

PRODUCT CATALOGUE



04 Shank Tools

Edition X

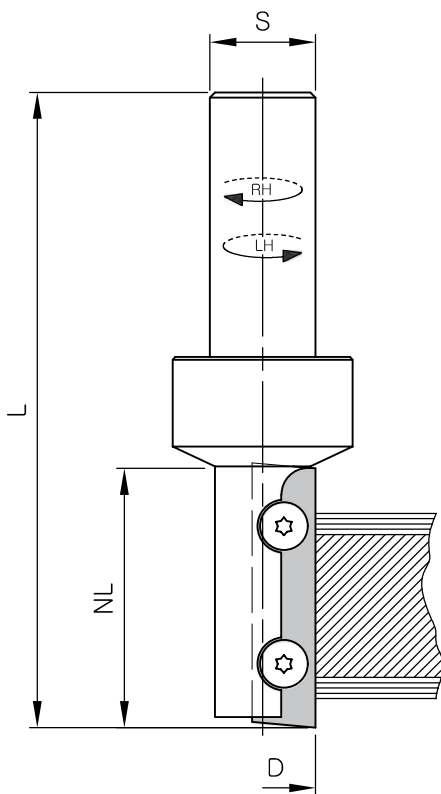
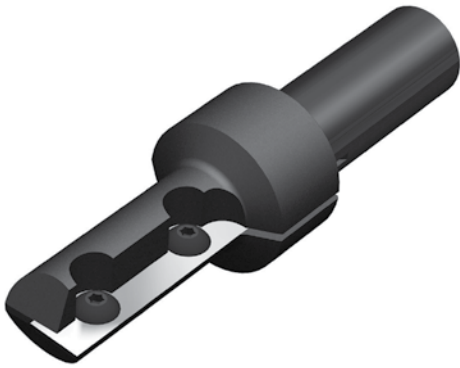
[2026]

Shank Tools



04

Peripheral Rebating Cutter with Indexable Inserts



APPLICATION

For peripheral rebating, grooving and chamfering
For CNC machining centres and machines for shank tools

WORKPIECE MATERIAL

Hardwood and softwood, HDF, MDF, chipboard, plastic

OPERATING CONDITIONS

n_{max} : 20,000–24,000 RPM
 v_f : 8–10 m/min

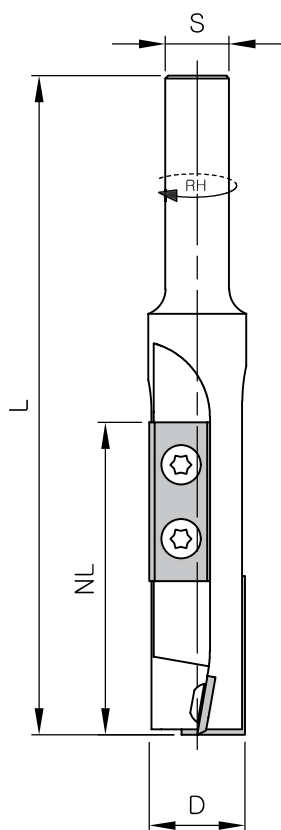
TECHNICAL SPECIFICATIONS

Straight cutting edge, constant tool diameter
HW indexable insert Z1
Tool equipped as standard with indexable insert for solid wood
Plunging capability

| D mm | NL mm | L mm | S mm | Direction of rotation | ID No. |
|------|-------|------|------|-----------------------|-----------|
| 16 | 28 | 105 | 20 | RH | 162810510 |
| | | | | LH | 162810511 |
| 16 | 48 | 120 | 20 | RH | 164812010 |
| | | | | LH | 164812011 |
| 20 | 28 | 105 | 20 | RH | 202810510 |
| | | | | LH | 202810511 |
| 20 | 49 | 120 | 20 | RH | 204912010 |
| | | | | LH | 204912011 |

| Spare parts \varnothing 16 | Application | Direction of rotation | ID No. |
|------------------------------|-------------|-----------------------|------------|
| VBD 29.5×9×1.5 | Universal | RH | 162810510P |
| | | LH | 162810511P |
| VBD 49.5×9×1.5 | Universal | RH | 164812010P |
| | | LH | 164812011P |
| SCREW M3.5×5 TX15 | | | |
| TX15 KEY | | | 710235 |

| Spare parts \varnothing 20 | Application | Direction of rotation | ID No. |
|------------------------------|------------------------------|-----------------------|------------|
| VBD 30×12×1.5 | Softwood and hardwood | RH | 0088140572 |
| | | LH | 0088140574 |
| VBD 30×12×1.5 | HDF, MDF, chipboard, plastic | RH | 0088140571 |
| | | LH | 0088140573 |
| VBD 50×12×1.5 | Softwood and hardwood | RH | 0088140562 |
| | | LH | 0088140564 |
| VBD 50×12×1.5 | HDF, MDF, chipboard, plastic | RH | 0088140561 |
| | | LH | 0088140563 |
| SCREW M4×6 TX15 | | | 710080 |
| TX15 KEY | | | 710235 |

**APPLICATION**

For peripheral milling and grooving
Mortising
For CNC machining centres, routers, and machines for shank tools

WORKPIECE MATERIAL

Hardwood and softwood, plywood, MDF, chipboard, plastic

OPERATING CONDITIONS

n_{max} : 16,000–20,000 RPM (depending on type)

TECHNICAL SPECIFICATIONS

Straight cutting edge, constant tool diameter
HW indexable inserts Z1 +1
Tool equipped as standard with indexable insert for solid wood

| D mm | NL mm | L mm | S mm | Direction of rotation | ID No. |
|------|-------|------|------|-----------------------|-----------|
| 16 | 29.5 | 100 | 20 | RH | 162910010 |
| 18 | 58 | 125 | 12 | RH | 185812510 |
| 18 | 58 | 130 | 25 | RH | 185813010 |
| 20 | 58 | 125 | 12 | RH | 205812510 |
| 20 | 58 | 130 | 25 | RH | 205813010 |

| Spare parts $\varnothing 16$ | Application | ID No. |
|------------------------------|-------------|-------------|
| VBD 29.5×12×1.5 | Universal | 02202912150 |
| VBD 7.5×12×1.5 | Universal | 1200712150 |
| SCREW M3.5×4 TX15 | | |
| SCREW M4×4 TX20 | | 710079 |
| TX15 KEY | | 710235 |

| Spare parts $\varnothing 18, \varnothing 20$ | Application | ID No. |
|---|-------------|----------------|
| Indexable inserts 30×12×1.5 for D = 18 D = 20 | Universal | 1203012150 |
| Indexable inserts 30×12×1.5 for D = 18 | Universal | 185813010.1.P2 |
| Indexable inserts 30×12×1.5 for D = 20 | Universal | 205812510.2P |
| Indexable inserts 9×11.3×1.5 for D = 18 | Universal | 185813010.1P1 |
| Indexable inserts 10×11.3×1.5 for D = 20 | Universal | 205812510.1P |
| SCREW M4×5 TX20 | | 710047 |
| TX20 KEY | | 710240 |



APPLICATION

Peripheral rounding and chamfering
Designed for CNC machining centres

WORKPIECE MATERIAL

Hardwood and softwood, MDF, plastic

OPERATING CONDITIONS

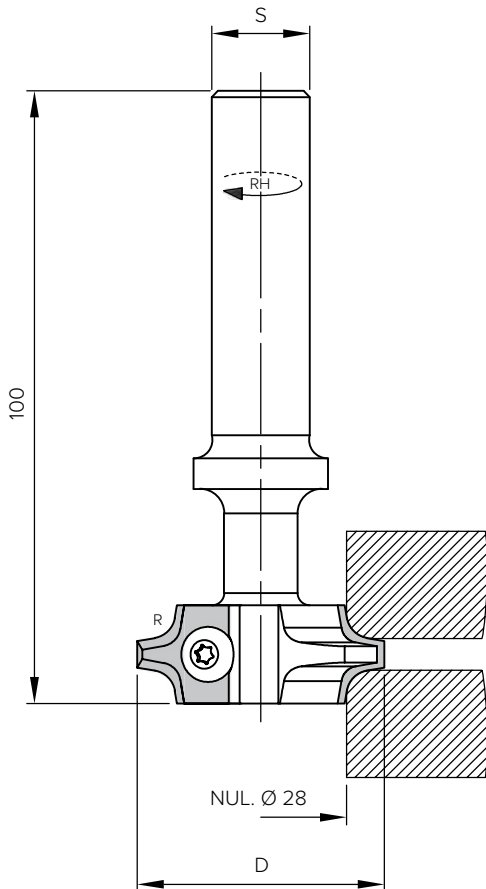
n_{max} : 20,000 RPM

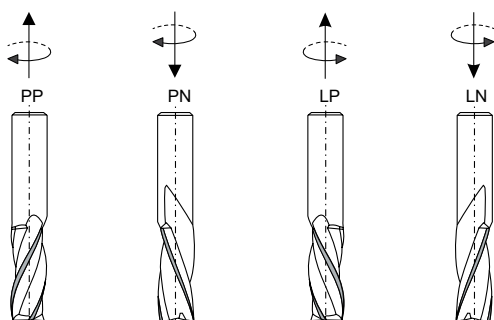
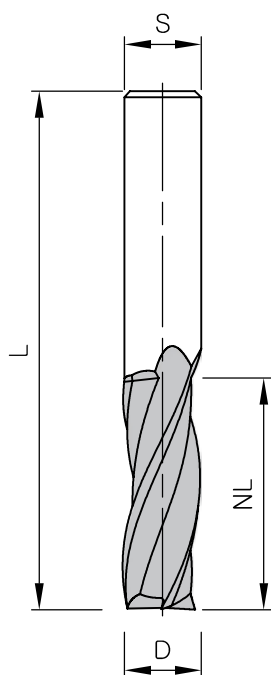
TECHNICAL SPECIFICATIONS

HW indexable inserts R2/R3/R4/R5/45°
Tangential radius run-out
Option of double-sided rounding

| D mm | S mm | Z | R/V | ID No. |
|------|------|---|-------------|-----------|
| 40.4 | 16 | 2 | 2/3/4/5/45° | 004040201 |

| Spare parts | R/V | ID No. |
|-----------------|-----|-------------|
| VBD 16×17.5×2 | 2 | 016510 |
| VBD 16×17.5×2 | 3 | 016511 |
| VBD 16×17.5×2 | 4 | 016512 |
| VBD 16×17.5×2 | 5 | 016513 |
| VBD 16×17.5×2 | 45° | 004040201.P |
| SCREW M4×9 TX15 | | 710081 |
| TX15 KEY | | 710235 |





APPLICATION

For peripheral milling and grooving with a high-quality surface finish
For CNC machining centres and routers

WORKPIECE MATERIAL

Hardwood, MDF, chipboard, laminate

OPERATING CONDITIONS

n_{max} : 30,000 RPM
 v_f : up to 10 m/min for Z2
 v_f : more than 10 m/min for Z3

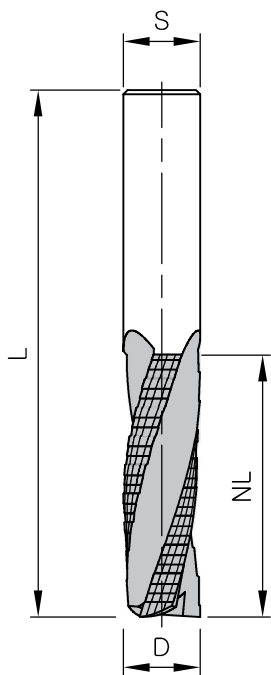
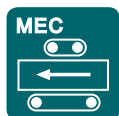
TECHNICAL SPECIFICATIONS

Solid HW cutter
Positive or negative spiral variants

- PP – right-hand positive helix, excellent cut quality on the bottom side, upward chip removal
- PN – right-hand negative helix, excellent cut quality on the top side, downward chip removal, cutting force directed towards the table
- LP – left-hand positive helix, excellent cut quality on the bottom side, upward chip removal
- LN – left-hand negative helix, excellent cut quality on the top side, downward chip removal, cutting force directed towards the table, optional coating for cutting edges

| D mm | NL mm | L mm | S | Z | Spiral design | ID No. |
|------|-------|------|----|---|---------------|--------|
| 4 | 15 | 50 | 4 | 2 | PP | 201042 |
| 4 | 15 | 60 | 4 | 2 | PN | 202042 |
| 5 | 17 | 50 | 5 | 2 | PP | 201052 |
| 5 | 17 | 60 | 5 | 2 | PN | 202052 |
| 6 | 22 | 60 | 6 | 2 | PP | 201062 |
| 6 | 22 | 70 | 6 | 2 | PN | 202062 |
| 8 | 32 | 80 | 8 | 2 | PP | 201082 |
| 8 | 32 | 90 | 8 | 2 | PN | 202082 |
| 10 | 32 | 80 | 10 | 2 | PP | 201102 |
| 10 | 32 | 90 | 10 | 2 | PN | 202102 |
| 8 | 32 | 80 | 8 | 3 | PP | 201083 |
| 8 | 32 | 90 | 8 | 3 | PN | 202083 |
| 10 | 32 | 80 | 10 | 3 | PP | 201103 |
| 10 | 32 | 90 | 10 | 3 | PN | 202103 |
| 10 | 52 | 100 | 10 | 3 | PP | 231103 |
| 10 | 52 | 110 | 10 | 3 | PN | 232103 |
| 12 | 52 | 100 | 12 | 3 | PP | 201123 |
| 12 | 52 | 110 | 12 | 3 | PN | 202123 |
| 14 | 52 | 100 | 14 | 3 | PP | 201143 |
| 14 | 52 | 110 | 14 | 3 | PN | 202143 |
| 16 | 52 | 100 | 16 | 3 | PP | 201163 |
| 16 | 52 | 110 | 16 | 3 | PN | 202163 |
| 18 | 52 | 100 | 18 | 3 | PP | 201183 |
| 18 | 52 | 115 | 18 | 3 | PN | 202183 |
| 20 | 52 | 100 | 20 | 3 | PP | 201203 |
| 20 | 52 | 110 | 20 | 3 | PN | 202203 |
| 20 | 72 | 120 | 20 | 3 | PP | 201200 |
| 20 | 72 | 135 | 20 | 3 | PN | 202200 |
| 25 | 72 | 130 | 25 | 3 | PP | 201253 |
| 25 | 72 | 150 | 25 | 3 | PN | 202253 |

\\ RAPTOR Spiral Cutter with Staggered Cutting Edge



APPLICATION

For peripheral milling and grooving with a high-quality surface finish
 For CNC machining centres and routers
 High-speed machining

WORKPIECE MATERIAL

Hardwood and softwood, plywood, MDF, multi-layer laminated wood

OPERATING CONDITIONS

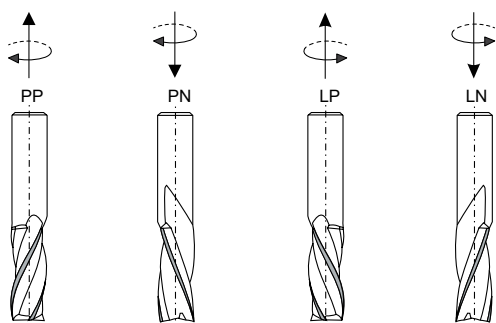
n_{max} : 24,000–30,000 RPM

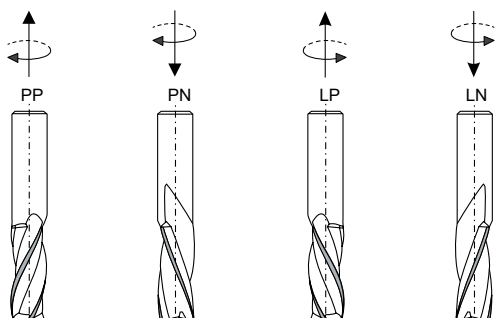
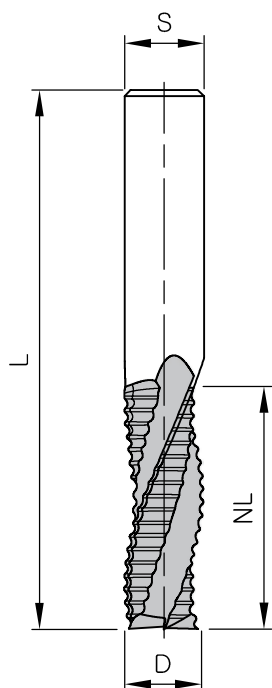
TECHNICAL SPECIFICATIONS

Solid HW cutter Z3
 Cutting edges with chipbreaker for high-speed machining
 Positive or negative spiral variants

- PP – right-hand positive helix, excellent cut quality on the bottom side, upward chip removal
- PN – right-hand negative helix, excellent cut quality on the top side, downward chip removal, cutting force directed towards the table
- LP – left-hand positive helix, excellent cut quality on the bottom side, upward chip removal
- LN – left-hand negative helix, excellent cut quality on the top side, downward chip removal, cutting force directed towards the table, optional coating for cutting edges

| D mm | NL mm | L mm | S mm | Z | Spiral design | ID No. |
|------|-------|------|------|---|---------------|-----------|
| 6 | 20 | 60 | 8 | 3 | PP | 062006030 |
| 6 | 20 | 65 | 8 | 3 | PN | 062006531 |
| 8 | 25 | 70 | 8 | 3 | PP | 082507030 |
| 8 | 25 | 75 | 8 | 3 | PN | 082507531 |
| 10 | 32 | 80 | 10 | 3 | PP | 103208030 |
| 10 | 32 | 90 | 10 | 3 | PN | 103209031 |
| 12 | 45 | 95 | 12 | 3 | PP | 124509530 |
| 12 | 45 | 100 | 12 | 3 | PN | 124510031 |
| 16 | 55 | 110 | 16 | 3 | PP | 165511030 |
| 16 | 55 | 120 | 16 | 3 | PN | 165511031 |
| 20 | 72 | 120 | 20 | 3 | PP | 207212030 |
| 20 | 72 | 135 | 20 | 3 | PN | 207213531 |





APPLICATION

For peripheral milling and grooving
For CNC machining centres and routers

WORKPIECE MATERIAL

Hardwood, MDF, chipboard, laminate

OPERATING CONDITIONS

n_{max} : 30,000 RPM
 v_f : up to 10 m/min for Z2
 v_f : more than 10 m/min for Z3

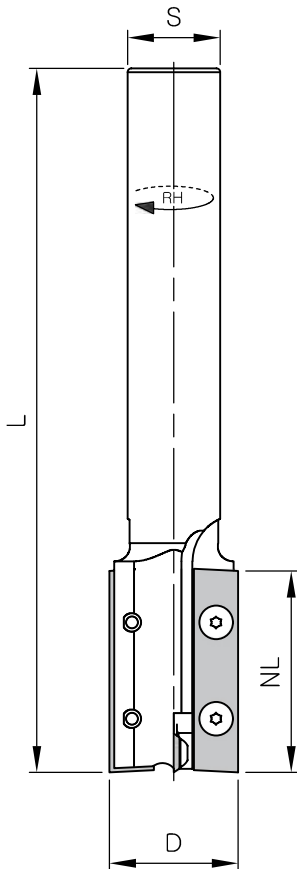
TECHNICAL SPECIFICATIONS

Solid HW cutter with staggered cutting edge
Positive or negative spiral variants

- PP – right-hand positive helix, excellent cut quality on the bottom side, upward chip removal
- PN – right-hand negative helix, excellent cut quality on the top side, downward chip removal, cutting force directed towards the table
- LP – left-hand positive helix, excellent cut quality on the bottom side, upward chip removal
- LN – left-hand negative helix, excellent cut quality on the top side, downward chip removal, cutting force directed towards the table, optional coating for cutting edges

| D mm | NL mm | L mm | S | Z | Spiral design | ID No. |
|------|-------|------|----|---|---------------|--------|
| 4 | 15 | 35 | 4 | 2 | PP | 101042 |
| 4 | 15 | 35 | 4 | 2 | PN | 102042 |
| 6 | 20 | 60 | 6 | 3 | PP | 101063 |
| 6 | 20 | 70 | 6 | 3 | PN | 102063 |
| 8 | 32 | 80 | 8 | 3 | PP | 101083 |
| 8 | 32 | 90 | 8 | 3 | PN | 102083 |
| 10 | 52 | 100 | 10 | 3 | PP | 101103 |
| 10 | 52 | 110 | 10 | 3 | PN | 102103 |
| 12 | 52 | 100 | 12 | 3 | PP | 101123 |
| 12 | 52 | 110 | 12 | 3 | PN | 102123 |
| 14 | 52 | 100 | 14 | 3 | PP | 101143 |
| 14 | 52 | 110 | 14 | 3 | PN | 102143 |
| 16 | 52 | 100 | 16 | 3 | PP | 101163 |
| 16 | 52 | 110 | 16 | 3 | PN | 102163 |
| 18 | 52 | 100 | 18 | 3 | PP | 101183 |
| 18 | 52 | 110 | 18 | 3 | PN | 102183 |
| 20 | 52 | 100 | 20 | 3 | PP | 101203 |
| 20 | 52 | 115 | 20 | 3 | PN | 102203 |
| 20 | 72 | 120 | 20 | 3 | PP | 101200 |
| 20 | 72 | 135 | 20 | 3 | PN | 102200 |
| 25 | 72 | 130 | 25 | 3 | PP | 101253 |
| 25 | 72 | 150 | 25 | 3 | PN | 102253 |

\\ Straight Modelling Cutter with Indexable Inserts



APPLICATION

Milling of foundry patterns
For CNC machining centres

WORKPIECE MATERIAL

Suitable for modelling wood, MDF, and multi-layer laminated wood

OPERATING CONDITIONS

n_{max} : 12,000–18,000 RPM (depending on type)

TECHNICAL SPECIFICATIONS

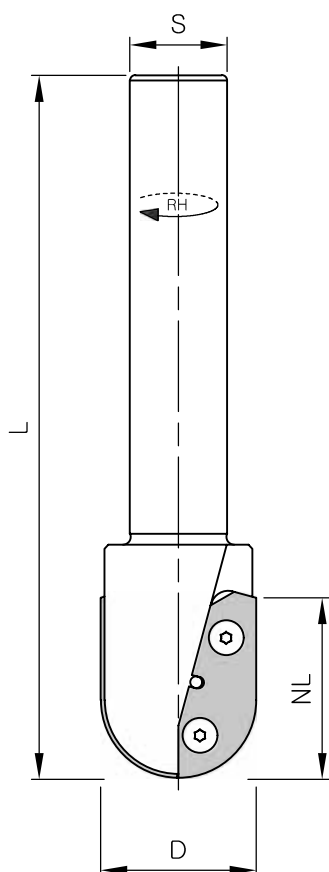
HW indexable inserts Z2 +1
Constant cutting diameter
Extra-long version

Cutting tool

| D mm | NL mm | L mm | S mm | n RPM | ID No. |
|------|-------|------|------|---------------|-----------|
| 26 | 28.7 | 220 | 25 | 12,000–18,000 | 139014030 |
| 35 | 54.3 | 220 | 25 | 12,000–16,000 | 054213002 |

| Spare parts | Application | ID No. |
|-------------------|-------------|-------------|
| VBD 29.2×9×1.5 | for D = 26 | 139014030.P |
| VBD 10.5×10.5×1.5 | for D = 26 | 2201010150 |
| VBD 55×12×1.5 | for D = 35 | 054213002.P |
| VBD 12×12×1.5 | for D = 35 | 2201212150 |
| SCREW M4×5 TX20 | | 710047 |
| SCREW M4×6 TX15 | | 710080 |
| TX15 KEY | | 710235 |
| TX20 KEY | | 710240 |

Ball-Nose Modelling Cutter with Indexable Inserts //



APPLICATION

For milling deep contours in model making
For CNC machining centres

WORKPIECE MATERIAL

Suitable for modelling wood, MDF, and multi-layer laminated wood

OPERATING CONDITIONS

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

TECHNICAL SPECIFICATIONS

HW indexable insert cutter, Z2
Constant cutting diameter
Extra-long version

Cutting tool

| R mm | D mm | NL mm | L mm | S mm | n RPM | ID No. |
|------|------|-------|------|------|---------------|-----------|
| 10 | 20 | 40 | 200 | 25 | 15,000–18,000 | 259615001 |
| 20 | 40 | 46 | 160 | 25 | 16,000–20,000 | 174310001 |
| 30 | 60 | 60 | 220 | 25 | 9,000–14,000 | 054214004 |

for R10

| Spare parts | ID No. |
|-------------------|-------------|
| VBD 40.5×10.2×1.5 | 259615001.1 |
| VBD 40.5×9×1.5 | 259615001.2 |
| SCREW M3.5×5 TX15 | 710118 |
| TX15 KEY | 710235 |

for R20

| Spare parts | ID No. |
|-----------------|-------------|
| VBD 49.4×18×2 | 174310001.1 |
| VBD 49.3×18×2 | 174310001.2 |
| SCREW M4×6 TX15 | 710080 |
| TX15 KEY | 710235 |

for R30

| Spare parts | ID No. |
|-----------------|-------------|
| VBD 67.6×23.8×2 | 054214004.1 |
| VBD 67×23.8×2 | 054214004.2 |
| SCREW M5×8 TX25 | 711049 |
| TX25 KEY | 710245 |



APPLICATION

For milling deep contours in model making with high-quality surface finishing
For CNC machining centres

WORKPIECE MATERIAL

Suitable for modelling wood, MDF, and multi-layer laminated wood

OPERATING CONDITIONS

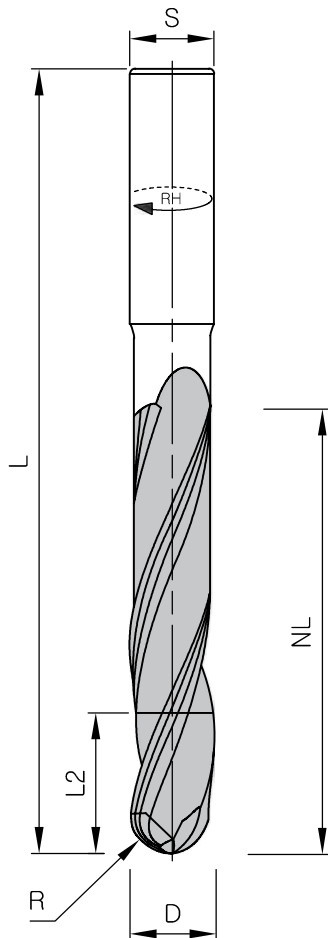
n_{max} : 18,000–24,000 RPM

TECHNICAL SPECIFICATIONS

Solid HW spiral cutter Z2
The cutting diameter decreases after re-sharpening
Long version

Cutting tool

| R mm | D mm | L2 mm | NL mm | L mm | S mm | ID No. |
|------|------|-------|-------|------|------|--------|
| 3 | 6 | 9 | 35 | 70 | 6 | 205010 |
| 4 | 8 | 12 | 42 | 82 | 8 | 205020 |
| 5 | 10 | 15 | 55 | 95 | 10 | 205030 |
| 6 | 12 | 18 | 90 | 130 | 12 | 205040 |
| 8 | 16 | 24 | 100 | 154 | 16 | 205050 |
| 10 | 20 | 30 | 125 | 180 | 20 | 205060 |
| 12.5 | 25 | 38 | 160 | 222 | 25 | 205070 |





APPLICATION

For milling deep contours in model making
For 5-axis CNC machining centres
High-productivity milling

WORKPIECE MATERIAL

Suitable for modelling wood, MDF, and multi-layer laminated wood

OPERATING CONDITIONS

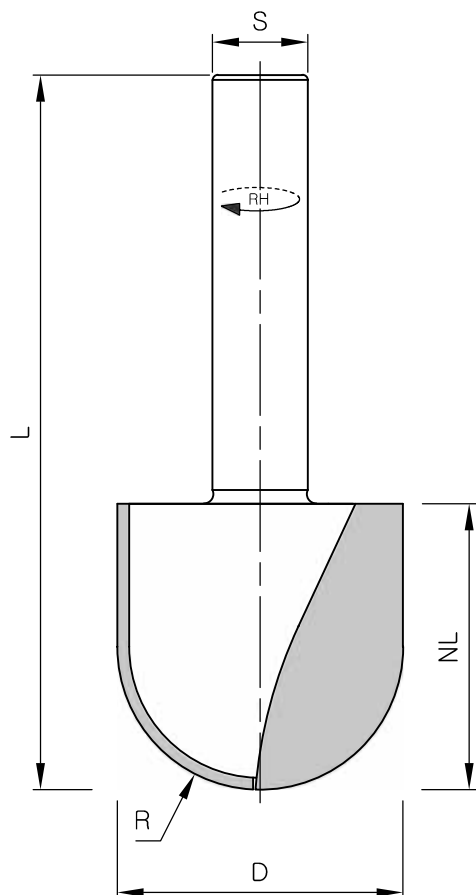
n_{max} : 12,000–20,000 RPM (depending on type)

TECHNICAL SPECIFICATIONS

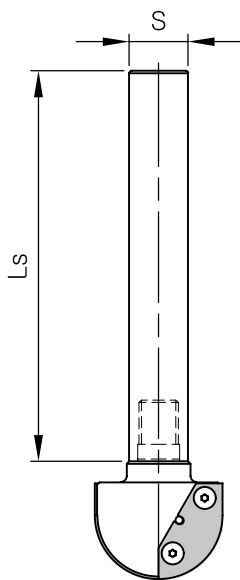
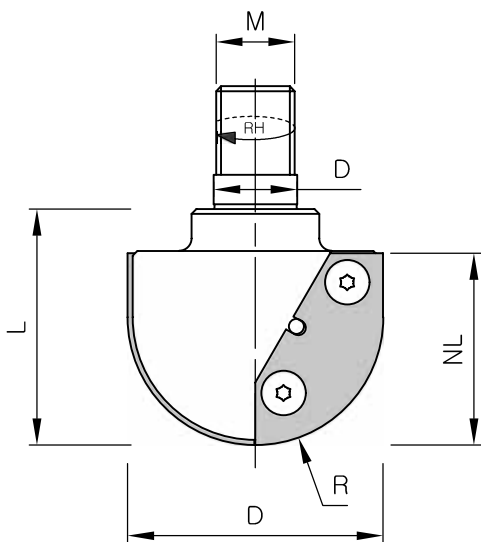
HW brazed cutter, Z2
The cutting diameter decreases after re-sharpening

Cutting tool

| R mm | D mm | NL mm | L mm | S mm | n RPM | ID No. |
|------|------|-------|------|------|--------|-----------|
| 20 | 40 | 60 | 160 | 25 | 20,000 | 139006006 |
| 30 | 60 | 60 | 150 | 20 | 16,000 | 139007013 |
| 40 | 80 | 60 | 140 | 25 | 12,000 | 139006005 |



\\ Ball-Nose Modelling Cutter with External Mounting Thread



APPLICATION

For milling deep contours in model making
For CNC machining centres

WORKPIECE MATERIAL

Suitable for modelling wood, MDF, and multi-layer laminated wood

OPERATING CONDITIONS

n_{max} : 18,000 RPM

TECHNICAL SPECIFICATIONS

HW indexable insert Z2
Constant cutting diameter
Modular system with cylindrical holder

Cutting tool

| R mm | D mm | NL mm | L mm | M | D1 mm | ID No. |
|------|------|-------|------|----|-------|-----------|
| 15 | 30 | 30 | 40 | 10 | 10.5 | 107809004 |
| 26 | 52 | 39 | 50 | 16 | 17 | 107808002 |

Milling arbor

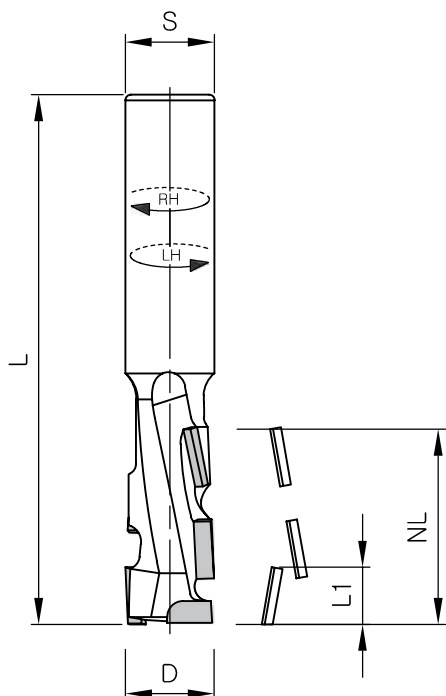
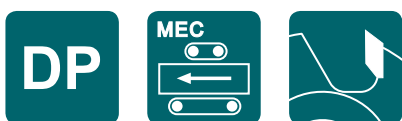
| S mm | Ls mm | M | D1 mm | Material | ID No. |
|------|-------|----|-------|----------|--------|
| 20 | 100 | 10 | 10.5 | Steel | 900400 |
| 20 | 150 | 10 | 10.5 | Densimet | 900401 |
| 25 | 100 | 16 | 17 | Steel | 900410 |
| 25 | 150 | 16 | 17 | Densimet | 900411 |

for R15—107809004

| Spare parts | ID No. |
|------------------|-------------|
| VBD 16×30×2-P1 | 107809004.1 |
| VBD 13.4×30×2-P2 | 107809004.2 |
| SCREW M4×6 TX20 | 710048 |
| TX20 KEY | 710240 |

for R26—107808002

| Spare parts | ID No. |
|--------------------|-------------|
| VBD 19.2×44×2-P1 | 107808002.1 |
| VBD 19.2×43.9×2-P2 | 107808002.2 |
| SCREW M5×8 TX25 | 711049 |
| TX25 KEY | 710245 |



DP tips arranged in a continuous spiral.
H = tip height

APPLICATION

For sizing, surface planing, and grooving
Mechanical feed MEC
For CNC machining centres and routers

WORKPIECE MATERIAL

Exotic hardwood, MDF, chipboard, multi-layer laminated wood, plastics

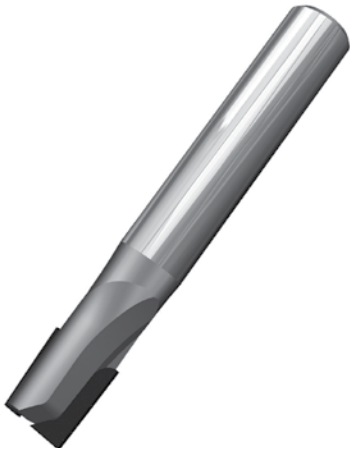
OPERATING CONDITIONS

n_{max} : 18,000–24,000 RPM
 v_f : 4–8 m/min

TECHNICAL SPECIFICATIONS

Z1+1 configuration
Cutting edges—brazed DP tips
Plunge tip—brazed DP tip
Up to 4 re-sharpening operations possible, depending on wear
Available in LH and RH versions

| D mm | NL mm | L mm | L1 mm | S mm | H mm | Spiral design | ID No. |
|------|-------|------|-------|------|------|---------------|-----------|
| 8 | 26 | 80 | 9.7 | 10 | 2 | RH | 082608030 |
| 8 | 26 | 80 | 9.7 | 10 | 2 | LH | 082608031 |
| 10 | 26 | 70 | 9.7 | 12 | 2.4 | RH | 102607030 |
| 10 | 26 | 70 | 9.7 | 12 | 2.4 | LH | 102607031 |
| 10 | 35 | 80 | 9.7 | 12 | 2.4 | RH | 103508030 |
| 10 | 35 | 80 | 9.7 | 12 | 2.4 | LH | 103508031 |
| 12 | 26 | 70 | 9.7 | 12 | 3 | RH | 122607030 |
| 12 | 26 | 70 | 9.7 | 12 | 3 | LH | 122607031 |
| 12 | 35 | 80 | 9.7 | 12 | 3 | RH | 123508030 |
| 12 | 35 | 80 | 9.7 | 12 | 3 | LH | 123508031 |
| 12 | 43 | 95 | 9.7 | 12 | 3 | RH | 124309530 |
| 12 | 43 | 95 | 9.7 | 12 | 3 | LH | 124309531 |
| 16 | 26 | 85 | 9.7 | 16 | 3 | RH | 162608530 |
| 16 | 26 | 85 | 9.7 | 16 | 3 | LH | 162608531 |
| 16 | 35 | 95 | 9.7 | 16 | 3 | RH | 163509530 |
| 16 | 35 | 95 | 9.7 | 16 | 3 | LH | 163509531 |
| 16 | 43 | 105 | 9.7 | 16 | 3 | RH | 164310530 |
| 16 | 43 | 105 | 9.7 | 16 | 3 | LH | 164310531 |
| 18 | 26 | 90 | 9.7 | 20 | 3 | RH | 182609030 |
| 18 | 26 | 90 | 9.7 | 20 | 3 | LH | 182609031 |
| 18 | 35 | 95 | 9.7 | 20 | 3 | RH | 183509530 |
| 18 | 35 | 95 | 9.7 | 20 | 3 | LH | 183509531 |
| 18 | 43 | 105 | 9.7 | 20 | 3 | RH | 184310530 |
| 18 | 43 | 105 | 9.7 | 20 | 3 | LH | 184310531 |
| 18 | 52 | 110 | 9.7 | 20 | 3 | RH | 185211030 |
| 18 | 52 | 110 | 9.7 | 20 | 3 | LH | 185211031 |
| 18 | 43 | 110 | 9.7 | 25 | 3 | RH | 184311030 |
| 18 | 43 | 110 | 9.7 | 25 | 3 | LH | 184311031 |
| 20 | 26 | 90 | 9.7 | 20 | 3 | RH | 202609030 |
| 20 | 26 | 90 | 9.7 | 20 | 3 | LH | 202609031 |
| 20 | 43 | 105 | 9.7 | 20 | 3 | RH | 204310530 |
| 20 | 43 | 105 | 9.7 | 20 | 3 | LH | 204310531 |
| 20 | 52 | 110 | 9.7 | 20 | 3 | RH | 205211030 |
| 20 | 52 | 110 | 9.7 | 20 | 3 | LH | 205211031 |
| 20 | 65 | 122 | 9.7 | 20 | 3 | RH | 206512230 |
| 20 | 65 | 122 | 9.7 | 20 | 3 | LH | 206512231 |
| 25 | 26 | 85 | 9.7 | 25 | 3 | RH | 252608530 |
| 25 | 26 | 85 | 9.7 | 25 | 3 | LH | 252608531 |



APPLICATION

For sizing, surface planing, and grooving
 Mechanical feed MEC
 For CNC machining centres and routers

WORKPIECE MATERIAL

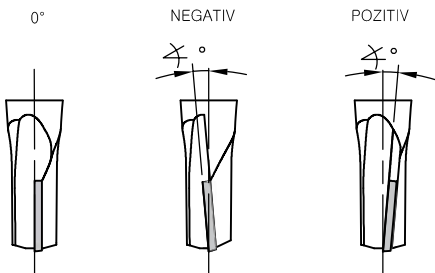
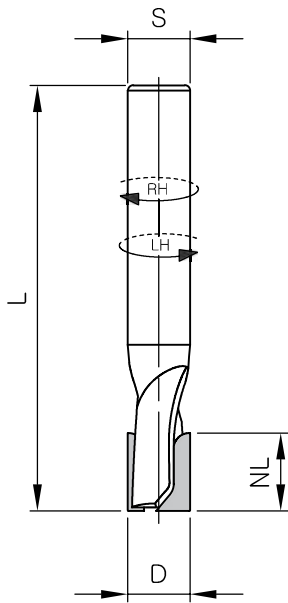
Exotic hardwood, MDF, chipboard, multi-layer laminated wood, plastics

OPERATING CONDITIONS

n_{max} : 18,000–24,000 RPM
 v_f : 4–8 m/min

TECHNICAL SPECIFICATIONS

Z1 and Z2 configuration
 Cutting edges—brazed DP tips
 Plunge tip
 HW or Fe cutter body

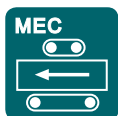


With plunge tip

| D mm | NL mm | L mm | S mm | Z | Axial angle design | Body material | Spiral design | ID No. |
|------|-------|------|------|---|--------------------|---------------|---------------|-----------|
| 5 | 12 | 60 | 6 | 1 | 0° | HW | RH | 051206010 |
| 6 | 15 | 60 | 6 | 2 | Negative | Fe | RH | 061506025 |
| 8 | 12 | 60 | 8 | 2 | Negative | HW | RH | 081206027 |
| 8 | 12 | 60 | 8 | 2 | Negative | HW | LH | 081206028 |
| 8 | 22 | 60 | 8 | 2 | 0° | HW | RH | 082206020 |
| 8 | 22 | 60 | 8 | 2 | 0° | HW | LH | 082206021 |
| 8 | 22 | 60 | 8 | 2 | 0° | Fe | RH | 082206023 |
| 8 | 22 | 60 | 8 | 2 | 0° | Fe | LH | 082206024 |
| 8 | 20 | 65 | 8 | 1 | 0° | Fe | RH | 082006510 |
| 10 | 12 | 60 | 10 | 2 | 0° | HW | RH | 101206020 |
| 10 | 15 | 60 | 10 | 2 | Negative | Fe | RH | 101506025 |
| 10 | 15 | 60 | 10 | 2 | Negative | Fe | LH | 101506026 |

Without plunge tip

| D mm | NL mm | L mm | S mm | Z | Axial angle design | Body material | Spiral design | ID No. |
|------|-------|------|------|---|--------------------|---------------|---------------|-----------|
| 6 | 15 | 60 | 6 | 1 | 0° | Fe | RH | 061506018 |
| 6 | 15 | 60 | 6 | 1 | 0° | Fe | LH | 061506019 |
| 6 | 15 | 60 | 6 | 2 | 0° | HW | RH | 061506026 |
| 6 | 15 | 60 | 6 | 2 | 0° | HW | LH | 061506027 |
| 6 | 15 | 60 | 6 | 2 | 0° | Fe | RH | 061506028 |
| 6 | 15 | 60 | 6 | 2 | 0° | Fe | LH | 061506029 |
| 10 | 15 | 70 | 10 | 2 | Negative | Fe | RH | 101507026 |



APPLICATION

For sizing, surface planing, and grooving
For CNC machining centres

WORKPIECE MATERIAL

Exotic hardwood, MDF, chipboard, multi-layer laminated wood, plastics

OPERATING CONDITIONS

n_{max} : 18,000–24,000 RPM

v_f : 5–15 m/min

TECHNICAL SPECIFICATIONS

Z2+1 configuration

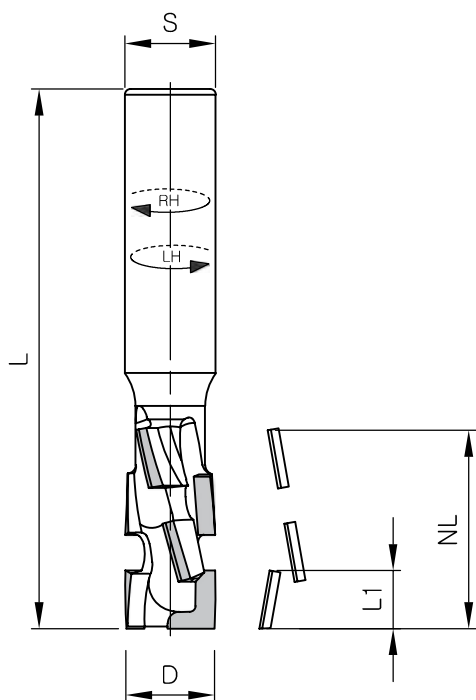
Cutting edges—brazed DP tips

Plunge tip—brazed DP tip

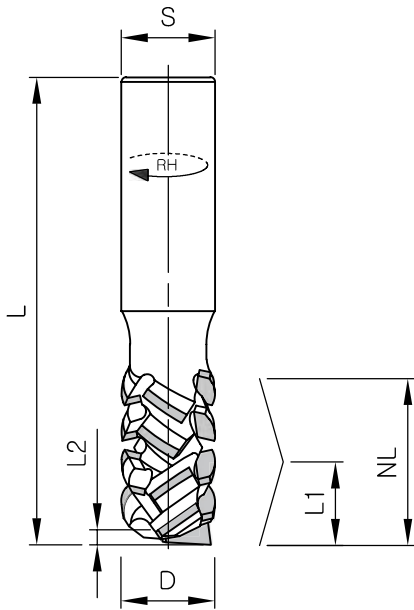
Tip height H = 2.5 to 3.8 mm

Up to 4 re-sharpening operations possible, depending on wear

Available in LH and RH versions



| D mm | NL mm | L mm | L1 mm | S mm | H mm | Spiral design | ID No. |
|------|-------|------|-------|------|------|---------------|-----------|
| 16 | 20 | 80 | 9.7 | 16 | 3 | RH | 162008020 |
| 16 | 26 | 85 | 9.7 | 16 | 3 | RH | 162608520 |
| 16 | 35 | 95 | 9.7 | 16 | 3 | RH | 163509520 |
| 18 | 26 | 90 | 9.7 | 20 | 3 | RH | 182609020 |
| 18 | 30 | 90 | 9.7 | 20 | 3 | RH | 183009020 |
| 18 | 35 | 95 | 9.7 | 20 | 3 | RH | 183509520 |
| 18 | 43 | 105 | 9.7 | 20 | 3 | RH | 184310520 |
| 18 | 43 | 105 | 9.7 | 20 | 3 | LH | 184310521 |
| 18 | 52 | 110 | 9.7 | 20 | 3 | RH | 185211030 |
| 20 | 26 | 90 | 9.7 | 20 | 3 | RH | 202609020 |
| 20 | 26 | 90 | 9.7 | 20 | 3 | LH | 202609021 |
| 20 | 43 | 105 | 9.7 | 20 | 3 | RH | 204310520 |
| 20 | 54 | 110 | 9.7 | 20 | 3 | RH | 205411020 |
| 20 | 65 | 122 | 9.7 | 20 | 3 | RH | 206512220 |
| 25 | 48 | 115 | 9.7 | 25 | 3 | RH | 254811520 |



APPLICATION

For sizing, surface planing, grooving
For CNC machining centres

WORKPIECE MATERIAL

Exotic hardwood, MDF, chipboard,
multi-layer laminated solid wood, plastics

OPERATING CONDITIONS

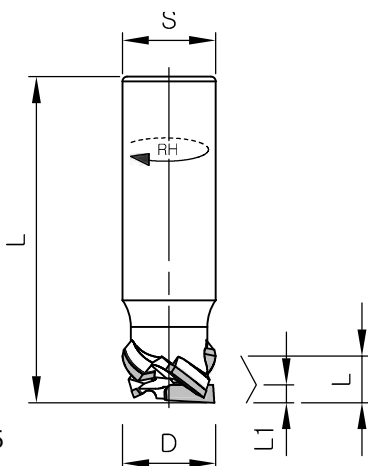
n_{max} : 18,000–24,000 RPM
 v_f : 12–20 m/min

TECHNICAL SPECIFICATIONS

Z2+1 configuration
Cutting edges and plunge tip—brazed DP tips
Tip height H = 2.6 mm (for D = 20 mm)
Tip height H = 3 mm (for D = 25 mm)
Up to 5 re-sharpening operations, depending on wear
Available in LH and RH versions
High-quality surface finish and clean-cut edges
Clean entry and exit without edge splintering

| D mm | NL mm | L mm | L1 mm | L2 mm | S mm | H mm | Spiral design | ID No. |
|------|-------|------|-------|-------|------|------|---------------|-----------|
| 20 | 26 | 90 | 15 | 5 | 20 | 3 | RH | 2026090M0 |
| 20 | 35 | 100 | 18.8 | 2.5 | 20 | 3 | RH | 2035100M3 |
| 25 | 52 | 115 | 27.5 | 4.3 | 25 | 3.5 | RH | 2550115M0 |

\\ DP shallow grooving cutter MALLARD



04 - 15

APPLICATION

For rebating, shallow grooving
For CNC machining centres

WORKPIECE MATERIAL

Exotic hardwood, MDF, chipboard, multi-layer laminated solid wood,
plastics, laminated and veneered panels

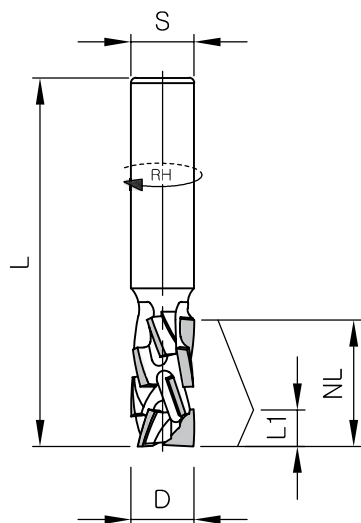
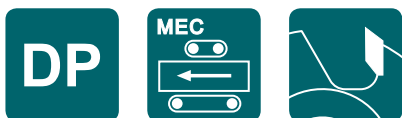
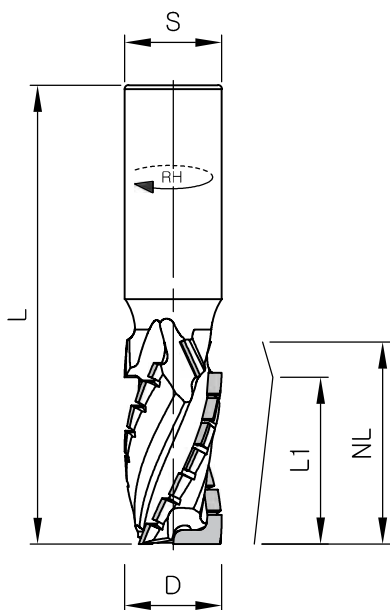
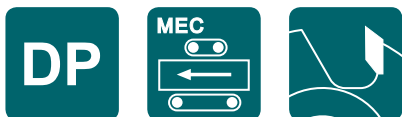
OPERATING CONDITIONS

n_{max} : 24,000 RPM
 v_f : 10–20 m/min

TECHNICAL SPECIFICATIONS

Z1, Z2 configuration
Cutting edges and plunge tip—brazed DP tips
Tip height H = 3.5 mm
Up to 4 re-sharpening operations possible, depending on wear
Asymmetric (AS) cutting edge arrangement
High-quality surface finish and clean-cut edges
Clean entry and exit without edge splintering
High machining productivity, minimum groove depth 1.5 mm

| D mm | NL mm | L mm | L1 mm | S mm | H mm | Z | Cutting edge arrangement | ID No. |
|------|-------|------|-------|------|------|---|--------------------------|-----------|
| 16 | 10 | 70 | 1.5 | 16 | 3.5 | 1 | AS | 1610070M0 |
| 20 | 10 | 70 | 3.3 | 20 | 3.5 | 2 | AS | 2010070M0 |



APPLICATION

For sizing, surface planing, grooving
For CNC machining centres

WORKPIECE MATERIAL

Exotic hardwood, MDF, chipboard, OSB, multi-layer laminated solid wood, plastics, laminated and veneered panels

OPERATING CONDITIONS

n_{max} : 24,000 RPM
 v_f : 20–30 m/min

TECHNICAL SPECIFICATIONS

Z3 configuration
Cutting edges and plunge tip—brazed DP tips
Tip height H = 3.5 mm
Up to 6 re-sharpening operations, depending on wear
PP = right-hand positive helix
Excellent cut quality on the bottom surface, upward chip removal
High machining productivity

| D mm | NL mm | L mm | L1 mm | S mm | H mm | Spiral design | ID No. |
|------|-------|------|-------|------|------|---------------|-----------|
| 25 | 55 | 118 | 46.2 | 25 | 3.5 | RH | 255211830 |

DP Shank Cutter Z3 NESTING //

APPLICATION

For sizing, surface planing, grooving, and NESTING
For CNC machining centres and routers

WORKPIECE MATERIAL

Exotic hardwood, MDF, chipboard, multi-layer laminated solid wood, plastics

OPERATING CONDITIONS

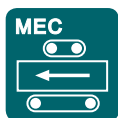
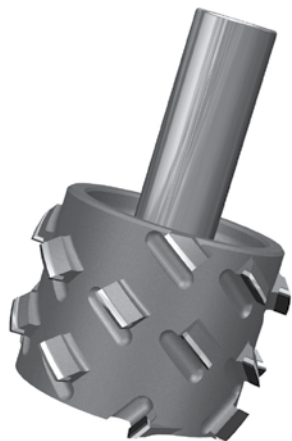
n_{max} : 20,000–24,000 RPM
 v_f : 18–35 m/min

TECHNICAL SPECIFICATIONS

Z3 configuration
Cutting edges and plunge tip—brazed DP tips
Up to 4 re-sharpening operations possible, depending on wear
Tool body made of special high-density alloy
For heavy-duty applications

| D mm | NL mm | L mm | L1 mm | S mm | H mm | Spiral design | ID No. |
|------|-------|------|-------|------|------|---------------|-----------|
| 12 | 24 | 70 | 7 | 12 | 2.8 | RH | 122407030 |

DP Surface Planing and Rebating Cutter Z2 MALLARD



APPLICATION

For rebating, sizing, surface planing, grooving
For CNC machining centres

WORKPIECE MATERIAL

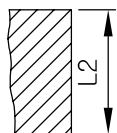
Softwood and hardwood, exotic hardwood, MDF, chipboard,
multi-layer laminated solid wood, plastics

OPERATING CONDITIONS

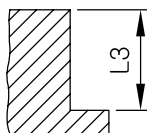
n_{max} : 10,000–18,000 RPM
 v_f : 10–20 m/min

TECHNICAL SPECIFICATIONS

Z2 configuration
DP brazed tips
Tip height H = 4.2 mm
Up to 6 re-sharpening operations, depending on wear
Asymmetric (AS) cutting edge arrangement
High-quality surface finish and clean-cut edges
Clean entry and exit without edge splintering
High machining productivity

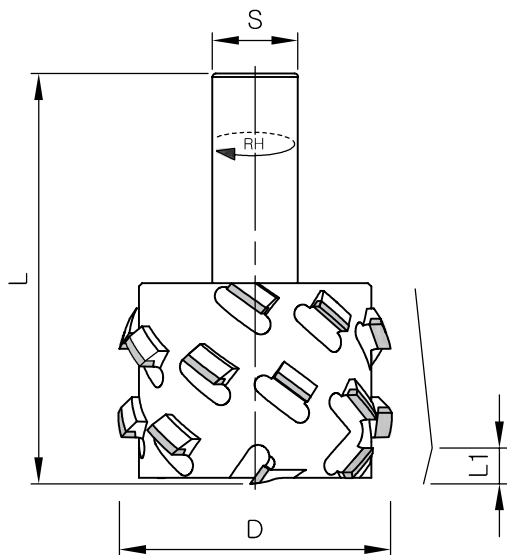


Sizing Surface planing

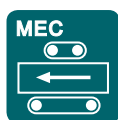
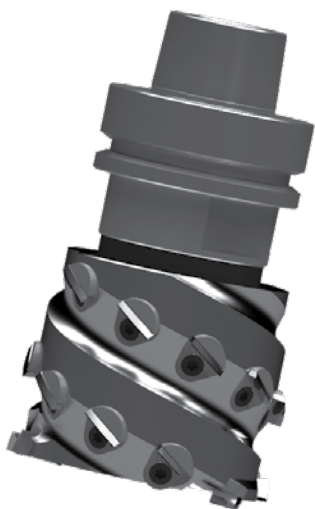


Rebating

| D mm | L1 mm | L2 mm | L3 mm | S mm | L mm | Cutting edge arrangement | ID No. |
|------|-------|-------|-------|------|------|--------------------------|-----------|
| 80 | 10.5 | 32 | 35 | 25 | 95 | AS | 8036095M0 |
| 80 | 10.5 | 53 | 56 | 25 | 120 | AS | 8057120M0 |



Surface Planing and Rebating Cutter StabilHEAD system—MALLARD DP—Indexable Inserts//



APPLICATION

For rebating, sizing, surface planing, and grooving
For CNC machining centres

WORKPIECE MATERIAL

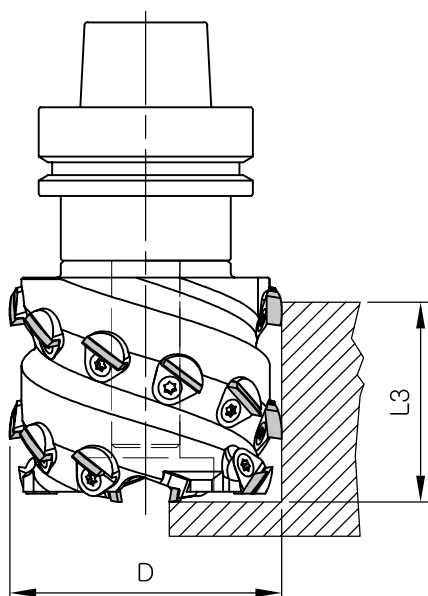
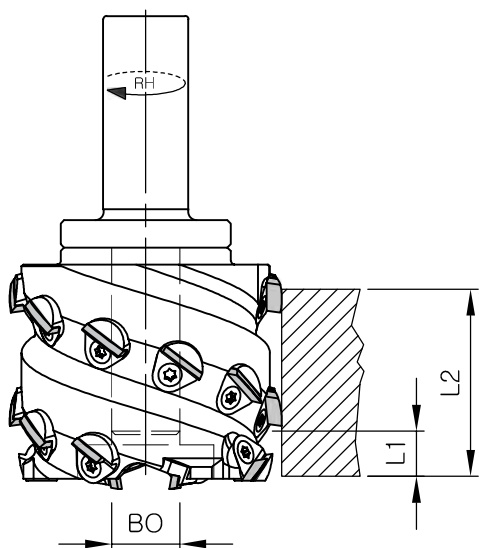
Hardwood and softwood, exotic hardwood, MDF, chipboard, multi-layer laminated solid wood, plastics

OPERATING CONDITIONS

n_{max} : 13,000 RPM

TECHNICAL SPECIFICATIONS

Z2 configuration; StabilHead DP-indexable insert mounting with high axial shear angle in the MALLARD system
Tip height H = 4 mm—up to 5 re-sharpening operations possible, depending on wear
Asymmetric (AS) cutting edge arrangement
High-quality surface finish and clean-cut edges
Aluminium alloy body = significant reduction in tool weight
High machining productivity

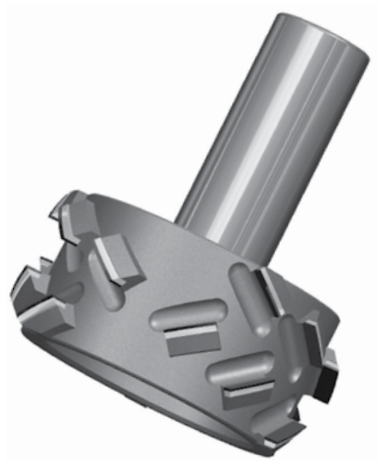


| D mm | BO mm | L1 mm | L2 mm | L3 mm | H mm | ID No. |
|------|-------|-------|-------|-------|------|----------|
| 80 | 20 | 5 | 55 | 58 | 4 | 805820M0 |

| Spare parts | pcs | ID No. |
|--------------------------------------|-----|------------|
| DP-indexable inserts 13.5 StabilHEAD | 14 | 970400 |
| DP-indexable inserts StabilHEAD | 2 | 805820M0.2 |
| DP-indexable inserts StabilHEAD | 2 | 805820M0.3 |
| DP-indexable inserts StabilHEAD | 2 | 805820M0.4 |
| SCREW M5×0.8-10 TX20 | 20 | 710120 |
| TX20 KEY | | 710240 |

! Milling arbor is not included with the tool and must be ordered separately (Refer to Section 06—Clamping Systems), as shown in the example.

| CNC Tool Holders | ID No. |
|--|------------|
| Milling arbor HSK63F d20×55 | 900121 |
| Milling arbor with S25 shank d20×55 RH | 900131 |
| Milling arbor ISO 30 d20 | On request |



APPLICATION

For sizing, surface planing, grooving
For CNC machining centres

WORKPIECE MATERIAL

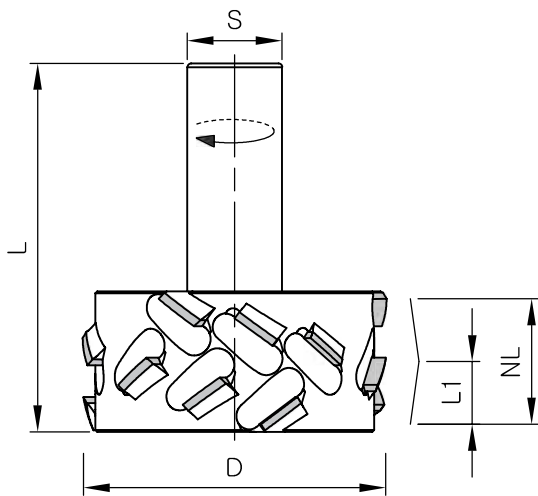
Softwood and hardwood, exotic hardwood, MDF, chipboard,
multi-layer laminated wood, plastics

OPERATING CONDITIONS

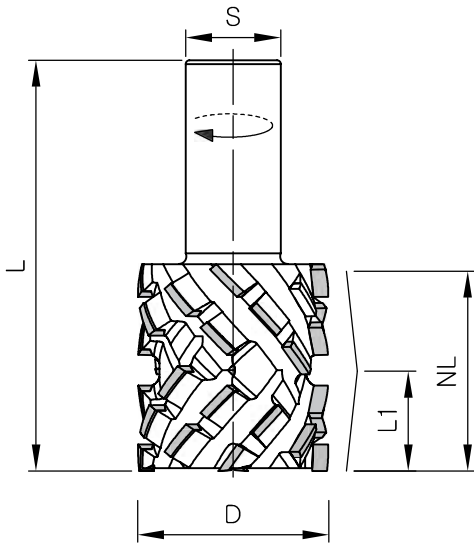
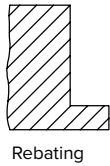
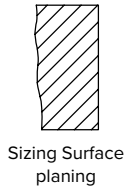
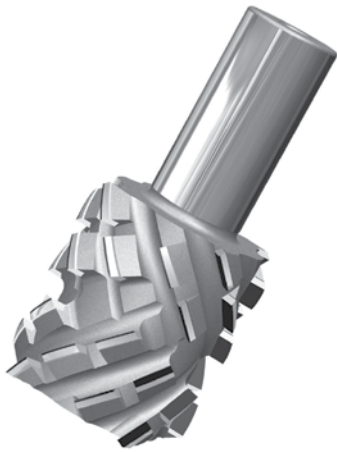
n_{max} : 10,000–18,000 RPM
 v_r : 10–50 m/min

TECHNICAL SPECIFICATIONS

Z3 configuration
Cutting edges and plunge tip—brazed DP tips
Tip height H = 4.2 mm
Up to 6 re-sharpening operations, depending on wear
Available with AS (asymmetric) or SY (symmetric) cutting edge arrangement
High-quality surface finish and clean-cut edges
Clean entry and exit without edge splintering
High machining productivity



| D mm | NL mm | L mm | L1 mm | S mm | H mm | Arrangement of edges | ID No. |
|------|-------|------|-------|------|------|----------------------|------------|
| 80 | 33 | 97 | 16.5 | 25 | 4.2 | SY | 8033097M0 |
| 80 | 53 | 117 | 26.5 | 25 | 4.2 | SY | 8053117M0 |
| 100 | 43 | 128 | 21.5 | 25 | 4.2 | SY | 10043128M0 |
| 100 | 53 | 138 | 26.5 | 25 | 4.2 | SY | 10053138M0 |



APPLICATION

For rebating, sizing
For CNC machining centres

WORKPIECE MATERIAL

Exotic hardwood, MDF, chipboard, multi-layer laminated solid wood, plastics, laminated and veneered panels

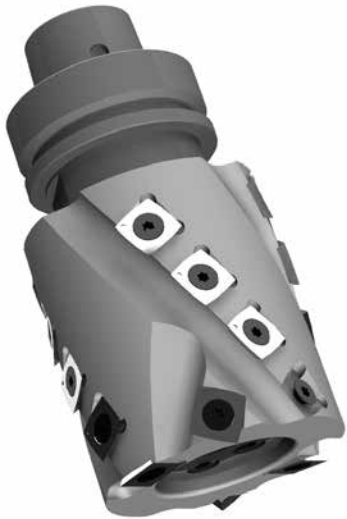
OPERATING CONDITIONS

n_{max} : 24,000 RPM
 v_f : up to 30 m/min

TECHNICAL SPECIFICATIONS

Z4+2+4 configuration
Cutting edges—brazed DP tips
Tip height H = 4.2 mm
Up to 6 re-sharpening operations, depending on wear
Symmetric (SY) cutting edge arrangement
High-quality surface finish
and clean-cut edges on both top and bottom surfaces
Clean entry and exit without edge splintering
High machining productivity
Includes an adjustment screw for setting the tool projection

| D mm | NL mm | L mm | L1 mm | S mm | H mm | Cutting edge arrangement | ID No. |
|------|-------|------|-------|------|------|--------------------------|-----------|
| 50 | 53 | 108 | 26.5 | 25 | 4.2 | SY | 505310840 |



APPLICATION

Designed for longitudinal and transverse milling, rebating and sizing
 Mechanical feed MEC
 For CNC machining centres

WORKPIECE MATERIAL

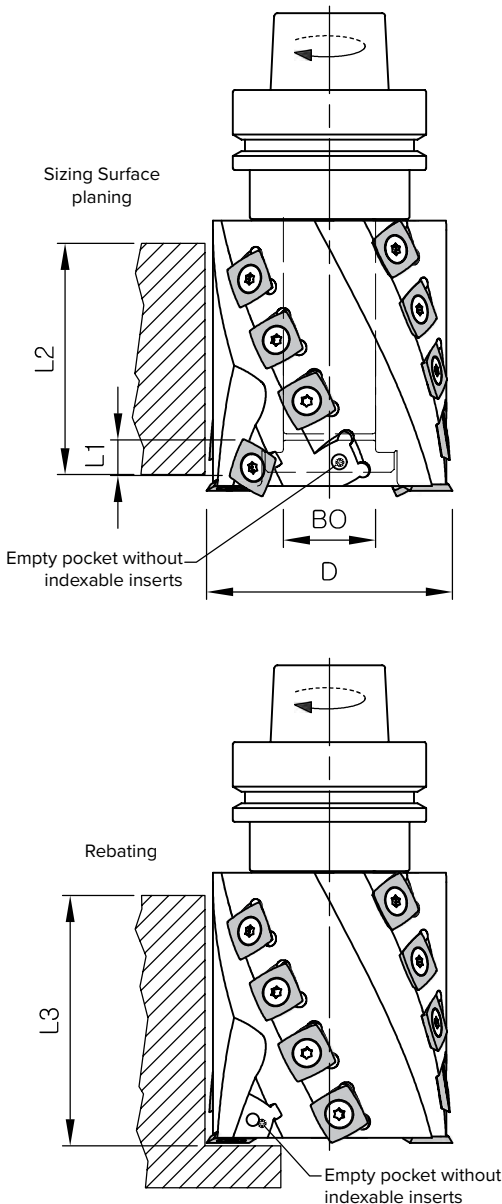
Softwood and hardwood
 Plywood

OPERATING CONDITIONS

n_{max} : 16,000 RPM

TECHNICAL SPECIFICATIONS

Cutter body made of high-strength aluminium alloy
 HW indexable inserts—4 cutting edges with R50 radius (peripheral)
 HW indexable inserts—4 straight cutting edges (face)
 Z2 configuration = 4 helical spirals
 Small chips facilitate chip extraction
 Indexable inserts are set at an axial shear angle
 High-quality machining



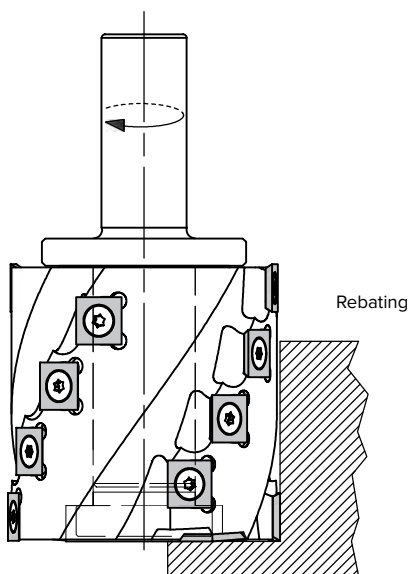
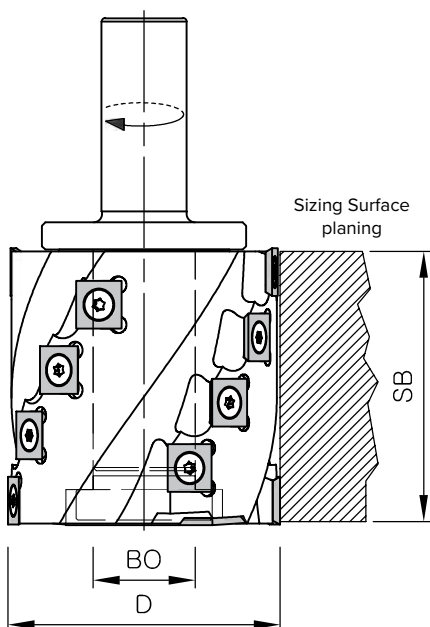
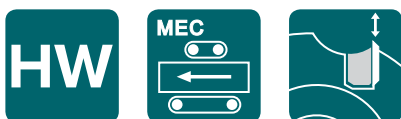
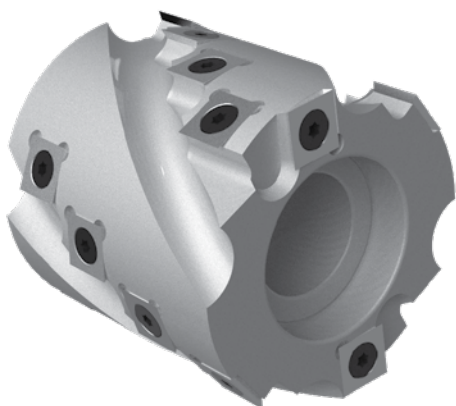
| D mm | BO mm | L1 | L2 | L3 | Z | Number of inserts | ID No. |
|------|-------|----|-----|-----|-----|-------------------|-----------|
| 80 | 30 | 11 | 74 | 80 | 2+2 | 16+2 | 122517539 |
| 80 | 30 | 11 | 113 | 120 | 2+2 | 24+2 | 122518658 |

CNC milling arbor is not included in the scope of delivery

| Spare parts | ID No. |
|-------------------|------------|
| VBD 14×14×2 | 2101414200 |
| VBD 15×15×2.5-R50 | 2101515252 |
| SCREW M5×10 TX20 | 710086 |
| TX20 KEY | 710240 |

! Milling arbor is not included with the tool and must be ordered separately (Refer to Section 06—Clamping Systems), as shown in the example.

| CNC Tool Holders | ID No. |
|-----------------------------|------------|
| Milling arbor HSK63F d30×70 | 900225 |
| Milling arbor ISO 30 d30 | On request |



APPLICATION

For rebating, sizing, surface planing, and grooving
 For CNC machining centres and sizing cutters

WORKPIECE MATERIAL

Hardwood and softwood

OPERATING CONDITIONS

n_{max} : 13,000–16,000 RPM

TECHNICAL SPECIFICATIONS

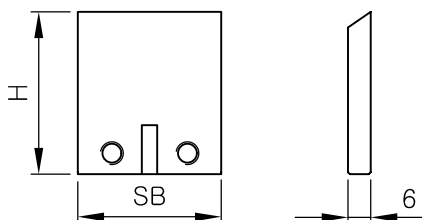
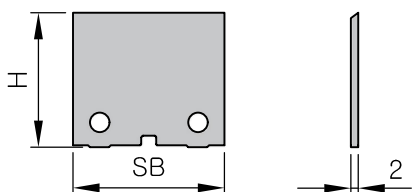
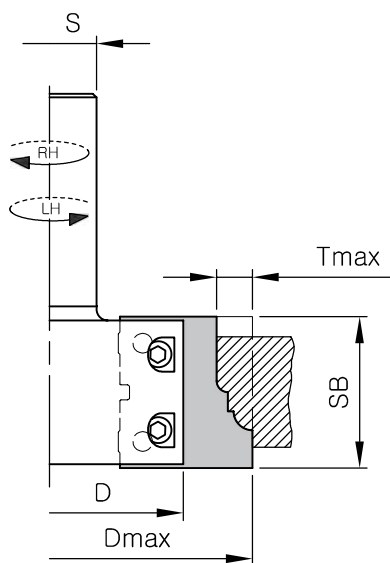
HW 4-edge indexable inserts with straight cutting edge
 Aluminium alloy body = significant reduction in tool weight

| D mm | BO mm | SB mm | Z | ID No. |
|------|-------|-------|----------|--------|
| 80 | 30 | 80 | 2 (16+2) | 15040 |
| 80 | 30 | 100 | 2 (20+2) | 15010 |
| 100 | 30 | 60 | 3 (18+3) | 15020 |
| 100 | 30 | 104 | 3 (30+3) | 15030 |

CNC milling arbor is not included in the scope of delivery

| Spare parts | ID No. |
|------------------|------------|
| VBD 14×14×2 | 2201414200 |
| SCREW M5×10 TX20 | 710086 |
| TX20 KEY | 710240 |

! Milling arbor is not included with the tool and must be ordered separately (Refer to Section 06—Clamping Systems).



APPLICATION

For CNC machining centres
Mechanical feed MEC
For all types of profiles

WORKPIECE MATERIAL

Solid wood and panel materials

OPERATING CONDITIONS

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

TECHNICAL SPECIFICATIONS

Steel tool body
HW indexable inserts for universal use
Available in LH or RH versions
Quick change of profiling knives with secure and precise positioned clamping

Holder with wedge

| D mm | S mm | SB mm | Z | ID No. LH | ID No. RH |
|------|-------|-------|---|-----------|-----------|
| 71 | 25×60 | 40 | 2 | 911020 | 901020 |
| 71 | 25×60 | 60 | 2 | 911010 | 901010 |

Spare parts

| | ID No. |
|---------------------|--------|
| SCREW M8×1-20 ISK 5 | 710045 |
| SCREW M5×16 TX25 | 711053 |
| TX25 KEY | 710245 |
| HEX KEY 5 | 710205 |

HW knife blank

| SB mm | H mm | D _{max} mm | T _{max} mm | ID No. |
|-------|------|---------------------|---------------------|--------|
| 40 | 20.5 | 82 | 3.1 | 901026 |
| 40 | 25.5 | 91 | 8.1 | 901027 |
| 40 | 30.5 | 100 | 13.1 | 901028 |
| 40 | 35.5 | 110 | 18.1 | 901029 |
| 60 | 25.5 | 91 | 8.1 | 901037 |
| 60 | 35.5 | 110 | 18.1; | 901038 |

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 |



APPLICATION

Custom profile milling
Designed for CNC machining centres

WORKPIECE MATERIAL

Hardwood and softwood
MDF, chipboard, plastic

OPERATING CONDITIONS

n_{max} : 10,000 RPM
Mechanical feed MEC

TECHNICAL SPECIFICATIONS

Steel tool body
Compatible with safety cutterhead knives
Long knife life
Suitable for prototyping and single-piece production
Secure and precise knife clamping

| D mm | S mm | B mm | Z | ID No. |
|------|-------|------|---|--------|
| 80 | 25×60 | 58 | 2 | 970260 |

| Spare parts | ID No. |
|----------------------|----------|
| Clamping wedge | 970260.K |
| Screw M 10×1–20 ISK5 | 710046 |
| ISK5 key | 710205 |

Custom profile grinding
for safety cutterhead knives


TECHNICAL SPECIFICATIONS—HSS KNIVES

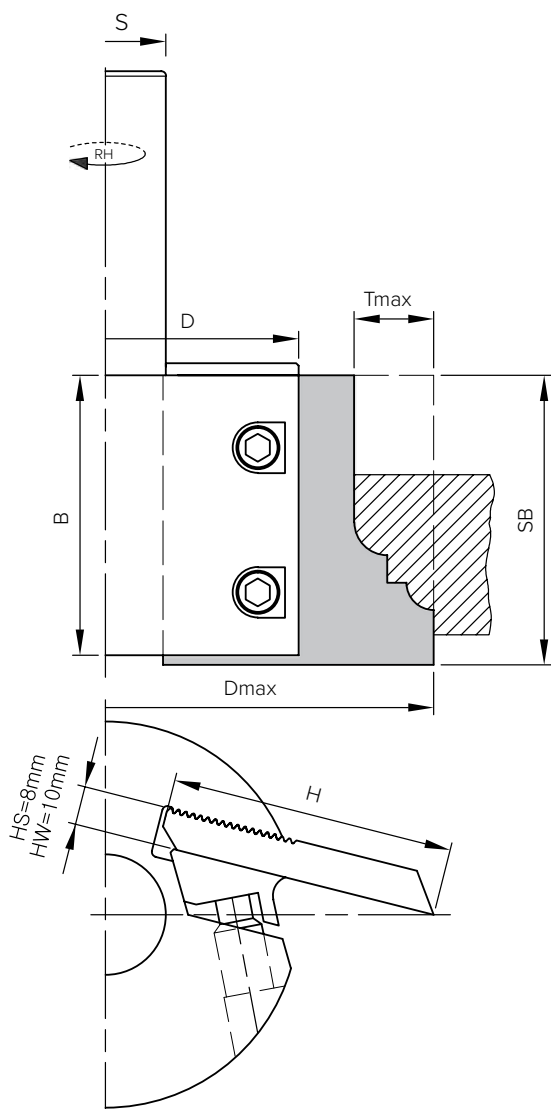
HSS knife blanks – 6% W
Designed for milling both hardwood and softwood

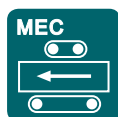
| SB mm | H mm | D _{max} mm | T _{max} mm | ID No. |
|-------|------|---------------------|---------------------|--------|
| 60 | 60 | 136 | 25.5 | 030328 |
| 60 | 50 | 117 | 16 | 030309 |
| 60 | 40 | 98 | 6.5 | 030291 |

TECHNICAL SPECIFICATIONS—HW KNIVES

Designed for milling hardwood, MDF, chipboard, and plastics
UNI PACK system
System with brazed HW tips

 On request





APPLICATION

Custom profile milling
Designed for CNC machining centres

WORKPIECE MATERIAL

Hardwood and softwood

OPERATING CONDITIONS

n_{max} : 10,000 RPM
Mechanical feed MEC

TECHNICAL SPECIFICATIONS

Steel tool body
Knife widths 40 mm and 50 mm
Compatible with safety cutterhead knives

| D mm | S mm | B mm | Z | ID No. |
|------|-------|------|---|--------|
| 75 | 25×60 | 38 | 2 | 971200 |

| Spare parts | ID No. |
|--------------------|----------|
| Clamping wedge | 971200.K |
| Screw M 10×16 ISK5 | DIN915 |
| ISK5 key | 710205 |

Custom profile grinding for universal cutterhead knives

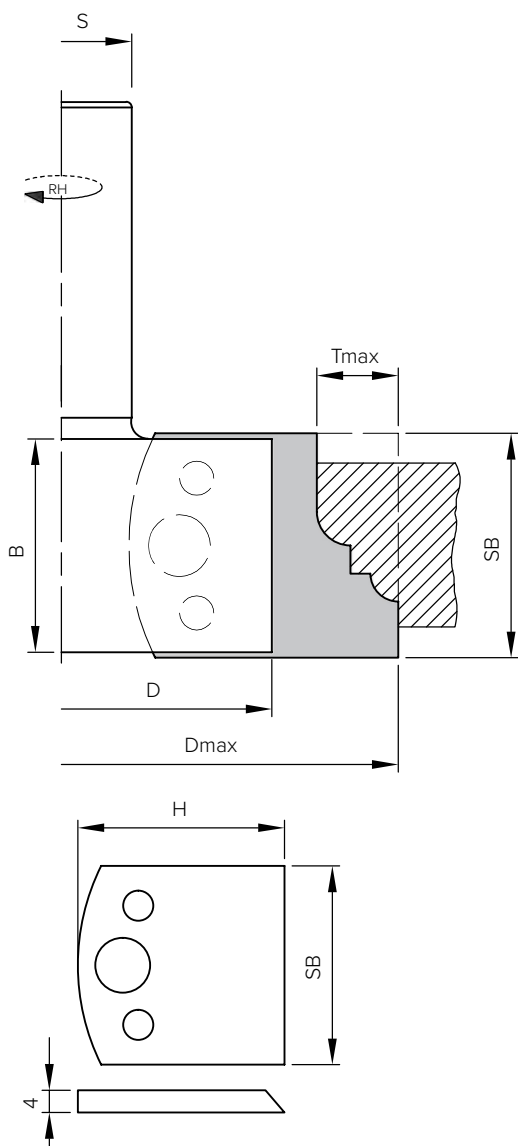
TECHNICAL SPECIFICATIONS

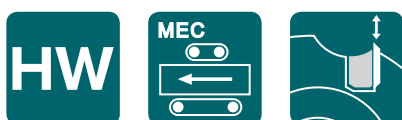
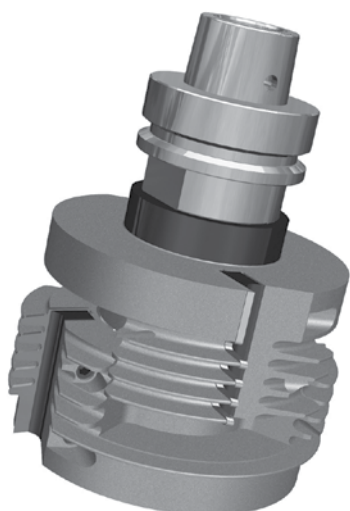
HS knife blanks – C

| SB mm | H mm | D_{max} mm | T_{max} mm | ID No. |
|-------|------|--------------|--------------|--------|
| 40 | 48 | 120 | 20 | 610640 |
| 50 | 50 | 120 | 20 | 611855 |

Limiter blank

| SB mm | H mm | D_{max} mm | T_{max} mm | ID No. |
|-------|------|--------------|--------------|--------|
| 38 | 47 | - | - | 613847 |
| 48 | 49 | - | - | 614849 |





APPLICATION

Designed for cross-joining of segments
in arched window production
Mechanical feed MEC

WORKPIECE MATERIAL

Hardwood and softwood

OPERATING CONDITIONS

n_{max} : 10,500 RPM

TECHNICAL SPECIFICATIONS

Adjustable cutter
Aluminium alloy cutter body
HW indexable profile inserts

| D mm | SB mm | BO mm | B mm | H mm | Z | ID No. |
|------|-------|-------|---------|------|---|--------|
| 125 | 40–96 | 30 | 37.8–66 | 10 | 2 | 21107 |

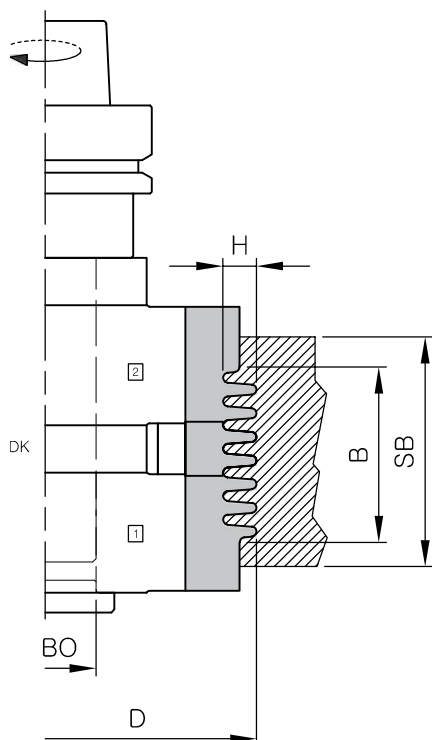
CNC milling arbor is not included in the scope of delivery

| 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 ISK5 | | 710045 |
| ISK5 KEY | | |

! Milling arbor is not included with the tool and must be ordered separately (Refer to Section 06—Clamping Systems), as shown in the example.

| CNC Tool Holders | ID No. |
|-----------------------------|------------|
| Milling arbor HSK63F d30×90 | 900124 |
| Milling arbor ISO 30 d30 | On request |



Adjustable Rounding and Chamfering Set with Rebating



APPLICATION

For various combinations of chamfering and rounding on CNC machining centres
Mechanical feed MEC

WORKPIECE MATERIAL

Softwood and hardwood, MDF

OPERATING CONDITIONS

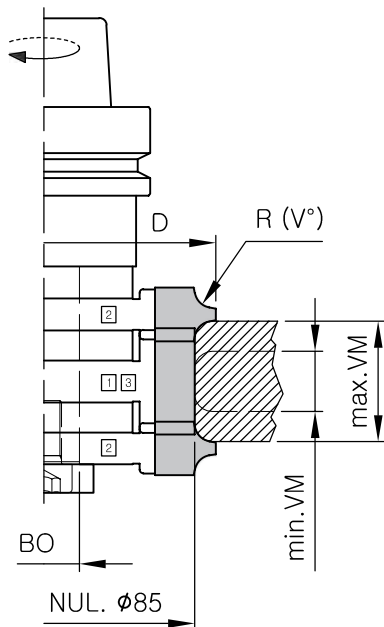
n_{max} : 13,000 RPM

TECHNICAL SPECIFICATIONS

HW indexable inserts
Z2 configuration
Steel tool body
Both clockwise (RH) and counter-clockwise (LH) rotation can be used
Can be fitted with inserts for R2/R3/R4/R5 rounding and up to 5×45° chamfering

| D mm | BO mm | SB mm | Position | ID No. |
|------|-------|-------|----------|--------|
| 85 | 20 | 30 | 1 | 900051 |
| 85 | 20 | 50 | 3 | 900061 |
| 97 | 20 | 15.1 | 2 | 900052 |

CNC milling arbor is not included in the scope of delivery



| Spare parts | Position | ID No. |
|-------------------|----------|------------|
| VBD 15.1×19×2-R2 | 2 | 900053 |
| VBD 15.1×19×2-R3 | 2 | 900054 |
| VBD 15.1×19×2-R4 | 2 | 900055 |
| VBD 15.1×19×2-R5 | 2 | 900056 |
| VBD 15.1×19×2-45° | 2 | 900057 |
| VBD 30×12×1.5 | 1 | 1103012150 |
| VBD 50×12×1.5 | 3 | 1105012150 |

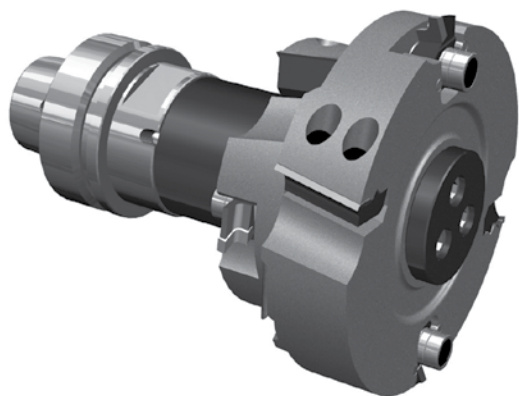
| Spare parts | ID No. |
|---------------|--------|
| SCREW M6×1-16 | DIN913 |
| ISK3 KEY | 710203 |

Workpiece material height VM according to profile

| Tool body numbers | max VM | min VM |
|-------------------|--------|--------|
| 2+1+2 | 28+2R | 10+2R |
| 2+3+2 | 48+2R | 18+2R |

! Milling arbor is not included with the tool and must be ordered separately (Refer to Section 06—Clamping Systems), as shown in the example.

| CNC Tool Holders | ID No. |
|-----------------------------|------------|
| Milling arbor HSK63F d20×55 | 900121 |
| Milling arbor ISO 30 d20 | On request |



APPLICATION

Designed for producing 15 mm door rebate
Mechanical feed MEC

WORKPIECE MATERIAL

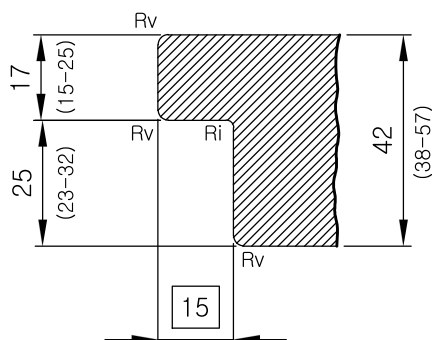
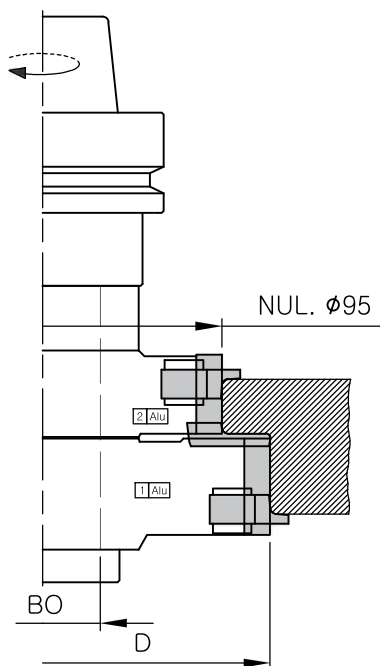
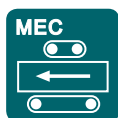
Hardwood and softwood, exotic wood,
Laminated solid wood in combination with MDF

OPERATING CONDITIONS

n_{max} : 10,500 RPM

TECHNICAL SPECIFICATIONS

HW indexable inserts, Z2 configuration
Cutter body made of aluminium alloy
Versatile external rounding (chamfering) R2/R2.5/R3/45°



Ri - 1/ 1.5 mm
Rv - 2/ 2.5/ 3mm / 45°

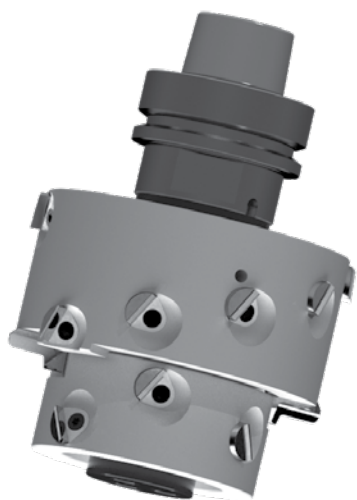
| D mm | BO mm | Z | ID No. |
|-------|-------|-----|--------|
| 136.4 | 30 | 2+2 | 33107 |

| Spare parts | Rv/Ri | Position | ID No. |
|--------------------------------|-------------|----------|--------------|
| VBD 30×8×1.5 | | 1 | 4203008150 |
| VBD 26.2×15×9 | Rv2 | 1 | 361020 |
| VBD 26.2×15×9 | Rv2.5 | 1 | 361025 |
| VBD 26.2×15×9 | Rv3 | 1 | 361030 |
| Indexable inserts R1/15/R2 | Rv2/Ri1 | 1 | 007171015020 |
| Indexable inserts R1/15/R2.5 | Rv2.5/Ri1 | 1 | 007171015025 |
| Indexable inserts R1/15/R3 | Rv3/Ri1 | 1 | 007171015030 |
| Indexable inserts R1.5/15/R2 | Rv2/Ri1.5 | 1 | 007171515020 |
| Indexable inserts R1.5/15/R2.5 | Rv2.5/Ri1.5 | 1 | 007171515025 |
| Indexable inserts R1.5/15/R3 | Rv3/Ri1.5 | 1 | 007171515030 |
| VBD 24.7×8×1.5 | | 2 | 4202408150 |
| VBD 26.2×15×9 | Rv2 | 2 | 361120 |
| VBD 26.2×15×9 | Rv2.5 | 2 | 361125 |
| VBD 26.2×15×9 | Rv3 | 2 | 361130 |
| SCREW M6×18 TX25 | | 1/2 | 710057 |
| SCREW M6×20 TX20 | | 1/2 | 710070 |
| SCREW M6×14 TX20 | | 1 | 710068 |
| TX20 KEY | | | 710240 |
| TX25 KEY | | | 710245 |

! External adjustable rounding inserts can be replaced with DP tipped versions; this option is available on request.

The milling arbor is not included with the tool and must be ordered separately (see Section 06—Clamping Systems), as shown in the example.

| CNC Tool Holders | ID No. |
|-----------------------------|------------|
| Milling arbor HSK63F d30×90 | 900124 |
| Milling arbor ISO 30, d30 | On request |



APPLICATION

For rebating
For CNC machining centres

WORKPIECE MATERIAL

MDF
Multi-layer laminated solid wood

OPERATING CONDITIONS

n_{max} : 10,500 RPM

TECHNICAL SPECIFICATIONS

Z2 configuration
DP-indexable inserts StabilHEAD
Tip height H = 4 mm—up to 5 re-sharpening operations possible, depending on wear
High-quality surface finish and clean-cut edges
Aluminium alloy body = significant reduction in tool weight

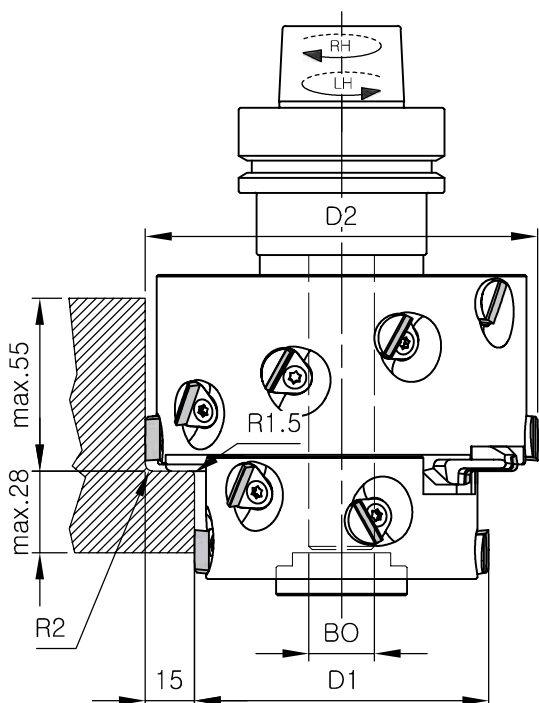
| D1 mm | D2 mm | BO mm | ID No. LH | ID No. RH |
|-------|-------|-------|------------|------------|
| 90 | 120 | 30 | 090719035L | 090719035R |

CNC milling arbor is not included in the scope of delivery

| Spare parts | Rot. direction | pcs | ID No. |
|--------------------------------------|----------------|-----|--------------|
| DP-indexable inserts 13.5 StabilHEAD | RH/LH | 16 | 970400 |
| DP-VBD R1.5/R2 | LH | 2 | 406919002P.L |
| DP-VBD R1.5/R2 | RH | 2 | 406919002P.R |
| SCREW M5×0.8-10 TX20 | | 18 | 710120 |
| TX20 KEY | | | 710240 |

! Milling arbor is not included with the tool and must be ordered separately (Refer to Section 06—Clamping Systems), as shown in the example.

| CNC Tool Holders | ID No. |
|-----------------------------|------------|
| Milling arbor HSK63F d30×90 | 900124 |
| Milling arbor ISO 30 d30 | On request |





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



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