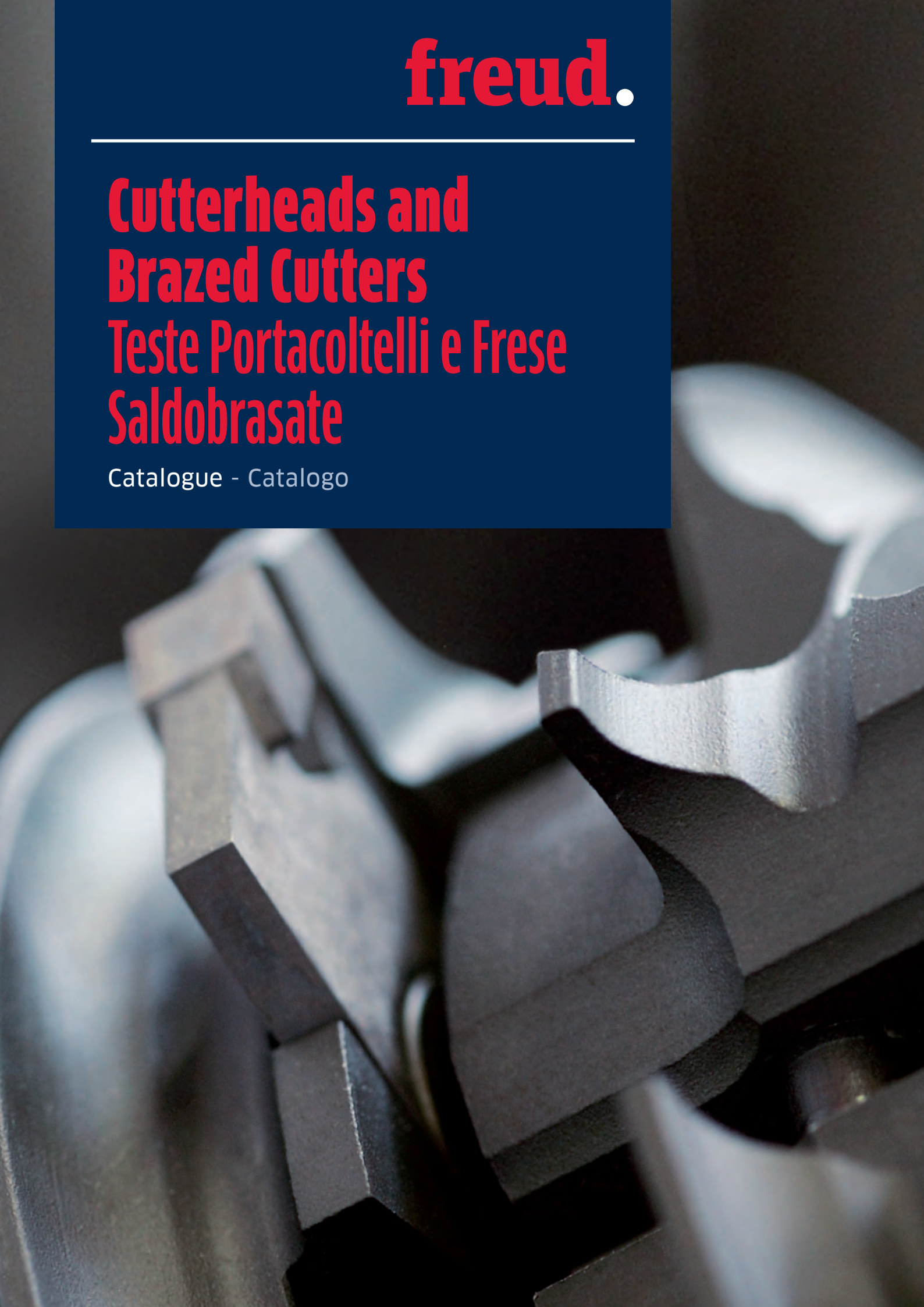


freud.

**Cutterheads and
Brazen Cutters
Teste Portacoltelli e Frese
Saldobrasate**

Catalogue - Catalogo



TW01M



Finger joint cutterheads

Teste per giunzioni - profilo intercambiabile

Cutterhead diameter with knives is 150 mm.

Advantages of our tool: On the same tool body, different jointing profiles can be fitted (see following page). It is possible to adjust the type of joint (tight, regular, loose) by means of a thumb screw mechanism.

Tools for working long and cross grain on short workpieces.

The item does not include knives and support plates.

Diametro della testa con i coltelli: 150 mm.

Vantaggi: Sullo stesso corpo possibilità di montaggio di differenti profili di giunzione (vedi pagina seguente). Possibilità di regolazione del gioco di accoppiamento (giunzione forzata, normale e lasca).

Utensili per la lavorazione lungo e trasverso vena di pezzi corti.

L'articolo non comprende i coltelli e i supporti.

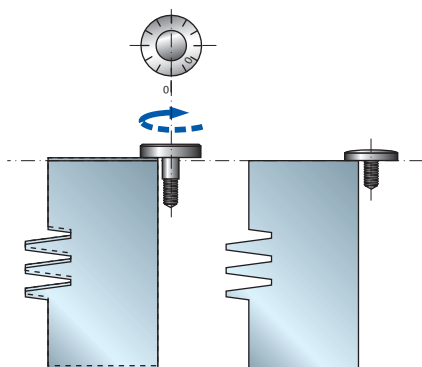
D mm	B mm	d* mm	Z	R	Max RPM 1/min.	Code Codice	SAP SAP
136	55	35 (50)	4		9.600	TW01M AB3	F03FC20555

Spare parts Parti di ricambio		Dimensions Dimensioni mm	Code Codice	SAP SAP
	Wedge / Cuneo	53 x 19 x 8,5	CN11M C510A	F03FC24405
	Screw / Vite	M10 x 18	VT03M CC9	F03FA04438
	Screw / Vite	M5 x 8	VT08M AC9	F03FC20652
	Positioning plate / Piastrina di riscontro	22 x 1,7 x 19	VT18M GB9	F03FA04489
	Screw / Vite	M5 x 8	VT05M AA9	F03FA04444
	Screw / Vite	M4 x 6	2602M CE9	F03FA07349
	Screw / Vite	M3 x 8	2607M AB3	F03F010001
	Allen key / Chiave	5 x 110	CB03M EA9	F03FA00169

Order example:

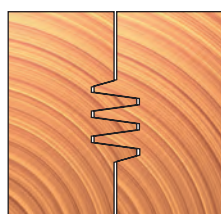
Esempio di ordinazione:

Item Articolo	SAP SAP	Dimensions Dimensioni mm	Quantity Quantità PCS. - PZ.
TW01M AB3	F03FC20555	136 x 55 x 35 Z4	1
CW10MAA301	F03FC24120	55 x 29 x 3	4
SD02M AB9	F03FC18894	55 x 27 x 5,5	4

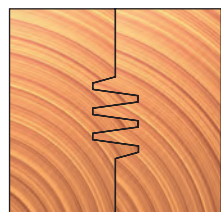


Adjustment examples:

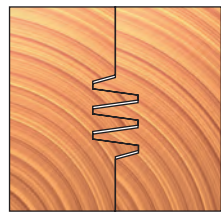
Esempi di regolazione:



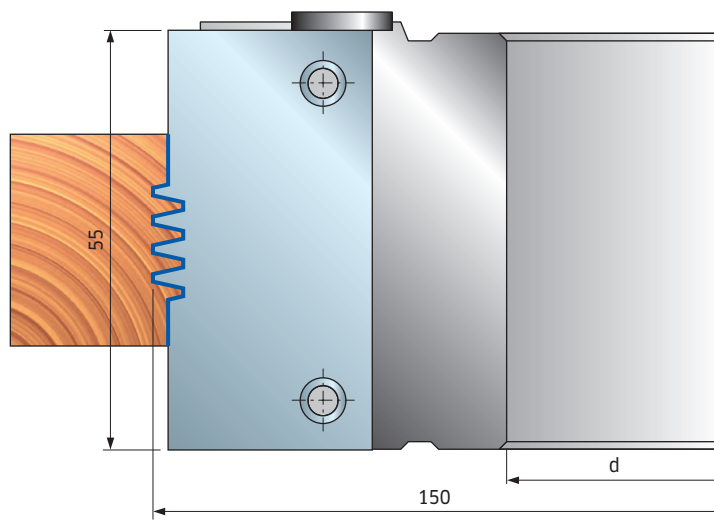
Tight joint
Giunzione forzata



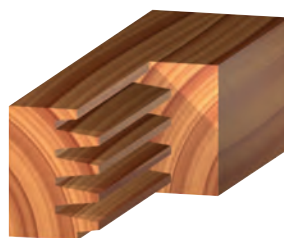
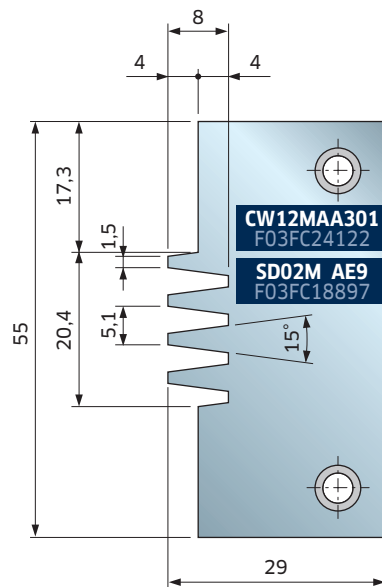
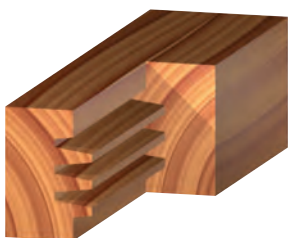
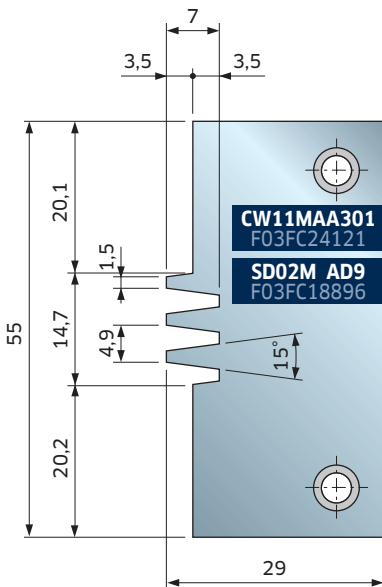
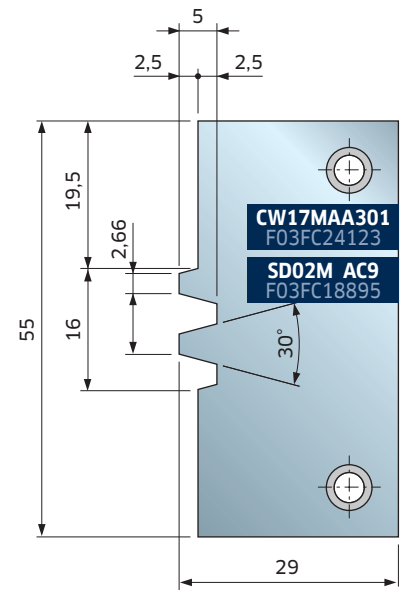
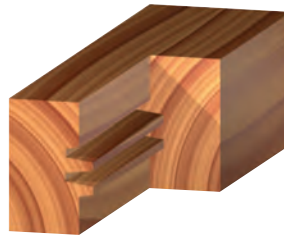
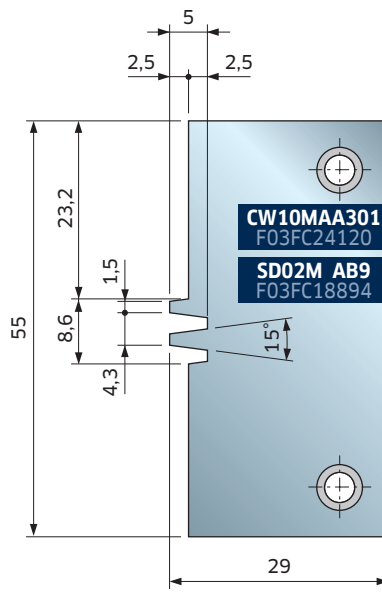
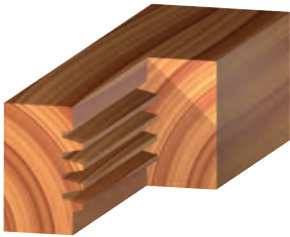
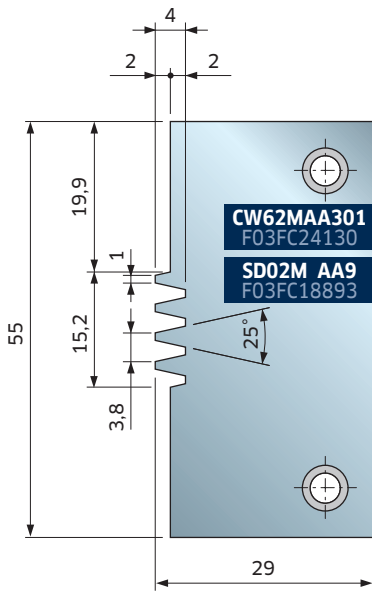
Regular joint
Giunzione normale



Loose joint
Giunzione lasca



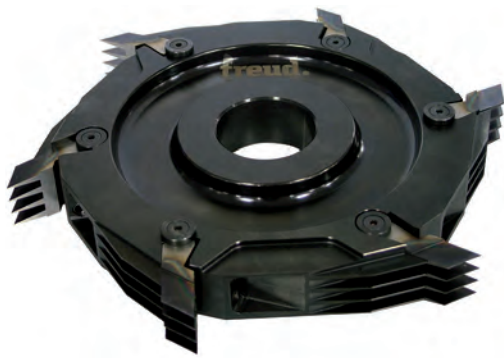
* Size shown between brackets is the max. rebore possible • La quota tra parentesi è la massima allargatura foro possibile



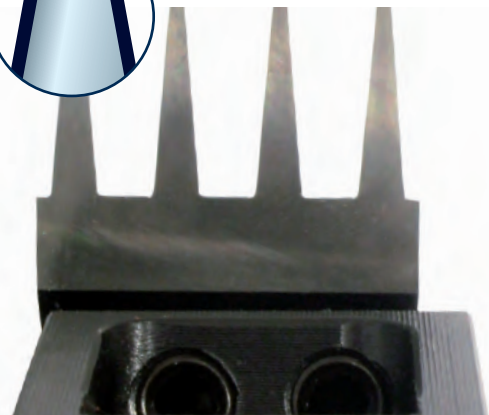
Dimensions Dimensioni mm	Spare knives Coltelli di ricambio	SAP SAP
55 x 29 x 3	CW62MAA301	F03FC24130
55 x 29 x 3	CW10MAA301	F03FC24120
55 x 29 x 3	CW17MAA301	F03FC24123
55 x 29 x 3	CW11MAA301	F03FC24121
55 x 29 x 3	CW12MAA301	F03FC24122

Dimensions Dimensioni mm	Spare support plates Supporti di ricambio	SAP SAP
55 x 27 x 5,5	SD02M AA9	F03FC18893
55 x 27 x 5,5	SD02M AB9	F03FC18894
55 x 27 x 5,5	SD02M AC9	F03FC18895
55 x 27 x 5,5	SD02M AD9	F03FC18896
55 x 27 x 5,5	SD02M AE9	F03FC18897

TW05M



Enlargement of hard coating
Particolare del rivestimento



Finger joint cutterheads with resharpenable knives Teste per giunzioni con coltelli riaffilabili

Steel tool body with exchangeable knives. Individually replaceable knives if damaged. Always sharpen sets of tools to the same diameter. Finger joint machines with and without cut off saw.

- Advantages:
- Possibility of single knives substitution;
 - Same amount of regrinding options than brazed solution;
 - Easy maintenance.

PVD coating of the knives:

- Advantages:
- Great reduction of friction coefficient;
 - Longer lifetime.

Testa a fissaggio meccanico. Riaffilare sempre i coltelli in un pacco utensili allo stesso diametro. Utensili indicati per macchine con o senza lama intestatrice.

- Vantaggi:
- Sostituzione dei soli coltelli a fine vita degli stessi.
 - Numero di affilature uguale alla soluzione saldobrasata.
 - Facile manutenzione in caso di rottura accidentale.

Rivestimento PVD dei coltelli.

- Vantaggi:
- Riduzione di oltre metà del coefficiente d'attrito.
 - Durata di taglio superiore.

Tools (supplied without knives) - Utensile (fornito senza coltelli)

D mm	B mm	d* mm	Joint lenght L. giunzione mm	Z	Max RPM 1/min.	Code Codice	SAP SAP
160	30,4	40 (50)	10/10-10/11	4	8.500	TW05M CA9	F03FA18836
250	30,4	40 (50)	10/10-10/11	6	5.500	TW05M CC9	F03FA18837
170	30,4	40 (50)	15/15-15/16,5	4	8.000	TW05M DA9	F03FA18838
260	30,4	40 (50)	15/15-15/16,5	6	5.200	TW05M DC9	F03FA18839
180	37,2	40 (50)	20/20-20/22	4	7.500	TW05M EA9	F03FA18840
260	37,2	40 (50)	20/20-20/22	6	5.200	TW05M EC9	F03FA18841
160	30,4	50	10/10-10/11	4	8.500	TW05M50CA9	F03FA18973
250	30,4	50 (60)	10/10-10/11	6	5.500	TW05M50CC9	F03FA18974
170	30,4	50	15/15-15/16,5	4	8.000	TW05M50DA9	F03FA18975
260	30,4	50 (60)	15/15-15/16,5	6	5.200	TW05M50DC9	F03FA18976
180	37,2	50	20/20-20/22	4	7.500	TW05M50EA9	F03FA18977
260	37,2	50 (60)	20/20-20/22	6	5.200	TW05M50EC9	F03FA18978

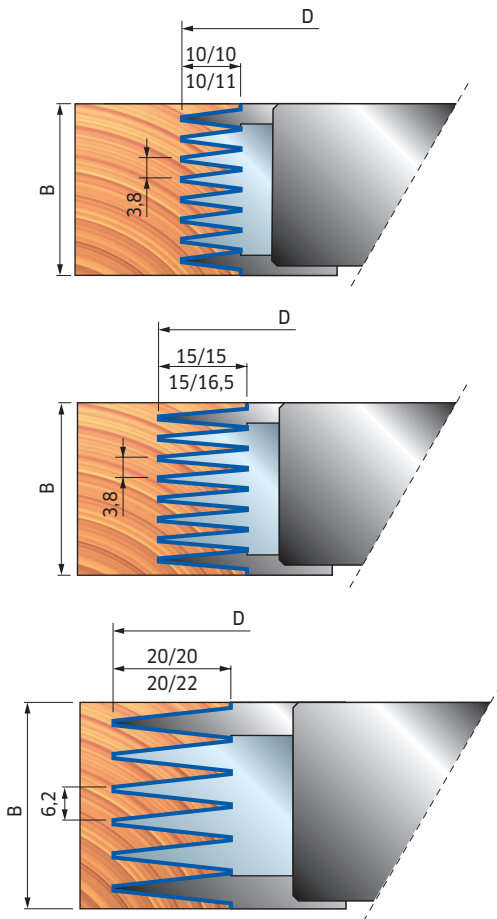
Spare knives - Coltelli di ricambio

Joint lenght Lunghezza giunzione mm	Pitch Passo mm	Dimensions Dimensioni mm	Code Codice	SAP SAP
10/10	3,8	28,4 x 38,5 x 14	CW05MCA201	F03FA18842
10/11	3,8	28,4 x 38,5 x 14	CW05MCB201	F03FA18843
15/15	3,8	28,4 x 43,5 x 14	CW05MDA201	F03FA18844
15/16,5	3,8	28,4 x 43,5 x 14	CW05MDB201	F03FA18845
20/20	6,2	32,5 x 48,5 x 14	CW05MEA201	F03FA18846
20/22	6,2	32,5 x 48,5 x 14	CW05MEB201	F03FA18847

L mm	Pitch Passo mm	B max mm	No. cutters N. teste
10/10 10/11	3,8	29,8	1
		60,2	2
		90,6	3
		121	4
		151,4	5
		181,8	6
		212,2	7
15/15 15/16,5	3,8	29,8	1
		60,2	2
		90,6	3
		121	4
		151,4	5
		181,8	6
		212,2	7
20/20 20/22	6,2	36,3	1
		73,6	2
		110,7	3
		147,9	4
		185,1	5
		222,3	6
		259,5	7

Table for determination of maximum wood thickness depending on the number of cutterheads used.

Tabella per determinare il massimo spessore legno lavorato in base al numero di teste utilizzate.



* Size shown between brackets is the max. rebore possible • La quota tra parentesi è la massima allargatura foro possibile

TW22M

Finger joint cutterheads Teste per giunzioni

Tools for working long grain on short workpieces.

Please note: two different types of knives are fitted on the cutterheads: two **CW22MAAA301** and two **CW22MBAA301**.

Light alloy body (Aluminum alloy). For cleaning do not use products containing caustic soda.

Utensili per la lavorazione lungo vena di pezzi corti.

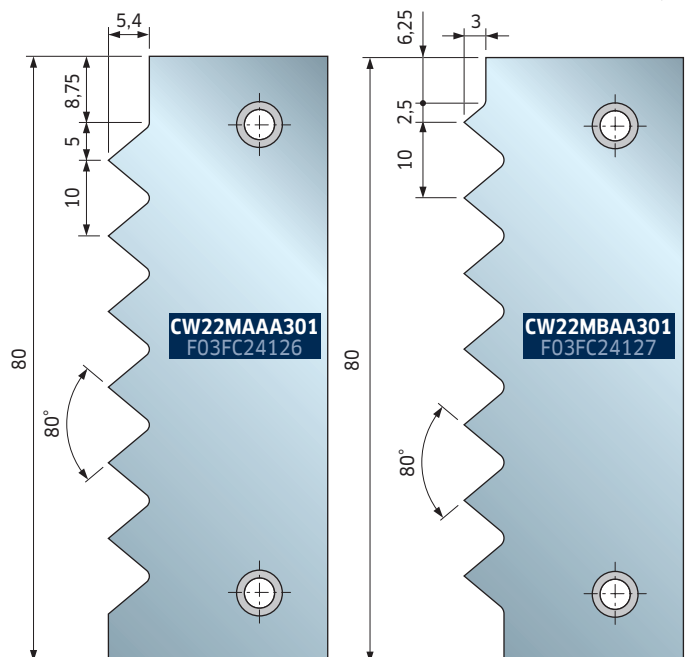
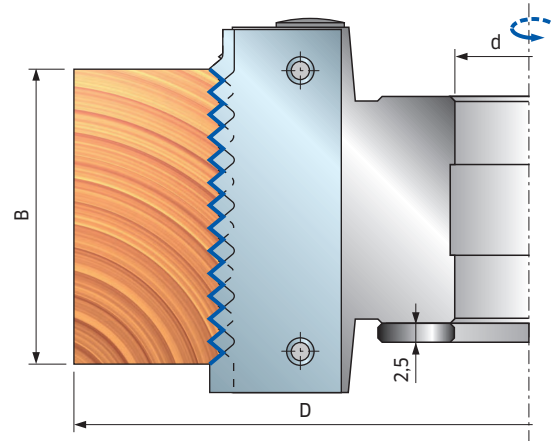
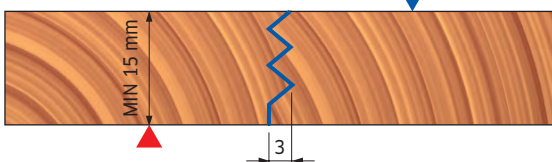
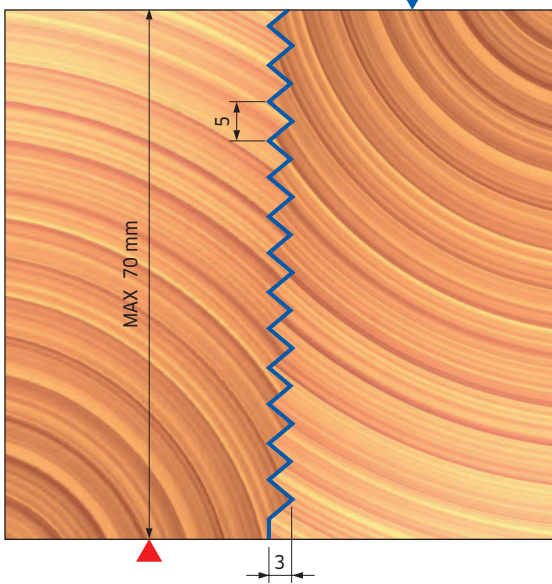
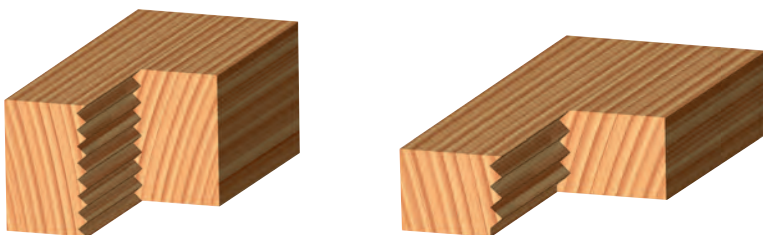
Sulla testa vengono montati due tipi di coltelli: due **CW22MAAA301** + due **CW22MBAA301**.

Corpo in lega leggera (Lega di alluminio). Per la pulizia non utilizzare prodotti contenenti soda caustica.



D mm	B mm	d* mm	Z	R	Max RPM 1/min.	Code Codice	SAP SAP
140	80	30	4		9.600	TW22M BA3	F03FC23047
140	80	32	4		9.600	TW22M BG3	F03FC24406
140	80	35 (50)	4		9.600	TW22M BB3	F03FC20566

Spare parts Parti di ricambio	Dimensions Dimensioni mm	Code Codice	SAP SAP
Knife / Coltello	80 x 29 x 3	CW22MAAA301	F03FC24126
Knife / Coltello	80 x 29 x 3	CW22MBAA301	F03FC24127
Spacer / Anello distanziale	50 x 2,5 x 30	AN20M AI9	F03FC00552
Spacer / Anello distanziale	55 x 2,5 x 35	AN20M BI9	F03FC00553
Spacer / Anello distanziale	52 x 2,5 x 32	AN20M EI9	F03FC24411
Wedge / Cuneo	76 x 24 x 8	CN13M AG9	F03FC01388
Screw / Vite	M10 x 18	VT03M CC9	F03FA04438
Screw / Vite	M5 x 7 x 16	VT08M AE9	F03FA04457
Allen key / Chiave	5 x 110	CB03M EA9	F03FA00169

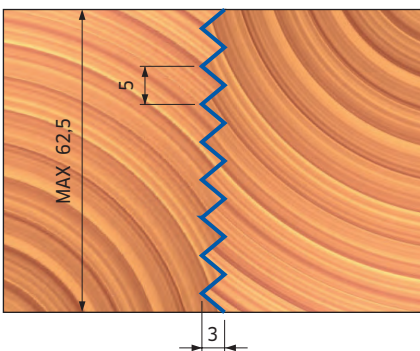
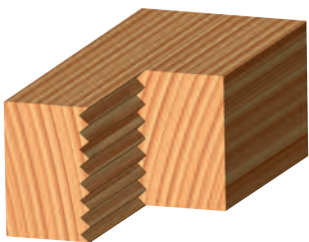
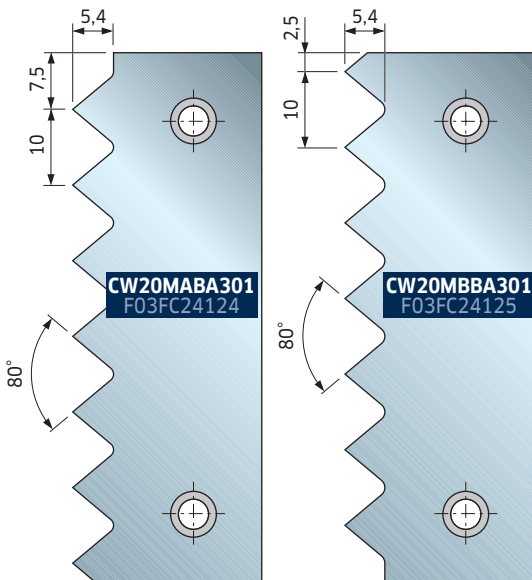


* Size shown between brackets is the max. rebore possible • La quota tra parentesi è la massima allargatura foro possibile

TW23M - TW20M

Z = 2

Z = 4



Finger joint cutterheads Teste per giunzioni

Tools for working long grain on short workpieces.

Please note: two different types of knives are fitted on the cutterheads: **CW20MA** and **CW20MB**. The tool is supplied with a spacing ring $S=2,5$ mm so that a perfect joint can be obtained and the initial zero-point programming maintained. The max. thickness possible is 62,5 mm. Light alloy body (Aluminum alloy). For cleaning do not use products containing caustic soda.

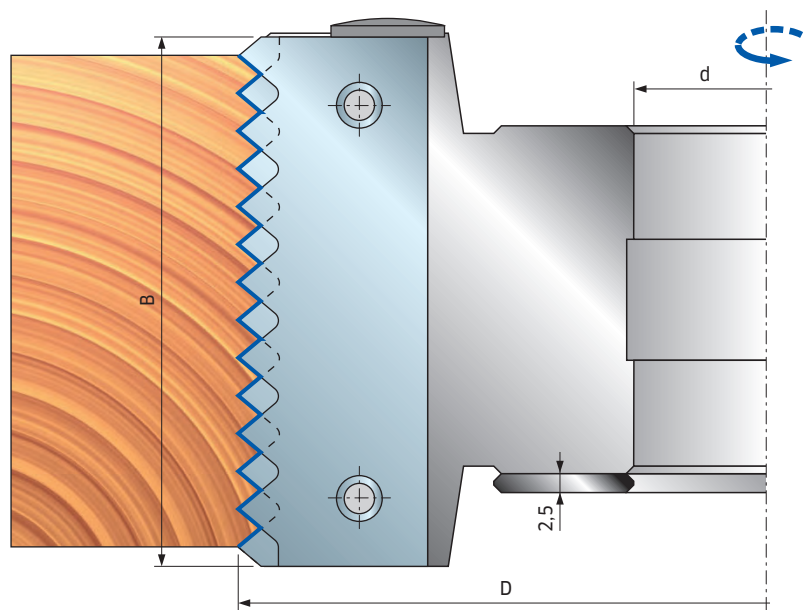
Utensili per la lavorazione lungo vena di pezzi corti.

Attenzione: sulle teste sono montati due tipi di coltelli diversi: **CW20MA** e **CW20MB**. Vengono forniti in dotazione i coltelli ed un anello distanziale $S=2,5$ mm per ottenere una perfetta giunzione mantenendo la programmazione iniziale inalterata. Lo spessore massimo ottenibile è di 62,5 mm. Corpo in lega leggera (Lega di alluminio). Per la pulizia non utilizzare prodotti contenenti soda caustica.

D mm	B mm	d* mm	Z	R	Max RPM 1/min.	Code Codice	SAP SAP
140	70	30	4		9.600	TW20M BA3	F03FC22727
140	70	35 (50)	4		9.600	TW20M BF3	F03FC20564
140	70	30	2		9.600	TW23M BE3	F03FC24404
140	70	32	2		9.600	TW23M BG3	F03F668303
140	70	35 (50)	2		9.600	TW23M BF3	F03FC20567

Spare parts Parti di ricambio	Dimensions Dimensioni mm	Code Codice	SAP SAP
Knife / Coltello	70 x 25 x 3	CW20MABA301	F03FC24124
Knife / Coltello	70 x 25 x 3	CW20MBBA301	F03FC24125
Wedge / Cuneo	68 x 19 x 8	CN11M C660A	F03FC01354
Screw / Vite	M10 x 18	VT03M CC9	F03FA04438
Screw / Vite	M5 x 8	VT05M AA9	F03FA04444
Positioning plate / Piastrina di riscontro	22 x 1,7 x 19	VT18M GB9	F03FA04489
Allen key / Chiave	5 x 110	CB03M EA9	F03FA00169
Spacer / Anello distanziale	50 x 2,5 x 30	AN20M AI9	F03FC00552
Spacer / Anello distanziale	55 x 2,5 x 35	AN20M BI9	F03FC00553
Spacer / Anello distanziale	52 x 2,5 x 32	AN20M EI9	F03FC24411

TW20M BA3
TW23M BE3
TW20M BF3
TW23M BF3
TW23M BG3



TW24M

Adjustable finger joint cutterheads set Gruppi di teste per giunzioni regolabili

Tools for working long and cross grain on short workpieces. Adjustable for wood thicknesses between 40 and 70 mm.

Cutterhead supplied with resharpenable HW knives and spacers.

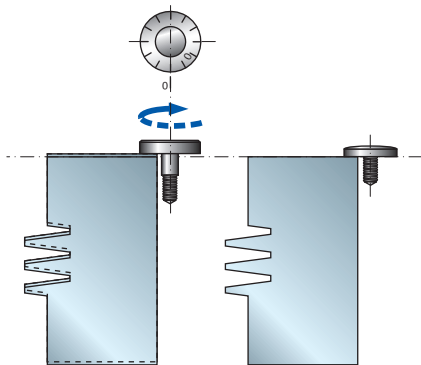
Utensili per la lavorazione lungo e trasverso vena di pezzi corti. Regolazione per spessore legno: 40÷70 mm.

Testa fornita di coltelli in HW riaffilabili e set anelli.

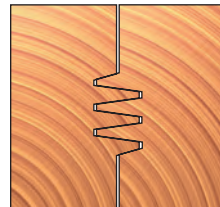


D mm	B mm	d* mm	Z	R	Max RPM 1/min.	Code Codice	SAP SAP
150		30	2+2		9.000	TW24M AA3	F03FC24412
150		32	2+2		9.000	TW24M AE3	F03FC24413
150		35 (50)	2+2		9.000	TW24M AB3	F03FC20568
150		40 (50)	2+2		9.000	TW24M AC3	F03FC20569

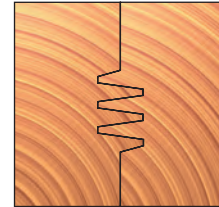
	Spare parts Parti di ricambio	Dimensions Dimensioni mm	Code Codice	SAP SAP
	Knife for tool. "A" / Colt. testa "A"	45 x 30 x 3	CW24MAAA301	F03FC24128
	Knife for tool. "B" / Colt. testa "B"	45 x 30 x 3	CW24MBAA301	F03FC24129
	Screw / Vite	M5 x 7 x 16	VT08M AE9	F03FA04457
	Screw / Vite	M6 x 7 x 18	VT08M AG9	F03FC20653
	Wedge / Cuneo	41 x 17 x 8	CN11M B410A	F03FC01352
	Screw / Vite	M10 x 18	VT03M CC9	F03FA04438
	Screw / Vite	M4 x 6	2602M CE9	F03FA07349
	Allen key / Chiave	5 x 110	CB03M EA9	F03FA00169
	Allen key / Chiave a "L"	2	2619M BA9	F03FA07431
AA3	Set spacers / Set anelli	50 x 5,8 x 30	AN04M AC9	F03FC00500
AB3	Set spacers / Set anelli	55 x 5,8 x 35	AN04M BC9	F03FC00502
AC3	Set spacers / Set anelli	60 x 5,8 x 40	AN04M CC9	F03FC00503
AE3	Set spacers / Set anelli	82 x 5,8 x 32	AN04M EC9	F03FC24414



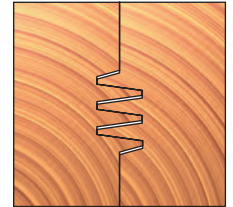
Adjustment examples: Esempi di regolazione:



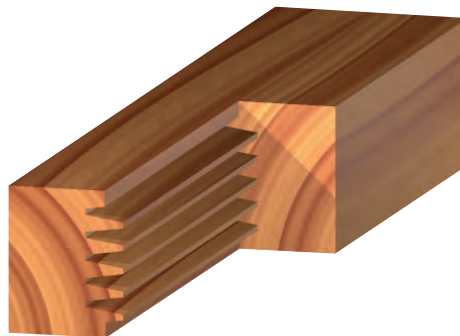
Tight joint
Giunzione forzata



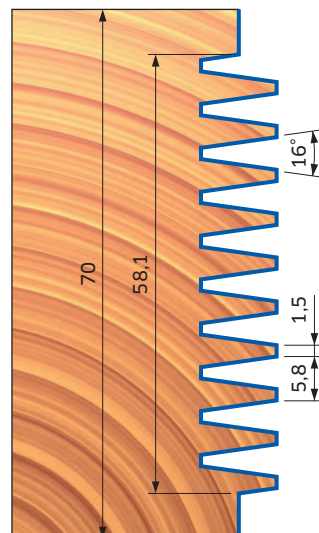
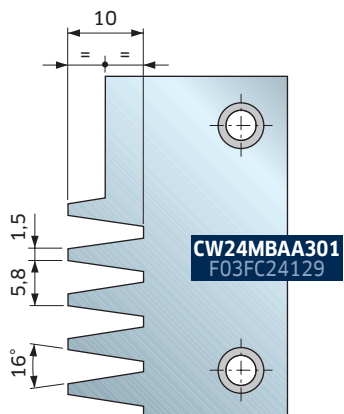
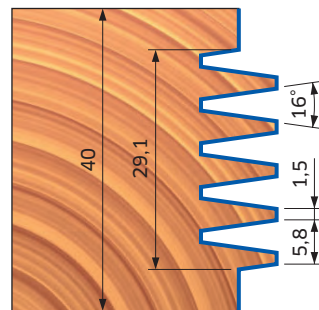
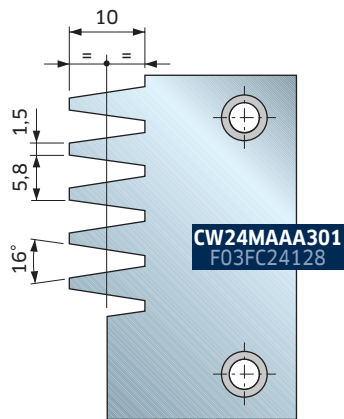
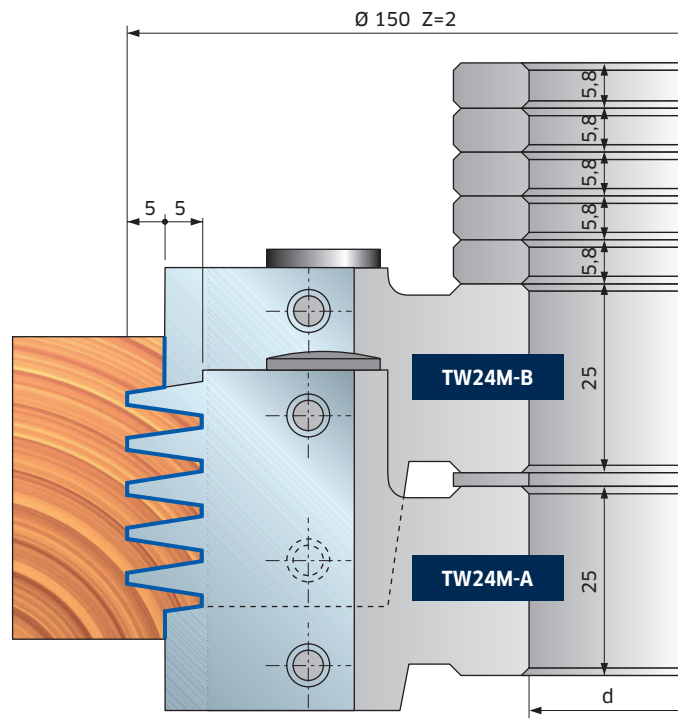
Regular joint
Giunzione normale



Loose joint
Giunzione lasca



* Size shown between brackets is the max. rebore possible • La quota tra parentesi è la massima allargatura foro possibile



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