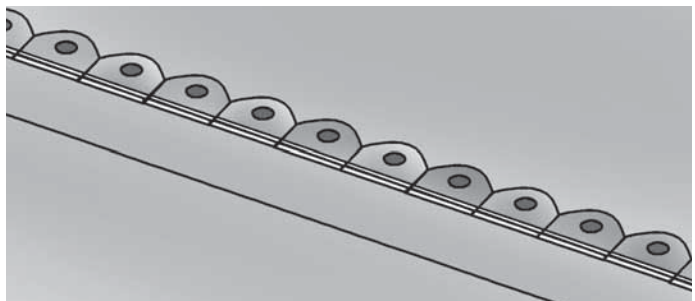
635600

Planing cutterheads Hydro for ultra-fine planing, system SIDEWINDER

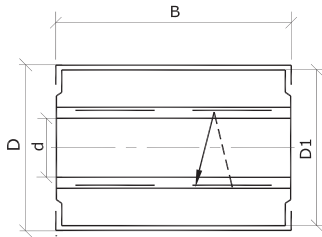
The OERTLI SIDEWINDER is a high performance planing cutterhead for ultra-fine planing of solid wood on standard machines, high performance planing machines and machines with PowerLock adaptor. The SIDEWINDER is equipped with Hydro clamping as well as with HW knife segments. The regrindable and replaceable segments are spirally arranged. The cutting pressure is thereby reduced leading to more performance and better cutting quality. In addition a considerable noise reduction is achieved. The knife segments are reground ultra-precise in the head in order that the concentric running accuracy can be maintained. The result is a finish-surface without knife-markings.



Left spirale: Chip ejection towards right



Right spirale: Chip ejection towards left



Planing cutterheads Hydro with Allen screw clamping system

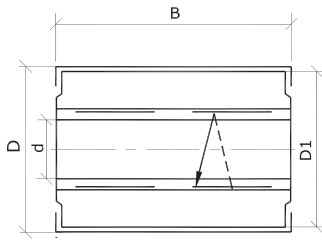
Application: For ultra-fine planing of solid wood at high feed rates • Four-sided moulding machines

Design: High-speed steel (HS) • HS Super-Rapid • Tungsten carbide tipped • Straight cut • Cutterhead with grinding rebate and regrindable planing knives 30x3mm • Basic equipment without knives • Gibs with spring balls for simple setting of planing knives • Integrated Hydro-locking system for precise concentricity • Tool body in steel • MEC (mechanical feed)

Art. Nr.	D	D1	B	d	Z	n max.	Index
463509	163	157	130	50	4	8'000	1
463510	163	157	130	50	6	8'000	2
463515	163	157	180	50	4	8'000	3
463516	163	157	180	50	6	8'000	4
463518	163	157	235	50	4	8'000	5
463519	163	157	235	50	6	8'000	6
463521	163	157	260	50	4	8'000	7
463522	163	157	260	50	6	8'000	8
463524	163	157	305	50	4	8'000	9
463525	163	157	305	50	6	8'000	10
463533	180	174	130	50	8	7'400	11
463534	180	174	180	50	8	7'400	12
463537	180	174	235	50	8	7'400	13
463540	180	174	260	50	8	7'400	14
463543	180	174	305	50	8	7'400	15

Spare parts

Art.Nr.		Index
950973	Gib, L=129	1, 2, 11
950976	Gib, L=179	3, 4, 12
950979	Gib, L=229	5, 6, 13
950980	Gib, L=259	7, 8, 14
950981	Gib, L=299	9, 10, 15
851609	Set screws, M=12 L=20 Typ=ISK 6	1-15



Planing cutterheads with square bolt clamping system

Application: For ultra-fine planing of solid wood at high feed rates • Four-sided moulding machines

Design: High-speed steel (HS) • HS Super-Rapid • Tungsten carbide tipped • Straight cut • Cutterhead with grinding rebate and regrindable planing knives 30x3mm • Basic equipment without knives • Gibs with spring balls for simple setting of planing knives • Integrated Hydro-locking system for precise concentricity • Tool body in steel • Tool body in aluminium • MEC (mechanical feed)

Tool body in steel

Art. Nr.	D	D1	B	d	Z	n max.	Index
463611	163	157	110	50	6	8'000	1
463616	163	157	130	50	6	8'000	2
463620	163	157	150	50	6	8'000	3
463626	163	157	180	50	6	8'000	4
463631	163	157	230	50	6	8'000	5
463635	163	157	260	50	6	8'000	6
463640	163	157	310	50	6	8'000	7
463651	180	174	130	50	8	7'400	8
463676	180	174	230	50	8	7'400	9

Tool body in aluminium

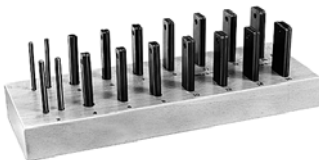
Art. Nr.	D	D1	B	d	Z	n max.	Index
463702	163	157	110	50	6	8'000	10
463704	163	157	130	50	6	8'000	11
463705	163	157	150	50	6	8'000	12
463707	163	157	180	50	6	8'000	13
463709	163	157	230	50	6	8'000	14
463710	163	157	260	50	6	8'000	15
463711	163	157	310	50	6	8'000	16
463715	180	174	130	50	8	7'400	17
463720	180	174	230	50	8	7'400	18

Spare parts

Art.Nr.		Index
950442	Gib, L=104	1, 10
950446	Gib, L=174	4, 13
950454	Gib, L=124	2, 11
950455	Gib, L=144	3, 12
950460	Gib, L=224	5, 14
950462	Gib, L=254	6, 15
950463	Gib, L=304	7, 16
950485	Gib, L=124	8, 17
950490	Gib, L=224	9, 18
851208	Screws, M=10 D=14 L=16.5 Typ=SW14	1-7, 10, 11-16
851209	Screws, M=8 D=10 L=14.0 Typ=SW10	8, 9, 17, 18

Spacer bars for Hydro planing cutterheads

Art. Nr.
466500





Jointing stones

Art. Nr.	Typ
465010	Weinig 60x20x15
465015	Weinig 20x15x60 400
465017	Weinig 20x15x60 280
465016	Weinig 60x20
465511	Kupfermühle 18x12x100
465520	Prof. 60x15x160



Moulding cutterheads for knife blanks with back serration

Application: Universal tool for profiling of solid wood • Four-sided moulding machines

Design: High-speed steel (HS) • Tungsten carbide (HW) • Profile knife, one-sided profileable, straight cut • Knife clamping with high precision serration • Knives regrindable and adjustable • Basic equipment without knives • Tool body in steel • MEC (mechanical feed)

Bore 30

Art. Nr.	D1	B1	d	Z	n max.	Index
468070	122	40	30	2	8'500	1

Bore 40

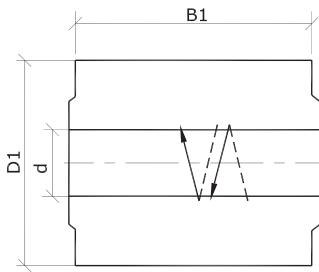
Art. Nr.	D1	B1	d	Z	n max.	Index
468071	122	40	40	2	8'500	2
468109	122	60	40	2	8'500	3
468100	122	60	40	4	8'500	4
468101	122	80	40	2	8'500	5
468105	122	80	40	4	8'500	6
468102	122	100	40	2	8'500	7
468110	122	100	40	4	8'500	8
468114	122	130	40	2	8'500	9
468115	122	130	40	4	8'500	10
468199	122	150	40	2	8'500	11
468120	122	150	40	4	8'500	12
468121	122	180	40	4	8'500	13
468098	122	230	40	2	8'500	14
468122	122	230	40	4	8'500	15

Bore 50

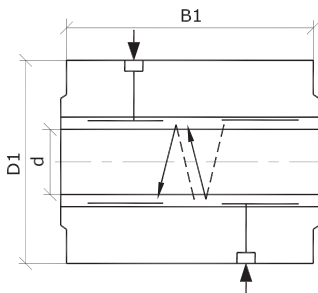
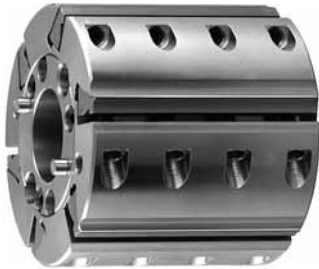
Art. Nr.	D1	B1	d	Z	n max.	Index
468151	137	60	50	4	7'500	16
468156	137	80	50	4	7'500	17
468161	137	100	50	4	7'500	18
468166	137	130	50	4	7'500	19
468171	137	150	50	4	7'500	20
468172	137	180	50	4	7'500	21
468173	137	230	50	4	7'500	22

Spare parts

Art.Nr.		Index
950849	Gib, L=40	1, 2
950850	Gib, L=60	3, 4, 16
950851	Gib, L=80	5, 6, 17
950852	Gib, L=100	7, 8, 18
950853	Gib, L=130	9, 10, 19
950854	Gib, L=150	11, 12, 20



Art.Nr.		Index
950855	Gib, L=180	13, 21
950856	Gib, L=230	14, 15, 22
851493	Set screws, M=10 L=20 Typ=ISK 5	1-22



Moulding cutterheads Hydro for knife blanks with back serration

Application: Universal tool for profiling of solid wood • Four-sided moulding machines

Design: High-speed steel (HS) • Tungsten carbide (HW) • Profile knife, one-sided profileable, straight cut • Knife clamping with high precision serration • Knives regrindable and adjustable • Basic equipment without knives • Integrated Hydro-locking system for precise concentricity • Tool body in steel • MEC (mechanical feed)

Bore 40

Art. Nr.	D1	B1	d	Z	n max.	Index
468201	137	60	40	4	6'000	1
468200	137	80	40	4	6'000	2
468204	137	130	40	4	6'000	3
468205	137	150	40	4	6'000	4
468202	137	180	40	4	6'000	5

Bore 50

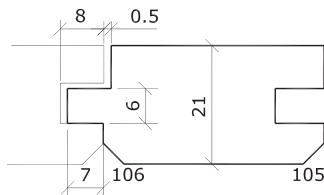
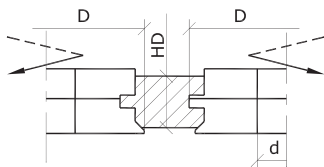
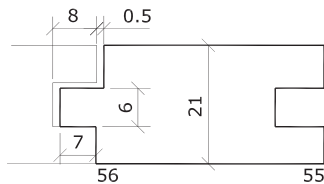
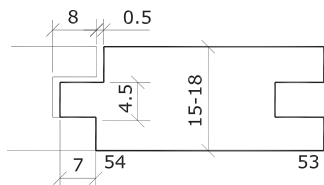
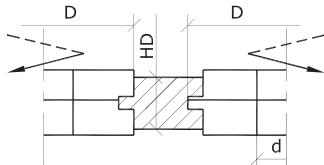
Art. Nr.	D1	B1	d	Z	n max.	Index
468208	150	60	50	6	6'000	6
468220	150	80	50	6	6'000	7
468211	150	130	50	6	6'000	8
468224	150	150	50	6	6'000	9
468215	150	180	50	6	6'000	10
468217	150	230	50	6	6'000	11

Spare parts

Art.Nr.		Index
950970	Gib, L=59	1, 6
950971	Gib, L=79	2, 7
950973	Gib, L=129	3, 8
950974	Gib, L=149	4, 9
950976	Gib, L=179	5, 10
950979	Gib, L=229	11
851609	Set screws, M=12 L=20 Typ=ISK 6	1-11

Blanking pieces

Art. Nr.	L
468920	60
468921	80
468922	100
468923	130
468924	150
468925	180
468926	230
468927	260
468928	310



Cutters for matched boards for floors (tongue and groove)

Application: For cutting of groove and tongue profiles on floor panels • Four-sided moulding machines

Design: High-speed steel (HS) • Straight cut • Groove and tongue adjustable by spacers (are included) • Tool body in steel • MEC (mechanical feed)

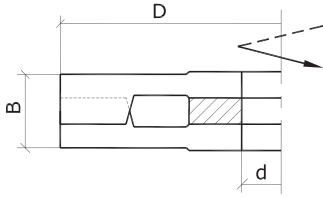
Art. Nr.	D	d	Z	n max.	Pos.
320122	180	59.96	6	8'000	54
320123	180	59.96	6	8'000	53
320132	180	59.96	6	8'000	56
320133	180	59.96	6	8'000	55

Cutters for matched boards with chamfer (tongue and groove)

Application: For cutting of groove and tongue profiles on wall- and ceiling panels • Four-sided moulding machines

Design: High-speed steel (HS) • Straight cut • Groove and tongue adjustable by spacers (are included) • Tool body in steel • MEC (mechanical feed)

Art. Nr.	D	d	Z	n max.	Pos.
330152	180	59.96	6	8'000	106
330153	180	59.96	6	8'000	105



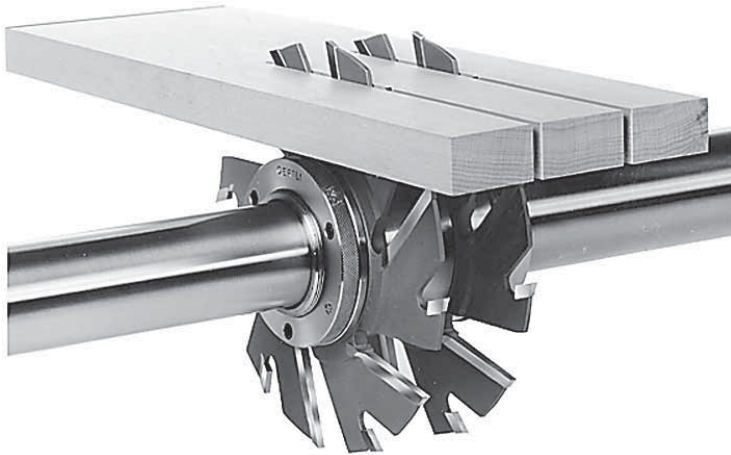
Grooving- and rebating cutter, 2-parts

Application: For rebating and grooving in solid wood, along grain • Four-sided moulding machines

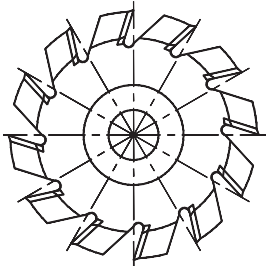
Design: High-speed steel (HS) • Raker knives with alternate shear cut angle • Grooving width adjustable with spacers (1 set included) • Tool body in steel • MEC (mechanical feed)

Art. Nr.	D	B	d	Z	n max.
40502	180	21-40	59.96	6 (3+3)	8'000

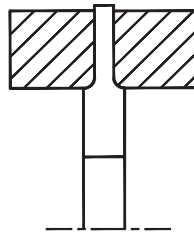
Splitting cutter with planing teeth



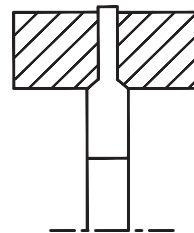
For splitting of solid wood, profile bars and similar components, OERTLI uses a specific splitting technique. Instead of a circular saw blade, a splitting cutter is used. In a single pass, the workpiece is not only split, but also – as required – simultaneously rounded or bevelled on the edges. Laterally arranged planing teeth produce perfectly smooth surfaces. Therefore, additional machining operations such as finish planing, bevelling and rounding are not necessary anymore. OERTLI splitting cutters are designed for the particular operating condition, type of wood and application.



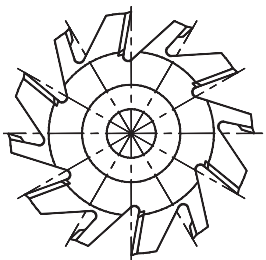
With planing teeth



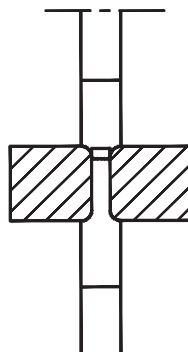
With rounding teeth



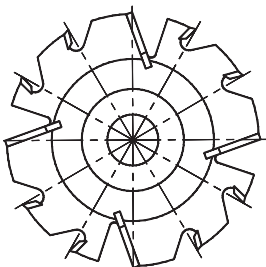
With bevelling teeth



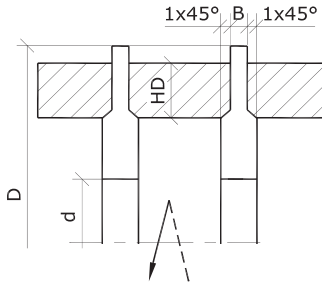
With planing teeth positive /
Raker teeth positive



Special design in 2-parts



With planing teeth negative /
Raker teeth positive

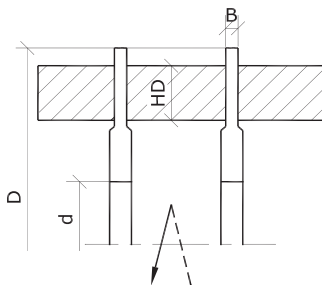


Splitting cutter with positive planing teeth

Application: For splitting of homogeneous woods without knots or soft wood with small knots • Four-sided moulding machines

Design: Tantung/ Stellite tipped (ST) • Positive planing teeth (0.5° conical) and positive raker knives, with bevel • Tool body in steel • MEC (mechanical feed)

Art. Nr.	D	B	HD	d	Z	n max.
390055	200	5.4	40	59.96	12 (6+6)	8'500
390060	200	6.5	50	59.96	12 (4+8)	8'500
390065	206	4.5	32	59.96	12 (6+6)	8'250
390066	206	4.5	32	60.00	12 (6+6)	8'250
390075	225	7.0	50	59.96	12 (6+6)	7'600
390077	225	7.0	50	60.00	12 (6+6)	7'600

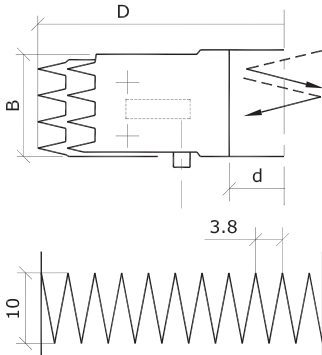
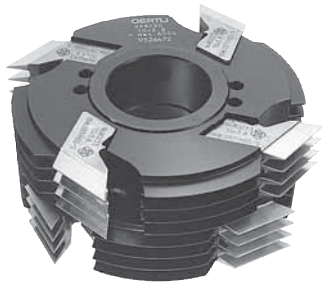


Splitting cutter with negative planing teeth

Application: For splitting of wood materials with knots and difficult to machine woods • Four-sided moulding machines

Design: Tantung/ Stellite tipped (ST) • Negative planing teeth (0.5° conical) and positive raker knives, without bevel • Tool body in steel • MEC (mechanical feed)

Art. Nr.	D	B	HD	d	Z	n max.
390028	180	4.0	25	59.96	12 (4+8)	9'000
390048	180	4.5	32	59.96	12 (4+8)	9'000
390051	200	4.5	32	59.96	12 (4+8)	8'500
390068	215	5.5	40	59.96	12 (4+8)	8'000
390080	230	7.0	50	59.96	12 (4+8)	7'400



Mini finger jointing cutter, profile 10x3.8

Application: For cutting of mini finger jointing connections in solid wood • Finger jointing machines

Design: HS for soft wood, HW for hard wood • Exchangeable profile teeth • Large regrinding range • Tool body in steel • MEC (mechanical feed)

On machines without cut-off saw, High-speed steel (HS)

Art. Nr.	D	B	d	Z	n max.	Index
98020	160	30.4	50	4 (2+2)	6'000	1
98025	250	30.4	50	6 (3+3)	4'500	2

On machines without cut-off saw, Tungsten carbide (HW)

Art. Nr.	D	B	d	Z	n max.	Index
98021	160	30.4	50	4 (2+2)	6'000	3
98026	250	30.4	50	6 (3+3)	4'500	4

On machines with cut-off saw, High-speed steel (HS)

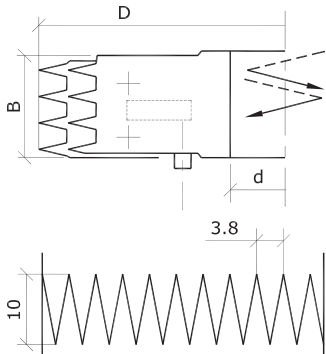
Art. Nr.	D	B	d	Z	n max.	Index
98022	160	30.4	50	4 (2+2)	6'000	5
98027	250	30.4	50	6 (3+3)	4'500	6

On machines with cut-off saw, Tungsten carbide (HW)

Art. Nr.	D	B	d	Z	n max.	Index
98023	160	30.4	50	4 (2+2)	6'000	7
98028	250	30.4	50	6 (3+3)	4'500	8

Spare parts

Art.Nr.		Index
98035	HS profile teeth, Typ=Profil 10x3.8	1, 2
98036	HW profile teeth, Typ=Profil 10x3.8	3, 4
98037	HS profile teeth, Typ=Profil 10/11x3.8	5, 6
98038	HW profile teeth, Typ=Profil 10/11x3.8	7, 8
851505	Set screws, M=6 L=30 Typ=ISK 3	2, 4, 6, 8
851536	Set screws, M=6 L=25 Typ=ISK 3	1, 3, 5, 7



Mini finger jointing cutter, profile 10x3.8

Application: For cutting of mini finger jointing connections in solid wood • Finger jointing machines

Design: HS coated • Exchangeable profile teeth • Tool body in steel • MEC (mechanical feed)

On machines without cut-off saw, HS coated (HS-HP)

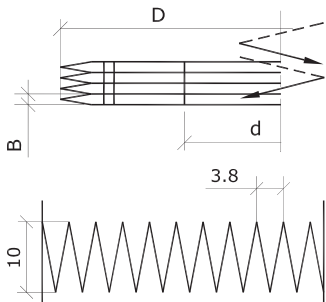
Art. Nr.	D	B	d	Z	n max.	Index
98310	160	38	50	4 (2+2)	7'000	1
98314	250	38	50	6 (3+3)	7'000	2

On machines with cut-off saw, HS coated (HS-HP)

Art. Nr.	D	B	d	Z	n max.	Index
98311	160	38	50	4 (2+2)	7'000	3
98315	250	38	50	6 (3+3)	7'000	4

Spare parts

Art.Nr.		Index
98320	HS-HP profile teeth, Typ=Profil 10x3.8	1, 2
98321	HS-HP profile teeth, Typ=Profil 10/11x3.8	3, 4



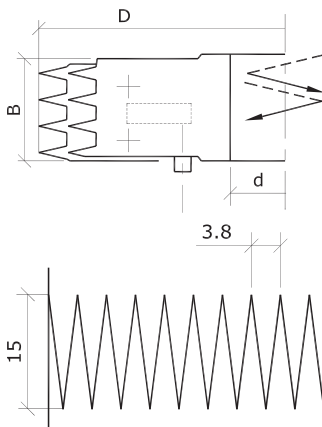
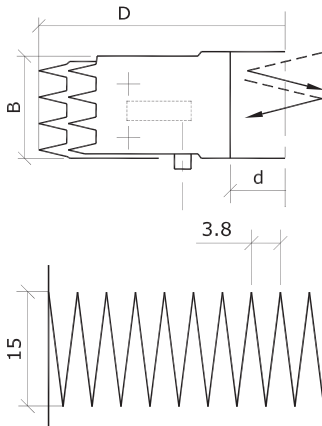
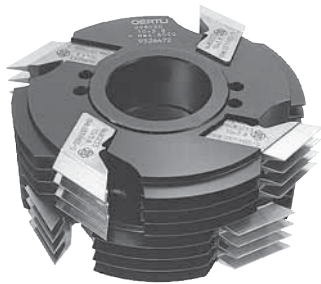
Mini finger jointing cutter, profile 10/11x3.8

Application: For cutting of mini finger jointing connections in solid wood • Finger jointing machines

Design: Tungsten carbide coated • Tool body in steel • MEC (mechanical feed)

On machines with cut-off saw, Tungsten carbide (HW)

Art. Nr.	D	B	d	Z	n max.
98301	160	3.8	70	2	8'000
98300	160	3.8	70	4	8'000
98302	250	3.8	70	6	8'000



Mini finger jointing cutter, profile 15x3.8

Application: For cutting of mini finger jointing connections in solid wood • Finger jointing machines

Design: High-speed steel (HS) • Exchangeable profile teeth • Large regrinding range • Tool body in steel • MEC (mechanical feed)

On machines without cut-off saw, High-speed steel (HS)

Art. Nr.	D	B	d	Z	n max.	Index
98083	170	30.4	50	4 (2+2)	6'000	1
98088	260	30.4	50	6 (3+3)	4'500	2

On machines with cut-off saw, High-speed steel (HS)

Art. Nr.	D	B	d	Z	n max.	Index
98082	170	30.4	50	4 (2+2)	6'000	3
98087	260	30.4	50	6 (3+3)	4'500	4

Spare parts

Art.Nr.		Index
98097	HS profile teeth, Typ=Profil 15/16.5x3.8	3, 4
98098	HS profile teeth, Typ=Profil 15x3.8	1, 2
851505	Set screws, M=6 L=30 Typ=ISK 3	2, 4
851536	Set screws, M=6 L=25 Typ=ISK 3	1, 3

Mini finger jointing cutter, profile 15x3.8

Application: For cutting of mini finger jointing connections in solid wood • Finger jointing machines

Design: HS coated • Exchangeable profile teeth • Tool body in steel • MEC (mechanical feed)

On machines without cut-off saw, HS coated (HS-HP)

Art. Nr.	D	B	d	Z	n max.	Index
98312	170	38	50	4 (2+2)	7'000	1
98316	260	38	50	6 (3+3)	7'000	2

On machines with cut-off saw, HS coated (HS-HP)

Art. Nr.	D	B	d	Z	n max.	Index
98313	170	38	50	4 (2+2)	7'000	3
98317	260	38	50	6 (3+3)	7'000	4

Spare parts

Art.Nr.		Index
98322	HS-HP profile teeth, Typ=Profil 15x3.8	1, 2
98323	HS-HP profile teeth, Typ=Profil 15/16.5x3.8	3, 4

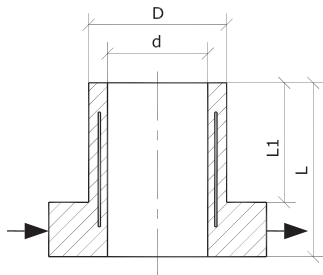


Fig. 1

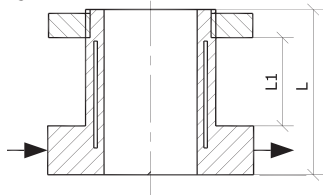
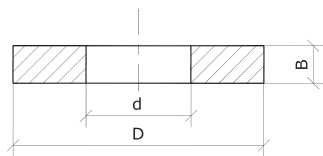


Fig. 2

Hydro clamping sleeves

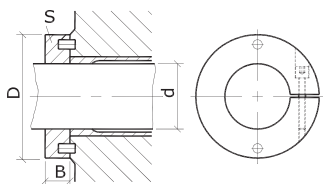
Application: For fix screw connection, type A • For multi-part tools, type B • Type A: Precision sleeve for fix-screwed tools. Hydro clamping towards inside • Type B: Precision sleeve with clamping nut for mounting of multi-part tools. Partial screwing possible. Hydro clamping towards inside and outside

Art. Nr.	D	L	d	L1	Typ	Fig.
467562	60.00	55	40	35	A	1
467522	60.00	35	45	15	A	1
467563	60.00	55	45	35	A	1
467524	60.00	75	45	55	A	1
467564	60.00	35	50	15	A	1
467565	60.00	55	50	35	A	1
467553	60.00	75	50	55	A	1
467686	60.00	115	50	95	A	1
467687	60.00	140	50	120	A	1
467623	50.00	140	40	100	B	2
467591	50.00	115	40	75	B	2
467630	59.96	75	40	35	B	2
467631	59.96	115	40	80	B	2
467632	59.96	140	40	105	B	2
467684	59.96	100	45	65	B	2
467651	59.96	115	45	80	B	2
467600	59.96	140	45	105	B	2
467603	59.96	190	45	150	B	2
467604	59.96	240	45	200	B	2
467670	59.96	75	50	40	B	2
467671	59.96	115	50	80	B	2
467672	59.96	140	50	105	B	2
467673	59.96	190	50	155	B	2
467610	59.96	240	50	200	B	2
467680	60.00	75	50	40	B	2
467611	60.00	190	50	150	B	2
467677	70.00	165	60	130	B	2
467679	70.00	260	60	225	B	2
467690	95.00	260	80	225	B	2



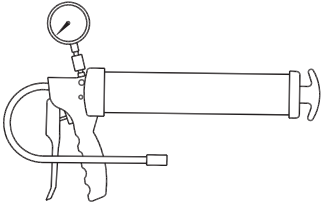
Spacers for Hydro clamping sleeves

Art. Nr.	D	B	d
467939	90	3	59.96
467940	90	5	59.96
467942	90	10	59.96
467943	90	12	59.96
467944	90	15	59.96
467946	90	20	59.96
467948	90	25	59.96



Safety rings

Art. Nr.	D	B	d
467921	95	20	50



High-pressure grease gun

Art. Nr.

467804

Spare parts**Art.Nr.**

467932 Sealing ring

467805 Replacement grease cartridge

467813 Hydraulic holder

467816 Grease hose

467930 Exhaust valve

467931 Pressure nipple

