

Laminated Panels



Reference table of saw blades for panel sizing machines

Machine type	Tool type *	D	B-B1	b	d	Z	Tooth type	α	β	NL	Freud Code	Art. No.
		mm	mm	mm	mm							
BIESSE-SELCO												
EB 70 (L)	Main blade	300	4,4	3,0	65	60	TCG	15°	15°	2/9/110	LSB30002X	F03FS09159
	HW Scorer	200	4,3-5,5	3,2	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M43PI3	F03FS02681
	HW Scorer	300	4,3-5,5	3,0	65	48	ATB	12°	15°	2/9/100 + 2/9/110	LI25M43RX3	F03FS07616
	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH4	F03FS09625
	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH6	F03FS09626
	Postf. scorer	300	4,55	3,2	65	72	ATB	15°	15°	2/9/100 + 2/9/110	LI27M DA3	F03FS02737
EB 70 (KIT 80), 75 (SEKTOR 430), 80 (SEKTOR 450), SK350, SK450	Main blade	320	4,4	3,2	65	60	TCG	15°	15°	2/9/110	LSB32003X	F03FS09161
	Main blade	320	4,4	3,2	65	72	TCG	15°	15°	2/9/95 + 2/9/110	LSB32001X	F03FS07805
	HW Scorer	200	4,3-5,5	3,2	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M43PI3	F03FS02681
	HW Scorer	300	4,3-5,5	3,0	65	48	ATB	12°	15°	2/9/100 + 2/9/110	LI25M43RX3	F03FS07616
	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH4	F03FS09625
	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH6	F03FS09626
WN2, WN230, SK230	Postf. scorer	300	4,55	3,2	65	72	ATB	15°	15°	2/9/100 + 2/9/110	LI27M DA3	F03FS02737
	Main blade	320	4,4	3,2	65	72	TCG	15°	15°	2/9/95 + 2/9/110	LSB32001X	F03FS07805
	HW Scorer	200	4,3-5,5	3,2	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M43PI3	F03FS02681
	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH4	F03FS09625
WN 250	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH6	F03FS09626
	Main blade	350	4,4	3,2	65	72	TCG	15°	15°	2/9/110	LSB35013X	F03FS09659
	HW Scorer	200	4,3-5,5	3,2	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M43PI3	F03FS02681
	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH4	F03FS09625
EB 95, SEKTOR 470, K470, SK370	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH6	F03FS09626
	Main blade	355	4,4	3,2	65	72	TCG	15°	15°	2/9/95 + 2/9/110	LSB35508X	F03FS08740
	HW Scorer	200	4,3-5,5	3,2	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M43PI3	F03FS02681
	HW Scorer	300	4,3-5,5	3,0	65	48	ATB	12°	15°	2/9/100 + 2/9/110	LI25M43RX3	F03FS07616
	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH4	F03FS09625
	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH6	F03FS09626
EB100	Postf. scorer	300	4,55	3,2	65	72	ATB	15°	15°	2/9/100 + 2/9/110	LI27M DA3	F03FS02737
	Main blade	360	4,4	3,2	65	72	TCG	15°	15°	2/9/95 + 2/9/110	LSB36002X	F03FS07673
	HW Scorer	200	4,3-5,5	3,2	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M43PI3	F03FS02681
	HW Scorer	300	4,3-5,5	3,0	65	48	ATB	12°	15°	2/9/100 + 2/9/110	LI25M43RX3	F03FS07616
	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH4	F03FS09625
	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH6	F03FS09626
WN-WNA 610, WN-WNA 610 (PFS)	Postf. scorer	300	4,55	3,2	65	72	ATB	15°	15°	2/9/100 + 2/9/110	LI27M DA3	F03FS02737
	Main blade	380	4,4	3,2	65	72	TCG	15°	15°	2/9/110	LSB38014X	F03FS09166
	HW Scorer	200	4,3-5,5	3,2	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M43PI3	F03FS02681
	HW Scorer	300	4,3-5,5	3,0	65	48	ATB	12°	15°	2/9/100 + 2/9/110	LI25M43RX3	F03FS07616
	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH4	F03FS09625
EB108, EB110, EB120	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH6	F03FS09626
	Main blade	400	4,4	3,2	80	72	TCG	15°	15°	2/15/105 + 2/9/130 + 4/19/120	LSB40009X	F03FS07810
	HW Scorer	200	4,3-5,5	3,2	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M43PI3	F03FS02681
	HW Scorer	300	4,3-5,5	3,0	65	48	ATB	12°	15°	2/9/100 + 2/9/110	LI25M43RX3	F03FS07616
	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH4	F03FS09625
	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH6	F03FS09626
WN-WNA 630, WN-WNA 630 (PFS)	Postf. scorer	300	4,55	3,2	65	72	ATB	15°	15°	2/9/100 + 2/9/110	LI27M DA3	F03FS02737
	Main blade	400	4,4	3,2	65	72	TCG	15°	15°	2/9/110	LSB40016X	F03FS09172
	HW Scorer	200	4,3-5,5	3,2	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M43PI3	F03FS02681
	HW Scorer	300	4,3-5,5	3,0	65	48	ATB	12°	15°	2/9/100 + 2/9/110	LI25M43RX3	F03FS07616
	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH4	F03FS09625
DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH6	F03FS09626	

* Tool type: Main saw blade, Scoring saw blade, Polycrystalline Diamond scorer and Postforming scorer.

Reference table of saw blades for panel sizing machines

Machine type	Tool type *	D	B-B1	b	d	Z	Tooth type	α	β	NL	Freud Code	Art. No.
		mm	mm	mm	mm							
EB/EBT 120, WN 125	Main blade	430	4,4	3,2	80	72	TCG	15°	15°	2/9/130 + 2/14/110 + 4/19/120	LSB43009X	F03FS07909
	HW Scorer	200	4,3-5,5	3,2	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M43PI3	F03FS02681
	HW Scorer	300	4,3-5,5	3,2	65	72	ATB	12°	15°	2/9/100 + 2/9/110	LI25M43RI3	F03FS02689
	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH4	F03FS09625
	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH6	F03FS09626
	Postf. scorer	300	4,55	3,2	65	72	ATB	15°	15°	2/9/100 + 2/9/110	LI27M DA3	F03FS02737
WN-WNA 650, WN-WNA 650 (PFS)	Main blade	430	4,4	3,2	65	72	TCG	15°	15°	2/9/110	LSB43012X	F03FS09178
	HW Scorer	200	4,3-5,5	3,2	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M43PI3	F03FS02681
	HW Scorer	300	4,3-5,5	3,0	65	48	ATB	12°	15°	2/9/100 + 2/9/110	LI25M43RX3	F03FS07616
	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH4	F03FS09625
	DP Scorer	200	4,3-5,1	3,2	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M43PIH6	F03FS09626
WN 710, WN 710 (PFS)	Main blade	430	4,8	3,5	70	72	TCG	15°	15°	4/11/130	LSB43013X	F03FS09180
	HW Scorer	200	4,7-5,9	3,5	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M47PI3	F03FS02720
	HW Scorer	300	4,7-5,9	3,5	65	48	ATB	6°	15°	2/9/110	LI25M47RX3	F03FS07744
	DP Scorer	200	4,7-5,5	3,5	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M47PIH4	F03FS09631
	DP Scorer	200	4,7-5,5	3,5	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M47PIH6	F03FS09632
WN 600/132, WN 200	Main blade	450	4,8	3,5	80	72	TCG	15°	15°	2/14/125 + 2/9/130 + 4/19/120	LSB45018X	F03FS07812
	HW Scorer	200	4,7-5,9	3,5	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M47PI3	F03FS02720
	DP Scorer	200	4,7-5,5	3,5	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M47PIH4	F03FS09631
	DP Scorer	200	4,7-5,5	3,5	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M47PIH6	F03FS09632
	Postf. scorer	300	4,95	3,0	65	72	ATB	15°	15°	2/9/100 + 2/9/110	LI27M DB3	F03FS02739
WN 600/132, WN 200	Main blade	450	4,8	3,5	80	72	TCG	15°	15°	2/14/125 + 2/9/130 + 4/19/120	LSB45018X	F03FS07812
	HW Scorer	200	4,7-5,9	3,5	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M47PI3	F03FS02720
	DP Scorer	200	4,7-5,5	3,5	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M47PIH4	F03FS09631
	DP Scorer	200	4,7-5,5	3,5	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M47PIH6	F03FS09632
	Postf. scorer	300	4,95	3,0	65	72	ATB	15°	15°	2/9/100 + 2/9/110	LI27M DB3	F03FS02739
WN-WNA 730, WN-WNA 730 (PFS)	Main blade	470	4,8	3,5	70	72	TCG	15°	15°	4/11/130	LSB47005X	F03FS09185
	HW Scorer	200	4,7-5,9	3,5	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M47PI3	F03FS02720
	HW Scorer	300	4,7-5,9	3,5	65	48	ATB	6°	15°	2/9/110	LI25M47RX3	F03FS07744
	DP Scorer	200	4,7-5,5	3,5	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M47PIH4	F03FS09631
	DP Scorer	200	4,7-5,5	3,5	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M47PIH6	F03FS09632
WN-WNA 750, WN-WNA 750 (PFS)	Main blade	470	4,8	3,5	70	72	TCG	15°	15°	4/11/130	LSB47005X	F03FS09185
	Main blade	520	4,8	3,5	70	72	TCG	15°	15°	4/11/130	LSB52006X	F03FS09193
	HW Scorer	200	5,7-6,9	3,5	65	36	ATB	8°	15°	2/9/110	LI25M57PI3BS	F03FS08165
WN 600/145, WN 512	Main blade	480	4,8	3,5	80	72	TCG	15°	15°	2/9/130 + 4/19/120	LSB48001X	F03FS09188
	HW Scorer	200	4,7-5,9	3,5	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M47PI3	F03FS02720
	DP Scorer	200	4,7-5,5	3,5	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M47PIH4	F03FS09631
	DP Scorer	200	4,7-5,5	3,5	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M47PIH6	F03FS09632
	Postf. scorer	300	4,55	3,2	65	72	ATB	15°	15°	2/9/100 + 2/9/110	LI27M DA3	F03FS02737
WNA600/162	Main blade	510	4,8	3,5	80	72	TCG	15°	15°	2/9/130 + 4/19/120	LSB51001X	F03FS09984
	HW Scorer	200	4,7-5,9	3,5	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M47PI3	F03FS02720
	DP Scorer	200	4,7-5,5	3,5	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M47PIH4	F03FS09631
	DP Scorer	200	4,7-5,5	3,5	65	36	FLAT	6°	14°	2/9/100 + 2/9/110	DLI25M47PIH6	F03FS09632
	Postf. scorer	300	4,95	3,0	65	72	ATB	15°	15°	2/9/100 + 2/9/110	LI27M DB3	F03FS02739
WN-WNA 850	Main blade	600	5,8	4,0	70	60	TCG	15°	15°	4/11/130	LSB60004X	F03FS10258
	Main blade	600	5,8	4,0	75	60	TCG	15°	15°	4/6,5/130 + 4/11/130	LSB60006X	F03FS10259
	HW Scorer	200	5,7-6,9	3,5	65	36	ATB	8°	15°	2/9/110	LI25M57PI3BS	F03FS08165
AES												
ALPHA PS-03	Main blade	320	4,4	3,2	30	72	TCG	15°	15°	2/10/60 + 2/13/94	LSB32009X	F03FS10296
	HW Scorer	200	4,3-5,5	3,2	20	36	ATB	8°	15°	2/10/60 + 2/9/62 + 2/11/66	LI25M43PA3	F03FS02670
ALPHA PS-05	Main blade	430	4,4	3,2	30	72	TCG	15°	15°	2/13/94	LSB43007X	F03FS09177
	HW Scorer	200	4,3-5,5	3,2	20	36	ATB	8°	15°	2/11/66 + 2/10/60 + 2/9/62	LI25M43PA3	F03FS02670

* Tool type: Main saw blade, Scoring saw blade, Polycrystalline Diamond scorer and Postforming scorer.

Reference table of saw blades for panel sizing machines

Machine type	Tool type *	D	B-B1	b	d	Z	Tooth type	α	β	NL	Freud Code	Art. No.
		mm	mm	mm	mm							
ALPHA PS-06	Main blade	460	4,4	3,2	30	72	TCG	15°	15°	2/13/94	LSB46001X	F03FS08922
	HW Scorer	200	4,3-5,5	3,2	20	36	ATB	8°	15°	2/11/66 + 2/10/60 + 2/9/62	LI25M43PA3	F03FS02670
ANTHON												
LN (90)	400	4,4	3,2	60	72	72	TCG	15°	15°	2/14/100 + 2/11/85	LSB40017X	F03FS09272
	180	4,3-5,5	3,2	20	28	28	ATB	8°	15°	-	LI25M43NA3	F03FS02661
	180	4,3-5,5	3,2	20	36	36	ATB	8°	15°	-	LI25M43XA3	F03FS06372
PORTA 100	400	4,4	3,2	60	72	72	TCG	15°	15°	2/14/100 + 2/11/85	LSB40017X	F03FS09272
	180	4,3-5,5	3,2	20	36	36	ATB	8°	15°	-	LI25M43XA3	F03FS06372
LNA (100), LN (120)	450	4,4	3,2	60	72	72	TCG	15°	15°	2/14/125	LSB45008X	F03FS09182
	180	4,3-5,5	3,2	20	36	36	ATB	8°	15°	-	LI25M43XA3	F03FS06372
PORTA 150	500	4,8	3,5	60	60	60	TCG	15°	15°	2/11/115	LSB50009X	F03FS09189
	180	4,3-5,5	3,2	20	36	36	ATB	8°	15°	-	LI25M43XA3	F03FS06372
AYZA MIZRAK												
LANZA P3	Main blade	320	4,4	3,2	65	60	TCG	15°	15°	2/9/110	LSB32003X	F03FS09161
	Main blade	320	4,4	3,2	65	72	TCG	15°	15°	2/9/95 + 2/9/110	LSB32001X	F03FS07805
	HW Scorer	200	4,3-5,5	3,2	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M43PI3	F03FS02681
	Main blade	360	4,4	3,2	65	60	TCG	15°	15°	2/9/110	LSB36001X	F03FS10227
	Main blade	360	4,4	3,2	65	72	TCG	15°	15°	2/9/95 + 2/9/110	LSB36002X	F03FS07673
	HW Scorer	200	4,3-5,5	3,2	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M43PI3	F03FS02681
LANZA P4	Main blade	380	4,4	3,2	65	72	TCG	15°	15°	2/9/110	LSB38014X	F03FS09166
	HW Scorer	200	4,3-5,5	3,2	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M43PI3	F03FS02681
LANZA P5	Main blade	400	4,4	3,2	65	72	TCG	15°	15°	2/9/110	LSB40016X	F03FS09172
	HW Scorer	200	4,3-5,5	3,2	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M43PI3	F03FS02681
LANZA P5 CARRERA	Main blade	400	4,4	3,2	65	72	TCG	15°	15°	2/9/110	LSB40016X	F03FS09172
	HW Scorer	200	4,3-5,5	3,2	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M43PI3	F03FS02681
FELDER MAYER												
KAPPA AUTOMATIC 80	Main blade	320	4,4	3,2	30	60	TCG	15°	15°	2/10/60	LSB32005X	F03FS09160
	Main blade	320	4,4	3,2	30	72	TCG	15°	15°	2/10/60 + 2/13/94	LSB32009X	F03FS10296
	HW Scorer	150	4,3-5,6	3,2	30	36	ATB	8°	15°	-	LI25M43KC3	F03FS02649
KAPPA AUTOMATIC 80 EDITION	Main blade	320	4,4	3,2	30	60	TCG	15°	15°	2/10/60	LSB32005X	F03FS09160
	HW Scorer	150	4,3-5,6	3,2	30	36	ATB	8°	15°	-	LI25M43KC3	F03FS02649
KAPPA AUTOMATIC CLASSIC	Main blade	320	4,4	3,2	30	60	TCG	15°	15°	2/10/60	LSB32005X	F03FS09160
	HW Scorer	150	4,3-5,6	3,2	30	36	ATB	8°	15°	-	LI25M43KC3	F03FS02649
PS80	Main blade	320	4,4	3,2	30	60	TCG	15°	15°	2/10/60	LSB32005X	F03FS09160
	HW Scorer	150	4,3-5,6	3,2	30	36	ATB	8°	15°	-	LI25M43KC3	F03FS02649
KAPPA AUTOMATIC 100	Main blade	355	4,4	3,2	30	72	TCG	15°	15°	2/10/60	LSB35504X	F03FS07674
	HW Scorer	150	4,3-5,6	3,2	30	36	ATB	8°	15°	-	LI25M43KC3	F03FS02649
PS80 PREMIUM	Main blade	355	4,4	3,2	30	72	TCG	15°	15°	2/10/60	LSB35504X	F03FS07674
	HW Scorer	150	4,3-5,6	3,2	30	36	ATB	8°	15°	-	LI25M43KC3	F03FS02649
KAPPA AUTOMATIC 120	Main blade	400	4,4	3,2	30	48	TCG	15°	15°	2/10/60	LSB40001X	F03FS09168
	Main blade	400	4,4	3,2	30	60	TCG	15°	15°	2/10/60	LSB40004X	F03FS09169
	Main blade	400	4,4	3,2	30	72	TCG	15°	15°	2/10/60 + 2/13/94	LSB40007X	F03FS07725
	HW Scorer	150	4,3-5,6	3,2	30	36	ATB	8°	15°	-	LI25M43KC3	F03FS02649
PS100	Main blade	400	4,4	3,2	30	48	TCG	15°	15°	2/10/60	LSB40001X	F03FS09168
	Main blade	400	4,4	3,2	30	60	TCG	15°	15°	2/10/60	LSB40004X	F03FS09169
	Main blade	400	4,4	3,2	30	72	TCG	15°	15°	2/10/60 + 2/13/94	LSB40007X	F03FS07725
	HW Scorer	150	4,3-5,6	3,2	30	36	ATB	8°	15°	-	LI25M43KC3	F03FS02649
PS2 Z	Main blade	450	4,4	3,2	30	72	TCG	15°	15°	2/10/60 + 2/14/95	LSB45007X	F03FS09181
	HW Scorer	150	4,3-5,6	3,2	30	36	ATB	8°	15°	-	LI25M43KC3	F03FS02649
KAPPA AUTOMATIC 140	Main blade	450	4,4	3,2	30	72	TCG	15°	15°	2/10/60 + 2/14/95	LSB45007X	F03FS09181
	HW Scorer	150	4,3-5,6	3,2	30	36	ATB	8°	15°	-	LI25M43KC3	F03FS02649

* Tool type: Main saw blade, Scoring saw blade, Polycrystalline Diamond scorer and Postforming scorer.

Reference table of saw blades for panel sizing machines

Machine type	Tool type *	D	B-B1	b	d	Z	Tooth type	α	β	NL	Freud Code	Art. No.
		mm	mm	mm	mm							
FIMAL												
CONCEPT 350	Main blade	350	4,4	3,2	30	72	TCG	15°	15°	2/10/60	LSB35003X	F03FS07630
	Main blade	300	4,4	3,0	30	60	TCG	15°	15°	2/10/60	LSB30001X	F03FS07802
KR32	Main blade	350	4,4	3,2	30	72	TCG	15°	15°	2/10/60	LSB35003X	F03FS07630
KR43	Main blade	350	4,4	3,2	30	72	TCG	15°	15°	2/10/60	LSB35003X	F03FS07630
GIBEN												
MK, GAMMA, N, ST, SE, TREND	Main blade	355	4,4	3,2	75	72	TCG	15°	15°	4/15/105 + 2/7/110	LSB35505X	F03FS07633
	HW Scorer	125	4,3-5,5	3,2	45	24	ATB	0°	15°	-	LI25M43FE3	F03FS02645
SMART SP105, ICON 105	Main blade	380	4,4	3,2	50	72	TCG	15°	15°	4/13/80	LSB38008X	F03FS09165
	HW Scorer	250	4,3-5,5	3,2	50	48	ATB	8°	15°	3/13/80	LI25M430F3	F03FS02669
G 2000 STARMATIC	Main blade	400	4,4	3,2	75	72	TCG	15°	15°	4/15/105 + 2/7/110 + 2/14/100	LSB40008X	F03FS07726
	Main blade	400	4,4	3,2	75	84	TCG	15°	15°	4/15/105 + 2/7/110	LSB40019X	F03FS08990
	HW Scorer	125	4,5-5,7	3,0	45	24	ATB	0°	15°	-	LI25M45FE3	F03FS02699
PRISMATIC 101	Main blade	400	4,4	3,2	75	72	TCG	15°	15°	4/15/105 + 2/7/110 + 2/14/100	LSB40008X	F03FS07726
	HW Scorer	160	4,3-5,5	3,2	45	36	ATB	8°	15°	3/11/70	LI25M43LE3	F03FS02655
PRISMATIC 201	Main blade	400	4,4	3,2	75	72	TCG	15°	15°	4/15/105 + 2/7/110 + 2/14/100	LSB40008X	F03FS07726
	Main blade	430	4,4	3,2	75	72	TCG	15°	15°	4/15/105 + 2/7/110	LSB43008X	F03FS07908
	HW Scorer	215	4,3-5,5	3,2	50	42	ATB	8°	15°	2/7/80 + 3/15/80	LI25M430F3	F03FS02685
	HW Scorer	300	4,3-5,5	3,5	50	48	ATB	12°	15°	3/15/80	LI25M43RM3	F03FS02693
	DP Scorer	215	4,3-5,1	3,2	50	42	FLAT	6°	14°	2/7/80 + 3/15/80	DLI25M43QFH4	F03FS09633
	DP Scorer	215	4,3-5,1	3,2	50	42	FLAT	6°	14°	2/7/80 + 3/15/80	DLI25M43QFH6	F03FS09634
	Postf. Scorer	300	4,55	3,2	50	72	ATB	15°	15°	3/15/80	LI27M DD3	F03FS02743
PRISMATIC 2, 3	Main blade	470	4,4	3,2	75	96	TCG	15°	15°	4/15/105	LSB47004X	F03FS09184
	HW Scorer	215	4,3-5,5	3,2	50	42	ATB	8°	15°	2/7/80 + 3/15/80	LI25M430F3	F03FS02685
	HW Scorer	215	4,5-5,7	3,2	50	42	ATB	8°	15°	3/15/80	LI25M45PF3	F03FS02713
	HW Scorer	300	4,3-5,5	3,5	50	48	ATB	12°	15°	3/15/80	LI25M43RM3	F03FS02693
	DP Scorer	215	4,3-5,1	3,2	50	42	FLAT	6°	14°	2/7/80 + 3/15/80	DLI25M43QFH4	F03FS09633
	DP Scorer	215	4,3-5,1	3,2	50	42	FLAT	6°	14°	2/7/80 + 3/15/80	DLI25M43QFH6	F03FS09634
	Postf. Scorer	300	4,55	3,2	50	72	ATB	15°	15°	3/15/80	LI27M DD3	F03FS02743
ICONFAST LM D-816	Main blade	530	4,8	3,5	75	72	TCG	15°	15°	2/7/110	LSB53004X	F03FS09651
	HW Scorer	215	4,7-5,9	3,5	50	42	ATB	8°	15°	2/7/80	LI25M47QF3	F03FS09650
HOLZHER												
CUT 85, 82	Main blade	350	4,4	3,2	30	72	TCG	15°	15°	2/10/60	LSB35003X	F03FS07630
	HW Scorer	180	4,3-5,5	3,2	30	28	ATB	8°	15°	2/7/42 + 2/10/60	LI25M43NC3	F03FS02663
	HW Scorer	180	4,3-5,5	3,2	30	36	ATB	8°	15°	2/7/42 + 2/10/60	LI25M43XN3	F03FS06373
	Postf. scorer	250	4,60	3,0	30	48	ATB	15°	15°	-	LI27M BA3	F03FS02734
TECTRA 6120 CLASSIC	Main blade	350	4,4	3,2	30	72	TCG	15°	15°	2/10/60	LSB35003X	F03FS07630
	HW Scorer	180	4,3-5,5	3,2	30	36	ATB	8°	15°	2/7/42 + 2/10/60	LI25M43XN3	F03FS06373
CUT 110	Main blade	400	4,4	3,2	30	72	TCG	15°	15°	2/10/60 + 2/13/94	LSB40007X	F03FS07725
	HW Scorer	250	4,3-5,5	3,2	30	48	CON	8°	15°	2/10/60	LI25M430C3	F03FS02668
	Postf. scorer	250	4,60	3,0	30	48	ATB	15°	15°	-	LI27M BA3	F03FS02734
ZENTREX 6220 (POWER, LIFT, DYNAMIC)	Main blade	430	4,4	3,2	30	72	TCG	15°	15°	2/13/94	LSB43007X	F03FS09177
	HW Scorer	180	4,3-5,5	3,2	30	36	ATB	8°	15°	2/7/42 + 2/10/60	LI25M43XN3	F03FS06373
HOLZMA												
HPP130	Main blade	300	4,4	3,2	60	72	TCG	15°	15°	2/14/100	LSB30012X	F03FS09207
	DP Scorer	180	4,3-5,1	3,2	45	30	FLAT	6°	14°	-	DLI25M43NEH4	F03FS09621
	DP Scorer	180	4,3-5,1	3,2	45	30	FLAT	6°	14°	-	DLI25M43NEH6	F03FS09622
	HW Scorer	180	4,3-5,5	3,2	45	36	CON	8°	15°	-	LI25M43NE3	F03FS02664

* Tool type: Main saw blade, Scoring saw blade, Polycrystalline Diamond scorer and Postforming scorer.

Reference table of saw blades for panel sizing machines

Machine type	Tool type *	D	B-B1	b	d	Z	Tooth type	α	β	NL	Freud Code	Art. No.
		mm	mm	mm	mm							
HPP230, 250 (before 06/2014)	Main blade	300	4,4	3,2	60	72	TCG	15°	15°	2/14/100	LSB30012X	F03FS09207
	Main blade	350	4,4	3,2	60	72	TCG	15°	15°	2/14/100	LSB35004X	F03FS07636
	HW Scorer	200	4,3-5,5	3,2	45	36	ATB	8°	15°	-	LI25M43PE3	F03FS02676
	HW Scorer	180	4,3-5,5	3,2	45	36	ATB	8°	15°	-	LI25M43NE3	F03FS02664
	DP Scorer	180	4,3-5,1	3,2	45	30	FLAT	6°	14°	-	DLI25M43NEH4	F03FS09621
	DP Scorer	180	4,3-5,1	3,2	45	30	FLAT	6°	14°	-	DLI25M43NEH6	F03FS09622
SAWTEQ B-200	Main blade	310	4,4	3,2	60	72	TCG	15°	15°	2/14/100	LSB31001X	F03FS09949
	HW Scorer	200	4,3-5,5	3,2	45	36	ATB	8°	15°	-	LI25M43PE3	F03FS02676
HPP350	Main blade	350	4,4	3,2	75	72	TCG	15°	15°	-	LSB35008X	F03FS07634
	HW Scorer	180	4,3-5,5	3,2	45	36	ATB	8°	15°	-	LI25M43NE3	F03FS02664
	DP Scorer	180	4,3-5,1	3,2	45	30	FLAT	6°	14°	-	DLI25M43NEH4	F03FS09621
	DP Scorer	180	4,3-5,1	3,2	45	30	FLAT	6°	14°	-	DLI25M43NEH6	F03FS09622
	DP Scorer	180	4,3-5,1	3,2	45	30	FLAT	6°	14°	-	DLI25M43NEH6	F03FS09622
HPP180	Main blade	380	4,4	3,2	60	72	TCG	15°	15°	2/14/100	LSB38002X	F03FS07631
	HW Scorer	180	4,3-5,5	3,2	45	36	ATB	8°	15°	-	LI25M43NE3	F03FS02664
	DP Scorer	180	4,3-5,1	3,2	45	30	FLAT	6°	14°	-	DLI25M43NEH4	F03FS09621
	DP Scorer	180	4,3-5,1	3,2	45	30	FLAT	6°	14°	-	DLI25M43NEH6	F03FS09622
HPP380, 82	Main blade	380	4,4	3,2	60	72	TCG	15°	15°	2/14/100	LSB38002X	F03FS07631
	Main blade	380	4,8	3,5	60	72	TCG	15°	15°	2/14/100	LSB38004X	F03FS07632
	Main blade	380	4,8	3,5	60	84	TCG	15°	15°	2/14/100	LSB38005X	F03FS07807
	HW Scorer	180	4,3-5,5	3,2	45	36	ATB	8°	15°	-	LI25M43NE3	F03FS02664
	HW Scorer	180	4,7-5,9	3,5	45	36	ATB	8°	15°	-	LI25M47NE3	F03FS02715
	DP Scorer	180	4,3-5,1	3,2	45	30	FLAT	6°	14°	-	DLI25M43NEH4	F03FS09621
	DP Scorer	180	4,3-5,1	3,2	45	30	FLAT	6°	14°	-	DLI25M43NEH6	F03FS09622
	DP Scorer	180	4,7-5,5	3,5	45	30	FLAT	6°	14°	-	DLI25M47NEH4	F03FS09623
	DP Scorer	180	4,7-5,5	3,5	45	30	FLAT	6°	14°	-	DLI25M47NEH6	F03FS09624
	Postf. scorer	280	5,0	3,5	45	84	ATB	15°	15°	-	LI27M CA3	F03FS02736
HPL410	Main blade	420	4,8	3,5	60	60	TCG	15°	15°	2/14/125	LSB42001X	F03FS10234
	Main blade	420	4,8	3,5	60	84	TCG	15°	15°	2/14/100 + 2/14/125	LSB42002X	F03FS09176
	HW Scorer	180	4,7-5,9	3,5	45	36	ATB	8°	15°	-	LI25M47NE3	F03FS02715
	DP Scorer	180	4,7-5,5	3,5	45	30	FLAT	6°	14°	-	DLI25M47NEH4	F03FS09623
	DP Scorer	180	4,7-5,5	3,5	45	30	FLAT	6°	14°	-	DLI25M47NEH6	F03FS09624
	Postf. scorer	340	5,0	3,5	45	108	ATB	15°	15°	3/14/65	LI27M EB3	F03FS02747
HPP430, 510, 11	Main blade	450	4,8	3,5	60	72	TCG	15°	15°	2/14/125 + 2/17/100	LSB45017X	F03FS07391
	HW Scorer	180	4,7-5,9	3,5	45	36	ATB	8°	15°	-	LI25M47NE3	F03FS02715
	DP Scorer	180	4,7-5,5	3,5	45	30	FLAT	6°	14°	-	DLI25M47NEH4	F03FS09623
	DP Scorer	180	4,7-5,5	3,5	45	30	FLAT	6°	14°	-	DLI25M47NEH6	F03FS09624
	Postf. scorer	340	5,0	3,5	45	108	ATB	15°	15°	3/14/65	LI27M EB3	F03FS02747
22	Main blade	500	4,8	3,5	60	72	TCG	15°	15°	2/11/115	LSB50011X	F03FS09191
	HW Scorer	200	4,7-5,9	3,5	45	36	ATB	8°	15°	-	LI25M47PE3	F03FS02719
	DP Scorer	200	4,7-5,5	3,5	45	36	FLAT	6°	14°	-	DLI25M47PEH4	F03FS09629
	DP Scorer	200	4,7-5,5	3,5	45	36	FLAT	6°	14°	-	DLI25M47PEH6	F03FS09630
	Postf. scorer	340	5,0	3,5	45	108	ATB	15°	15°	3/14/65	LI27M EB3	F03FS02747
HPL550	Main blade	520	4,8	3,5	60	72	TCG	15°	15°	2/11/115 + 2/19/120	LSB52003X	F03FS09192
	HW Scorer	200	4,7-5,9	3,5	45	36	ATB	8°	15°	-	LI25M47PE3	F03FS02719
	DP Scorer	200	4,7-5,5	3,5	45	36	FLAT	6°	14°	-	DLI25M47PEH4	F03FS09629
	DP Scorer	200	4,7-5,5	3,5	45	36	FLAT	6°	14°	-	DLI25M47PEH6	F03FS09630
	Postf. scorer	340	5,0	3,5	45	108	ATB	15°	15°	3/14/65	LI27M EB3	F03FS02747
HPL570	Main blade	570	4,8	3,5	60	60	TCG	15°	15°	2/11/115 + 2/19/120	LSB57001X	F03FS09199
	HW Scorer	200	4,7-5,9	3,5	45	36	ATB	8°	15°	-	LI25M47PE3	F03FS02719
	DP Scorer	200	4,7-5,5	3,5	45	36	FLAT	6°	14°	-	DLI25M47PEH4	F03FS09629
	DP Scorer	200	4,7-5,5	3,5	45	36	FLAT	6°	14°	-	DLI25M47PEH6	F03FS09630
	Postf. scorer	340	5,0	3,5	45	108	ATB	15°	15°	3/14/65	LI27M EB3	F03FS02747

* Tool type: Main saw blade, Scoring saw blade, Polycrystalline Diamond scorer and Postforming scorer.

Reference table of saw blades for panel sizing machines

Machine type	Tool type *	D	B-B1	b	d	Z	Tooth type	α	β	NL	Freud Code	Art. No.
		mm	mm	mm	mm							
HPP42, 33	Main blade	600	5,8	4,0	60	60	TCG	15°	15°	2/11/115 + 2/19/120	LSB60001X	F03FS09200
	Main blade	600	5,8	4,0	60	72	TCG	15°	15°	2/11/115 + 2/19/120	LSB60002X	F03FS09201
	HW Scorer	200	5,7-6,9	4,0	45	36	ATB	8°	15°	-	LI25M57PE3	F03FS02728
HOMAG												
CH 3	Main blade	300	4,4	3,0	75	60	TCG	15°	15°	-	LSB30003X	F03FS03916
	HW Scorer	125	4,3-5,5	3,2	45	24	ATB	0°	15°	-	LI25M43FE3	F03FS02645
CH 3	Main blade	300	4,4	3,0	75	60	TCG	15°	15°	-	LSB30003X	F03FS03916
	HW Scorer	125	4,3-5,5	3,2	45	24	ATB	0°	15°	-	LI25M43FE3	F03FS02645
CT 04/40	Main blade	300	4,4	3,0	75	60	TCG	15°	15°	-	LSB30003X	F03FS03916
	HW Scorer	150	4,3-5,6	3,2	45	36	ATB	8°	15°	-	LI25M43KE3	F03FS02651
CV'S	Main blade	300	4,4	3,0	75	60	TCG	15°	15°	-	LSB30003X	F03FS10218
	HW Scorer	125	4,3-5,5	3,2	45	24	ATB	0°	15°	-	LI25M43FE3	F03FS02645
CH 04	Main blade	355	4,4	3,2	75	72	TCG	15°	15°	3/7/100	LSB35507X	F03FS07710
	HW Scorer	180	4,3-5,5	3,2	45	36	ATB	8°	15°	-	LI25M43NE3	F03FS02664
	DP Scorer	180	4,3-5,1	3,2	45	30	FLAT	6°	14°	-	DLI25M43NEH4	F03FS09621
	DP Scorer	180	4,3-5,1	3,2	45	30	FLAT	6°	14°	-	DLI25M43NEH6	F03FS09622
CH 08/12	Main blade	400	4,4	3,2	75	72	TCG	15°	15°	4/15/105 + 2/7/110 + 2/14/100	LSB40008X	F03FS07726
	HW Scorer	150	4,3-5,6	3,2	45	36	ATB	8°	15°	-	LI25M43KE3	F03FS02651
NANXING												
NPC330	Main blade	380	4,4	3,2	60	72	TCG	15°	15°	2/14/100	LSB38002X	F03FS07631
	Main blade	350	4,4	3,2	60	72	TCG	15°	15°	2/14/100	LSB35004X	F03FS07636
	HW Scorer	200	4,3-5,5	3,2	45	36	ATB	8°	15°	-	LI25M43PE3	F03FS02676
MJB1327B	Main blade	450	4,8	3,5	60	72	TCG	15°	15°	2/14/125 + 2/17/100	LSB45017X	F03FS09272
	Main blade	400	4,4	3,2	60	84	TCG	15°	15°	2/14/100	LSB40021X	F03FS09255
	HW Scorer	180	4,3-5,5	3,2	30	36	ATB	8°	15°	2/7/42 + 2/10/60	LI25M43XN3	F03FS06373
NP280FG NP280F	Main blade	450	4,8	3,5	60	72	TCG	15°	15°	2/14/125 + 2/17/100	LSB45017X	F03FS09272
	Main blade	400	4,4	3,2	60	84	TCG	15°	15°	2/14/100	LSB40021X	F03FS09255
	Main blade	350	4,4	3,2	60	72	TCG	15°	15°	2/14/100	LSB35004X	F03FS07636
	HW Scorer	180	4,3-5,5	3,2	30	36	ATB	8°	15°	2/7/42 + 2/10/60	LI25M43XN3	F03FS06373
	Main blade	450	4,8	3,5	60	72	TCG	15°	15°	2/14/125 + 2/17/100	LSB45017X	F03FS07391
NPL330HG NP330H NP330HG	HW Scorer	180	4,7-5,9	3,5	45	36	ATB	8°	15°	-	LI25M47NE3	F03FS02715
	DP Scorer	180	4,7-5,5	3,5	45	30	FLAT	6°	14°	-	DLI25M47NEH4	F03FS09623
	DP Scorer	180	4,7-5,5	3,5	45	30	FLAT	6°	14°	-	DLI25M47NEH6	F03FS09624
NP380FG NP330FG NP330F	Main blade	450	4,8	3,5	60	72	TCG	15°	15°	2/14/125 + 2/17/100	LSB45017X	F03FS09272
	Main blade	400	4,4	3,2	60	84	TCG	15°	15°	2/14/100	LSB40021X	F03FS09255
	HW Scorer	180	4,7-5,9	3,5	45	36	ATB	8°	15°	-	LI25M47NE3	F03FS02715
	DP Scorer	180	4,7-5,5	3,5	45	30	FLAT	6°	14°	-	DLI25M47NEH4	F03FS09623
	DP Scorer	180	4,7-5,5	3,5	45	30	FLAT	6°	14°	-	DLI25M47NEH6	F03FS09624
NZH3318 NPD380	Main blade	450	4,8	3,5	60	72	TCG	15°	15°	2/14/125 + 2/17/100	LSB45017X	F03FS07391
	HW Scorer	180	4,7-5,9	3,5	45	36	ATB	8°	15°	-	LI25M47NE3	F03FS02715
	DP Scorer	180	4,7-5,5	3,5	45	30	FLAT	6°	14°	-	DLI25M47NEH4	F03FS09623
	DP Scorer	180	4,7-5,5	3,5	45	30	FLAT	6°	14°	-	DLI25M47NEH6	F03FS09624
NIMAC												
HERMES 70 CNC	Main blade	300	4,4	3,0	65	72	TCG	15°	15°	2/9/95 + 2/9/110	LSB30006X	F03FS09158
	Main blade	320	4,4	3,2	65	72	TCG	15°	15°	2/9/95 + 2/9/110	LSB32001X	F03FS07805
ATLAS 80	Main blade	320	4,4	3,2	65	72	TCG	15°	15°	2/9/95 + 2/9/110	LSB32001X	F03FS07805
ATLAS 100/100TL	Main blade	355	4,4	3,2	65	72	TCG	15°	15°	2/9/95 + 2/9/110	LSB35508X	F03FS08740
	Main blade	360	4,4	3,2	65	72	TCG	15°	15°	2/9/95 + 2/9/110	LSB36002X	F03FS07673
PANHANS												
EURO 10 SF	Main blade	300	4,4	3,0	30	60	TCG	15°	15°	2/10/60	LSB30001X	F03FS07802
	HW Scorer	250	4,3-5,5	3,2	30	48	CON	8°	15°	2/10/60	LI25M430C3	F03FS02668
	Postf. scorer	250	4,6	3,0	30	48	ATB	15°	15°	-	LI27M BA3	F03FS02734

* Tool type: Main saw blade, Scoring saw blade, Polycrystalline Diamond scorer and Postforming scorer.

Reference table of saw blades for panel sizing machines

Machine type	Tool type *	D	B-B1	b	d	Z	Tooth type	α	β	NL	Freud Code	Art. No.
		mm	mm	mm	mm							
EURO 5 (SF, COMPACT, ECOPAN)	Main blade	300	4,4	3,0	30	60	TCG	15°	15°	2/10/60	LSB30001X	F03FS07802
	HW Scorer	125	4,3-5,5	3,2	20	24	CON	0°	15°	-	LI25M43FA3	F03FS02643
EURO10, 693/SH 70	Main blade	300	4,4	3,0	30	60	TCG	15°	15°	2/10/60	LSB30001X	F03FS07802
	HW Scorer	125	4,3-5,5	3,2	20	24	CON	0°	15°	-	LI25M43FA3	F03FS02643
	HW Scorer	180	4,3-5,5	3,2	30	28	CON	8°	15°	2/7/42 + 2/10/60	LI25M43NC3	F03FS02663
S 45	Main blade	300	4,4	3,0	30	60	TCG	15°	15°	2/10/60	LSB30001X	F03FS07802
	Main blade	350	4,4	3,2	30	72	TCG	15°	15°	2/10/60	LSB35003X	F03FS07630
	HW Scorer	180	4,3-5,5	3,2	30	28	CON	8°	15°	2/7/42 + 2/10/60	LI25M43NC3	F03FS02663
EURO 12, 30	Main blade	350	4,4	3,2	30	72	TCG	15°	15°	2/10/60	LSB35003X	F03FS07630
	HW Scorer	180	4,3-5,5	3,2	30	28	CON	8°	15°	2/7/42 + 2/10/60	LI25M43NC3	F03FS02663
EURO 12 SF	Main blade	350	4,4	3,2	30	72	TCG	15°	15°	2/10/60	LSB35003X	F03FS07630
	HW Scorer	280	4,3-5,5	3,2	30	48	CON	12°	15°	2/10/60	LI25M43VC3	F03FS07419
POLYPAN 47	Main blade	350	4,4	3,2	30	72	TCG	15°	15°	2/10/60	LSB35003X	F03FS07630
	HW Scorer	180	4,3-5,5	3,2	30	28	CON	8°	15°	2/7/42 + 2/10/60	LI25M43NC3	F03FS02663
	Postf. scorer	300	4,55	3,0	30	72	ATB	15°	15°	-	LI27M DF3	F03FS02745
EUROSTAR 2 XL, POLYSTAR	Main blade	370	4,4	3,2	30	72	TCG	15°	15°	2/10/60	LSC37001	F03FS06312
	HW Scorer	180	4,3-5,5	3,2	30	28	CON	8°	15°	2/7/42 + 2/10/60	LI25M43NC3	F03FS02663
	HW Scorer	280	4,3-5,5	3,2	30	48	CON	6°	15°	2/10/60	LI25M43VC3	F03FS07419
EURO 32	Main blade	370	4,4	3,2	30	72	TCG	15°	15°	2/10/60	LSB37001X	F03FS10228
	HW Scorer	180	4,3-5,5	3,2	30	28	CON	8°	15°	2/7/42 + 2/10/60	LI25M43NC3	F03FS02663
693/SH 110	Main blade	400	4,4	3,2	30	72	TCG	15°	15°	2/10/60 + 2/13/94	LSB40007X	F03FS07725
	HW Scorer	180	4,3-5,5	3,2	30	28	CON	8°	15°	2/7/42 + 2/10/60	LI25M43NC3	F03FS02663
	Main blade	400	4,4	3,2	30	72	TCG	15°	15°	2/10/60 + 2/13/94	LSB40007X	F03FS07725
EUROSTAR 2 XXL	HW Scorer	180	4,3-5,5	3,2	30	28	CON	8°	15°	2/7/42 + 2/10/60	LI25M43NC3	F03FS02663
	HW Scorer	280	4,3-5,5	3,2	30	48	CON	6°	15°	2/10/60	LI25M43VC3	F03FS07419
SCHEER KOCH												
PA 6000, 5500	Main blade	350	4,4	3,2	30	72	TCG	15°	15°	2/10/60	LSB35003X	F03FS07630
	HW Scorer	200	4,3-5,5	3,2	20	36	ATB	8°	15°	2/11/66 + 2/10/60 + 2/9/62	LI25M43PA3	F03FS02670
	HW Scorer	200	4,3-5,5	3,2	30	36	ATB	8°	15°	2/9/60 + 2/10/60	LI25M43PC3	F03FS02674
SCHELLING												
FH3	Main blade	300	4,4	3,0	30	72	TCG	15°	15°	2/10/60	LSB30005X	F03FS07803
	Main blade	350	4,4	3,2	30	72	TCG	15°	15°	2/10/60	LSB35003X	F03FS07630
	HW Scorer	180	4,3-5,5	3,2	30	36	ATB	8°	15°	2/7/42 + 2/10/60	LI25M43XN3	F03FS06373
FH4 (till 06/2015)	Main blade	350	4,4	3,2	30	72	TCG	15°	15°	2/10/60	LSB35003X	F03FS07630
	HW Scorer	300	4,3-5,5	3,2	30	48	ATB	12°	15°	2/11/73 + 2/11/75 + 2/13/94	LI25M43RC3	F03FS07577
S45	Main blade	350	4,4	3,2	30	72	TCG	15°	15°	2/10/60	LSB35003X	F03FS07630
	Main blade	400	4,4	3,2	30	72	TCG	15°	15°	2/10/60 + 2/13/94	LSB40007X	F03FS07725
	HW Scorer	180	4,3-5,5	3,2	30	36	ATB	8°	15°	2/7/42 + 2/10/60	LI25M43XN3	F03FS06373
SCHELLING FH4 (from 07/2015 till 07/2017)	HW Scorer	300	4,3-5,5	3,2	30	48	ATB	12°	15°	2/11/73 + 2/11/75 + 2/13/94	LI25M43RC3	F03FS07577
	Main blade	360	4,4	3,2	30	72	TCG	15°	15°	2/13/94	LSB36003X	F03FS09341
	HW Scorer	200	4,3-5,5	3,2	20	36	ATB	8°	15°	2/11/66 + 2/10/60 + 2/9/62	LI25M43PA3	F03FS02670
FH4 (from 07/2017)	Main blade	360	4,4	3,2	30	72	TCG	15°	15°	2/13/94	LSB36003X	F03FS09341
	HW Scorer	300	4,3-5,5	3,2	30	48	ATB	12°	15°	2/11/73 + 2/11/75 + 2/13/94	LI25M43RC3	F03FS07577
FH5 (from 07/2015)	Main blade	400	4,4	3,2	30	72	TCG	15°	15°	2/10/60 + 2/13/94	LSB40007X	F03FS07725
	HW Scorer	300	4,3-5,5	3,2	30	48	ATB	12°	15°	2/11/73 + 2/11/75 + 2/13/94	LI25M43RC3	F03FS07577
FH5 (from 07/2015)	Main blade	400	4,4	3,2	30	72	TCG	15°	15°	2/10/60 + 2/13/94	LSB40007X	F03FS07725
	HW Scorer	300	4,3-5,5	3,2	30	48	ATB	12°	15°	2/11/73 + 2/11/75 + 2/13/94	LI25M43RC3	F03FS07577
FH5	Main blade	400	4,4	3,2	30	72	TCG	15°	15°	2/10/60 + 2/13/94	LSB40007X	F03FS07725
	HW Scorer	200	4,3-5,5	3,2	20	36	ATB	8°	15°	2/11/66 + 2/10/60 + 2/9/62	LI25M43PA3	F03FS02670
FK4 (from 07/2015)	Main blade	400	4,4	3,2	30	72	TCG	15°	15°	2/10/60 + 2/13/94	LSB40007X	F03FS07725
	HW Scorer	200	4,3-5,5	3,2	20	36	ATB	8°	15°	2/11/66 + 2/10/60 + 2/9/62	LI25M43PA3	F03FS02670
FK4 (from 07/2017)	Main blade	400	4,4	3,2	30	72	TCG	15°	15°	2/10/60 + 2/13/94	LSB40007X	F03FS07725
	HW Scorer	300	4,3-5,5	3,2	30	48	ATB	12°	15°	2/11/73 + 2/11/75 + 2/13/94	LI25M43RC3	F03FS07577

* Tool type: Main saw blade, Scoring saw blade, Polycrystalline Diamond scorer and Postforming scorer.

Reference table of saw blades for panel sizing machines

Machine type	Tool type *	D	B-B1	b	d	Z	Tooth type	α	β	NL	Freud Code	Art. No.
		mm	mm	mm	mm							
FH6, AH6, CH6 (till 06/2015)	Main blade	460	4,4	3,2	30	72	TCG	15°	15°	2/13/94	LSB46001X	F03FS08922
	HW Scorer	200	4,3-5,5	3,2	20	36	ATB	8°	15°	2/11/66 + 2/10/60 + 2/9/62	LI25M43PA3	F03FS02670
FK6, FP6, FM6	Main blade	460	4,4	3,2	30	72	TCG	15°	15°	2/13/94	LSB46001X	F03FS08922
	HW Scorer	200	4,3-5,5	3,2	20	36	ATB	8°	15°	2/11/66 + 2/10/60 + 2/9/62	LI25M43PA3	F03FS02670
FH6, AH6, CH6 (starting from 07/2015)	Main blade	480	4,8	3,5	30	72	TCG	15°	15°	2/10/60 + 2/13/94	LSB48004X	F03FS09187
	HW Scorer	220	4,7-5,9	3,5	20	36	ATB	8°	15°	2/9/62	LI25M47UA3	F03FS09266
	HW Scorer	200	4,7-5,9	3,5	20	36	ATB	8°	15°	2/11/66	LI25M47PA3	F03FS02716
FL	Main blade	480	4,4	3,2	30	72	TCG	15°	15°	2/10/60 + 2/13/94	LSB48007X	F03FS09914
	HW Scorer	200	4,3-5,5	3,2	20	36	ATB	8°	15°	2/11/66 + 2/10/60 + 2/9/62	LI25M43PA3	F03FS02670
FH8, AH8, CH8	Main blade	520	4,8	3,5	30	72	TCG	15°	15°	2/13/94	LSB52007X	F03FS09319
	Main blade	520	4,4	3,2	30	72	TCG	15°	15°	2/13/94	LSB52008X	F03FS09319
	HW Scorer	200	4,3-5,5	3,2	20	36	ATB	8°	15°	2/11/66 + 2/10/60 + 2/9/62	LI25M43PA3	F03FS02670
	HW Scorer	220	4,7-5,9	3,5	20	36	ATB	8°	15°	2/9/62	LI25M47UA3	F03FS09266
	HW Scorer	200	4,7-5,9	3,5	20	36	ATB	8°	15°	2/11/66	LI25M47PA3	F03FS02716
	HW Scorer	200	4,7-5,9	3,5	20	36	ATB	8°	15°	2/13/94	LSB52007X	F03FS09319
FK8, FM8	HW Scorer	200	4,7-5,9	3,5	20	36	ATB	8°	15°	2/11/66	LI25M47PA3	F03FS02716
	Main blade	520	4,4	3,2	30	72	TCG	15°	15°	2/13/94	LSB52008X	F03FS09319
	HW Scorer	200	4,3-5,5	3,2	20	36	ATB	8°	15°	2/11/66 + 2/10/60 + 2/9/62	LI25M43PA3	F03FS02670
	HW Scorer	200	4,3-5,5	3,2	20	36	ATB	8°	15°	2/13/140 + 2/17/140 + 2/13/114	LSB68001X	F03FS09203
FK10, FM10	Main blade	680	6,2	4,2	40	60	TCG	18°	13°	2/13/140 + 2/17/140 + 2/13/114	LSB68001X	F03FS09203
	HW Scorer	200	6,1-7,3	4,0	20	36	ATB	8°	15°	2/11/66	LI25M61PA3	F03FS02730
ASH (FSM)	Main blade	720	6,4	4,4	40	60	TCG	18°	13°	2/14/114 + 2/14/140	LSB72001X	F03FS09204
	HW Scorer	220	6,3-7,5	4,4	20	36	ATB	8°	15°	2/11/66	LI25M63UA3	F03FS02732
SCM												
PRIMA 50	Main blade	300	4,4	3,0	80	60	TCG	15°	15°	4/9/100 + 2/14/110	LSB30004X	F03FS09157
	Main blade	300	4,4	3,0	80	72	TCG	15°	15°	4/9/100 + 2/14/110	LSB30008X	F03FS07804
	HW Scorer	160	4,3-5,5	3,2	55	36	ATB	8°	15°	3/6/84 + 3/7/66	LI25M43LG3	F03FS02657
PRIMA 67	Main blade	320	4,4	3,2	80	60	TCG	10°	15°	4/9/100 + 2/9/110 + 2/14/110	LSB32006X	F03FS10101
	HW Scorer	160	4,3-5,5	3,2	55	36	ATB	8°	15°	3/6/84 + 3/7/66	LI25M43LG3	F03FS02657
	Postf. scorer	280	4,65	3,2	80	72	ATB	15°	15°	2/14/110	LI27M47VL3	F03FS08014
IMPACT 85 K	Main blade	350	4,4	3,2	80	72	TCG	15°	15°	4/9/100 + 2/9/110 + 2/14/110	LSB35005X	F03FS07635
	HW Scorer	160	4,3-5,5	3,2	55	36	ATB	8°	15°	3/6/84 + 3/7/66	LI25M43LG3	F03FS02657
IMPACT 105 C/D, PLUS 105 C/D/P	Main blade	380	4,4	3,2	80	72	TCG	15°	15°	4/9/100 + 2/9/110 + 2/14/110	LSB38010X	F03FS07808
	HW Scorer	160	4,3-5,5	3,2	55	36	ATB	8°	15°	3/6/84 + 3/7/66	LI25M43LG3	F03FS02657
IMPACT 90	Main blade	380	4,4	3,2	80	48	TCG	15°	15°	4/9/100 + 2/9/110 + 2/14/110	LSB38009X	F03FS09164
	HW Scorer	160	4,3-5,5	3,2	55	36	ATB	8°	15°	3/6/84 + 3/7/66	LI25M43LG3	F03FS02657
	HW Scorer	200	4,3-5,5	3,2	80	36	ATB	8°	15°	2/14/110	LI25M43PL3	F03FS02683
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH4	F03FS09627
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH6	F03FS09628
	Postf. scorer	300	4,70	3,2	80	72	ATB	15°	15°	2/14/110	LI27M DC3	F03FS02741
IMPACT 110	Main blade	400	4,4	3,2	80	72	TCG	15°	15°	4/9/100 + 2/9/110 + 2/14/110 + 2/14/125	LSB40012X	F03FS09173
	HW Scorer	160	4,3-5,5	3,2	55	36	ATB	8°	15°	3/6/84 + 3/7/66	LI25M43LG3	F03FS02657
	HW Scorer	200	4,3-5,5	3,2	80	36	ATB	8°	15°	2/14/110	LI25M43PL3	F03FS02683
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH4	F03FS09627
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH6	F03FS09628
	Postf. scorer	300	4,7	3,2	80	72	ATB	15°	15°	2/14/110	LI27M DC3	F03FS02741
SCM-GABBIANI												
GALAXY 90	Main blade	300	4,4	3,0	80	60	TCG	15°	15°	4/9/100 + 2/14/110	LSB30004X	F03FS09157
	Main blade	300	4,4	3,0	80	72	TCG	15°	15°	4/9/100 + 2/14/110	LSB30008X	F03FS07804
	HW Scorer	200	4,3-5,5	3,2	80	36	ATB	8°	15°	2/14/110	LI25M43PL3	F03FS02683
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH4	F03FS09627
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH6	F03FS09628
	Postf. scorer	300	4,70	3,2	80	72	ATB	15°	15°	2/14/110	LI27M DC3	F03FS02741

* Tool type: Main saw blade, Scoring saw blade, Polycrystalline Diamond scorer and Postforming scorer.

Reference table of saw blades for panel sizing machines

Machine type	Tool type *	D	B-B1	b	d	Z	Tooth type	α	β	NL	Freud Code	Art. No.
		mm	mm	mm	mm							
GALAXY 85	Main blade	350	4,4	3,2	80	72	TCG	15°	15°	4/9/100 + 2/9/110 + 2/14/110	LSB35005X	F03FS07635
	HW Scorer	200	4,3-5,5	3,2	80	36	ATB	8°	15°	2/14/110	LI25M43PL3	F03FS02683
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH4	F03FS09627
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH6	F03FS09628
GALAXY3 110, 110A	Main blade	400	4,4	3,2	80	72	TCG	15°	15°	4/9/100 + 2/9/110 + 2/14/110 + 2/14/125	LSB40012X	F03FS09173
	HW Scorer	200	4,3-5,5	3,2	80	36	ATB	8°	15°	2/14/110	LI25M43PL3	F03FS02683
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH4	F03FS09627
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH6	F03FS09628
	Postf. scorer	300	4,70	3,2	80	72	ATB	15°	15°	2/14/110	LI27M DC3	F03FS02741
GALAXY 115	Main blade	400	4,4	3,2	80	72	TCG	15°	15°	4/9/100 + 2/9/110 + 2/14/110 + 2/14/125	LSB40012X	F03FS09173
	HW Scorer	200	4,3-5,5	3,2	80	36	ATB	8°	15°	2/14/110	LI25M43PL3	F03FS02683
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH4	F03FS09627
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH6	F03FS09628
GALAXY3 130, 130A	Main blade	430	4,4	3,2	80	72	TCG	15°	15°	2/9/130 + 2/14/110 + 4/19/120	LSB43009X	F03FS07909
	HW Scorer	200	4,3-5,5	3,2	80	36	ATB	8°	15°	2/14/110	LI25M43PL3	F03FS02683
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH4	F03FS09627
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH6	F03FS09628
	Postf. scorer	300	4,70	3,2	80	72	ATB	15°	15°	2/14/110	LI27M DC3	F03FS02741
GALAXY3 145	Main blade	450	4,4	3,2	80	72	TCG	15°	15°	2/9/130 + 2/14/110 + 4/19/120	LSB45009X	F03FS07811
	HW Scorer	200	4,3-5,5	3,2	80	36	ATB	8°	15°	2/14/110	LI25M43PL3	F03FS02683
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH4	F03FS09627
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH6	F03FS09628
GALAXY 140, ELITE	Main blade	450	4,4	3,2	80	72	TCG	15°	15°	2/9/130 + 2/14/110 + 4/19/120	LSB45009X	F03FS07811
	HW Scorer	200	4,3-5,5	3,2	80	36	ATB	8°	15°	2/14/110	LI25M43PL3	F03FS02683
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH4	F03FS09627
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH6	F03FS09628
GALAXY3	Main blade	460	4,4	3,2	80	72	TCG	15°	15°	2/14/110 + 4/9/100	LSB46003X	F03FS09950
	HW Scorer	200	4,3-5,5	3,2	80	36	ATB	8°	15°	2/14/110	LI25M43PL3	F03FS02683
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH4	F03FS09627
	DP Scorer	200	4,3-5,1	3,2	80	36	FLAT	6°	14°	2/14/110	DLI25M43PLH6	F03FS09628
TÖRK MAKINE												
MP70R	Main blade	320	4,4	3,2	75	72	TCG	15°	15°	3/7/100 + 3/13/95	LSB32002X	F03FS09162
	HW Scorer	160	4,3-5,5	3,2	55	36	ATB	8°	15°	3/6/84 + 3/7/66	LI25M43LG3	F03FS02657
TURANLAR												
T-PE 433	Main blade	300	4,4	3,0	30	60	TCG	15°	15°	2/10/60	LSB30001X	F03FS07802
	Main blade	300	4,4	3,0	30	72	TCG	15°	15°	2/10/60	LSB30005X	F03FS07803
	HW Scorer	150	4,3-5,6	3,2	30	36	ATB	8°	15°	-	LI25M43KC3	F03FS02649
T-PE 434 (before 2020)	Main blade	400	4,4	3,2	80	72	TCG	15°	15°	4/9/100 + 2/9/110 + 2/14/110 + 2/14/125	LSB40012X	F03FS07810
	HW Scorer	200	4,3-5,5	3,2	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M43PI3	F03FS02681
T-PE 434	Main blade	430	4,4	3,2	80	72	TCG	15°	15°	2/9/130 + 2/14/110 + 4/19/120	LSB43009X	F03FS07909
	HW Scorer	200	4,3-5,5	3,2	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M43PI3	F03FS02681
T-PE 435	Main blade	430	4,4	3,2	80	72	TCG	15°	15°	2/9/130 + 2/14/110 + 4/19/120	LSB43009X	F03FS07909
	HW Scorer	200	4,3-5,5	3,2	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M43PI3	F03FS02681
T-PE 436 (before 2020)	Main blade	450	4,8	3,5	80	72	TCG	15°	15°	2/14/125 + 2/9/130 + 4/19/120	LSB45018X	F03FS07812
	HW Scorer	200	4,7-5,9	3,5	65	36	ATB	8°	15°	2/9/100 + 2/9/110	LI25M47PI3	F03FS02720

* Tool type: Main saw blade, Scoring saw blade, Polycrystalline Diamond scorer and Postforming scorer.

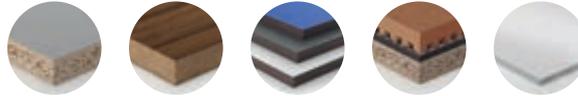


LSB X

Industrial panel sizing saw blades



Horizontal Panel Sizing Machines



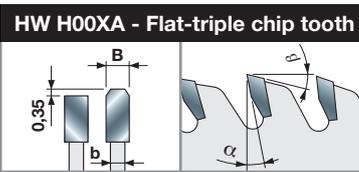
Laminated Chipboard

Laminated MDF

HPL

Thermoplastic Composites

Plexiglas

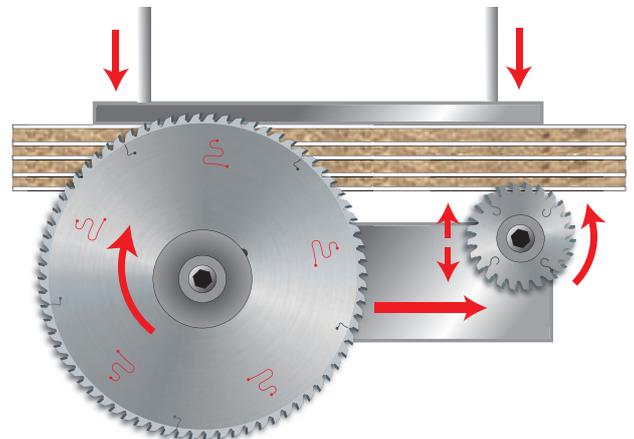


Machines:
Horizontal panel sizing machines.

Materials:
Laminated chipboard, laminated MDF, HPL, thermoplastic composites and plexiglas.

Applications:
Industrial panel sizing.

Technical information:
The LSB X range represents the ideal choice for industrial panel sizing. Saw blades suitable for chipboard and MDF bilaminated panels. Good finishing also in HPL and acrylic panel cutting.



D	B	b	d	Z	α	β	NL	Machines	Freud Code	Art. No.
mm	mm	mm	mm							
250	4,2	3,0	30	60	15°	15°	2/10/60	SCM - Techmatic, Verry	LSB25003X	F03FS10212
250	4,2	3,0	50	60	15°	15°	-	Usikraft	LSB25005X	F03FS10214
250	4,2	3,0	55	60	15°	15°	4/10/70	Baldan, SCM - Techmatic	LSB25002X	F03FS10211
250	4,4	3,0	30	80	15°	15°	2/9/46,4 + 2/10/60		LSB25004X	F03FS10213
270	4,2	3,0	55	60	15°	15°	-	SCM - Techmatic	LSB27001X	F03FS10215
280	4,4	3,2	55	60	15°	15°	2/10/70	Baldan	LSB28001X	F03FS10216
290	4,2	3,0	55	60	15°	15°	-	SCM - Techmatic	LSB29001X	F03FS10217
300	4,4	3,0	30	60	15°	15°	2/10/60	Panhans	LSB30001X	F03FS07802
300	4,4	3,0	65	60	15°	15°	2/9/110	Selco	LSB30002X	F03FS09159
300	4,4	3,0	75	60	15°	15°	-	Homag	LSB30003X	F03FS10218
300	4,4	3,0	80	60	15°	15°	4/9/100 + 2/14/110	SCM	LSB30004X	F03FS09157
300	4,4	3,0	30	72	15°	15°	2/10/60	Panhans, Verry	LSB30005X	F03FS07803
300	4,4	3,2	60	72	15°	15°	2/14/100	Holzma	LSB30012X	F03FS09207
300	4,4	3,0	65	72	15°	15°	2/9/95 + 2/9/110	Selco	LSB30006X	F03FS09158
300	4,4	3,0	75	72	15°	15°	-	Holzma	LSB30007X	F03FS10219
300	4,4	3,0	80	72	15°	15°	4/9/100 + 2/14/110	SCM	LSB30008X	F03FS07804
300	4,4	3,0	75	96	15°	15°	-		LSB30010X	F03FS10220
305	4,4	3,0	30	60	15°	15°	2/10/60	Mayer, Panhans, SCM	LSB30501X	F03FS10221
310	4,4	3,2	60	72	15°	15°	2/14/100	Holzma	LSB31001X	F03FS09949
320	4,4	3,2	30	60	15°	15°	2/10/60		LSB32005X	F03FS09160
320	4,4	3,2	50	60	15°	15°	3/13/95 + 3/15/80	Giben	LSB32004X	F03FS10222
320	4,4	3,2	65	60	15°	15°	2/9/110	Selco	LSB32003X	F03FS09161
320	4,4	3,2	80	60	10°	15°	4/9/100 + 2/9/110 + 2/14/110		LSB32006X	F03FS10101
320	4,4	3,2	60	72	15°	15°	2/14/100		LSB32008X	F03FS10268
320	4,4	3,2	65	72	15°	15°	2/9/95 + 2/9/110	Selco	LSB32001X	F03FS07805
320	4,4	3,2	75	72	15°	15°	3/13/95 + 3/7/100	Giben	LSB32002X	F03FS09162
320	4,4	3,2	80	72	15°	15°	4/9/100 + 2/9/110 + 2/14/110		LSB32007X	F03FS10267
350	4,2	3,2	80	96	15°	15°			LSB35011X	F03FS10225

D	B	b	d	Z	α	β	NL	Machines	Freud Code	Art. No.	
mm	mm	mm	mm		°	°					
350	4,4	3,2	30	54	15°	15°	2/10/60	Panhans, Scheer		LSB35001X	F03FS10223
350	4,4	3,2	60	54	15°	15°	2/14/100	Holzma		LSB35002X	F03FS10224
350	4,4	3,2	30	72	15°	15°	2/10/60	Panhans, Scheer		LSB35003X	F03FS07630
350	4,4	3,2	50	72	15°	15°	4/13/80	Giben		LSB35006X	F03FS07709
350	4,4	3,2	60	72	15°	15°	2/14/100	Holzma		LSB35004X	F03FS07636
350	4,4	3,2	65	72	15°	15°	2/9/110	Selco		LSB35013X	F03FS09659
350	4,4	3,2	75	72	15°	15°	-	Giben, Hansol Machine		LSB35008X	F03FS07634
350	4,4	3,2	80	72	15°	15°	4/9/100 + 2/9/110 + 2/14/110	Gabbiani		LSB35005X	F03FS07635
355	4,4	3,2	75	54	15°	15°	-	Giben		LSB35502X	F03FS10226
355	4,4	3,2	80	54	15°	15°	4/9/100 + 2/9/110 + 2/14/110	Gabbiani		LSB35503X	F03FS09205
355	4,4	3,2	30	72	15°	15°	2/10/60	Panhans, SCM		LSB35504X	F03FS07674
355	4,4	3,2	65	72	15°	15°	2/9/95 + 2/9/110	Selco		LSB35508X	F03FS08740
355	4,4	3,2	75	72	15°	15°	4/15/105 + 2/7/110	Giben, KDT, Hold		LSB35505X	F03FS07633
355	4,4	3,2	75	72	15°	15°	3/7/100	Gabbiani		LSB35507X	F03FS07710
355	4,4	3,2	80	72	15°	15°	4/9/100 + 2/9/110 + 2/14/110	Gabbiani		LSB35506X	F03FS09163
360	4,4	3,2	65	60	15°	15°	2/9/110	Selco		LSB36001X	F03FS10227
360	4,4	3,2	30	72	15°	15°	2/13/94	Schelling		LSB36003X	F03FS09341
360	4,4	3,2	65	72	15°	15°	2/9/95 + 2/9/110	Selco		LSB36002X	F03FS07673
370	4,4	3,2	30	72	15°	15°	2/10/60	Schelling		LSB37001X	F03FS10228
380	4,4	3,2	80	48	15°	15°	4/9/100 + 2/9/110 + 2/14/110	Gabbiani		LSB38009X	F03FS09164
380	4,4	3,2	50	60	15°	15°	4/13/80	Giben		LSB38007X	F03FS10230
380	4,4	3,2	60	60	15°	15°	2/14/100	Holzma		LSB38001X	F03FS07806
380	4,4	3,2	30	72	15°	15°	2/10/60 + 2/8/83			LSB38011X	F03FS10231
380	4,4	3,2	50	72	15°	15°	4/13/80	Giben		LSB38008X	F03FS09165
380	4,4	3,2	60	72	15°	15°	2/14/100	Holzma		LSB38002X	F03FS07631
380	4,4	3,2	65	72	15°	15°	2/9/110	Selco		LSB38014X	F03FS09166
380	4,4	3,2	75	72	15°	15°	2/14/100	Holzma wp, Wonpoong		LSB38012X	F03FS07672
380	4,4	3,2	80	72	15°	15°	4/9/100 + 2/9/110 + 2/14/110	Gabbiani		LSB38010X	F03FS07808
380	4,4	3,2	60	84	15°	15°	2/14/100	Holzma		LSB38015X	F03FS08989
380	4,4	3,2	80	96	15°	15°	4/9/100 + 2/9/110 + 2/14/110	Gabbiani		LSB38013X	F03FS07809
380	4,8	3,5	60	60	15°	15°	2/14/100	Holzma		LSB38003X	F03FS10229
380	4,8	3,5	60	72	15°	15°	2/14/100	Holzma		LSB38004X	F03FS07632
380	4,8	3,5	60	84	15°	15°	2/14/100	Holzma		LSB38005X	F03FS07807
390	4,4	3,2	80	72	15°	15°	2/14/110	Sigma		LSB39001X	F03FS09167
400	4,4	3,2	30	48	15°	15°	2/10/60			LSB40001X	F03FS09168
400	4,4	3,2	80	48	15°	15°	2/9/110 + 4/9/100 + 2/14/110	Gabbiani		LSB40010X	F03FS10233
400	4,4	3,2	30	60	15°	15°	2/10/60			LSB40004X	F03FS09169
400	4,4	3,2	75	60	15°	15°	4/15/105	Giben		LSB40005X	F03FS09170
400	4,4	3,2	80	60	15°	15°	2/9/130 + 4/19/120	Selco		LSB40006X	F03FS10232
400	4,4	3,2	80	60	15°	15°	4/9/100 + 2/9/110 + 2/14/110	Gabbiani		LSB40011X	F03FS09171
400	4,4	3,2	30	72	15°	15°	2/10/60 + 2/13/94	Scheer		LSB40007X	F03FS07725
400	4,4	3,2	50,8	72	10°	15°	2/16/127 + 4/13/80			LSB40018X	F03FS08957
400	4,4	3,2	60	72	15°	15°	2/11/85 + 2/14/100	Anthon		LSB40017X	F03FS09272
400	4,4	3,2	65	72	15°	15°	2/9/110	Selco		LSB40016X	F03FS09172
400	4,4	3,2	75	72	15°	15°	4/15/105 + 2/7/110 + 2/14/100	Giben, Haisung Woodworking Machinery, Hansol Machine, HOMAG, Hyundai Sangi, KDT		LSB40008X	F03FS07726
400	4,4	3,2	80	72	15°	15°	2/15/105 + 2/9/130 + 4/19/120	Selco, MAS		LSB40009X	F03FS07810
400	4,4	3,2	80	72	15°	15°	4/9/100 + 2/9/110 + 2/14/110 + 2/14/125	Gabbiani		LSB40012X	F03FS09173
400	4,4	3,2	60	84	15°	15°	2/14/100	Nanxing		LSB40021X	F03FS09255
400	4,4	3,2	75	84	15°	15°	4/15/105 + 2/7/110	KDT		LSB40019X	F03FS08990
400	4,8	3,5	60	72	15°	15°	2/14/125	Holzma		LSB40013X	F03FS07711
420	4,4	3,2	80	60	15°	15°	4/9/100 + 2/9/110 + 2/14/110	Gabbiani		LSB42004X	F03FS10235
420	4,4	3,2	50	72	15°	15°	4/13/80	Selco		LSB42006X	F03FS09174
420	4,4	3,2	80	72	15°	15°	4/9/100 + 2/9/110 + 2/14/110	Gabbiani		LSB42005X	F03FS09175
420	4,8	3,5	60	60	15°	15°	2/14/125	Holzma		LSB42001X	F03FS10234
420	4,8	3,5	60	84	15°	15°	2/14/100 + 2/14/125	Holzma		LSB42002X	F03FS09176
430	4,4	3,2	30	48	15°	15°	-			LSB43001X	F03FS10236
430	4,4	3,2	75	48	15°	15°	4/15/105	Giben		LSB43002X	F03FS10237
430	4,4	3,2	30	60	15°	15°	2/10/60			LSB43004X	F03FS10238
430	4,4	3,2	75	60	15°	15°	4/15/105	Giben		LSB43005X	F03FS10239
430	4,4	3,2	80	60	15°	15°	2/9/130 + 2/14/110 + 4/19/120	Selco - Gabbiani		LSB43006X	F03FS10240
430	4,4	3,2	30	72	15°	15°	2/13/94			LSB43007X	F03FS09177
430	4,4	3,2	65	72	15°	15°	2/9/110	Selco		LSB43012X	F03FS09178
430	4,4	3,2	75	72	15°	15°	4/15/105 + 2/7/110	Giben		LSB43008X	F03FS07908
430	4,4	3,2	80	72	15°	15°	2/9/130 + 2/14/110 + 4/19/120	Selco, Gabbiani		LSB43009X	F03FS07909

D mm	B mm	b mm	d mm	Z	α	β	NL	Machines	Freud Code	Art. No.	
430	4,4	3,2	75	96	15°	15°	4/15/105 + 2/7/110	Giben Prismatic		LSB43010X	F03FS09179
430	4,8	3,5	70	72	15°	15°	4/11/130	Selco		LSB43013X	F03FS09180
450	4,4	3,2	30	48	15°	15°	2/9/60	Mayer, Panhans, SCM		LSB45001X	F03FS10241
450	4,4	3,2	60	48	15°	15°	2/14/125	Holzma		LSB45002X	F03FS10242
450	4,4	3,2	30	60	15°	15°	2/10/60	Mayer, Panhans, SCM		LSB45004X	F03FS10243
450	4,4	3,2	60	60	15°	15°	2/14/125	Holzma		LSB45005X	F03FS10244
450	4,4	3,2	80	60	15°	15°	2/9/130 + 4/19/120 + 2/14/110	Selco - Gabbiani		LSB45006X	F03FS10245
450	4,4	3,2	30	72	15°	15°	2/10/60 + 2/14/95	Mayer, Panhans, SCM		LSB45007X	F03FS09181
450	4,4	3,2	60	72	15°	15°	2/14/125	Holzma		LSB45008X	F03FS09182
450	4,4	3,2	80	72	15°	15°	2/9/130 + 2/14/110 + 4/19/120	Selco, Gabbiani		LSB45009X	F03FS07811
450	4,8	3,5	30	72	15°	15°	2/9/60	Scheer		LSB45016X	F03FS10246
450	4,8	3,5	60	72	15°	15°	2/14/125 + 2/17/100	Holzma, Nanxing		LSB45017X	F03FS07391
450	4,8	3,5	80	72	15°	15°	2/14/125 + 2/9/130 + 4/19/120	Selco		LSB45018X	F03FS07812
450	4,8	3,5	60	84	15°	15°	2/14/125	Holzma		LSB45019X	F03FS10247
460	4,4	3,2	30	72	15°	15°	2/13/94	Schelling		LSB46001X	F03FS08922
460	4,4	3,2	75	72	15°	15°	2/7/110	Giben		LSB46002X	F03FS07914
460	4,4	3,2	80	72	15°	15°	2/14/110 + 4/9/100	Gabbiani		LSB46003X	F03FS09950
470	4,4	3,2	75	48	15°	15°	4/15/105	Giben		LSB47001X	F03FS10248
470	4,4	3,2	75	60	15°	15°	4/15/105	Giben		LSB47002X	F03FS10249
470	4,4	3,2	75	72	15°	15°	4/15/105	Giben, Hyundai Sangi		LSB47003X	F03FS09183
470	4,4	3,2	75	96	15°	15°	4/15/105	Giben		LSB47004X	F03FS09184
470	4,8	3,5	70	72	15°	15°	4/11/130	Selco		LSB47005X	F03FS09185
480	4,4	3,2	30	72	15°	15°	2/10/60 + 2/13/94	Schelling		LSB48007X	F03FS09914
480	4,8	3,5	80	60	15°	15°	2/9/130 + 4/19/120	Selco		LSB48003X	F03FS09186
480	4,8	3,5	30	72	15°	15°	2/10/60 + 2/13/94	Schelling		LSB48004X	F03FS09187
480	4,8	3,5	60	72	15°	15°	2/19/120			LSB48006X	F03FS10269
480	4,8	3,5	80	72	15°	15°	2/9/130 + 4/19/120	Selco		LSB48001X	F03FS09188
500	4,4	3,2	30	60	15°	15°	2/13/94	Schelling		LSB50003X	F03FS10250
500	4,4	3,2	30	72	15°	15°	2/13/94	Schelling		LSB50005X	F03FS10251
500	4,8	3,5	60	60	15°	15°	2/11/115	Holzma		LSB50009X	F03FS09189
500	4,8	3,5	75	60	15°	15°	4/15/105	Giben		LSB50010X	F03FS09190
500	4,8	3,5	60	72	15°	15°	2/11/115	Holzma		LSB50011X	F03FS09191
510	4,8	3,5	80	72	15°	15°	2/9/130 + 4/19/120	Selco		LSB51001X	F03FS09984
520	4,4	3,2	30	54	15°	15°	2/13/94	Schelling		LSB52005X	F03FS10253
520	4,4	3,2	30	72	15°	15°	2/13/94	Schelling		LSB52008X	F03FS09602
520	4,8	3,5	60	60	15°	15°	2/11/115 + 2/19/120	Holzma		LSB52002X	F03FS10252
520	4,8	3,5	70	60	15°	15°	4/11/130			LSB52009X	F03FS09958
520	4,8	3,5	30	72	15°	15°	2/13/94	Schelling		LSB52007X	F03FS09319
520	4,8	3,5	60	72	15°	15°	2/11/115 + 2/19/120	Holzma		LSB52003X	F03FS09192
520	4,8	3,5	70	72	15°	15°	4/11/130	Selco		LSB52006X	F03FS09193
530	4,8	3,5	75	72	15°	15°	2/7/110	Giben		LSB53004X	F03FS09651
530	5,2	3,5	30	60	15°	15°	-	Schelling		LSB53001X	F03FS09194
530	5,2	3,5	100	60	15°	15°	2/7/140			LSB53003X	F03FS09195
530	5,8	4,0	60	60	15°	15°	1/11/85	Anthon		LSB53002X	F03FS10254
540	4,8	3,5	60	60	15°	15°	2/11/115 + 2/19/120	Holzma Typ 33		LSB54002X	F03FS10255
540	4,8	3,5	60	72	15°	15°	2/11/115 + 2/19/120	Holzma Typ 33		LSB54003X	F03FS10256
550	5	3,5	40	72	15°	15°	2/13/122	Schelling		LSB55007X	F03FS09216
550	5,2	3,5	80	48	15°	15°	2/14/110	Gabbiani		LSB55005X	F03FS10257
550	5,2	3,5	40	72	15°	15°	2/13/122			LSB55009X	F03FS09915
550	5,2	3,5	60	60	15°	15°	-			LSB55002X	F03FS09196
550	5,2	3,5	75	60	15°	15°	4/10,5/140			LSB55010X	F03FS10030
550	5,2	3,5	80	60	15°	15°	2/14/110	Gabbiani		LSB55006X	F03FS09197
550	5,2	3,5	90	60	15°	15°	-	Giben		LSB55008X	F03FS09970
565	5	3,5	100	72	15°	15°	-	Giben		LSB56504X	F03FS09215
565	5,2	3,5	100	60	15°	15°	-	Giben		LSB56502X	F03FS09198
570	4,8	3,5	60	60	15°	15°	2/11/115 + 2/19/120	Holzma		LSB57001X	F03FS09199
600	5,8	4,0	60	60	15°	15°	2/11/115 + 2/19/120	Holzma Typ 33		LSB60001X	F03FS09200
600	5,8	4,0	70	60	15°	15°	4/11/130			LSB60004X	F03FS10258
600	5,8	4,0	75	60	15°	15°	4/6,5/130 + 4/11/130	Selco		LSB60006X	F03FS10259
600	5,8	4,0	60	72	15°	15°	2/11/115 + 2/19/120	Holzma Typ 33		LSB60002X	F03FS09201
670	6,2	4,2	40	60	18°	13°	2/17/140 + 2/13/140	Schelling		LSB67003X	F03FS09202
670	6,2	4,2	40	72	18°	13°	2/17/140 + 2/13/140	Schelling		LSB67004X	F03FS10260
680	6,2	4,2	40	60	18°	13°	2/13/140 + 2/17/140 + 2/13/114	Schelling		LSB68001X	F03FS09203
720	6,4	4,4	40	60	18°	13°	2/14/114 + 2/14/140	Schelling		LSB72001X	F03FS09204



LSC

“Supercut” panel sizing saw blades with variable pitch



Horizontal Panel Sizing Machines



Chipboard



Laminated Chipboard



MDF



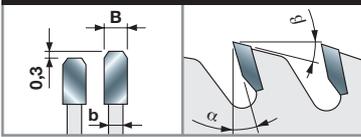
Laminated MDF



●●●● Ultimate ●● High ● Good



HW H00XA - Double triple chip tooth



Machines:

Horizontal panel sizing machines.

Materials:

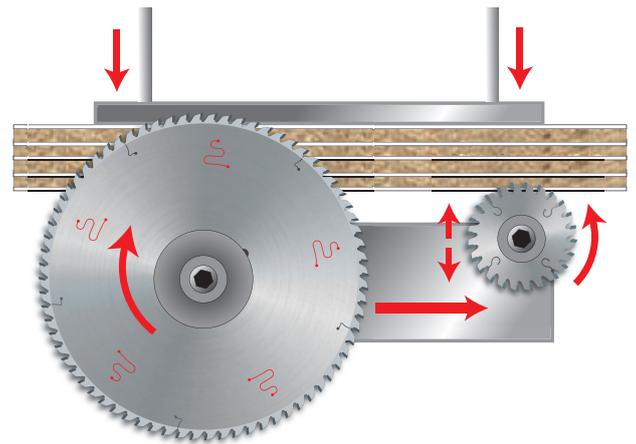
Wood based panels, laminated chipboard, MDF and laminated MDF.

Applications:

Panel sizing.

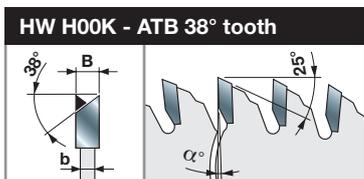
Technical information:

Saw blades suitable for sizing of single panels or small stacks with very good finishing, thanks to the double triple chip tooth grinding.



*Dedicated laser marking.

D mm	B mm	b mm	d mm	Z	α	β	NL	Machines	Freud Code	Art. No.
300	4,4	3,0	30	60	10°	15°	2/10/60	Panhans	LSC30001	F03FS06322
300	4,4	3,0	65	60	10°	15°	2/9/110	Selco	LSC30002	F03FS06325
300	4,4	3,0	75	60	10°	15°	-	Holzma	LSC30003	F03FS06326
300	4,4	3,0	80	60	10°	15°	2/14/110 + 4/9/100	SCM	LSC30004	F03FS06327
320	4,4	3,2	50	60	10°	15°	3/15/80 + 3/13/95	Giben	LSC32004	F03FS06328
320	4,4	3,2	65	60	10°	15°	2/9/110	Selco	LSC32003	F03FS06329
350	4,4	3,2	30	72	15°	15°	2/10/60	Panhans - Scheer	LSC35003	F03FS06305
350	4,4	3,2	50	72	15°	15°	4/13/80	Giben	LSC35006	F03FS06309
350	4,4	3,2	60	72	15°	15°	2/14/100	Holzma	LSC35004	F03FS06310
350	4,4	3,2	80	72	15°	15°	4/9/100 + 2/9/110 + 2/14/110	Gabbiani	LSC35005	F03FS06311
355	4,4	3,2	30	72	15°	15°	2/10/60	Panhans - SCM	LSC35504	F03FS06306
355	4,4	3,2	65	72	15°	15°	2/9/110	Selco	LSC35508BS*	F03FS07869
355	4,4	3,2	75	72	15°	15°	-	Giben	LSC35505	F03FS06307
360	4,4	3,2	65	72	15°	15°	2/9/110	Selco	LSC36002	F03FS06308
370	4,4	3,2	30	72	15°	15°	2/10/60	Schelling	LSC37001	F03FS06312
380	4,4	3,2	50	72	15°	15°	4/13/80	Giben	LSC38008	F03FS06343
380	4,4	3,2	60	72	15°	15°	2/14/100	Holzma	LSC38002	F03FS06313
380	4,4	3,2	80	72	15°	15°	4/9/100 + 2/9/110 + 2/14/110	Gabbiani	LSC38010	F03FS06314
380	4,8	3,5	60	72	15°	15°	2/14/100	Holzma	LSC38004	F03FS06332
400	4,4	3,2	30	72	15°	15°	2/10/60	Scheer	LSC40007	F03FS06315
400	4,4	3,2	65	72	15°	15°	2/9/110	Selco	LSC40016BS*	F03FS07870
400	4,4	3,2	75	72	15°	15°	4/15/105	Giben	LSC40008	F03FS06317
400	4,4	3,2	80	72	15°	15°	4/19/120 + 2/9/130	Selco	LSC40009	F03FS06319
400	4,4	3,2	80	72	15°	15°	4/9/100 + 2/9/110 + 2/14/110	Gabbiani	LSC40012	F03FS06320
430	4,4	3,2	75	72	15°	15°	4/15/105	Giben	LSC43008	F03FS06316
430	4,4	3,2	80	72	15°	15°	2/9/130 + 2/14/110 + 4/19/120	Selco - Gabbiani	LSC43009	F03FS06321
450	4,4	3,2	60	72	15°	15°	2/14/125	Holzma	LSC45008	F03FS06318
450	4,8	3,5	60	72	15°	15°	2/14/125	Holzma	LSC45017	F03FS06323
450	4,8	3,5	80	72	15°	15°	2/9/130 + 4/19/120	Selco	LSC45018	F03FS06324
520	4,8	3,5	30	72	18°	13°	2/13/94	Schelling	LSC52007	F03FS07879



Machines:

Squaring saws and vertical panel sizing machines, hand-held circular saws.

Materials:

Laminated chipboard, laminated MDF and plywood.

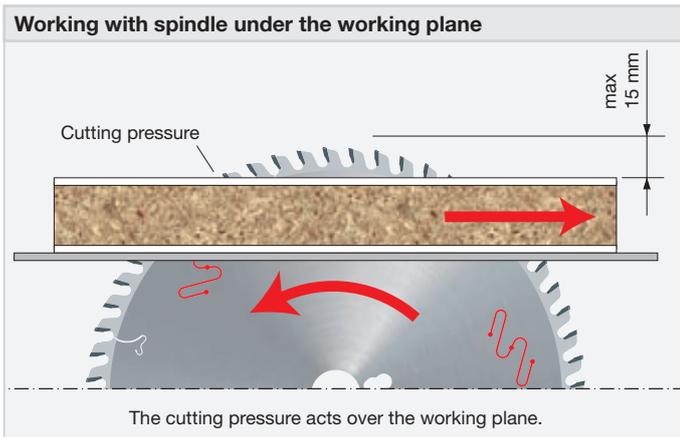
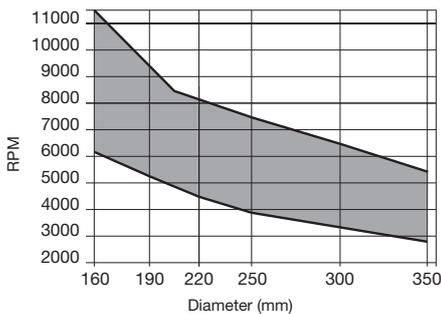
Applications:

Panel sizing.

Technical information:

To size chipboard and MDF bilaminated panels. The ATB 38° tooth geometry grants perfect finishing on both sides.

No scoring saw blades needed.

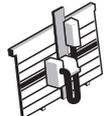


LU3A

Saw blades to cut bilaminated panels



Squaring Saws



Vertical Panel Sizing Machines



Hand-held Circular Saws



Laminated Chipboard



Laminated MDF



Plywood

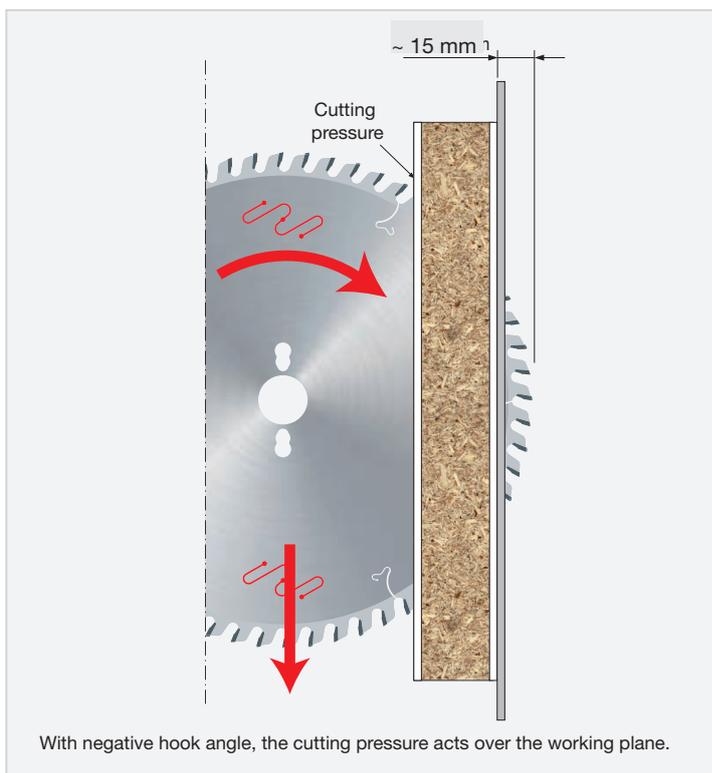
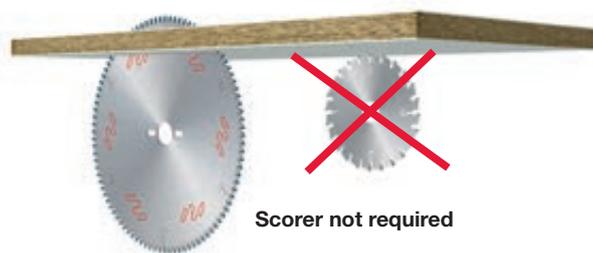


●●● Ultimate ●● High ● Good

D	B	b	d	Z	α	NL	Freud Code	Art. No.
mm	mm	mm	mm		°			
160	2,2	1,6	20	48	-2°	-		LU3A 0001 F03FS07411
190	2,5	1,8	30	48	-2°	-		LU3A 0002 F03FS07412
210	2,5	1,8	30	54	-2°	-		LU3A 0003 F03FS07413

D	B	b	d	Z	α	NL	Freud Code	Art. No.
mm	mm	mm	mm		°			
220	3,2	2,2	30	64	-5°	2/7/42		LU3A 0100 F03FS05059
250	3,2	2,2	30	80	-2°	FT01		LU3A 0200 F03FS05061
300	3,2	2,2	25,4	96	2°	-		LU3A 0600 F03FS05807
300	3,2	2,2	30	96	2°	FT01		LU3A 0300 F03FS05064
350	3,5	2,5	30	108	5°	FT02		LU3A 0400 F03FS05066

FT01: 2/7/42 + 2/9/46,4 + 2/10/60 - FT02: 2/9/46,4 + 2/10/60



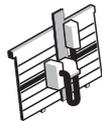


LU3B

Saw blades to cut bilaminated panels



Squaring Saws



Vertical Panel Sizing Machines



Plywood



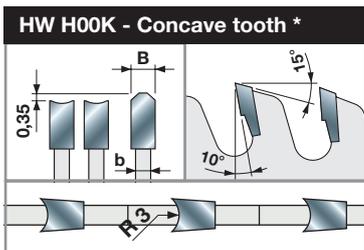
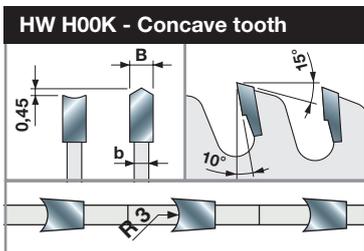
Laminated Chipboard



Laminated MDF



●●● Ultimate ●● High ● Good



D	B	b	d	Z	NL	Freud Code	Art. No.
mm	mm	mm	mm				
220	3,2	2,2	30	42	2/7/42	LU3B 0100	F03FS05069
250	3,2	2,2	30	48	FT01	LU3B 0200	F03FS05071
303	3,2	2,2	30	60	FT01	LU3B 0300	F03FS05073
350	3,2	2,2	30	72	FT01	LU3B 0400	F03FS05075

D	B	b	d	Z	NL	Freud Code	Art. No.
mm	mm	mm	mm				
303	3,2	2,2	30	60	FT01	LU3B 1300 *	F03FS06478

Features: Flat - triple chip tooth with concave face and positive cutting angle.

FT01: 2/7/42 + 2/9/46,4 + 2/10/60

Machines:

Squaring saws and vertical panel sizing machines.

Materials:

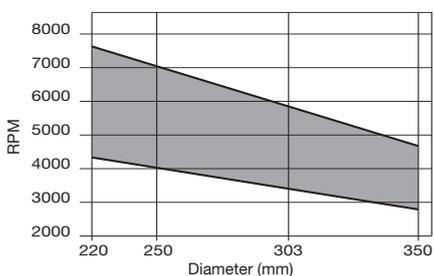
Plywood, laminated chipboard and laminated MDF.

Applications:

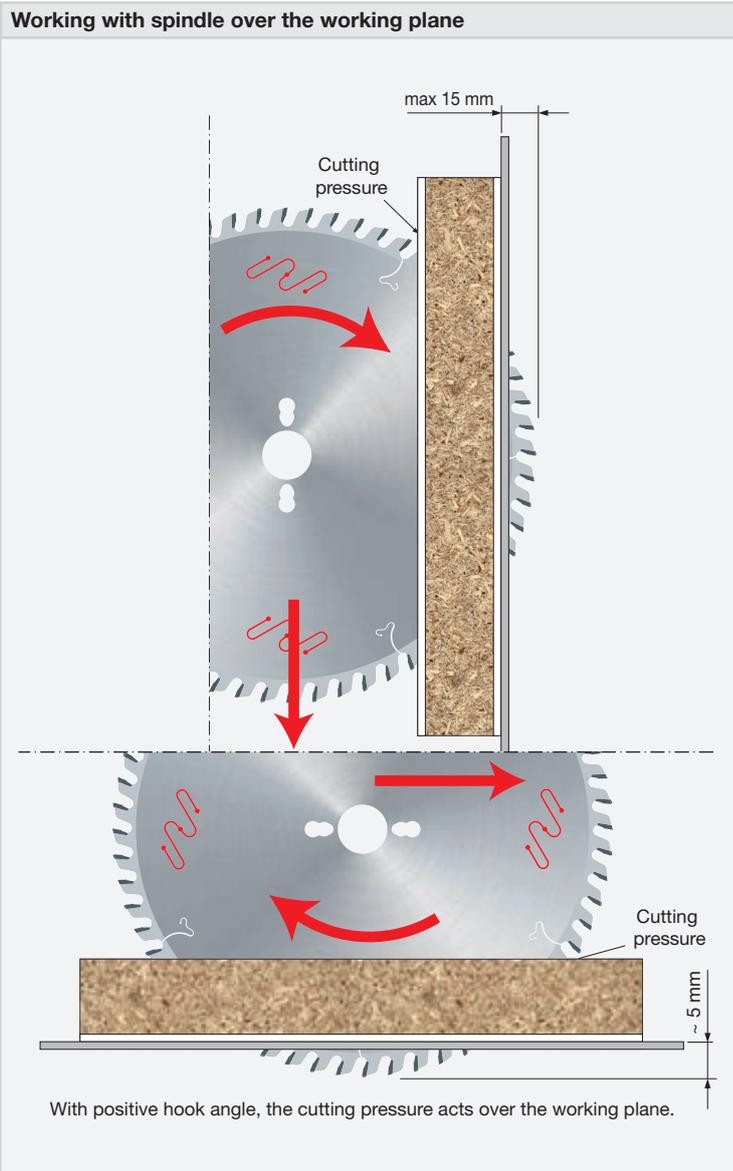
Panel sizing.

Technical information:

To size chipboard and MDF bilaminated panels with good finishing and long cutting life. No scoring saw blades needed.



Minimum and maximum RPM based on the blade diameter.





LU3C

Saw blades to cut bilaminated panels



Squaring Saws



Vertical Panel Sizing Machines



Plywood



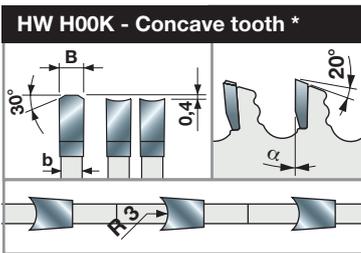
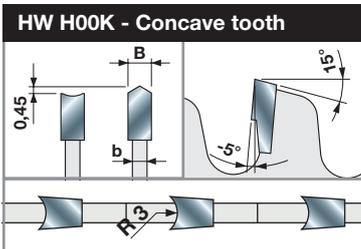
Laminated Chipboard



Laminated MDF



●●● Ultimate ●● High ● Good



Scorer not required

D	B	b	d	Z	NL	Freud Code	Art. No.
mm	mm	mm	mm				
220	3,2	2,2	30	42	2/7/42	LU3C 0100	F03FS05076
250	3,2	2,2	30	48	FT01	LU3C 0200	F03FS05077
303	3,2	2,2	30	60	FT01	LU3C 0300	F03FS05078
350	3,2	2,2	30	72	FT01	LU3C 0400	F03FS05080

D	B	b	d	Z	α	NL	Freud Code	Art. No.
mm	mm	mm	mm					
250	3,4	2,4	30	54	-2°	FT01	LU3C 0204 *	F03FS09537
303	3,4	2,4	30	66	0°	FT01	LU3C 0302 *	F03FS09038

FT01: 2/7/42 + 2/9/46,4 + 2/10/60

Machines:

Squaring saws and vertical panel sizing machines.

Materials:

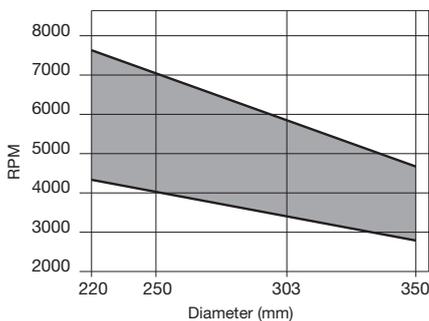
Plywood, laminated chipboard and laminated MDF.

Applications:

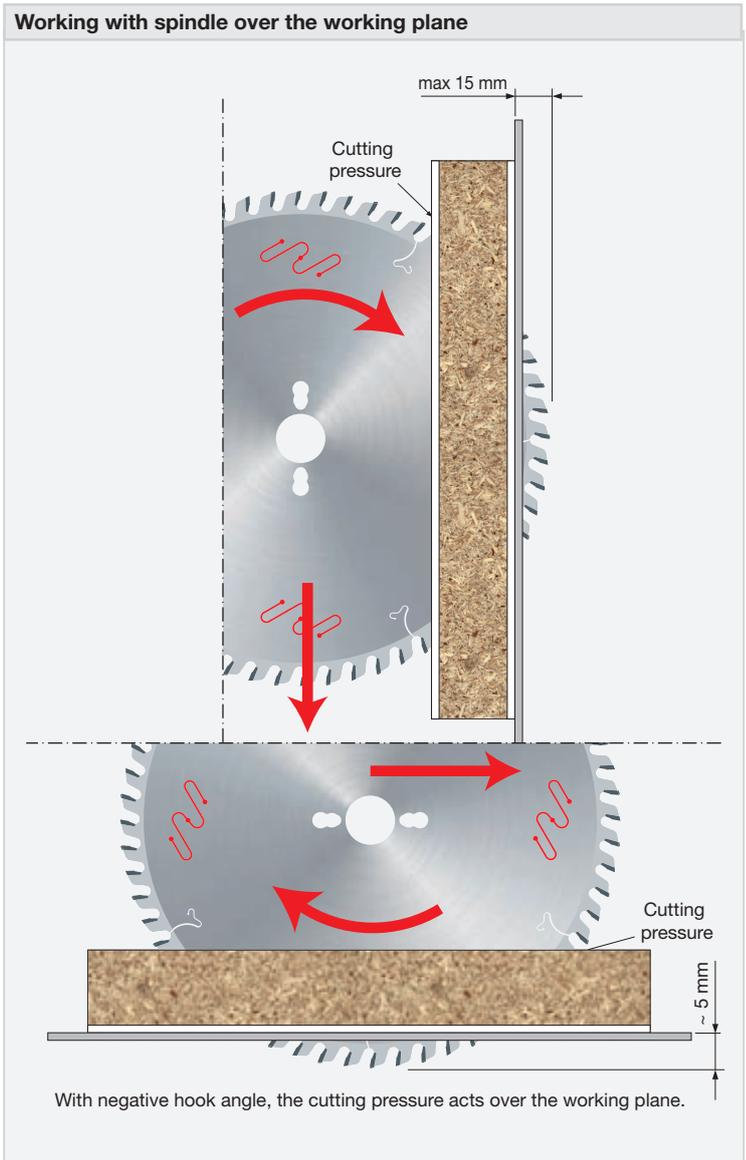
Panel sizing.

Technical information:

Recommended for vertical panel sizing machines. To size chipboard and MDF bilaminated panels with good finishing and long cutting life. No scoring saw blades needed.



Minimum and maximum RPM based on the blade diameter.





LU3D

Saw blades to cut bilaminated panels



Squaring Saws



Chipboard



Laminated Chipboard



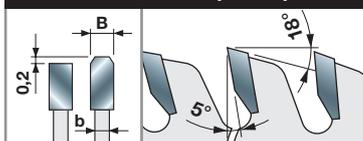
MDF



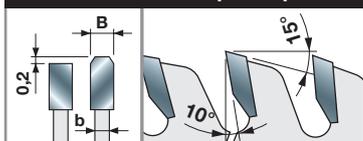
Laminated MDF



HW H00XA - Flat-triple chip tooth



HW H00XA - Flat-triple chip tooth



Machines:

Squaring saws.

Materials:

Wood based panels, laminated chipboard, MDF and laminated MDF.

Applications:

Panel sizing.

Technical information:

To size chipboard and MDF bilaminated panels with the use of the scoring saw blade, in detail melamine-coated panels, with good finishing and long cutting life.

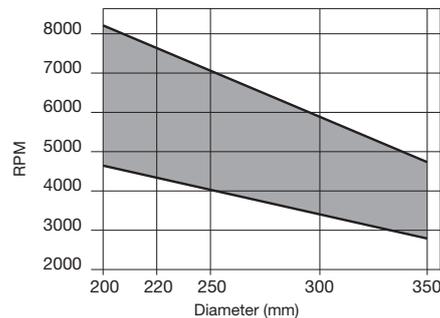
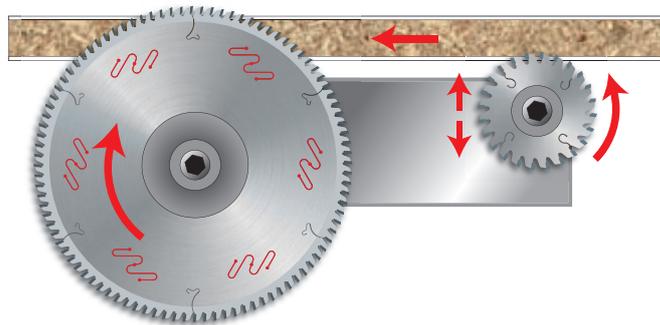
Hook angle 5° for cutting heights up to 30 mm

D	B	b	d	Z	α	NL	Freud Code	Art. No.
mm	mm	mm	mm					
200	3,2	2,2	30	64	5°	2/7/42	LU3D 0100	F03FS05081
220	3,2	2,2	30	64	5°	-	LU3D 0200	F03FS05083
250	3,2	2,2	30	80	5°	FT01	LU3D 0400	F03FS05088
250	3,2	2,2	55	80	5°	-	LU3D 0455	F03FS09973
300	3,2	2,2	30	96	5°	FT01	LU3D 0600	F03FS05093
300	3,2	2,2	35	96	5°	-	LU3D 0700	F03FS05096
350	3,5	2,5	30	108	5°	FT02	LU3D 0900	F03FS05098

Hook angle 10° for cutting heights up to 40 mm

D	B	b	d	Z	α	NL	Freud Code	Art. No.
mm	mm	mm	mm					
250	3,2	2,2	30	60	10°	FT01	LU3D 1100	F03FS05100
250	3,2	2,2	60	60	10°	2/11/85	LU3D 1160	F03FS09974
300	3,2	2,2	30	72	10°	FT01	LU3D 2100	F03FS05810
300	3,2	2,2	30	84	10°	FT01	LU3D 1300	F03FS05101
300	3,2	2,2	30	96	10°	FT01	LU3D 1500	F03FS05104
350	3,5	2,5	30	72	10°	FT02	LU3D 2000	F03FS05108
350	3,5	2,5	30	108	10°	FT02	LU3D 1700	F03FS05105

FT01: 2/7/42 + 2/9/46,4 + 2/10/60 - FT02: 2/9/46,4 + 2/10/60



Minimum and maximum RPM based on the blade diameter.



LU3E

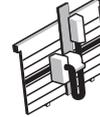
Saw blades to cut bilaminated panels



Squaring Saws



Horizontal Panel Sizing Machines



Vertical Panel Sizing Machines



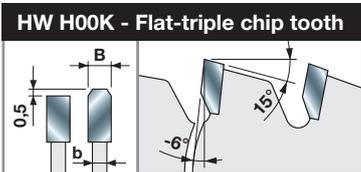
Laminated Chipboard



Laminated MDF



●●● Ultimate ●● High ● Good



Machines:

Squaring saws, horizontal and vertical panel sizing machines.

Materials:

Laminated chipboard and laminated MDF.

Applications:

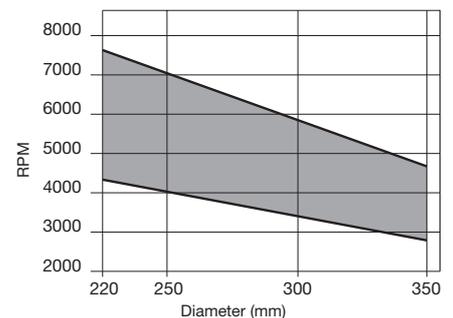
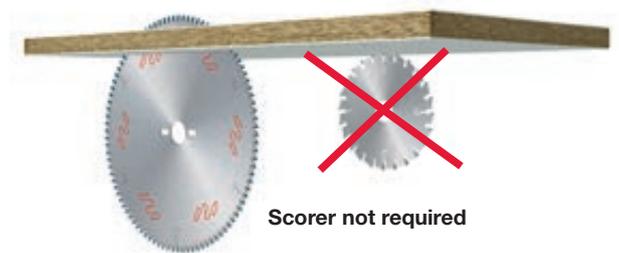
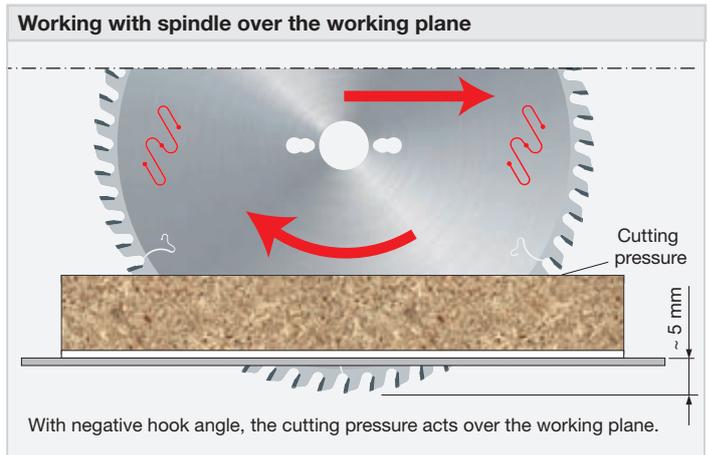
Panel sizing.

Technical information:

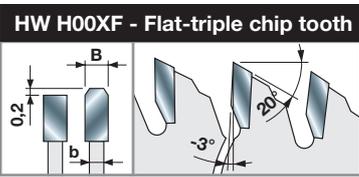
To size chipboard and MDF bilaminated panels with thickness up to 40 mm. In detail, it is suitable to work melamine-coated panels. No scoring saw blades needed.

D	B	b	d	Z	NL	Freud Code	Art. No.
mm	mm	mm	mm				
220	3,2	2,2	30	56	2/7/42	LU3E 0100	F03FS05109
250	3,2	2,2	30	60	FT01	LU3E 0200	F03FS05111
300	3,2	2,2	30	72	FT01	LU3E 0300	F03FS05113
350	3,5	2,5	30	84	FT02	LU3E 0400	F03FS05115

FT01: 2/7/42 + 2/9/46,4 + 2/10/60 - FT02: 2/9/46,4 + 2/10/60



Minimum and maximum RPM based on the blade diameter.



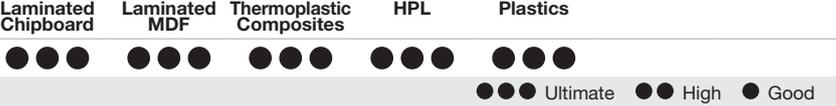
Machines:
Squaring saws, horizontal and vertical panel sizing machines.

Materials:
Laminated chipboard, laminated MDF, thermoplastic composites, HPL and plastics.

Applications:
Panel sizing.

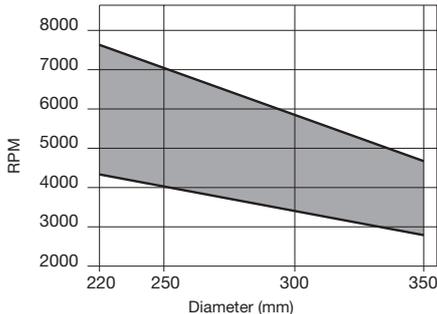
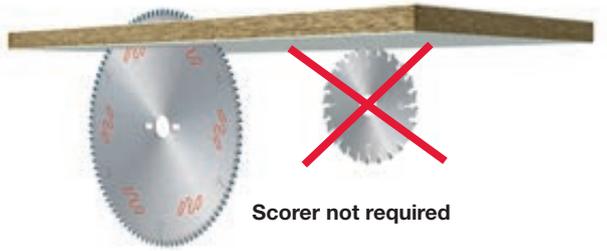
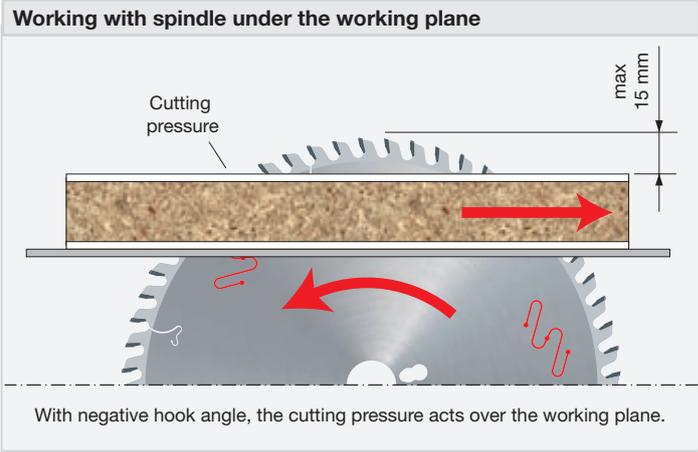
Technical information:
Suitable to work melamine-coated chipboard and MDF panels and plastic materials.
No scoring saw blades needed.
The H00XF Carbide grants extremely long blade lifetime.

LU3F Saw blades to cut bilaminated panels and plastic materials



D mm	B mm	b mm	d mm	Z	NL	Freud Code	Art. No.
220	3,2	2,2	30	64	2/7/42	LU3F 0100	F03FS05117
250	3,2	2,2	30	80	FT01	LU3F 0200	F03FS05119
300	3,2	2,2	30	96	FT01	LU3F 0300	F03FS05121
350	3,5	2,5	30	108	FT02	LU3F 0400	F03FS05124

FT01: 2/7/42 + 2/9/46,4 + 2/10/60 - FT02: 2/9/46,4 + 2/10/60



Minimum and maximum RPM based on the blade diameter.



LG3D

Saw blades to cut bilaminated panels



Squaring Saws



Chipboard



Laminated Chipboard



MDF



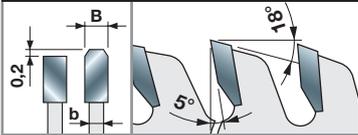
Laminated MDF



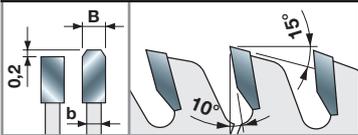
●●●● Ultimate ●● High ● Good



HW H00XA - Flat-triple chip tooth



HW H00XA - Flat-triple chip tooth



Machines:
Squaring saws.

Materials:
Wood based panels, laminated chipboard, MDF and laminated MDF.

Applications:
Panel sizing.

Technical information:
To size chipboard and MDF bilaminated panels with the employment of the scoring saw blade, in detail melamine-coated panels, with good finishing and long cutting life.

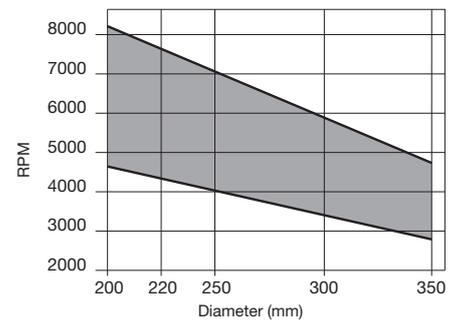
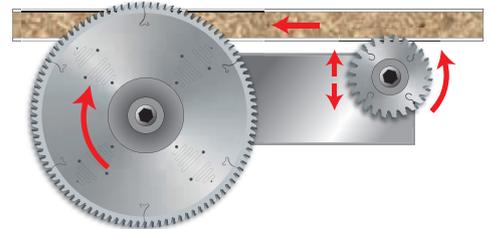
Hook angle 5°

D mm	B mm	b mm	d mm	Z	α	NL	Freud Code	Art. No.
250	3,2	2,2	30	80	5°	FT01	LG3D 0400	F03FS07438
300	3,2	2,2	30	96	5°	FT01	LG3D 0600	F03FS07436
350	3,5	2,5	30	108	5°	FT02	LG3D 0900	F03FS07437

Hook angle 10°

D mm	B mm	b mm	d mm	Z	α	NL	Freud Code	Art. No.
300	3,2	2,2	30	72	10°	FT01	LG3D 2100	F03FS07574
350	3,5	2,5	30	72	10°	FT02	LG3D 2000	F03FS07573

FT01: 2/7/42 + 2/9/46,4 + 2/10/60 - FT02: 2/9/46,4 + 2/10/60

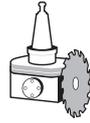


Minimum and maximum RPM based on the blade diameter.



LU34M

Saw blades for grooving and sizing on CNC units



CNC Cutting Units



Softwood



Hardwood



Laminated Chipboard



Laminated MDF



Plywood



Ripping



Crosscutting



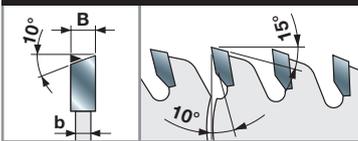
Grooving



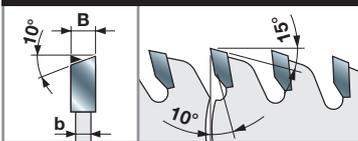
●●● Ultimate ●● High ● Good



HW H00K - ATB 10° tooth



HW H00XA - ATB 10° tooth **



Machines:

CNC cutting units.

Materials:

Softwood, hardwood, laminated chipboard, laminated MDF and plywood.

Applications:

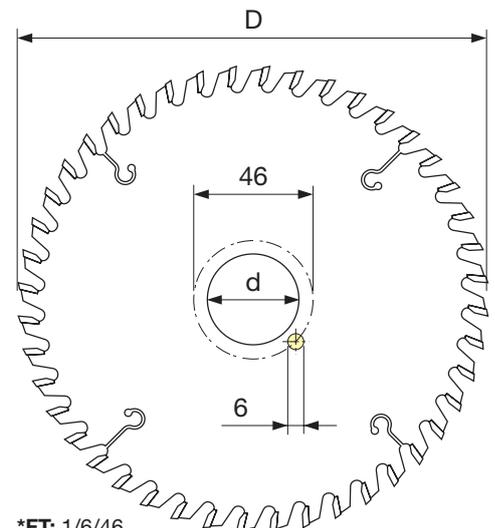
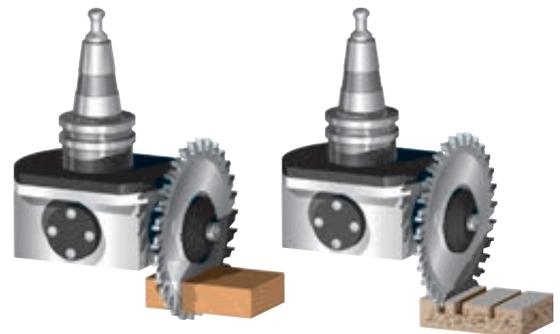
Sizing on CNC, ripping, crosscutting, grooving on CNC.

Technical information:

Saw blades dedicated to CNC machines. For grooving along and across grain on softwood, hardwood and laminates.

D	B	b	d	Z	Max RPM	Freud Code	Art. No.
mm	mm	mm	mm		1/min.		
120	4,0	3,0	30	18	12.000	LU34M40AC3	F03FS06095
120	4,0	3,0	20	30	12.000	LU34M40EA3	F03FS06367
120	4,0	3,0	35	30	12.000	LU34M40EC3*	F03FS05141
120	5,0	3,0	30	18	12.000	LU34M50AC3	F03FS06096
120	5,0	3,0	35	30	12.000	LU34M50EC3*	F03FS05143
120	6,0	3,0	30	18**	12.000	LU34M60AC3	F03FS06097
120	6,0	3,0	35	30**	12.000	LU34M60EC3*	F03FS05145
180	4,0	3,0	35	44	10.000	LU34M40NC3*	F03FS05142
180	5,0	3,0	35	44	10.000	LU34M50NC3*	F03FS05144
180	6,0	3,0	35	44**	10.000	LU34M60NC3*	F03FS05146

Working examples



*FT: 1/6/46



LI25M

Conical scoring saw blades



Horizontal Panel Sizing Machines



Squaring Saws



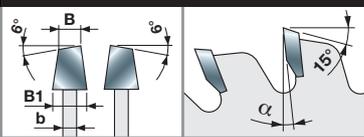
Laminated Chipboard



Laminated MDF



HW H00XA - ATB 6° conical tooth



Machines:

Horizontal panel sizing machines and squaring saws.

Materials:

Laminated chipboard and laminated MDF.

Applications:

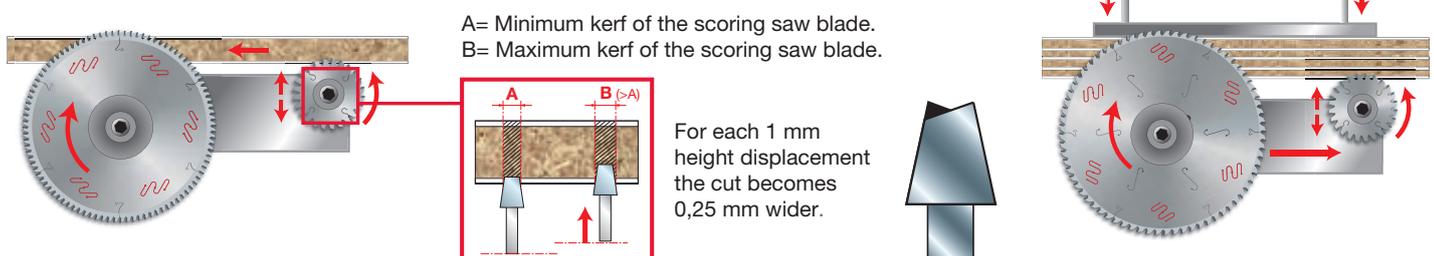
Panel scoring.

Technical information:

To score the coating on bilaminated panels.

D mm	B-B1 mm	b mm	d mm	Z	α	NL	Machines	Freud Code	Art. No.
80	3,1 - 4,3	2,2	20	12	0°	-	Casadei	LI25M31AA3	F03FS02606
80	3,1 - 4,3	2,2	22	12	0°	-		LI25M31AB3	F03FS02608
100	3,1 - 4,3	2,5	20	20	0°	-		LI25M31BC3	F03FS06099
100	3,1 - 4,3	2,2	20	24	0°	-	Schelling	LI25M31BA3	F03FS02610
100	3,1 - 4,3	2,2	22	24	0°	-		LI25M31BB3	F03FS02612
110	3,1 - 4,3	2,2	20	24	0°	-		LI25M31CA3	F03FS02614
110	3,1 - 4,3	2,2	22	24	0°	-		LI25M31CB3	F03FS02615
115	3,1 - 4,3	2,2	20	24	0°	-		LI25M31DA3	F03FS02616
115	3,1 - 4,3	2,2	22	24	0°	-		LI25M31DB3	F03FS02618
115	4,1 - 5,3	3,0	45	24	0°	-	SCM	LI25M41DE3	F03FS08039
120	2,8 - 4,0	2,2	20	24	0°	-	Schelling	LI25M28EA3	F03FS02604
120	2,8 - 4,0	2,2	22	24	0°	-		LI25M28EB3	F03FS02605
120	3,1 - 4,3	2,2	20	24	0°	-		LI25M31EA3	F03FS02620
120	3,1 - 4,3	2,2	22	24	0°	-		LI25M31EB3	F03FS02622
120	3,1 - 4,3	2,5	20	24	0°	-		LI25M31EC3	F03FS05978
120	3,4 - 4,6	2,2	20	24	0°	-	SCM	LI25M34EA3	F03FS02632
125	3,1 - 4,3	2,2	20	24	0°	-	Panhans - Schelling	LI25M31FA3	F03FS02623
125	3,1 - 4,3	2,2	22	24	0°	-	Martin	LI25M31FB3	F03FS02625
125	3,1 - 4,3	2,5	20	24	0°	-	Panhans - Schelling	LI25M31FC3	F03FS05932
125	3,4 - 4,6	2,2	20	24	0°	-		LI25M34FA3	F03FS02634
125	3,4 - 4,6	2,2	45	24	0°	-		LI25M34FE3	F03FS02636
125	4,3 - 5,5	3,2	20	24	0°	-	Panhans - Gabbiani	LI25M43FA3	F03FS02643
125	4,3 - 5,5	3,2	45	24	0°	-	Giben - Homag	LI25M43FE3	F03FS02645
125	4,5 - 5,7	3,0	20	24	0°	-		LI25M45FA3	F03FS02697
125	4,5 - 5,7	3,0	45	24	0°	-	Giben - Homag	LI25M45FE3	F03FS02699
140	3,1 - 4,3	2,2	16	28	8°	1/6/33	Scheer	LI25M31HM3	F03FS02627
140	3,4 - 4,6	3,0	45	24	8°	-		LI25M34HE3	F03FS02638
140	4,3 - 5,5	3,2	45	28	8°	-	Euromac	LI25M43HE3	F03FS02647
140	4,5 - 5,7	3,0	45	24	8°	-		LI25M45HE3	F03FS02701
145	4,3 - 5,5	3,2	45	30	8°	-	Hansol Machine	LI25M43WE3	F03FS08015
150	3,1 - 4,3	2,2	30	36	8°	-	SCM	LI25M31KC3	F03FS02628
150	3,4 - 4,6	2,2	30	36	8°	-	SCM	LI25M34KC3	F03FS02639
150	4,3 - 5,6	3,2	30	36	8°	-	SCM, Verry	LI25M43KC3	F03FS02649
150	4,3 - 5,6	3,2	45	36	8°	-	SCM, Holzma, Homag, Haisung Woodworking Machinery	LI25M43KE3	F03FS02651
150	4,5 - 5,8	3,0	30	36	8°	-	SCM	LI25M45KC3	F03FS02702
150	4,5 - 5,8	3,0	45	36	8°	-	SCM	LI25M45KE3	F03FS02704
160	3,1 - 4,3	2,2	20	36	8°	-	Langzauner	LI25M31LA3	F03FS02630
160	3,4 - 4,6	2,2	25,4	36	8°	-		LI25M34LR3	F03FS02641
160	4,3 - 5,5	3,2	25,4	36	8°	-		LI25M43LR3	F03FS02660
160	4,3 - 5,5	3,2	30	36	8°	-	Langzauner	LI25M43LC3	F03FS02653

D mm	B-B1 mm	b mm	d mm	Z	α	NL	Machines	Freud Code	Art. No.
160	4,3 - 5,5	3,2	45	36	8°	3/11/70	Giben	LI25M43LE3	F03FS02655
160	4,3 - 5,5	3,2	55	36	8°	3/6/84 + 3/7/66	Gabbiani - SCM	LI25M43LG3	F03FS02657
160	4,3 - 5,5	3,2	60	36	8°	3/7/80		LI25M43LH3	F03FS02659
160	4,5 - 5,7	3,0	45	36	8°	3/11/70	Giben	LI25M45LE3	F03FS02706
160	4,5 - 5,7	3,0	55	36	8°	3/7/66 + 3/9/72	Gabbiani	LI25M45LG3	F03FS02708
175	4,3 - 5,5	3,2	75	36	8°	-	Wonpoong	LI25M43WT3	F03FS07816
180	3,1 - 4,3	2,2	16	42	8°	1/6/33	Scheer	LI25M31NM3	F03FS02631
180	3,4 - 4,6	2,2	25,4	36	8°	-		LI25M34NR3	F03FS02642
180	4,3 - 5,5	3,2	20	28	8°	-	Schelling - Anthon	LI25M43NA3	F03FS02661
180	4,3 - 5,5	3,2	30	28	8°	2/7/42 + 2/10/60	Panhans - Holzer	LI25M43NC3	F03FS02663
180	4,3 - 5,5	3,2	20	36	8°	-	Schelling - Anthon	LI25M43XA3	F03FS06372
180	4,3 - 5,5	3,2	30	36	8°	2/7/42 + 2/10/60	Holzher, Nanxing, KDT	LI25M43XN3	F03FS06373
180	4,3 - 5,5	3,2	45	36	8°	-	Holzma	LI25M43NE3	F03FS02664
180	4,3 - 5,5	3,2	50	36	8°	8/13/80	Giben	LI25M43NF3	F03FS02666
180	4,5 - 5,7	3,0	20	36	8°	-	Schelling - Anthon	LI25M45NA3	F03FS02710
180	4,7 - 5,9	3,5	45	36	8°	-	Holzma	LI25M47NE3	F03FS02715
180	5,1 - 6,3	3,5	55	36	8°	3/7/66	Gabbiani	LI25M51NG3	F03FS02724
180	5,7 - 6,9	4,0	20	36	8°	-	Anthon - Holzma	LI25M57NA3	F03FS02727
200	4,3 - 5,5	3,2	20	36	8°	2/10/60 + 2/9/62 + 2/11/66	Schelling	LI25M43PA3	F03FS02670
200	4,3 - 5,5	3,2	22	36	8°	-		LI25M43PB3	F03FS02673
200	4,3 - 5,5	3,2	30	36	8°	2/9/60 + 2/10/60	Scheer	LI25M43PC3	F03FS02674
200	4,3 - 5,5	3,2	45	36	8°	-	Holzma, Hyundai Sangi	LI25M43PE3	F03FS02676
200	4,3 - 5,5	3,2	50	36	8°	2/7/80 + 3/13/80	Giben, KDT	LI25M43PF3	F03FS02679
200	4,3 - 5,5	3,2	65	36	8°	2/9/100 + 2/9/110	Selco	LI25M43PI3	F03FS02681
200	4,3 - 5,5	3,2	75	36	8°	-	Hyundai Sangi	LI25M43PT3	F03FS07755
200	4,3 - 5,5	3,2	80	36	8°	2/14/110	Gabbiani	LI25M43PL3	F03FS02683
200	4,5 - 5,7	3,0	22	36	8°	-		LI25M45PB3	F03FS02712
200	4,5 - 5,7	3,0	65	36	8°	2/9/110	Selco	LI25M45PI3	F03FS02714
200	4,7 - 5,9	3,5	20	36	8°	2/11/66		LI25M47PA3	F03FS02716
200	4,7 - 5,9	3,5	22	36	8°	-		LI25M47PB3	F03FS02717
200	4,7 - 5,9	3,5	30	36	8°	2/9/60	Scheer	LI25M47PC3	F03FS02718
200	4,7 - 5,9	3,5	45	36	8°	-	Holzma	LI25M47PE3	F03FS02719
200	4,7 - 5,9	3,5	65	36	8°	2/9/100 + 2/9/110	Selco	LI25M47PI3	F03FS02720
200	5,4 - 6,6	4,0	20	36	8°	-		LI25M54PA3	F03FS02726
200	5,7 - 6,9	4,0	45	36	8°	-	Holzma	LI25M57PE3	F03FS02728
200	5,7 - 6,9	3,5	65	36	8°	2/9/110		LI25M57PI3BS	F03FS08165
200	6,1 - 7,3	4,0	20	36	8°	2/11/66	Schelling, Scheer	LI25M61PA3	F03FS02730
215	4,3 - 5,5	3,2	50	42	8°	2/7/80 + 3/15/80	Giben	LI25M43QF3	F03FS02685
215	4,5 - 5,7	3,2	50	42	8°	3/15/80	Giben	LI25M45PF3	F03FS02713
220	6,3 - 7,5	4,4	20	36	8°	2/11/66	Schelling	LI25M63UA3	F03FS02732
250	3,1 - 4,3	2,2	30	54	8°	-		LI25M310C3	F03FS07595
250	4,3 - 5,5	3,2	50	48	8°	3/13/80	Giben	LI25M430F3	F03FS02669
250	4,3 - 5,5	3,2	30	48	8°	2/10/60		LI25M430C3	F03FS02668
280	4,3 - 5,5	3,2	30	48	12°	2/10/60	Panhans	LI25M43VC3	F03FS07419
300	4,3 - 5,5	3,0	65	48	12°	2/9/100 + 2/9/110	Selco	LI25M43RX3	F03FS07616
300	4,3 - 5,5	3,2	30	48	12°	2/11/73 + 2/11/75 + 2/13/94	Schelling	LI25M43RC3	F03FS07577
300	4,3 - 5,5	3,5	50	48	12°	3/15/80	Giben	LI25M43RM3	F03FS02693
300	4,3 - 5,5	3,2	65	72	12°	2/9/100 + 2/9/110	Selco	LI25M43RI3	F03FS02689
300	4,3 - 5,5	3,2	80	72	12°	2/14/110		LI25M43RL3	F03FS02691
300	4,7 - 5,9	3,5	65	48	6°	2/9/110	Selco	LI25M47RX3	F03FS07744
320	4,3 - 5,5	3,0	45	48	12°	-		LI25M43SE3	F03FS02696
320	4,3 - 5,5	3,2	45	48	12°	-		LI25M43SA3	F03FS02695
340	4,7 - 5,9	3,5	45	72	12°	3/14/65	Holzma	LI25M47TE3	F03FS02722





DLI25M Polycrystalline Diamond conical scoring saw blades (H4 - H6)



Horizontal Panel Sizing Machines



Squaring Saws



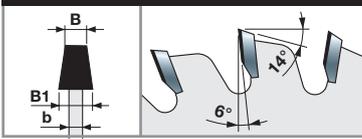
Laminated Chipboard



Laminated MDF



DP - Conical tooth



Machines:

Horizontal panel sizing machines and squaring saws.

Materials:

Laminated chipboard and laminated MDF.

Applications:

Panel scoring.

Technical information:

Extremely longer lifetime thanks to the Polycrystalline Diamond teeth material.

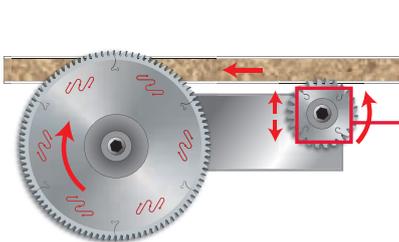
Delivered in dedicated wooden boxes.

Polycrystalline Diamond conical scoring saw blades H4

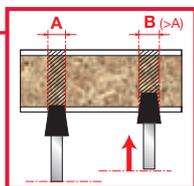
D mm	B-B1 mm	b mm	d mm	Z	NL	Machines	Freud Code	Art. No.
120	2,8 - 3,6	2,2	20	24	-	Schelling	DLI25M28EAH4	F03FS09613
120	2,8 - 3,6	2,2	22	24	-		DLI25M28EBH4	F03FS09615
120	3,1 - 3,9	2,2	20	24	-		DLI25M31EAH4	F03FS09617
125	3,1 - 3,9	2,2	20	24	-	Panhans - Schelling	DLI25M31FAH4	F03FS09619
180	4,3 - 5,1	3,2	45	30	-	Holzma	DLI25M43NEH4	F03FS09621
180	4,7 - 5,5	3,5	45	30	-	Holzma	DLI25M47NEH4	F03FS09623
200	4,3 - 5,1	3,2	65	36	2/9/100 + 2/9/110	Selco	DLI25M43PIH4	F03FS09625
200	4,3 - 5,1	3,2	80	36	2/14/110	Gabbiani	DLI25M43PLH4	F03FS09627
200	4,7 - 5,5	3,5	45	36	-	Holzma	DLI25M47PEH4	F03FS09629
200	4,7 - 5,5	3,5	65	36	2/9/100 + 2/9/110	Selco	DLI25M47PIH4	F03FS09631
215	4,3 - 5,1	3,2	50	42	2/7/80 + 3/15/80	Giben	DLI25M43QFH4	F03FS09633

Polycrystalline Diamond conical scoring saw blades H6

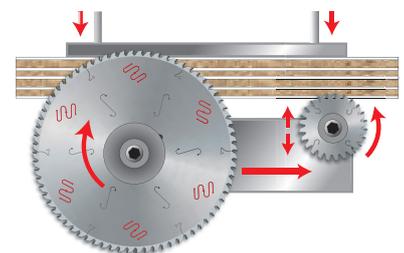
D mm	B-B1 mm	b mm	d mm	Z	NL	Machines	Freud Code	Art. No.
120	2,8 - 3,6	2,2	20	24	-	Schelling	DLI25M28EAH6	F03FS09614
120	2,8 - 3,6	2,2	22	24	-		DLI25M28EBH6	F03FS09616
120	3,1 - 3,9	2,2	20	24	-		DLI25M31EAH6	F03FS09618
125	3,1 - 3,9	2,2	20	24	-	Panhans - Schelling	DLI25M31FAH6	F03FS09620
180	4,3 - 5,1	3,2	45	30	-	Holzma	DLI25M43NEH6	F03FS09622
180	4,7 - 5,5	3,5	45	30	-	Holzma	DLI25M47NEH6	F03FS09624
200	4,3 - 5,1	3,2	65	36	2/9/100 + 2/9/110	Selco	DLI25M43PIH6	F03FS09626
200	4,3 - 5,1	3,2	80	36	2/14/110	Gabbiani	DLI25M43PLH6	F03FS09628
200	4,7 - 5,5	3,5	45	36	-	Holzma	DLI25M47PEH6	F03FS09630
200	4,7 - 5,5	3,5	65	36	2/9/100 + 2/9/110	Selco	DLI25M47PIH6	F03FS09632
215	4,3 - 5,1	3,2	50	42	2/7/80 + 3/15/80	Giben	DLI25M43QFH6	F03FS09634

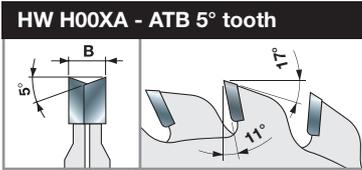


A= Minimum kerf of the scoring saw blade.
B= Maximum kerf of the scoring saw blade.



For each 1 mm height displacement the cut becomes 0,2 mm wider for H4 and 0,15 mm wider for H6.





Machines:
Squaring saws.

Materials:
Laminated chipboard and laminated MDF.

Applications:
Panel scoring.

Technical information:
To score the coating on bilaminated panels.

LI16M

Adjustable scoring saw blades



Squaring Saws



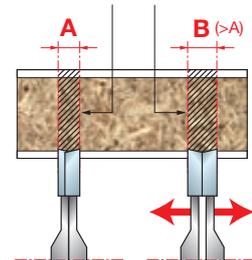
Laminated
Chipboard

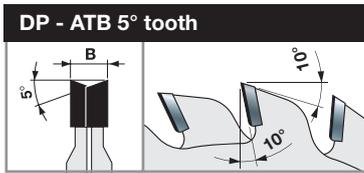
Laminated
MDF

D mm	B mm	d mm	Z	Machines	Freud Code	Art. No.
80	2,8 - 3,6	20	10 + 10	Robland	LI16M HA3	F03FS02502
80	2,8 - 3,6	20	12 + 12	Felder	LI16M GA3	F03FS02501
100	2,8 - 3,6	20	12 + 12	Schelling - Panhans - Martin	LI16M BA3	F03FS02491
100	2,8 - 3,6	22	12 + 12	Altendorf - Striebig - Panhans	LI16M BB3	F03FS02493
100	2,8 - 3,6	25,4	12 + 12	Baldan	LI16M BR3	F03FS07433
105	2,8 - 3,6	20	10 + 10		LI16M CA3	F03FS02495
120	2,8 - 3,6	20	12 + 12	Holzher - SCM	LI16M AA3	F03FS02485
120	2,8 - 3,6	22	12 + 12	Altendorf - Martin - Mrozek	LI16M AB3	F03FS02488
120	2,8 - 3,6	50	12 + 12	Altendorf - Griggio	LI16M PF3*	F03FS02512
120	2,8 - 3,6	50	12 + 12	Felder	LI16M RF3*	F03FS06512
120	4,0 - 5,0	50	12 + 12		LI16M IF3*	F03FS02504
125	2,8 - 3,6	20	12 + 12	Paoloni	LI16M FA3	F03FS02500
125	2,8 - 3,6	20	14 + 14		LI16M EA3	F03FS02498
125	2,8 - 3,6	22	14 + 14		LI16M EB3	F03FS02499
125	4,0 - 4,7	20	20 + 20	SCM	LI16M DA3	F03FS02496
125	4,0 - 5,0	45	12 + 12	Giben - Mayer	LI16M KE3	F03FS02506
200	4,0 - 5,2	50	28 + 28	Giben	LI16M OF3	F03FS02511

* Thickness adjustment controlled by the machines, no spacers required.

A= Minimum kerf of the scoring saw blade.
B= Maximum kerf of the scoring saw blade.





Machines:
Squaring saws.

Materials:
Laminated chipboard and laminated MDF.

Applications:
Panel scoring.

Technical information:
To score the coating on bilaminated panels.
Extremely longer lifetime thanks to the Polycrystalline Diamond teeth material.
Delivered in dedicated wooden boxes.

DLI16M

Polycrystalline Diamond adjustable scoring saw blades (H6)



Squaring Saws

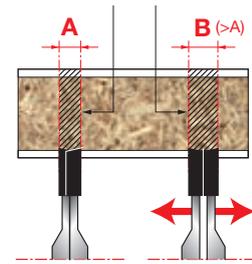


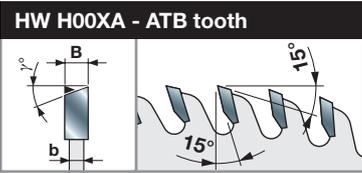
Laminated Chipboard Laminated MDF

DP - Polycrystalline Diamond adjustable scoring saw blades H6

D	B	d	Z	NL	Freud Code	Art. No.
mm	mm	mm	mm			
100	2,8 - 3,6	20	12 + 12	Schelling - Panhans - Martin	DLI16MBAH6	F03FS09635
120	2,8 - 3,6	20	12 + 12	Holzer - SCM	DLI16MAAH6	F03FS09636
120	2,8 - 3,6	22	12 + 12	Altendorf - Martin - Mrozek	DLI16MABH6	F03FS09637

A= Minimum kerf of the scoring saw blade.
B= Maximum kerf of the scoring saw blade.



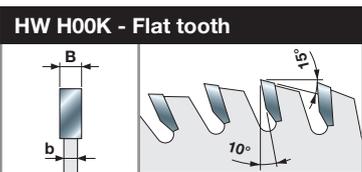


Machines:
Horizontal panel sizing machines.

Materials:
Laminated chipboard and laminated MDF.

Applications:
Panel scoring.

Technical information:
To score the coating on bilaminated panels.



Machines:
Horizontal panel sizing machines.

Materials:
Laminated chipboard and laminated MDF.

Applications:
Panel scoring.

Technical information:
To score bilaminated panels with plastic coating.

LI27M

Postforming scoring saw blades



Horizontal Panel Sizing Machines



Laminated Chipboard



Laminated MDF

D mm	B mm	b mm	d mm	Z	γ	NL	Freud Code	Art. No.
200	4,7	3,5	80	42	10°	2/14/110	LI27M FA3	F03FS02749
220	3,4	2,2	30	48	10°	-	LI27M AA3	F03FS02733
250	4,6	3,0	30	48	10°	-	LI27M BA3	F03FS02734
280	4,65	3,2	80	72	15°	2/14/110	LI27M47VL3	F03FS08014
280	5,0	3,5	45	84	30°	-	LI27M CA3	F03FS02736
300	4,55	3,0	30	72	10°	-	LI27M DF3	F03FS02745
300	4,55	3,2	65	72	10°	2/9/100+2/9/110	LI27M DA3	F03FS02737
300	4,55	3,2	50	72	10°	3/15/80	LI27M DD3	F03FS02743
300	4,7	3,2	80	72	10°	2/14/110	LI27M DC3	F03FS02741
300	4,95	3,0	65	72	10°	2/9/100+2/9/110	LI27M DB3	F03FS02739
340	5,0	3,5	45	48	30°	3/14/65	LI27M EA3	F03FS02746
340	5,0	3,5	45	108	30°	3/14/65	LI27M EB3	F03FS02747

LI20M

Flat tooth scoring saw blades



Horizontal Panel Sizing Machines



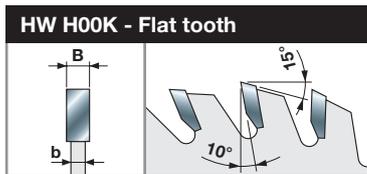
Laminated Chipboard



Laminated MDF

D mm	B mm	b mm	d mm	Z	NL	Freud Code	Art. No.
180	3,2	2,2	50	54	3/22/80	LI20M BB3	F03FS02579



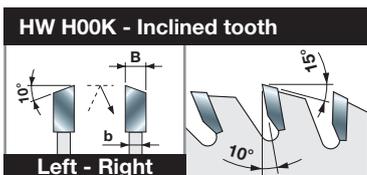


Machines:
SCM horizontal panel sizing machines.

Materials:
Laminated chipboard and laminated MDF.

Applications:
Panel scoring.

Technical information:
To score the coating on bilaminated panels.



Machines:
Horizontal panel sizing machines.

Materials:
Laminated chipboard and laminated MDF.

Applications:
Panel scoring.

Technical information:
To score the coating on bilaminated panels.

LI17M

Flat tooth scoring saw blades



Horizontal Panel Sizing Machines

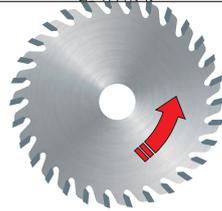


Laminated Chipboard



Laminated MDF

D	B	b	d	Z	NL	Freud Code	Art. No.
mm	mm	mm	mm				
115	3,2	2,2	20	30	-	LI17M FA3	F03FS02572
120	3,2	2,2	20	30	-	LI17M GA3	F03FS02574



LI22MD LI22MS

Inclined tooth scoring saw blades



Horizontal Panel Sizing Machines

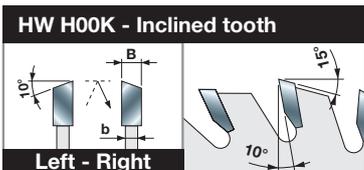


Laminated Chipboard



Laminated MDF

D	B	b	d	Z	NL	Freud Code	Art. No.	Freud Code	Art. No.
mm	mm	mm	mm			Right (D)		Left (S)	
150	3,2	2,2	30	36		LI22MD KC3	F03FS02581	LI22MS KC3	F03FS02592
150	3,2	2,2	55	36		LI22MD KG3	F03FS02583	LI22MS KG3	F03FS02594
150	3,2	2,2	60	36		LI22MD KH3	F03FS02584	LI22MS KH3	F03FS02595
180	3,2	2,2	30	42		LI22MD NC3	F03FS02585	LI22MS NC3	F03FS02596
180	3,2	2,2	55	42		LI22MD NG3	F03FS02586	LI22MS NG3	F03FS02598
200	3,2	2,2	30	48		LI22MD PC3	F03FS02589	LI22MS PC3	F03FS02601
200	3,2	2,2	60	48		LI22MD PH3	F03FS02590	LI22MS PH3	F03FS02602



Machines:

Horizontal panel sizing machines and edge banders.

Materials:

Wood based panels, laminated chipboard and laminated MDF.

Applications:

Panel scoring.

Technical information:

To score the coating on bilaminated panels. Especially dedicated to very fragile coating.

LI13MD LI13MS Inclined tooth scoring saw blades



Horizontal Panel Sizing Machines

Edge Banders



Chipboard



Laminated Chipboard

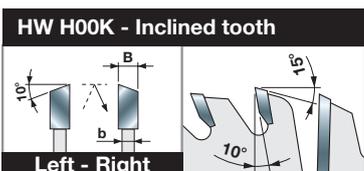


MDF



Laminated MDF

D	B	b	d	Z	NL	Freud Code	Art. No.	Freud Code	Art. No.
mm	mm	mm	mm			Right (D)		Left (S)	
100	3,2	2,2	20	24		LI13MD AA3	F03FS02452	LI13MS AA3	F03FS02466
100	3,2	2,2	22	24		LI13MD AB3	F03FS02454	LI13MS AB3	F03FS02468
125	3,2	2,2	20	30		LI13MD BA3	F03FS02455	LI13MS BA3	F03FS02470
150	3,2	2,2	30	48		LI13MD DA3	F03FS02459	LI13MS DA3	F03FS02474
150	3,2	2,2	55	48		LI13MD DB3	F03FS02461	LI13MS DB3	F03FS02476



LI14MD LI14MS End trim unit for panels with banded edges



Edge Banders



Chipboard



Laminated Chipboard



MDF



Laminated MDF

D	B	b	d	Z	NL	Freud Code	Art. No.	Freud Code	Art. No.
mm	mm	mm	mm			Right (D)		Left (S)	
140	3,2	2,2	30	28 + 4		LI14MD CA3	F03FS02481	LI14MS CA3	F03FS02483

Machines:

Edge banders.

Materials:

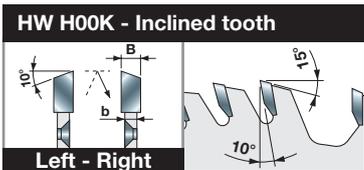
Wood based panels, laminated chipboard and laminated MDF.

Applications:

Panel scoring.

Technical information:

To score the coating on bilaminated panels. Particularly dedicated to very fragile coatings.



Machines:

Double end tenoners.

Materials:

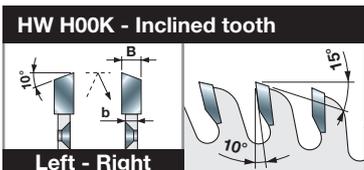
Softwood, hardwood, MDF and plywood.

Applications:

Hogging.

Technical information:

Saw blades suitable for squaring and trimming panels.



Machines:

Squaring edge banding machines and double end tenoners.

Materials:

Chipboard and MDF, laminated chipboard and laminated MDF.

Applications:

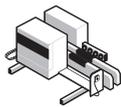
Hogging.

Technical information:

Saw blades suitable for squaring and trimming panels.

**LT16MD
LT16MS**

**Saw blades for
Freud hogging units**



Double End Tenoners



Softwood



Hardwood

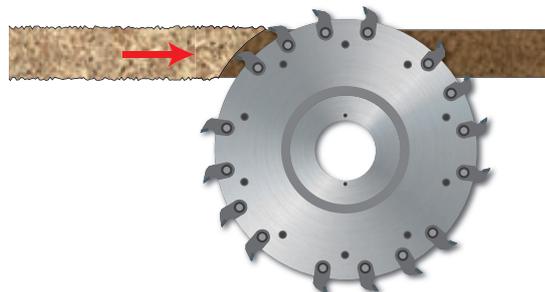


MDF



Plywood

D	B	b	d	Z	NL	Freud Code	Art. No.	Freud Code	Art. No.
mm	mm	mm	mm			Right (D)		Left (S)	
250	4,2	3,0	130	56	10/8,5/170	LT16MD BD3	F03FS04401	LT16MS BD3	F03FS04409
300	4,2	3,0	130	68	10/8,5/215	LT16MD CD3	F03FS04404	LT16MS CD3	F03FS04412

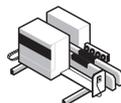


**LT12MD
LT12MS**

Saw blades for hogging units



Edge Banders



Double End Tenoners



Chipboard



MDF

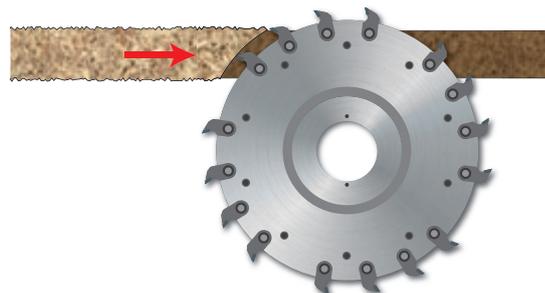


Laminated Chipboard



Laminated MDF

D	B	b	d	Z	NL	Freud Code	Art. No.	Freud Code	Art. No.
mm	mm	mm	mm			Right (D)		Left (S)	
250	4,2	3,0	130	60	4/8,5/185	LT12MD BB3	F03FS04372	LT12MS BB3	F03FS07063



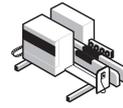


LT14MD LT14MS

Saw blades for hogging units - customised



Edge Banders



Double End
Tenoners



Chipboard



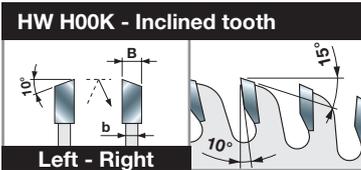
MDF



Laminated
Chipboard



Laminated
MDF



Machines:

Squaring edge banding machines and double end tenoners.

Materials:

Chipboard, MDF, laminated chipboard and laminated MDF.

Applications:

Hogging.

Technical information:

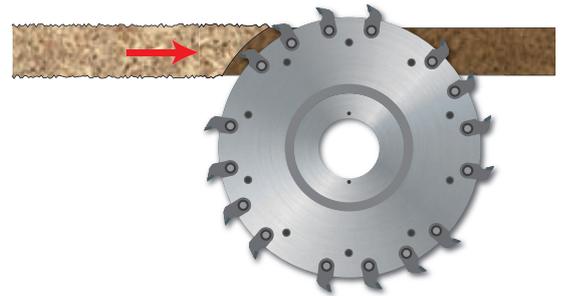
Saw blades suitable for squaring and trimming panels.

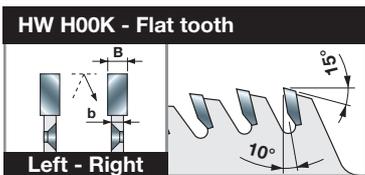
D	B	b	d	Z	NL	Freud Code	Art. No.	Freud Code	Art. No.
mm	mm	mm	mm			Right (D)		Left (S)	
200	4,2	3,0	30	48	*	LT14MD AA3	F03FS04378	LT14MS AA3	F03FS04389
250	4,2	3,0	30	60	*	LT14MD BA3	F03FS04380	LT14MS BA3	F03FS04391
250	4,2	3,0	130	60	*	LT14MD BB3	F03FS04382	LT14MS BB3	F03FS04393
255	4,2	3,0	80	60	*	LT14MD FA3	F03FS04387	LT14MS FA3	F03FS04398
350	4,2	3,0	30	84	*	LT14MD DA3	F03FS04386	LT14MS DA3	F03FS04397

* WHEN ORDERING, ALWAYS SPECIFY:

- OPT08 AA9 - to increase bore \varnothing ;
- OPTFO... - for pin holes (NL* - see page 92).

Send sample saw blade or drawing with bore size. Specify no. of pin holes, diameter of holes (D1) and the diameter of the circumference passing through the centre of the holes (D2).





Machines:

Double end tenoners.

Materials:

Softwood, hardwood, MDF and plywood.

Applications:

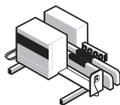
Hogging.

Technical information:

Saw blades suitable for squaring and trimming panels.

**LT18MD
LT18MS**

**Saw blades for
Freud hogging units**



Double End Tenoners



Softwood



Hardwood

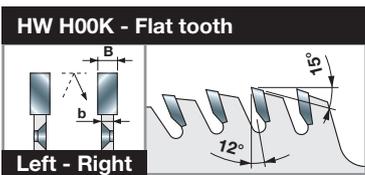


MDF



Plywood

D	B	b	d	Z	NL	Freud Code	Art. No.	Freud Code	Art. No.
mm	mm	mm	mm			Right (D)		Left (S)	
250	4,2	3,0	130	72	10/8,5/170	LT18MD BB3	F03FS04415	LT18MS BB3	F03FS04417



Machines:

Double end tenoners.

Materials:

Softwood, hardwood, MDF and plywood.

Applications:

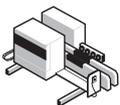
Hogging.

Technical information:

Saw blades suitable for squaring and trimming panels.

**LT20MD
LT20MS**

**Saw blades for Leuco
hogging units**



Double End Tenoners



Softwood



Hardwood

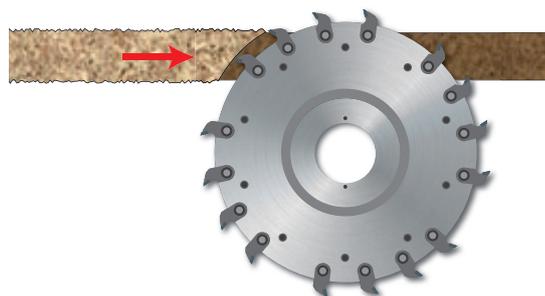


MDF



Plywood

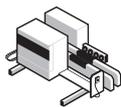
D	B	b	d	Z	NL	Freud Code	Art. No.	Freud Code	Art. No.
mm	mm	mm	mm			Right (D)		Left (S)	
250	4,0	3,0	100	72	6/7/200	LT20MD BB3	F03FS04421	LT20MS BB3	F03FS04422





TR16MD TR16MS

Hogging units with SR06M interchangeable inserts



Double End
Tenoners



Softwood



Hardwood



MDF



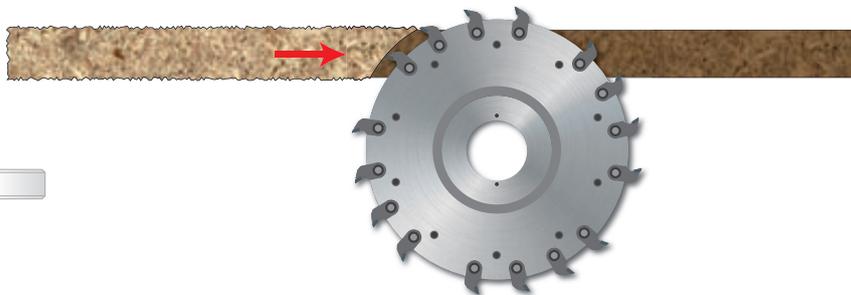
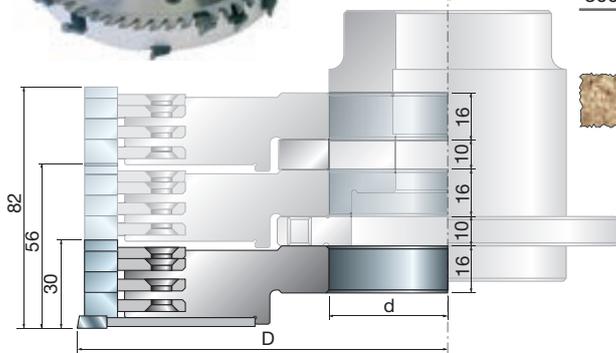
Plywood

* Nominal saw blade diameter.

D*	B	d	Z	Freud Code	Art. No.	Freud Code	Art. No.
mm	mm	mm	mm	Right (D)		Left (S)	
200	30	80	16	TR16MD AA3	F03FC20547	TR16MS AA3	F03FC20550
250	30	60	16	TR16MD BA3	F03FC20548	TR16MS BA3	F03FC20551
250	30	80	16	TR16MD BB3	F03FC22094	TR16MS BB3	F03FC22096
300	30	60	16	TR16MD CA3	F03FC20549	TR16MS CA3	F03FC20552
300	30	80	16	TR16MD CB3	F03FC22095	TR16MS CB3	F03FC22097



TR16MS
TR16MD



These tools can be stacked and used in multiples thus enabling the machining of a wider area.

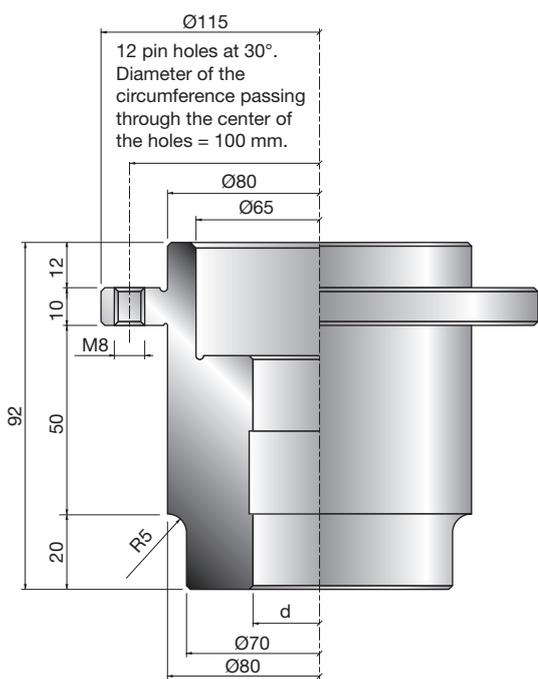
Particularly indicated for squaring solid wood panels.

Spare parts	Dimensions	Freud Code	Art. No.
Grooving inserts	34 x 9 x 16	SR06MDBB301	F03FC24198
Grooving inserts	34 x 9 x 16	SR06MSBB301	F03FC24201
Screw	M6 x 11,5	VT16M AB9	F03FA04477
Screw	M6 x 10	VT01M AA9	F03FA04429
Allen key	4	CB03M BA9	F03FA00163

MT01M

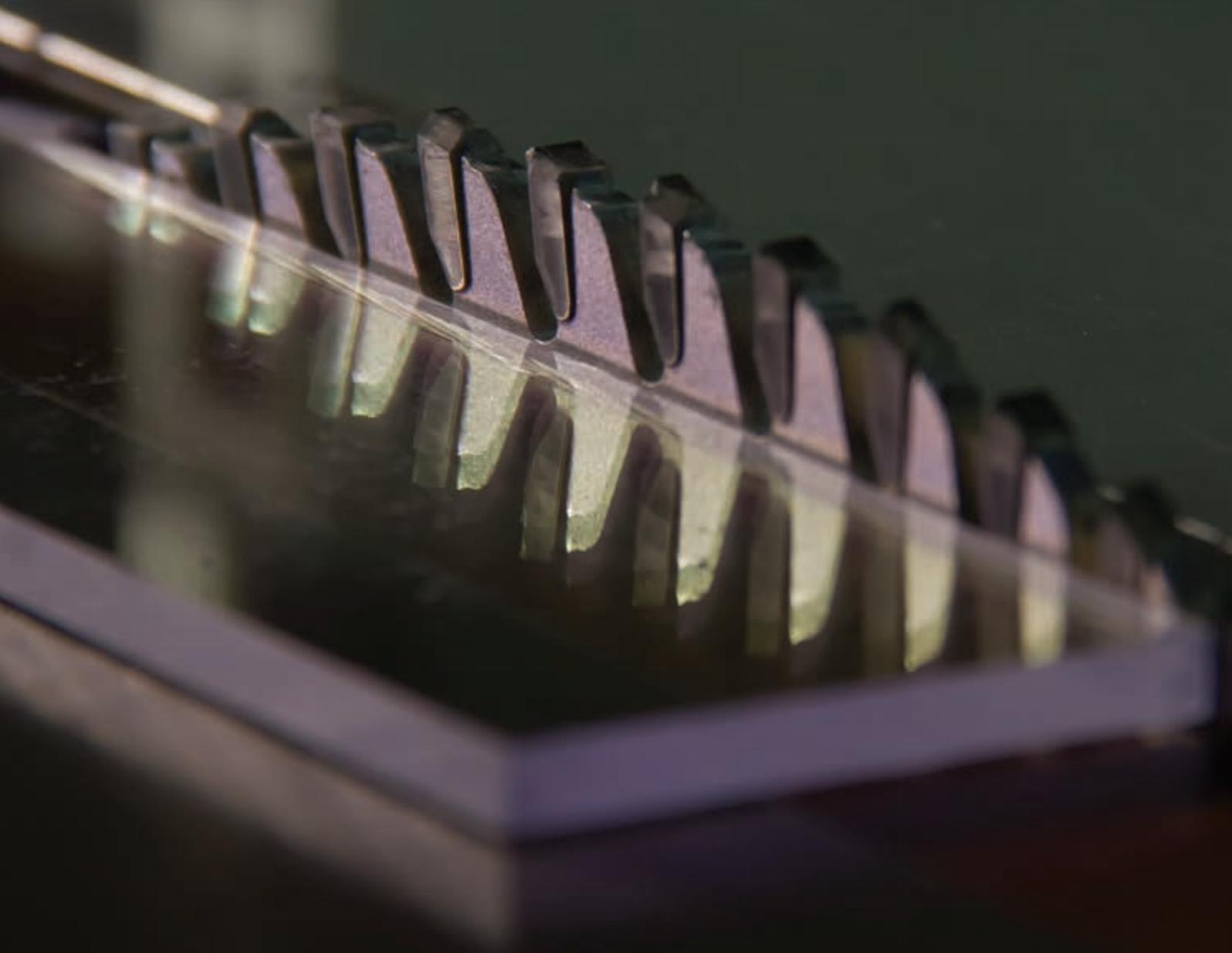
Mounting sleeves for hogging units

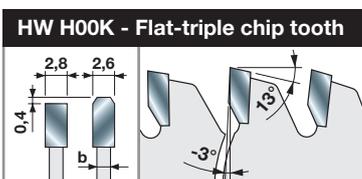
d	KN	Freud Code	Art. No.
mm			
35	10 x 4	MT01M DA9	F03FC15424



Item **MT01M** includes the fixing operation of the mounting sleeve to the hogging unit.

Polymeric Materials





Machines:

Squaring saws and table saws, hand-held circular saws.

Materials:

Plexiglas and plastics.

Applications:

Plexiglas and plastic cutting.

Technical information:

Saw blades with negative cutting angle suitable to cut plastic materials. For a proper use, a blade projection of approximately 30 mm over the workpiece is recommended.

LU4A

Saw blades to cut plastic materials



Squaring Saws



Table Saws



Hand-held Circular Saws



Plexiglas



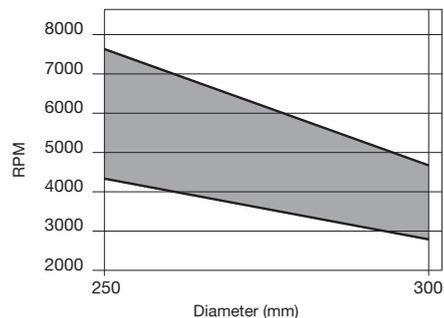
Plastics



●●● Ultimate ●● High ● Good

D	B	b	d	Z	NL	Freud Code	Art. No.
mm	mm	mm	mm				
250	2,8	2,2	30	80	FT01	LU4A 0100	F03FS05163
300	2,8	2,2	30	96	FT01	LU4A 0200	F03FS05165

FT01: 2/7/42 + 2/9/46,4 + 2/10/60



Minimum and maximum RPM based on the blade diameter.



LU4B Thin kerf saw blades to cut plastic materials and plexiglas - axial angle



Squaring Saws



Table Saws



Hand-held Circular Saws



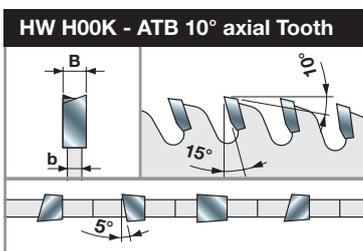
Plexiglas



Plastics



●●● Ultimate ●● High ● Good



Machines:

Squaring saws and table saws, hand-held circular saws.

Materials:

Plexiglas and plastics.

Applications:

Plexiglas and plastic cutting.

Technical information:

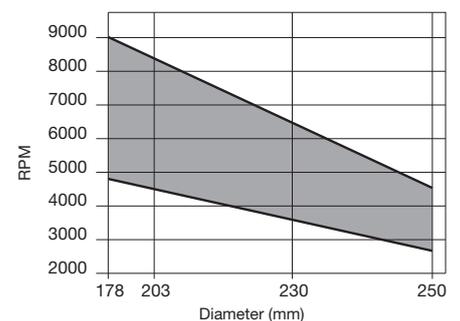
To size plexiglas and plastic panels.

The thin kerf design makes the workpiece feed easy especially when using low-power machines.

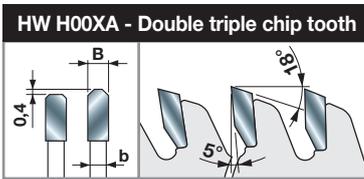
A perfect cutting finishing is granted by the 5° axial angle.

D	B	b	d	Z	NL	Freud Code	Art. No.
mm	mm	mm	mm				
178	1,5	1,0	25,4	80	-	LU4B 0500	F03FS05173
203	2,0	1,4	25,4	90	-	LU4B 0100	F03FS05167
230	2,2	1,6	25,4	100	-	LU4B 0200	F03FS05169
250	2,2	1,6	30	100	FT01	LU4B 0300	F03FS05170
255	2,2	1,6	25,4	100	-	LU4B 0400	F03FS05172

FT01: 2/7/42 + 2/9/46,4 + 2/10/60



Minimum and maximum RPM based on the blade diameter.



Machines:
Squaring saws and table saws, mitre saws.

Materials:
Solid surfaces.

Applications:
Solid surfaces cutting.

Technical information:
The double triple chip grinding ensures flawless finishing, moreover the H00XA Carbide grants a long blade lifetime, thanks to its extraordinary resistance to abrasive materials.

LU4D Saw blades to cut solid surfaces



Squaring Saws



Table Saws



Mitre Saws



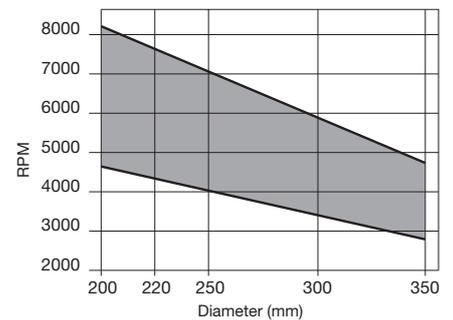
Solid Surfaces



●●● Ultimate ●● High ● Good

D	B	b	d	Z	NL	Freud Code	Art. No.
mm	mm	mm	mm				
250	3,2	2,5	30	80	FT02	LU4D 0100	F03FS07294
300	3,2	2,5	30	96	FT02	LU4D 0200	F03FS07295
350	3,5	2,8	30	108	FT02	LU4D 0300	F03FS07296

FT02: 2/9/46,4 + 2/10/60



Minimum and maximum RPM based on the blade diameter.

Non-ferrous Metals





LU5A

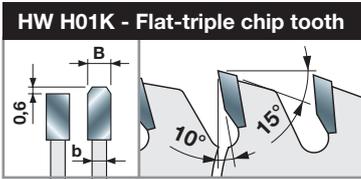
Saw blades to cut non-ferrous metals



Aluminium Copper and Brass



●●● Ultimate ●● High ● Good



Machines:
Double head cutting machines and CNC cutting units.

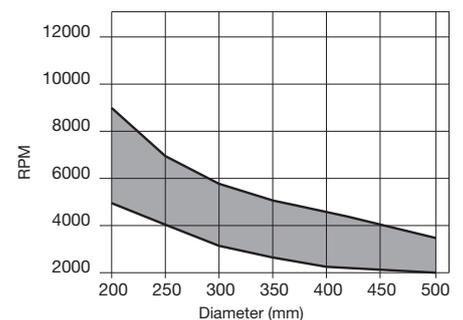
Materials:
Aluminium, copper and brass.

Applications:
Aluminium and non-ferrous metals cutting.

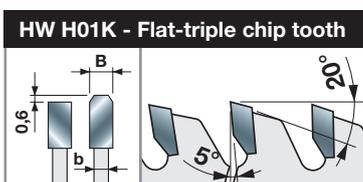
Technical information:
To cut solid drawn products with a thickness between 2 and 10 mm.

D mm	B mm	b mm	d mm	Z	NL	Freud Code	Art. No.
200	2,8	2,2	30	54	-	LU5A 0100	F03FS05181
250	3,5	3,0	30	60	FT02	LU5A 0200	F03FS05182
250	3,5	3,0	32	60	2/11/63	LU5A 0300	F03FS05183
275	3,5	3,0	40	68	2/9/55 + 4/12/64	LU5A 0400	F03FS05185
300	3,5	3,0	30	72	FT02	LU5A 0500	F03FS05186
300	3,5	3,0	32	72	2/11/63	LU5A 0600	F03FS05187
330	3,5	3,0	30	84	FT02	LU5A 0800	F03FS05190
330	3,5	3,0	32	84	2/11/63	LU5A 0900	F03FS05192
350	3,5	3,0	30	84	FT02	LU5A 1000	F03FS05193
350	3,5	3,0	32	84	2/11/63	LU5A 1100	F03FS05194
350	3,5	3,0	40	84	2/9/55 + 4/12/64	LU5A 1200	F03FS05196
370	3,5	3,0	30	90	-	LU5A 1300	F03FS05197
370	3,5	3,0	50	90	4/15/80	LU5A 1400	F03FS05198
380	3,5	3,0	32	96	2/11/63	LU5A 1500	F03FS05199
400	3,5	3,0	30	96	2/11/63	LU5A 1600	F03FS05200
400	3,5	3,0	32	96	2/11/63	LU5A 1700	F03FS05202
400	3,5	3,0	40	96	2/12/64 + 2/15/80	LU5A 1800	F03FS05205
400	3,5	3,0	50	96	4/15/80	LU5A 1900	F03FS05206
420	3,5	3,0	30	96	2/11/70	LU5A 2000	F03FS05207
450	4,0	3,2	30	108	2/11/63	LU5A 2100	F03FS05208
450	4,0	3,2	32	108	2/11/63	LU5A 2200	F03FS05210
450	4,0	3,2	40	108	2/12/64 + 2/15/80	LU5A 2300	F03FS08047
450	4,0	3,2	50	108	4/15/80	LU5A 2400	F03FS07420
500	4,0	3,2	30	120	2/10,5/70	LU5A 2500	F03FS05212
500	4,0	3,2	32	120	2/11/63	LU5A 2600	F03FS05214
500	4,0	3,2	50	120	4/15/80	LU5A 2700	F03FS08244
500	4,4	3,5	30	120	-	LU5A 3000	F03FS07543
530	4,2	3,5	30	126	2/10,5/70	LU5A 2800	F03FS06607
550	4,2	3,5	30	132	2/10,5/70	LU5A 2900	F03FS06608

FT02: 2/9/46,4 + 2/10/60



Minimum and maximum RPM based on the blade diameter.



Machines:

Double head cutting machines and CNC cutting units.

Materials:

Aluminium, copper, brass, plastics and PVC.

Applications:

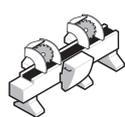
Aluminium, non-ferrous metals and plastic cutting.

Technical information:

To cut drawn products and tubes with a thickness between 2 and 5 mm, as well as polymeric panels up to 20 mm. Suitable for PVC profiles cutting.

LU5B

Saw blades to cut non-ferrous metals and plastics



Double Head Cutting Machines



CNC Cutting Units



Aluminium



Copper and Brass



Plastics



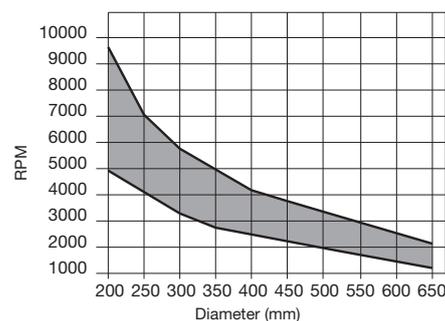
PVC



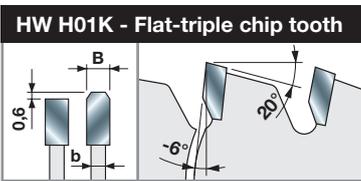
●●● Ultimate ●● High ● Good

D mm	B mm	b mm	d mm	Z	NL	Freud Code	Art. No.
200	2,8	2,2	30	64	-	LU5B 0100	F03FS05217
250	3,5	3,0	30	80	FT02	LU5B 0200	F03FS05218
250	3,5	3,0	32	80	2/11/63	LU5B 0300	F03FS05221
275	3,5	3,0	40	84	2/9/55 + 4/12/64	LU5B 0400	F03FS05223
300	3,5	3,0	30	88	FT02	LU5B 0500	F03FS05224
300	3,5	3,0	32	88	2/11/63	LU5B 0600	F03FS05225
300	3,5	3,0	40	88	2/9/55 + 4/12/64	LU5B 0700	F03FS05227
300	3,5	3,0	30	96	FT02	LU5B 0800	F03FS05228
300	3,5	3,0	32	96	2/11/63	LU5B 0900	F03FS05230
300	3,5	3,0	40	96	2/9/55 + 4/12/64	LU5B 1000	F03FS05232
330	3,5	3,0	30	104	FT02	LU5B 1100	F03FS05233
330	3,5	3,0	32	104	2/11/63	LU5B 1200	F03FS05234
350	3,5	3,0	30	96	FT02	LU5B 1300	F03FS05235
350	3,5	3,0	32	96	2/11/63	LU5B 1400	F03FS05236
350	3,5	3,0	40	96	2/9/55 + 4/12/64	LU5B 1500	F03FS05238
350	3,5	3,0	30	108	FT02	LU5B 1600	F03FS05239
350	3,5	3,0	32	108	2/11/63	LU5B 1700	F03FS05240
350	3,5	3,0	40	108	2/9/55 + 4/12/64	LU5B 1800	F03FS05242
370	3,5	3,0	30	112	-	LU5B 1900	F03FS07745
370	3,5	3,0	50	112	4/15/80	LU5B 2000	F03FS05243
380	3,5	3,0	32	112	2/11/63	LU5B 2100	F03FS05244
400	3,5	3,0	30	120	2/11/63	LU5B 2200	F03FS05245
400	3,5	3,0	32	120	2/11/63	LU5B 2300	F03FS05246
400	3,5	3,0	40	120	2/12/64 + 2/15/80	LU5B 2400	F03FS05248
400	3,5	3,0	50	120	4/15/80	LU5B 2500	F03FS05249
400	3,5	3,0	75	120	2/15/96 + 2/15/114 + 4/18/105	LU5B 2275	F03FS09967
420	3,5	3,0	30	120	2/11/70	LU5B 2600	F03FS05250
450	4,0	3,0	30	128	-	LU5B 2700	F03FS05251
450	4,0	3,0	32	128	2/11/63	LU5B 2800	F03FS05252
500	4,0	3,2	30	140	2/10,5/70	LU5B 3100	F03FS05254
500	4,0	3,2	32	140	2/11/63	LU5B 3200	F03FS05255
550	4,2	3,5	30	148	2/11/63	LU5B 3500	F03FS05257
550	4,2	3,5	32	148	2/11/63	LU5B 3800	F03FS05260
600	4,8	3,8	30	156	-	LU5B 3600	F03FS05258

FT02: 2/9/46,4 + 2/10/60



Minimum and maximum RPM based on the blade diameter.



Machines:

Double head cutting machines, mitre saws.

Materials:

Aluminium, copper and brass.

Applications:

Aluminium and non-ferrous metals cutting.

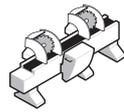
Technical information:

To cut solid drawn products whose thickness exceeds 3 mm.

It is recommended to use it on cutting machines where the saw blade is over the workpiece to be cut.

LU5C

Saw blades to cut non-ferrous metals



Double Head Cutting Machines



Mitre Saws



Aluminium



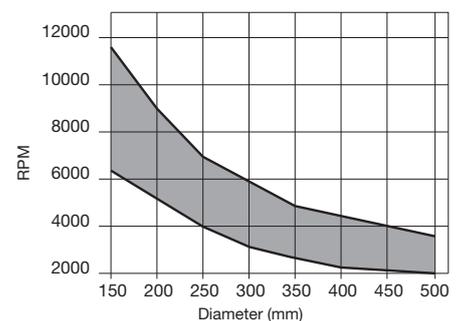
Copper and Brass



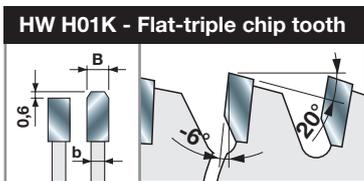
●●● Ultimate ●● High ● Good

D mm	B mm	b mm	d mm	Z	NL	Freud Code	Art. No.
180	2,8	2,2	20	42	-	LU5C 0100	F03FS07195
180	2,8	2,2	30	42	-	LU5C 0200	F03FS05261
200	2,8	2,2	30	48	-	LU5C 0300	F03FS05262
250	3,5	3,0	30	54	-	LU5C 0400	F03FS05263
275	3,5	3,0	40	60	-	LU5C 0600	F03FS05264
300	3,5	3,0	30	72	FT02	LU5C 0700	F03FS05265
300	3,5	3,0	32	72	2/11/63	LU5C 0800	F03FS05266
300	3,5	3,0	40	72	2/9/55 + 4/12/64	LU5C 0900	F03FS05267
330	3,5	3,0	30	80	-	LU5C 1000	F03FS05268
330	3,5	3,0	32	80	2/11/63	LU5C 1100	F03FS05269
350	3,5	3,0	30	84	FT01	LU5C 1200	F03FS05270
350	3,5	3,0	32	84	2/11/63	LU5C 1300	F03FS05271
350	3,5	3,0	40	84	2/9/55 + 4/12/64	LU5C 1400	F03FS05272
370	3,5	3,0	30	90	-	LU5C 1500	F03FS05273
370	3,5	3,0	50	90	4/15/80	LU5C 1600	F03FS05274
380	3,5	3,0	32	96	2/11/63	LU5C 1700	F03FS05275
400	3,5	3,0	30	96	2/11/70	LU5C 1800	F03FS05276
400	3,5	3,0	32	96	2/11/63	LU5C 1900	F03FS05277
400	3,5	3,0	40	96	2/12/64 + 2/15/80	LU5C 2000	F03FS05278
400	3,5	3,0	50	96	4/15/80	LU5C 2100	F03FS05279
420	4,0	3,2	30	96	2/11/70	LU5C 2200	F03FS05280
420	4,0	3,2	40	96	-	LU5C 2300	F03FS05281
450	4,0	3,2	30	108	-	LU5C 2400	F03FS05282
450	4,0	3,2	32	108	2/11/63	LU5C 2500	F03FS05283
450	4,0	3,2	40	108	2/12/64 + 2/15/80	LU5C 2600	F03FS05284
450	4,0	3,2	50	108	4/15/80	LU5C 2700	F03FS05285
500	4,0	3,2	30	120	-	LU5C 2800	F03FS06110
500	4,0	3,2	32	120	2/11/63	LU5C 2900	F03FS05286

FT01: 2/7/42 + 2/9/46,4 + 2/10/60 - FT02: 2/9/46,4 + 2/10/60



Minimum and maximum RPM based on the blade diameter.



Machines:

Double head cutting machines, mitre saws.

Materials:

Aluminium, copper, brass, plastics and PVC.

Applications:

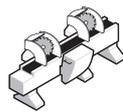
Aluminium, non-ferrous metals and plastics cutting.

Technical information:

To cut drawn products and tubes whose thickness does not exceed 3 mm. It is recommended to use it on cutting machines where the saw blade is over the workpiece to be cut. Suitable for PVC profiles cutting.

LU5D

Saw blades to cut non-ferrous metals and plastics



Double Head Cutting Machines



Mitre Saws



Aluminium



Copper and Brass



Plastics



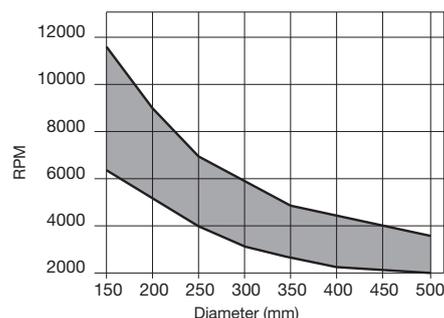
PVC



●●● Ultimate ●● High ● Good

D mm	B mm	b mm	d mm	Z	NL	Freud Code	Art. No.
160	2,8	2,2	20	42	-	LU5D 0100	F03FS05288
190	2,8	2,2	30	54	-	LU5D 0200	F03FS05289
200	2,8	2,2	30	60	-	LU5D 0300	F03FS05290
210	2,8	2,2	30	60	-	LU5D 0400	F03FS05291
216	2,8	2,2	30	60	-	LU5D 0500	F03FS05292
220	3,0	2,5	30	64	FT02	LU5D 0600	F03FS05293
230	3,0	2,5	30	64	-	LU5D 0700	F03FS05294
250	3,5	3,0	30	80	FT02	LU5D 0800	F03FS05295
250	3,5	3,0	32	80	2/11/63	LU5D 0900	F03FS05297
250	3,5	3,0	40	80	2/9/55 + 4/12/64	LU5D 1000	F03FS05299
275	3,5	3,0	40	84	2/9/55 + 4/12/64	LU5D 1100	F03FS05300
300	3,5	3,0	96	96	FT02	LU5D 1200	F03FS05301
300	3,5	3,0	32	96	2/11/63	LU5D 1300	F03FS05303
300	3,5	3,0	40	96	2/9/55 + 4/12/64	LU5D 1400	F03FS05305
330	3,5	3,0	30	104	FT02	LU5D 1500	F03FS05306
330	3,5	3,0	32	104	2/11/63	LU5D 1600	F03FS05308
350	3,5	3,0	30	108	FT02	LU5D 1700	F03FS05309
350	3,5	3,0	32	108	2/11/63	LU5D 1800	F03FS05311
350	3,5	3,0	40	108	2/9/55 + 4/12/64	LU5D 1900	F03FS05313
370	3,5	3,0	30	108	-	LU5D 2000	F03FS05314
380	3,5	3,0	32	108	2/11/63	LU5D 2200	F03FS05315
400	3,5	3,0	30	120	-	LU5D 2300	F03FS05316
400	3,5	3,0	32	120	2/11/63	LU5D 2400	F03FS05317
400	3,5	3,0	40	120	2/15/80 + 2/12/64	LU5D 2500	F03FS05318
400	3,5	3,0	50	120	4/15/80	LU5D 2600	F03FS05319
420	4,0	3,2	30	120	2/11/70	LU5D 2700	F03FS05320
420	4,0	3,2	40	120	-	LU5D 2800	F03FS05321
450	4,0	3,2	30	128	-	LU5D 2900	F03FS05322
500	4,0	3,2	32	140	2/11/63	LU5D 3400	F03FS05323

FT02: 2/9/46,4 + 2/10/60

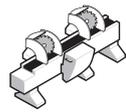


Minimum and maximum RPM based on the blade diameter.



LU5F

Saw blades to cut non-ferrous metals and plastics



Double Head Cutting Machines



CNC Cutting Units



Aluminium



Copper and Brass



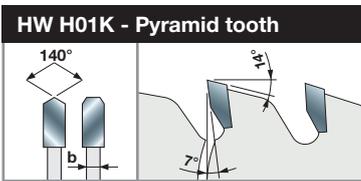
Plastics



PVC



●●● Ultimate ●● High ● Good



Machines:

Double head cutting machines and CNC cutting units.

Materials:

Aluminium, copper, brass, plastics and PVC.

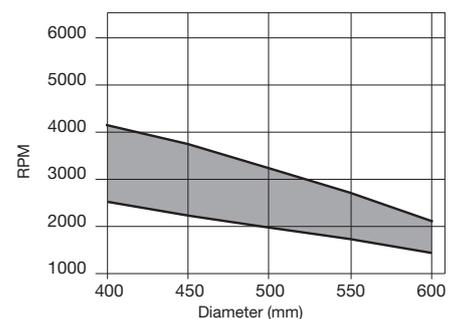
Applications:

Aluminium, non-ferrous metals and plastics cutting.

Technical information:

Saw blades to cut thin wall aluminium profiles up to 4,5 mm for doors and windows, also including built-in plastic profiles.

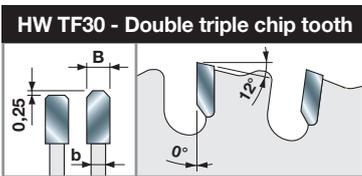
D	B	b	d	Z	NL	Freud Code	Art. No.
mm	mm	mm	mm				
400	3,5	3,0	30	96	2/11/63 + 2/11/70	LU5F40001	F03FS07683
400	3,5	3,0	32	96	2/11/63 + 2/11/70	LU5F40002	F03FS07684
400	3,5	3,0	30	120	2/11/63 + 2/11/70	LU5F40003	F03FS07685
400	3,5	3,0	32	120	2/11/63 + 2/11/70	LU5F40004	F03FS07686
420	3,5	3,0	30	100	2/11/63 + 2/11/70	LU5F42001	F03FS07687
420	3,5	3,0	32	100	2/11/63 + 2/11/70	LU5F42002	F03FS07688
450	3,5	3,0	30	108	2/11/63 + 2/11/70	LU5F45001	F03FS07689
450	3,5	3,0	32	108	2/11/63 + 2/11/70	LU5F45002	F03FS07690
500	4,0	3,5	30	120	2/11/63 + 2/11/70	LU5F50001	F03FS07691
500	4,0	3,5	32	120	2/11/63 + 2/11/70	LU5F50002	F03FS07692
530	4,0	3,5	30	126	2/11/63 + 2/11/70	LU5F53001	F03FS07693
530	4,0	3,5	32	126	2/11/63 + 2/11/70	LU5F53002	F03FS07694
550	4,0	3,5	30	132	2/11/63 + 2/11/70	LU5F55001	F03FS07695
550	4,0	3,5	32	132	2/11/63 + 2/11/70	LU5F55002	F03FS07696
600	4,7	4,0	30	144	2/11/63 + 2/11/70	LU5F60001	F03FS07697
600	4,7	4,0	32	144	2/11/63 + 2/11/70	LU5F60002	F03FS07698
600	4,7	4,0	30	156	2/11/63 + 2/11/70	LU5F60003	F03FS07699
600	4,7	4,0	32	156	2/11/63 + 2/11/70	LU5F60004	F03FS07700



Minimum and maximum RPM based on the blade diameter.

Ferrous Metals





Machines:
Dry cut mitre saws.

Materials:
Steel.

Applications:
Steel dry cutting.

Technical information:
Dry-cut saw blades for steel tubes and profiles.
Suitable also for small-size steel bars.
Ensure the workpiece is properly clamped when cutting.

Saw blade diameter	Maximum RPM
160 mm	3.200
184 mm	3.000
190 mm	2.600
210 mm	2.300
216 mm	2.200
230 mm	2.100
250 mm	1.900
255 mm	1.900
300 mm	1.800
305 mm	1.800
315 mm	1.700
350 mm	1.600
355 mm	1.600
400 mm	1.400

Table of maximum RPM based on the blade diameter, for saw blades to cut ferrous metals.

LU6A

Saw blades to cut ferrous metal



Dry cut
Mitre Saws



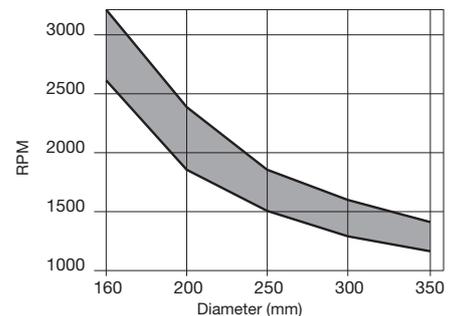
Steel



●●● Ultimate ●● High ● Good

D	B	b	d	Z	NL	Freud Code	Art. No.
mm	mm	mm	mm				
160	2,0	1,6	20	30	-	LU6A 0100	F03FS05343
184	2,0	1,6	15,88	38	-	LU6A 0200	F03FS05344
184	2,0	1,6	15,88	48	-	LU6A 1900	F03FS06586
190	2,0	1,6	30	38	-	LU6A 0300	F03FS05345
210	2,0	1,6	30	40	-	LU6A 0400	F03FS05346
216	2,0	1,6	30	40	-	LU6A 0500	F03FS05347
230	2,0	1,6	30	48	FT01	LU6A 0600	F03FS05348
230	2,4	2,0	25,4	44	-	LU6A 0700	F03FS05349
250	2,4	2,0	30	48	FT01	LU6A 0800	F03FS05350
254	2,4	2,0	25,4	50	-	LU6A 0900	F03FS05351
254	2,4	2,0	25,4	60	-	LU6A 1000	F03FS05352
300	2,6	2,2	30	60	FT01	LU6A 1700	F03FS05359
300	2,6	2,2	30	80	FT01	LU6A 1800	F03FS05360
305	2,6	2,2	25,4	60	-	LU6A 1100	F03FS05353
305	2,6	2,2	25,4	80	-	LU6A 1200	F03FS05354
350	2,6	2,2	30	72	FT01	LU6A 1300	F03FS05355
350	2,6	2,2	30	90	FT01	LU6A 1400	F03FS05356
355	2,6	2,2	25,4	72	-	LU6A 1500	F03FS05357
355	2,6	2,2	25,4	90	-	LU6A 1600	F03FS05358

FT01: 2/7/42 + 2/9/46,4 + 2/10/60



Minimum and maximum RPM based on the blade diameter.

BLA

Standard reduction rings for saw blades

D mm	S mm	d mm	Freud Code	Art. No.
15,88	0,8	10	BLA08158100	F03FA23018
20	1,2	12,7	BL15M20127	F03FC00694
20	1,5	16	BLA15200160V01	F03FS11956
20	1,8	16	BLA18200160V01	F03FS11960
25,4	1,0	19,05	BLA10254190V01	F03FS11954
25,4	1,2	20	BLA12254200V01	F03FS11955
30	1,5	15,88	BLA15300158	F03FA23019
30	1,8	15,88	BLA18300158	F03FA23020
30	1,5	20	BLA15300200V01	F03FS11957
30	1,8	20	BLA18300200	F03FA23021
30	1,5	25	BLA15300250V01	F03FS11958
30	1,8	25	BLA18300250	F03FA23022
30	1,5	25,4	BLA15300254V01	F03FS11959
30	1,8	25,4	BLA18300254V01	F03FS11961
35	1,8	25,4	BLA18350254	F03FA22201
35	1,8	30	BLA18350300	F03FA23023

OPT06

Optional workings Standard keyways

D mm	B mm	Freud Code	Art. No.
10	5	OPT06 AA9	F03FC16213
12	5	OPT06 BA9	F03FC16214
12,5	4	OPT06 CA9	F03FC16215
13	5	OPT06 DA9	F03FC16216
15	5	OPT06 EA9	F03FC16217
17	5	OPT06 FA9	F03FC16218
18	5	OPT06 GA9	F03FC16219
21	5	OPT06 HA9	F03FC16220

OPT07

Optional workings Special keyways

Freud Code	Art. No.
OPT07 AA9	F03FC16221

OPT08

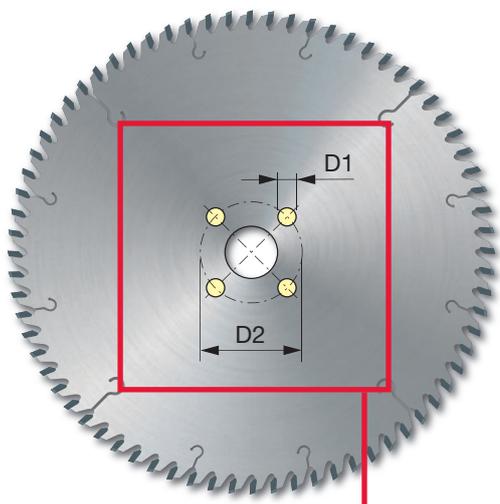
Optional workings Special reboring

Freud Code	Art. No.
OPT08 AA9	F03FC16222

OPTF0

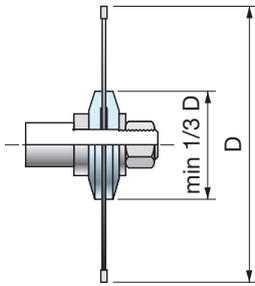
Optional workings Safety pin holes for saw blades

	Freud Code	Art. No.
1	OPTF0 AA9	F03FC16103
2	OPTF0 AB9	F03FC16104
3	OPTF0 AC9	F03FC16105
4	OPTF0 AD9	F03FC16106
5	OPTF0 AE9	F03FC16107
6	OPTF0 AF9	F03FC16108
7	OPTF0 AG9	F03FC16109
8	OPTF0 AM9	F03FC16111
10	OPTF0 AH9	F03FC16110

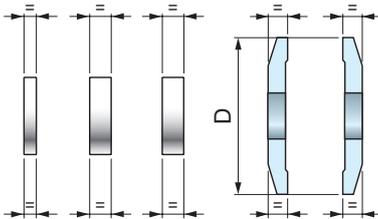


Specify no. of pin holes, diameter of holes (D1) and the diameter of the circumference passing through the centre of the holes (D2).

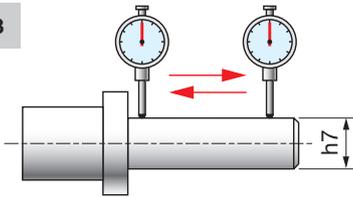
1



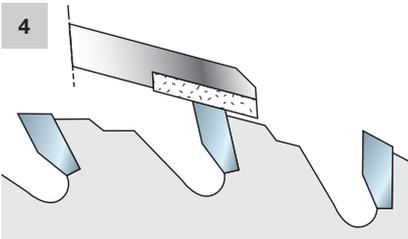
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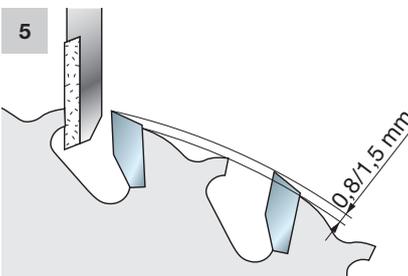
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4



5



TIPS FOR THE CORRECT USE OF A CIRCULAR SAW BLADE

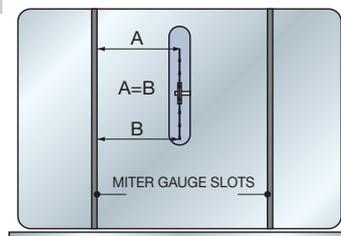
To obtain the best performance from a saw blade we suggest following these simple instructions:

- The machine must be in good condition, free from vibrations.
- The flanges used to secure the blade must be of the same diameter, at least 1/3 of the blade's diameter (Fig. 1).
- The flanges must be parallel to each other. Also check tolerances on diameters, sides and concentricity, by using a clock gauge (Fig. 2).
- The spacers must be perfectly parallel (Fig. 2).
- The spindle must be perfectly straight and with an h7 tolerance (Fig. 3).
- After continuous use, remove the blade and clean it with the appropriate solvents making sure to get rid of built up resin. For the synthetic coated (Perma-SHIELD Coating) blades, it is sufficient to use warm water. In any case, avoid using solvents containing caustic soda.
- The blades must be sharpened as soon as they become dull, maintaining the original tooth angles.
- For sharpening, always use the correct grinding wheels and plenty of cooling liquid.
- Always keep spacers and flanges clean.
- When sharpening, the shoulder of the teeth must not be lowered more than needed. This operation must be done with appropriate precision machinery and never by hand. There is the risk of breaking the tip or upsetting the blade balance (Fig. 4 - 5).
- On ripping machines, the feeding track must be levelled with the fixed table.
- Before starting the cut of the material, make sure the blade is correctly locked according to the machine specifications.

Saw blade alignment on a table saw:

- If the saw blade and the saw are not correctly aligned to the table and the fence, then there is the possibility that a serious accident may occur (for example, violent kickbacks) or that the workpiece may scorch or splinter. The first thing you must do is read the instruction sheet carefully. This is necessary to acquire the understanding and comprehension of the corrections suggested in this section.
- Before carrying out the following instructions, make sure that the starter switch is off and that the machine is not connected to the socket.
- Mounting the saw blade onto the table:
We advise you to use precise measuring instruments when mounting your saw blade. Clean the saw blade well, before mounting it onto the machine. Mount the saw blade onto the arbor. Adjust the arbor to its maximum height. With the aid of the most precise measuring instrument available, verify that the saw blade is parallel to the mitre gauge slots (Fig. 6). Adjust as needed. This step is necessary to obtain crosscuts with the maximum quality finish and for setting up the fence for ripping.
- Positioning the fence for ripping:
After having positioned the saw blade so as it is parallel to the mitre gauge slots, you may proceed with setting the fence. The fence should ideally be parallel to the saw blade. However since it is impossible to position the guide "exactly" it is necessary to leave a slight margin of clearance on the exit side of the cut so as to avoid the wood becoming wedged in between the fence and the saw blade. Adjust the fence so as when it is aligned to the mitre gauge slots, there is a space of 0,1 mm (Fig. 7; for the correct adjustment, consult the machine's instruction manual).

6



7

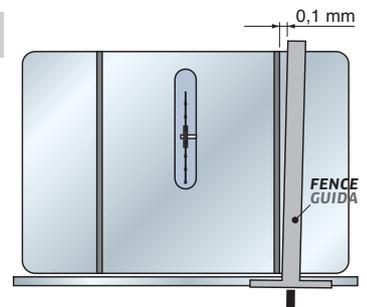


Table 1

Saw blade diameter	Maximum RPM
100 mm	23.000
125 mm	18.000
150 mm	14.500
180 mm	11.500
185 mm	11.000
200 mm	10.000
225 mm	8.500
250 mm	8.000
255 mm	7.800
280 mm	7.100
300 mm	6.500
320 mm	6.000
350 mm	5.500
380 mm	5.000
400 mm	4.700
430 mm	4.400
450 mm	4.200
500 mm	3.750
550 mm	3.400
600 mm	3.100
630 mm	2.950
650 mm	2.800
700 mm	2.600
730 mm	2.500
760 mm	2.400
800 mm	2.250

Not valid for saw blades to cut ferrous metals.

TIPS FOR THE CORRECT USE OF A CIRCULAR SAW BLADE

- The maximum RPM of a circular saw blade varies according to the diameter of the blade itself (table 1). If you exceed this limit, the saw blade will lose its characteristics, therefore influencing the cutting quality and the work life of the blade itself, not to mention the dangers implied to the user who may incur serious injury.
- The saw blade's projection (T) with respect to the workpiece must be at least equal to the height of the blade's tooth (Fig. 8). Increase or decrease the projection of the saw blade to improve the quality of the cutting finish.
- The number of teeth cutting the wood simultaneously (Fig. 9) must be between 3 or 4. With less than three teeth cutting, the saw blade begins to vibrate leading to an uneven cut. If you want to cut workpieces with increased thicknesses (S - Fig. 11), but wish to maintain the same diameter saw blade, then use a blade with less teeth. If instead you want to cut workpieces with a reduced thickness, but also maintain the same diameter saw blade, then use a blade with more teeth.
- To obtain the pitch (P) of a blade (the distance between teeth; Fig. 10 - see formula "A") multiply the thickness of the workpiece by 1,4142 and divide by 3 (if you want 3 teeth cutting) or by 4 (if you want 4 teeth cutting).
- Formula "B": to obtain the number of teeth (Z) of the saw blade, multiply the diameter (D) of the saw blade by 3,14 (π) and divide by the pitch of the saw blade - obtained from the previous formula. The shorter formula "C" allows you to obtain the number of the saw blade's teeth, knowing its diameter and the thickness of the workpiece.

Formula A	Formula B	Formula C
$P = \frac{S \times 1,4142}{3}$	$Z = \frac{D \times 3,14}{P}$	$Z = \frac{D \times 8}{S}$

KEY:

P= Pitch

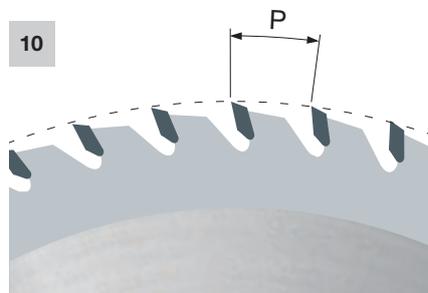
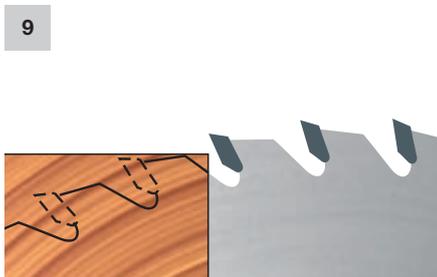
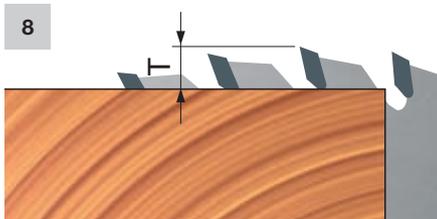
S= Thickness of the workpiece

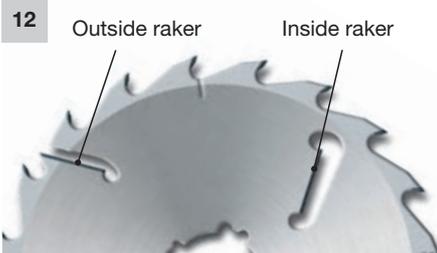
Z= Number of teeth of the saw blade

D= Diameter of the saw blade

Attention:

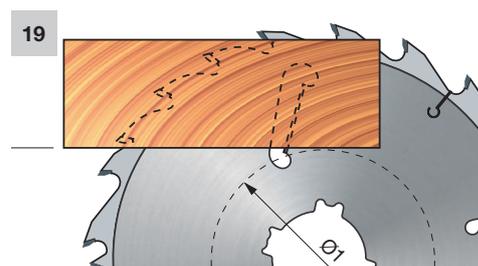
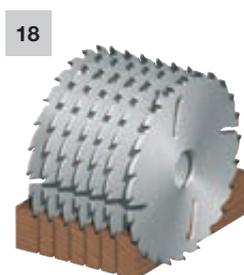
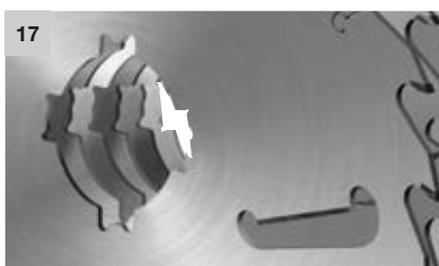
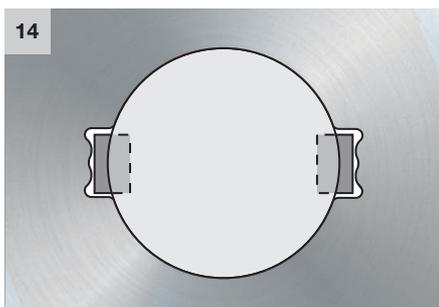
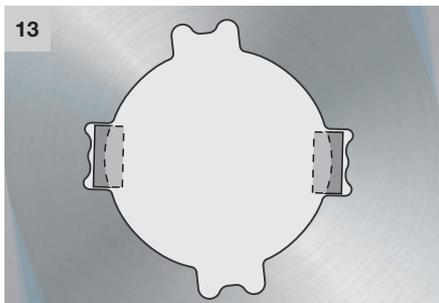
These formulas are valid for crosscutting and cutting other wood composites (MDF, plywood, chipboard and laminated panels) and cannot be applied for ripping.





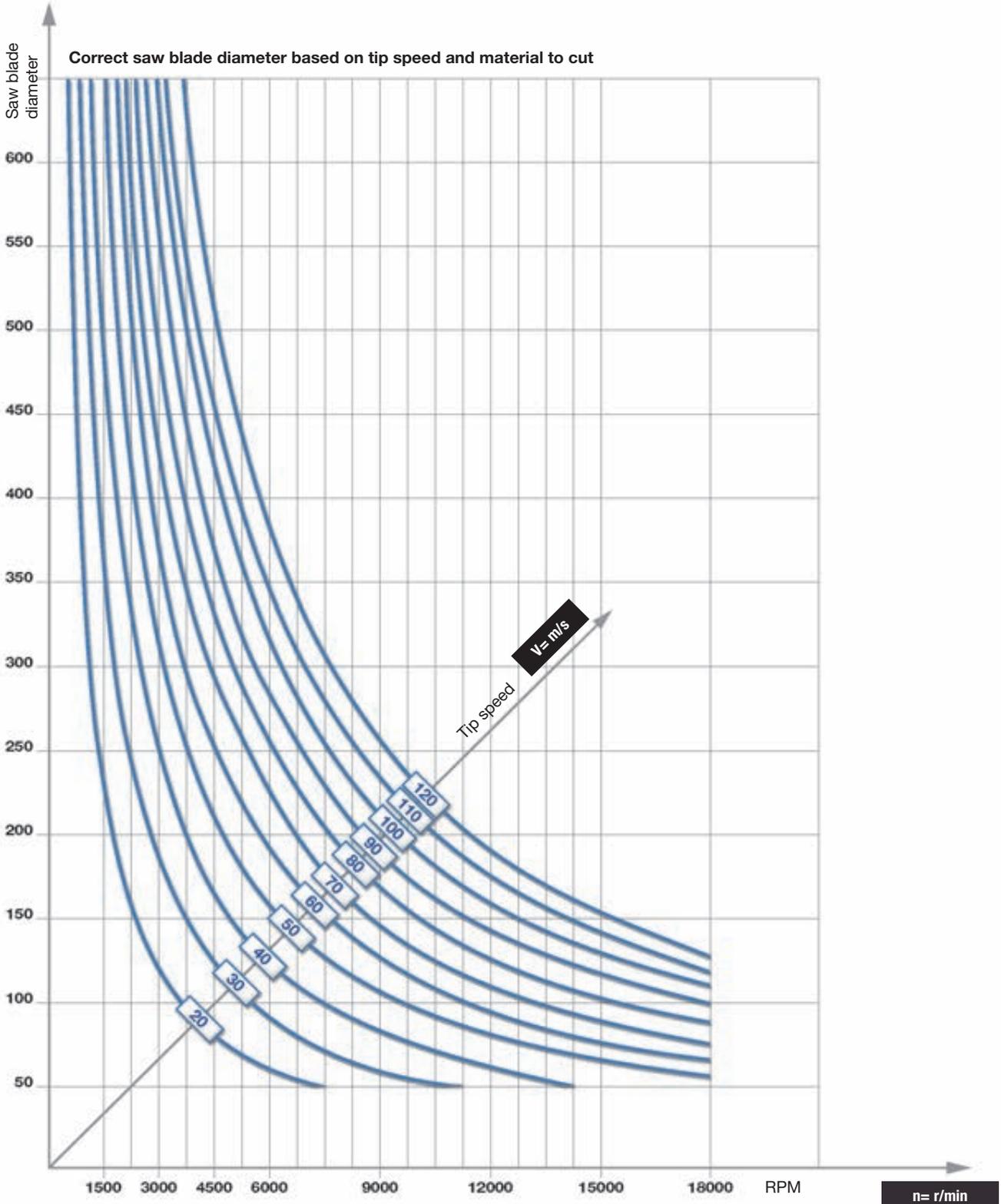
TIPS FOR THE CORRECT USE OF A CIRCULAR SAW BLADE

- Rakers (Fig. 12) are inserts in HW that are brazed onto saw blades exclusively for cutting wood. They help keep a distance between the saw blade body and the workpiece, in order to avoid friction and overheating which cause the blade to deform.
- On saw blades for multiripping machines, the anti-kickback device is advised in cases where wood has loose knots and discards cases insert themselves underneath the saw blade.
- The pairing of blade and arbor with keyways is excellent in all cases where the keyways are the same (Fig. 13) or smaller than the blade slots (Fig. 14).
- On machines with an arbor with 1 keyway, you can only mount blades with 1 keyway slot (Fig. 15); on machines with an arbor with 2 keyways, you can only mount blades with 2 or 4 keyway slots (Fig. 16).
- You cannot mount a saw blade with 2 keyways on an arbor with 1 keyway slot, because the pairing will not be balanced.
- In case multiripping saw blades are used, it is recommendable to assembly them with alternate keyways (Fig. 17).
- Shoulder blade ensures correct distribution of lateral forces created by crooked planks in heavy duty use. The shoulder blade must be the first blade on the guide side of the multiripping machine.
- Always use shoulder blade with the set of multiripping blades (Fig. 18).
- On multiripping saw blades, the thickness of the workpiece (S) varies according to the diameter of the blade (\varnothing) and the minimum diameter (\varnothing_1) of the rakers (the rakers position may vary from blade to blade - Fig. 19).



TIPS FOR THE CORRECT USE OF A CIRCULAR SAW BLADE

Tip speed (m/s)	Recommended for
50 - 90	Softwood
50 - 80	Hardwood
50 - 85	Exotic wood
60 - 80	Chipboard
60 - 80	Joinery wood
30 - 60	MDF
40 - 60	Laminated and bilaminated

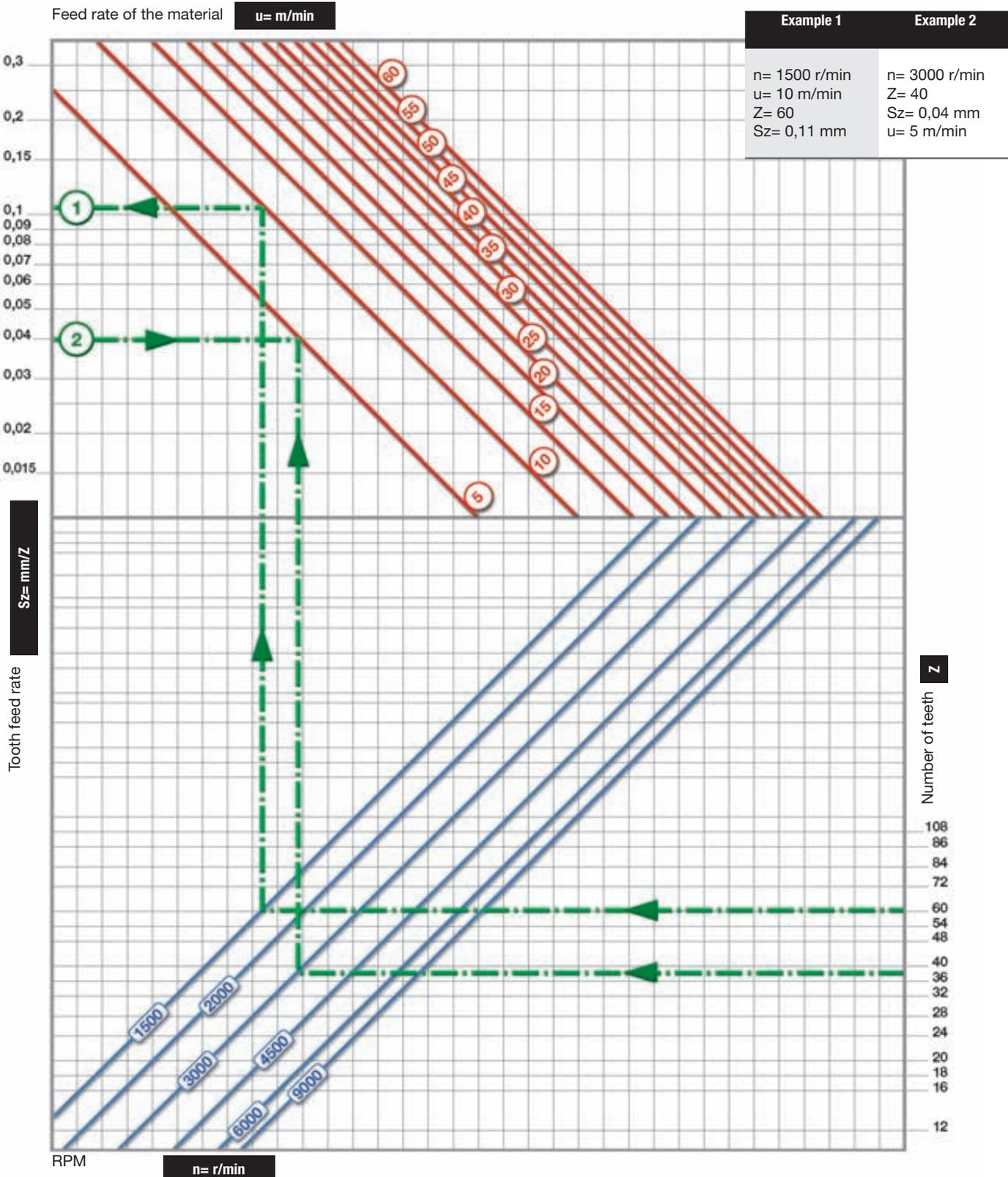


TIPS FOR THE CORRECT USE OF A CIRCULAR SAW BLADE

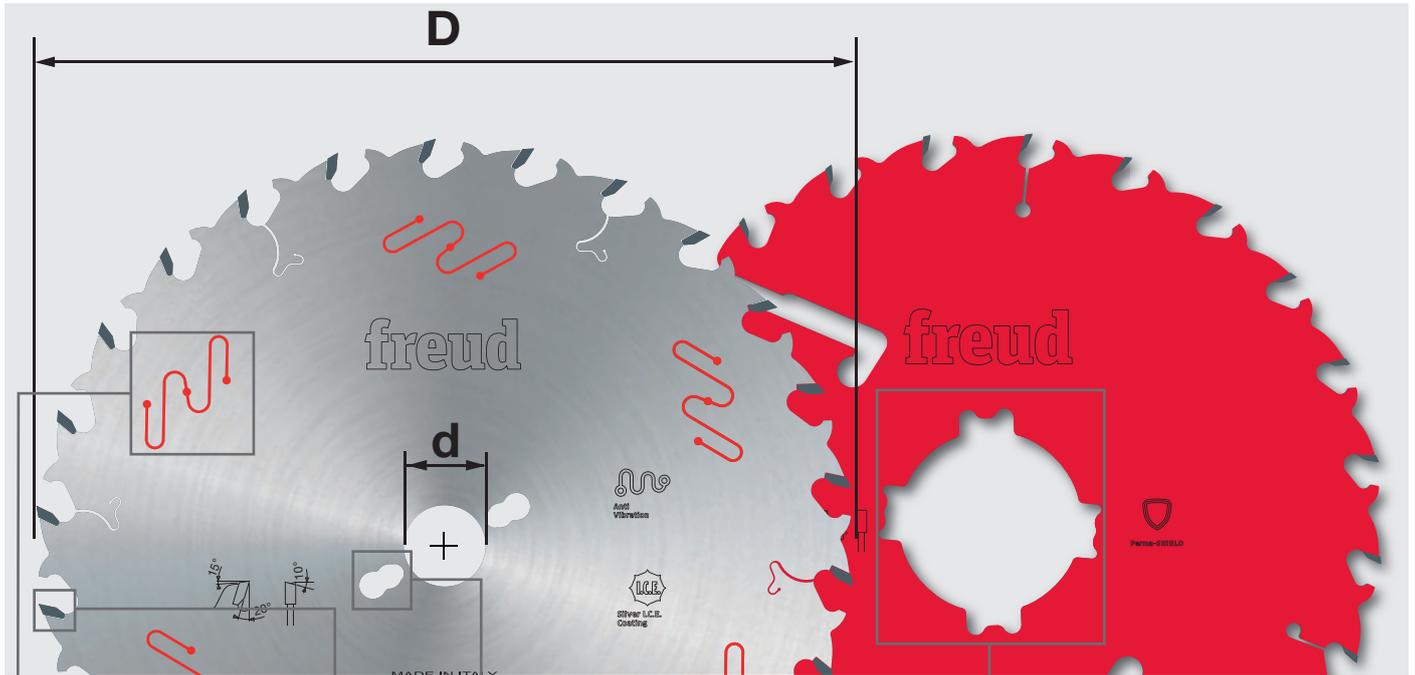
Correct tooth feed rate, material feedrate, number of teeth and RPM

Recommended tooth feed rate (Sz= mm/tooth)	Recommended for
0,20 - 0,30	Softwood with grain
0,10 - 0,20	Softwood cross grain
0,06 - 0,15	Hardwood
0,10 - 0,25	Chipboard

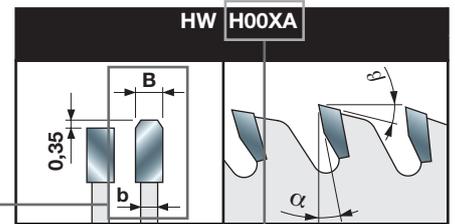
Recommended tooth feed rate (Sz= mm/tooth)	Recommended for
0,05 - 0,12	Plywood
0,05 - 0,10	Laminated board
0,02 - 0,05	Aluminium and plastic laminated chipboard



EXPLANATION OF SYMBOLS AND ABBREVIATIONS



D	B	b	d	Z	NL	KN	Freud Code	Art. No.
mm	mm	mm	mm					
250	3,2	2,2	30	22		FT01	ABCD 1234	A00BC01234
250	3,2	2,2	70	22		4CH 21x5	ABCD 1234	A00BC01234
300	3,2	2,2	30	26		FT01	ABCD 1234	A00BC01234



Tooth features

MICRO-GRAIN CARBIDE (HW) HARDNESS USED FOR MANUFACTURING TIPS

