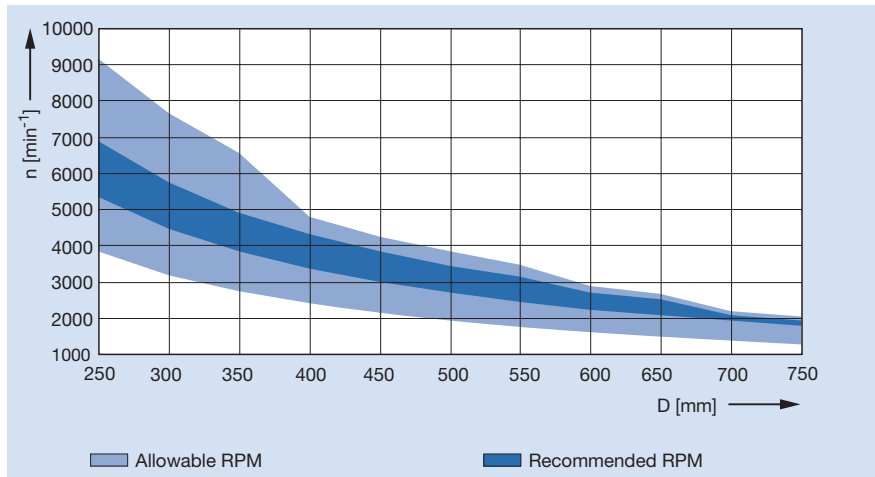


1. Sawing

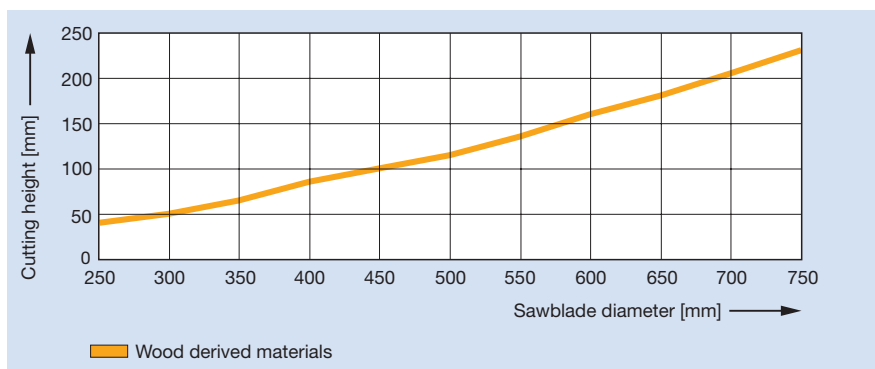
1.5 Panel sizing

| | |
|----------------------------|--|
| Working process | For sizing single boards or boards in stacks. |
| Workpiece materials | Solid wood, wood-derived materials, plastic and light metals. |
| Machines | Table saws and panel sizing saws with pressure clamping beam. |
| Type of application | Scoring sawblades cut with the feed and main sawblades cut against the feed. |

RPM diagram

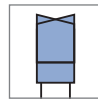


Cutting height diagram

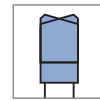


Horizontal panel sizing sawblades –
The cutting height depends on the sawblade diameter D and the workpiece material.

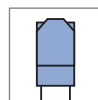
Tooth shape



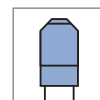
WZ (alternative top bevel teeth):
Multi-purpose tooth shape, economical to purchase and maintain. Ideal for chipboard, veneered chipboard, solid wood, block board, plywood and similar materials.



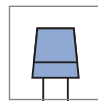
WZ/FA (alternative top bevel teeth with bevel): Tooth shape for delicate and abrasive materials such as acrylic glass (PMMA), plastic coated chipboard and hard fibreboard to a finish cut quality. High performance – boards in stacks at high feed rate.



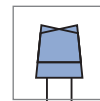
FZ/TR (square/trapezoidal teeth):
Tooth shape for plastic-coated and foil-coated wood derived materials.



TR/TR (trapezoidal/trapezoidal teeth):
Tooth shape for especially abrasive materials such as HPL or CPL-coated wood derived materials.



KON/FZ (flat teeth – conical):
For scoring sawblades. Prevents splitting of the cut edge by the main sawblade as it passes through the bottom surface of the panel.



KON/WZ (alternative top bevel teeth – conical): For scoring sawblades. Prevents splitting of the cut edge by the main sawblade as it passes through the bottom surface of the panel – low cutting pressure.

Recommended feed rate f_z (in mm)

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

| Material | Tooth progression in mm |
|--|-------------------------|
| OSB | 0.10 – 0.20 |
| Veneered boards, block boards | 0.03 – 0.10 |
| Plastic-coated chipboards | 0.03 – 0.06 |
| HPL-coated chipboards | 0.02 – 0.10 |
| Plywood | 0.05 – 0.10 |
| Aluminium alloys | 0.03 – 0.10 |
| Hard fibreboards | 0.03 – 0.08 |
| Cement compounded wood-derived materials | 0.02 – 0.05 |
| Glulam | 0.02 – 0.06 |
| Plaster materials | 0.10 – 0.20 |
| Thermoplastics | 0.05 – 0.10 |
| Duroplastics | 0.02 – 0.05 |
| Aluminium castings | 0.01 – 0.04 |

1. Sawing

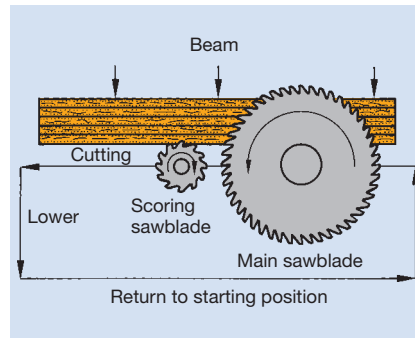
1.5 Panel sizing

Scoring sawblades

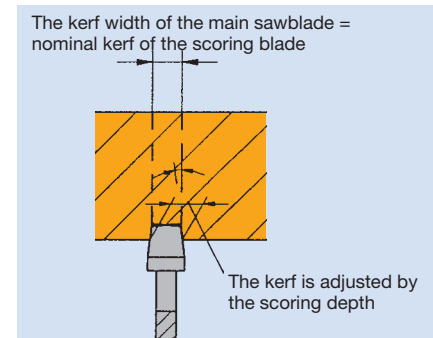
A scoring saw is recommended for a high cut edge quality on both sides of coated panels. The scoring sawblade cutting width (kerf) is slightly bigger than the width (kerf) of the main sawblade so the exiting tooth of the main sawblade does not touch the bottom surface cut edge.

As secure, flat positioning is only possible with pressure clamping, split scoring sawblades are used on table and sizing saws.

Schematic representation

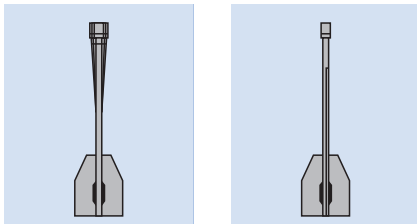


Panel sizing machine with pre-scoring unit and top pressure beam.



Setting of conical scoring sawblade. The cutting width (kerf) has to be matched to the cutting width (kerf) of the main saw for the maintenance of the tools.

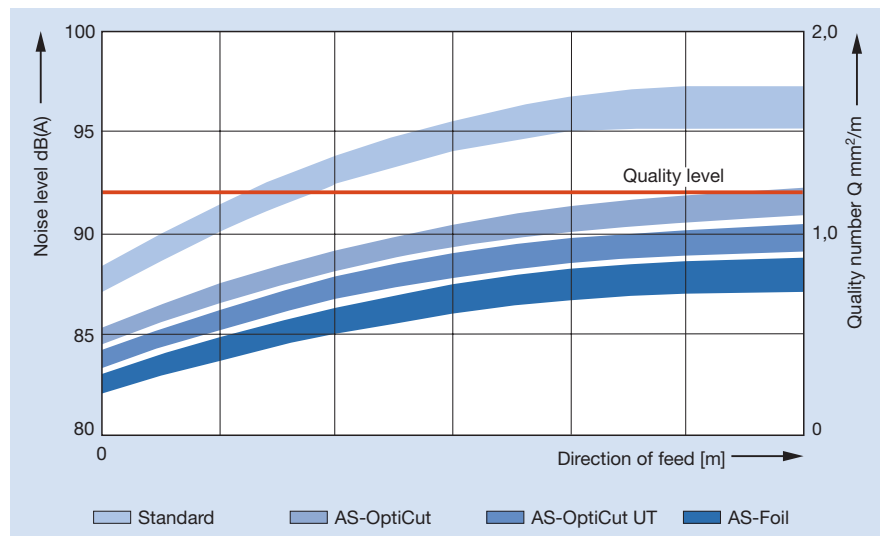
Low-noise sawblades



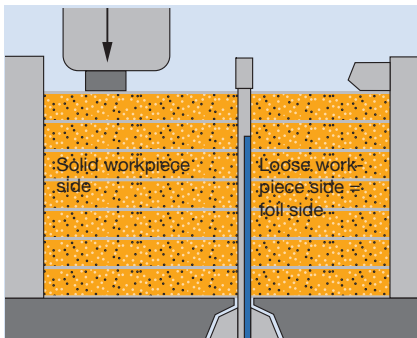
Sawblade without noise damping.

Sawblade with laminated noise damping.

Comparison of the efficiency of noise reduction for different designs of sawblades and edge quality Q depending on the performance.



Advantages of low-noise sawblades



Determination of the foil side

- Optimum noise reduction
- Longer performance time from vibration damping.
- High 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 audible.
- Better operator working conditions due to lower noise exposure.
- Can be resharpened on all popular makes of automatic saw sharpening machines.



Sizing cuts - uncoated wood products

Application:

For sizing individual boards and stacks of boards with pre-scoring sawblades.

Machine:

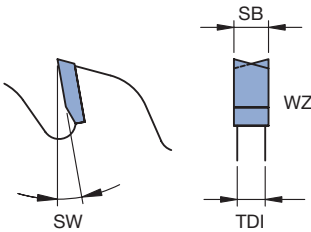
Sizing saw machines and panel sizing saws with pre-scoring unit and pressure beam.

Workpiece material:

Uncoated and veneered wood materials or laminated wood.

Technical information:

Stable tool body tooth shape.



Sawblade

WK 250-2-36

| D | SB | TDI | BO | BO _{max.} | NLA | FLD | Z | ZF | SW | ID |
|-----|-----|-----|----|--------------------|---------------------|-----|----|----|--------|----------|
| mm | mm | mm | mm | mm | mm | mm | | | Degree | |
| 300 | 4,4 | 3,0 | 30 | 80 | | 120 | 48 | WZ | 15 | 059100 ● |
| 350 | 4,4 | 3,2 | 30 | 100 | | 120 | 54 | WZ | 15 | 059102 ● |
| 350 | 4,4 | 3,2 | 80 | 100 | | 120 | 54 | WZ | 15 | 059103 ● |
| 400 | 4,4 | 3,2 | 30 | 100 | | 140 | 60 | WZ | 15 | 059105 ● |
| 400 | 4,4 | 3,2 | 75 | 100 | | 160 | 60 | WZ | 15 | 059107 □ |
| 400 | 4,4 | 3,2 | 80 | 100 | 2/9/130 4/19/120 | 160 | 60 | WZ | 15 | 059460 ● |
| 430 | 4,4 | 3,2 | 30 | 80 | | 140 | 72 | WZ | 15 | 059431 ● |
| 430 | 4,4 | 3,2 | 80 | | 2/9/130 4/19/120 | 140 | 72 | WZ | 15 | 059461 ● |
| 450 | 4,4 | 3,2 | 30 | 80 | | 140 | 54 | WZ | 15 | 059480 ● |
| 450 | 4,4 | 3,2 | 30 | 80 | | 140 | 72 | WZ | 15 | 059433 ● |
| 450 | 4,4 | 3,2 | 80 | 80 | | 180 | 72 | WZ | 15 | 059434 ● |
| 480 | 4,4 | 3,2 | 30 | 80 | | 140 | 72 | WZ | 15 | 059481 ● |
| 500 | 5,2 | 3,5 | 30 | 80 | | 140 | 60 | WZ | 15 | 059442 ● |
| 500 | 5,2 | 3,5 | 80 | | | 180 | 60 | WZ | 15 | 059443 ● |
| 530 | 5,2 | 3,5 | 30 | 80 | | 140 | 60 | WZ | 15 | 059444 ● |
| 550 | 5,2 | 3,5 | 30 | 80 | | 140 | 60 | WZ | 15 | 059445 ● |
| 550 | 5,2 | 3,5 | 80 | | | 180 | 48 | WZ | 15 | 059482 ● |
| 550 | 5,2 | 3,5 | 80 | | | 180 | 60 | WZ | 15 | 059446 ● |
| 550 | 5,5 | 3,5 | 40 | 80 | | 140 | 48 | WZ | 15 | 059457 ● |

1. Sawing

 1.5 Panel sizing
 1.5.1 Panel sizing sawblades

**Sizing cuts - uncoated wood products -
 LowNoise design**
Application:

For noise-reduced sizing of individual boards and stacks of boards with pre-scoring sawblades.

Machine:

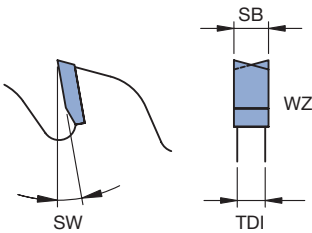
Sizing saw machines and panel sizing saws with pre-scoring unit and pressure beam.

Workpiece material:

Uncoated and veneered wood materials or laminated wood.

Technical information:

Stable tooth shape of tool body. **AS LowNoise UT** design - Noise reduction during no-load operation by up to 6 dB(A). Tool body with vibration damping irregular tooth pitch.


Sawblade - AS LowNoise UT

WK 270-2-87

| D | SB | TDI | BO | BO _{max.} | NLA | FLD | Z | ZF | SW | ID |
|-----|-----|-----|----|--------------------|----------|-----|----|----|--------|-----------------|
| mm | mm | mm | mm | mm | mm | mm | | | Degree | |
| 300 | 4,4 | 3 | 30 | 80 | 2/10/ 60 | 120 | 48 | WZ | 15 | 059483 ● |
| 300 | 4,4 | 3 | 30 | 80 | 2/10/ 60 | 120 | 60 | WZ | 15 | 059484 ● |
| 350 | 4,4 | 3,2 | 60 | | 2/14/100 | 120 | 54 | WZ | 15 | 059485 ● |
| 350 | 4,4 | 3,2 | 30 | 80 | 2/10/ 60 | 120 | 72 | WZ | 15 | 059486 ● |
| 350 | 4,4 | 3,2 | 60 | | 2/14/100 | 120 | 72 | WZ | 15 | 059487 □ |
| 370 | 4,4 | 3,2 | 30 | 80 | 2/13/ 94 | 140 | 54 | WZ | 15 | 059488 ● |
| 370 | 4,4 | 3,2 | 30 | 80 | 2/13/ 94 | 140 | 72 | WZ | 15 | 059489 ● |
| 380 | 4,8 | 3,5 | 60 | | 2/14/100 | 140 | 54 | WZ | 15 | 059490 ● |
| 380 | 4,8 | 3,5 | 60 | | 2/14/100 | 140 | 72 | WZ | 15 | 059491 ● |
| 400 | 4,4 | 3,2 | 30 | 100 | 2/10/ 60 | 140 | 72 | WZ | 15 | 059492 ● |
| 450 | 4,8 | 3,5 | 60 | | 2/14/100 | 140 | 72 | WZ | 20 | 059493 ● |
| 460 | 4,4 | 3,2 | 30 | 100 | 2/13/ 94 | 140 | 48 | WZ | 20 | 059494 ● |
| 460 | 4,4 | 3,2 | 30 | 100 | 2/13/ 94 | 140 | 72 | WZ | 20 | 059495 ● |
| 480 | 4,8 | 3,5 | 80 | | 2/9/130 | 180 | 72 | WZ | 20 | 059496 ● |
| | | | | | 4/9/120 | | | | | |
| 520 | 4,4 | 3,2 | 30 | | 2/13/94 | 140 | 72 | WZ | 20 | 059497 ● |



Sizing cuts - uncoated wood products - LowNoise design

Application:

For noise-reduced sizing combined with pre-scoring sawblades.

Machine:

Sizing saw machines and panel sizing saws with pre-scoring unit and pressure beam.

Workpiece material:

Uncoated and veneered wood materials or laminated wood.

Technical information:

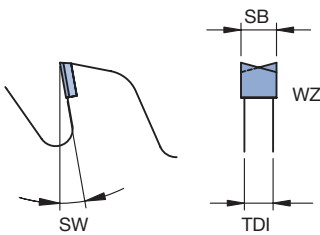
Stable tool body tooth shape. **AS LowNoise UT** design - Noise reduction during no-load operation by up to 6 dB(A). Tool body with vibration damping irregular tooth pitch. **Diamaster PLUS** with 6.0 mm tipping height.



Sawblade - AS LowNoise UT - Diamaster Plus

WK 250-2

| D | SB | TDI | BO | BO _{max.} | NLA | FLD | Z | ZF | SW | ID |
|-----|-----|-----|----|--------------------|----------------------|-----|----|----|--------|-----------------|
| mm | mm | mm | mm | mm | mm | mm | | | Degree | |
| 300 | 4,4 | 3,2 | 30 | 80 | 2/10/ 60 | 120 | 60 | WZ | 15 | 190609 ● |
| 350 | 4,4 | 3,2 | 30 | 100 | 2/10/ 60 | 120 | 60 | WZ | 15 | 190610 ● |
| 350 | 4,4 | 3,2 | 30 | 100 | 2/10/ 60 | 120 | 72 | WZ | 15 | 190611 ● |
| 380 | 4,8 | 3,5 | 60 | 100 | 2/14/100 2/14/125 | 140 | 72 | WZ | 15 | 190612 ● |
| 400 | 4,4 | 3,2 | 30 | 100 | 2/10/ 60 | 140 | 72 | WZ | 15 | 190613 ● |



1. Sawing

1.5 Panel sizing 1.5.1 Panel sizing sawblades



Cross and sizing cuts - uncoated wood products

Application:

For cross-cutting and sizing on manufacturing machines with cross-cutting unit.

Machine:

Sizing saw machines and panel sizing saws with pre-scoring unit and pressure beam.

Workpiece material:

Uncoated and veneered wood materials or laminated wood.

Technical information:

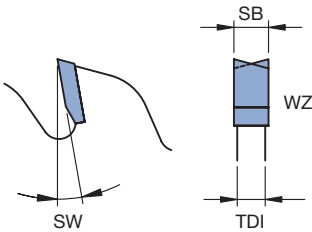
Stable tool body tooth shape.

Sawblade

WK 250-2-37



| D | SB | TDI | BO | BO _{max.} | FLD | Z | ZF | SW | ID |
|-----|-----|-----|----|--------------------|-----|----|----|--------|----------|
| mm | mm | mm | mm | mm | mm | | | Degree | |
| 355 | 4,4 | 3,2 | 30 | 100 | 120 | 72 | WZ | 15 | 059190 ● |
| 355 | 4,4 | 3,2 | 80 | 100 | 120 | 72 | WZ | 15 | 059191 ● |
| 400 | 4,4 | 3,2 | 30 | 100 | 140 | 72 | WZ | 15 | 059185 ● |





Sizing cuts - coated wood products

Application:

For sizing individual boards and stacks of boards with pre-scoring sawblades.

Machine:

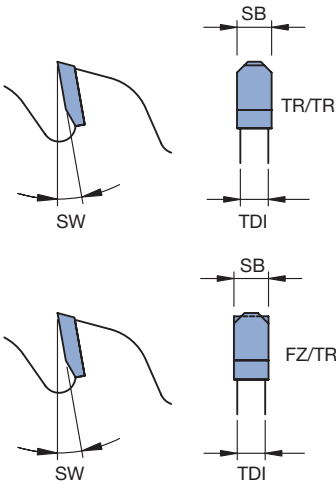
Sizing saw machines and panel sizing saws with pre-scoring unit and pressure beam.

Workpiece material:

Plastic-coated particle and fibre materials (MDF, HDF, WF etc.), compound materials (fibre-reinforced gypsum-plaster boards) and plastic panels.

Technical information:

Stable tool body tooth shape. Tooth shape FZ/TR and TR/TR. The tooth shape TR/TR is recommended when cutting hard coatings.



Sawblade

WK 852-2, WK 852-2-35, WK 852-2-36, WK 852-2-37, WK 858-2, WK 858-2-35

| Machine | D mm | SB mm | TDI mm | BO mm | NLA mm | Z | ZF | SW De- gree | ID | |
|------------|---------|----------|-----------|----------|-----------|----|-------|-------------------|--------|---|
| Reich | 220 | 3,2 | 2,2 | 30 | 2/7/42 | 64 | FZ/TR | 10 | 061350 | ● |
| Striebig | 250 | 3,2 | 2,2 | 30 | 2/10/60 | 60 | FZ/TR | 10 | 061351 | ● |
| | 250 | 3,2 | 2,2 | 30 | 2/7/42 | 80 | FZ/TR | 10 | 061357 | ● |
| | 300 | 3,2 | 2,2 | 30 | 2/7/42 | 72 | FZ/TR | 10 | 061358 | ● |
| Striebig | 300 | 3,2 | 2,2 | 30 | 2/7/42 | 96 | FZ/TR | 10 | 061352 | ● |
| | | | | | 2/10/60 | | | | | |
| Höfer | 300 | 4,4 | 3,0 | 30 | 2/10/60 | 60 | FZ/TR | 15 | 059250 | ● |
| Langzauner | | | | | | | | | | |
| Panhans | | | | | | | | | | |
| Selco | 300 | 4,4 | 3,0 | 65 | 2/9/110 | 60 | FZ/TR | 15 | 059667 | ● |
| Homag | 300 | 4,4 | 3,0 | 75 | | 60 | FZ/TR | 15 | 059309 | ● |
| Diverse | 305 | 4,4 | 3,0 | 30 | | 60 | FZ/TR | 15 | 059678 | ● |
| Höfer | 350 | 4,4 | 3,2 | 30 | 2/10/60 | 72 | FZ/TR | 15 | 059252 | ● |
| Langzauner | | | | | | | | | | |
| Panhans | | | | | | | | | | |
| Schelling | | | | | | | | | | |
| Holzma | 350 | 4,4 | 3,2 | 60 | 2/14/100 | 72 | FZ/TR | 15 | 059693 | ● |
| Homag | 350 | 4,4 | 3,2 | 75 | | 72 | FZ/TR | 15 | 059253 | ● |
| Gabbiani | 350 | 4,4 | 3,2 | 80 | 2/14/110 | 54 | FZ/TR | 15 | 059271 | ● |
| | | | | | 4/9/100 | | | | | |
| Giben | 355 | 4,4 | 3,2 | 75 | | 60 | FZ/TR | 15 | 059275 | ● |
| Homag | | | | | | | | | | |
| Selco | 355 | 4,4 | 3,2 | 80 | 2/9/130 | 72 | FZ/TR | 15 | 059656 | ● |
| | | | | | 4/19/120 | | | | | |
| Giben | 360 | 4,4 | 3,2 | 50 | 6/13/ 80 | 72 | FZ/TR | 18 | 059685 | ● |
| | | | | | 2/13/ 80 | | | | | |
| Giben | 380 | 4,4 | 3,2 | 50 | 6/13/ 80 | 72 | FZ/TR | 18 | 059686 | ● |
| | | | | | 2/13/ 80 | | | | | |
| Holzma | 380 | 4,4 | 3,2 | 60 | 2/14/100 | 72 | FZ/TR | 18 | 059681 | ● |
| Giben | 380 | 4,4 | 3,2 | 75 | 3/15/75 | 72 | FZ/TR | 15 | 059301 | ● |
| Holz Her | | | | | | | | | | |
| Holzma | 380 | 4,8 | 3,5 | 60 | 2/14/100 | 84 | TR/TR | 15 | 059314 | ● |
| Höfer | 400 | 4,4 | 3,2 | 30 | 2/10/60 | 72 | FZ/TR | 15 | 059256 | ● |
| Panhans | | | | | | | | | | |
| Scheer | | | | | | | | | | |
| Schelling | | | | | | | | | | |
| Homag | 400 | 4,4 | 3,2 | 75 | | 72 | FZ/TR | 15 | 059260 | ● |
| Giben | 400 | 4,4 | 3,2 | 75 | 4/15/105 | 72 | FZ/TR | 15 | 059293 | ● |

1. Sawing
1.5 Panel sizing
1.5.1 Panel sizing sawblades

| Machine | D mm | SB mm | TDI mm | BO mm | NLA mm | Z | ZF | SW De- gree | ID | |
|-----------|---------|----------|-----------|----------|----------------------|----|-------|-------------------|---------------|---|
| Selco | 400 | 4,4 | 3,2 | 80 | 2/9/130 4/19/120 | 72 | FZ/TR | 15 | 059291 | ● |
| Gabbiani | 400 | 4,4 | 3,2 | 80 | 2/14/110 4/9/100 | 80 | FZ/TR | 15 | 059454 | ● |
| Holzma | 420 | 4,8 | 3,5 | 60 | | 72 | FZ/TR | 15 | 059296 | ● |
| Holzma | 420 | 4,8 | 3,5 | 60 | | 84 | FZ/TR | 15 | 059300 | ● |
| Schelling | 430 | 4,4 | 3,2 | 30 | | 72 | FZ/TR | 15 | 059551 | ● |
| Giben | 430 | 4,4 | 3,2 | 75 | 4/15/105 | 72 | FZ/TR | 15 | 059277 | ● |
| Diverse | 450 | 4,4 | 3,2 | 30 | | 72 | FZ/TR | 15 | 059553 | ● |
| Anthon | 450 | 4,4 | 3,2 | 60 | 2/11/85 | 72 | FZ/TR | 15 | 059677 | □ |
| Scheer | 450 | 4,8 | 3,5 | 30 | 2/10/60 | 72 | FZ/TR | 18 | 059687 | ● |
| Holzma | 450 | 4,8 | 3,5 | 60 | 2/14/125 | 72 | FZ/TR | 15 | 059261 | ● |
| Holzma | 450 | 4,8 | 3,5 | 60 | 2/14/125 | 72 | TR/TR | 20 | 059316 | ● |
| Schelling | 460 | 4,4 | 3,2 | 30 | 2/13/94 | 72 | FZ/TR | 15 | 059303 | ● |
| Giben | 470 | 4,4 | 3,2 | 75 | 4/15/105 | 96 | FZ/TR | 15 | 059584 | ● |
| Schelling | 480 | 4,4 | 3,2 | 30 | | 72 | FZ/TR | 15 | 059679 | ● |
| Holzma | 480 | 4,8 | 3,5 | 60 | 2/19/120 | 72 | FZ/TR | 18 | 059688 | ● |
| Selco | 480 | 4,8 | 3,5 | 80 | 2/9/130 4/19/120 | 72 | FZ/TR | 15 | 059307 | ● |
| Holzma | 500 | 4,8 | 3,5 | 60 | 2/11/115 | 60 | FZ/TR | 15 | 059294 | ● |
| Holzma | 500 | 4,8 | 3,5 | 60 | 2/11/115 | 72 | TR/TR | 20 | 059317 | ● |
| Schelling | 500 | 5,2 | 3,5 | 30 | | 60 | FZ/TR | 15 | 059286 | ● |
| Selco | 510 | 4,8 | 3,5 | 80 | 2/9/130 4/19/120 | 72 | FZ/TR | 18 | 059689 | ● |
| Schelling | 520 | 4,4 | 3,2 | 30 | 2/13/94 | 72 | FZ/TR | 18 | 059690 | ● |
| Holzma | 520 | 4,8 | 3,5 | 60 | 2/11/115 2/19/120 | 84 | TR/TR | 15 | 059658 | ● |
| Schelling | 530 | 5,2 | 3,5 | 30 | | 60 | FZ/TR | 15 | 059287 | ● |
| Holzma | 540 | 4,8 | 3,5 | 60 | 2/11/115 2/19/120 | 72 | FZ/TR | 15 | 059659 | ● |
| Holzma | 540 | 4,8 | 3,5 | 60 | 2/11/115 2/19/120 | 84 | TR/TR | 15 | 059660 | ● |
| Giben | 550 | 5,0 | 3,5 | 100 | | 72 | FZ/TR | 15 | 059280 | ● |
| Giben | 565 | 5,0 | 3,5 | 100 | | 72 | FZ/TR | 15 | 059370 | ● |
| Holzma | 600 | 5,8 | 4 | 60 | 2/11/115 2/19/120 | 72 | FZ/TR | 22 | 059371 | ● |
| Holzma | 670 | 5,8 | 4,2 | 60 | 2/11/148 2/19/120 | 42 | FZ/TR | 22 | 059372 | ● |
| Schelling | 680 | 6,2 | 4,2 | 40 | | 60 | FZ/TR | 22 | 059374 | ● |
| Anthon | 700 | 6,2 | 4,2 | 80 | 1/17/110 | 60 | FZ/TR | 22 | 059375 | ● |
| Schelling | 720 | 6,5 | 4,5 | 40 | 2/14/140 2/14/114 | 60 | FZ/TR | 22 | 059376 | ● |
| Holzma | 730 | 6,2 | 4,2 | 60 | 2/11/148 2/19/120 | 60 | FZ/TR | 22 | 059377 | ● |
| Selco | 750 | 7,0 | 5 | 110 | 6/9/190 | 72 | FZ/TR | 22 | 059378 | ● |



Sizing cuts - uncoated/coated wood products

Application:

For sizing individual boards and stacks of boards on high-performance panel sizing saws with pre-scoring sawblade.

Machine:

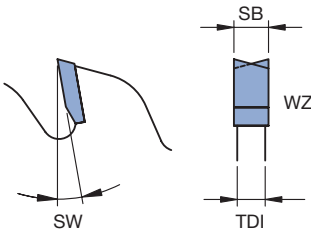
Sizing saw machines and panel sizing saws with pre-scoring unit and pressure beam.

Workpiece material:

Uncoated, veneered, paper and plastic coated chipboard material and fibre boards or glulam.

Technical information:

Stable tool body tooth shape. At feed speeds of $V_f > 40$ m/min the machine regrinds from WZ to WZ/FA.



Sawblade

WK 850-2

| Machine | D mm | SB mm | TDI mm | BO mm | NLA mm | Z | ZF | SW Degree | ID |
|-----------|---------|----------|-----------|----------|----------------------|----|----|--------------|----------|
| Schelling | 670 | 6,0 | 4,0 | 40 | 1/11/140 | 60 | WZ | 22 | 059386 ● |
| Schelling | 680 | 6,2 | 4,2 | 40 | | 60 | WZ | 22 | 059387 ● |
| Anthon | 700 | 6,2 | 4,4 | 80 | 1/17/110 | 60 | WZ | 22 | 059388 ● |
| Schelling | 720 | 6,5 | 4,5 | 40 | 2/14/140 2/14/114 | 60 | WZ | 22 | 059389 ● |
| Holzma | 730 | 6,2 | 4,2 | 60 | 2/11/148 2/19/120 | 60 | WZ | 22 | 059390 ● |

1. Sawing

1.5 Panel sizing 1.5.1 Panel sizing sawblades



Sizing cuts - coated wood products - LowNoise design

Application:

For noise-reduced sizing of individual boards and stacks of boards with pre-scoring sawblade.

Machine:

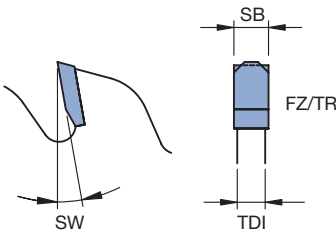
Sizing saw machines and panel sizing saws with pre-scoring unit and pressure beam.

Workpiece material:

Plastic-coated particle and fibre materials (MDF, HDF, WF etc.), compound materials (fibre-reinforced gypsum-plaster boards) and plastic panels.

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 body design by steel foil.



Sawblade - AS LowNoise foil right

WK 872-3, WK 852-2

| Machine | D mm | SB mm | TDI mm | BO mm | NLA mm | Z | ZF | SW Degree | ID |
|--------------------|---------|----------|-----------|----------|---------------------|----|-------|--------------|-----------------|
| SCM | 300 | 4,4 | 2,8 | 80 | 2/14/110 2/7/110 | 60 | FZ/TR | 15 | 065338 ● |
| Gabbiani SCM | 350 | 4,4 | 3,0 | 80 | 2/14/110 2/7/110 | 72 | FZ/TR | 15 | 065339 ● |
| Holzma | 380 | 4,8 | 3,5 | 60 | 2/14/100 | 72 | FZ/TR | 15 | 065337 ● |
| SCM | 400 | 4,4 | 3,0 | 80 | 2/14/110 2/7/110 | 72 | FZ/TR | 15 | 065340 ● |
| Gabbiani SCM | 450 | 4,4 | 3,0 | 80 | 2/14/110 2/7/110 | 72 | FZ/TR | 15 | 065341 ● |
| Striebig Holzma | 450 | 4,8 | 3,5 | 60 | 2/14/125 | 72 | FZ/TR | 15 | 065349 ● |



Sizing cuts - coated wood products - LowNoise design

Application:

For noise-reduced sizing of individual boards and stacks of boards with pre-scoring sawblade.

Machine:

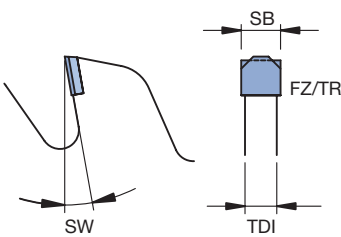
Sizing saw machines and panel sizing saws with pre-scoring unit and pressure beam.

Workpiece material:

Plastic coated chipboard material and fibre boards (MDF, HDF, WF etc.), compound materials (fibre reinforced gypsum plaster boards and cement boards) and plastic boards (GFK, CFK etc.).

Technical information:

Stable tool body tooth shape. **AS LowNoise UT** design - Noise reduction during no-load operation by up to 6 dB(A). Tool body with vibration damping irregular tooth pitch. **Diamaster PLUS** design with 6.0 mm tipping height.



Sawblade - AS LowNoise UT, Diamaster PLUS

WK 852-2

| D | SB | TDI | BO | BO _{max.} | NLA | FLD | Z | ZF | SW | ID |
|-----|-----|-----|----|--------------------|----------------------|-----|----|-------|--------|-----------------|
| mm | mm | mm | mm | mm | mm | mm | | | Degree | |
| 300 | 4,4 | 3,2 | 30 | 80 | 2/10/ 60 | 120 | 60 | FZ/TR | 15 | 190604 ● |
| 350 | 4,4 | 3,2 | 30 | 100 | 2/10/ 60 | 120 | 60 | FZ/TR | 15 | 190605 ● |
| 350 | 4,4 | 3,2 | 30 | 100 | 2/10/ 60 | 120 | 72 | FZ/TR | 15 | 190606 ● |
| 380 | 4,8 | 3,5 | 60 | 100 | 2/14/100 2/14/125 | 140 | 72 | FZ/TR | 15 | 190607 ● |
| 400 | 4,4 | 3,2 | 30 | 100 | 2/10/ 60 | 140 | 72 | FZ/TR | 15 | 190608 ● |

1. Sawing

1.5 Panel sizing 1.5.1 Panel sizing sawblades



Sizing cuts in finish cut quality - coated wood products - LowNoise design

Application:

For noise-reduced sizing in finish cut quality of individual boards and stacks of boards with pre-scoring sawblade.

Machine:

Sizing saw machines and panel sizing saws with pre-scoring unit and pressure beam.

Workpiece material:

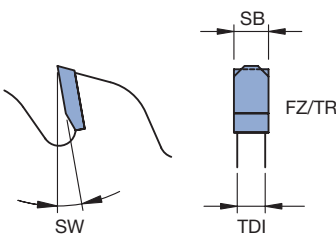
Paper- and plastic-coated particle and fibre materials (MDF, HDF, WF etc.) and plastic panels.

Technical information:

Special cutting geometry for perfect cut surfaces and break-out-free cut edges.

AS OptiCut UT design - Noise reduction during no-load operation by up to 8 dB(A).

Tool body with laser ornaments and irregular tooth pitch.



Sawblade - AS OptiCut UT

WK 852-2, WK 852-2-37, WK 872-2-87

| D mm | SB mm | TDI mm | BO mm | NLA mm | Z | ZF | SW Degree | ID |
|---------|----------|-----------|----------|----------------------|----|-------|--------------|-----------------|
| 250 | 3,2 | 2,2 | 30 | 2/ 7/ 42 2/10/ 60 | 60 | FZ/TR | 15 | 069088 ● |
| 280 | 3,2 | 2,2 | 30 | 2/10/60 | 60 | FZ/TR | 10 | 061353 ● |
| 300 | 3,5 | 2,5 | 30 | 2/10/60 2/7/42 | 60 | FZ/TR | 10 | 069021 ● |
| 300 | 4,4 | 3,0 | 30 | 2/10/60 | 60 | FZ/TR | 10 | 069016 ● |
| 320 | 4,4 | 3,2 | 50 | 3/15/80 | 60 | FZ/TR | 15 | 061361 ● |
| 320 | 4,4 | 3,2 | 75 | 3/13/95 | 60 | FZ/TR | 15 | 061362 ● |
| 350 | 4,4 | 3,2 | 30 | 2/10/60 | 72 | FZ/TR | 15 | 069018 ● |
| 360 | 4,4 | 3,2 | 65 | 2/9/110 | 72 | FZ/TR | 15 | 059683 ● |
| 370 | 4,4 | 3,2 | 30 | 2/10/60 | 72 | FZ/TR | 15 | 059319 ● |
| 380 | 4,8 | 3,5 | 60 | 2/14/100 | 72 | FZ/TR | 15 | 069089 ● |
| 400 | 4,4 | 3,2 | 30 | 2/10/60 | 72 | FZ/TR | 15 | 069017 ● |
| 430 | 4,4 | 3,2 | 80 | 2/9/130 4/19/120 | 72 | FZ/TR | 15 | 069090 ● |
| 450 | 4,8 | 3,6 | 60 | 2/14/125 | 72 | FZ/TR | 15 | 061354 ● |
| 450 | 4,8 | 3,6 | 80 | 2/9/130 4/19/120 | 72 | FZ/TR | 15 | 069097 ● |



Sizing cuts in finish cut quality - coated wood products - LowNoise design

Application:

For noise-reduced sizing in finish cut quality of individual boards and stacks of boards with pre-scoring sawblade.

Machine:

Sizing saw machines and panel sizing saws with pre-scoring unit and pressure beam.

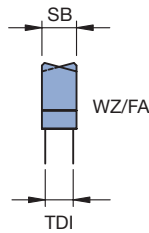
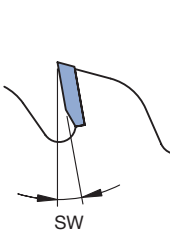
Workpiece material:

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

Technical information:

Special cutting geometry for perfect cut surfaces and break-out-free cut edges.

AS LowNoise foil design - Noise reduction during operation by up to 10 dB(A).
Vibration damping tipped tool body design.

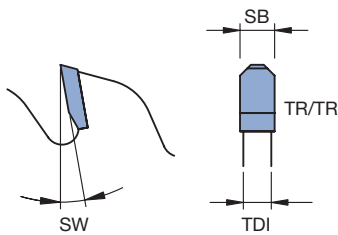


Sawblade - AS LowNoise design

WK 871-2, WK 871-3

| D | SB | TDI | BO | BO _{max.} | NLA | FLD | Dampfoil | Z | ZF | SW | ID |
|-----|-----|-----|----|--------------------|----------|-----|----------|----|-------|--------|-----------------|
| mm | mm | mm | mm | mm | mm | mm | mm | | | Degree | |
| 300 | 3,5 | 2,5 | 30 | 70 | 2/10/60 | 120 | right | 20 | WZ/FA | 15 | 065342 ● |
| 300 | 3,5 | 2,5 | 30 | 70 | 2/10/60 | 120 | right | 60 | WZ/FA | 15 | 065343 ● |
| 350 | 4,4 | 3,2 | 30 | 70 | 2/10/60 | 120 | right | 64 | WZ/FA | 15 | 065345 ● |
| 380 | 4,8 | 3,5 | 60 | | 2/14/100 | 140 | left | 72 | WZ/FA | 15 | 065353 ● |
| 400 | 4,4 | 3,2 | 30 | 70 | 2/10/60 | 140 | right | 72 | WZ/FA | 15 | 065346 ● |
| 450 | 4,8 | 3,5 | 30 | 70 | 2/14/125 | 160 | right | 72 | WZ/FA | 15 | 065347 ● |
| 450 | 4,8 | 3,5 | 60 | 70 | 2/14/125 | 150 | left | 72 | WZ/FA | 15 | 065348 ● |

1. Sawing

 1.5 Panel sizing
 1.5.1 Panel sizing sawblades

Sizing cuts in finish cut quality - coated wood products - LowNoise design
Application:

For noise-reduced sizing in finish cut quality with pre-scoring sawblade.

Machine:

Sizing saw machines and panel sizing saws with pre-scoring unit and pressure beam.

Workpiece material:

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

Technical information:

Special cutting geometry for perfect cut surfaces and break-out-free cut edges.

AS OptiCut UT design - Noise reduction during no-load operation by up to 8 dB(A).

Tool body with laser ornaments and irregular tooth pitch. Increased cutting performance and reduced resin build-up from special tool body coating.

Sawblade - RazorCut design

WK 878-2

| Maschine | D mm | SB mm | TDI mm | BO mm | NLA mm | Z | ZF | SW Grad | ID |
|------------------------------|---------|----------|-----------|----------|---------------------|----|-------|------------|-----------------|
| Striebig | 250 | 3,2 | 2,2 | 30 | 2/7/42 2/10/60 | 60 | TR/TR | 15 | 069100 ● |
| | 280 | 3,2 | 2,2 | 30 | 2/10/60 | 60 | TR/TR | 15 | 069101 ● |
| Striebig | 300 | 3,2 | 2,2 | 30 | 2/7/42 2/10/60 | 72 | TR/TR | 15 | 069102 ● |
| | 300 | 3,5 | 2,5 | 30 | 2/7/42 2/10/60 | 60 | TR/TR | 15 | 069103 ● |
| Höfer, Panhans Langzauner | 300 | 4,4 | 3,0 | 30 | 2/10/60 | 60 | TR/TR | 15 | 069104 ● |
| Selco | 300 | 4,4 | 3,0 | 65 | 2/9/110 | 60 | TR/TR | 15 | 069105 ● |
| Homag | 300 | 4,4 | 3,0 | 75 | | 60 | TR/TR | 15 | 069106 ● |
| | 320 | 4,4 | 3,2 | 50 | 3/15/80 | 60 | TR/TR | 15 | 069108 ● |
| Höfer, Panhans Langzauner | 350 | 4,4 | 3,2 | 30 | 2/10/60 | 72 | TR/TR | 15 | 069109 ● |
| Schelling | | | | | | | | | |
| Homag | 350 | 4,4 | 3,2 | 75 | | 72 | TR/TR | 15 | 069110 □ |
| Selco | 355 | 4,4 | 3,2 | 80 | 2/9/130 4/19/120 | 72 | TR/TR | 15 | 069111 ● |
| | 370 | 4,4 | 3,2 | 30 | 2/10/60 | 72 | TR/TR | 15 | 069112 ● |
| Giben | 380 | 4,4 | 3,2 | 75 | 3/15/75 | 72 | TR/TR | 15 | 069113 ● |
| Holzher | | | | | | | | | |
| Holzma | 380 | 4,8 | 3,5 | 60 | 2/14/100 | 72 | TR/TR | 15 | 069114 ● |
| Höfer, Panhans | 400 | 4,4 | 3,2 | 30 | 2/10/60 | 72 | TR/TR | 15 | 069115 ● |
| Schelling | | | | | | | | | |
| Giben, Homag | 400 | 4,4 | 3,2 | 75 | 4/15/105 | 72 | TR/TR | 15 | 069117 □ |
| Selco | 400 | 4,4 | 3,2 | 80 | 2/9/130 4/19/120 | 72 | TR/TR | 15 | 069118 □ |
| | 430 | 4,4 | 3,2 | 30 | 2/9/130 4/19/120 | 72 | TR/TR | 15 | 069119 ● |
| | 430 | 4,4 | 3,2 | 75 | 4/15/105 | 72 | TR/TR | 15 | 069120 □ |
| | 430 | 4,4 | 3,2 | 80 | 2/9/130 4/19/120 | 72 | TR/TR | 15 | 069121 ● |
| | 450 | 4,4 | 3,2 | 30 | | 72 | TR/TR | 15 | 069122 ● |
| Anthon | 450 | 4,4 | 3,2 | 60 | 2/11/85 | 72 | TR/TR | 15 | 069123 □ |
| Holzma | 450 | 4,8 | 3,6 | 60 | 2/14/125 | 72 | TR/TR | 15 | 069125 ● |
| Schelling | 460 | 4,4 | 3,2 | 30 | 2/13/94 | 72 | TR/TR | 15 | 069126 ● |
| Selco | 480 | 4,8 | 3,5 | 80 | 2/9/130 4/19/120 | 72 | TR/TR | 15 | 069127 ● |
| | 520 | 4,4 | 3,2 | 30 | 2/13/94 | 72 | TR/TR | 15 | 069128 ● |



Scoring - universal

Application:

For scoring with feed with scoring depths of 1.50 - 2.00 mm.

Machine:

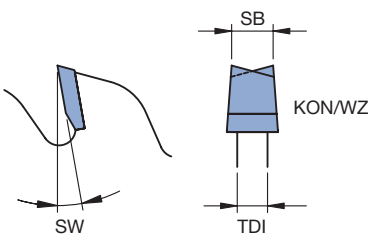
Sizing saw machines and panel sizing saws with pre-scoring unit and pressure beam.

Workpiece material:

Paper- and plastic-coated or veneered particle and fibre materials or laminated wood as well as compound materials (gypsum plaster board and mineral wool boards).

Technical information:

The cutting width of the scoring sawblade must be identical to the cutting width of the main sawblade. If type UT **AS OptiCut UT** design is used - noise reduction during no-load operation by up to 3 dB(A). Tool body with irregular tooth pitch.



Sawblade

WK 856-2, WK 856-2-01, WK 856-2-05

| Machine | D | SB | TDI | BO | NLA | Z | ZF | SW | Type | n _{max} | ID |
|------------|-----|-----|-----|----|---------|----|--------|--------|------|-------------------|-----------------|
| | mm | mm | mm | mm | mm | | | Degree | | min ⁻¹ | |
| Panhans | 125 | 3,2 | 2,5 | 20 | | 24 | KON/WZ | 5 | | 18300 | 061470 ● |
| | 125 | 3,2 | 2,5 | 22 | | 24 | KON/WZ | 5 | | 18300 | 061507 ● |
| Scheer | 140 | 3,2 | 2,5 | 16 | 1/6/33 | 32 | KON/WZ | 5 | | 16300 | 061538 ● |
| | 150 | 3,2 | 2,5 | 20 | | 24 | KON/WZ | 5 | | 15200 | 061471 ● |
| SCM | 150 | 3,2 | 2,5 | 30 | | 24 | KON/WZ | 5 | | 15200 | 061472 ● |
| Langzauner | 160 | 3,2 | 2,5 | 20 | | 32 | KON/WZ | 5 | | 14300 | 061543 ● |
| Scheer | 180 | 3,2 | 2,5 | 16 | 1/6/33 | 36 | KON/WZ | 5 | | 12700 | 061473 ● |
| Höfer | 180 | 3,2 | 2,5 | 20 | | 36 | KON/WZ | 5 | | 12700 | 061493 ● |
| Scheer | 200 | 3,2 | 2,5 | 30 | | 60 | KON/WZ | 5 | | 11400 | 061549 ● |
| Martin | 125 | 4,4 | 3,5 | 22 | | 24 | KON/WZ | 5 | | 18300 | 061474 ● |
| Giben | 125 | 4,4 | 3,5 | 45 | | 20 | KON/WZ | 5 | | 18300 | 061485 ● |
| Homag | | | | | | | | | | | |
| Mayer | | | | | | | | | | | |
| Schelling | 150 | 4,4 | 3,5 | 20 | | 24 | KON/WZ | 5 | | 15200 | 061477 ● |
| Irion | 150 | 4,4 | 3,5 | 30 | | 24 | KON/WZ | 5 | | 15200 | 061486 ● |
| Mayer | | | | | | | | | | | |
| SCM | | | | | | | | | | | |
| Steton | | | | | | | | | | | |
| Homag | 150 | 4,4 | 3,5 | 45 | | 24 | KON/WZ | 5 | | 15200 | 061530 ● |
| Steton | 160 | 4,4 | 3,5 | 30 | | 36 | KON/WZ | 5 | | 14300 | 061495 ● |
| Giben | 160 | 4,4 | 3,2 | 45 | 3/11/70 | 28 | KON/WZ | 5 | | 14300 | 061509 ● |
| Gabbiani | 160 | 4,4 | 3,5 | 55 | 3/7/66 | 36 | KON/WZ | 5 | | 14300 | 061487 ● |
| SCM | | | | | | | | | | | |
| Anthon | 180 | 4,4 | 3,5 | 45 | | 36 | KON/WZ | 5 | UT | 12700 | 061553 ● |
| Anthon | 180 | 4,4 | 3,5 | 20 | | 30 | KON/WZ | 5 | | 12700 | 061478 ● |
| Höfer | | | | | | | | | | | |
| Schelling | | | | | | | | | | | |
| Homag | 180 | 4,4 | 3,5 | 45 | | 30 | KON/WZ | 5 | | 12700 | 061544 ● |
| Giben | 180 | 4,5 | 3,2 | 50 | 3/13/80 | 36 | KON/WZ | 5 | | 12700 | 061558 ● |
| Schelling | 200 | 4,3 | 4,5 | 20 | | 24 | KON/WZ | 5 | | 11400 | 061522 ● |
| Höfer | 200 | 4,4 | 3,5 | 20 | | 34 | KON/WZ | 5 | | 11400 | 061479 ● |
| Langzauner | | | | | | | | | | | |
| Schelling | | | | | | | | | | | |
| Scheer | 200 | 4,4 | 3,5 | 30 | | 36 | KON/WZ | 5 | | 11400 | 061489 ● |
| Holzma | 200 | 4,4 | 3,5 | 45 | | 36 | KON/WZ | 5 | | 11400 | 061490 ● |
| Selco | 200 | 4,4 | 3,5 | 65 | 2/9/100 | 36 | KON/WZ | 5 | | 11400 | 061505 ● |
| | | | | | 2/9/110 | | | | | | |
| | 200 | 4,5 | 3,2 | 50 | 3/13/80 | 44 | KON/WZ | 5 | UT | 11400 | 061559 ● |
| Giben | 215 | 4,4 | 3,2 | 50 | 3/15/80 | 42 | KON/WZ | 5 | | 10600 | 061508 ● |
| Giben | 300 | 4,4 | 3,2 | 50 | 3/15/80 | 48 | KON/WZ | 5 | | 7600 | 061510 ● |

1. Sawing

1.5 Panel sizing 1.5.2 Scoring sawblades

| Machine | D mm | SB mm | TDI mm | BO mm | NLA mm | Z | ZF | SW Degree | Type | n_{max} , min ⁻¹ | ID | |
|-----------|---------|----------|-----------|----------|-----------|----|--------|--------------|------|----------------------------------|---------------|---|
| | 300 | 4,4 | 3,2 | 30 | | 48 | KON/WZ | 5 | | 7600 | 061555 | ● |
| Selco | 300 | 4,4 | 3,5 | 65 | 2/9/100 | 72 | KON/WZ | 5 | | 7600 | 061529 | ● |
| | | | | | 2/9/110 | | | | | | | |
| Scheer | 200 | 4,8 | 3,5 | 30 | 2/10/60 | 36 | KON/WZ | 5 | | 11400 | 061562 | □ |
| Selco | 200 | 4,8 | 3,5 | 65 | 2/9/110 | 36 | KON/WZ | 5 | | 11400 | 061528 | ● |
| Giben | 180 | 5,0 | 3,5 | 55 | | 30 | KON/WZ | 5 | | 12700 | 061500 | ● |
| Schelling | 200 | 5,2 | 3,5 | 20 | | 24 | KON/WZ | 5 | | 11400 | 061501 | ● |
| Schelling | 200 | 5,4 | 4,5 | 20 | | 24 | KON/WZ | 5 | | 11400 | 061523 | ● |
| Holzma | 200 | 5,8 | 4,6 | 45 | | 34 | KON/WZ | 5 | | 11400 | 061499 | ● |
| Anthon | 180 | 6,0 | 4,0 | 20 | | 30 | KON/WZ | 5 | | 12700 | 061520 | ● |
| Schelling | 200 | 6,2 | 4,5 | 20 | | 36 | KON/WZ | 5 | | 11400 | 061546 | ● |
| Holzma | 200 | 6,2 | 4,2 | 45 | | 36 | KON/WZ | 5 | | 11400 | 061547 | ● |
| Schelling | 220 | 6,5 | 4,5 | 20 | | 36 | KON/WZ | 5 | | 10400 | 061560 | ● |
| Anthon | 180 | 7,0 | 5,0 | 20 | | 30 | KON/WZ | 5 | | 12700 | 061545 | ● |
| Selco | 250 | 7,0 | 5,0 | 75 | 4/9/116 | 36 | KON/WZ | 5 | | 9100 | 061548 | ● |



Scoring - coated wood products

Application:

For scoring with feed with scoring depths of 1.50 - 2.00 mm.

Machine:

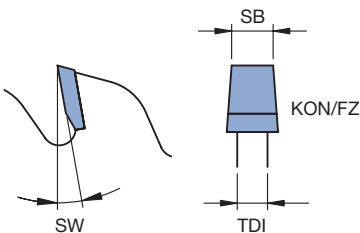
Sizing saw machines and panel sizing saws with pre-scoring unit and pressure beam.

Workpiece material:

Plastic-coated particle and fibre materials or compound materials (gypsum-plaster and mineral-wool boards).

Technical information:

The cutting width of the scoring sawblade must be identical to the cutting width of the main sawblade. If type UT **AS OptiCut UT** design is used - noise reduction during no-load operation by up to 3 dB(A). Tool body with irregular tooth pitch.



Sawblade

WK 804-2

| Machine | D mm | SB mm | TDI mm | BO mm | NLA mm | Z | ZF | SW Degree | Type | n_{max} , min ⁻¹ | ID | |
|------------|---------|----------|-----------|----------|-----------|----|--------|--------------|------|----------------------------------|---------------|---|
| SCM | 100 | 3,2 | 2,5 | 20 | | 20 | KON/FZ | 5 | | 22900 | 061556 | ● |
| | 100 | 3,2 | 2,5 | 22 | | 20 | KON/FZ | 5 | | 22900 | 061557 | ● |
| | 120 | 3,2 | 2,5 | 20 | | 24 | KON/FZ | 5 | | 19000 | 061552 | ● |
| Panhans | 220 | 3,2 | 2,5 | 30 | | 36 | KON/FZ | 5 | | 10400 | 061535 | ● |
| Panhans | 125 | 4,4 | 3,5 | 20 | | 24 | KON/FZ | 5 | | 18300 | 061516 | ● |
| Holz Her | 125 | 4,4 | 3,5 | 45 | | 24 | KON/FZ | 5 | | 18300 | 061518 | □ |
| Holz Her | 140 | 4,4 | 3,5 | 45 | 1/8/58 | 24 | KON/FZ | 5 | | 16300 | 061519 | ● |
| Panhans | 180 | 4,4 | 3,5 | 30 | 2/10/60 | 30 | KON/FZ | 5 | | 12700 | 061517 | ● |
| Teutomatic | | | | | | | | | | | | |
| SCM | 200 | 5,5 | 3,5 | 80 | 2/14/110 | 36 | KON/FZ | 5 | UT | 11400 | 061542 | ● |
| Panhans | 250 | 4,4 | 3,5 | 30 | 2/10/60 | 42 | KON/FZ | 5 | | 9100 | 061537 | ● |
| Panhans | 280 | 4,4 | 3,0 | 30 | 2/10/60 | 48 | KON/FZ | 5 | | 8100 | 061540 | ● |
| Holzma | 180 | 4,8 | 3,5 | 45 | | 36 | KON/FZ | 5 | UT | 12700 | 061526 | ● |
| Scheer | 200 | 4,8 | 3,5 | 30 | 2/10/60 | 36 | KON/FZ | 5 | UT | 11400 | 061561 | ● |
| Holzma | 200 | 4,8 | 3,5 | 45 | | 36 | KON/FZ | 5 | UT | 11400 | 061527 | ● |



Scoring - universal, AS LowNoise UT design

Application:

For noise-reduced scoring with feed with scoring depths of 2.00 - 2.50 mm.

Machine:

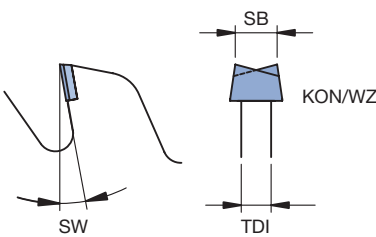
Sizing saw machines and panel sizing saws with pre-scoring unit and pressure beam.

Workpiece material:

Paper- and plastic-coated or veneered particle and fibre materials or laminated wood as well as compound materials (gypsum plaster board and mineral wool boards).

Technical information:

The cutting width of the scoring sawblade must be 0.10 mm lower than the cutting width of the main sawblade. **AS LowNoise** design - Noise reduction during no-load operation by up to 3 dB(A). Tool body with irregular tooth pitch. **Diamaster PLUS** design with 6.00 mm tipping height.



Sawblade - AS LowNoise UT design - Diamaster PLUS

WK 856-2

| D | SB | TDI | BO | NLA | Z | ZF | SW | n _{max} | ID |
|-----|-----|-----|----|----------|----|--------|--------|-------------------|-----------------|
| mm | mm | mm | mm | mm | | | Degree | min ⁻¹ | |
| 125 | 3,1 | 2,5 | 20 | | 20 | KON/WZ | 10 | 18300 | 190584 ● |
| 125 | 3,1 | 2,5 | 22 | | 20 | KON/WZ | 10 | 18300 | 190617 □ |
| 150 | 4,3 | 3,2 | 20 | | 24 | KON/WZ | 10 | 15200 | 190585 ● |
| 150 | 4,3 | 3,2 | 30 | | 24 | KON/WZ | 10 | 15200 | 190586 □ |
| 150 | 4,3 | 3,2 | 45 | | 24 | KON/WZ | 10 | 15200 | 190587 □ |
| 160 | 4,3 | 3,5 | 30 | | 30 | KON/WZ | 10 | 14300 | 190588 ● |
| 160 | 4,3 | 3,2 | 45 | 3/11/ 70 | 30 | KON/WZ | 10 | 14300 | 190589 □ |
| 160 | 4,3 | 3,5 | 55 | 3/ 7/ 66 | 30 | KON/WZ | 10 | 14300 | 190590 □ |
| 180 | 4,3 | 3,5 | 20 | 2/10/ 60 | 30 | KON/WZ | 10 | 12700 | 190591 ● |
| 180 | 4,3 | 3,5 | 30 | 2/10/60 | 30 | KON/WZ | 10 | 12700 | 190592 □ |
| 180 | 4,3 | 3,5 | 45 | | 30 | KON/WZ | 10 | 12700 | 190593 □ |
| 180 | 4,3 | 3,2 | 50 | 3/13/80 | 30 | KON/WZ | 10 | 12700 | 190594 □ |
| 180 | 4,7 | 3,5 | 45 | | 30 | KON/WZ | 10 | 12700 | 190595 ● |
| 200 | 4,3 | 3,5 | 20 | | 30 | KON/WZ | 10 | 11400 | 190596 ● |
| 200 | 4,3 | 3,5 | 30 | 2/10/ 60 | 30 | KON/WZ | 10 | 11400 | 190597 □ |
| 200 | 4,3 | 3,5 | 45 | | 30 | KON/WZ | 10 | 11400 | 190598 □ |
| 200 | 4,3 | 3,2 | 50 | 3/13/ 80 | 30 | KON/WZ | 10 | 11400 | 190599 □ |
| 200 | 4,3 | 3,5 | 65 | 2/ 9/100 | 30 | KON/WZ | 10 | 11400 | 190618 □ |
| | | | | 2/ 9/110 | | | | | |
| 200 | 4,3 | 3,5 | 80 | 2/14/110 | 30 | KON/WZ | 10 | 11400 | 190619 □ |
| 200 | 4,7 | 3,5 | 45 | | 30 | KON/WZ | 10 | 11400 | 190600 □ |
| 200 | 4,7 | 3,5 | 65 | 2/ 9/110 | 30 | KON/WZ | 10 | 11400 | 190601 □ |
| 215 | 4,3 | 3,2 | 50 | 3/15/ 80 | 36 | KON/WZ | 10 | 10600 | 190602 □ |
| 250 | 4,3 | 3,5 | 30 | 2/10/ 60 | 36 | KON/WZ | 10 | 9100 | 190603 □ |

1. Sawing

 1.5 Panel sizing
 1.5.2 Scoring sawblades

Scoring - coated wood products, LowNoise design
Application:

For noise-reduced scoring with feed with scoring depths of 2.00 - 2.50 mm.

Machine:

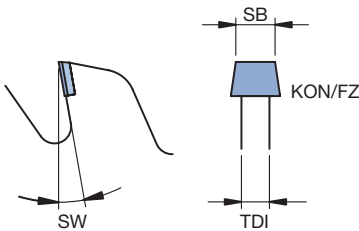
Sizing saw machines and panel sizing saws with pre-scoring unit and pressure beam.

Workpiece material:

Plastic-coated particle and fibre materials or compound materials (gypsum plaster board and mineral wool boards).

Technical information:

 The cutting width of the scoring sawblade must be 0.10 mm lower than the cutting width of the main sawblade. **AS LowNoise UT** design - Noise reduction during no-load operation by up to 3 dB(A). Tool body with irregular tooth pitch.

Diamaster PLUS design with 6.00 mm tipping height.

Sawblade - AS LowNoise UT design - Diamaster PLUS

WK 804-2

| D | SB | TDI | BO | NLA | Z | ZF | SW | $n_{max.}$ | ID |
|-----|-----|-----|----|----------|----|--------|--------|------------|-----------------|
| mm | mm | mm | mm | mm | | | Degree | min^{-1} | |
| 125 | 3,1 | 2,5 | 20 | | 20 | KON/FZ | 10 | 18300 | 190564 ● |
| 125 | 3,1 | 2,5 | 22 | | 20 | KON/FZ | 10 | 18300 | 190614 □ |
| 150 | 4,3 | 3,2 | 20 | | 24 | KON/FZ | 10 | 15200 | 190577 ● |
| 150 | 4,3 | 3,2 | 30 | | 24 | KON/FZ | 10 | 15200 | 190565 ● |
| 150 | 4,3 | 3,2 | 45 | | 24 | KON/FZ | 10 | 15200 | 190578 □ |
| 160 | 4,3 | 3,5 | 30 | | 30 | KON/FZ | 10 | 14300 | 190579 ● |
| 160 | 4,3 | 3,2 | 45 | 3/11/ 70 | 30 | KON/FZ | 10 | 14300 | 190580 ● |
| 160 | 4,3 | 3,5 | 55 | 3/ 7/ 66 | 30 | KON/FZ | 10 | 14300 | 190566 □ |
| 180 | 4,3 | 3,5 | 20 | 2/10/ 60 | 30 | KON/FZ | 10 | 12700 | 190581 ● |
| 180 | 4,3 | 3,5 | 30 | 2/10/ 60 | 30 | KON/FZ | 10 | 12700 | 190567 ● |
| 180 | 4,3 | 3,5 | 45 | | 30 | KON/FZ | 10 | 12700 | 190568 ● |
| 180 | 4,3 | 3,2 | 50 | 3/13/ 80 | 30 | KON/FZ | 10 | 12700 | 190582 ● |
| 180 | 4,7 | 3,5 | 45 | | 30 | KON/FZ | 10 | 12700 | 190569 ● |
| 200 | 4,3 | 3,5 | 20 | | 30 | KON/FZ | 10 | 11400 | 190570 ● |
| 200 | 4,3 | 3,5 | 30 | 2/10/ 60 | 30 | KON/FZ | 10 | 11400 | 190571 ● |
| 200 | 4,3 | 3,5 | 45 | | 30 | KON/FZ | 10 | 11400 | 190572 ● |
| 200 | 4,3 | 3,2 | 50 | 3/13/ 80 | 30 | KON/FZ | 10 | 11400 | 190583 □ |
| 200 | 4,3 | 3,5 | 65 | 2/ 9/100 | 30 | KON/FZ | 10 | 11400 | 190615 □ |
| | | | | 2/ 9/110 | | | | | |
| 200 | 4,3 | 3,5 | 80 | 2/14/110 | 30 | KON/FZ | 10 | 11400 | 190616 □ |
| 200 | 4,7 | 3,5 | 45 | | 30 | KON/FZ | 10 | 11400 | 190573 ● |
| 200 | 4,7 | 3,5 | 65 | 2/ 9/110 | 30 | KON/FZ | 10 | 11400 | 190574 ● |
| 215 | 4,3 | 3,2 | 50 | 3/15/ 80 | 36 | KON/FZ | 10 | 10600 | 190575 ● |
| 250 | 4,3 | 3,5 | 30 | 2/10/ 60 | 36 | KON/FZ | 10 | 9100 | 190576 ● |



Soft- and postforming profiles

Application:

For scoring with feed at high feed rates and deep cutting depths.

Machine:

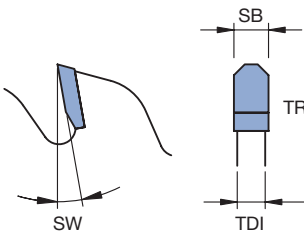
Panel sizing units with controllable soft- and postforming scoring units.

Workpiece material:

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

Technical information:

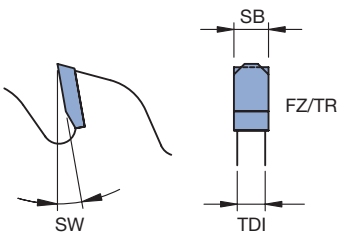
Tooth shape to manufacturers' specifications.



Sawblade - TR tooth shape

WK 803-2-37

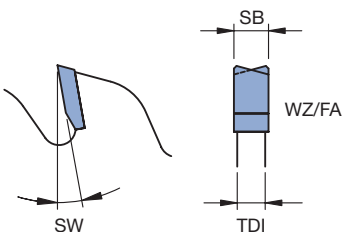
| Machine | D | SB | TDI | BO | NLA | Z | ZF | SW | $n_{max.}$ | ID |
|---------|-----|------|-----|----|---------|----|----|--------|------------|-----------------|
| | mm | mm | mm | mm | mm | | | Degree | min^{-1} | |
| Giben | 300 | 4,6 | 3,2 | 50 | 3/15/80 | 80 | TR | 10 | 7600 | 068000 ● |
| Holzma | 340 | 4,95 | 3,5 | 45 | | 80 | TR | 15 | 6700 | 061606 ● |



Sawblade - FZ7TR tooth shape

WK 852-2

| Machine | D | SB | TDI | BO | NLA | Z | ZF | SW | $n_{max.}$ | ID |
|------------|-----|------|-----|----|---------|----|-------|--------|------------|-----------------|
| | mm | mm | mm | mm | mm | | | Degree | min^{-1} | |
| Panhans | 220 | 3,35 | 2,5 | 30 | | 48 | FZ/TR | 10 | 10400 | 061536 ● |
| Panhans | 250 | 4,55 | 3,5 | 30 | 2/10/60 | 48 | FZ/TR | 10 | 9100 | 061521 ● |
| Panhans | 280 | 4,55 | 3 | 30 | 2/10/60 | 60 | FZ/TR | 15 | 8100 | 061614 ● |
| Homag Esp. | 300 | 4,55 | 3,2 | 75 | | 96 | FZ/TR | 15 | 7600 | 061615 ● |
| Homag | 350 | 4,55 | 3,2 | 75 | | 72 | FZ/TR | 15 | 6500 | 061613 ● |
| Höfer | 400 | 4,4 | 3,2 | 30 | 2/10/60 | 72 | FZ/TR | 15 | 4700 | 059256 ● |
| Panhans | | | | | | | | | | |
| Scheer | | | | | | | | | | |
| Schelling | | | | | | | | | | |
| Scheer | 450 | 4,8 | 3,5 | 30 | 2/10/60 | 72 | FZ/TR | 15 | 4200 | 061616 ● |



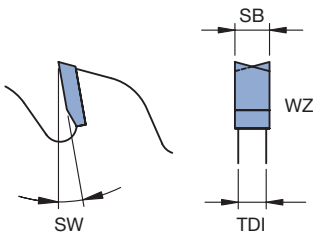
Sawblade - WZ/FA tooth shape

WK 251-2

| Machine | D | SB | TDI | BO | NLA | Z | ZF | SW | $n_{max.}$ | ID |
|-----------|-----|------|-----|----|---------|----|-------|--------|------------|-----------------|
| | mm | mm | mm | mm | mm | | | Degree | min^{-1} | |
| Panhans | 180 | 4,55 | 3,5 | 30 | | 36 | WZ/FA | 5 | 12700 | 059192 ● |
| Selco | 300 | 4,55 | 3,2 | 65 | 2/9/110 | 72 | WZ/FA | 10 | 7600 | 059189 ● |
| Schelling | 300 | 4,55 | 3,2 | 30 | | 72 | WZ/FA | 10 | 7600 | 061618 ● |

1. Sawing

1.5 Panel sizing 1.5.2 Scoring sawblades



Sawblade - WZ tooth shape

WK 850-2

| Machine | D mm | SB mm | TDI mm | BO mm | Z | ZF | SW Degree | n_{max} min^{-1} | ID |
|---------|---------|----------|-----------|----------|-----|----|--------------|-------------------------|-----------------|
| Homag | 250 | 4,55 | 3,2 | 45 | 80 | WZ | 10 | 9100 | 061617 ● |
| Holzma | 280 | 4,55 | 3,2 | 45 | 84 | WZ | 10 | 8100 | 061619 ● |
| Holzma | 280 | 4,95 | 3,5 | 45 | 84 | WZ | 10 | 8100 | 061676 ● |
| Holzma | 340 | 5,0 | 3,5 | 45 | 108 | WZ | 10 | 6700 | 061611 ● |