

PRODUCT CATALOGUE



01 Grooving | Surface planing

02 Profiling | Rounding | Chamfering

03 Planing | Finger jointing | Chamfering

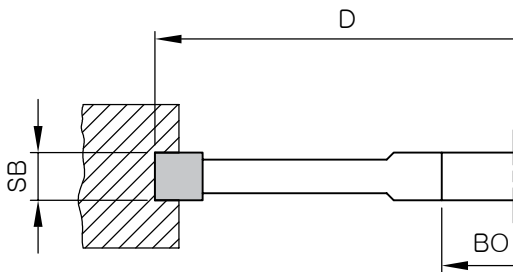
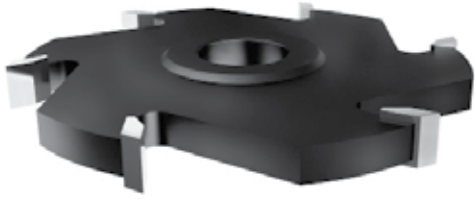
Edition X

[2026]

Grooving Surface planing



01



APPLICATION

Designed for longitudinal and transverse grooving of wood
Mechanical feed MEC

WORKPIECE MATERIAL

Softwood
Hardwood, MDF, chipboard—HW version

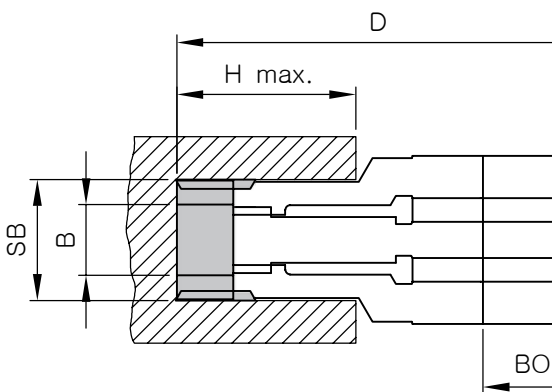
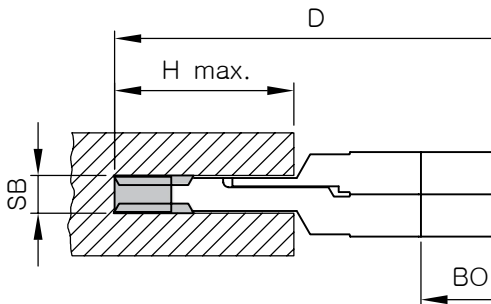
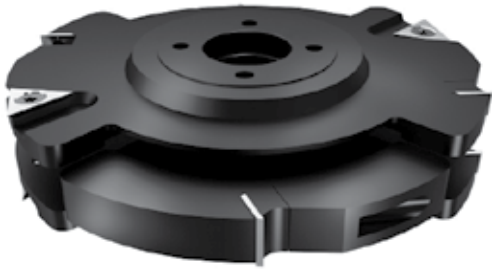
OPERATING CONDITIONS

n_{max} : 8,000 RPM

TECHNICAL SPECIFICATIONS

Brazed HW tips with straight cutting edges

D mm	SB mm	BO mm	Z	ID No. HW
150	4	30	6	11104
150	5	30	6	11105
150	6	30	6	11106
150	8	30	6	11108
150	10	30	6	11110
150	12	30	6	11112
150	14	30	6	11114
150	16	30	6	11116
150	20	30	6	11120



APPLICATION

Designed for longitudinal and transverse grooving of wood
Manual feed MAN

WORKPIECE MATERIAL

Softwood and hardwood, MDF, chipboard

OPERATING CONDITIONS

n: 5,000–8,000 RPM

TECHNICAL SPECIFICATIONS

HW indexable inserts with straight cutting edges

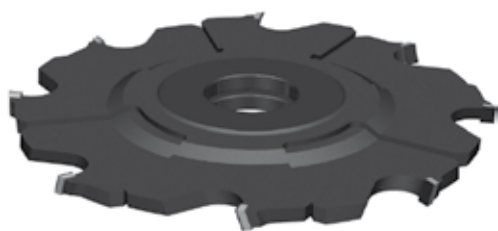
D mm	SB mm	B mm	BO mm	H _{max} mm	Z	ID No.
160	4–7.5	-	30	38	2+2	13274
160	8–15.5	-	30	38	2+2	13275
160	16–30	15	30	38	2	13276

13274

Spare parts	ID No.
VBD 18×18×1.95	3401818190
VBD 14×14×1.2	2201414120
SCREW M4×3.2 TX10	710077
COUNTERSUNK NUT M4×1.7	710083
COUNTERSUNK NUT M4×1.6	710082
TX10 KEY	710220

13275/13276

Spare parts	ID No.
VBD 15×12×1.5	1201512150
VBD 22×22×2	2102222200
VBD 7.5×12×1.5	1200712150
SCREW M6×4.8 TX20	710065
TX20 KEY	710240
HEX KEY 2.5	710202



APPLICATION

Designed for longitudinal and transverse milling or for widening of grooves
Mechanical feed MEC

WORKPIECE MATERIAL

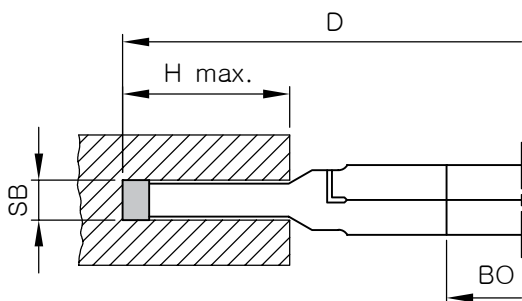
Hardwood and softwood
Hardwood, MDF, chipboard—HW, DP version

OPERATING CONDITIONS

n_{max} : 4,000–8,000 RPM (depending on type)

TECHNICAL SPECIFICATIONS

Brazed HW tips
Brazed DP tips
Groove width adjustment in 0.1 mm increments using spacer rings



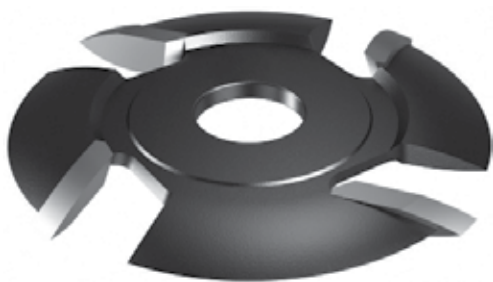
HW

D mm	SB mm	B mm	BO mm	H _{max} mm	Z	ID No. HW
150	4–7.5	-	30	30	2+2	13104
150	8–15.5	-	30	30	2+2	13175
150	16–30	15	30	30	2	13115

DP

D mm	SB mm	B mm	BO mm	H _{max} mm	Z	ID No.
160	4–7.5	-	30	30	4+4	13374
160	8–15.5	-	30	30	4+4	13375
180	4–7.5	-	30	40	4+4	13476

Patching cutter



APPLICATION

Cutting pockets for wooden patches
For specialized hand-held power tools, ensuring high-quality surface finish
Clean entry and exit without edge splintering

WORKPIECE MATERIAL

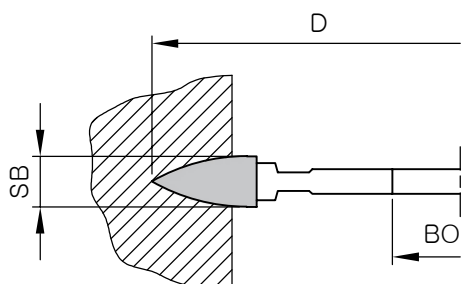
Softwood
Hardwood—HW version

OPERATING CONDITIONS

n_{max} : 15,000 RPM

TECHNICAL SPECIFICATIONS

Brazed HW tips with alternate shear angle



D mm	SB mm	BO mm	Z	ID No. HW
100	8	22	4	47101

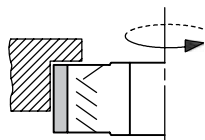
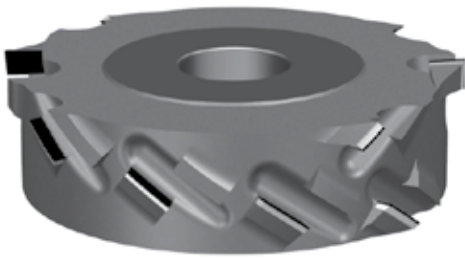


DIAGRAM I
Bottom stock removal

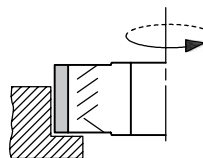
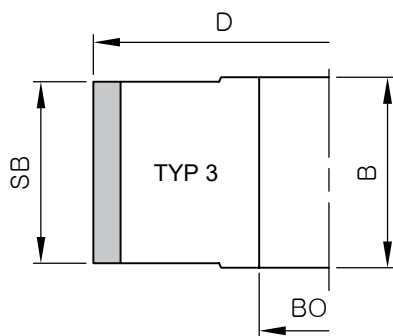


DIAGRAM II
Top stock removal



APPLICATION

Sizing and rebating with one-sided scoring
Mechanical feed MEC or manual feed MAN

WORKPIECE MATERIAL

Plywood, MDF, chipboard, softwood and hardwood, exotic wood
Glued materials, plastics

OPERATING CONDITIONS

n_{max} : 13,000 RPM
 v_f : 20 m/min
Recommended speed n : 12,000 RPM

TECHNICAL SPECIFICATIONS

High-quality surface finish
Clean entry and exit without edge splintering
DP cutting teeth with high axial shear angle
Asymmetric cutting teeth arrangement
Tooth height $H = 4.2$ mm
Up to 6 re-sharpening operations, depending on wear

MEC

D mm	SB mm	B mm	BO mm	H mm	Z	Diagram	ID No.
125	34	36	30	4.2	2	Bottom	1253402M0
125	34	36	30	4.2	2	Top	1253402M1

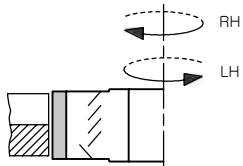
MAN

D mm	SB mm	B mm	BO mm	H mm	Z	Diagram	ID No.
125	34	36	30	4.2	2	Bottom	1253412M0
125	34	36	30	4.2	2	Top	1253412M1

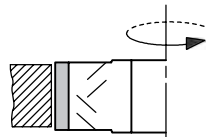
Planing cutter, StabilHead System, DP Indexable Inserts

01

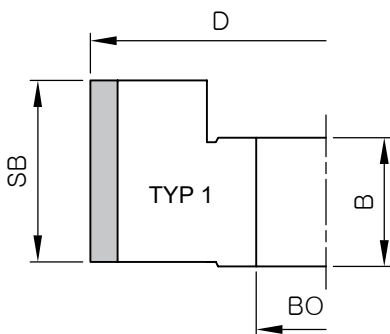
Grooving \ Surface planing



Asymmetric cutting teeth arrangement



Symmetric cutting teeth arrangement



APPLICATION

For pre-milling panels before edge banding
Climb or conventional milling

WORKPIECE MATERIAL

Chipboard and fibreboard (MDF, chipboard...)
Uncoated or coated with paper, plastic, or veneer
Glass or carbon fibre reinforced plastics

OPERATING CONDITIONS

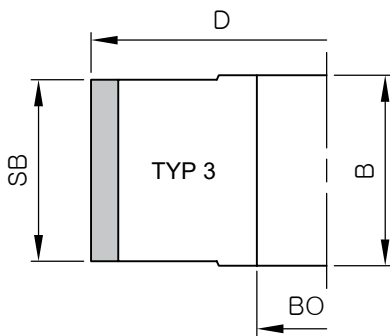
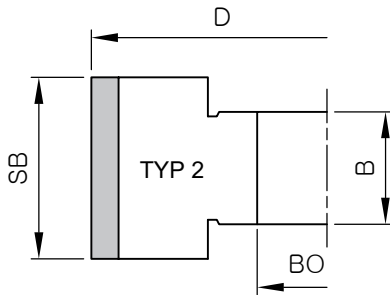
n_{max} : 17,000 RPM (D = 70–80 mm)
 n_{max} : 15,000 RPM (D = 85–100 mm)
 n_{max} : 12,000 RPM (D = 125 mm)

TECHNICAL SPECIFICATIONS

High axial rake angle
High-quality surface finish
Significant reduction in operating noise
Clean entry and exit without edge splintering
Cutting tip height H = 3.5 mm
Up to 5 re-sharpening operations, depending on wear
Available in LH/RH rotation, cutting edge arrangement AS/SY

Type 1

D mm	SB mm	B mm	BO mm	Z	Tooth arrangement	LH/RH	Machine	ID No.
70	66.7	41	25DKN	2 (12)	AS	LH	HOLZ HER	970401
70	66.7	41	25DKN	2 (12)	AS	RH	HOLZ HER	970402
80	66.7	53	30DKN	3 (18)	AS	LH	IMA/BRANDT	970407
80	66.7	53	30DKN	3 (18)	AS	RH	IMA/BRANDT	970408
85	55.8	62	30DKN	3 (15)	AS	LH	IMA/BRANDT	970405
85	55.8	62	30DKN	3 (15)	AS	RH	IMA/BRANDT	970404
100	44.8	41	25DKN	2 (8)	AS	LH	IMA/BRANDT	970409
100	44.8	41	25DKN	2 (8)	AS	RH	IMA/BRANDT	970410
100	44.8	41	30DKN	3 (12)	AS	LH	IMA/BRANDT	970411
100	44.8	41	30DKN	3 (12)	AS	RH	IMA/BRANDT	970412
100	55.8	41	30DKN	3 (15)	AS	LH	IMA/BRANDT	970413
100	55.8	41	30DKN	3 (15)	AS	RH	IMA/BRANDT	970414
100	66.7	41	30DKN	3 (18)	AS	LH	IMA/BRANDT	970415
100	66.7	41	30DKN	3 (18)	AS	RH	IMA/BRANDT	970416
100	88.6	60	30DKN	3 (24)	AS	LH	IMA/BRANDT	970417
100	88.6	60	30DKN	3 (24)	AS	RH	IMA/BRANDT	970418



Type 2

D mm	SB mm	B mm	BO mm	Z	Tooth arrangement	LH/RH	Machine	ID No.
70	55.8	31	30DKN	2 (10)	AS	LH	HOLZ HER	970503
70	55.8	31	30DKN	2 (10)	AS	RH	HOLZ HER	970504
70	44.8	50	30DKN	2 (10)	AS	LH	HOLZ HER	970505
70	44.8	50	30DKN	2 (10)	AS	RH	HOLZ HER	970506
100	44.8	25	30DKN	2 (8)	AS	LH	HOLZ HER	970507
100	44.8	25	30DKN	2 (8)	AS	RH	HOLZ HER	970508
100	55.8	26	30DKN	3 (15)	AS	LH	HOMAG	970509
100	55.8	26	30DKN	3 (15)	AS	RH	HOMAG	970510
100	66.7	25	30DKN	2 (12)	AS	LH	HOLZ HER	970511
100	66.7	25	30DKN	2 (12)	AS	RH	HOLZ HER	970512
100	66.7	44	30DKN	3 (18)	AS	LH	OTT	970513
100	66.7	44	30DKN	3 (18)	AS	RH	OTT	970514
125	44.8	40	30DKN	3 (12)	AS	LH	Biesse, Homag, IMA	970515
125	44.8	40	30DKN	3 (12)	AS	RH	Biesse, Homag, IMA	970516
125	66.7	41	30DKN	3 (18)	AS	LH	Biesse, Homag, IMA	970517
125	66.7	41	30DKN	3 (18)	AS	RH	Biesse, Homag, IMA	970518

Type 3

D mm	SB mm	B mm	BO mm	Z	Tooth arrangement	LH/RH	Machine	ID No.
85	44.8	48	30DKN	3 (12)	AS	LH	OTT	970601
85	44.8	48	30DKN	3 (12)	AS	RH	OTT	970602
125	34	36	30DKN	3 (9)	SY	LH, RH	HOMAG	970603
125	34	36	30DKN	3 (9)	AS	LH	Biesse, Homag, IMA	970605
125	34	36	30DKN	3 (9)	AS	RH	Biesse, Homag, IMA	970604
125	44.8	52	30DKN	3 (12)	AS	LH	OTT	970607
125	44.8	52	30DKN	3 (12)	AS	RH	OTT	970606

Spare parts

	ID No.
Screw M5×0.8-10 TX20	710120
DP-indexable inserts 13.5 StabilHead	970400
TX20 key	710240



APPLICATION

For pre-milling panels before edge banding
 Climb or conventional milling
 For machines: Biesse, Brandt, Homag, Holz Her, IMA, Felder, Ott

WORKPIECE MATERIAL

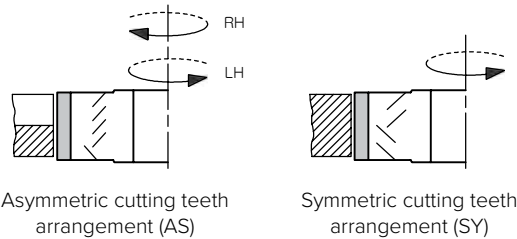
Chipboard and fibreboard (MDF, chipboard...)
 Uncoated or coated with paper, plastic, or veneer
 Glass or carbon fibre reinforced plastics

OPERATING CONDITIONS

n_{max} : 22,000 RPM (D = 60–70 mm)
 n_{max} : 18,000 RPM (D = 80–100 mm)
 Recommended speed n: 20,000 RPM (D = 60–70 mm)
 n: 12,000 RPM (D = 80–100 mm)

TECHNICAL SPECIFICATIONS

High axial rake angle
 High-quality surface finish
 Clean entry and exit without edge splintering
 Cutting tip height H = 3.5 mm
 Up to 5 re-sharpening operations, depending on wear
 Available in LH/RH rotation, cutting edge arrangement AS/SY



Type 1

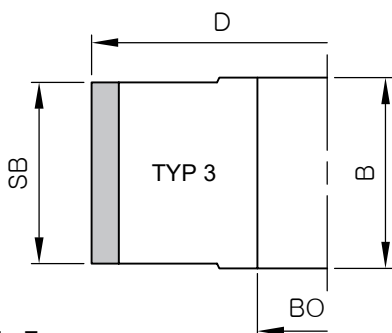
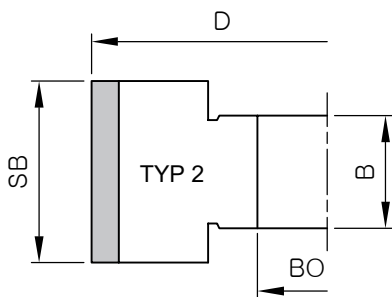
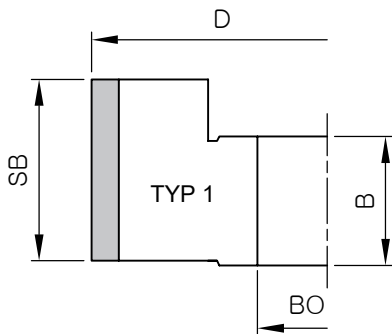
D mm	SB mm	B mm	BO mm	Z	Tooth arrangement	LH/RH	Machine	ID No.
70	65	41	25DKN	2	AS	LH	HOLZ HER	970101
70	65	41	25DKN	2	AS	RH	HOLZ HER	970102
80	65	53	30DKN	3	AS	LH	IMA / BRANDT	970107
80	65	53	30DKN	3	AS	RH	IMA / BRANDT	970108
100	44.6	41	25DKN	2	AS	LH	IMA / BRANDT	970109
100	44.6	41	25DKN	2	AS	RH	IMA / BRANDT	970110
100	48	41	30DKN	3	AS	LH	IMA / BRANDT	970103
100	48	41	30DKN	3	AS	RH	IMA / BRANDT	970104
100	65	41	30DKN	3	AS	LH	IMA / BRANDT	970105
100	65	41	30DKN	3	AS	RH	IMA / BRANDT	970106

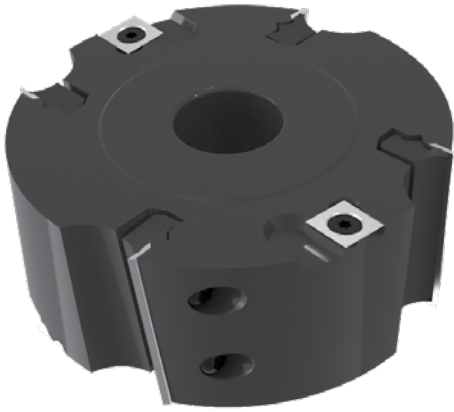
Type 2

D mm	SB mm	B mm	BO mm	Z	Tooth arrangement	LH/RH	Machine	ID No.
60	64	62	25DKN	2	AS	LH	FELDER	970201
60	64	62	25DKN	2	AS	RH	FELDER	970202
70	55	31	30DKN	2	AS	LH	HOLZ HER	970203
70	55	31	30DKN	2	AS	RH	HOLZ HER	970204
100	48	25	30DKN	2	AS	LH	HOLZ HER	970205
100	48	25	30DKN	2	AS	RH	HOLZ HER	970206
100	65	25	30DKN	2	AS	LH	HOLZ HER	970207
100	65	25	30DKN	2	AS	RH	HOLZ HER	970208
125	43	40	30DKN	3	AS	LH	HOLZ HER	970209
125	43	40	30DKN	3	AS	RH	Biesse, Homag, IMA	970210
125	63	41	30DKN	3	AS	LH	Biesse, Homag, IMA	970211
125	63	41	30DKN	3	AS	RH	Biesse, Homag, IMA	970212

Type 3

D mm	SB mm	B mm	BO mm	Z	Tooth arrangement	LH/RH	Machine	ID No.
85	46	48	30DKN	3	AS	LH	OTT	970301
85	46	48	30DKN	3	AS	RH	OTT	970302
125	34	36	30DKN	3	SY	LH, RH	HOMAG	970303
125	34	36	30DKN	3	AS	LH	Biesse, Homag, IMA	970305
125	34	36	30DKN	3	AS	RH	Biesse, Homag, IMA	970306





APPLICATION

Designed for milling flat surfaces and rebating
Manual feed MAN

WORKPIECE MATERIAL

Hardwood and softwood, plywood

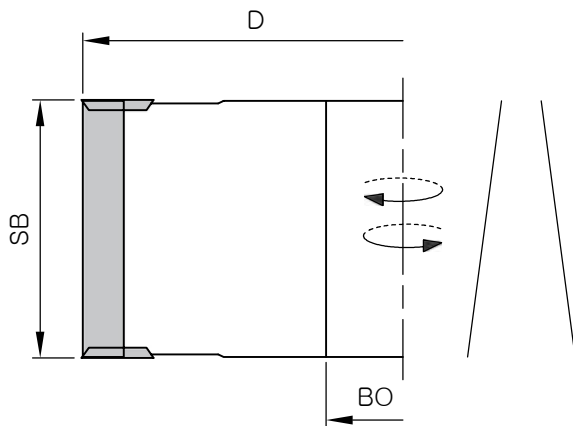
OPERATING CONDITIONS

n_{max} : 4,000–8,000 RPM (depending on type)

TECHNICAL SPECIFICATIONS

HW indexable inserts
HW 4-edge indexable scoring inserts with straight cutting edge

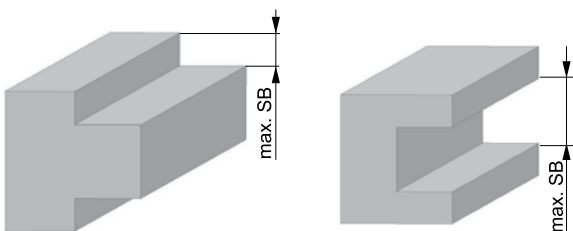
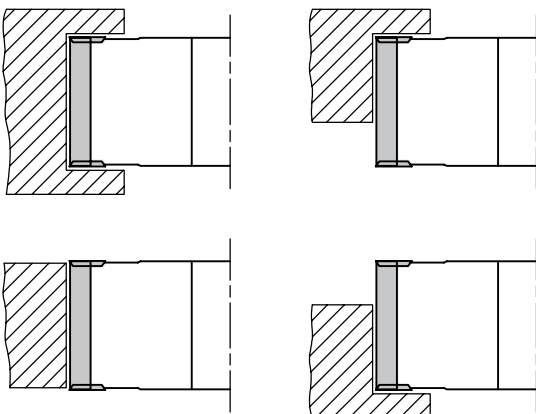
D mm	SB mm	BO mm	Z	ID No.
125	30	30/50	4+4	14130
125	50	30/50	4+4	14150



Spare parts

	ID No.
VBD 30×8×1.5	4103008150
VBD 50×8×1.5	4105008150
VBD 14×14×2	2201414200
SCREW M5×10 TX20	710086
SCREW M6×28 TX25	710057
TX25 KEY	710245
TX20 KEY	710240

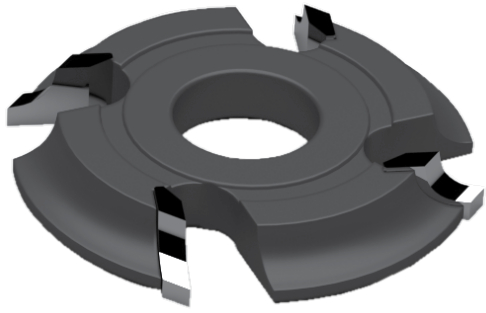
Machining Options



Profiling
Rounding
Chamfering



02



APPLICATION

For final edge rounding
Mechanical feed MEC

WORKPIECE MATERIAL

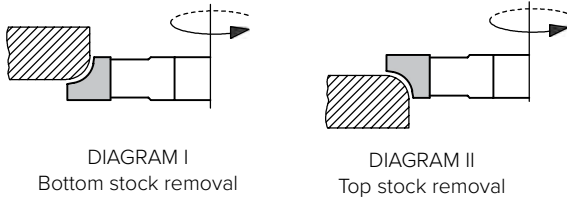
Softwood
Hardwood—HW version

OPERATING CONDITIONS

n_{max} : 12,000 RPM

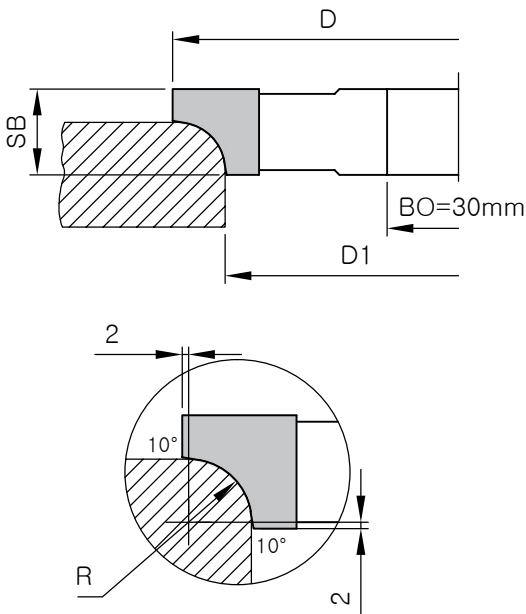
TECHNICAL SPECIFICATIONS

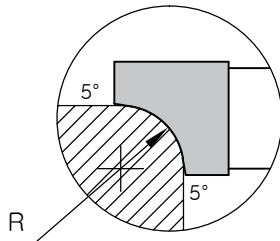
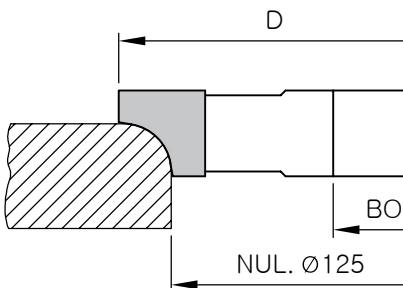
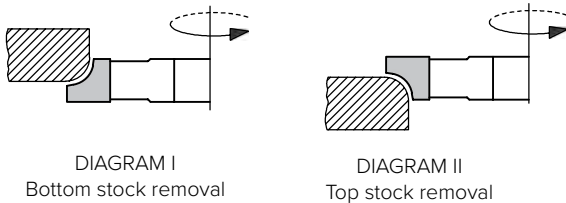
Brazed HW tips
Bottom and top stock removal



D mm	D1 mm	SB mm	R mm	Z	DIAGRAM I ID No.	DIAGRAM II ID No.
110	100	10	3	4	26203	26103
112	100	11	4	4	26204	26104
114	100	12	5	4	26205	26105
116	100	13	6	4	26206	26106
120	100	15	8	4	26208	26108
124	100	17	10	4	26210	26110
128	100	20	12	4	26212	26112
132	100	22	14	4	26214	26114
136	100	24	16	4	26216	26116

! Larger rounding dimensions available upon request.





APPLICATION

For final edge rounding
Manual feed MAN
Smooth transition to the flat surface

WORKPIECE MATERIAL

Hardwood and softwood, MDF

OPERATING CONDITIONS

n_{max} : 4,700–9,000 RPM (depending on type)

TECHNICAL SPECIFICATIONS

HW indexable inserts Z3
Universal steel cutter body: R2-R6, R7-R10, R12-R16, R18-R20

Cutter body for bottom stock removal—DIAGRAM I

R mm	D mm	BO mm	Z	n RPM	ID No.
R2–R6	140	30/40	3	5500–9000	260020
R7–R10	148	30/40	3	5200–8800	260070
R12–R16	159	30/40	3	5000–8000	260120
R18–R20	167	30/40	3	4700–7800	260180

Cutter body for top stock removal—DIAGRAM II

R mm	D mm	BO mm	Z	n RPM	ID No.
R2–R6	140	30/40	3	5500–9000	260021
R7–R10	148	30/40	3	5200–8800	260071
R12–R16	159	30/40	3	5000–8000	260121
R18–R20	167	30/40	3	4700–7800	260181

Profile indexable inserts for cutter bodies:

R mm	Machining diagram	ID No.	Rounding radius	Machining diagram	ID No.
R2	Bottom	262020	R10	Bottom	261100
R2	Top	262021	R10	Top	261101
R3	Bottom	262030	R12	Bottom	262120
R3	Top	262031	R12	Top	261121
R4	Bottom	261040	R14	Bottom	261140
R4	Top	261041	R14	Top	261141
R5	Bottom	261050	R15	Bottom	261150
R5	Top	261051	R15	Top	261151
R6	Bottom	261060	R16	Bottom	261160
R6	Top	261061	R16	Top	261161
R7	Bottom	261070	R18	Bottom	261180
R7	Top	261071	R18	Top	261181
R8	Bottom	261080	R20	Bottom	261200
R8	Top	261081	R20	Top	261201

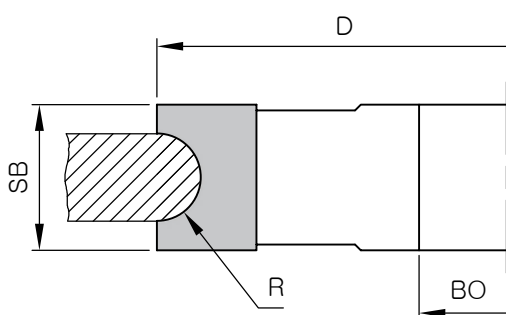
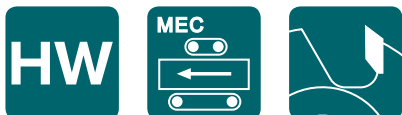
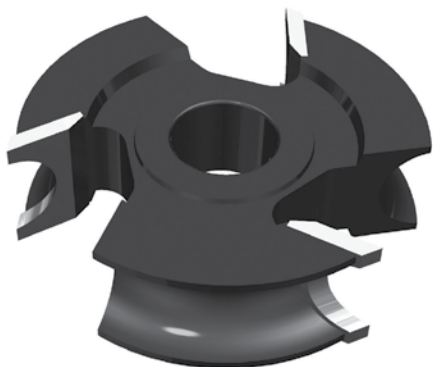
Spare parts

	ID No.
SCREW M6×20TX25	710058
TX25 KEY	710245

\\ Concave Half-Round Cutter

02

Profiling \ Rounding \ Chamfering



APPLICATION

For final edge rounding
Mechanical feed MEC

WORKPIECE MATERIAL

Softwood
Hardwood—HW version

OPERATING CONDITIONS

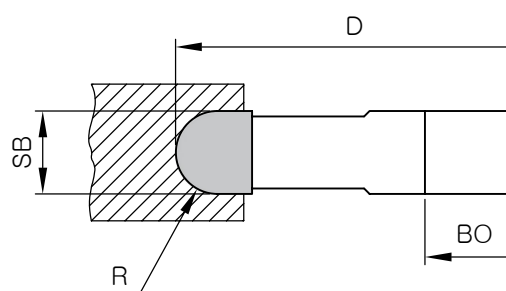
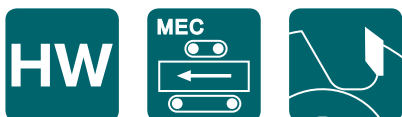
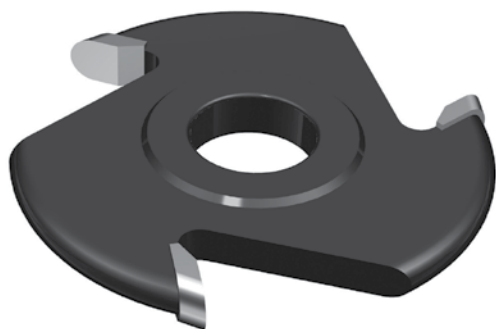
n_{max} : 12,000 RPM

TECHNICAL SPECIFICATIONS

Brazed HW tips

D mm	SB mm	BO mm	R mm	Z	ID No. HW
120	18	30	4	3	24104
120	20	30	5	3	24105
120	22	30	6	3	24106
120	25	30	7.5	3	24108
120	30	30	10	3	24110
120	35	30	12.5	3	24113
120	40	30	15	3	24115
140	45	30	17.5	3	24118
140	50	30	20	3	24120

\\ Convex Half-Round Cutter



APPLICATION

Fluting and grooving with rounded internal edges
Mechanical feed MEC

WORKPIECE MATERIAL

Softwood
Hardwood—HW version

OPERATING CONDITIONS

n_{max} : 12,000 RPM

TECHNICAL SPECIFICATIONS

Brazed HW tips

D mm	SB mm	BO mm	R mm	Z	ID No. HW
120	8	30	4	3	25104
120	10	30	5	3	25105
120	12	30	6	3	25106
120	15	30	7.5	3	25108
120	20	30	10	3	25110
120	25	30	12.5	3	25113
120	30	30	15	3	25115
140	35	30	17.5	3	25118
140	40	30	20	3	25120

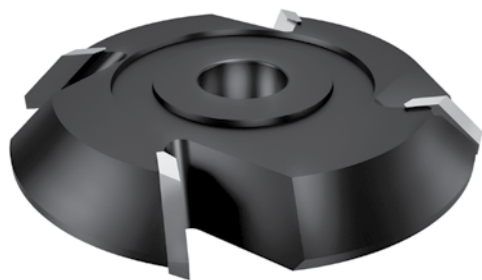


DIAGRAM I
Bottom stock removal

DIAGRAM II
Top stock removal

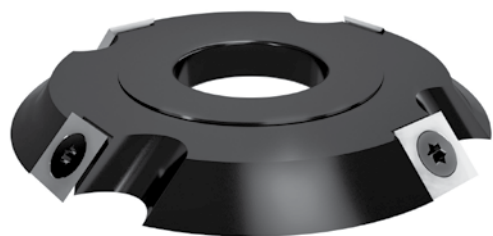
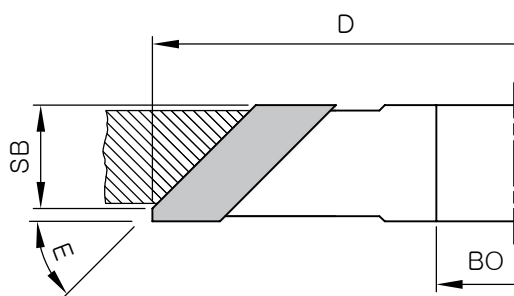
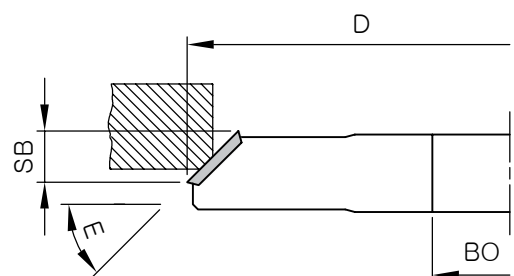


DIAGRAM I
Bottom stock removal

DIAGRAM II
Top stock removal



APPLICATION

For final edge chamfering
Mechanical feed MEC

WORKPIECE MATERIAL

Softwood
Hardwood—HW version

OPERATING CONDITIONS

n_{max} : 12,000 RPM

TECHNICAL SPECIFICATIONS

Brazed HW tips

D mm	SB mm	BO mm	E °	Z	DIAGRAM I ID No.	DIAGRAM II ID No.
120	15	30	45	4	28200	28101
140	20	30	45	4	28202	28102
160	30	30	45	4	28203	28103

Indexable Chamfer Cutter //

APPLICATION

For final edge chamfering
Manual feed MAN

WORKPIECE MATERIAL

Softwood and hardwood

OPERATING CONDITIONS

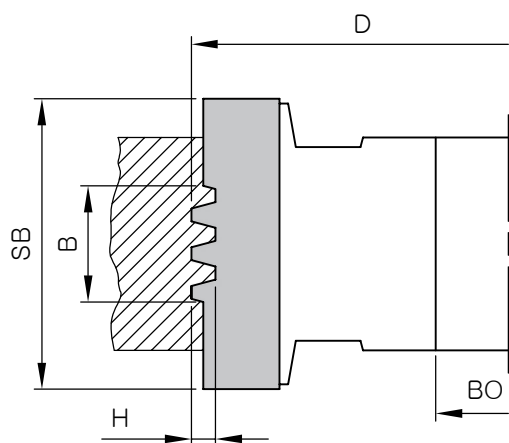
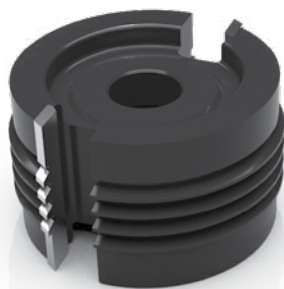
n: 6,000–12,000 RPM

TECHNICAL SPECIFICATIONS

HW indexable inserts

D mm	SB mm	BO mm	E °	Z	DIAGRAM I ID No.	DIAGRAM II ID No.
125	9.5	30/40	45	4	28301	28201

Spare parts	Application	ID No.
VBD 14×14×2	Hardwood	2101414200
VBD 14×14×2	Universal	2201414200
VBD 14×14×2	MDF	2301414200
SCREW M5×8.5 TX20		710064
TX20 KEY		710240



APPLICATION

Designed for edge-to-edge jointing of segments
Mechanical feed MEC

WORKPIECE MATERIAL

Softwood
Hardwood—HW version

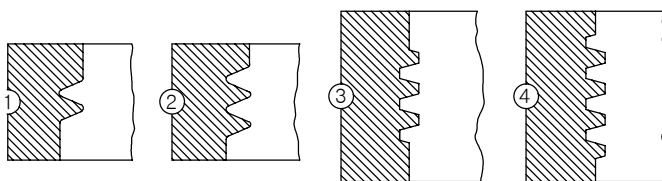
OPERATING CONDITIONS

n_{max} : 8,000 RPM (depending on type)

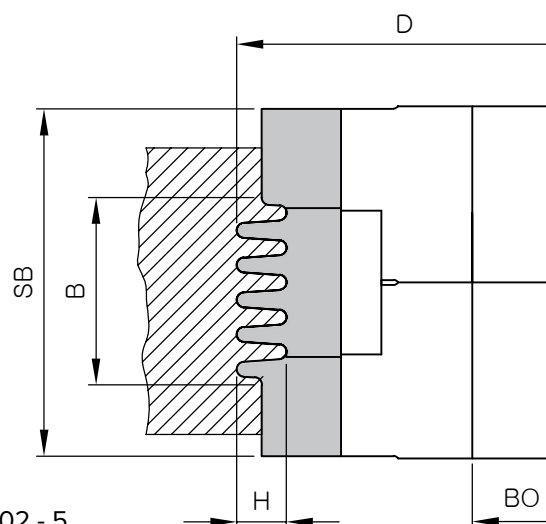
TECHNICAL SPECIFICATIONS

Steel cutter body
Brazed HW tips

D mm	SB mm	BO mm	B mm	H mm	Z	Pr. No.	ID No. HW
120	40	30	11.7	6	2	1	21101
120	40	30	19.5	6	2	2	21112
120	50	30	19.5	6	2	2	21122
120	60	30	24	5	2	3	21103
120	70	30	32	5	2	4	21104



\\ Glue Joint Cutter for Arched Segments



APPLICATION

Designed for transverse jointing of segments in arched window production
Mechanical feed MEC

WORKPIECE MATERIAL

Hardwood and softwood

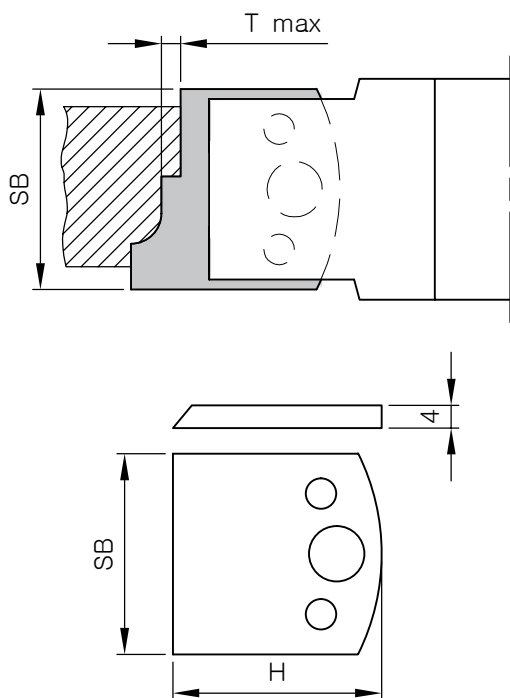
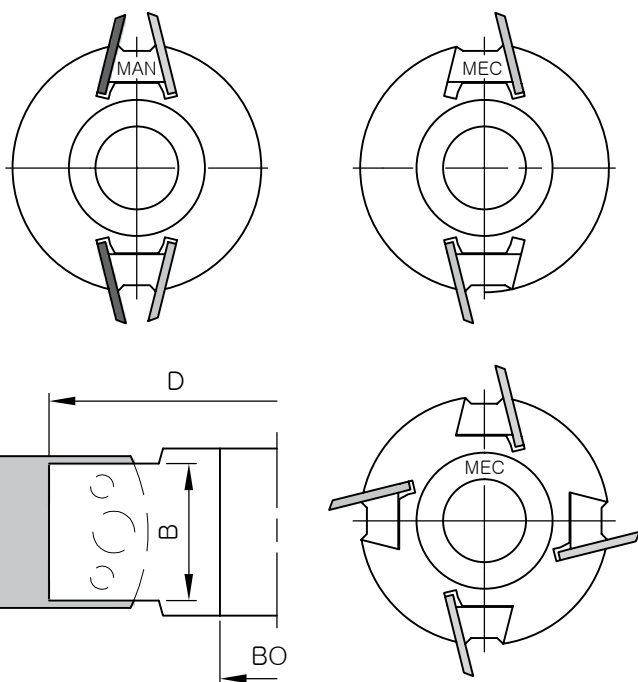
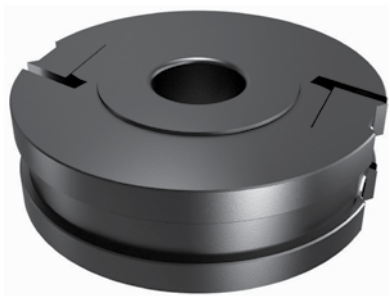
TECHNICAL SPECIFICATIONS

Adjustable cutter
Steel cutter body
HW indexable inserts

D mm	SB mm	BO mm	B mm	H mm	Z	ID No.
125	40–96	30	37.8–66	10	2	21106

SB mm	B mm	DK mm
40–68	37.8	-
55–82	51.8	14
70–96	66	2×14

Spare parts	Position	ID No.
VBD 50×28×2	1	21106.1
VBD 50×28×2	2	21106.2
Screw M8×1-20 ISK4		710045
ISK4 KEY		710204



APPLICATION

Profile milling
 Mechanical feed MEC, manual feed MAN
 For spindle moulders and multi-spindle moulders

WORKPIECE MATERIAL

HS version—softwood
 HW version—hardwood, MDF, chipboard

OPERATING CONDITIONS

n_{max} : 8,000 RPM (depending on type)

TECHNICAL SPECIFICATIONS

Steel cutter body
 Manual feed MAN—must be equipped with limiters
 Knife widths 40 mm and 50 mm
 Can be fitted with custom-ground profile knives

D mm	B mm	BO mm	Z	Version	ID No.
93	36	30	2	MAN	71100
93	36	30	2	MEC	71200
120	36	30	2	MAN	71120
120	36	30	2	MEC	71220
120	36	40	4	MEC	71300

Spare parts

	ID No.
CLAMPING WEDGE MAN	71100.K
CLAMPING WEDGE MEC	71200.K
SCREW M10×16 ISK5	DIN915
ISK5 KEY	710205

Custom Profile Grinding for Universal Cutterhead Knives //

APPLICATION

For universal cutterheads—profile milling
 Knives are custom-ground according to customer requirements

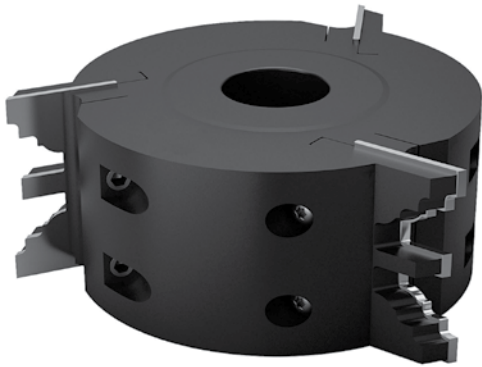
WORKPIECE MATERIAL

HS version—softwood
 HW version—hardwood, MDF, chipboard

TECHNICAL SPECIFICATIONS

Manual feed MAN—must be equipped with limiters

SB mm	H mm	T_{max} mm
40	48	18
50	50	20



APPLICATION

Mechanical feed MEC
For spindle moulders or multi-spindle moulders
For all types of profiles

WORKPIECE MATERIAL

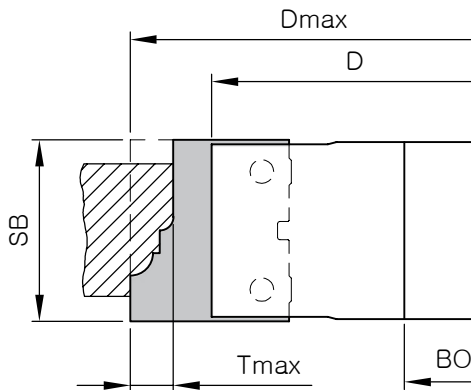
Solid wood, MDF

OPERATING CONDITIONS

n_{max} : 9,000–20,000 RPM (depending on type)

TECHNICAL SPECIFICATIONS

Steel cutter body
HW indexable inserts for universal use
Quick change of profile knives
Secure and precise positioned clamping

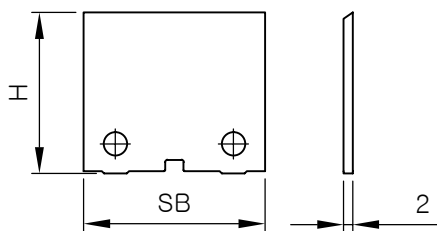


D mm	SB mm	BO mm	Z	ID No.
115	40	30/40	3	901040
115	60	30/40	3	901030

Spare parts

	ID No.
SCREW M10×1-20 ISK6	710046
SCREW M5×16 TX25	711053
TX25 KEY	710245
ISK6 KEY	710206

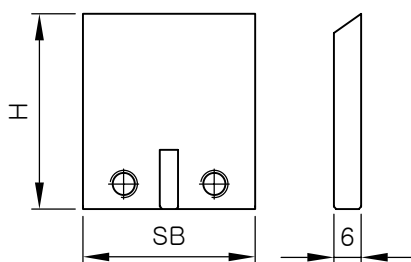
HW knife blank



HW knife blank

SB mm	H mm	T _{max} mm	D _{max} mm	ID No.
40	20.5	3.1	126	901026
40	25.5	8.1	135,5	901027
40	30.5	13.1	145	901028
40	35.5	18.1	155	901029
60	25.5	8.1	135,5	901037
60	35.5	18.1	155	901038

Backing plate blank



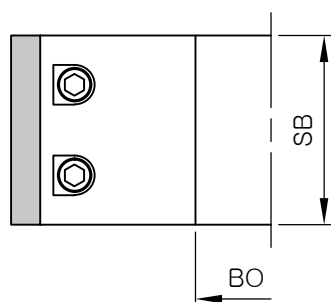
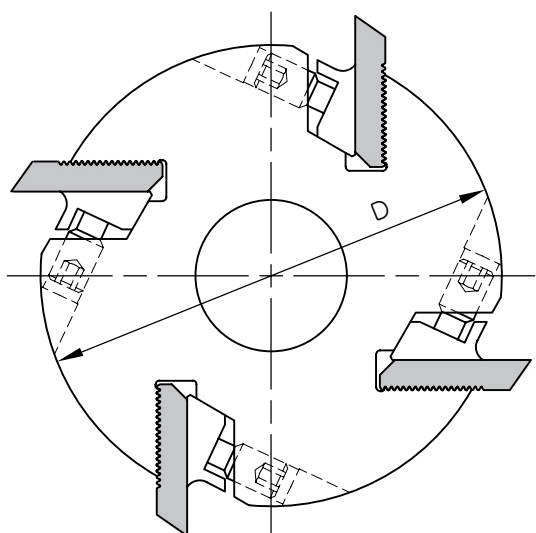
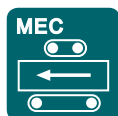
Backing plate blank

SB mm	H mm	ID No.
38	27.5	901022
38	32.5	901023
38	37.5	901024
38	42.5	901025
58	32.5	901034
58	42.5	901035



HW

HS



APPLICATION

For profiling
Mechanical feed MEC
For multi-spindle moulders

WORKPIECE MATERIAL

Hardwood and softwood, MDF

OPERATING CONDITIONS

n_{max} : 9,000 RPM (for D = 122 mm)
 n_{max} : 6,000 RPM (for D = 137 mm)

TECHNICAL SPECIFICATIONS

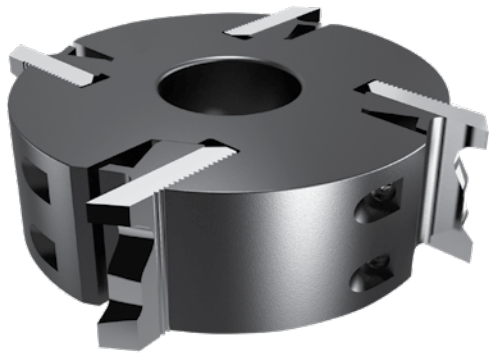
Steel cutter body
Long knife life thanks to HS 6% W material
Secure and precise knife clamping thanks to precision-ground grooves
High flexibility in knife production
Particularly suitable for prototyping and single-piece production

D mm	SB mm	BO mm	Z	ID No.
122	40	40	4	70240
137	40	50	4	70740
122	60	40	4	70260
137	60	50	4	70760
122	80	40	4	70280
137	80	50	4	70780
122	100	40	4	70210
137	100	50	4	70710
122	130	40	4	70213
137	130	50	4	70713
122	150	40	4	70215
137	150	50	4	70715
122	180	40	4	70218
137	180	50	4	70718
122	230	40	4	70223
137	230	50	4	70723

Spare parts

	ID No.
SCREW M10×1-20 ISK 5	710046
HEX KEY 5	710205

Custom Profile Grinding for HS Knives for Safety Cutterheads



APPLICATION

For profiling
 Mechanical feed MEC
 For multi-spindle moulders

WORKPIECE MATERIAL

Hardwood and softwood

OPERATING CONDITIONS

n_{max} : 9,000 RPM (for D = 122 mm)
 n_{max} : 6,000 RPM (for D = 137 mm)

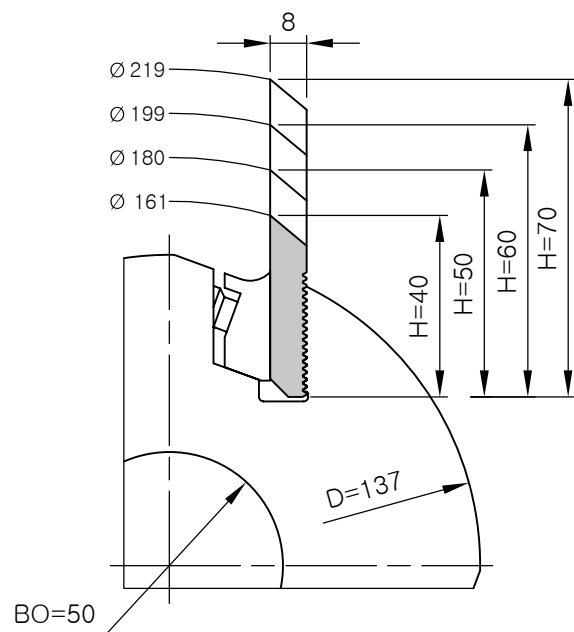
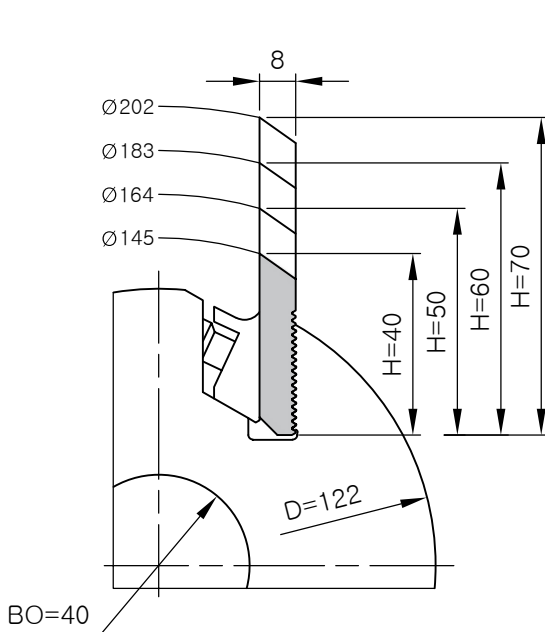
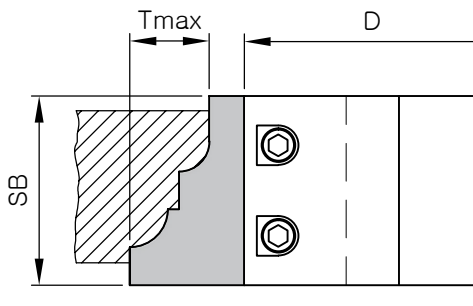
TECHNICAL SPECIFICATIONS

Steel cutter body
 Long knife life
 Secure and precise knife clamping thanks to precision-ground grooves
 High flexibility in knife production
 Particularly suitable for prototyping and single-piece production

Maximum ground profile depth Tmax depending on blank height H at maximum clamping.

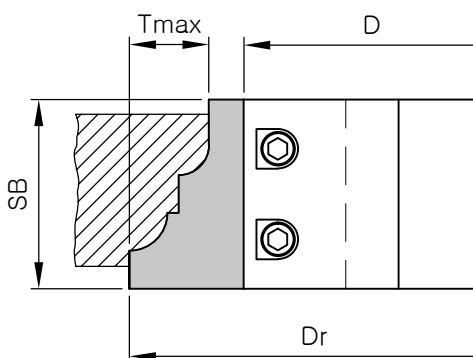
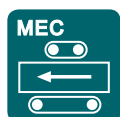
H mm	D mm	T _{max} mm
40	122	7
40	137	7
50	122	17
50	137	17
60	122	27
60	137	27
70	122	35
70	137	35

SB—depending on the safety cutterhead used (40–230 mm)
 Knife blanks for planing cutterheads on page 107.

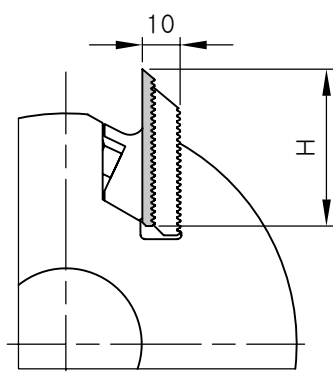


Cutting diameter diagram depending on blank height (H) and safety cutterhead diameter (D)

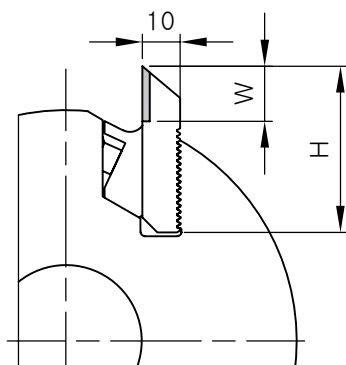
Maximum blank projection approx. 6.4 mm



UNI PACK System—HW Indexable Inserts



Brazed HW insert system



Custom Profile Grinding for HW Knives for Safety Cutterheads //

APPLICATION

For profiling
Mechanical feed MEC
For multi-spindle moulders

WORKPIECE MATERIAL

Hardwood and softwood, MDF

OPERATING CONDITIONS

n_{\max} : 9,000 RPM (for D = 122 mm)
 n_{\max} : 6,000 RPM (for D = 137 mm)

TECHNICAL SPECIFICATIONS

Steel cutter body
High clamping precision is achieved by positioning
in precision-ground micro-grooves
Multiple resharpening—high cost-effectiveness

Maximum profile depth Tmax depending on cutting diameter Dr and blank height H. UNI PACK

H mm	D mm	Dr mm	T _{max} mm
38	122	135	For planing only
38	137	150	For planing only
50	122	160	12
50	137	175	12
60	122	180	23
60	137	195	23

Cutting edge projection above the backing plate = 3.2 mm

Maximum profile depth Tmax depending on cutting diameter Dr and blank height H. HW PÁJENÝ

H mm	D mm	Dr mm	T _{max} mm	W mm
40	122	138	7	14
40	137	153	7	14
50	122	160	12	20
50	137	175	12	20
60	122	180	23	30
60	137	195	23	30

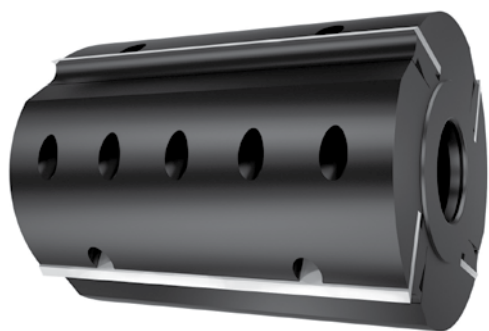
Cutting edge projection above the backing plate = 3.2 mm

SB—depending on the safety cutterhead used (40–230 mm)
Knife blanks for planing cutterheads on page 115.

Planing
Finger jointing
Chamfering



03



APPLICATION

For longitudinal planing—solid wood finishing
Mechanical feed MEC
For multi-spindle moulders

WORKPIECE MATERIAL

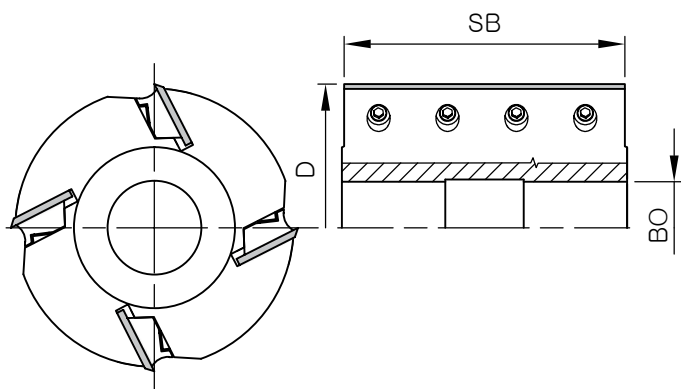
Hardwood and softwood

OPERATING CONDITIONS

n_{max} : 9,000 RPM (depending on type)

TECHNICAL SPECIFICATIONS

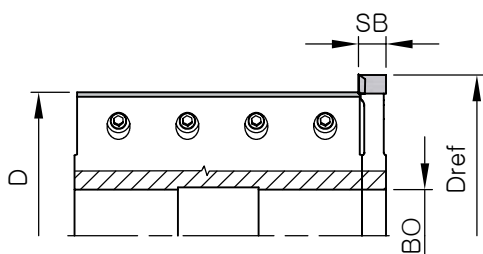
Cutter body made of steel (Fe) or high-strength aluminium alloy (Al)
Equipped as standard with SB×30×3 planing knives made of HS 18% W
HW planing knives available upon request



D mm	SB mm	BO mm	Z	ID No. Al	ID No. Fe
125	80	40	4	73080	72080
125	100	40	4	73100	72100
125	120	40	4	73120	72120
125	130	40	4	73130	72130
125	150	40	4	73150	72150
125	180	40	4	73180	72180
125	230	40	4	73230	72230
125	240	40	4	73240	72240

Spare parts	ID No.
SCREW M8×1-20 ISK4	710045
HEX KEY 4	710204

\\ Reference Cutter for Planing Cylinders HW Brazed / HW Indexable



APPLICATION

The reference cutter is used in combination with 730xx and 720xx planing cylinders
Mechanical feed MEC
Multi-spindle moulders

WORKPIECE MATERIAL

Hardwood and softwood

OPERATING CONDITIONS

n_{max} : 9,000 RPM

TECHNICAL SPECIFICATIONS

Steel cutter body (Fe)
Brazed HW inserts with a single-sided spur and a 0.5 mm lateral projection beyond the planing knife

BRAZED VERSION

Dref mm	D mm	BO mm	SB mm	Z	ID No.
140	125	40	12	4+2	72014
160	140	40	12	4+2	72016

INDEXABLE INSERT VERSION

Dref mm	D mm	BO mm	SB mm	Z	ID No.
145	125	40	14.2	3+3	72114
160	140	40	14.2	2+2	72116

QuickClamping Planing Cutterhead with Indexable Inserts //



APPLICATION

For longitudinal planing—solid wood finishing
Mechanical feed MEC
Multi-spindle moulders

WORKPIECE MATERIAL

Hardwood and softwood

OPERATING CONDITIONS

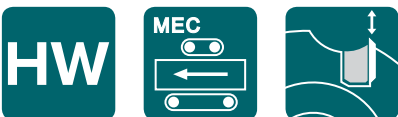
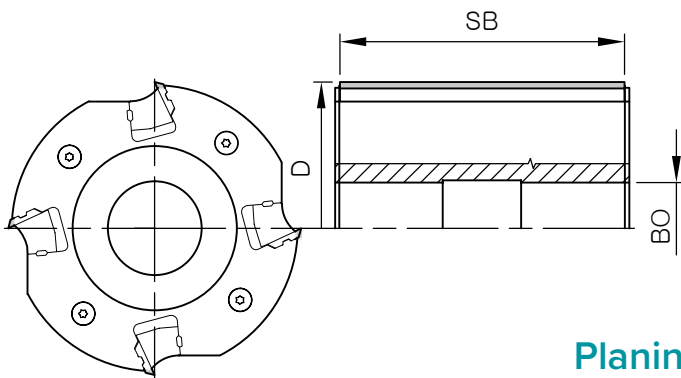
n_{max} : 10,500 RPM

TECHNICAL SPECIFICATIONS

Cutter body made of high-strength aluminium alloy (Al)
Centrolock system indexable inserts—self-centring, equipped as standard with HS indexable inserts (18% W), HW indexable planing knives available upon request
Max. recommended stock removal (a_e) 6 mm

D mm	SB mm	BO mm	Z	ID No.
125	80	40	4	73082
125	100	40	4	73102
125	130	40	4	73132
125	150	40	4	73152
125	180	40	4	73182
125	230	40	4	73232
125	240	40	4	73242

! For indexable insert order numbers, see Section 07—Knives



Planing Cutterhead with HW Indexable Inserts //

APPLICATION

For longitudinal planing and pre-planing of solid wood
Mechanical feed MEC
Multi-spindle moulders
Variable cutting height

WORKPIECE MATERIAL

Hardwood and softwood

OPERATING CONDITIONS

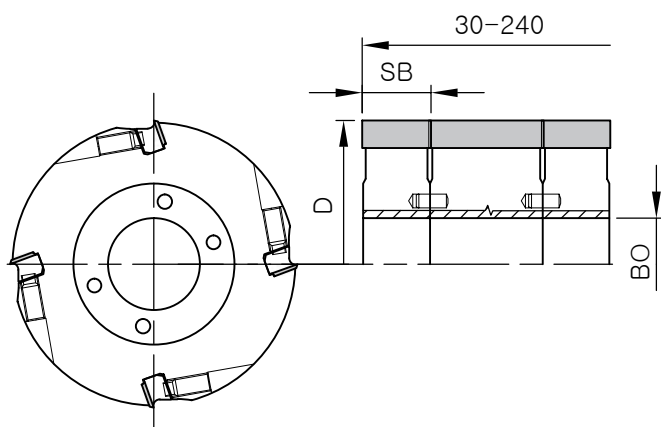
n_{max} : 12,000 RPM

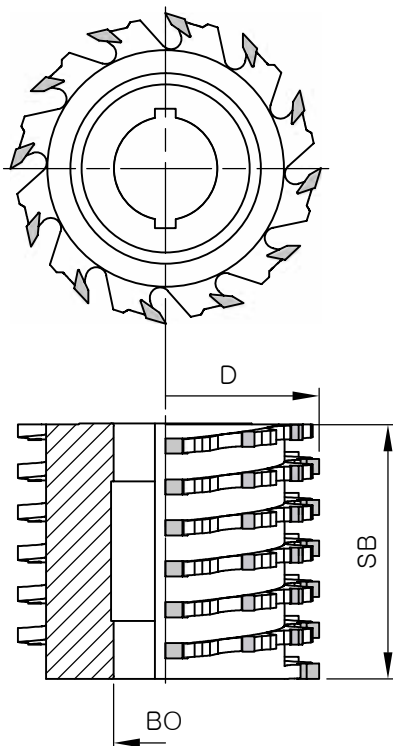
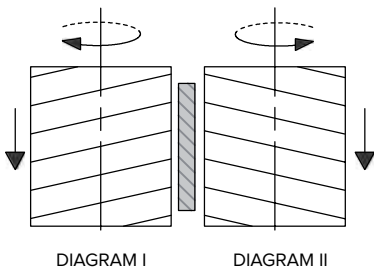
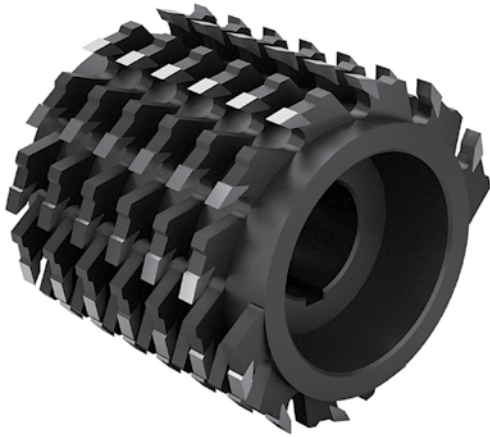
TECHNICAL SPECIFICATIONS

Steel cutter body; individual tools can be stacked for variable cutting heights; the tool is fitted with standard HW indexable inserts SB×12×1.5

D mm	SB mm	BO mm	Z	ID No. Fe
125	30	40	2	14230
125	50	40	2	14250
125	30	40	4	14430
125	50	40	4	14450

Spare parts	ID No.
VBD 30×12×1.5	1203012150
VBD 50×12×1.5	1205012150
SCREW M8×1-20 ISK4	710045
ISK4 KEY	710204





APPLICATION

For profile milling on copy shapers
Mechanical feed MEC

WORKPIECE MATERIAL

Hardwood and softwood

OPERATING CONDITIONS

- n_{max} : 9,000 RPM (D = 140 mm)
- n_{max} : 10,500 RPM (D = 125 mm)
- n_{max} : 11,000 RPM (D = 120 mm)
- n_{max} : 12,000 RPM (D = 110 mm)
- n_{max} : 13,000 RPM (D = 100 mm)
- n_{max} : 16,000 RPM (D = 80 mm)

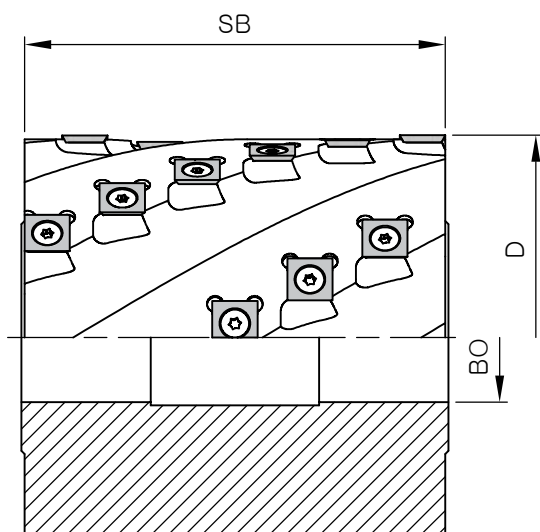
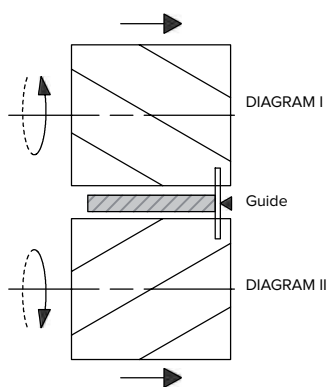
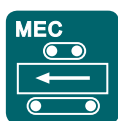
TECHNICAL SPECIFICATIONS

Steel cutter body, brazed HW inserts
Versions differ in tooth arrangement and the number of helices
12-2 = 12 rows of teeth, double helix
16-2 = 16 rows of teeth, double helix
16-1 = 16 rows of teeth, single helix
Modifications available for keyway, hub counter-bore, and rotation direction
Please specify modifications in your order

Order example for cutter D = 100, SB = 80, BO = 40, rows of teeth = 12, helices = 2, ID No. 72001:

Multi-Edge Spiral Cutterhead 100-80-40-12-2-72001, without keyway

D mm	SB mm	BO mm	Z	ID No.
80/100/110	60	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
80/100/110	80	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
80/100/110	100	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
80/100/110	120	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
80/100/110	130	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
80/100/110	140	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
80/100/110	150	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
80/100/110	160	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
80/100/110	170	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
80/100/110	180	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
120/125/140	60	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
120/125/140	80	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
120/125/140	100	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
120/125/140	120	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
120/125/140	130	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
120/125/140	140	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
120/125/140	150	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
120/125/140	160	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
120/125/140	170	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
120/125/140	180	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
120/125/140	200	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
120/125/140	220	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001
120/125/140	230	30/35/40	12-2/16-2/16-1	D-SB-BO-Z-72001



APPLICATION

For longitudinal planing—roughing of solid wood
 Mechanical feed MEC
 For multi-spindle moulders

WORKPIECE MATERIAL

Hardwood and softwood

OPERATING CONDITIONS

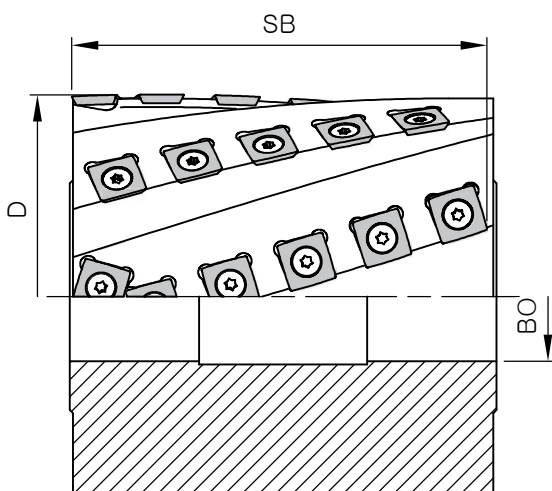
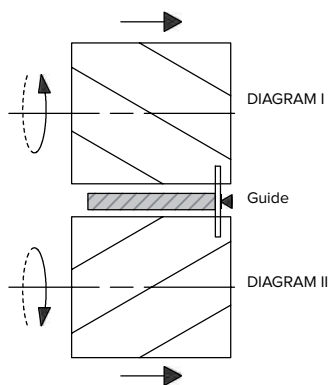
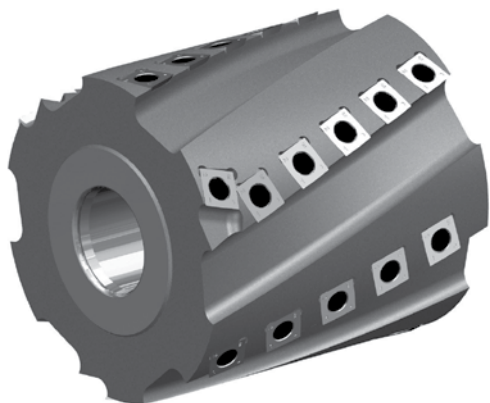
n_{max} : 6,000–10,000 RPM (depending on type)

TECHNICAL SPECIFICATIONS

Cutter body made of high-strength aluminium alloy
 4-edge HW indexable inserts
 Z3 = 6 spirals, Z4 = 8 spirals
 Progressive knife engagement ensures smooth operation and significantly reduces machine load
 Small chips facilitate chip extraction

D mm	SB mm	BO mm	Z	Number of inserts	ID No. Diagram I	ID No. Diagram II
125	100	40	3	27	85100	85101
125	130	40	3	33	85130	85131
125	150	40	3	39	85150	85151
125	180	40	3	45	85180	85181
125	230	40	3	57	85230	85231
125	240	40	3	63	85240	85241
140	100	40	4	36	87100	87101
140	130	40	4	44	87130	87131
140	150	40	4	52	87150	87151
140	180	40	4	60	87180	87182
140	230	40	4	76	87230	87231
140	240	40	4	84	87240	87241
140	310	50	4	112	87310	87311

Spare parts	Application	ID No.
VBD 14×14×2	Hardwood	2201414200
VBD 14×14×2	Softwood	2101414200
SCREW M5×10 TX20		710086
TX20 KEY		710240



APPLICATION

For longitudinal planing—solid wood finishing
 Mechanical feed MEC
 For multi-spindle moulders

WORKPIECE MATERIAL

Hardwood and softwood

OPERATING CONDITIONS

n_{max} : 6,000–10,000 RPM (depending on type)

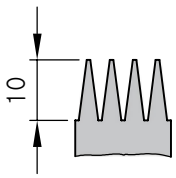
TECHNICAL SPECIFICATIONS

Cutter body made of high-strength aluminium alloy
 4-edge HW indexable inserts with R150 radius
 Z3 = 6 spirals, Z4 = 8 spirals
 Progressive engagement of knives arranged in a helix ensures smooth operation, significantly reduces machine load, and produces small chips for easier extraction

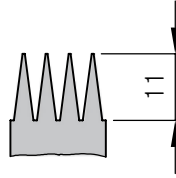
D mm	SB mm	BO mm	Z	Number of inserts	ID No. Diagram I	ID No. Diagram II
125	100	40	3	27	86100	86101
125	130	40	3	33	86130	86131
125	150	40	3	39	86150	86151
125	160	40	3	42	86160	86161
125	180	40	3	48	86180	86181
125	190	40	3	51	86190	86191
125	230	40	3	60	86230	86231
125	240	40	3	63	86240	86241
140	100	40	4	36	88100	88102
140	130	40	4	44	88130	88132
140	150	40	4	52	88150	88152
140	170	40	4	60	88170	88172
140	190	40	4	68	88190	88192
140	230	40	4	80	88230	88232
140	240	40	4	84	88240	88242

Spare parts

	ID No.
VBD 15×15×2.5 R150	2101515255
SCREW M5×10 TX20	710086
TX20 KEY	710240



FINGER JOINT PROFILE
Without a cross-cut saw
ZL 10/10



FINGER JOINT PROFILE
With a cross-cut saw
ZL 10/11

APPLICATION

These tools are designed for the end-jointing of wooden scantlings and beams for the production of:

- Window and door scantlings (10 mm finger length)
- Structural timber (KVH, BSH) (15–20 mm finger length)
- Reclaiming wood waste for furniture production

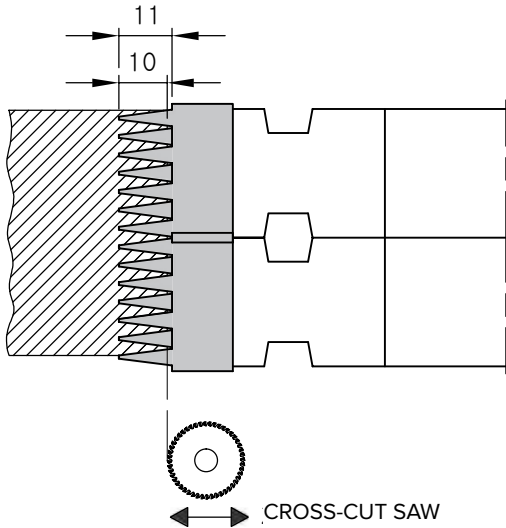
WORKPIECE MATERIAL

Hardwood and softwood

TECHNICAL SPECIFICATIONS

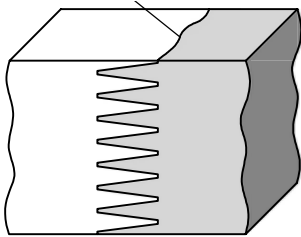
The tools are divided into two groups depending on the machine type:

- ZL 10/10, 15/15, and 20/20 tools are designed for machines without a cross-cut saw. In this setup, the entire finger profile is machined solely by the cutter, which determines the precision and tightness of the joint fit
- ZL 10/11, 15/16.5, and 20/22 tool sets are designed for machines equipped with a cross-cut saw. With these tools, the final joint tightness is fine-tuned by a leading cross-cut saw with a hogging unit



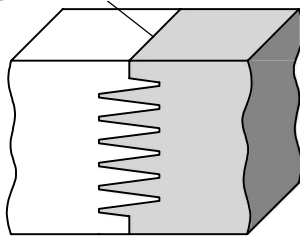
FINGER JOINT VARIATIONS

Non-defined joint—Uneven joint line

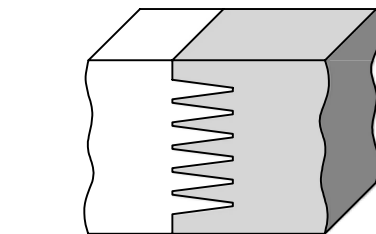


Continuous finger joint

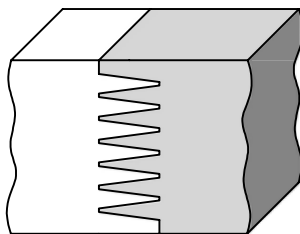
Defined joint—Straight, sharp joint line



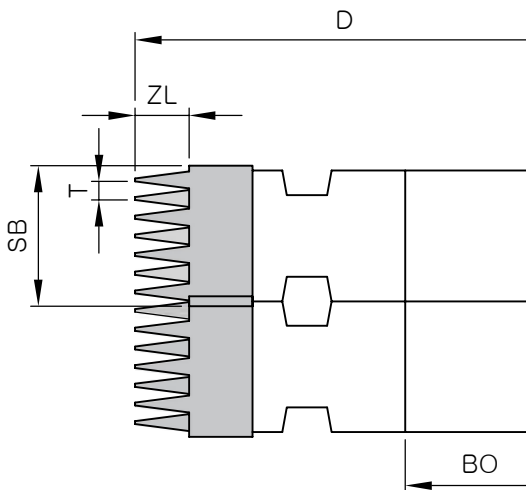
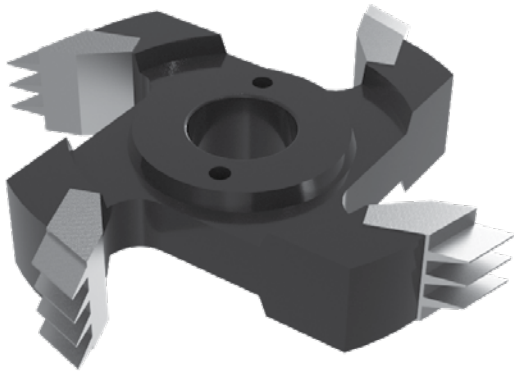
Finger joint with shoulders at half-length



Symmetrical finger joint with shoulders at the base



Asymmetrical finger joint with shoulders at the base



APPLICATION

These tools are designed for the end-jointing of wooden scantlings and beams for the production of:

- Window and door scantlings (10 mm finger length)
- Structural timber (KVH, BSH) (15–20 mm finger length)
- Reclaiming wood waste for furniture production

WORKPIECE MATERIAL

Hardwood and softwood

TECHNICAL SPECIFICATIONS

Brazed HS tips

Cutting edges can be coated with a wear-resistant coating

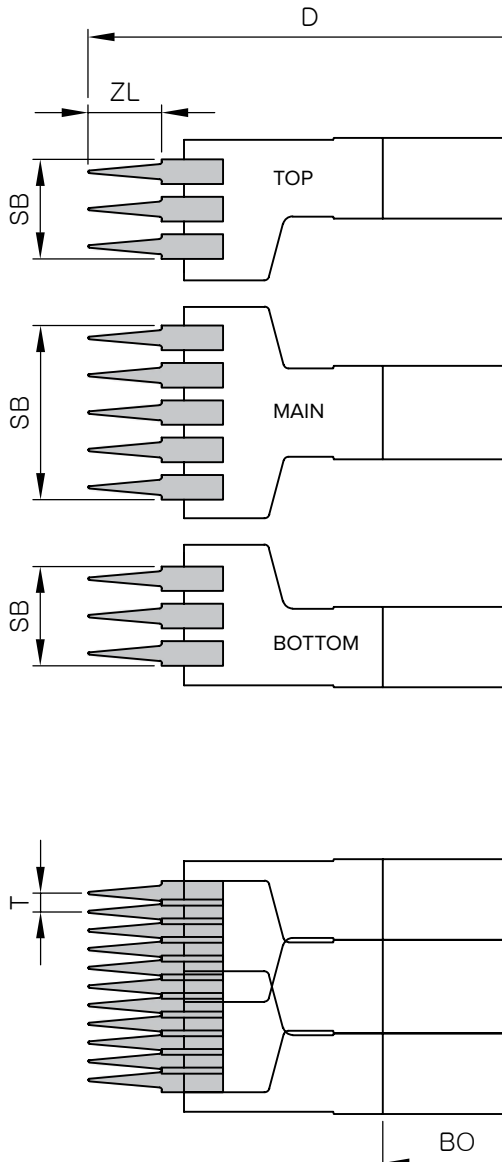
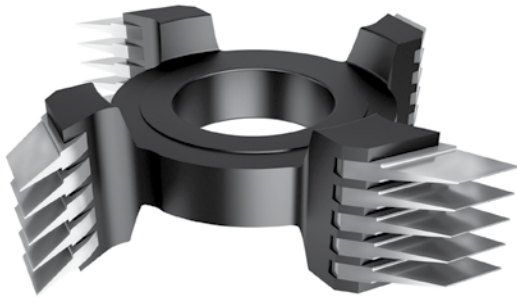
Can be supplied with shoulder cutters for the production of seating shoulders

D mm	ZL mm	T mm	SB mm	BO mm	Z	ID No.
160	10/10	3.8	28.6	30–50	2	021685
160	10/11	3.8	28.6	30–50	2	021686
170	15/15	3.8	28.6	30–50	2	021694
170	15/16.5	3.8	28.6	30–50	2	021695
180	20/20	6.2	33	30–50	2	021729
180	20/22	6.2	33	30–50	2	021728

Number of cutters required for a given joint width

SB 28.6 mm (10/10, 10/11, 15/15, 15/16.5)

Joint width	Number of cutters	Joint width	Number of cutters
24	1	157	6
51	2	184	7
77	3	210	8
104	4	237	9
131	5	264	10



APPLICATION

These tools are designed for the end-jointing of wooden scantlings and beams for the production of:

- Window and door scantlings (10 mm finger length)
- Structural timber (KVH, BSH) (15–20 mm finger length)
- Reclaiming wood waste for furniture production

WORKPIECE MATERIAL

Hardwood and softwood

TECHNICAL SPECIFICATIONS

Brazed HS tips

Cutting edges can be coated with a wear-resistant coating

Designed for higher feed rates or enhanced quality of the machined joint (finger profile)

Can be supplied with shoulder cutters for the production of seating shoulders

ZL 10. T3.8 mm

Tool type	D mm	SB mm	BO mm	Z	ID No. ZL 10/10	ID No. ZL 10/11
Top cutter	160	20.2	30–50	4	0216101	0216111
Main cutter	160	35.4	30–50	4	0216102	0216112
Bottom cutter	160	20.2	30–50	4	0216103	0216113

ZL 15. T3.8 mm

Tool type	D mm	SB mm	BO mm	Z	ID No. ZL 15/15	ID No. ZL 15/16.5
Top cutter	170	20.2	30–50	4	0216151	0216161
Main cutter	170	35.4	30–50	4	0216152	0216162
Bottom cutter	170	20.2	30–50	4	0216153	0216163

ZL 20. T6.2 mm

Tool type	D mm	SB mm	BO mm	Z	ID No. ZL 20/20	ID No. ZL 20/22
Top cutter	180	18.6	30–50	3	0216201	0216221
Main cutter	180	31	30–50	3	0216202	0216222
Bottom cutter	180	18.6	30–50	3	0216203	0216223

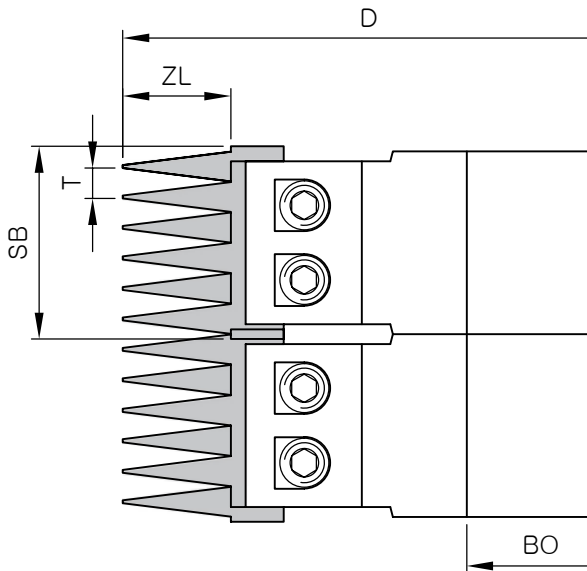
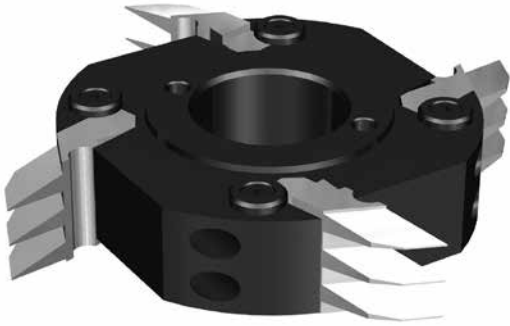
Number of cutters required for a given joint width ZL 10 a 15 mm;
T = 3.8 mm; Z4

Joint width	Main cutter	Top cutter	Bottom cutter
38	1	1	1
57	2	1	1
76	3	1	1
95	4	1	1
114	5	1	1
133	6	1	1
152	7	1	1
171	8	1	1
190	9	1	1
209	10	1	1
228	11	1	1
247	12	1	1
266	13	1	1

\\ Finger Joint Cutter with Replaceable HS Knives, Z2

03

Planing \ Finger jointing, Profiling



APPLICATION

These tools are designed for the end-jointing of wooden scantlings and beams for the production of:

- Window and door scantlings (10 mm finger length)
- Structural timber (KVH, BSH) (15–20 mm finger length)
- Reclaiming wood waste for furniture production

WORKPIECE MATERIAL

Hardwood and softwood

TECHNICAL SPECIFICATIONS

Replaceable HS knives

Cutting edges can be coated with a wear-resistant coating

Can be supplied with shoulder cutters for the production of seating shoulders

D mm	ZL mm	T mm	SB mm	BO mm	Z	ID No.
160	10/10	3.8	31.4	30–50	2	0218010
160	10/11	3.8	31.4	30–50	2	0218011
170	15/15	3.8	31.4	30–50	2	0218015
170	15/16.5	3.8	31.4	30–50	2	0218016
190	20/20	6.2	39.2	30–50	2	0218020
190	20/22	6.2	39.2	30–50	2	0218022

Individual knives

Profile knife	ZL mm	T mm	ID No.
Right	10/10	3.8	0218110
Left			0218210
Right	10/11	3.8	0218111
Left			0218211
Right	15/15	3.8	0218115
Left			0218215
Right	15/16.5	3.8	0218116
Left			0218216
Right	20/20	6.2	0218120
Left			0218220
Right	20/22	6.2	0218122
Left			0218222

Spare parts

	ID No.
SCREW M10×1-30 ISK 5	710091
HEX KEY 5	710205
SCREW M6×10 TX20	710066
TX20 KEY	710240

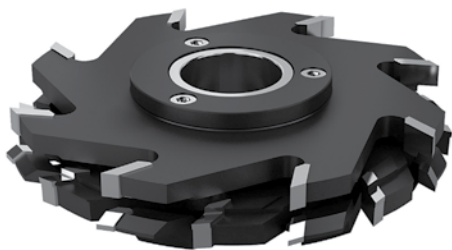
Number of cutters required for a given joint width

SB = 31.4 (10/10, 10/11, 15/15, 15/16,5) T = 3.8

Joint width mm	Number of cutters	Joint width mm	Number of cutters
28	1	180	6
58	2	210	7
89	3	241	8
119	4	271	9
150	5		

SB = 39.2 (20/20, 20/22) T = 6.2

Joint width mm	Number of cutters	Joint width mm	Number of cutters
34	1	183	5
71	2	220	6
108	3	257	7
145	4	294	8



APPLICATION

Designed for the production of tongue and groove joints along the grain
 For multi-spindle moulders
 Mechanical feed MEC

WORKPIECE MATERIAL

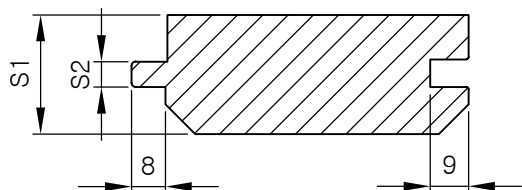
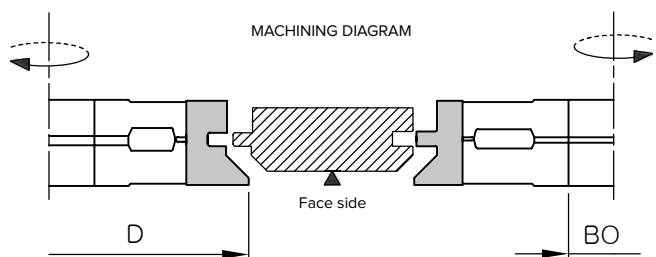
Hardwood and softwood

OPERATING CONDITIONS

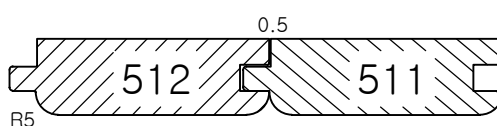
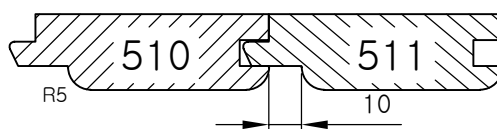
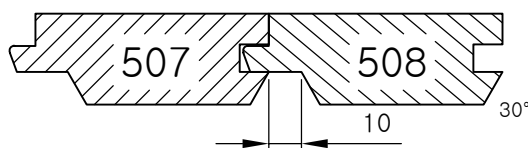
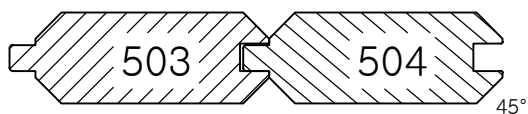
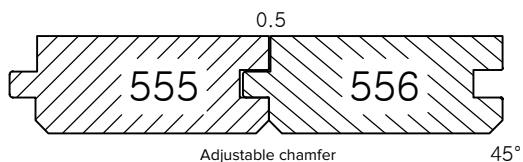
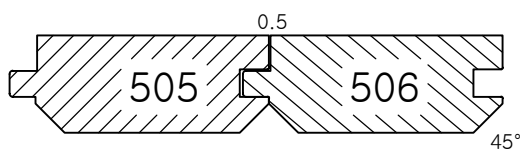
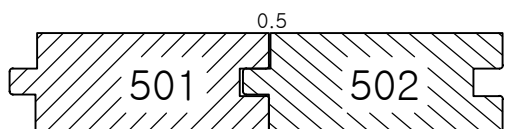
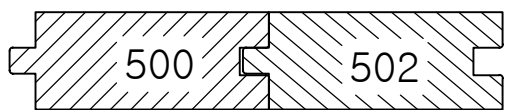
n_{max} : 8,000 RPM

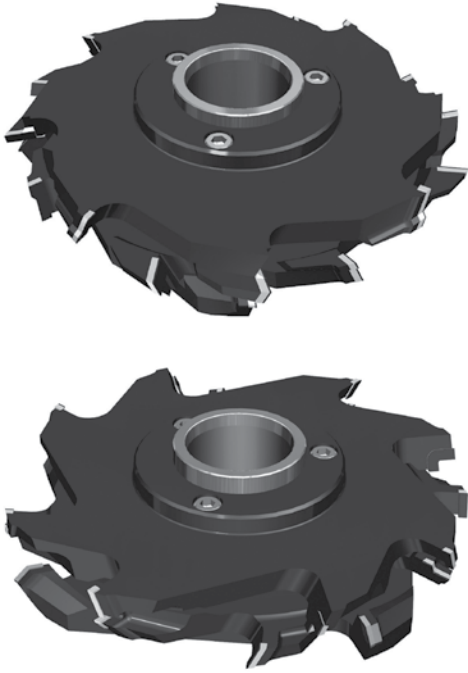
TECHNICAL SPECIFICATIONS

HS brazed tips
 HW brazed tips
 Cutters are secured by alignment pins
 Adjustable tools; can be reset to the original dimensions
 after re-sharpening using spacer rings



Profile	D mm	BO mm	S1 mm	S2 mm	Z/Vs	ID No. HS	ID No. HW
500-502	160	40/50	12-36	4-8	4	35006	35106
	180				6	35008	35108
501-502	160	40/50	12-36	4-8	4	35026	35126
	180				6	35028	35128
505-506	160	40/50	12-34	4-8	4	35056	35156
	180				6	35058	35158
555-556	160	40/50	12-36	4-8	4	35086	35186
	180				6	35088	35188
503-504	160	40/50	12-30	4-8	4	35036	35136
	180				6	35038	35138
507-508	160	40/50	14-32	6/8	4/2	35076	35176
	180				6/3	35078	35178
510-511	160	40/50	14-20	4-8	4/2	35016	35116
	180				6/3	35018	35118
512-511	160	40/50	14-20	4-8	4	35046	35146
	180				6	35048	35148





APPLICATION

Designed for the production of tongue and groove joints in both longitudinal and cross-grain directions
 For multi-spindle moulders
 Mechanical feed MEC

WORKPIECE MATERIAL

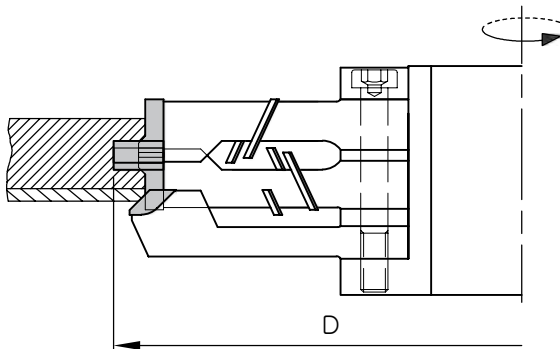
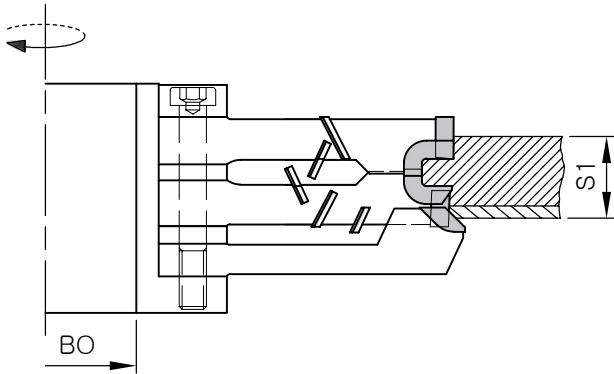
Multi-layer laminated solid wood
 MDF

TECHNICAL SPECIFICATIONS

Brazed DP tips
 H = 4 mm
 Tools are mounted on sleeves and securely locked
 The construction allows for multiple re-sharpening while maintaining the original joint profile
 Optimized cutting geometry ensures high-quality machining
 Precise adjustment is ensured via spacer rings
 Tools according to specific customer requirements

! Tool information is available upon request.

EXAMPLES OF TOOLS





TUNGSTEN CARBIDE (cutting edge material)



POLYCRYSTALLINE DIAMOND
(cutting edge material)



HIGH-SPEED STEEL
(cutting edge material)



STAGGERED CUTTING EDGES ON SPIRAL CUTTERS ©



HIGH SHEAR ANGLE CUTTING TIPS ©
(axial angle)



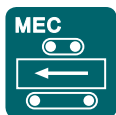
INDEXABLE INSERT WITH DP CUTTING TIP ©



CENTRIFUGAL CLAMPING SYSTEM
(Centrolock—planing knives)



MANUAL FEED



MECHANICAL FEED



INDEXABLE INSERT
(form-fit and force-fit clamping of the cutting insert)



BRAZED TIP
(fixed, permanent connection to the cutter body)



REBATING INDEXABLE INSERT WITH INTERNAL AND EXTERNAL
ROUNDING



VYDONA

VYDONA s.r.o.

Pravčice 244, 768 24 Pravčice

Czech Republic

+420 573 301 361 | info@vydona.cz

www.vydona.cz