# CUTTERS AND CUTTER COMBINATIONS

Carbide or Stellite Tipped

B

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## MADE ACCORDING TO APPLICATION:

**STELLITE** (Stellite Tipped)
For softwood and hardwood without glue lines.

**T.C.T.** (Tungsten Carbide-Tipped)
For hardwood, plywood, chipboard, MDF, and other panel materials.

Our cutters are designed to conform with safety regulations and are dynamically balanced.

To determine min. diameter on profiled cutters, the calculation is:

**bore (B) + 60mm (2-3/8") + (2 x profile depth) (P)**

As per table below:

### METRIC SIZES

| BORE B MM | PROFILE DEPTH P MM | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| | 5 | 10 | 15 | 20 | 25 | 30 | 35 | 40 |
| **30** | 100 | 110 | 120 | 130 | 140 | 150 | 160 | 170 |
| **35** | 105 | 115 | 125 | 135 | 145 | 155 | 165 | 175 |
| **40** | 110 | 120 | 130 | 140 | 150 | 160 | 170 | 180 |
| **50** | 120 | 130 | 140 | 150 | 160 | 170 | 180 | 190 |
| **60** | 130 | 140 | 150 | 160 | 170 | 180 | 190 | 200 |

**B = Bore Diameter** **P = Profile Depth**

### INCH SIZES

| BORE B | PROFILE DEPTH P | | | | |
|---|---|---|---|---|---|
| | 3/8" | 3/4" | 1" | 1-1/4" | 1-1/2" |
| **3/4"** | 3-7/8" | 4-5/8" | 5-1/8" | 5-5/8" | 6-1/8" |
| **1-1/4"** | 4-3/8" | 5-1/8" | 5-5/8" | 6-1/8" | 6-5/8" |
| **1-13/16"** | 4-7/8" | 5-7/16" | 5-11/16" | 5-15/16" | 6-3/16" |
| **2"** | 5-1/8" | 6-1/8" | 6-5/8" | 7-1/8" | 7-5/8" |

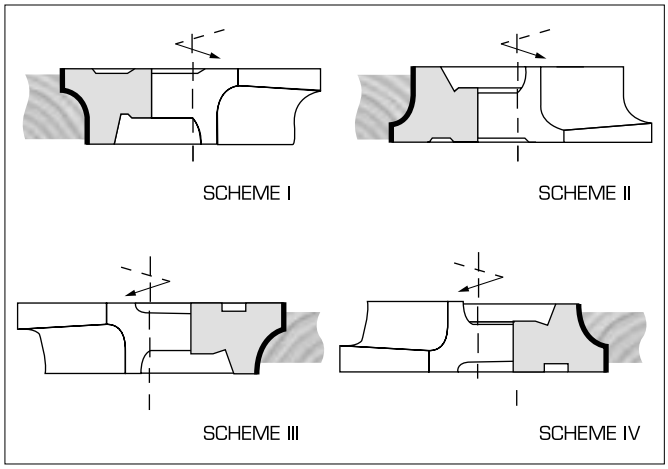
**B = Bore Diameter** **P = Profile Depth**

## WHEN ORDERING SPECIFY:

1. Type of cutter as numbered.
   For softwood and hardwood without glue lines.
2. Main dimensions in the following order:
   **(diameter) x (cutting width) x (bore) x (# of teeth)**
3. Cutting materials (STELLITE or T.C.T.).
4. RPM of machine and rate of feed.
   Material to be cut, if possible provide sample.
5. Type of cut: against feed direction or with feed direction.

## WHEN ORDERING CUTTERS WITH PROFILES:

Fully dimensioned sketches, CAD files, or samples of profiles must be supplied. Details of side to table, fence side, and direction of feed must also be given.



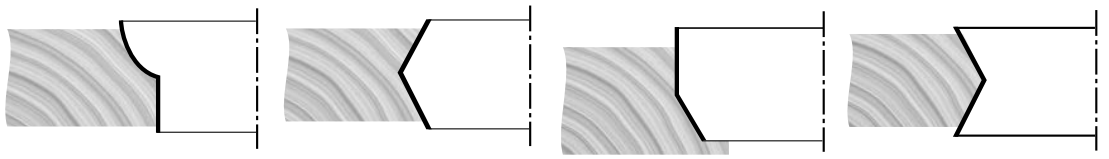

**Direction of Rotation**
Scheme I - II = Counter Clockwise (CCW)
Scheme III - IV = Counter Clockwise (CCW)

## PA PROFILE CUTTERS
SIMPLE PROFILES

Examples of Simple Profiles - PA

### DESIGN:
» With 2, 3, 4, or 6 cutting teeth, straight or with shear angle according to profile

### WHEN ORDERING SPECIFY:
» Type of wood or material to be cut
» Rotation
» Details of profile to table, fence side
» RPM of machine
» Rate of feed
» Exact sketch of profile
» Possibly a wood sample or a DXF file
» Bore diameter
» Diameter of cutter

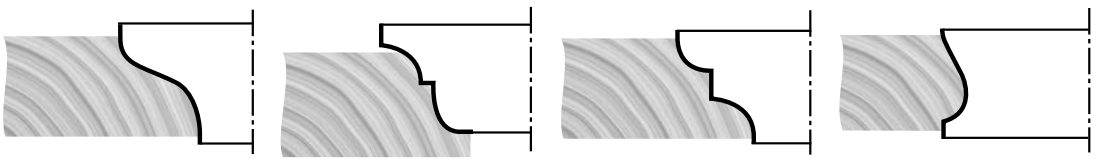


## PB PROFILE CUTTERS
COMPLEX PROFILES

Examples of Complex Profiles - PB

### DESIGN:
» With 2, 3, 4, or 6 cutting teeth, straight or with shear angle according to profile

### WHEN ORDERING SPECIFY:
» Type of wood or material to be cut
» Rotation
» Details of profile to table, fence side
» RPM of machine
» Rate of feed
» Exact sketch of profile
» Possibly a wood sample or a DXF file
» Bore diameter
» Diameter of cutter

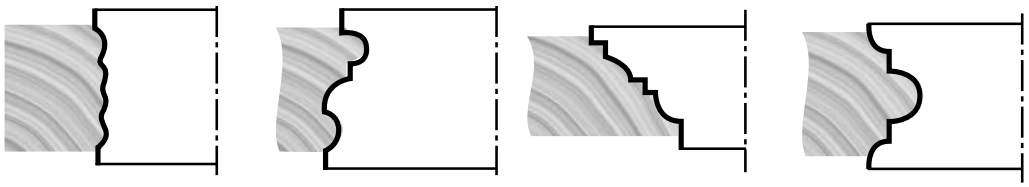


## PC PROFILE CUTTERS
VERY COMPLEX PROFILES

### DESIGN:
» With 2, 3, 4, or 6 cutting teeth, straight or with shear angle according to profile

### WHEN ORDERING SPECIFY:
» Type of wood or material to be cut
» Rotation
» Details of profile to table, fence side
» RPM of machine
» Rate of feed
» Exact sketch of profile
» Possibly a wood sample or a DXF file
» Bore diameter
» Diameter of cutter

**Examples of Very Combined Profiles - PC**

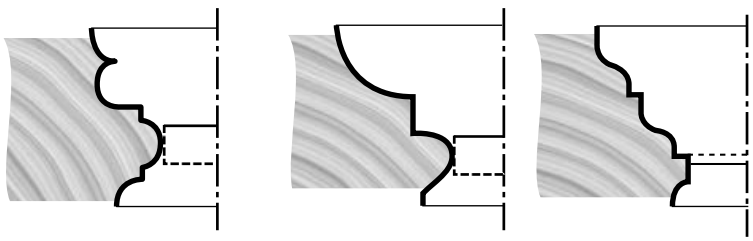


## PI PROFILE CUTTERS
COMBINED PROFILES

### DESIGN:
» With 2, 3, or 4 teeth interlocked for staggered cut and spur action with shearing cut

### WHEN ORDERING SPECIFY:
» Type of wood or material to be cut
» Rotation
» Details of profile to table, fence side
» RPM of machine
» Rate of feed
» Exact sketch of profile
» Possibly a wood sample or a DXF file
» Bore diameter
» Diameter of cutter

**Examples of Combined Profiles - PI**



## DESIGN:

» High tensile steel body
» 4 or 6 straight or bevelled teeth
» Tungsten carbide cutting edges

## APPLICATION:

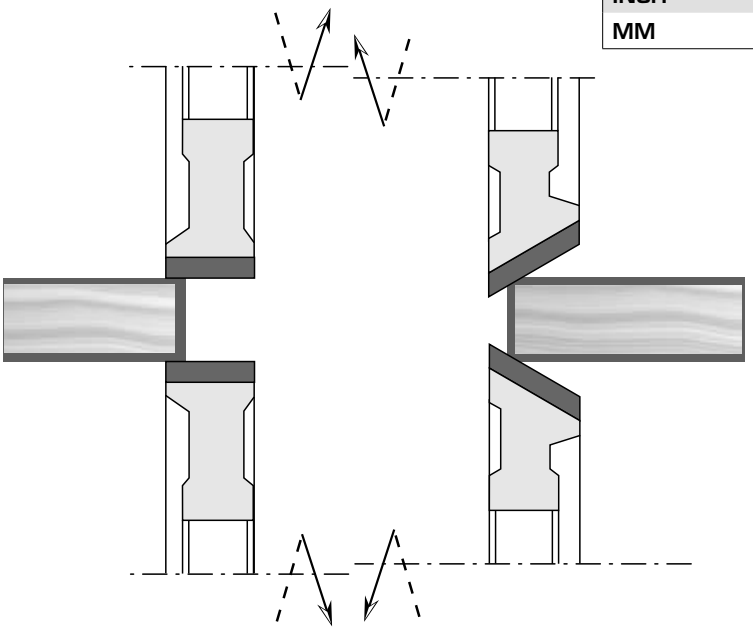
» On edgebanding cutters
» For flush trimming, chamfering, and profiling of wood veneer and plastic edge bands

## WHEN ORDERING SPECIFY:

» Machine
» If bevelled
» Cutting edge degrees required

## SPECIAL PRODUCTION

| UNIT OF MEASURE | DIAMETER | KERF | NO. TEETH |
|---|---|---|---|
| **INCH** | 2-3/4" to 4" | 5/8" to 1-3/8" | 4 or 6 |
| **MM** | 70 to 100 | 15 to 35 | 4 or 6 |



## DESIGN:

» High tensile steel body
» 8 or 12 rows of straight carbide teeth staggered on a spiral progression
» Tungsten carbide cutting edges

## APPLICATION:

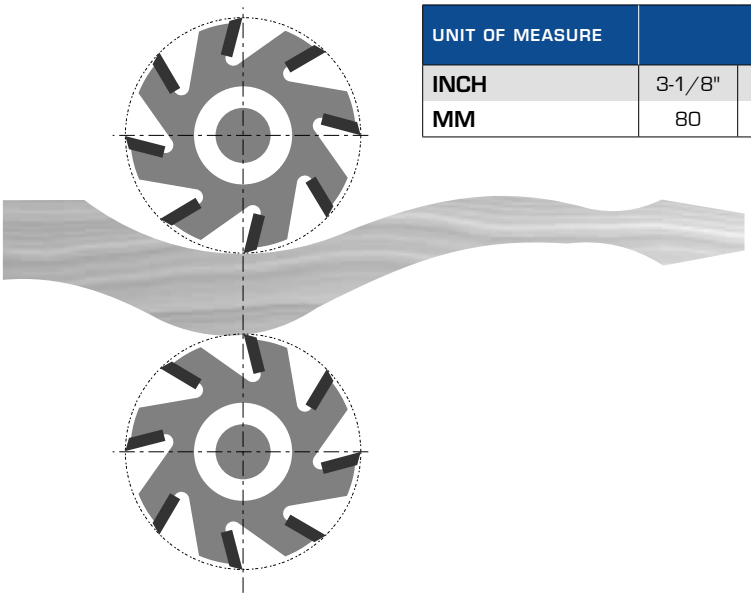
» Ideal for “easy chip flow” with fast feeding on solid wood and composite materials
» Mainly used for roughing-out furniture components
» On shapers and copying machines

## FOR MACHINES:

» Brandt, Egurco, Franke, Homag, Homburg, IDM, IMA, IMEF, Manea, Ocmac, Olympic, Raiman, Salgo, Stefani, and others

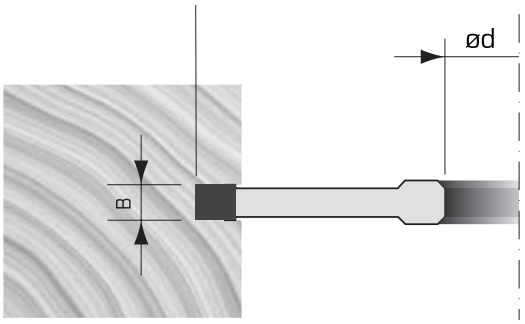
## WHEN ORDERING SPECIFY:

» Cutter diameter
» Bore diameter
» Number of teeth
» Type of wood to cut
» Usable length of spindle



## SPECIAL PRODUCTION

| UNIT OF MEASURE | DIAMETER | | | | KERF | NO. TEETH |
|---|---|---|---|---|---|---|
| **INCH** | 3-1/8" | 4" | 4-3/4" | 5-1/2" | 2-3/8" to 9" | 8 or 12 |
| **MM** | 80 | 100 | 120 | 140 | 60 to 230 | 8 or 12 |




## DESIGN:

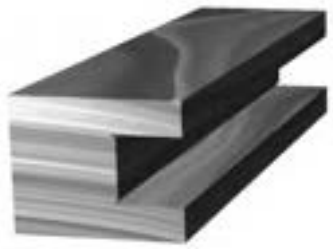
» High tensile steel body
» 6 straight teeth
» If required with alternating teeth or left-right + raker
» Tungsten carbide cutting edges

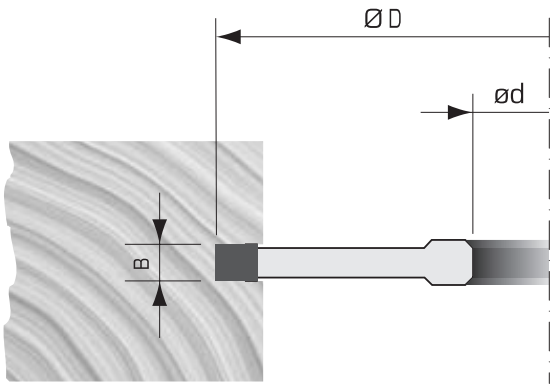
## APPLICATION:

» To make grooves in solid wood with the grain and in uncoated panels
» Can be used in laminated materials if cutting with feed

## MACHINES:

» On shapers, double-end tenoners, and moulders






## IMPERIAL

| DIAMETER ØD 4-3/4" | DIAMETER ØD 5-1/2" | DIAMETER ØD 6-1/4" | KERF B | NO. TEETH |
|---|---|---|---|---|
| PART NO. | PART NO. | PART NO. | | |
| 1121IC | 1127IC | 11213IC | 3/16" | 6 |
| 1122IC | 1128IC | 11214IC | 1/4" | 6 |
| 1123IC | 1129IC | 11215IC | 5/16" | 6 |
| 1124IC | 11210IC | 11216IC | 3/8" | 6 |
| 1125IC | 11211IC | 11217IC | 1/2" | 6 |
| 1126IC | 11212IC | 11218IC | 5/8" | 6 |

**ød Bore: 1-1/4"**
Bore can be opened or bushed to spindle size of your machine.
Maximum bore size: 50mm (2")

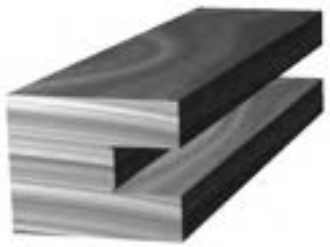
**Other sizes available upon request**

## METRIC

| DIAMETER ØD 120MM | DIAMETER ØD 140MM | DIAMETER ØD 160MM | KERF B MM | NO. TEETH |
|---|---|---|---|---|
| PART NO. | PART NO. | PART NO. | | |
| 1121MC | 1128MC | 11215MC | 5 | 6 |
| 1122MC | 1129MC | 11216MC | 6 | 6 |
| 1123MC | 11210MC | 11217MC | 8 | 6 |
| 1124MC | 11211MC | 11218MC | 10 | 6 |
| 1125MC | 11212MC | 11219MC | 12 | 6 |
| 1126MC | 11213MC | 11220MC | 14 | 6 |
| 1127MC | 11214MC | 11221MC | 16 | 6 |

**ød Bore: 30mm**
Bore can be opened or bushed to spindle size of your machine.
Maximum bore size: 50mm (2")

**Other sizes available upon request**



## DESIGN:

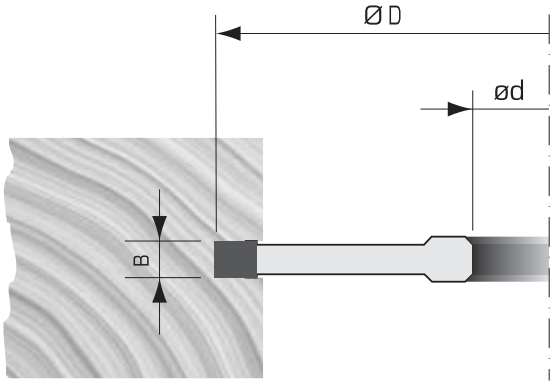
» High tensile steel body
» With 4 alternating spurs
» Tungsten carbide cutting edges

## APPLICATION:

» For grooving solid wood, plywood, and laminated panels

## MACHINES:

» On shapers, double-end tenoners, and moulders




## IMPERIAL

| DIAMETER ØD 4-3/4" | DIAMETER ØD 5-1/2" | DIAMETER ØD 6-1/4" | KERF B | NO. TEETH + SPURS |
|---|---|---|---|---|
| PART NO. | PART NO. | PART NO. | | |
| 1131IC | 1137IC | 11313IC | 3/16" | 4+4 |
| 1132IC | 1138IC | 11314IC | 1/4" | 4+4 |
| 1133IC | 1139IC | 11315IC | 5/16" | 4+4 |
| 1134IC | 11310IC | 11316IC | 3/8" | 4+4 |
| 1135IC | 11311IC | 11317IC | 1/2" | 4+4 |
| 1136IC | 11312IC | 11318IC | 5/8" | 4+4 |

**ød Bore: 1-1/4"**
Bore can be opened or bushed to spindle size of your machine.
Maximum bore size: 50mm (2")

**Other sizes available upon request**

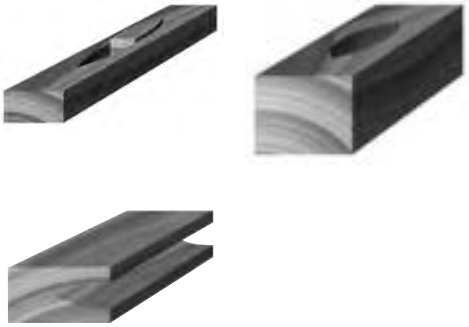
## METRIC

| DIAMETER ØD 120 MM | DIAMETER ØD 140 MM | DIAMETER ØD 160 MM | KERF B MM | NO. TEETH + SPURS |
|---|---|---|---|---|
| PART NO. | PART NO. | PART NO. | | |
| 1131MC | 1138MC | 11315MC | 5 | 4+4 |
| 1132MC | 1139MC | 11316MC | 6 | 4+4 |
| 1133MC | 11310MC | 11317MC | 8 | 4+4 |
| 1134MC | 11311MC | 11318MC | 10 | 4+4 |
| 1135MC | 11312MC | 11319MC | 12 | 4+4 |
| 1136MC | 11313MC | 11320MC | 14 | 4+4 |
| 1137MC | 11314MC | 11321MC | 16 | 4+4 |

**ød Bore: 30mm**
Bore can be opened or bushed to spindle size of your machine.
Maximum bore size: 50mm (2")

**Other sizes available upon request**

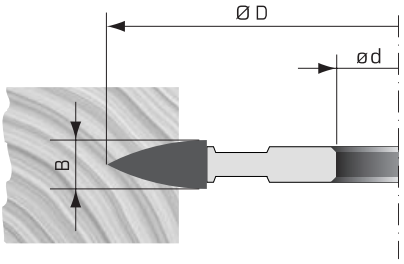
# 113B LAMELLO GROOVING CUTTERS



## DESIGN:
» High tensile steel body
» With 4 alternating shear angle teeth
» Tungsten carbide cutting edges

## APPLICATION:
» For cutting out defects in solid woods
» For patch sizes 1-4

## MACHINES:
» For use on mini-spot machines



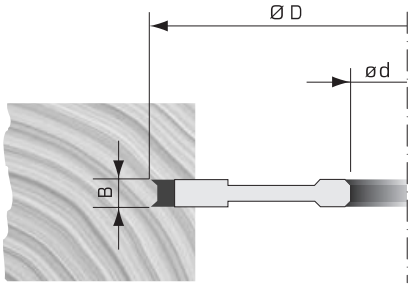

| PART NO. | DIAM. ØD MM | KERF B MM | BORE ød MM | NO. TEETH | RPM MIN-MAX |
|---|---|---|---|---|---|
| **113B** | 100 | 8 | 22 | 4 | 7600-13400 |

# 113L LAMELLO GROOVING CUTTERS

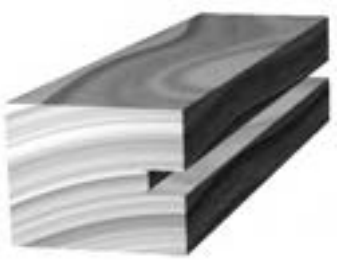
## DESIGN:
» High tensile steel body
» With 2 teeth and 4 spurs
» Tungsten carbide cutting edges

## APPLICATION:
» For chip free grooving of LAMELLO wood joints
» For solid woods with and against the grain

## MACHINES:
» On LAMELLO and ELU machines for biscuit joints




| PART NO. | DIAM. Ø MM | KERF B MM | BORE ød MM | NO. TEETH | NO. SPURS | RPM MIN-MAX |
|---|---|---|---|---|---|---|
| **113L** | 100 | 3.95 | 22 | 2 | 2+2 | 7600-13400 |



## DESIGN:

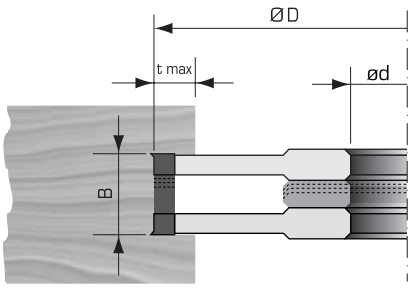
» High tensile steel body
» Set of cutters with 4 teeth + 4 spurs, each adjustable by a set of spacers
» Tungsten carbide cutting edges

## APPLICATION:

» For chip-free grooving of plywood, chipboard, and solid wood with and across the grain
» In uncoated and laminated panel materials with feed

## MACHINES:

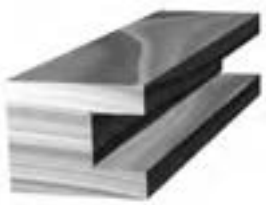
» On shapers, moulders, and double-end tenoners




| PART NO. | DIAM. ØD | KERF MIN. B | KERF MAX. B | BORE ød | NO. TEETH | NO. SPURS | GROOVE DEPTH T MAX | RPM MIN-MAX |
|---|---|---|---|---|---|---|---|---|
| **1141MC** | 140mm 5-1/2" | 1.8mm 5/64" | 3.4mm 9/64" | 31.75mm 1-1/4" | 4 | 4 | 15mm 19/32" | 5500-9500 |
| **1142MC** | 140mm 5-1/2" | 2.5mm 3/32" | 4.8mm 3/16" | 31.75mm 1-1/4" | 4 | 4 | 15mm 19/32" | 5500-9500 |
| **1143MC** | 160mm 6-1/4" | 4.0mm 5/32" | 7.5mm 19/64" | 31.75mm 1-1/4" | 4 | 4 | 35mm 1-3/8" | 5100-9000 |
| **1144MC** | 160mm 6-1/4" | 7.5mm 19/64" | 14mm 9/16" | 31.75mm 1-1/4" | 4 | 4 | 35mm 1-3/8" | 5100-9000 |
| **1145MC** | 160mm 6-1/4" | 10mm 13/32" | 19mm 3/4" | 31.75mm 1-1/4" | 4 | 4 | 40mm 1-9/16" | 4800-8300 |
| **1146MC** | 180mm 7-3/32" | 4.0mm 5/32" | 7.5mm 19/64" | 31.75mm 1-1/4" | 4 | 4 | 50mm 2" | 4200-7400 |
| **1147MC** | 180mm 7-3/32" | 7.5mm 19/64" | 14mm 9/16" | 31.75mm 1-1/4" | 4 | 4 | 50mm 2" | 4200-7400 |
| **1148MC** | 180mm 7-3/32" | 10mm 13/32" | 19mm 3/4" | 31.75mm 1-1/4" | 4 | 4 | 50mm 2" | 4200-7400 |

Bore can be opened or bushed to spindle size of your machine

Maximum bore size 50mm (2")



## DESIGN:

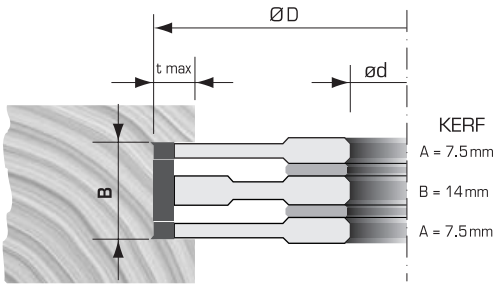
» High tensile steel body
» Set of 3 or 4 interlocked cutters adjustable by spacers and shims
» Outside cutters each with 2 raker teeth and 2 spurs on outside at negative rake
» Middle cutters with 4 raker teeth
» Chip limiter for manual feed
» Cuts grooves sharp and clean, no tear-outs
» Tungsten carbide cutting edges

## APPLICATION:

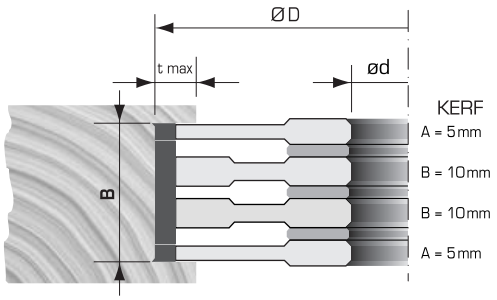
» For chip-free grooving of plywood, chipboard, and solid wood with and against the grain
» In uncoated and laminated panel materials with feed

## MACHINES:

» On shapers, moulders, and double-end tenoners




1151MC




1152MC

| PART NO. | DIAM. ØD | KERF MIN. B | KERF MAX. B | BORE ød MM | NO. TEETH | NO. SPURS | GROOVE DEPTH T MAX | RPM MIN-MAX |
|---|---|---|---|---|---|---|---|---|
| **1151MC** | 150mm 6" | 7.5mm 19/64" | 28mm 1-7/64" | 31.75mm 1-1/4" | 4 | 4+4 | 30mm 1-3/16" | 5100-8900 |
| **1152MC** | 220mm 8-5/8" | 5mm 3/16" | 30mm 1-3/16" | 31.75mm 1-1/4" | 4 | 4+4 | 40mm 1-9/16" | 3500-6000 |

Bore can be opened or bushed to spindle size of your machine

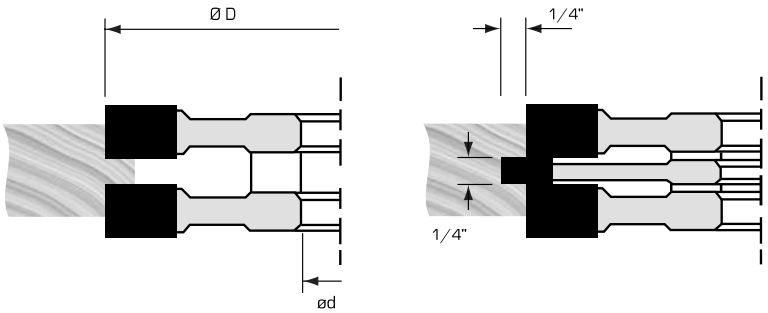
Maximum bore size 50mm (2")

# 139 TONGUE AND GROOVE SHAPER CUTTERS

## DESIGN:
» High tensile steel body
» Set of 3 cutters (1 groover + 2 cutters)
» Each with 3 teeth and spacers to obtain profiles
» Tungsten carbide cutting edges

## APPLICATION:
» For producing tongue and groove shapes on plywood and solid wood

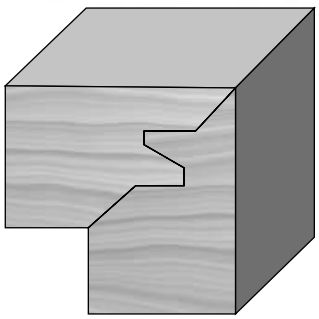
## MACHINES:
» On shapers




| PART NO. | DIAM. ØD | WOOD THICKNESS MIN. | WOOD THICKNESS MAX. | BORE ød | NO. TEETH |
|---|---|---|---|---|---|
| 139IC | 4" | 3/4" | 1-1/8" | 1-1/4" | 3+3+3 |

Bore can be opened or bushed to spindle size of your machine

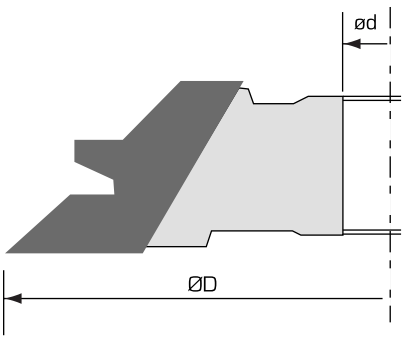
# 135 REVERSIBLE MITRE JOINT CUTTER



## DESIGN:
» High tensile steel body
» With 3 straight teeth
» Tungsten carbide cutting edges

## APPLICATION:
» For cutting mitre lock joints in solid wood and panel materials

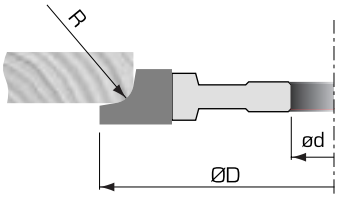
## MACHINES:
» On shapers




| PART NO. | DIAM. ØD | WOOD THICKNESS MIN. | WOOD THICKNESS MAX. | BORE ød | NO. TEETH |
|---|---|---|---|---|---|
| 135IC | 4-3/4" | 3/8" | 3/4" | 1-1/4" | 3 |

Bore can be opened or bushed to spindle size of your machine

# 149 QUARTER ROUND CUTTERS




## DESIGN:
» High tensile steel body
» With 3 teeth sheer cut for optimum quality of cut
» Tungsten carbide cutting edges

## APPLICATION:
» To cut quarter round shapes in solid wood and panel materials

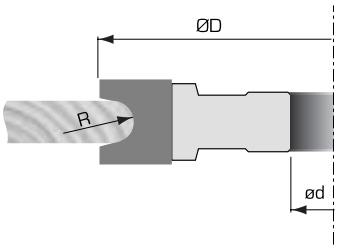
## MACHINES:
» On shapers

## SPECIAL PRODUCTION:
» For all other sizes see Cutters Special Profiles “PA” on page B2

| PART NO. | DIAM. ØD | RADIUS R | BORE ød | NO. TEETH |
|---|---|---|---|---|
| **1491IC** | 4" | 1/4" | 1-1/4" | 3 |
| **1492IC** | 4" | 3/8" | 1-1/4" | 3 |
| **1493IC** | 4" | 1/2" | 1-1/4" | 3 |
| **1494IC** | 4-3/4" | 3/4" | 1-1/4" | 3 |

Bore can be opened or bushed to spindle size of your machine

# 150 HALF ROUND CUTTERS




## DESIGN:
» High tensile steel body
» With 3 straight teeth
» Tungsten carbide cutting edges

## APPLICATION:
» To cut half round shapes in solid wood and panel materials

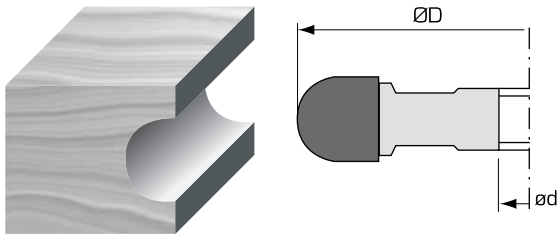
## MACHINES:
» On shapers

## SPECIAL PRODUCTION:
» For all other sizes see Cutters Special Profiles “PB” on page B2

| PART NO. | DIAM. ØD | RADIUS R | PROFILE HEIGHT | BORE ød | NO. TEETH |
|---|---|---|---|---|---|
| **1501IC** | 4" | 1/8" | 1/4" | 1-1/4" | 3 |
| **1502IC** | 4" | 1/4" | 1/2" | 1-1/4" | 3 |
| **1503IC** | 4-1/2" | 3/8" | 3/4" | 1-1/4" | 3 |
| **1504IC** | 4-1/2" | 1/2" | 1" | 1-1/4" | 3 |

Bore can be opened or bushed to spindle size of your machine

# 151 CONVEX RADIUS CUTTERS




## DESIGN:
» High tensile steel body
» With 4 straight teeth
» Tungsten carbide cutting edges

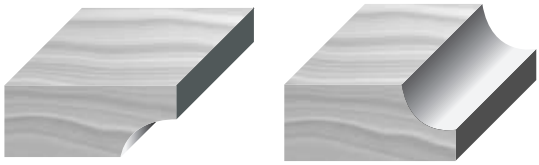
## APPLICATION:
» For cutting coves in solid wood and panel materials

## MACHINES:
» On shapers

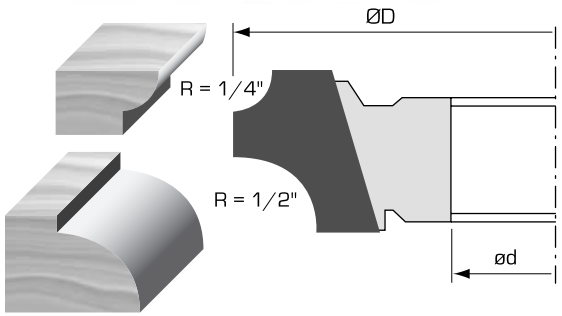
## SPECIAL PRODUCTION:
» For all other sizes see Cutters Special Profiles “PA” on page B2

| PART NO. | DIAM. ØD | RADIUS R | KERF B | BORE ød | NO. TEETH |
|---|---|---|---|---|---|
| **1516IC** | 4" | 3/8" | 3/4" | 1-1/4" | 4 |
| **1518IC** | 4" | 1/2" | 1" | 1-1/4" | 4 |

Bore can be opened or bushed to spindle size of your machine



# 154 DUAL QUARTER ROUND CUTTERS
## 1/4" AND 1/2" RADIUS




## DESIGN:
» High tensile steel body
» With 3 teeth, straight
» Tungsten carbide cutting edges

## APPLICATION:
» To make 1/4" or 1/2" quarter round shapes in solid wood and panel materials

## MACHINES:
» On shapers

## SPECIAL PRODUCTION:
» For all other sizes see Cutters Special Profiles “PB” on page B2

| PART NO. | DIAM. ØD | RADIUS R1 | RADIUS R2 | KERF B | BORE ød | NO. TEETH |
|---|---|---|---|---|---|---|
| **154IC** | 4" | 1/4" | 1/2" | 1" | 1-1/4" | 3 |

Bore can be opened or bushed to spindle size of your machine

## DESIGN:

» High tensile steel body
» Set of 4 cutters and spacers
» With 3 teeth
» Tungsten carbide cutting edges

## APPLICATION:

» To cut stile and rail for producing solid wood cabinet doors

## MACHINES:

» On shapers

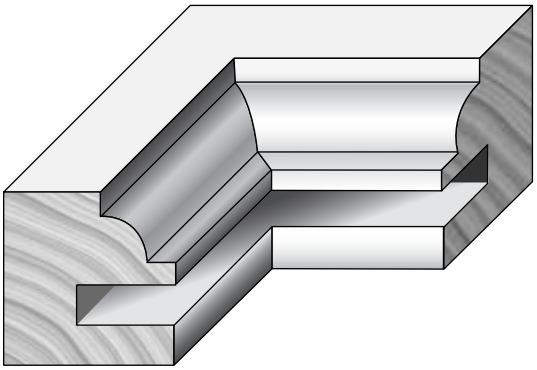
## SPECIAL PRODUCTION:

» For all other sizes see Cutters Special Profiles “PA” on page B2

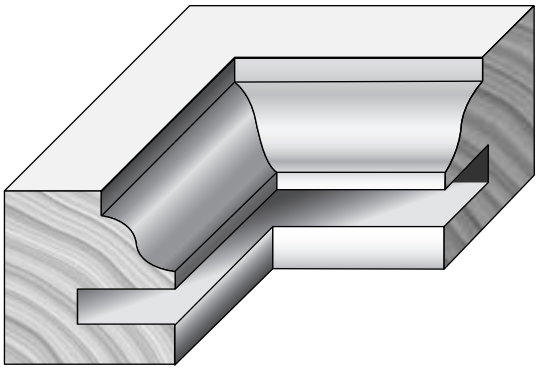
| PART NO. | PROFILE | DIAM. ØD | WOOD THICKNESS | BORE ød | NO. TEETH |
|---|---|---|---|---|---|
| **177AI** | A | 4" | 3/4" to 1" | 1-1/4" | 3+3 |
| **177BI** | B | 4" | 3/4" to 1" | 1-1/4" | 3+3 |

Bore can be opened or bushed to spindle size of your machine

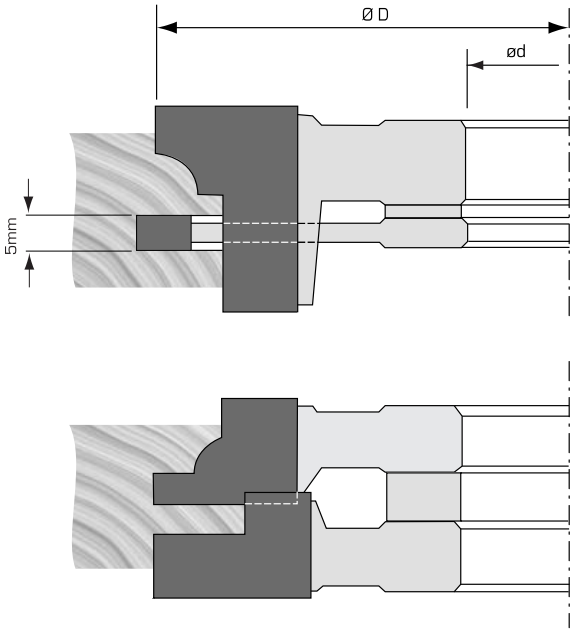
## PROFILE A



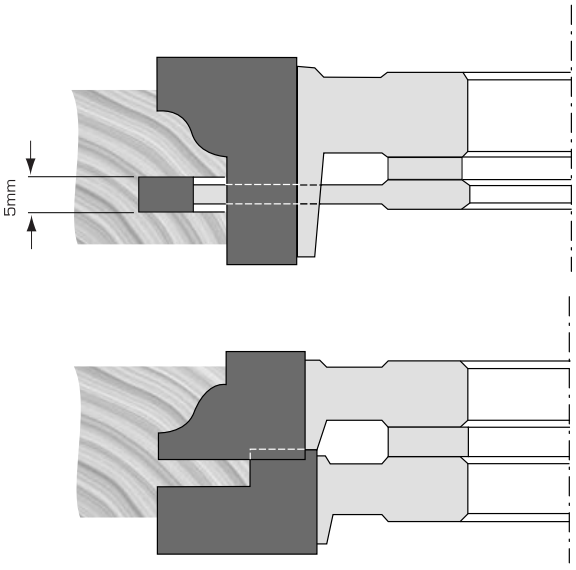
## PROFILE B



## BEAD PROFILE




## OGEE PROFILE



## DESIGN:

» High tensile steel body
» With 3 teeth and shear angle for optimum quality of cut
» Tungsten carbide cutting edges

## APPLICATION:

» For raised panel cutting in solid wood and MDF panels

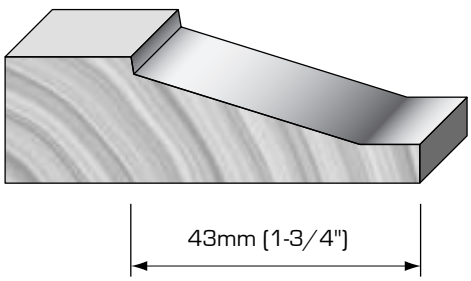
## MACHINES:

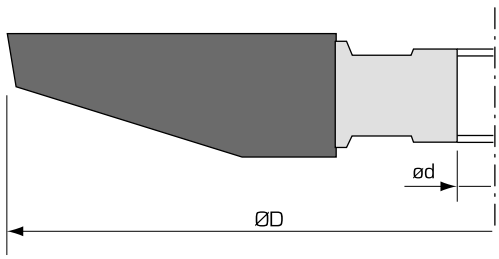
» On shapers

| PART NO. | PROFILE | DIAM. ØD | KERF B | BORE ød | NO. TEETH |
|---|---|---|---|---|---|
| **1681IC** | Profile No. 1 | 6" | 5/8" | 1-1/4" | 3 |
| **1682IC** | Profile No. 2 | 6" | 5/8" | 1-1/4" | 3 |
| **1693IC** | Profile No. 3 | 5-3/4" | 5/8" | 1-1/4" | 3 |
| **1694IC** | Profile No. 4 | 5-3/4" | 5/8" | 1-1/4" | 3 |
| **1695IC** | Profile No. 5 | 5-3/4" | 5/8" | 1-1/4" | 3 |
| **1696IC** | Profile No. 6 | 5-3/4" | 5/8" | 1-1/4" | 3 |

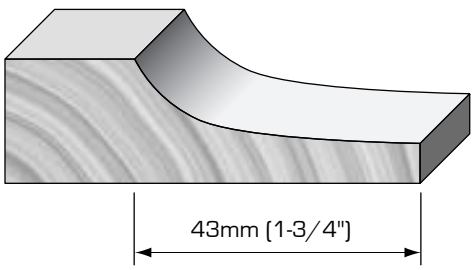
Bore can be opened or bushed to spindle size of your machine

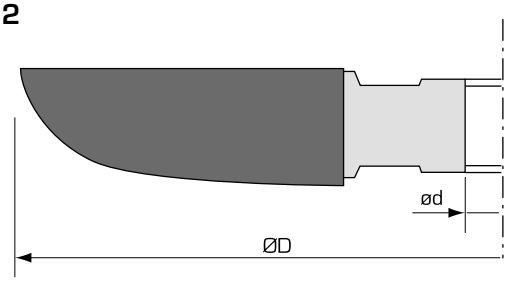
## PROFILE NO. 1



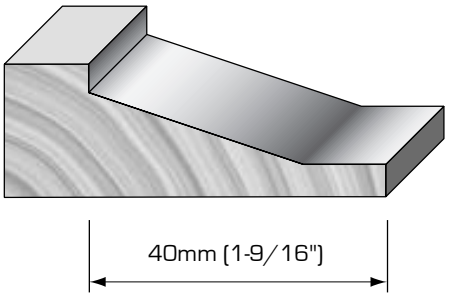

## PROFILE NO. 2

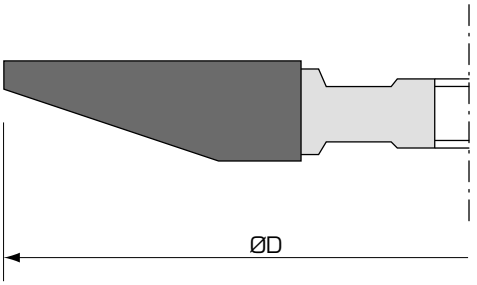


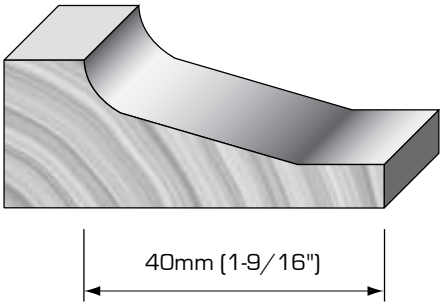

**SCALE 1:1**

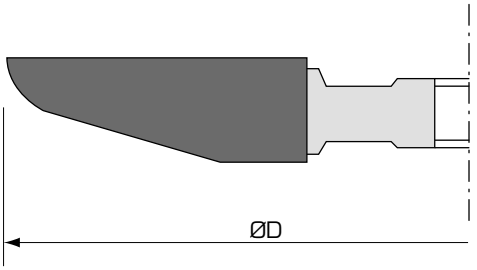
## PROFILE NO. 3



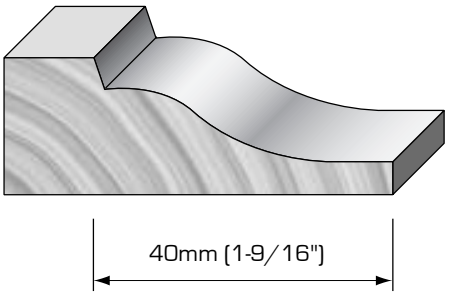



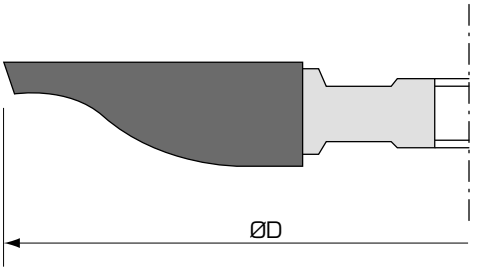

## PROFILE NO. 4



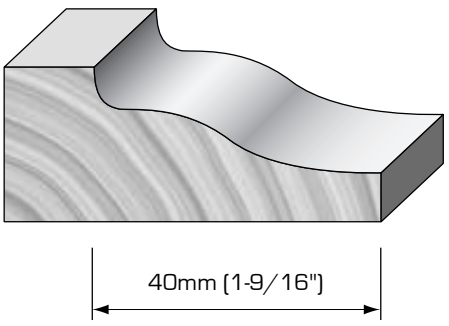



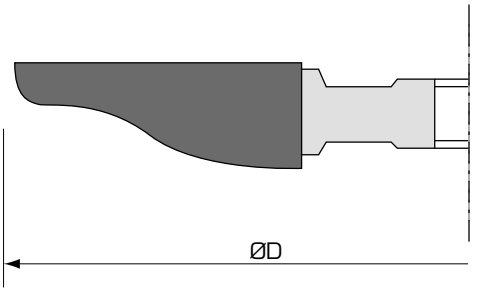

## PROFILE NO. 5




## PROFILE NO. 6




SCALE 1:1

## DESIGN:

» High tensile steel body
» Set of 5 cutters with 3 teeth interlocked and set of spacers
» Tungsten carbide cutting edges

## APPLICATION:

» To cut stile and rail in solid wood for producing entry and passage doors

## MACHINES:

» On shapers

## TYPE: 178

| PART NO. | PROFILE | DIAM. ØD | WOOD THICKNESS | TENON | BORE ød | NO. TEETH | RPM MIN-MAX |
|---|---|---|---|---|---|---|---|
| **178AI** | A | 4" | 1-3/8" | 1/4" | 1-1/4" | 3 | 7500-12500 |
| **178BI** | B | 4" | 1-3/8" | 1/4" | 1-1/4" | 3 | 7500-12500 |
| **178CI** | C | 4" | 1-3/8" | 1/4" | 1-1/4" | 3 | 7500-12500 |

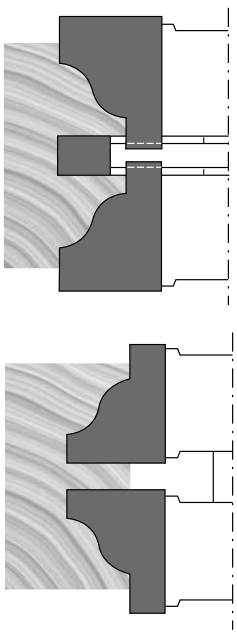
Bore can be opened or bushed to spindle size of your machine

## TYPE: 179

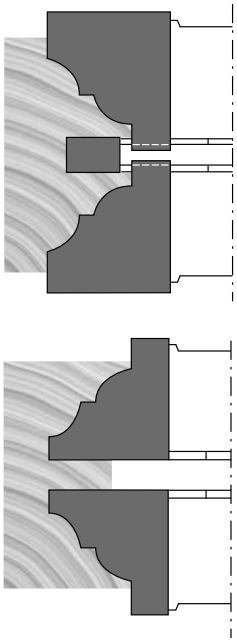
| PART NO. | PROFILE | DIAM. ØD | WOOD THICKNESS | TENON | BORE ød | NO. TEETH | RPM MIN-MAX |
|---|---|---|---|---|---|---|---|
| **179AI** | A | 4" | 1-3/4" | 3/8" | 1-1/4" | 3 | 7500-12500 |
| **179BI** | B | 4" | 1-3/4" | 3/8" | 1-1/4" | 3 | 7500-12500 |
| **179CI** | C | 4" | 1-3/4" | 3/8" | 1-1/4" | 3 | 7500-12500 |

Bore can be opened or bushed to spindle size of your machine

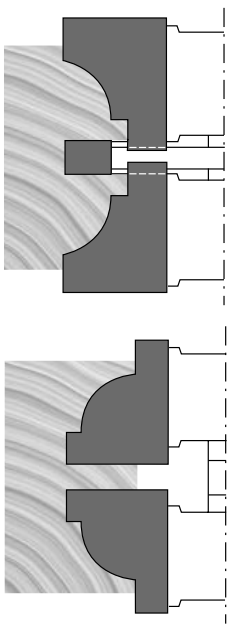
**PROFILE A**



**PROFILE B**



**PROFILE C**



## DESIGN:

» High tensile steel body
» Each set consists of 4 cutters with 3 teeth and 3 spacers engraved with No. 1, No. 2, and No. 3
» Tungsten carbide cutting edges
» 4 different interlocking joints

## APPLICATION:

» To cut all standard moulding profiles and anything else you can think of

## MACHINES:

» On shapers

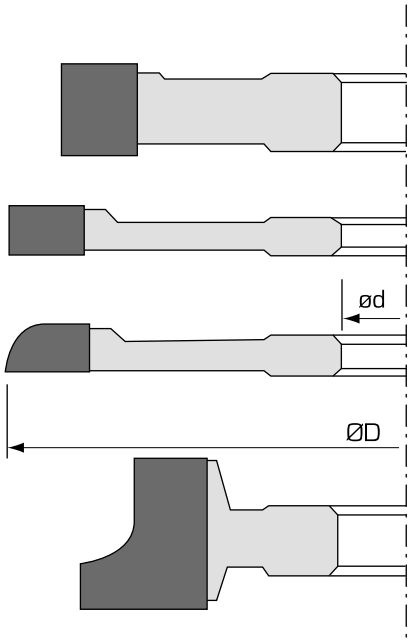
| PART NO. | TYPE | DIAM. ØD | BORE ØD | NO. TEETH |
|---|---|---|---|---|
| 1821IC | Small Set | 4-1/8" | 3/4" | 3 |
| 1822IC | Large Set | 5-1/2" | 1-1/4" | 3 |

TOOL. NO. 1

TOOL. NO. 2

TOOL. NO. 3

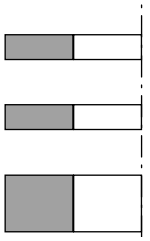
TOOL. NO. 4

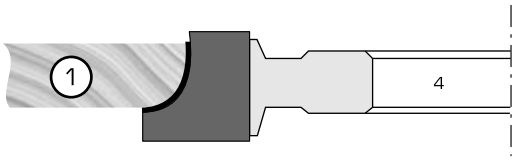



SPACER NO. 5

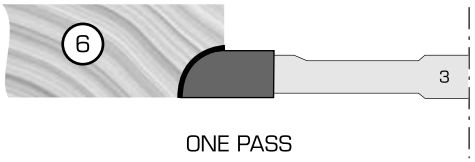
SPACER NO. 6

SPACER NO. 7






ONE PASS

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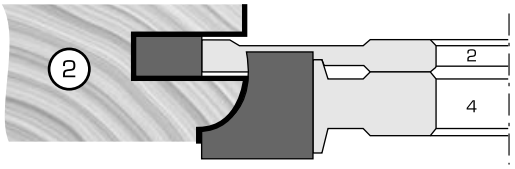


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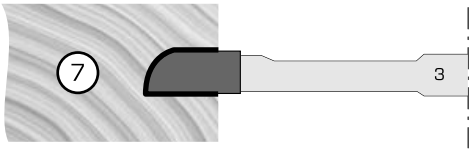


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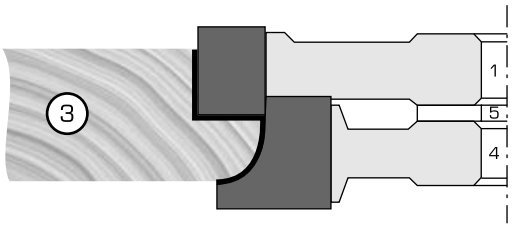


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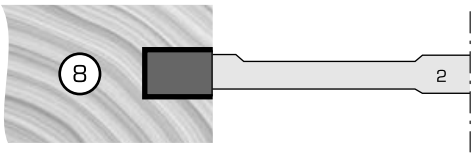
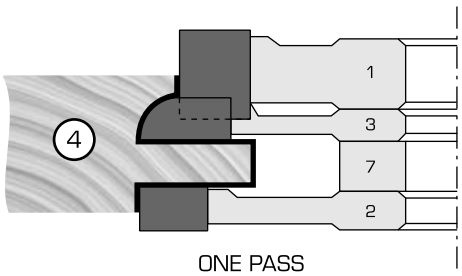



ONE PASS

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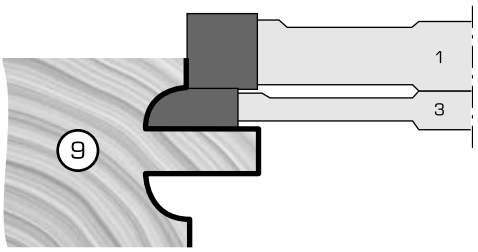
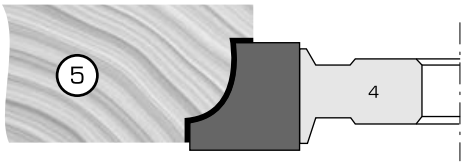
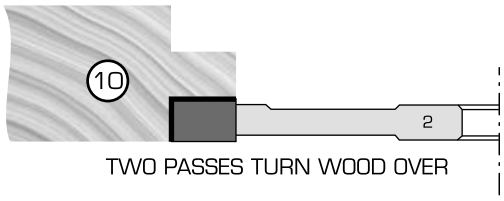



TWO PASSES TURN WOOD OVER




ONE PASS



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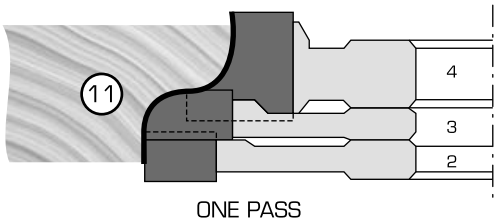

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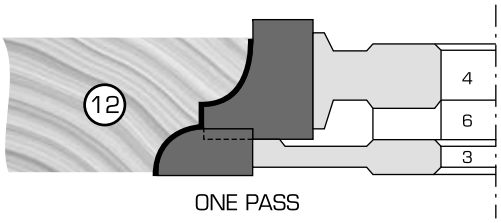

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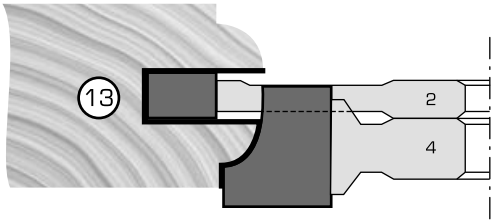

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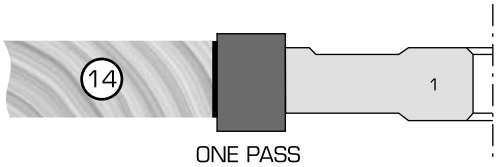

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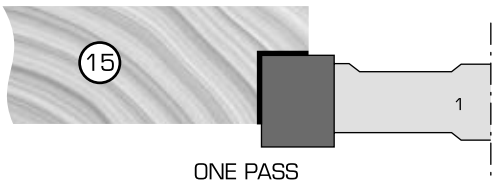

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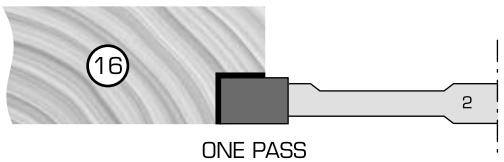

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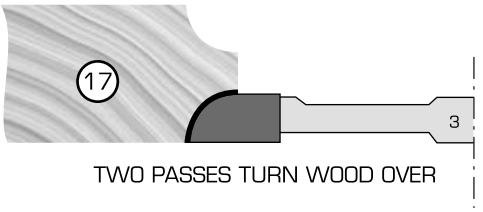

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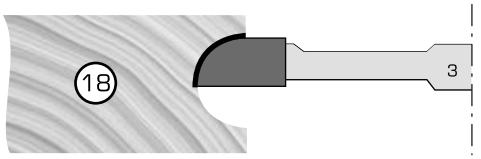

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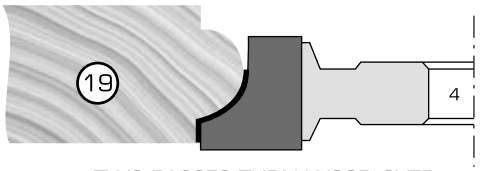

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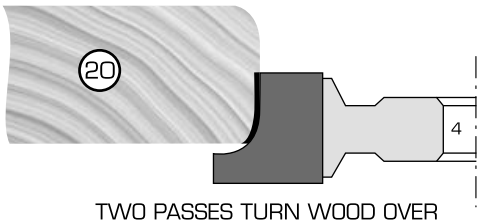

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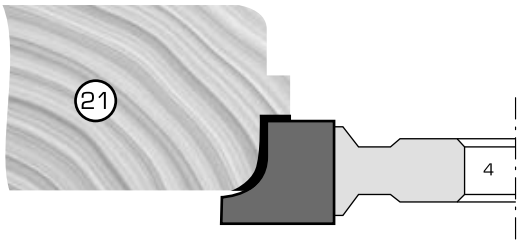

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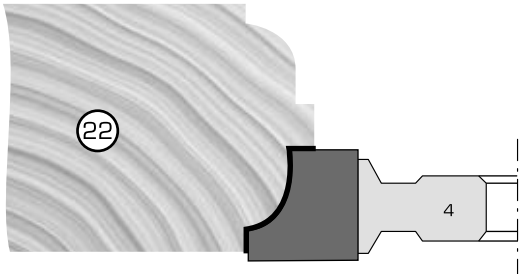

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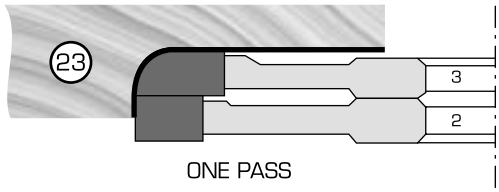


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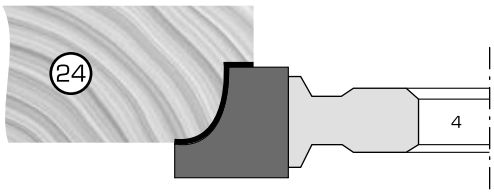


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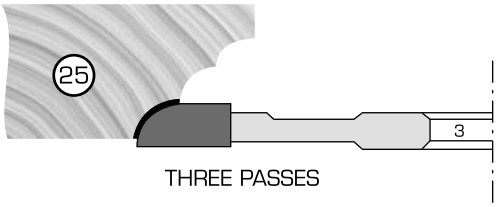


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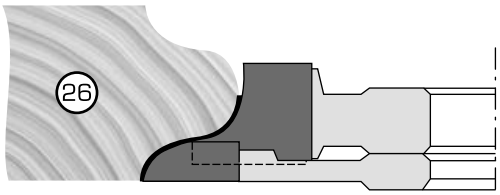


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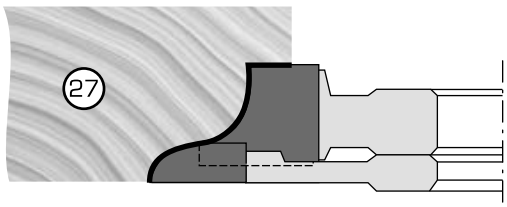


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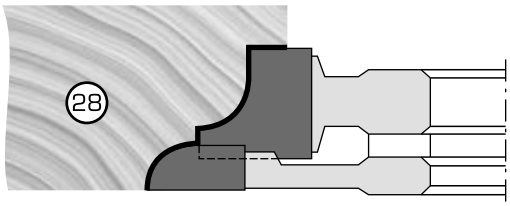


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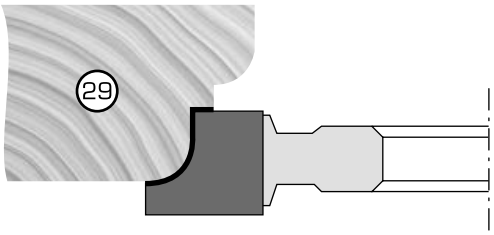


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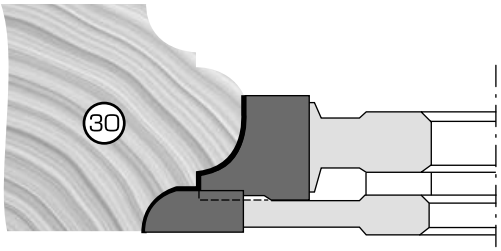


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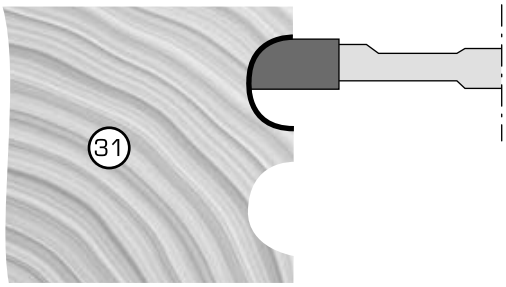


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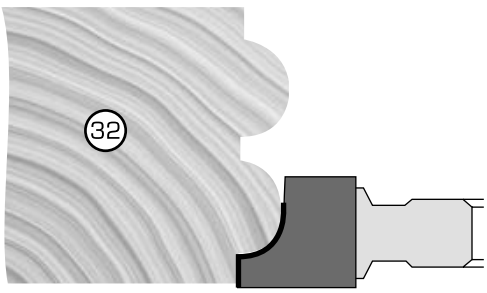


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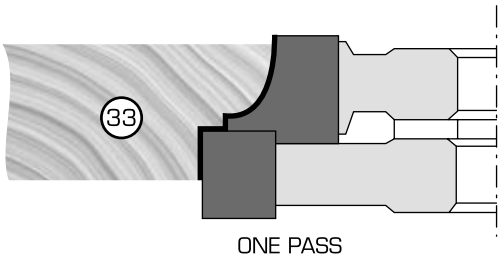


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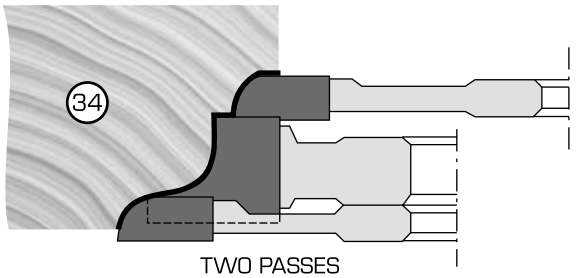


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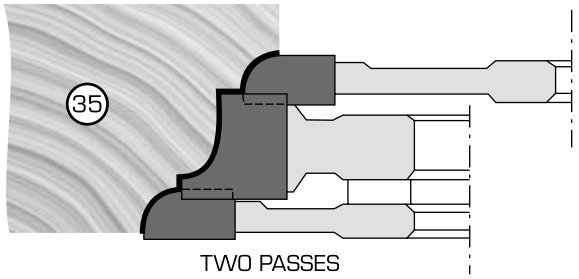


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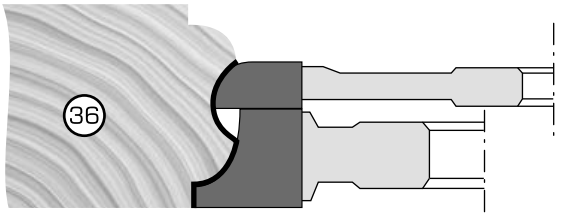


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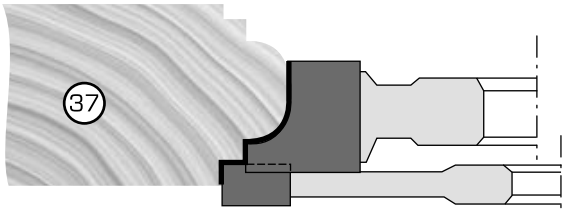


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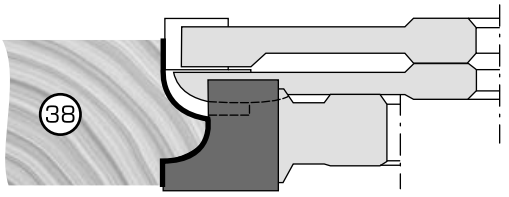


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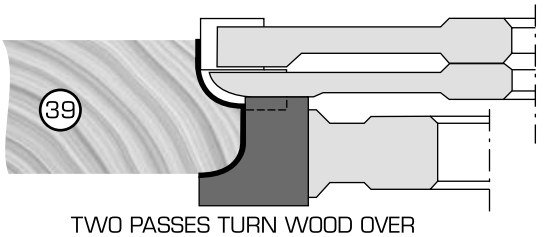


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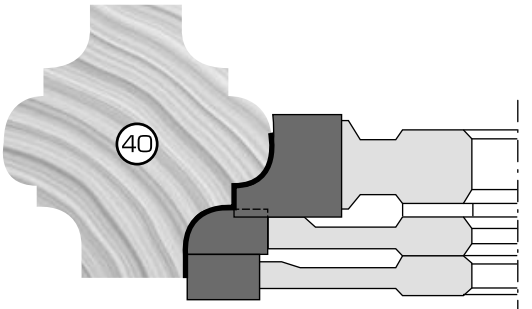


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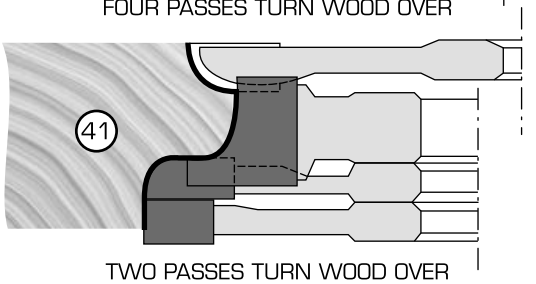


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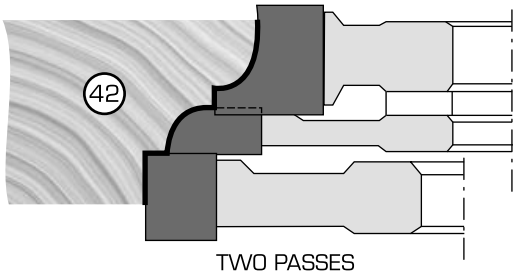


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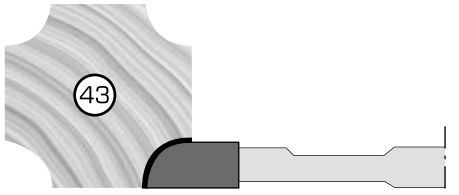


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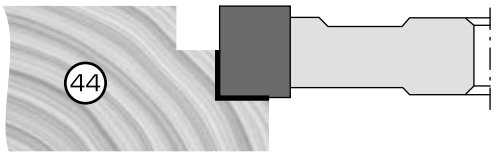


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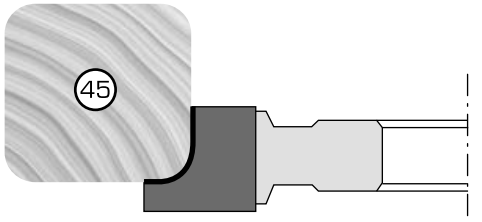


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