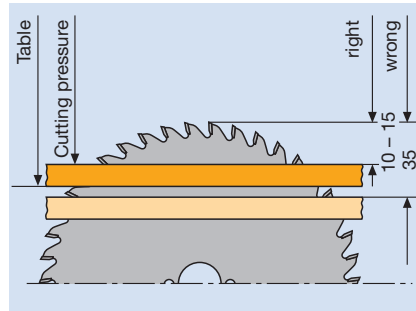


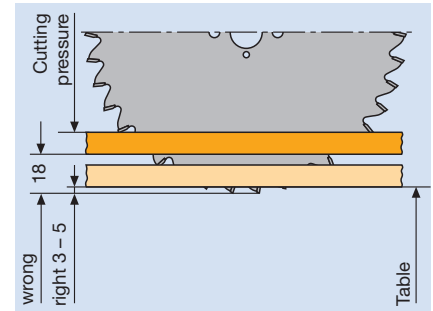
1. Sawing

1.4 Sizing

<b>Working process</b>	For cross cutting and sizing; grooving and cutting also possible if safety regulations are followed.
<b>Workpiece materials</b>	Solid wood, wood derived materials, synthetic materials and light metals.
<b>Machines</b>	Table saws, sizing machines with/without pre-scoring unit, vertical panel sizing saws and twin-saw dimensions saws.
<b>Application</b>	Suitable for cutting from below against the feed. On vertical panel sizing machines and twin-saw dimensions saws cutting either below or above against the feed.



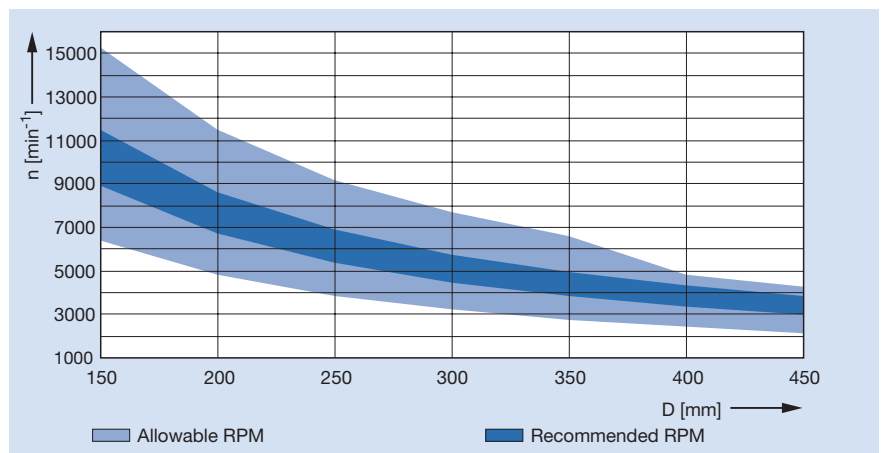
For sawblades with a positive cutting angle and the spindle below the workpiece. The positive cutting angle presses the material onto the table.



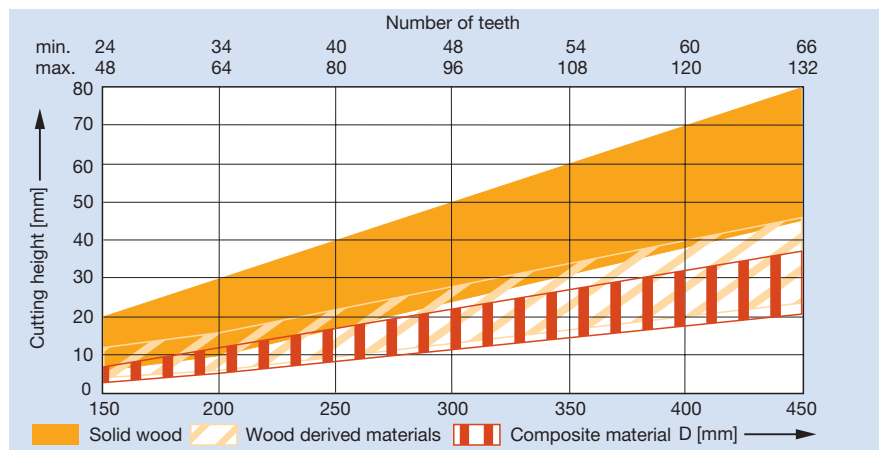
For sawblades with a negative cutting angle and the spindle above the workpiece. The negative cutting angle presses the material onto the table.

On radial saw machines, sawblades must be used (see EN1870-17) with a negative cutting angle against the feed.

RPM diagram



Cutting height diagram

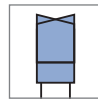


Sizing sawblades – cutting height  $a_c$  depending on sawblade diameter  $D$  and workpiece material.

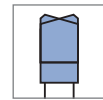
# 1. Sawing

## 1.4 Sizing

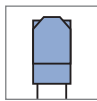
### Tooth shape



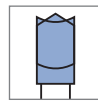
**WZ (alternative top bevel teeth):**  
Multi-purpose tooth shape, economical to purchase and maintain. Ideal for chipboard, veneered chipboard, solid wood, block board, plywood.



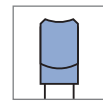
**WZ/FA (alternative top bevel teeth with bevel):**  
Tooth shape for demanding abrasive materials such as acrylic glass (PMMA), plastic coated chipboard and hardboard to a finish cut quality.



**FZ/TR (square/trapezoidal teeth):**  
Tooth shape for plastic and foil-coated wood derived materials.  
**TR/TR (trapezoidal/trapezoidal teeth):**  
Best tooth shape for cutting hard and abrasive coatings – can be altered from the existing FZ/TR shape.

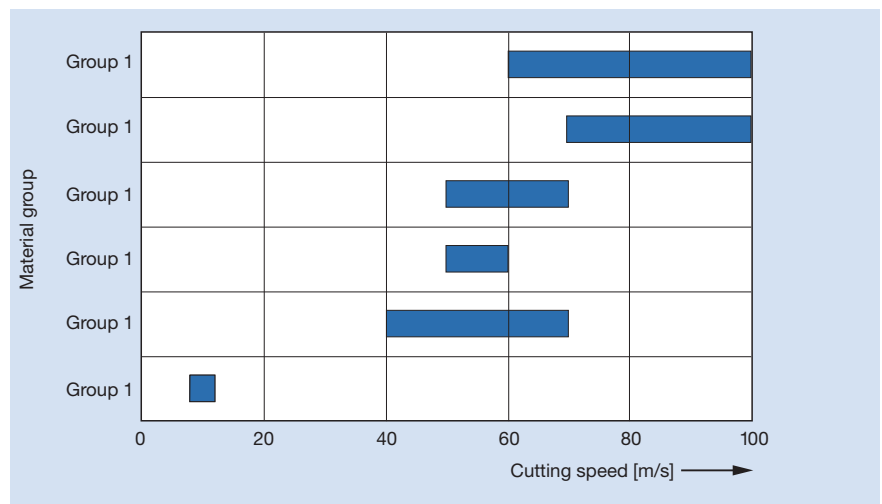


**HZ/DZ (hollow face/inverted V teeth):**  
Tooth shape for high cutting quality on plastic coated materials, with high upper and lower edge quality on machines without a pre-scoring unit.



**HZ/FA (bevelled hollow face teeth):**  
Same applications as WZ/FA and FZ/TR, but with higher cutting quality. Use for cuts in abrasive coatings on machines without a pre-scoring unit.

### Cutting speeds



- Group 1: Solid wood, untreated, veneered, synthetic and HPL coated chipboard and fibre materials and cement compound wood-derived materials, cast aluminium alloys and glulam.
- Group 2: Hard paper.
- Group 3: Plaster material.
- Group 4: Thermoplastic.
- Group 5: Duro-plastic.
- Group 6: Fibre cement board.

# 1. Sawing

## 1.4 Sizing

Recommended feed rate  $f_z$  (in mm)

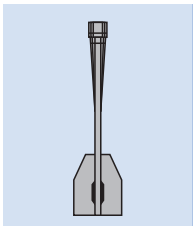
$$V_f = f_z \cdot n \cdot Z/1000$$

### Scoring sawblades

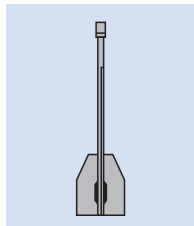
Material	Tooth progression in mm
Softwood across grain	0.10 – 0.20
Hardwood across grain	0.05 – 0.10
OSB board	0.10 – 0.20
Veneered board, block board	0.03 – 0.10
Plastic-coated chipboard	0.03 – 0.06
HPL-coated chipboard	0.02 – 0.10
Plywood	0.05 – 0.10
Aluminium alloy	0.03 – 0.10
Hard fibreboard	0.03 – 0.08
Cement-based wood-derived material	0.02 – 0.05
Glulam	0.02 – 0.06
Plaster material	0.10 – 0.20
Thermoplastics	0.05 – 0.10
Duroplastics	0.02 – 0.05

A scoring saw is recommended for high cut quality on both sides of coated panels. The scoring sawblade cutting width is slightly bigger than the width of the main sawblade so the exiting tooth of the main sawblade does not touch the bottom surface cut edge. As secure, flat positioning of the workpiece is only possible with pressure clamping, split scoring sawblades are used on table and sizing sawblades.

### Low-noise sawblades

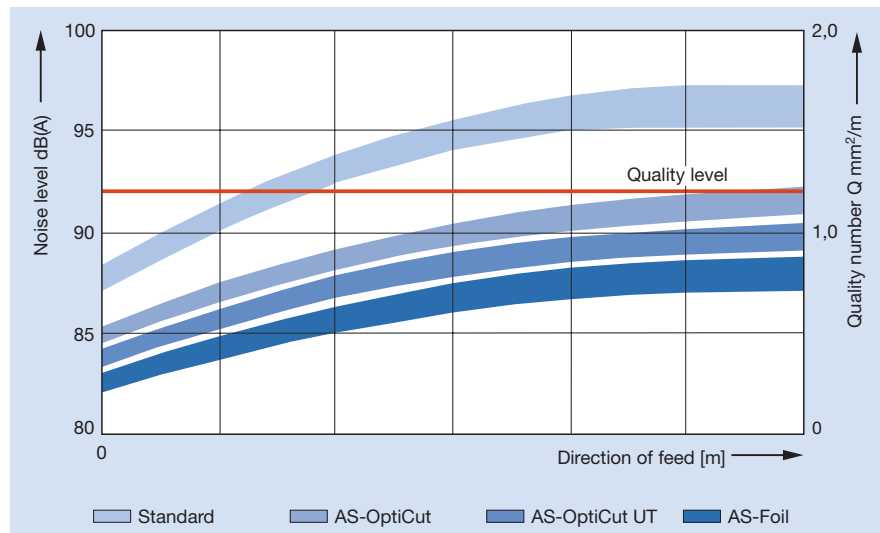


Sawblade without noise damping.

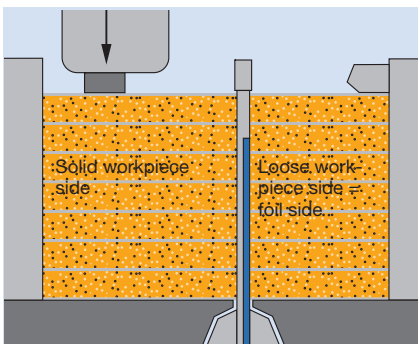


Sawblade with laminated noise damping.

Comparison of the noise reduction of different designs of sawblades and edge quality Q depending on the direction of feed.



### Advantages of low-noise sawblades



Determination of foil side

- Optimum noise reduction.
- Longer performance time from vibration damping.
- Improved cut quality, less wear and down time.
- Quiet running because of the high stability of the tool body.
- Reduced noise level of up to 10 dB(A) – 50% noise reduction – compared to standard sawblades.
- Increase in noise level due to blunting is hardly noticeable.
- Better operator working conditions from lower noise exposure.
- Can be resharpened on all popular makes of automatic saw sharpening machines.



### Cross cuts and sizing cuts up to 90 mm cutting height

**Application:**

For cross-cutting in solid wood and sizing in wood derived materials.

**Machine:**

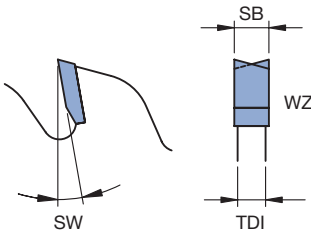
Circular saw benches, sizing, length-cutting and multi-blade circular saws.

**Workpiece material:**

Softwood and hardwood dry up to 90 mm cutting height and uncoated wood derived materials up to 45 mm cutting height.

**Technical information:**

Stable tool body tooth shape.



**Sawblade**

WK 850-2-01

D	SB	TDI	BO	BO <sub>max.</sub>	NLA	FLD	Z	ZF	SW	ID	
mm	mm	mm	mm/in	mm	mm	mm			Degree		
150	3,5	2,5	30	60		80	24	WZ	10	058050	●
180	3,5	2,5	30	60		80	30	WZ	10	058052	●
200	3,2	2,2	30	80		100	34	WZ	10	058053	●
250	3,2	2,2	15,88/5/8"	80		100	40	WZ	10	058054	●
250	3,2	2,2	30	80		100	40	WZ	10	058055	●
300	3,2	2,2	30		2/10/60	120	48	WZ	10	058057	●
350	3,2	2,2	25,40/1"	100		120	54	WZ	10	058058	●
350	3,2	2,2	30		2/10/60	120	54	WZ	10	058059	●
350	3,2	2,2	60			120	54	WZ	10	058065	●
400	3,8	2,8	30		2/10/60	140	60	WZ	10	058061	●
400	3,8	2,8	50			140	60	WZ	10	058070	●
450	3,8	2,8	30	100		160	66	WZ	10	058062	●
500	3,8	2,8	30	100		180	72	WZ	10	058063	●
550	4,2	3,2	30	100	2/10/60	140	84	WZ	10	058075	●

## 1. Sawing

### 1.4 Sizing

#### 1.4.1 Sizing sawblades



#### Cross cuts and sizing cuts up to 90 mm cutting height - LowNoise design

**Application:**

For noise-reduced cross-cutting in solid wood and sizing in wood derived materials.

**Machine:**

Circular saw benches, sizing, length-cutting and multi-blade circular saws.

**Workpiece material:**

Softwood and hardwood dry up to 60 mm cutting height and uncoated wood derived materials up to 30 mm cutting height.

**Technical information:**

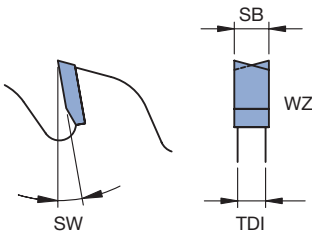
Stable tool body tooth shape. **AS OptiCut UT** design - Noise reduction during no-load operation by up to 8 dB(A). Tool body with vibration damping laser ornaments and irregular tooth pitch.



**Sawblade - AS OptiCut UT**

WK 870-2-51

D	SB	TDI	BO	BO <sub>max.</sub>	NLA	FLD	Z	ZF	SW	ID
mm	mm	mm	mm	mm	mm	mm			Degree	
250	3,2	2,2	30	60		100	40	WZ	10	<b>069005</b> ●
300	3,2	2,2	30		2/10/60	120	48	WZ	10	<b>069006</b> ●
350	3,2	2,2	30		2/10/60	120	54	WZ	10	<b>069007</b> ●
400	3,8	2,8	30		2/10/60	140	60	WZ	10	<b>069008</b> ●



# 1. Sawing

## 1.4 Sizing 1.4.1 Sizing sawblades



### Cross cuts and sizing cuts up to 90 mm cutting height - LowNoise design

**Application:**

For noise-reduced cross-cutting in solid wood and sizing in wood derived materials.

**Machine:**

Circular saw benches, sizing, length-cutting and multi-blade circular saws.

**Workpiece material:**

Softwood and hardwood dry up to 60 mm cutting height and uncoated wood derived materials up to 30 mm cutting height.

**Technical information:**

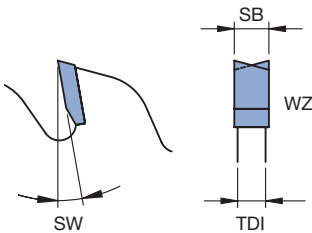
Stable tool body tooth shape. **AS LowNoise foil** design - Noise reduction during operation by up to 10 dB(A). Vibration damping tipped tool design of tool body by steel foil.



**Sawblade - AS Low Noise Foil left**

WK 870-3-01

D mm	SB mm	TDI mm	BO mm	NLA mm	FLD mm	Z	ZF	SW Degree	ID
300	3,5	2,5	30	2/10/60	120	48	WZ	10	<b>065931</b> ●
350	3,5	2,5	30	2/10/60	120	54	WZ	10	<b>065932</b> ●
400	4,0	2,8	30	2/10/60	140	60	WZ	10	<b>065933</b> ●



## 1. Sawing

### 1.4 Sizing

#### 1.4.1 Sizing sawblades



#### Cross cuts and sizing cuts up to 60 mm cutting height

**Application:**

For cross-cutting in solid wood and sizing in wood derived materials.

**Machine:**

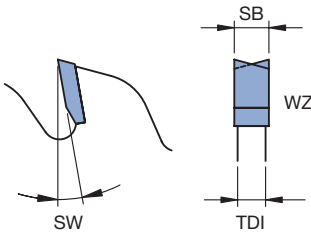
Circular saw benches, sizing and length-cutting saws.

**Workpiece material:**

Softwood and hardwood dry up to 60 mm cutting height, uncoated wood derived materials up to 40 mm cutting height or glulam up to 35 mm cutting height.

**Technical information:**

Stable tool body tooth shape.



**Sawblade**

WK 850-2-02, WK 850-3-02

D	SB	TDI	BO	BO <sub>max.</sub>	NLA	FLD	Z	ZF	SW	ID	
mm	mm	mm	mm/in	mm	mm	mm			Degree		
200	3,2	2,2	30	60		80	48	WZ	10	058380	●
250	3,2	2,2	15,88/5/8"	80		100	60	WZ	10	058381	●
250	3,2	2,2	30	80		100	60	WZ	10	058382	●
300	3,2	2,2	15,88/5/8"			120	72	WZ	10	058383	●
300	3,2	2,2	30		2/7/42	120	72	WZ	10	058384	●
					2/10/60						
300	3,2	2,2	31,75/1/4"			120	72	WZ	10	058388	□
350	3,2	2,2	25,40/1"			120	84	WZ	10	058385	●
350	3,2	2,2	30		2/10/60	120	84	WZ	10	058386	●
400	3,2	2,2	30		2/10/60	140	96	WZ	10	058387	●



### Cross cuts and sizing cuts up to 60 mm cutting height - LowNoise design

**Application:**

For noise-reduced cross-cutting in solid wood and sizing in wood derived materials.

**Machine:**

Circular saw benches, sizing and length-cutting saws.

**Workpiece material:**

Softwood and hardwood dry up to 45 mm cutting height, uncoated wood derived materials up to 35 mm cutting height or glulam up to 30 mm cutting height.

**Technical information:**

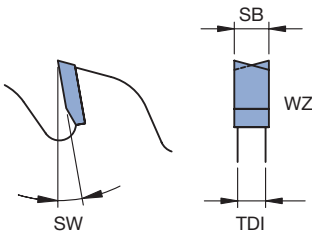
Stable tool body tooth shape. **AS OptiCut UT** design - Noise reduction during no-load operation by up to 8 dB(A). Tool body with vibration damping laser ornaments and irregular tooth pitch.



**Sawblade - AC OptiCut UT**

WK 870-2-52

D	SB	TDI	BO	BO <sub>max.</sub>	NLA	FLD	Z	ZF	SW	ID
mm	mm	mm	mm	mm	mm	mm			Degree	
250	3,2	2,2	30	60		100	60	WZ	10	<b>069076</b> ●
300	3,2	2,2	30		2/7/42 2/10/60	120	72	WZ	10	<b>069009</b> ●
350	3,2	2,2	30		2/10/60	120	84	WZ	10	<b>069077</b> ●





## 1. Sawing

### 1.4 Sizing

#### 1.4.1 Sizing sawblades



#### Cross cuts and sizing cuts up to 60 mm cutting height - LowNoise design

**Application:**

For noise-reduced cross-cutting in solid wood and sizing in wood derived materials.

**Machine:**

Circular saw benches, sizing and length-cutting saws.

**Workpiece material:**

Softwood and hardwood dry up to 45 mm cutting height, uncoated wood derived materials up to 35 mm cutting height or glulam up to 30 mm cutting height.

**Technical information:**

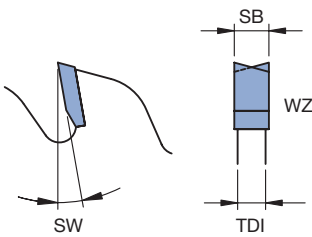
Stable tool body tooth shape. **AS LowNoise foil** design - Noise reduction during operation by up to 10 dB(A). Vibration damped tool body by steel foil.



**Sawblade - AS LowNoise UT left**

WK 870-3-02

D	SB	TDI	BO	NLA	FLD	Z	ZF	SW	ID
mm	mm	mm	mm	mm	mm			Degree	
300	3,5	2,5	30	2/10/60	120	72	WZ	10	<b>065937</b> ●
350	3,5	2,5	30	2/10/60	120	84	WZ	10	<b>065938</b> ●



# 1. Sawing

## 1.4 Sizing 1.4.1 Sizing sawblades



### Cross cuts and sizing cuts up to 45 mm cutting height

**Application:**

For cross-cutting in solid wood and sizing in wood derived materials.

**Machine:**

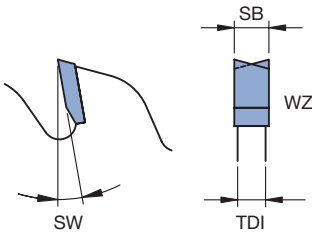
Circular saw benches, sizing and length-cutting saws.

**Workpiece material:**

Softwood and hardwood dry up to 45 mm cutting height, uncoated wood derived materials up to 30 mm cutting height or glulam up to 25 mm cutting height.

**Technical information:**

Stable tool body tooth shape.



**Sawblade**

WK 850-2-03

D	SB	TDI	BO	BO <sub>max.</sub>	NLA	FLD	Z	ZF	SW	ID
mm	mm	mm	mm/in	mm	mm	mm			Degree	
200	3,2	2,2	30	60		80	42	WZ	10	<b>058200</b> ●
250	3,2	2,2	30	80		100	48	WZ	10	<b>058202</b> ●
300	3,2	2,2	30		2/10/60	120	60	WZ	10	<b>058204</b> ●
350	3,2	2,2	25,40/1"			120	72	WZ	10	<b>058205</b> ●
350	3,2	2,2	30		2/10/60	120	72	WZ	10	<b>058206</b> ●
400	3,8	2,8	30		2/10/60	140	84	WZ	10	<b>058225</b> ●



### Cross cuts and sizing cuts up to 25 mm cutting height

**Application:**

For cutting along grain and across grain and and sizing with reduced cutting width.

**Machine:**

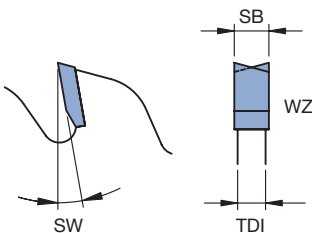
Circular saw benches, sizing and length-cutting saws.

**Workpiece material:**

Softwood and hardwood dry, veneered wood derived materials or glulam up to 25 mm cutting height and plastics (acrylic glass - PMMA) up to 3 mm cutting height.

**Technical information:**

Reduced cutting width and bossed tool body. Lower cutting and feed forces required.



**Sawblade - extreme thin kerf**

WK 850-2-22

D	SB	TDI	BO	BO <sub>max.</sub>	NLA	FLD	Z	ZF	SW	ID
mm	mm	mm	mm	mm	mm	mm			Degree	
250	1,7	1,0/2,4	30	80		100	80	WZ	8	<b>058520</b> ●
300	1,7	1,0/2,4	30		2/10/60	120	96	WZ	8	<b>058521</b> ●

## 1. Sawing

### 1.4 Sizing 1.4.1 Sizing sawblades



#### Cross cuts and sizing cuts up to 45 mm cutting height

**Application:**

For cross-cutting and sizing with reduced cutting width.

**Machine:**

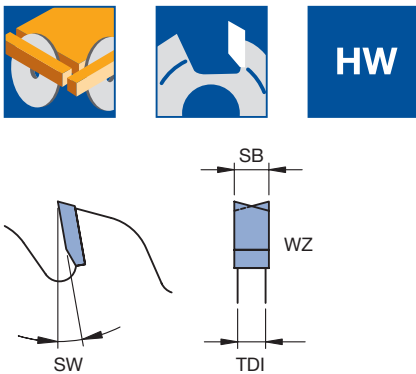
Circular saw benches, sizing and length-cutting saws.

**Workpiece material:**

Softwood and hardwood dry up to 35 mm cutting height, veneered wood derived materials or glulam up to 20 mm cutting height and plastics (acrylic glass - PMMA) up to 5 mm cutting height.

**Technical information:**

Reduced kerf and tool body widths. Lower cutting and feed forces required.



**Sawblade - thin kerf**

WK 850-2-10

D mm	SB mm	TDI mm	BO mm	BO <sub>max.</sub> mm	NLA mm	FLD mm	Z	ZF	SW Degree	ID
150	2,4	1,6	30	40		80	48	WZ	10	058450 ●
180	2,4	1,6	30	60		80	58	WZ	10	058451 ●
200	2,4	1,6	30	60		80	64	WZ	10	058452 ●
250	2,4	1,6	30	80		100	80	WZ	10	058453 ●
300	2,4	1,6	30		2/10/60	120	96	WZ	10	058454 ●
350	2,8	2,0	30		2/10/60	120	108	WZ	10	058458 ●

#### Cuts for veneer stacks up to 40 mm cutting height

**Application:**

For cutting along grain and across grain and sizing with reduced cutting width.

**Machine:**

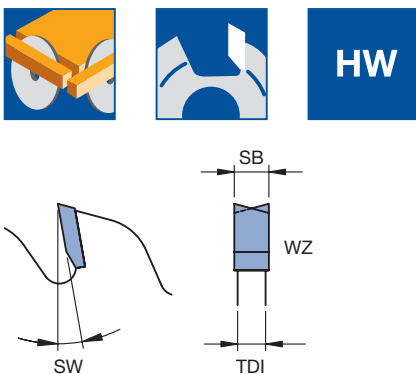
Circular saw benches, sizing and veneer saws.

**Workpiece material:**

Veneer stacks up to 40 mm cutting height.

**Technical information:**

Reduced kerf and tool body widths. ID **060592** with tooth shape combination WZ (1 teeth left, 5 teeth right WZ).



**Sawblade**

WK 250-2, WK 259-2

D mm	SB mm	TDI mm	BO mm	NLA mm	FLD mm	Z	ZF	SW Degree	ID
160	1,8	1,0/2,5	16	1/6/33	60	48	WZ	10	060574 ●
180	1,6	1,0/2,5	16	1/6/33	80	56	WZ	10	060591 ●
180	2,0	1,4	16		68	56	WZ	10	060645 ●
180	2,4	1,6	16			58	WZ	10	059665 ●
180	2,0	1,2	16	1/6/33	80	72	WZ	10	060592 ●
200	2,0	1,4	16		68	64	WZ	10	059666 ●



**Thin-kerf cuts for processing honeycombs - LowNoise design**

**Application:**

For noise-reduced sizing with reduced cutting width.

**Machine:**

Circular saw benches, sizing and veneer saws.

**Workpiece material:**

Light construction or honey comb.

**Technical information:**

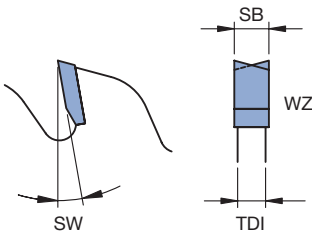
Reduced cutting width. Special cutting geometry to prevent delamination of board structure. **AS OptiCut UT** design - Noise reduction during no-load operation by up to 8 dB(A). Tool body with vibration damping laser ornaments and irregular tooth pitch. Increased cutting performance and reduced resin build-up from special tool body coating. Riving knife width must be adjusted to suit.



**Sawblade - AS OptiCut UT, thin kerf**

WK 850-2-10

D	SB	TDI	BO	NLA	FLD	Z	ZF	SW	ID
mm	mm	mm	mm	mm	mm			Degree	
250	2,4	1,6	30	2/7/42	100	80	WZ	20	<b>058456</b> ●
300	2,6	1,8	30	2/10/60	120	84	WZ	20	<b>058457</b> ●
350	2,8	2,0	30	2/10/60	120	96	WZ	20	<b>058459</b> ●
400	2,8	2,0	30	2/10/60	140	108	WZ	20	<b>058460</b> ●
450	3,0	2,2	30	2/14/125	140	120	WZ	20	<b>058461</b> ●



## 1. Sawing

### 1.4 Sizing

#### 1.4.1 Sizing sawblades



#### Cross cuts and sizing cuts up to 35 mm cutting height

**Application:**

For cross-cutting in solid wood and sizing in wood derived materials.

**Machine:**

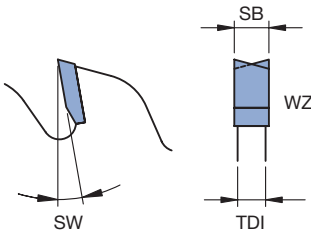
Circular saw benches, sizing, length-cutting and board-sawing machines.

**Workpiece material:**

Softwood and hardwood dry up to 35 mm cutting height, veneered wood derived materials or glulam up to 25 mm cutting height and plastics (acrylic glass - PMMA) up to 10 mm cutting height.

**Technical information:**

Stable tool body tooth shape.



**Sawblade**

WK 850-2

D	SB	TDI	BO	BO <sub>max.</sub>	NLA	FLD	Z	ZF	SW	ID
mm	mm	mm	mm/in	mm	mm	mm			Degree	
150	3,2	2,2	30	40		80	48	WZ	10	<b>058300</b> ●
180	3,2	2,2	30	60		80	58	WZ	10	<b>058301</b> ●
200	3,2	2,2	30	60		80	64	WZ	10	<b>058302</b> ●
220	3,2	2,2	30	60	2/7/42	80	64	WZ	10	<b>060646</b> ●
250	3,2	2,2	15,88/5/8"	80		100	80	WZ	10	<b>058303</b> ●
250	3,2	2,2	30	80		100	80	WZ	10	<b>058304</b> ●
300	3,2	2,2	15,88/5/8"	80		120	96	WZ	10	<b>058310</b> ●
300	3,2	2,2	30		2/10/60	120	96	WZ	10	<b>058311</b> ●
350	3,2	2,2	25,40/1"	100		120	108	WZ	10	<b>058307</b> ●
350	3,2	2,2	30		2/10/60	120	108	WZ	10	<b>058308</b> ●
400	3,2	2,2	30		2/10/60	140	120	WZ	10	<b>058309</b> ●



**Cross cuts and sizing cuts up to 35 mm cutting height - LowNoise design**

**Application:**

For noise-reduced cross-cutting in solid wood and sizing in wood derived materials.

**Machine:**

Circular saw benches, sizing, length-cutting and board-sawing machines.

**Workpiece material:**

Softwood and hardwood dry up to 35 mm cutting height, veneered wood derived materials or glulam up to 20 mm cutting height and plastics (acrylic glass - PMMA) up to 7 mm cutting height.

**Technical information:**

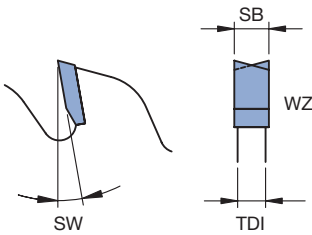
Stable tool body tooth shape. **AS OptiCut UT design** - Noise reduction during no-load operation by up to 5 dB(A). Tool body with vibration damping laser ornaments.



**Sawblade - AS OptiCut UT**

WK 870-2-50

D	SB	TDI	BO	BO <sub>max.</sub>	NLA	FLD	Z	ZF	SW	ID
mm	mm	mm	mm	mm	mm	mm			Degree	
250	3,2	2,2	30	60		100	80	WZ	10	<b>068251</b> ●
300	3,2	2,2	30		2/10/60	120	96	WZ	10	<b>068801</b> ●
350	3,2	2,2	30		2/10/60	120	108	WZ	10	<b>068252</b> ●



## 1. Sawing

### 1.4 Sizing

#### 1.4.1 Sizing sawblades



#### Cross cuts and sizing cuts up to 35 mm cutting height - LowNoise design

**Application:**

For noise-reduced cross-cutting in solid wood and sizing in wood derived materials.

**Machine:**

Circular saw benches, sizing, length-cutting and board-sawing machines.

**Workpiece material:**

Softwood and hardwood dry up to 35 mm cutting height, veneered wood derived materials or glulam up to 20 mm cutting height and plastics (acrylic glass - PMMA) up to 7 mm cutting height.

**Technical information:**

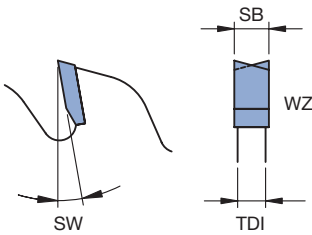
Stable tool body tooth shape. **AS LowNoise foil** design - Noise reduction during operation by up to 10 dB(A). Vibration damping tool body design by steel foil.



**Sawblade - AS LowNoise foil**

WK 870-3

D	SB	TDI	BO	BO <sub>max.</sub>	NLA	FLD	Dampfoil	Z	ZF	SW	ID
mm	mm	mm	mm	mm	mm	mm				Degree	
250	3,5	2,5	30	60		100	left	80	WZ	10	<b>065934</b> ●
300	3,5	2,5	30		2/10/60	120	left	96	WZ	10	<b>065935</b> ●
350	3,5	2,5	30		2/10/60	120	left	108	WZ	10	<b>065936</b> ●



# 1. Sawing

## 1.4 Sizing 1.4.1 Sizing sawblades



### Sizing cuts without pre-scoring unit

**Application:**

For sizing without pre-scoring sawblade.

**Machine:**

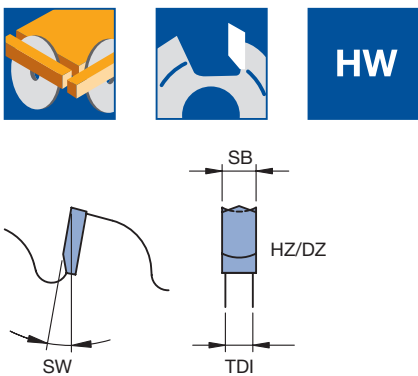
Vertical panel sizing saws, circular saw benches and sizing saw machines without pre-scoring unit.

**Workpiece material:**

Plastic coated chipboard material and fibre boards (MDF, HDF, WF etc.)

**Technical information:**

Negative cutting angle. If the saw spindle is positioned above the workpiece, the cutting pressure presses the workpiece onto the table.



**Sawblade with negative hook angle**

WK 864-2-04

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	FLD mm	Z	ZF	SW Degree	ID
Holz Her	220	3,2	2,2	30	2/7/42	80	42	DZ/HZ	-5	<b>058957</b> ●
Haffner	250	3,2	2,2	30	2/7/42	80	48	DZ/HZ	-5	<b>058972</b> ●
Striebig										
Haffner	303	3,2	2,2	30	2/7/42	110	60	DZ/HZ	-5	<b>058970</b> ●
Holz Her					2/10/60					
Striebig										
Altendorf	350	3,2	2,2	30	2/10/60	120	72	DZ/HZ	-5	<b>058960</b> ●



### Sizing cuts without pre-scoring unit

**Application:**

For sizing without pre-scoring sawblade.

**Machine:**

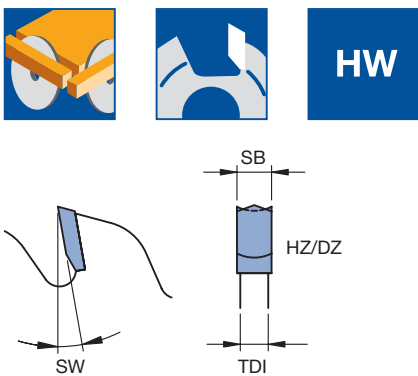
Vertical panel sizing saws, circular saw benches and sizing saw machines without pre-scoring unit.

**Workpiece material:**

Paper and plastic coated chipboard material and fibre boards (MDF, HDF, WF etc.)

**Technical information:**

Positive hook angle. When the saw spindle is positioned under the workpiece, the cutting force presses the workpiece onto the table.



**Sawblade**

WK 854-2, WK 854-2-15

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	FLD mm	Z	ZF	SW Degree	ID
Striebig	220	3,2	2,2	30	2/7/42	80	42	DZ/HZ	10	<b>058967</b> ●
Elektra Beckum	250	3,2	2,2	30	2/7/42	80	48	DZ/HZ	10	<b>058971</b> ●
Striebig										
Scheppach	303	3,5	2,4	30	2/7/42	120	60	DZ/HZ	10	<b>058963</b> ●
Striebig					2/10/60					
	350	3,5	2,5	30	2/10/60	120	72	DZ/HZ	10	<b>058969</b> ●



## 1. Sawing

### 1.4 Sizing

#### 1.4.1 Sizing sawblades



#### Sizing cuts without pre-scoring unit - LowNoise design

**Application:**

For noise-reduced sizing without pre-scoring sawblade.

**Machine:**

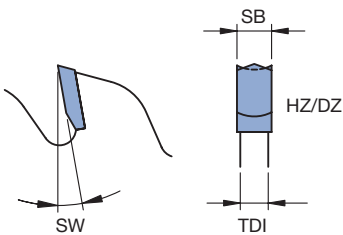
Vertical panel sizing saws, circular saw benches and sizing saw machines without pre-scoring unit.

**Workpiece material:**

Plastic-coated particle and fibre materials (MDF, HDF, WF etc.).

**Technical information:**

If the saw spindle is positioned below the workpiece, the cutting pressure presses the workpiece onto the table. **AS OptiCut** and **AS OptiCut UT** design - Noise reduction during no-load operation by up to 8 dB(A). Tool body with vibration damping laser ornaments or irregular tooth pitch.



**Sawblade - AS OptiCut / AS OptiCut UT design**

WK 874-2-50

Machine	D	SB	TDI	BO	NLA	FLD	Z	ZF	SW	Type	ID
	mm	mm	mm	mm	mm	mm			Degree		
Striebig	303	3,5	2,4	30	2/7/42 2/10/60	110	60	DZ/HZ	10		<b>068301</b> ●
Striebig	303	3,2	2,4	30	2/7/42 2/10/60	110	68	DZ/HZ	10		<b>068303</b> ●
Striebig	303	3,5	2,4	30	2/7/42 2/10/60	110	54	DZ/HZ	15	UT	<b>068302</b> ●



### Sizing cuts without pre-scoring unit - LowNoise design

**Application:**

For noise-reduced sizing without pre-scoring sawblade.

**Machine:**

Vertical panel sizing saws, circular saw benches and sizing saw machines without pre-scoring unit.

**Workpiece material:**

Plastic-coated particle and fibre materials (MDF, HDF, WF etc.).

**Technical information:**

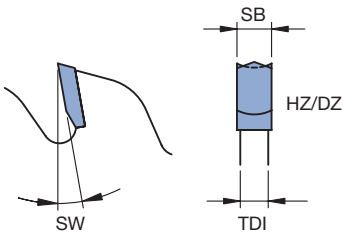
If the saw spindle is positioned below the workpiece, the cutting pressure presses the workpiece onto the table. **AS LowNoise foil** design - Noise reduction during operation by up to 10 dB(A). Vibration damped tool body by steel foil.



**Sawblade - AS LowNoise foil design**

WK 874-2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	FLD mm	Dampfoil Z	ZF	SW Degree	ID	
Striebig	250	3,5	2,5	30	2/7/42	80	left	48	DZ/HZ	10	<b>065336</b> ●
Striebig	303	3,5	2,5	30	2/7/42	120	left	60	DZ/HZ	10	<b>065941</b> ●
					2/10/60						
Striebig	303	3,5	2,5	30	2/7/42	120	right	60	DZ/HZ	10	<b>065335</b> ●
					2/10/60						
Altendorf Kölle Martin	350	3,5	2,5	30	2/10/60	120	left	72	DZ/HZ	10	<b>065957</b> ●



## 1. Sawing

### 1.4 Sizing

#### 1.4.1 Sizing sawblades



#### Sizing cuts with/without pre-scoring unit

**Application:**

For sizing with/without pre-scoring sawblade.

**Machine:**

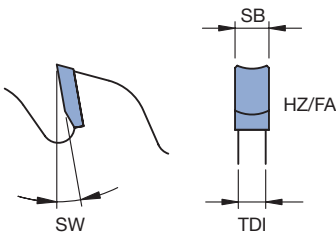
Circular saw benches, sizing, length-cutting and board-sawing machines with/without pre-scoring unit.

**Workpiece material:**

HPL- and plastic-coated wood materials.

**Technical information:**

If the saw spindle is positioned below the workpiece, the cutting pressure presses the workpiece onto the table. Tooth shape suitable for hard coatings (e.g. HPL).



**Sawblade**

WK 807-2

D	SB	TDI	BO	NLA	FLD	Z	ZF	SW	ID
mm	mm	mm	mm	mm	mm			Degree	
220	3,2	2,2	30	2/7/42	100	42	HZ/FA	10	<b>058880</b> ●
300	3,2	2,2	30	2/10/60	120	60	HZ/FA	10	<b>058881</b> ●
350	3,2	2,2	30	2/10/60	120	72	HZ/FA	10	<b>058882</b> ●
400	3,2	2,2	30	2/10/60	140	84	HZ/FA	10	<b>058883</b> ●



### Sizing cuts with/without pre-scoring unit

**Application:**

For noise-reduced sizing with/without pre-scoring sawblade.

**Machine:**

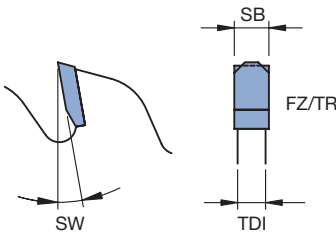
Circular saw benches, sizing, length-cutting and board-sawing machines with/without pre-scoring unit.

**Workpiece material:**

Uncoated wood materials. Laminated material panels (HPL, Trespa, multiplex), polymer compound materials (Corian) and duromers.

**Technical information:**

If the saw spindle is positioned below the workpiece, the cutting pressure presses the workpiece onto the table. **AS OptiCut design** - Noise reduction during no-load operation by up to 5 dB(A). Tool body with vibration damping laser ornaments.



**Sawblade - AS OptiCut design**

WK 872-2-60

D	SB	TDI	BO	NLA	FLD	Z	ZF	SW	ID
mm	mm	mm	mm	mm	mm			Degree	
250	3,5	2,5	30	3/7/42	100	72	FZ/TR	5	<b>068402</b> ●
300	3,2	2,2	30	2/7/42	120	72	FZ/TR	10	<b>068403</b> ●
300	3,2	2,2	30	2/10/60	120	96	FZ/TR	10	<b>068800</b> ●
303	3,5	2,5	30	2/7/42	120	84	FZ/TR	5	<b>068404</b> ●
350	3,2	2,2	30	2/10/60	120	108	FZ/TR	10	<b>068401</b> ●

## 1. Sawing

### 1.4 Sizing 1.4.1 Sizing sawblades



#### Sizing cuts, scoring, hogging

**Application:**

For sizing and as scoring sawblade with feed or for mounting on hogger and segmental hogger.

**Machine:**

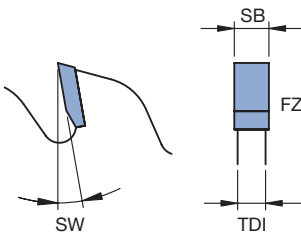
Saw benches, sizing, length cutting and panel saw machines with/without pre-scoring unit.

**Workpiece material:**

Paper- and plastic-coated and veneered particle and fibre materials (MDF, HDF etc.) or laminated wood.

**Technical information:**

Also suitable for mounting on hogger and segmental hogger. Design without pinholes for special applications.



**Scoring sawblade or sawblades for mounting on hogger**

WK 800-2-01, WK 800-2-03

D mm	SB mm	TDI mm	BO mm	BO <sub>max.</sub> mm	Z	ZF	SW Degree	ID
150	3,5	2,5	30	80	30	FZ	10	<b>058570</b> ●
150	3,5	2,5	55	80	30	FZ	10	<b>058578</b> ●
150	3,5	2,5	30	80	48	FZ	10	<b>058700</b> ●
180	3,5	2,5	30	80	36	FZ	10	<b>058572</b> ●
180	3,5	2,5	30	80	58	FZ	10	<b>058702</b> ●
200	3,2	2,2	30	80	42	FZ	10	<b>058573</b> ●
200	3,2	2,2	30	80	64	FZ	10	<b>058703</b> ●
250	3,2	2,2	60	80	48	FZ	10	<b>058574</b> ●



#### Sizing cuts with pre-scoring unit

**Application:**

For sizing individual boards and stacks of boards (up to 70 mm cutting height) with pre-scoring sawblade.

**Machine:**

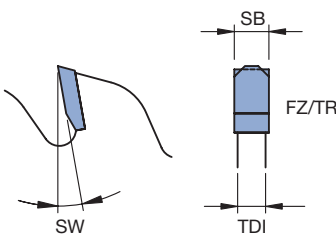
Saw benches, sizing, length cutting and panel saw machines with pre-scoring unit.

**Workpiece material:**

Paper and plastic coated chipboard material and fibre boards (MDF, HDF etc.) and plastic boards.

**Technical information:**

Stable tool body tooth shape.



**Sawblade**

WK 852-2-10

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW Degree	ID
Reich	220	3,2	2,2	30	2/7/42	64	FZ/TR	10	<b>061350</b> ●
Scheer	240	3,2	2,2	30	2/7/42	54	FZ/TR	10	<b>059255</b> ●
	250	3,2	2,2	30	2/7/42	80	FZ/TR	10	<b>061357</b> ●
	300	3,2	2,2	30	2/7/42 2/10/60	72	FZ/TR	10	<b>061358</b> ●
Striebig	300	3,2	2,2	30	2/7/42 2/10/60	96	FZ/TR	10	<b>061352</b> ●
	350	3,5	2,5	30	2/10/60	84	FZ/TR	5	<b>061359</b> ●

# 1. Sawing

## 1.4 Sizing 1.4.1 Sizing sawblades



### Sizing cuts with pre-scoring unit

**Application:**

For noise-reduced sizing with pre-scoring sawblade.

**Machine:**

Saw benches, sizing, length cutting and panel saw machines with pre-scoring unit.

**Workpiece material:**

Plastic-coated wood and compound materials as well as plastic panels.

**Technical information:**

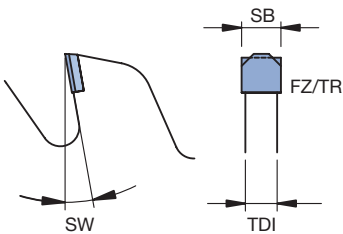
Stable tool body tooth shape. **Diamaster PRO** design with 4.5 mm tipping height.

**Sawblade - Diamaster PRO**

WK 852-2-DP



D	SB	TDI	BO	NLA	FLD	Z	ZF	SW	ID
mm	mm	mm	mm	mm	mm			Degree	
300	3,5	2,5	30	2/10/60	120	60	FZ/TR	10	<b>090638</b> ●



# 1. Sawing

## 1.4 Sizing 1.4.2 Scoring sawblades



### 2-part design

**Application:**

For scoring with feed, scoring depth 1.50 - 2.00 mm.

**Machine:**

Sizing saw machines with pre-scoring unit without pressure beam.

**Workpiece material:**

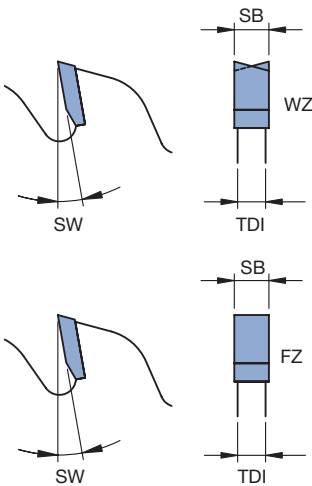
Paper- and plastic-coated and veneered wood materials, laminated wood.

**Technical information:**

Two-part, adjustable with spacers.

**Sawblade set - adjustable with spacers**

SK 199-2



Machine	D mm	SB mm	BO mm	Z	ZF	SW Degree	$n_{max}$ , min <sup>-1</sup>	ID
Putsch-Meniconi	70	2,8 - 3,6	20	8+8	WZ	8	32000	<b>061460</b> ●
Robland	80	2,8 - 3,6	20	10+10	FZ	8	28200	<b>061441</b> ●
Schelling	100	2,8 - 3,6	20	10+10	FZ	8	22600	<b>061409</b> ●
Altendorf	100	2,8 - 3,6	22	10+10	FZ	8	22600	<b>061400</b> ●
Martin								
Mrozek								
Panhans								
SCM	120	2,8 - 3,6	20	12+12	FZ	12	18900	<b>061402</b> ●
Altendorf	120	2,8 - 3,6	22	12+12	FZ	12	18900	<b>061401</b> ●
Martin								
Mrozek								
Martin	120	2,8 - 3,6	22	12+12	FZ	12	18900	<b>061456</b> ●
(electr. SB adjustment)								
Felder	125	2,8 - 3,6	20	12+12	FZ	12	18300	<b>061449</b> ●
SCM								
Giben	125	4,0 - 4,8	45	20+20	FZ	10	18300	<b>061407</b>
Mayer-Lombach								
Bäuerle	160	2,8 - 3,6	30	16+16	FZ	12	14300	<b>061408</b>
Kölle	180	3,0 - 3,8	30	18+18	FZ	12	12700	<b>061406</b>
Schelling	180	4,0 - 4,8	20	20+20	FZ	12	12700	<b>061447</b> ●
SCM	200	4,3 - 5,2	20	30+30	FZ	10	11400	<b>061414</b> ●
Schelling	220	4,0 - 4,8	20	24+24	FZ	12	10400	<b>061448</b> ●



### 2-part design

**Application:**

For scoring with feed on machines equipped with scoring unit which has been especially designed for this tool, scoring depth 1.50 - 2.00 mm.

**Machine:**

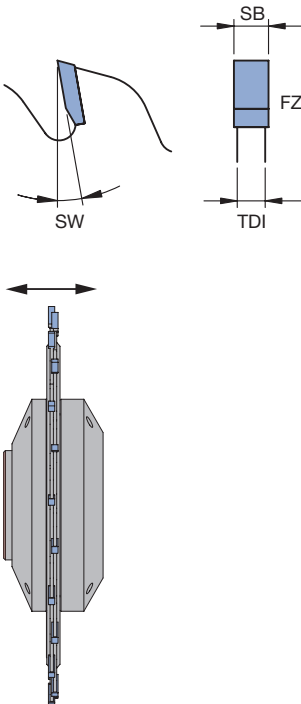
Sizing saw machines with pre-scoring unit without pressure beam.

**Workpiece material:**

Paper- and plastic-coated and veneered wood materials, laminated wood.

**Technical information:**

Two-part design, continuously adjustable when installed.



**Sawblade set - mounted on sleeve, continuously adjustable**

SK 199-2

Machine	D mm	SB mm	BO mm	Z	ZF	SW Degree	$n_{max}$ , min <sup>-1</sup>	ID
Altendorf	120	2,8 - 3,8	15	12+12	FZ	12	18900	<b>061450</b> ●
Martin	120	2,8 - 3,6	22	12+12	FZ	12	18900	<b>061452</b>
Martin	125	2,8 - 3,6	22	12+12	FZ	12	18900	<b>061454</b>
Panhans	125	2,8 - 3,8	22	12+12	FZ	12	18300	<b>061416</b>

**Spare sawblades:**

BEZ	QAL	ABM mm	ID
Scoring sawblade, 2 part design	HW	D125,d48,Z12/12,FZ	<b>061445</b> ●
Scoring sawblade, 2 part design	HW	D120,d48,Z12/12,FZ	<b>061446</b> ●
Scoring sawblade, 2 part design, Martin	HW	D120,d26,Z12/12,FZ	<b>061453</b> ●
Scoring sawblade, 2 part design, Martin	HW	D125,d26,Z12/12,FZ	<b>061455</b> ●

**Spare parts:**

BEZ	ABM mm	ID
Allen screw	M6x10	<b>006034</b> ●
Countersink screw	M4x6	<b>007042</b> ●
Double-thread allen screw	M6x0,5	<b>007830</b> ●
Allen Key	SW 2,5	<b>005472</b> ●
Allen Key	SW 3	<b>005444</b> ●