

PRODUCT CATALOGUE



05 Windows | Doors

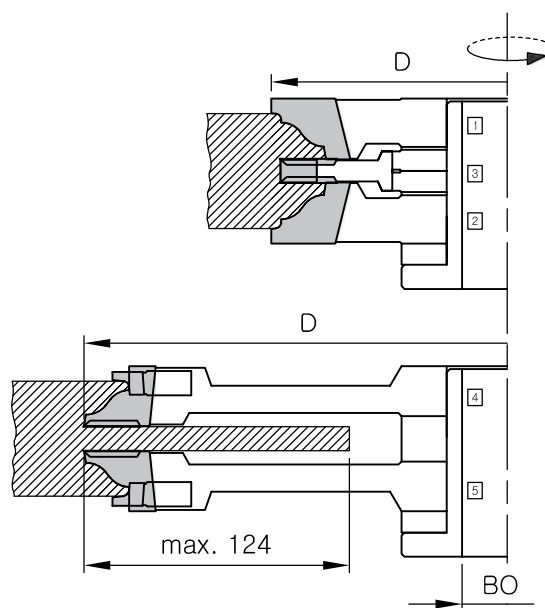
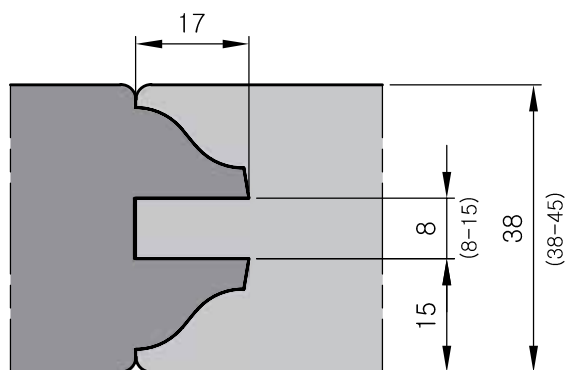
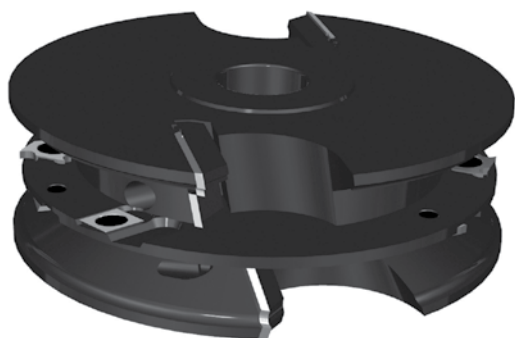
Edition X

[2026]

Windows Doors



05



APPLICATION

Designed for milling profiles and counter-profiles for doors with a shadow gap
For spindle moulders with manual feed (MAN)

WORKPIECE MATERIAL

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

OPERATING CONDITIONS

Profiling speed n: 4,500–8,000 RPM
Tenoning speed n: 4,000–5,000 RPM

TECHNICAL SPECIFICATIONS

HW – brazed tips—profiling and tenoning in Z2 configuration
HW – indexable inserts, Z2 configuration, tenon Z3
Tools are mounted on sleeves
Adjustable using spacer rings

BRAZED version

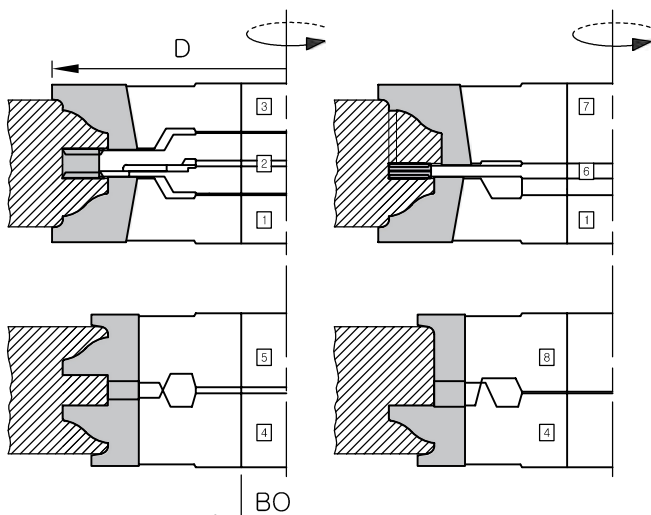
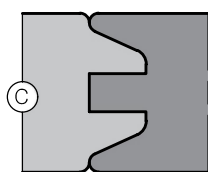
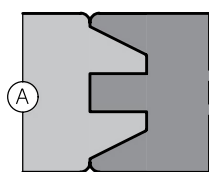
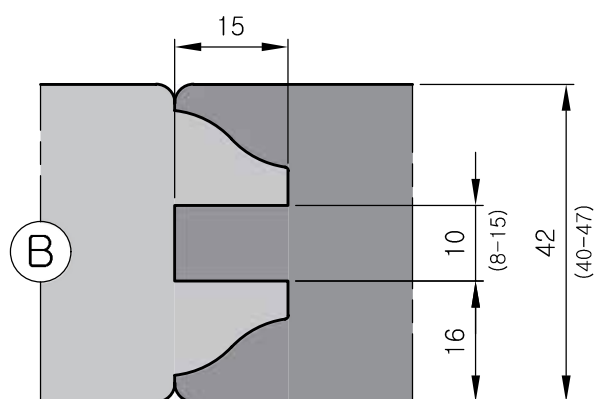
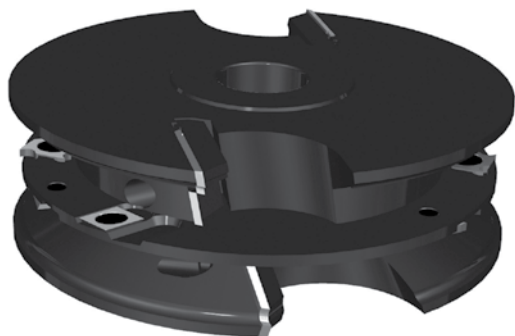
D mm	BO mm	Z	Position	ID No.
160	30/40	2	1	33101
160	30/40	2	2	
154	30/40	4+2	3	
320	30/40	2	4	
320	30/40	2	5	

Indexable insert version

D mm	BO mm	Z	Position	ID No.
156	30/40	2	1	33201
156	30/40	2	2	
150	30/40	4+2	3	
320	30/40	2	4	
320	30/40	2	5	

Spare parts

	Position	ID No.
VBD 20.9×29.3×2	1	33201.1P
VBD 20.9×29.3×2	2	33201.2P
VBD 7.5×12×1.5	3	1100712150
VBD 22×22×2	3	2102222200
VBD 19.5×29.1×2	4	33201.4P
VBD 19.5×29.1×2	5	33201.5P
Indexable inserts 26×15 – R2, RIGHT	4	261120
Indexable inserts 26×15 – R2, LEFT	5	261020
SCREW M6×1 – 20 Tx25	1/2/4/5	710058
SCREW M6×1 Tx20	4/5	710069
SCREW M6×0.5 Tx20	3/4/5	710065
Tx25 KEY		710245
Tx20 KEY		710240
HEX KEY 2.5		710202



APPLICATION

Designed for milling profiles and counter-profiles for doors with a shadow gap
Manual feed MAN

WORKPIECE MATERIAL

Softwood and hardwood, laminated wood in combination with MDF

OPERATING CONDITIONS

n: 4,000–8,500 RPM

TECHNICAL SPECIFICATIONS

HW indexable inserts

Z2 configuration

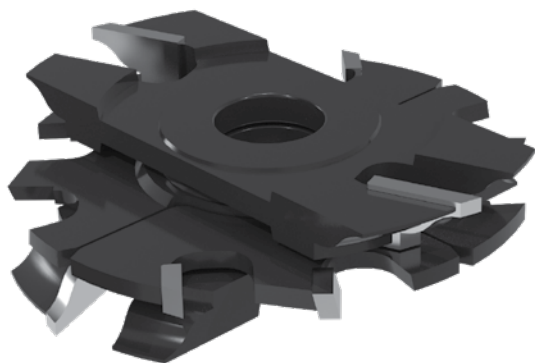
Ability to produce 3 different profiles by simply swapping the indexable inserts

Adjustable using spacer rings

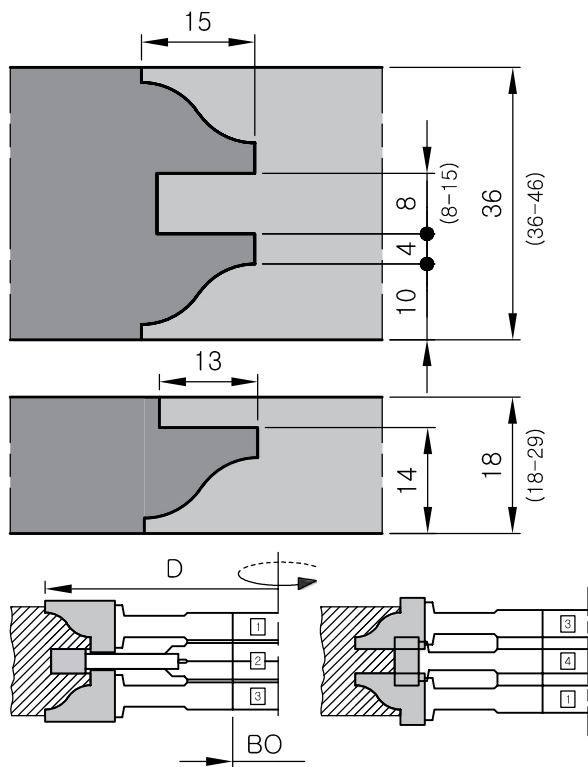
D mm	BO mm	Z	Position	ID No.
167	30/40	2	1	33102.1
160	30/40	4+2	2	33102.2
167	30/40	2	3	33102.3
160	30/40	2	4	33102.4
160	30/40	2	5	33102.5
160	30/40	2	6	33102.6
167	30/40	2	7	33102.7
141	30/40	2	8	33102.8

Spare parts	Profile	Position	ID No.
VBD 22.3×27×2	A	1	33102.1P.A
VBD 22.3×27×2	B	1	33102.1P.B
VBD 22.3×27×2	C	1	33102.1P.C
VBD 22.3×27×2	A	3	33102.3P.A
VBD 22.3×27×2	B	3	33102.3P.B
VBD 22.3×27×2	C	3	33102.3P.C
VBD 28.5×29.5×2	A	4	33102.4P.A
VBD 28.5×29.5×2	B	4	33102.4P.B
VBD 28.5×29.5×2	C	4	33102.4P.C
VBD 28.5×29.5×2	A	5	33102.5P.A
VBD 28.5×29.5×2	B	5	33102.5P.B
VBD 28.5×29.5×2	C	5	33102.5P.C
VBD 27.4×30.2×2	A	7	33102.7P.A
VBD 27.4×30.2×2	B	7	33102.7P.B
VBD 27.4×30.2×2	C	7	33102.7P.C
VBD 30.5×17.8×2	A/B/C	8	33102.8P
VBD 7.7×8×1.5	A/B/C	2	4200708150
VBD 14×14×2	A/B/C	2	2201414200
VBD 18×18×2.5	A/B/C	6	3401818250
VBD 14×14×1.2	A/B/C	6	2201414120
SCREW M6×1 TX25		1/3/4/5/8	710058
SCREW M4×0.5 Tx10		6	710077
NUT M4×0.5 L1.6		6	710082
NUT M4×0.5 L2.2		6	710084
SCREW M5 Tx15		2	710074
TX25 KEY			710245
TX20 KEY			710240
TX10 KEY			710220

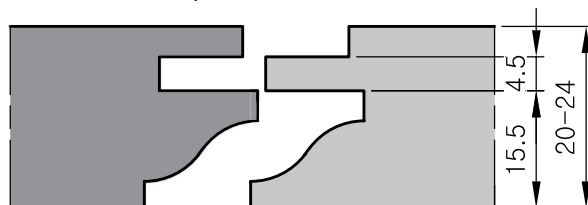
! The set is supplied with one profile system as standard; additional profile indexable inserts must be ordered separately.



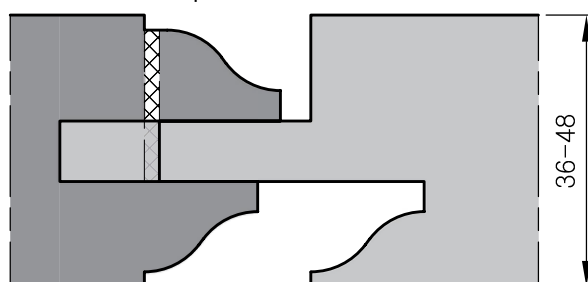
Standard set—item No. 1/2/3/4



Version after expansion—item No. 5



Version after expansion—item No. 6/9/8



APPLICATION

Designed for milling profiles and counter-profiles for doors and furniture doors
Without a shadow gap
For spindle moulders with manual feed (MAN)

WORKPIECE MATERIAL

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

OPERATING CONDITIONS

Profiling speed n: 5,000–8,500 RPM
Tenoning speed n: 4,000–5,000 RPM

TECHNICAL SPECIFICATIONS

HW – brazed tips, profile in Z2 configuration, tenon Z3
Tools are separate units
Adjustable using spacer rings

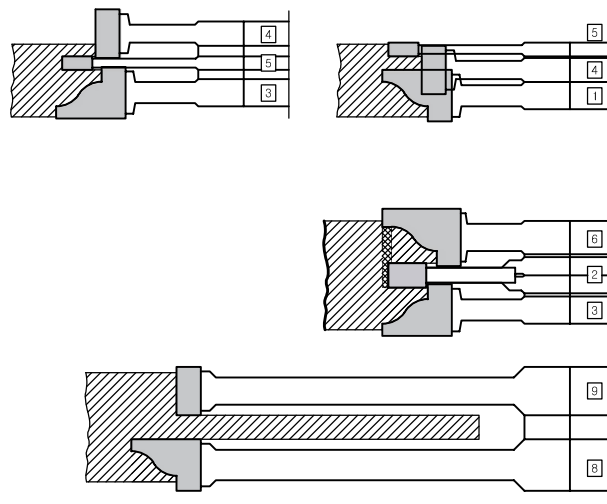
Standard set 1/2/3/4

D mm	BO mm	Z	Position	ID No.
154	30	2	1	331040
150	30	4+2	2	
154	30	2	3	
128	30	2	4	

Extended set 5/6/8/9

D mm	BO mm	Z	Position	ID No.
150	30	4	5	33153
154	30	4	6	33163
320	30	3	8	33183
290	30	3	9	33193

! The standard cutter set includes a set of spacer rings:
ø 60/30 – 3/3×1/0,5/0,2/2×0,1 mm





APPLICATION

Designed for milling profiles and counter-profiles for doors with a shadow gap
Manual feed MAN

WORKPIECE MATERIAL

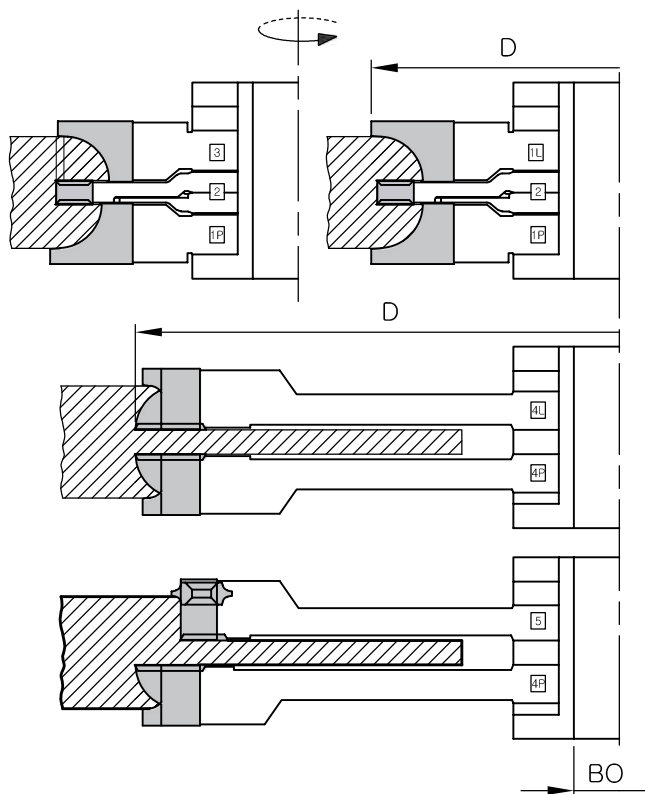
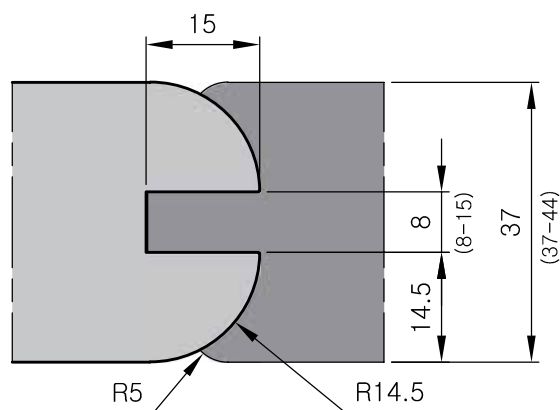
Softwood and hardwood, laminated wood in combination with MDF

OPERATING CONDITIONS

Profiling speed n: 4,500–7,500 RPM
Tenoning speed n: 4,000–5,000 RPM

TECHNICAL SPECIFICATIONS

HW indexable inserts
Z2 configuration
Tools are mounted on sleeves
Adjustable using spacer rings



Standard 5-piece set

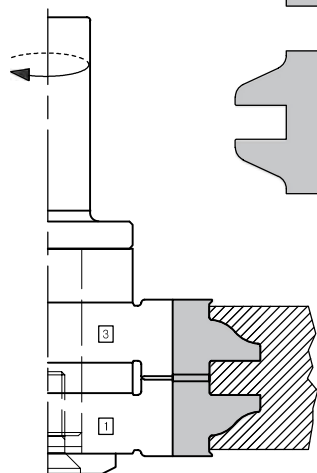
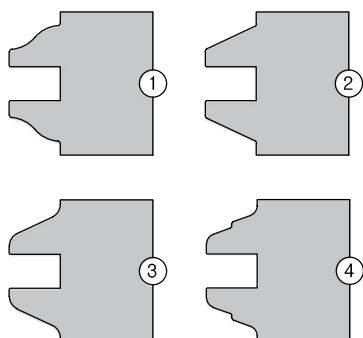
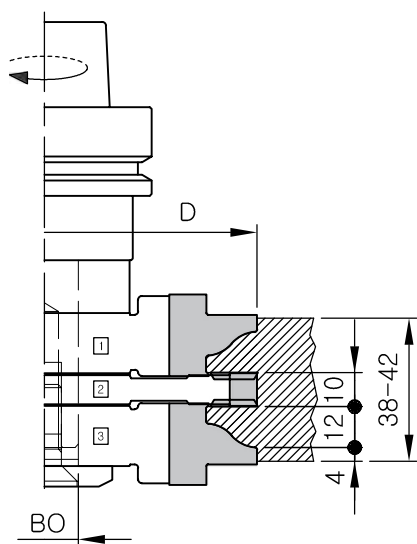
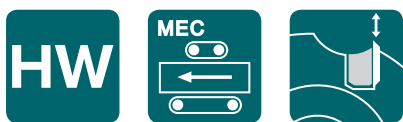
D mm	BO mm	Z	Position	ID No.
174	30	2	1P	331041
174	30	2	1L	
170	30	4+2	2	
320	30	2+2+2	4P	
320	30	2+2+2	4L	

Extended set

D mm	BO mm	Z	Position	ID No.
169	30	2	3	331043
290	30	2+2+2	5	331045

Spare parts

	Position	ID No.
VBD 20×26.7×2	1P	3300411
VBD 20×26.7×2	1L	3300412
VBD 7.5×12×1.5	2	1200712150
VBD 22×22×2	2/4P/4L/5	2102222200
VBD 20×26.7×2	3	330043
VBD 20×22×2	4P	33004411
VBD 20×19.2×2	4P	33004421
VBD 20×22×2	4L	33004412
VBD 20×19.2×2	4L	33004422
VBD 20×12×1.5	5	1102012151
VBD 15×20×7.3-R2	5	3401520730
SCREW M6×0.5 TX20	2/4P/4L/5	710065
SCREW M6×1 TX25	1P/1L/3/4P/4L/5	710058
TX20 KEY		710240
TX25 KEY		710245



One of the possible clamping options

APPLICATION

Designed for milling profiles and counter-profiles for doors without a shadow gap
For CNC machining centres

WORKPIECE MATERIAL

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

OPERATING CONDITIONS

n_{max} : 11,000 RPM

TECHNICAL SPECIFICATIONS

HW – indexable inserts, Z2 configuration
Ability to produce 4 different profiles by simply swapping an indexable insert
To produce the counter-profile, the cutters must be rearranged on the milling arbor

D mm	BO mm	Position	ID No.
125	20	1/2/3	122518627
125	20	1	122518627.1
125	20	3	122518627.3

CNC milling arbor is not included in the scope of delivery

Spare parts	Profile	Position	ID No.
VBD 24×25.2×2	1	1	122518627.1P
VBD 24×25.2×2	1	3	122518627.3P
VBD 24×25.2×2	2	1	122518627.4P
VBD 24×25.2×2	2	3	122518627.5P
VBD 24×25.2×2	3	1	122518627.6P
VBD 24×25.2×2	3	3	122518627.7P
VBD 24×25.2×2	4	1	122518627.8P
VBD 24×25.2×2	4	3	122518627.9P
VBD 9.6×8×1.5	1/2/3/4	2	122518627.2P
VBD 14×14×2	1/2/3/4	2	2101414200
SCREW M6×18 TX25		1/3	710057
SCREW M6×20 TX20		2	710073
SCREW M5×8.5 TX20		2	710064
TX20 KEY			710240
TX25 KEY			710245

! 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	970400
Milling arbor with S25 shank d20×55 RH	900131
Milling arbor ISO 30 d20	On request



APPLICATION

Designed for producing door casings with 14 mm and 12 mm seal rebates
Manual feed MAN

WORKPIECE MATERIAL

Softwood and hardwood, MDF, chipboard

OPERATING CONDITIONS

n: 5,000–8,500 RPM

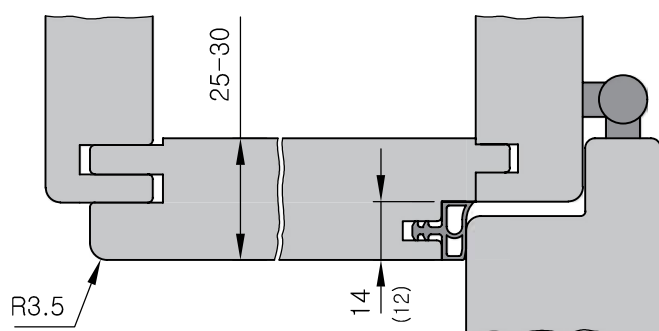
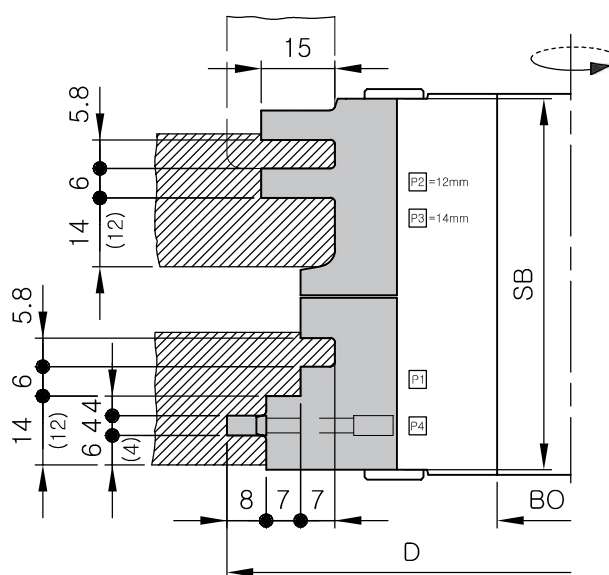
TECHNICAL SPECIFICATIONS

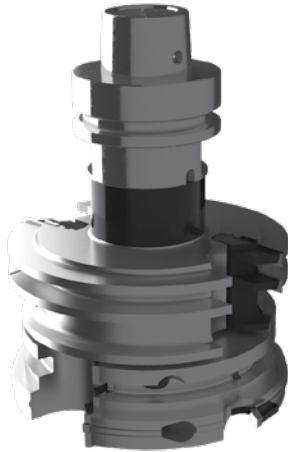
HW indexable inserts Z2

The tool is designed for casing joint production via spindle height adjustment
14 mm and 12 mm seal rebates can be produced by simply swapping
the profile inserts

D mm	SB mm	BO mm	Z	ID No.
140	75.5	30/40	2	49104

Spare parts		ID No.
P1	35×29×2	649111
P2	40×29×2 – 12mm	649121
P3	40×29×2 – 14mm	649141
P4	32×15×4	649131
SCREW M8×20 ISK4		710111
SCREW M5×8.5 TX20		710064
TX20 KEY		710240
ISK4 KEY		710204





APPLICATION

Designed for producing door casings with 14 mm and 12 mm seal rebates
Mechanical feed MEC

WORKPIECE MATERIAL

Softwood and hardwood, MDF, chipboard

OPERATING CONDITIONS

n: 5,000–9,500 RPM

TECHNICAL SPECIFICATIONS

HW indexable inserts Z2

The tool is designed for casing joint production via spindle height adjustment
14 mm and 12 mm seal rebates can be produced by simply swapping
the profile inserts

Tools mounted on an HSK 63 F arbor; the set can be split across two
separate arbors

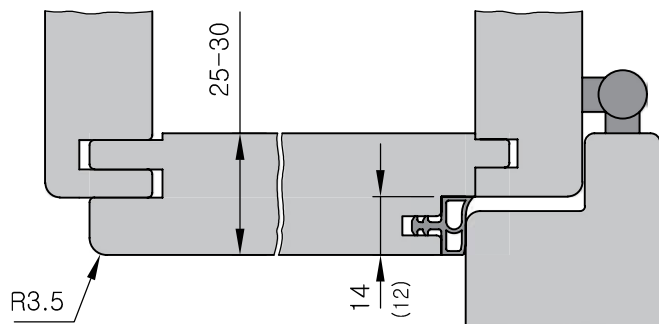
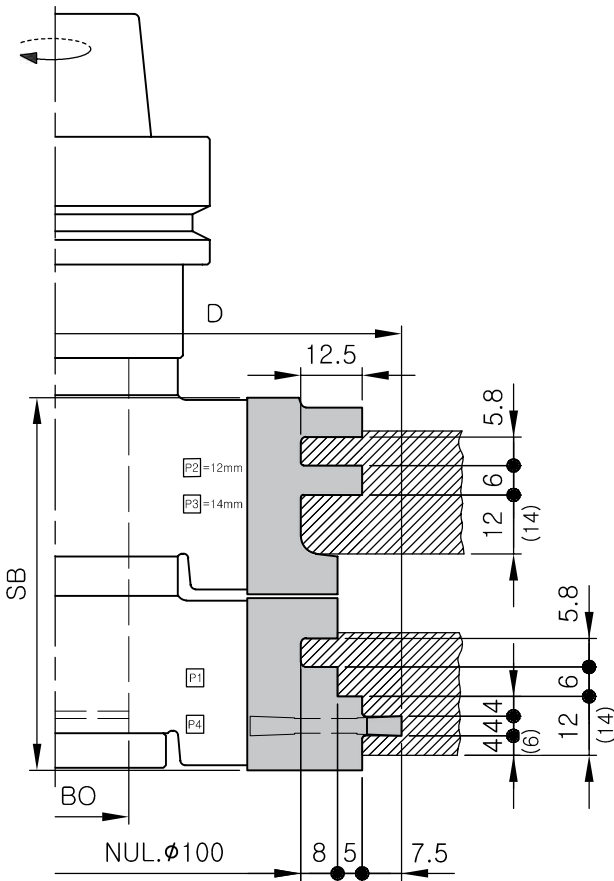
D mm	SB mm	BO mm	Z	ID No.
141	75.5	30	2	49105

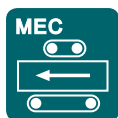
CNC milling arbor is not included in the scope of delivery

Spare parts	ID No.
P1 35×25×2	4910511
P2 40×25×2 – 12mm	4910521
P3 40×25×2 – 14mm	4910522
P4 44×18×4	239836
SCREW M6×18 TX25	710057
SCREW M6×10 TX20	710066
TX20 KEY	710240
TX25 KEY	710245

! 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





APPLICATION

Designed for producing 15 mm door rebate
Mechanical feed MEC

WORKPIECE MATERIAL

Softwood and hardwood, exotic wood,
laminated solid wood in combination with MDF

OPERATING CONDITIONS

n_{max} : 8,000 RPM

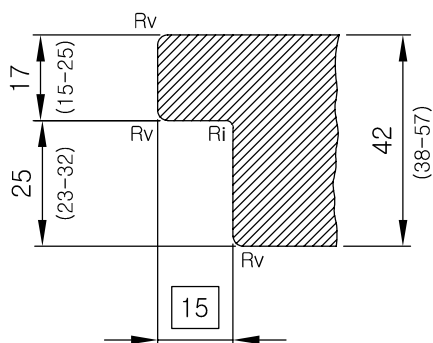
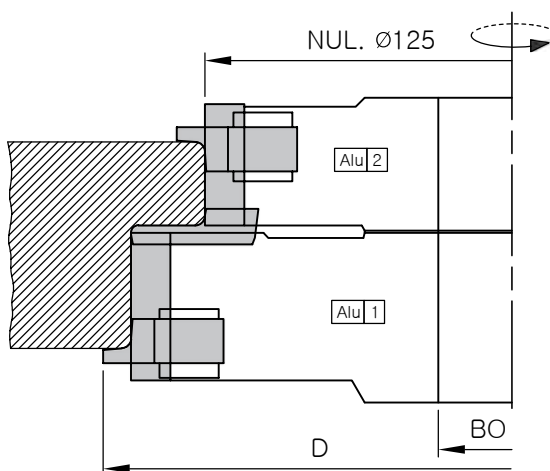
TECHNICAL SPECIFICATIONS

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

D mm	BO mm	Z	ID No.
166	30	2+2	33106
166	40	2+2	33108

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.



Ri – 1/1.5 mm
Rv – 2/2.5/3 mm / 45°



APPLICATION

Designed for milling door panels
Mechanical feed MEC

WORKPIECE MATERIAL

Softwood and hardwood

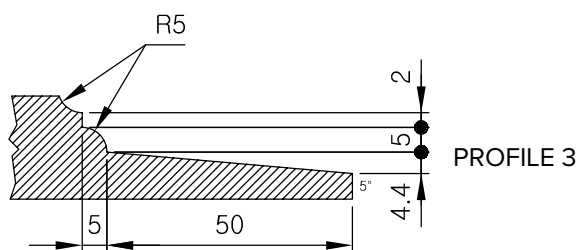
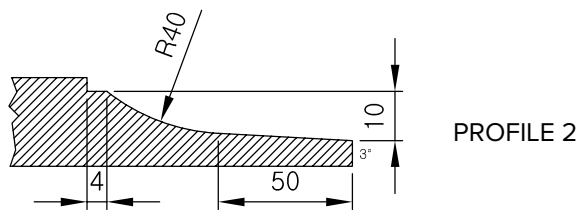
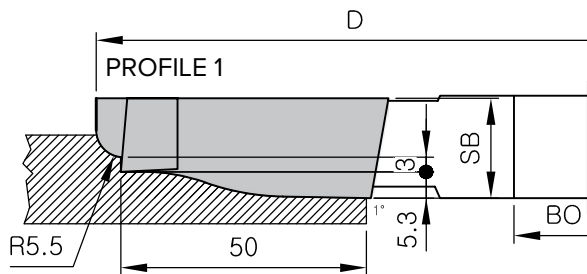
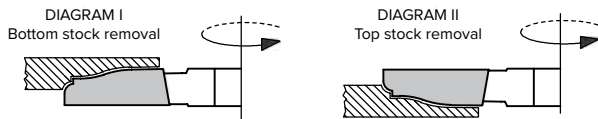
OPERATING CONDITIONS

n_{max} : 6,000 RPM

TECHNICAL SPECIFICATIONS

HW – brazed tips

Profile	D mm	SB mm	BO mm	Z	Diagram I ID No.	Diagram II ID No.
1	200	20	30/40	2+2	48111	48101
2	200	20	30/40	2+2	48112	48102
3	200	20	30/40	2+2	48113	48103





APPLICATION

For longitudinal and cross-grain milling of door panels
Manual feed MAN

WORKPIECE MATERIAL

Softwood and hardwood

OPERATING CONDITIONS

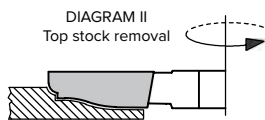
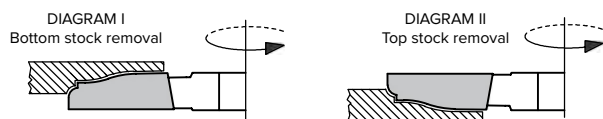
n: 4,000–6,000 RPM

TECHNICAL SPECIFICATIONS

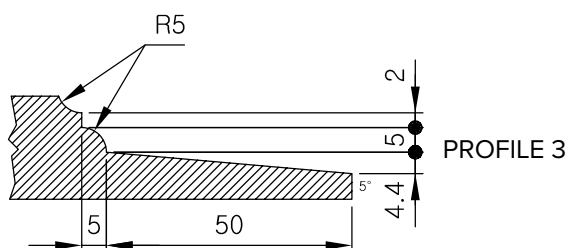
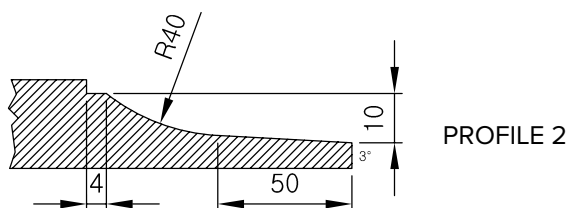
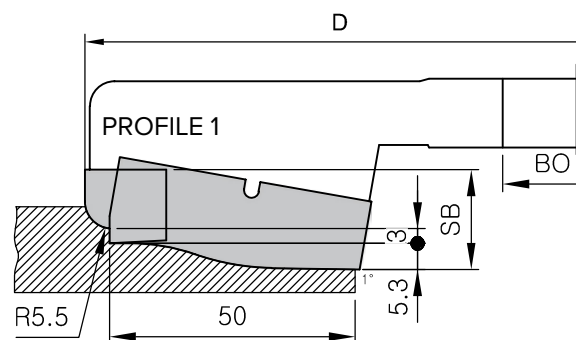
HW indexable inserts

Steel cutter body

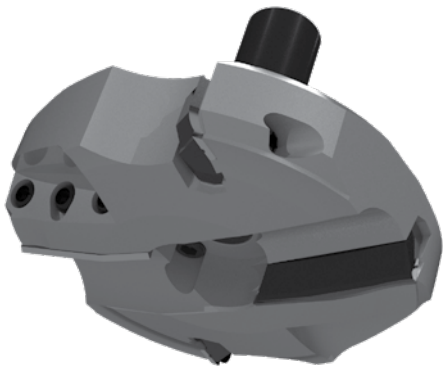
Profile shape and direction of rotation according to customer requirements



Profile	D mm	SB mm	BO mm	Z	Diagram I ID No.	Diagram II ID No.
1	200	20	30/40	2+2	48211	48201
2	200	20	30/40	2+2	48212	48202
3	200	20	30/40	2+2	48213	48203



Spare parts	Position	Diagram I ID No.	Diagram II ID No.
VBD 52.2×14.6×2	1	48211.P2	48201.P2
VBD 15.8×14.5×2	1	48211.P1	48201.P1
VBD 52.2×14.6×2	2	48212.P2	48202.P2
VBD 15.8×14.5×2	2	48212.P1	48202.P1
VBD 52.2×14.6×2	3	48213.P2	48203.P2
VBD 15.8×14.5×2	3	48213.P1	48203.P1
SCREW M6×1-20 TX20			710058
TX25 KEY			710245



APPLICATION

Designed for longitudinal and cross-grain milling of door panels
For CNC machining centres

WORKPIECE MATERIAL

Hardwood and softwood, exotic wood, MDF

OPERATING CONDITIONS

n_{max} : 9,500 RPM

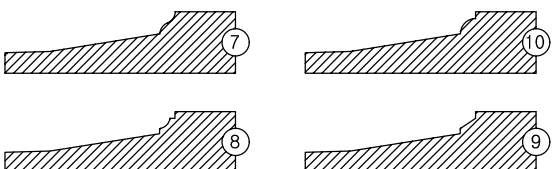
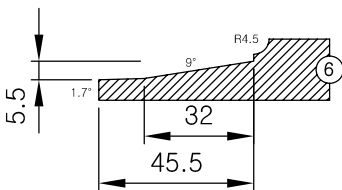
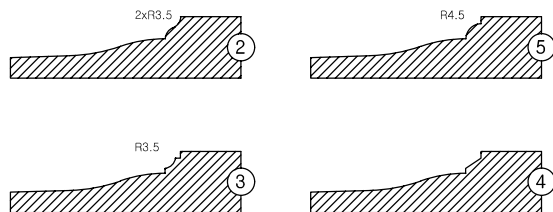
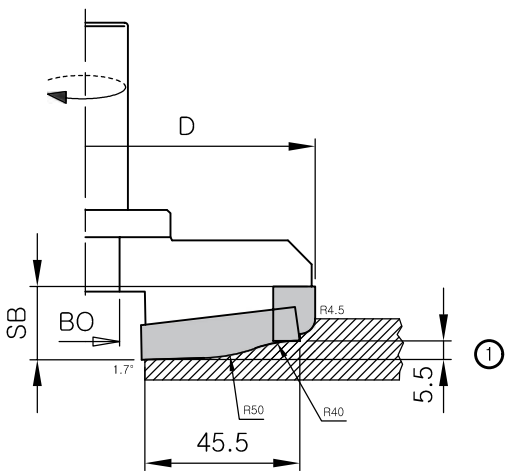
TECHNICAL SPECIFICATIONS

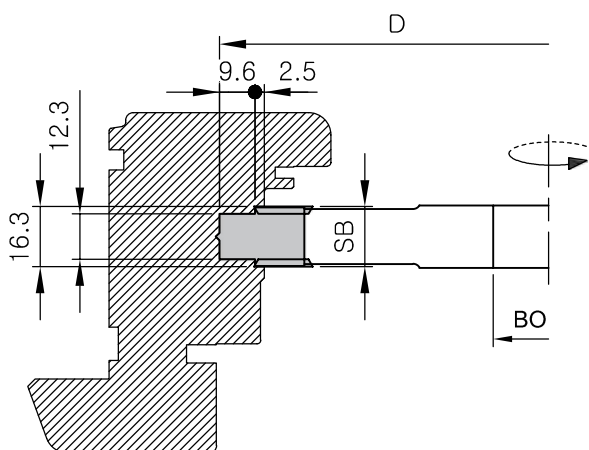
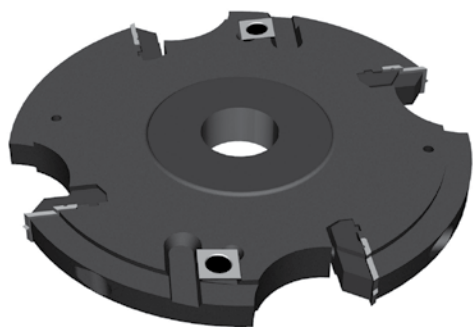
HW – indexable inserts, Z2+2 configuration
Ability to produce 10 different profiles by simply swapping the indexable inserts

D mm	SB mm	BO mm	ID No.
135	20	20	122518626

The milling arbor 20×16-s25 is included in the scope of delivery.
The tool is supplied fitted with one profile (1–10) according to customer requirements.

Spare parts	Profile	ID No.
VBD 16×15×2	1/6	122518626.1I
VBD 16×15×2	2/7	122518626.2I
VBD 16×15×2	3/8	122518626.3I
VBD 16×15×2	4/9	122518626.4I
VBD 16×15×2	5/10	122518626.5I
VBD 52.1×12×2	1/2/3/4/5	122518626.6I
VBD 52.1×11.1×2	6/7/8/9/10	122518626.7I
SCREW M6×20 TX20		710073
TX20 KEY		710240





APPLICATION

Designed for milling hardware grooves in windows and doors
Manual feed MAN

WORKPIECE MATERIAL

Hardwood and softwood

OPERATING CONDITIONS

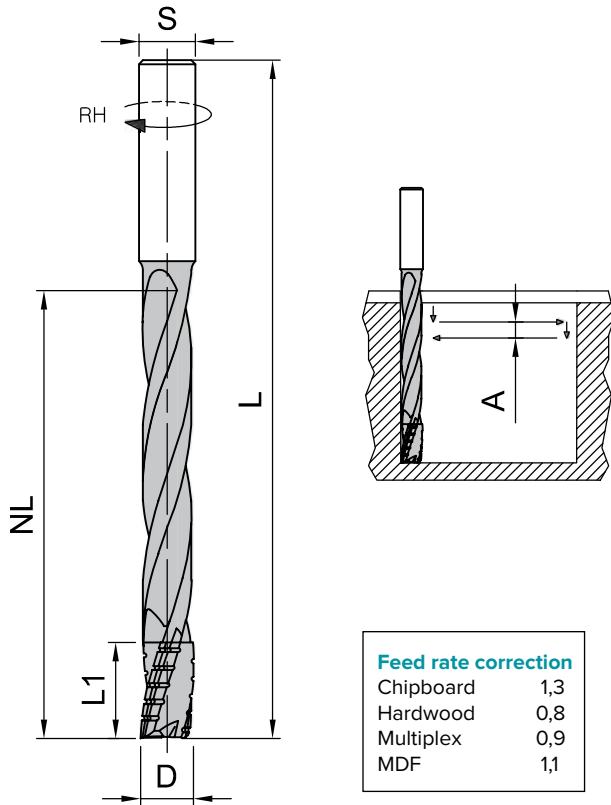
n: 4,000–7,500 RPM

TECHNICAL SPECIFICATIONS

HW indexable insert Z4+2+2
Steel body

D mm	SB mm	BO mm	Z	n RPM	ID No.
180	16.3	30/40	4+2+2	4,000–7,500	13300

Spare parts	Application	ID No.
VBD 14×14×2	Softwood and hardwood	2101414200
VBD 15.9×20×2		13300.P
SCREW M5×8.5 TX20		710064
SCREW M6×20 TX25		710058
TX20 KEY		710240
TX25 KEY		710245



Feed rate correction	
Chipboard	1,3
Hardwood	0,8
Multiplex	0,9
MDF	1,1

APPLICATION

High-quality finish milling of blind holes and door lock mortises
For CNC machining centres

WORKPIECE MATERIAL

Hardwood and softwood, exotic wood, MDF

OPERATING CONDITIONS

n_{max} : 24,000 RPM

TECHNICAL SPECIFICATIONS

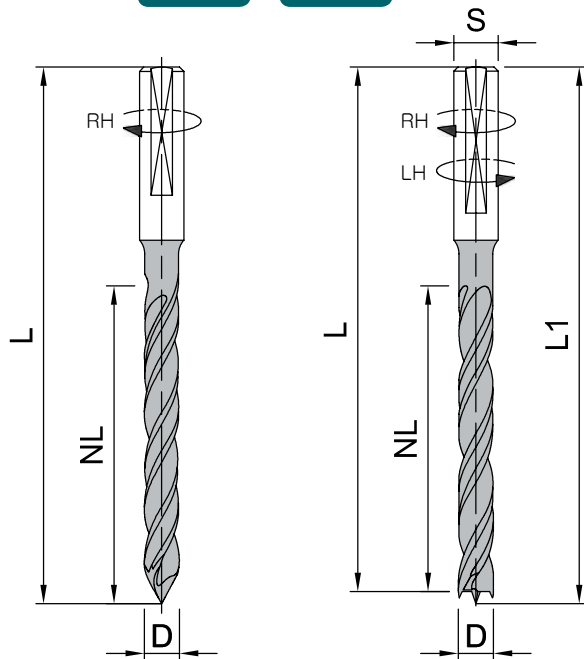
Solid HW cutter
Z3 configuration
Positive spiral angle
Cutting edges with RAPTOR-style grinding

D mm	L1 mm	NL mm	L mm	S mm	ID No.
14	25	120	175	16	101143175
16	25	120	175	16	101163175

Operating parameters for softwood:

D mm	A mm	RPM	Feed m/min
14	4–8	12,000–18,000	10–12
16	6–10	12,000–18,000	12–14

\\ Spiral Drill Bit—through-hole/blind-hole



Operating parameters	
RPM	Ax. feed m/min
3,000–5,000	1.5–2
5,000–8,000	2–3.5

APPLICATION

For drilling deep through-holes and blind holes
Manual feed MAN

WORKPIECE MATERIAL

Softwood and hardwood, exotic hardwood, laminated solid wood sections

OPERATING CONDITIONS

n : 3,000–9,000 RPM

TECHNICAL SPECIFICATIONS

HW – solid drill bit, extra long with double spiral flute
For smooth chip removal
Centring point enables angled drilling
Z2 configuration—through-hole drill bit; Z2+V2 with centring point and spurs—blind-hole drill bit

Through-hole drill bit

D mm	NL mm	L mm	S mm	DRI	ID No.
8	90	130	10	RH	102080130
10	120	160	10	RH	102100160
12	120	160	10	RH	102120160

Blind-hole drill bit

D mm	NL mm	L mm	L1 mm	S mm	DRI	ID No.
8	90	125	130	10	RH	103080130
					LH	103081130
10	90	124	130	10	RH	103100130
					LH	103101130
12	90	124	130	10	RH	103120130
					LH	103121130



We manufacture high-quality tools and tool sets for windows and doors using state-of-the-art CNC technology. The cutting tips and inserts offer a long service life, and their cutting geometry ensures a high-quality surface finish. The insert/tip material is specifically designed for machining laminated solid wood. Replacement of indexable inserts is precise in both radial and axial directions, achieving high accuracy in terms of radial and axial run-out. Individual sets are precisely adjusted and balanced to a high degree of accuracy with minimal residual unbalance.

Tool Sets for Euro-Windows//

APPLICATION

These tool sets are designed for window production
We manufacture tools for various machines – spindle moulders, multi-side moulders, window and door production centres, and CNC machining centres

WORKPIECE MATERIAL

Laminated softwood and hardwood sections

TECHNICAL SPECIFICATIONS

Sets are available in brazed or indexable insert versions
The cutting geometry of the inserts is optimised for high-quality profile finishing —axial rake angle
Individual profiles consist of several cutters adjusted on clamping sleeves or CNC tool holders, which maintain a consistent zero-line for both height and diameter
The standard set can be used to produce single and double-sash windows, glazing beads, inner sash counter-profiles, and outer frame machining
The sets can be modified and expanded with additional milling sets (frame counter-profiles, outer sash counter-profiling, tools for combined joints of opening and fixed sashes...)

OPERATING CONDITIONS

Operating conditions are specified on the individual tool sets
(max. operating speed and recommended feed rate)

SUPPLIED WITH THE TOOLS

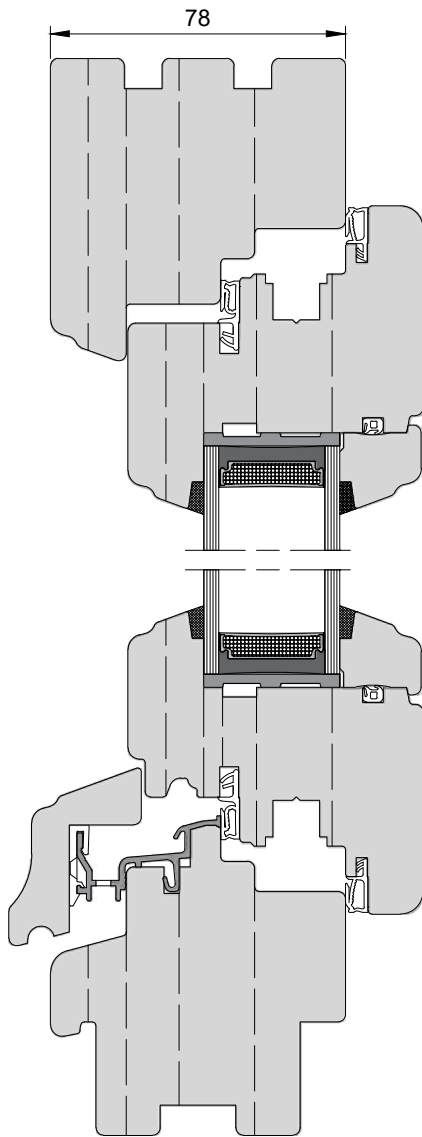
Detailed technical manual
Tool layout on the machine, specifying the set-up positions for the given machine
Dimensioned cross-sections of individual profiles at 1:1 scale in PDF, DWG and DXF formats
Detailed assembly drawings of individual sets at 1:1 scale
For indexable versions—detailed list of replacement inserts including identification numbers
Detailed list of screws used

CUSTOMER SUPPORT

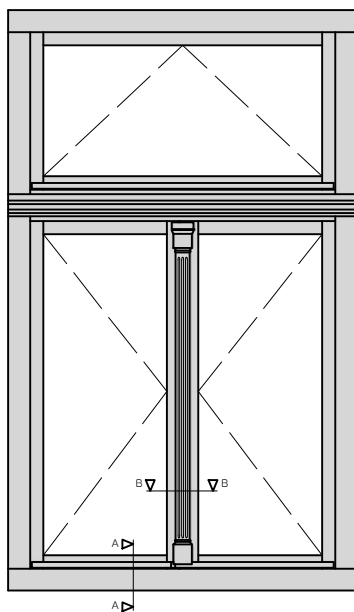
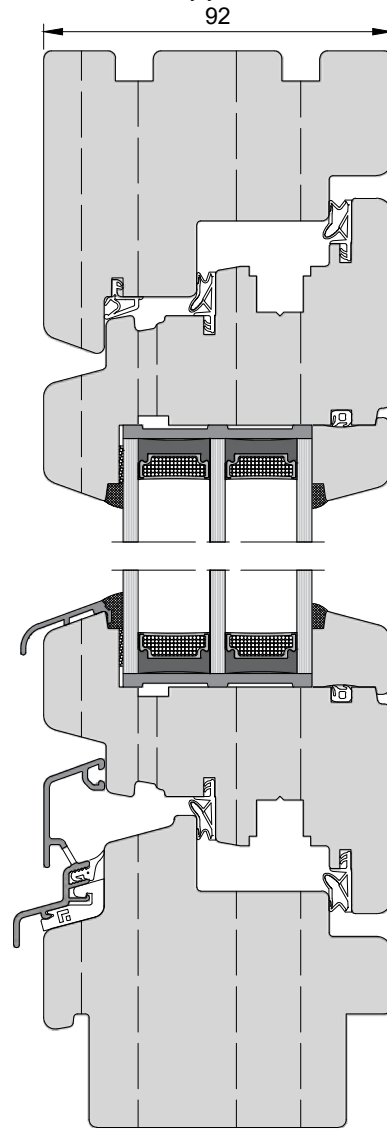
We provide technical consultancy in the field of production technology
Dimensional and profile layouts
We collaborate with machine tool manufacturers and suppliers
We consult individual steps with suppliers of window accessories (hardware, seals, aluminium cladding...)
We respond flexibly to the latest trends in the field and keep our customers informed
We provide full warranty and post-warranty servicing for our tools



EURO-WINDOW version—IV78-IV92 with all-wood capping in rustic profile

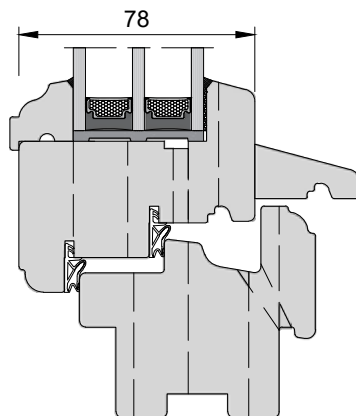


EURO-WINDOW version—IV92 External and internal flush-mounted sash and frame with concealed hardware

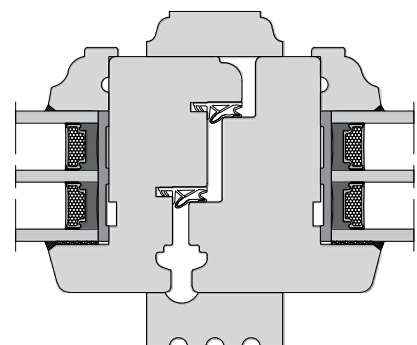


EURO-WINDOW version—IV78 Rustic profile designed for heritage conservation areas without aluminium components

Section A-A



Section B-B





APPLICATION

Tool sets are designed for the production of windows intended for subsequent aluminium cladding
 We manufacture tools for spindle moulders, multi-side moulders, window and door production centres, and CNC machining centres

WORKPIECE MATERIAL

Laminated softwood and hardwood sections

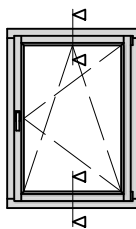
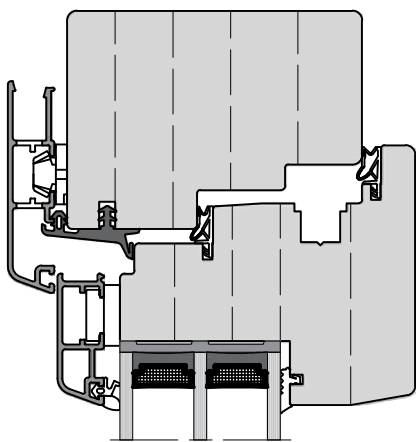
TECHNICAL SPECIFICATIONS

We manufacture tool sets with indexable inserts
 The cutting geometry of the inserts is optimised for high-quality profile finishing
 —axial rake angle
 Individual profiles consist of several cutters adjusted on clamping sleeves or CNC holders, which maintain a consistent zero-line for both height and diameter

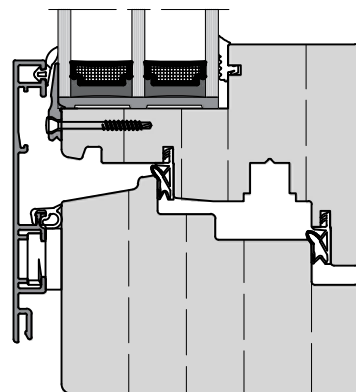
CUSTOMER SUPPORT

We provide technical consultancy in the field of production technology, dimensional and profiling layouts
 We collaborate with machine tool manufacturers and suppliers
 We consult individual steps with suppliers of window accessories (aluminium cladding, hardware, seals...)
 We respond flexibly to the latest industry trends and keep our customers informed
 We provide full warranty and post-warranty servicing for our tools

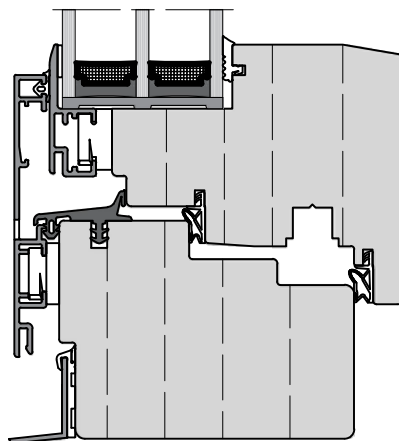
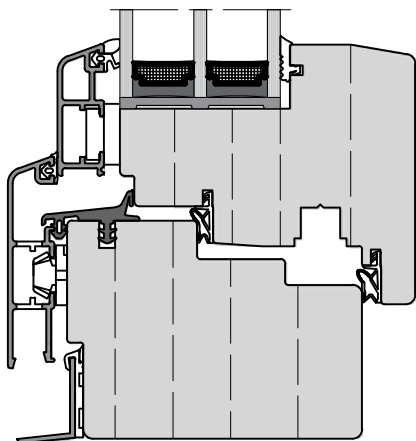
Version 1



Version 2

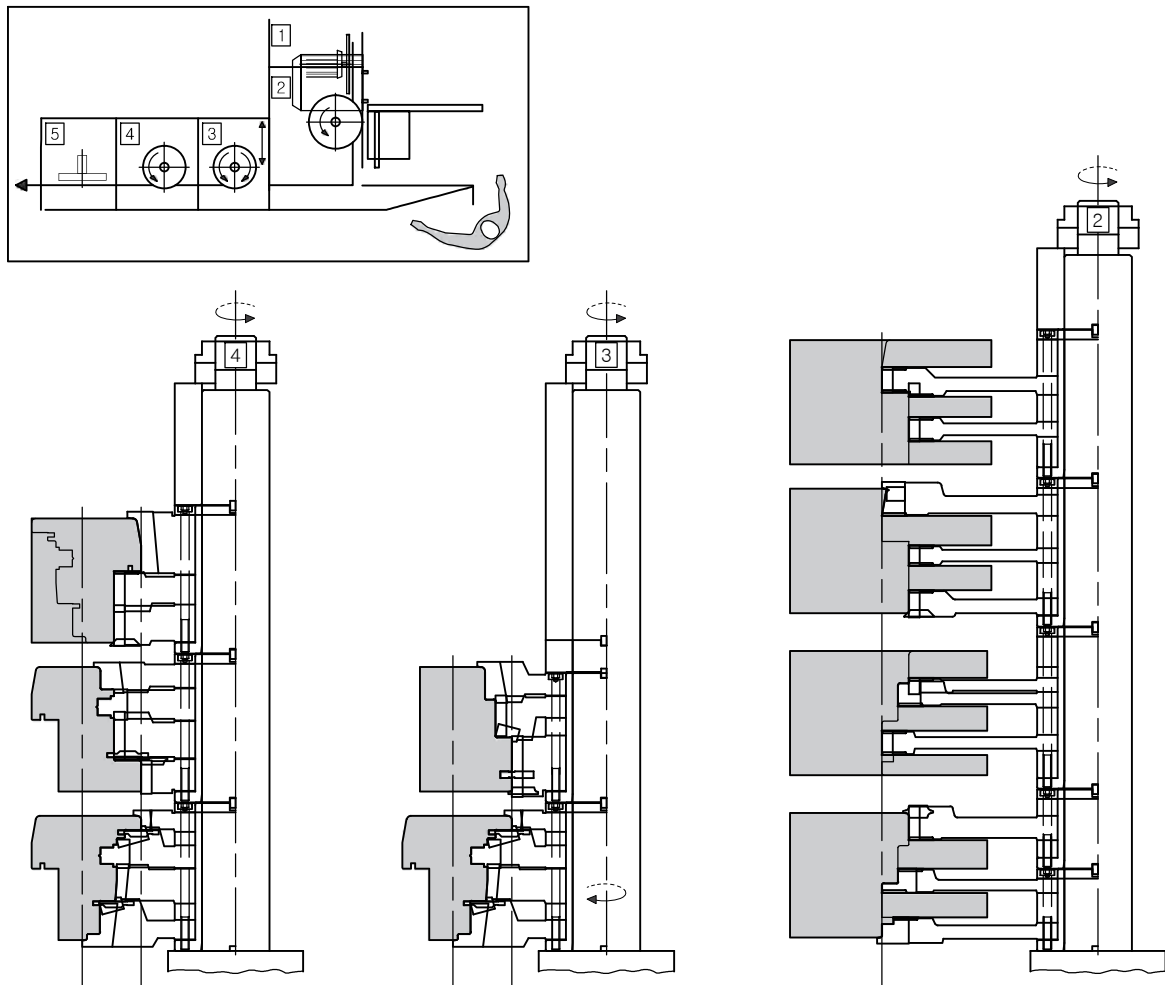


Version 3



Layout of window corner production centre and subsequent tool set arrangement on individual spindles //

Example



Max. RPM: 6500
 Recommended RPM: 6000
 Longitudinal feed rate: 6mm/min
 Transverse feed rate: ---m/min

92
10

R3

4

3

2 | ALU

1

151x15x40

DK-12

202x30.7x40

DK-0.7

178.1x26.5x40

DK-15.8

229x38x40

DK-0.5

P-40/30-105

⊙ R1
 ⊙ R1.5

	VYDONA s.r.o. Právčice 244 76324 Hulín, CZ tel: +420 573 351361 fax: +420 573 301370 e-mail: info@vydona.cz www.vydona.cz	WOOD / AL EURO-WINDOW-IV92	ASSEMBLY NAME: OUTER SASH PROFILE																																																												
	DRAWING NO: 190005-Ke DATE: 23.6.2015 PREPARED BY: Stanislav Vančura	ASSEMBLY NUMBER: 90005-Ke	TOOL: HW-VBD, z2 (2+2)																																																												
		<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th>POS.</th> <th>TOOL NUMBER</th> <th></th> <th></th> <th></th> <th></th> <th></th> <th></th> <th></th> <th></th> </tr> </thead> <tbody> <tr> <td>1</td> <td>190005.1</td> <td>190005.11P</td> <td>4</td> <td>190005.12P</td> <td>2</td> <td></td> <td></td> <td></td> <td>190005-25x15x3</td> </tr> <tr> <td>2</td> <td>190005.2</td> <td>190005.2P</td> <td>2</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>3</td> <td>190005.3</td> <td>190005.31P</td> <td>2</td> <td>1916-163P - R1</td> <td>2</td> <td></td> <td></td> <td></td> <td>190005-25x15x3</td> </tr> <tr> <td>4</td> <td>190005.4</td> <td>190005.41P</td> <td>2</td> <td>190005.32P</td> <td>2</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td>190005.42P</td> <td>2</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>	POS.	TOOL NUMBER									1	190005.1	190005.11P	4	190005.12P	2				190005-25x15x3	2	190005.2	190005.2P	2							3	190005.3	190005.31P	2	1916-163P - R1	2				190005-25x15x3	4	190005.4	190005.41P	2	190005.32P	2							190005.42P	2							
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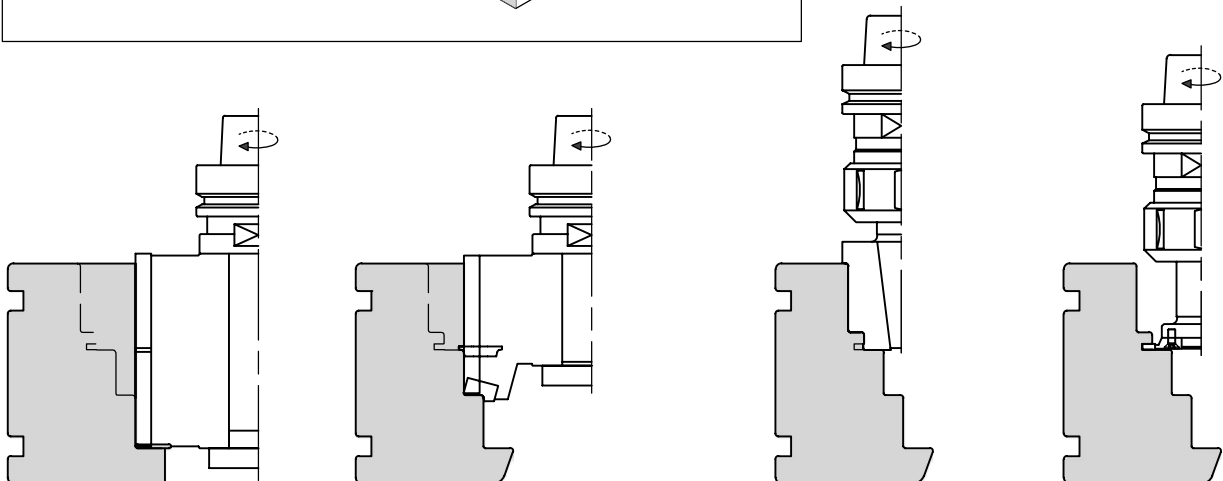
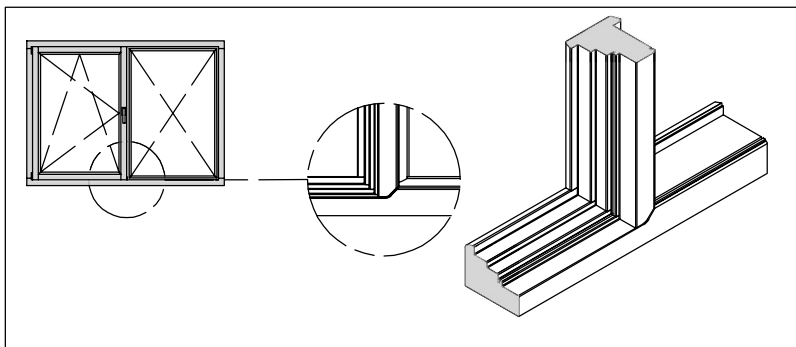
All rights to this drawing are the property of Vydona s.r.o. No part of this drawing may be reproduced or disclosed to any third party without prior written consent

Layout of window corner production centre and subsequent tool set arrangement on individual spindles

Tooling configuration for HSK63F tool holders



HSK63F tool holder configuration for the fixed/opening glazing machining system—“FALZWECHSEL”





APPLICATION

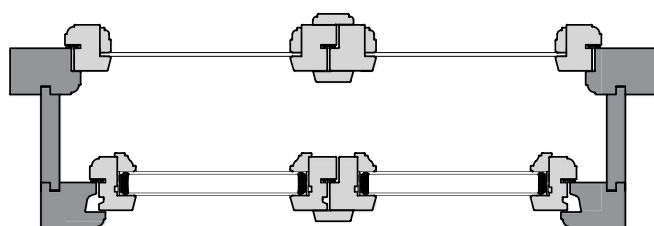
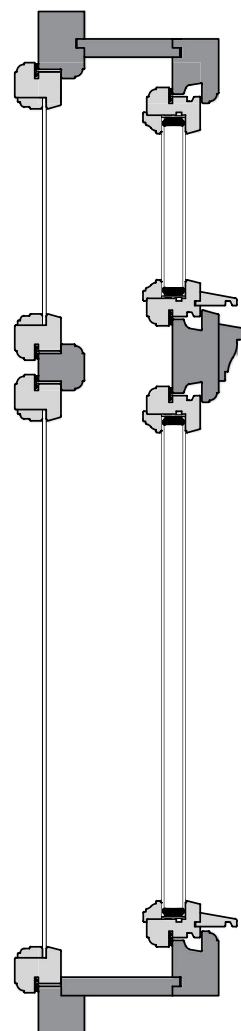
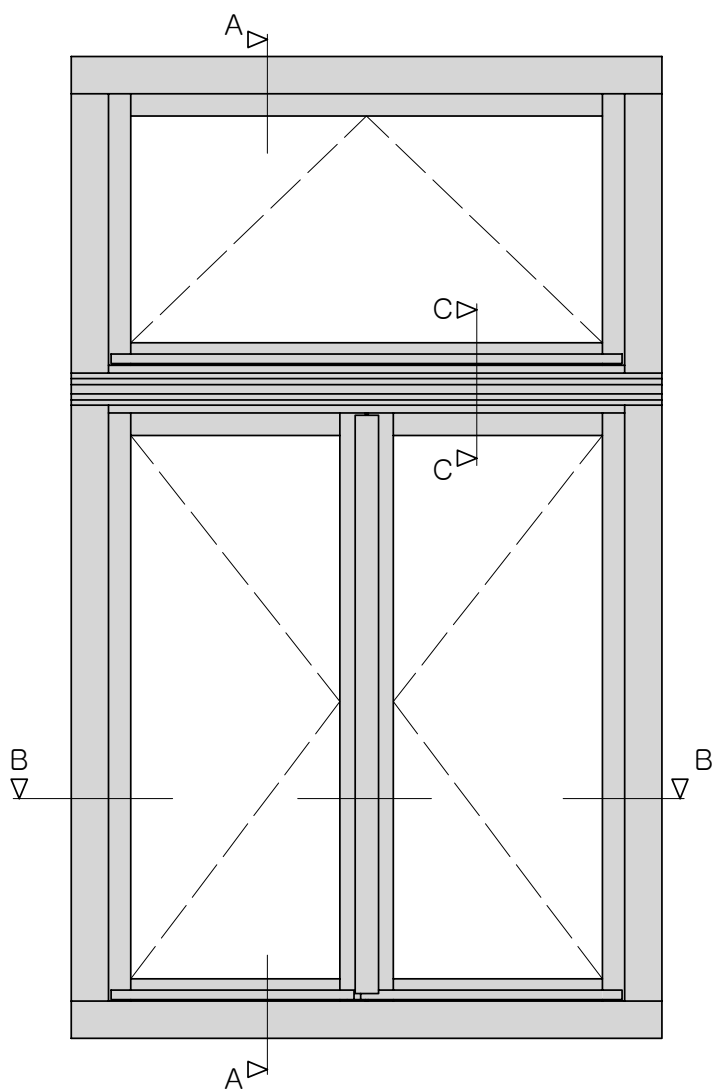
These tool sets are designed for the production of windows for heritage-protected buildings
 We manufacture tools for spindle moulders, multi-side moulders, window and door production centres, and CNC machining centres

WORKPIECE MATERIAL

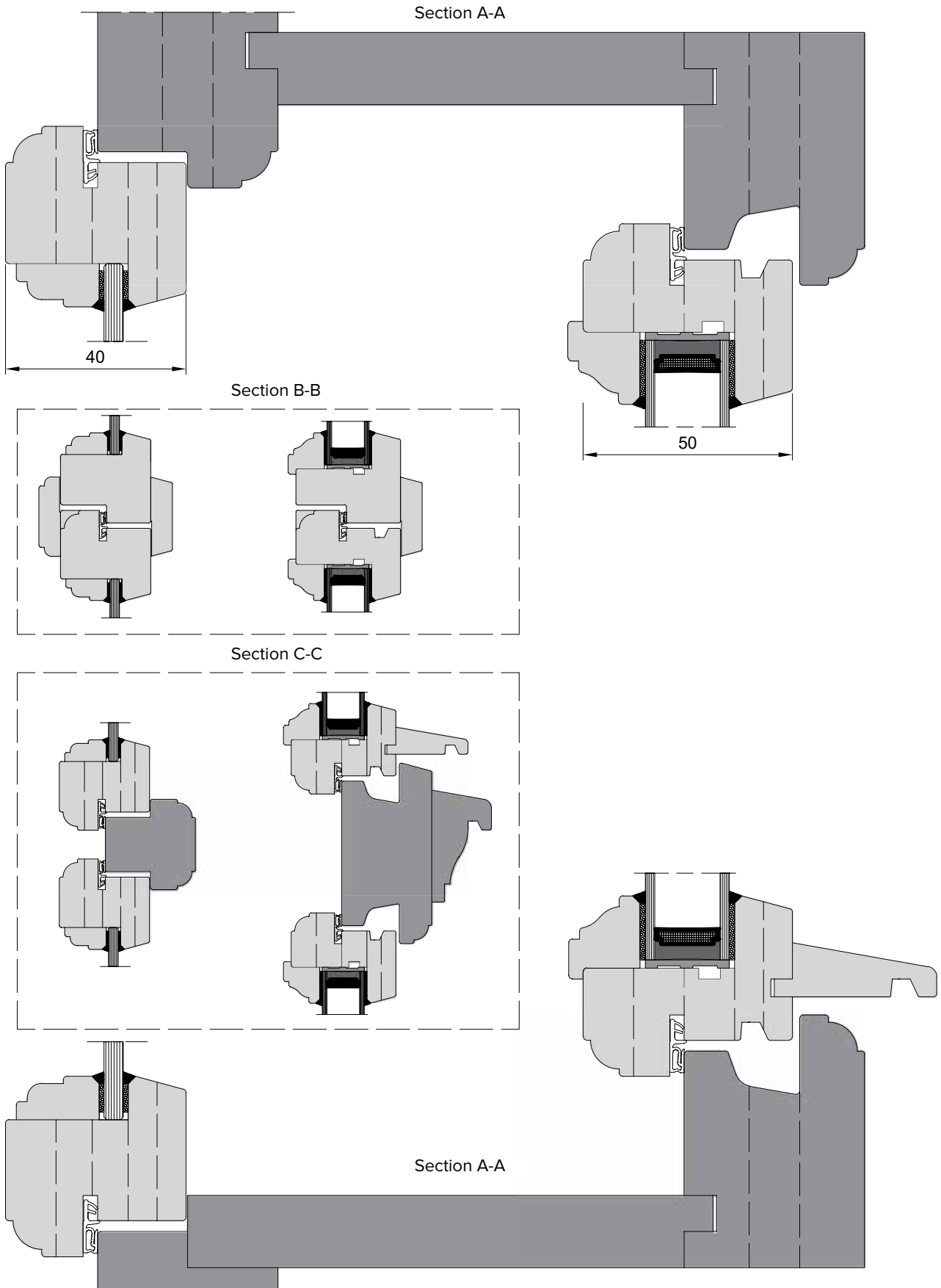
Softwood and hardwood
 Laminated softwood and hardwood sections

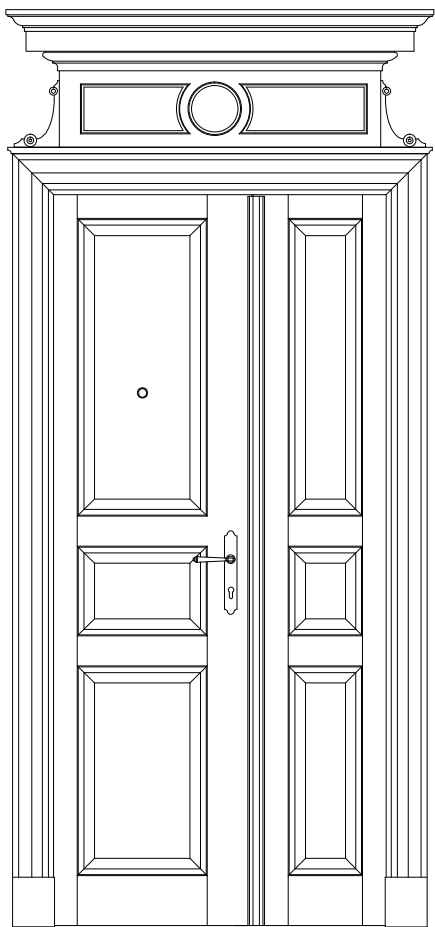
CUSTOMER SUPPORT

We provide technical consultancy in the field of production technology, dimensional and profile layouts
 We collaborate closely with architects and the National Heritage Institute (NPÚ)
 Documentation can be created based on a physical window sample
 We provide comprehensive digital documentation for further processing and official approval processes
 We provide full warranty and post-warranty servicing for our tools



NATIONAL
 HERITAGE
 INSTITUTE



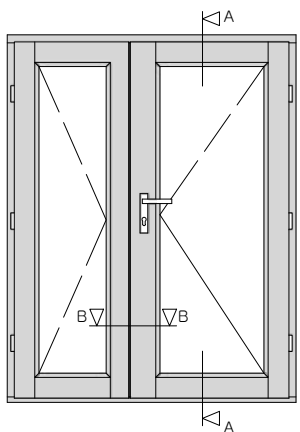


APPLICATION

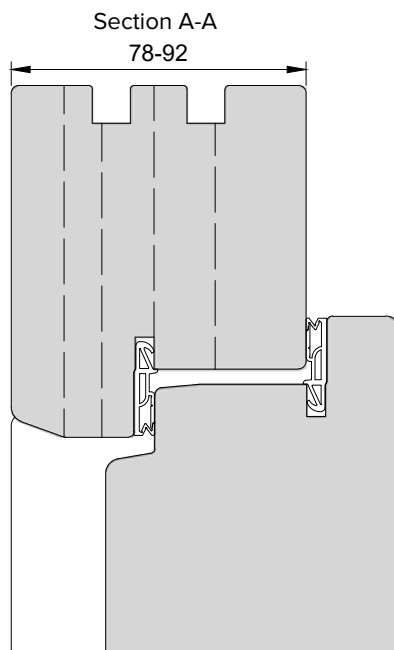
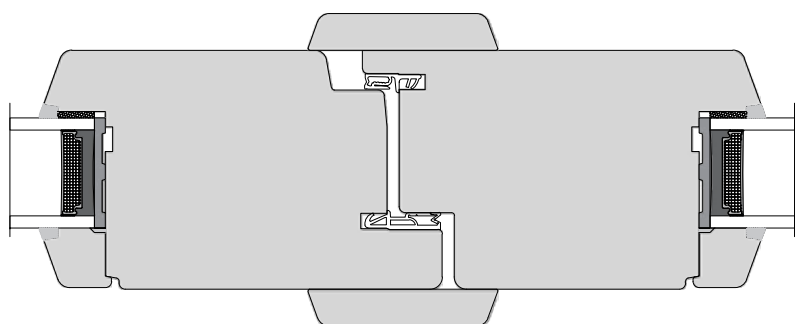
The tool sets are designed for the production of entrance doors in a single-rebate design

CUSTOMER SUPPORT

- We provide technical consultancy in the field of production technology, dimensional and profiling layouts
- We collaborate with machine tool manufacturers and suppliers
- We consult individual steps with suppliers of door accessories (hardware, seals...)
- We respond flexibly to the latest industry trends and keep our customers informed
- We provide full warranty and post-warranty servicing for our tools



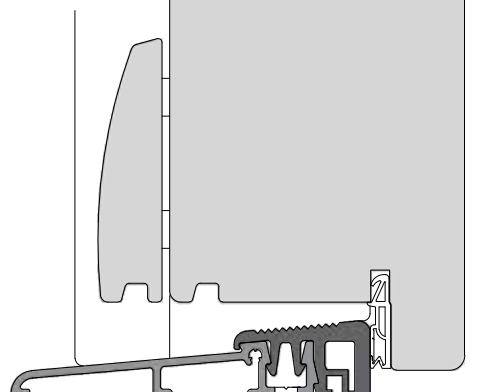
Section B-B



Section A-A
78-92

Single-sided lipping

Double-sided lipping





APPLICATION

The tool sets are designed for the production of entrance doors in a double-rebate design. We manufacture tools for spindle moulders and multi-side moulders, window and door production centres, and CNC machining centres.

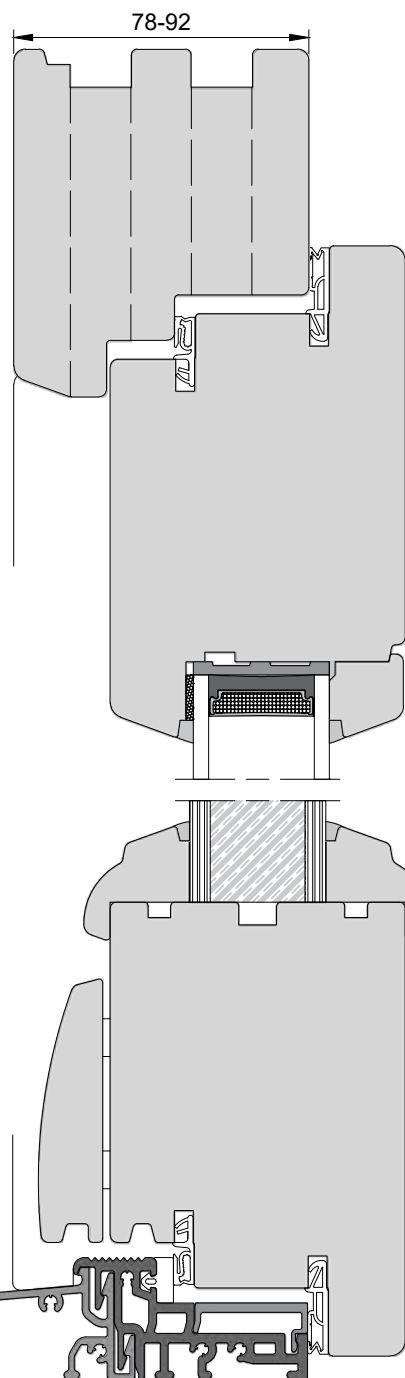
WORKPIECE MATERIAL

Laminated softwood and hardwood sections

TECHNICAL SPECIFICATIONS

The sets are manufactured in both brazed and indexable insert versions. The cutting geometry of the inserts is optimised for high-quality profile finishing —axial rake angle. Individual profiles consist of several cutters adjusted on clamping sleeves or CNC holders, which maintain a consistent zero-line for both height and diameter.

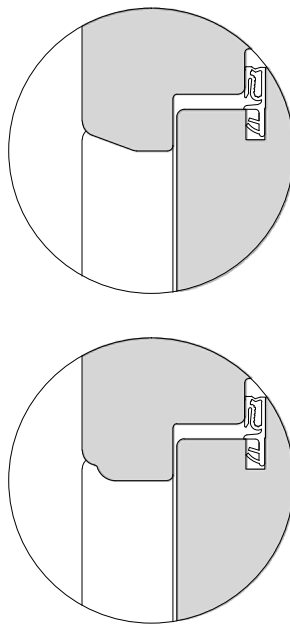
Section A-A



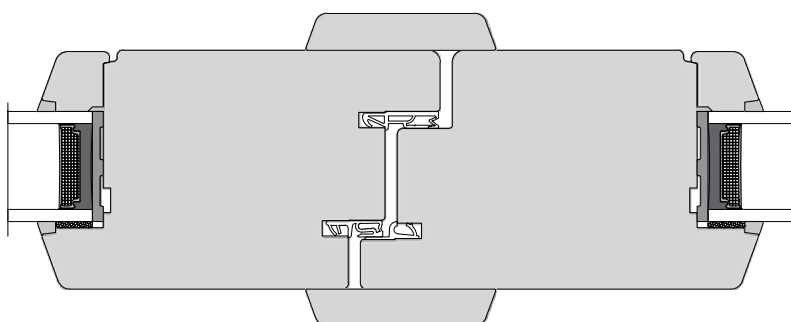
Single-sided lipping

Double-sided lipping

Exterior frame overlap variants



Section B-B





APPLICATION

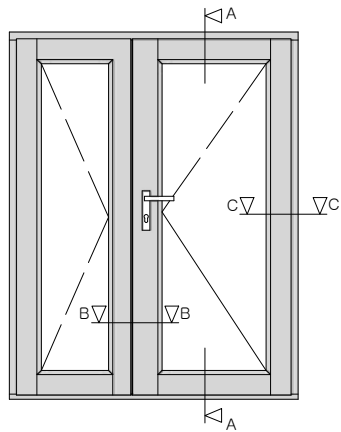
These tool sets are designed for the production of double-rebated entrance doors where the door sash is flush with the frame on both the interior and exterior sides

WORKPIECE MATERIAL

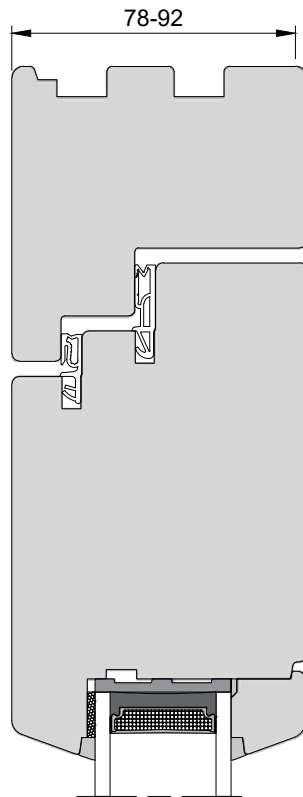
Laminated softwood and hardwood sections

TECHNICAL SPECIFICATIONS

The sets are manufactured in both brazed and indexable insert versions
 The cutting geometry of the inserts is optimised for high-quality profile finishing —axial rake angle
 Individual profiles consist of several cutters adjusted on clamping sleeves or CNC holders, which maintain a consistent zero-line for both height and diameter

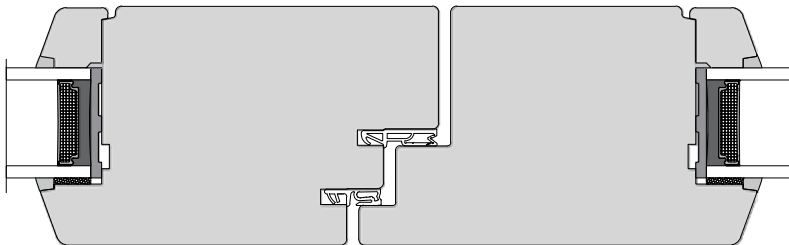


Section A-A



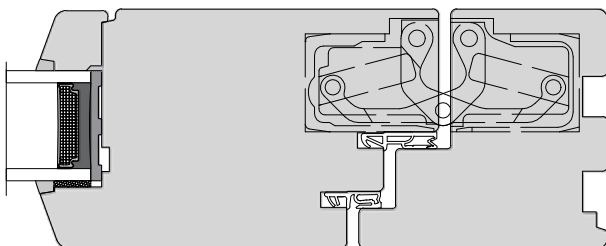
Single-sided lipping

Section B-B

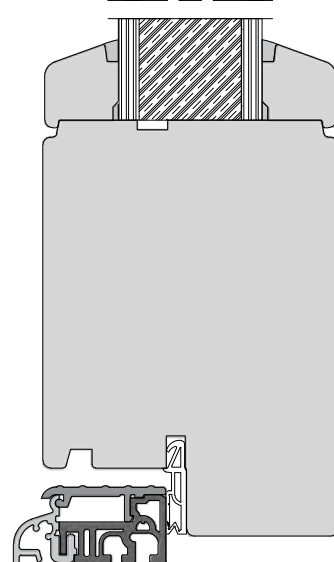


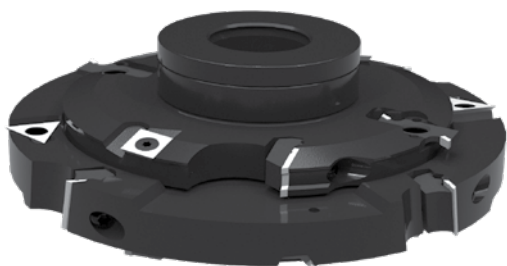
Double-sided lipping

Section C-C



Concealed recessed hardware





APPLICATION

For milling guide grooves and lock mortises for HS-PORTAL sliding doors
Designed for use on spindle moulders and multi-side moulders
Manual feed MAN

WORKPIECE MATERIAL

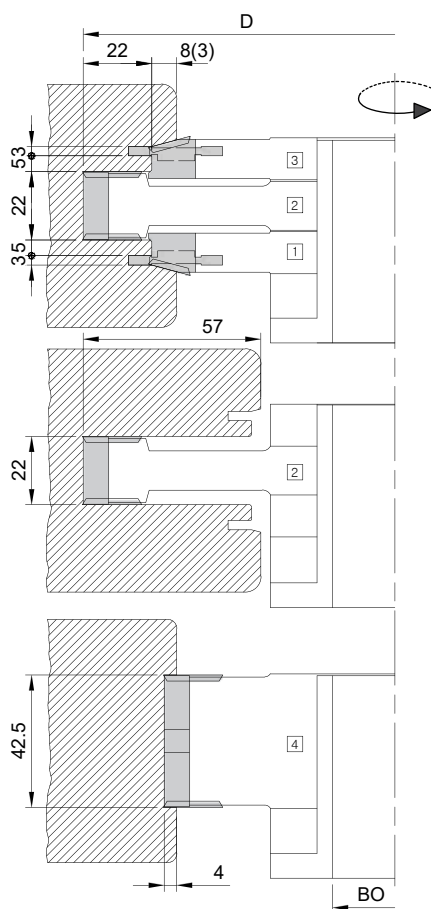
Softwood and hardwood

OPERATING CONDITIONS

n: 4,000–7,000 RPM
v_f: 4–8 m/min

TECHNICAL SPECIFICATIONS

HW indexable inserts Z2
Cutter body—steel
Individual tools are assembled on a clamping sleeve
Optional clamping diameter 30 mm, 40 mm—must be specified when ordering



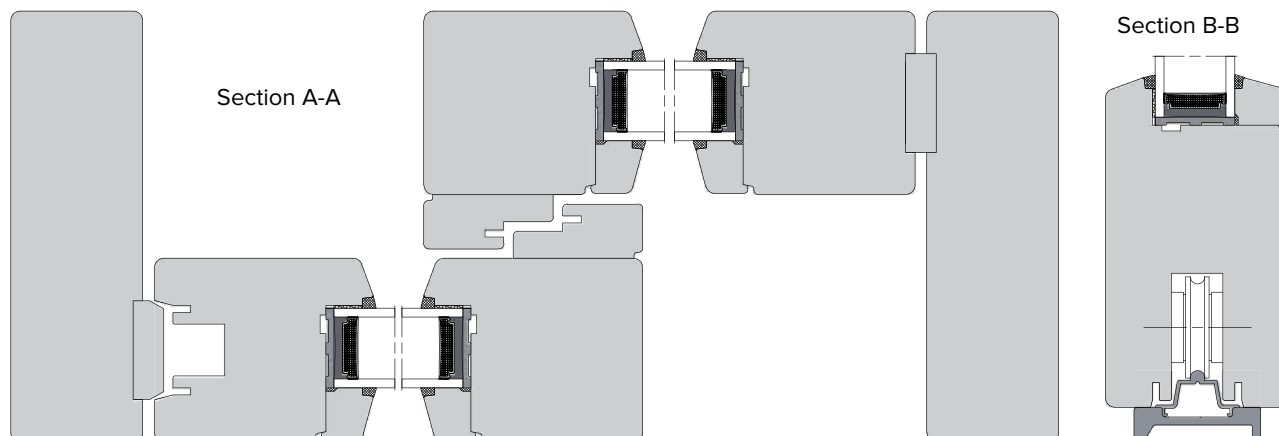
4-piece cutter set

D mm	BO mm	Z	Position	ID No.
200	30/40	2	1–4	217215094

Individual tools

D mm	B mm	BO mm	Z	Position	ID No.
171	13	50	2+2+2	1	2172150941
200	22	50	2+2+2	2	2172150942
171	13	50	2+2+2	3	2172150943
148	42.5	50	2+2+2	4	2172150944

Spare parts	Position	ID No.
VBD 14×14×2	1, 3	2201414200
VBD 22×22×2	2,4	2102222200
VBD 21.6×8×1.5	2	2172150942P
VBD 12.5×17.6×2	1	2172150941P
VBD 12.5×17.6×2	3	2172150943P
VBD 24.7×8×15	4	4202408150
CUTTING INSERT 35.2×15×3	1	139833
CUTTING INSERT 35.2×15×3	3	139834
SCREW M5×8.5 TX20	1, 2, 3	710064
SCREW M6×10 TX20	1, 3	710066
SCREW M6×20 TX20	1, 2, 3	710058
TX20 KEY		710240





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)



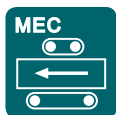
INDEXABLE INSERT WITH DP CUTTING TIP ©



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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