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HDS SAWMILL TOOLS

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COMPANY

Sawmill Tools for Sawmills

Based on our experience in recent years we are now able to offer a number of high quality, powerful sawmill tools which meet the needs of sawmill tools more than ever.

Our wide range of products includes BASIC, STABILO, TRIMCUT and CROSSCUT brand circular saw blades, as well as a number of segments and sizing rings in various styles.

Our butt end reducers, chipper and profiler knives, hogging and counter knives, as well as flaker knives make up a wide range of sawmill knives in a variety of styles.

A number of distance rings and system components as well as the SPINCUT milling shaft butt end reducer, the CANTERCUT chipper canter and the PROFILCUT profiler cutters complete our "Sawmill tools" product range.

HDS. THE FACTORY AND OUR WORKERS IN TOOL TOWN

REMSCHEID

TOOLS.

TRADITION.

QUALITY.

ENGINEERS.

TECHNICIANS.

WORKERS.

MANAGEMENT.

HDS designs and manufactures in Remscheid. This makes us a tradition of the German tool town, home to world renowned tool companies who have shaped our city's reputation on an international level with the established "Remscheid tool quality".

At HDS, "Made in Germany" means "Made in Remscheid", as this is where we find the perfect ingredients we combine to make our best sawmill tools. Our engineers and technicians who have gained their experience and skills in Remscheid toolmaking apply their entire expertise to each HDS development. It's our workers who give their best working the machines, ensuring our high manufacturing quality with their outstanding skills.

Of course this includes our employees in sales and in management, who ensure a smooth process from providing advise, processing orders, design, and production, all the way to final inspection and delivery.

We stand by our location with our high vertical range of manufacture and feel bound to this region, our city, and the legendary "Remscheid tool quality". Our engineers and technicians, our workers and our employees in sales, in management and in administration implement this standard on a daily basis.









COMPANY

Our company logo stands for "precision and perfection" and that's what we're passionate about. It's what drives us to make the existing even better for the future. Sometimes it's little optimisations which have a great impact, others it's the birth of a design revolution heralding the next generation of progress.

And we're not just thinking structurally, in hundredths or even thousandths of a millimetre, but even with regard to customers we think outside the box, as for example illustrated by tool management and sustainability.

Two aspects which at first glance may not seem to have much in common but a closer look will reveal an interesting potential for development.

Sawmill tools are perfect if they are extremely powerful and just as stable at the sawmills yet prove to be extremely effective, thus gentle on resources in wood machining. At HDS this is already "State of the Art" now. But our pursuit of perfection goes far beyond manufacturing high-quality sawmill tools.

HDS. THE SAWMILL TOOL COMPANY

That's why we now already design and manufacture sawmill tools with a quality of materials they can be regenerated multiple times. Compared to a new acquisition this sustainable use of materials is an extremely interesting process, both from an economic as well as an ecologic perspective.

As simple as this concept we already practice today may seem, the tool management it requires is just as challenging. Sawmill tools must always be available in sufficient quantities. This requires for "used" sawmill tools to be tested and regenerated, or replaced if the material wear warrants an end of service life. Here the challenge is not only the material, but also information- and tool logistics. And we are already rising to this challenge today.

Perfection can be described quite simple: Not all too long ago a batch of STABILO graduated circular saw blades needed regeneration at our factory. Not really a particularly noteworthy process had they not been from 2007 ...

This is perfection at its finest: Years of powerful and solid service, the kerf reduction from "AST Graduated Saw Blade Technology" making it extremely effective, regeneration making it reusable several times, and therefore of lasting quality. That's our standard.

PERFECTION

. POWERFUL

. STABLE

. EFFECTIVE

. SUSTAINABLE

. EFFICIENT







COMPANY

HDS. THE SAWMILL TOOL COMPANY

Our history alone shows that HDS-Group specialised in the tool requirements of sawmills more and more.

We pushed this trend in recent years, as we believe continuing to develop, design and manufacture particularly powerful sawmill tools requires the respective high level of specialisation and expertise. We therefore shifted the focus of our business policies on our customers in the sawmill industry and their requirements for modern sawmill tools more than ever.

We're not a passive tool supplier for mass-produced articles, but rather the competent specialist for highly efficient tool solutions for sawmills. It's our profession which embodies our slogan "HDS. THE SAWMILL TOOL COMPANY".

HDS STANDS FOR DYNAMIC DEVELOPMENT

2019 "Unmanned" third shift

To be in the position to handle the backlog of orders and the pricing pressure, robots enable a third shift.

Besides machine loading and unloading they take care of cleaning the workpieces and workholders and arrange milling, deburring or grinding of our sawmill tools.

2018 Expansion of 5-axis machining

The production of our sawmill tools like circular saw blades, knives or system components is more and more made by 5-axis machining centers included automatic tool measuring in integrated magazines. Furthermore non-productive times hours could be reduced by using automatic pallet changers.

2016 Again enlargement of production capacities

By reasons of an increase of needs for sawmills and therewith an excellent order situation, the production capacities had to be expanded. In another construction phase our places could be significantly enlarged.

2014 Expanded administration and production:

With the strong growth of the Sawmill Tools division the only 4 years old HDS building reached its capacity. Additional production halls and a new office wing were built.

2013 . Acquisition of the saw factory WIJAG (Wilms Jansen Germany):

The integration of WIJAG shifted the focus of our sawmill tools business segment even more on the existing circular saw blade product group.

2011 Business portfolio restructured:

The growing focus on the sawmill division required restructuring of our business segments, resulting in today's HDS-Group GmbH.

2010 New building for administration and production:

HDS moved into its first own, and back then quite spacious, company building in the Remscheid industrial park Bergisch Born.

2009 . Acquisition of HT-Maschinenmesser GmbH:

The integration of the Remscheid company HT-Maschinenmesser GmbH added to HDS Werkzeuge's production.

Acquisition of Remscheid's machine cutting tool and saw factory vom Hoff GmbH:

Only five years after HDS Werkzeug was founded, the business domain was expanded by integrating Remscheid's cutting tool and saw manufacturer vom Hoff.

HDS Werkzeuge founded:

2004

1999

Engineering graduate Andreas Hindrichs, sole proprietor and general manager, who previously worked in the Engineering Department at saw manufacturer Felde, founded the company "HDS Werkzeuge" in Remscheid.

MILESTONES

Since 2011, HDS-Group consists of three business segments: HDS-Sawmill Tools, HDS-Made-To-Order Production and HDS-Engineering. Each area focuses on the corresponding core competences and the resulting goods and services. All business segments work together closely and are jointly responsible for the high HDS quality standard of our products.

HDS-Sawmill Tools

The HDS-Sawmill Tools division is the interface between our customers from the sawmill industry and HDS-Group. This is where all sales and marketing activities for our sawmill tools are coordinated. This also includes customer support and the entire order and service management.

HDS-Made-To-Order Production

The HDS-Made-To-Order Production covers the production of our innovative sawmill tools. Our ultra-modern machinery is also utilised by the repair and regeneration service of our Made-To-Order Production. All products and services of HDS-Made-To-Order Production are subject to our strict quality standards.

HDS-Engineering

Our HDS-Engineering division is home to our design and development. This high-tech department particularly handles our "SoWa Sawmill Optimised Tool Design". Here the design and production of our sawmill tools are precisely adapted to the specific operating conditions at the sawmills.

This is home to our research and development of completely new sawmill tools and where we design optical measuring- and testing machines, including for our production.















SoWa. Sawmill tools perfectly adapted to your saw line

HDS-Sawmill Tools have always been designed for the requirements at the sawmill. The enhanced performance of such optimised sawmill tools combined with the satisfaction of our customers has now encouraged us to firmly anchor this optimisation process in our company philosophy and give it a uniform name.

"SoWa Sawmill Optimised Tool Design" puts our optimisation process in a nutshell.



Our HDS "Sawmill tools" product range covers the majority of a modern sawmill's tool needs.

For log yards there are our robust CROSSCUT circular saw blade with interchangeable inserts measuring up to 2.8 metres in diameter, and the tried and tested SPINCUT milling shaft butt end reducer.

For chipping we can supply all the necessary sawmill tools for your units. Here our product range includes segments, sizing rings and knives of various design styles. For economic increase in performance we offer our CANTERCUT chipper canter, a complete and optimally coordinated tool solution.

For profiler and cutting units, in addition to our complete PRO-FILCUT profiler cutters we also supply all sizing rings, smoothing segments, smoothing knives and the necessary system components such as segment carriers, knife holders, pressure plates, etc.

Our BASIC and the graduated STABILO provide two categories of high performance saw blades for all circular saw units. Both circular saw blades offer a number of technical refinements to coordinate optimally for the respective purpose.

HDS-Sawmill knives and the TRIMCUT circular saw blade designed specifically for trimming are used for subsequent processing.

HDS Sawmill Tools for the saw line

HDS-Sawmill Tools for chipping unit 1

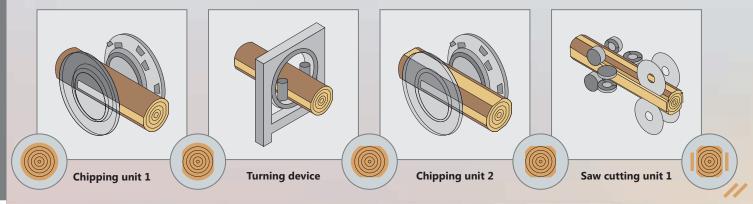
- + CANTERCUT chipper canter
- + Sizing rings
- + Smoothing segments
- + Smoothing and chipping knives
- + Knife holders, pressure plates
- + Sizing ring carrier

HDS-Sawmill Tools for chipping unit 2

- + CANTERCUT chipper canter
- + Sizing rings
- + Smoothing segments
- + Smoothing and chipping knives
- + Knife holders, pressure plates
- + Sizing ring carrier

HDS-Sawmill Tools for saw cutting unit 1

- + PROFILCUT profiler cutters
- + Sizing ring/segment
- + Profiler knife
- + Knife holders, pressure plates
- + Segment carrier
- + STABILO circular saw blades
- + BASIC circular saw blades
- + Distance rings



STABILO. Perfect for heavy duty rough and fine cuts

Graduated circular saw blades continue to define the standard in the heavy duty segment to this day, since modern sawmills didn't have access to a highly efficient circular saw blade until the "AST Graduated Saw Blade Technology" was developed.

STABILO class circular saw blades have since long taken root in saw-mills. They're used for the rough cut, and for a few years now also more and more for fine cuts, and ensure highly efficient tool use.



Compared to straight circular saw blades, STABILO circular saw blades with "AST Graduated Saw Blade Technology" allow for an extremely small kerf, thus an effective lumber yield.

The name "STABILO" alone already indicates the solid saw body which ensures a long circular saw blade life. A STABILO blade can therefore also be regenerated multiple times.

On the saw line, STABILO is used for rough as well as fine cuts. For rough cutting the STABILO circular saw blade can withstand extreme strain as a result of the desire for always increasing feeds

with high cutting heights and the least kerf possible. Even in fine cuts STABILO demonstrates the kerf reduction with high feed. When using the circular saw blade for rough and fine cuts, the lumber yield increases in two respects.

STABILO circular saw blades designed specifically to your cutting line, therefore combining maximum performance with extremely high stability, and the kerf reduction provides the optimal lumber yield. STABILO is therefore the perfect circular saw blade for rough and fine cuts on your saw line.

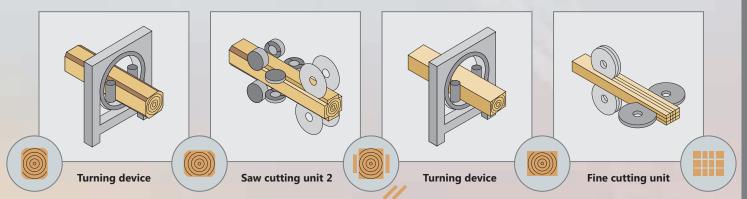
HDS Sawmill Tools for the saw line

HDS-Sawmill Tools for saw cutting unit 2

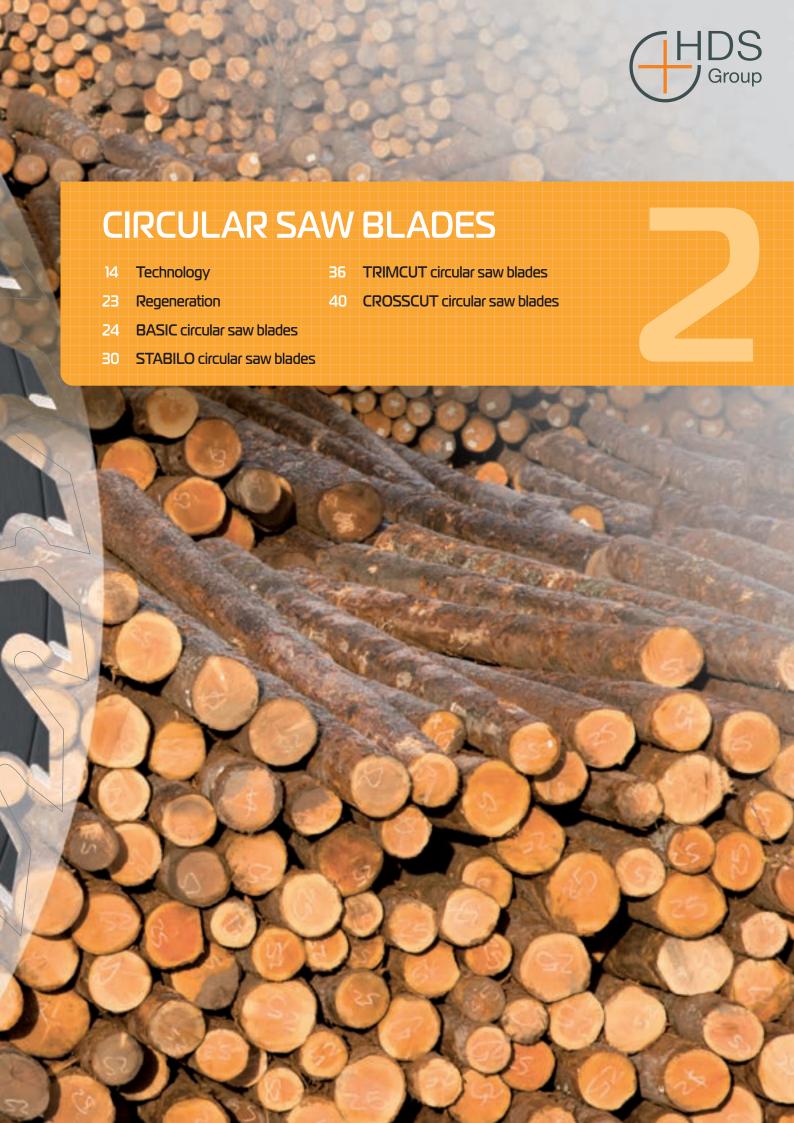
- + PROFILCUT profiler cutters
- + Sizing ring/segment
- + Profiler knife
- + Knife holders, pressure plates
- + Segment carrier
- + STABILO circular saw blades
- + BASIC circular saw blades
- + Distance rings

HDS-Sawmill Tools for fine cutting unit

- + STABILO circular saw blades
- + BASIC circular saw blades
- + Distance rings







SoWa. Our road to perfect sawmill tools

A circular saw blade – or broadly speaking – a sawmill tool can only convince with optimal performance and high stability if the sawmill tool is designed as closely as possible to the special working conditions at the sawmill. "Sawmill Optimised Tool Design", "SoWa" for short, is therefore also the essence of our HDS philosophy. We're convinced this is the only way to achieve outstanding sawmill tool quality. The fact HDS-Sawmill Tools are being used in high capacity sawmills domestically and internationally confirms this approach. Benefit from our "SoWa Sawmill Optimised Tool Design" for your saw line.



HDS circular saw blade for rough cuts

Rough cutting exposes circular saw blades to extreme strain. Increasing feed rates and large cutting heights not only require an optimal design, but also an extremely durable material quality as well as precise machining. It's not a surprise, since speed, kerfs and cutting heights greatly contribute to productivity, thus the profitability of the saw line.

The goal is for each sawmill to be identical at the core, since generally the same success factors apply:

- + Reducing kerfs
- + Increasing feed rates
- + Increasing cutting heights
- + Increasing the cutting quality

The competing goals can only be realised at a balanced ratio. Today, the "AST Graduated Saw Blade Technology" allows us to optimise this magic ratio even more. The introduction of the "graduated" STABILO circular saw blade has allowed sawmills to operate much more efficiently.

To achieve the greatest lumber yield possible with also a preferably high feed rate in rough cutting, we only recommend STABILO class circular saw blades with Graduated Saw Blade Technology (AST) designed specifically for your cutting jobs. Featuring high dynamic rigidity, our STABILO can handle even extreme strain such as in rough cutting due to the different cutting heights combined with high feed rates. The high stability of the circular saw blade body allows for the minimal kerf design in STABILO. Reducing the kerf in turn results in lower cutting force, thus reducing the energy requirement. In addition, the lumber yield is increased so that with certain cutting programs, moving to the next greater log diameter or the next larger box in the log yard can be avoided – or more fittingly – "spared".

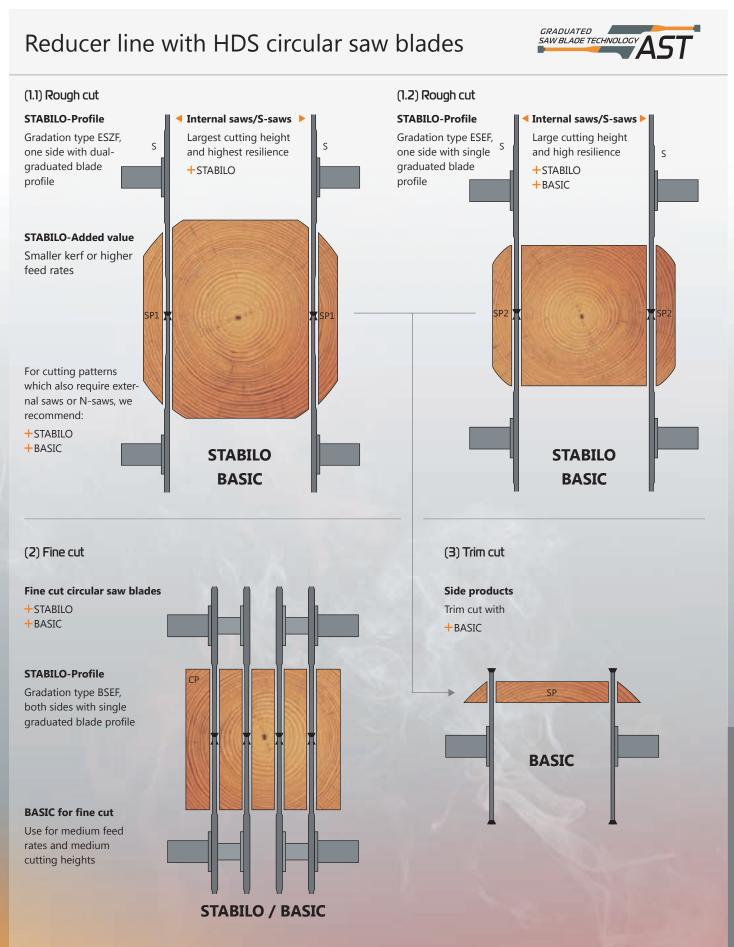
Trust in the highly efficient STABILO with "AST Graduated Saw Blade Technology" for rough cuts and use our "SoWa Sawmill Optimised Tool Design" for a premium product to best fit your cutting program, thus already guaranteeing a crucial competitive advantage in rough cutting.











CIRCULAR SAW BLADES

TECHNOLOGY

AST . Graduated Saw Blade Technology

No innovation has impacted the development of high-performance circular saw blades for use in sawmills in recent years as much as "AST Graduated Saw Blade Technology". Now, mature and proven designs are available to ensure maximum performance Sawmill Optimised Tool Design (SoWa) with outstanding stability.

Our STABILO combines the AST performance advantages in a circular saw blade designed to our standard in performance and quality.



HDS circular saw blade for fine cut

For efficient fine cuts with a high feed rate we always recommend our STABILO fine cut circular saw blade graduated on one or both sides. The STABILO blade profile developed specifically for fine cutting effectively compensates the laterally balanced relative strength which occurs when sawing consistent medium to high cutting heights with. This even allows minimal kerfs in fine cuts.

After increasing lumber yield in rough cutting, STABILO – the second time now – increases the recovery rate in fine cuts. Over the year you virtually benefit from this competitive edge in double.

Our tried and tested BASIC is excellent for trim cuts with low cutting heights and high feed rates. Our "SoWa Sawmill Optimised Tool Design" philosophy also applies here. It requires analysing your machine data, the desired feed rates, the cutting height of the primary product, as well as the type of wood to be cut for us to design a particularly efficient circular saw blade.

Take advantage of this development concept, since high-quality HDS-Sawmill Tools offer profitable advantages, shift after shift, day after day, and year after year!

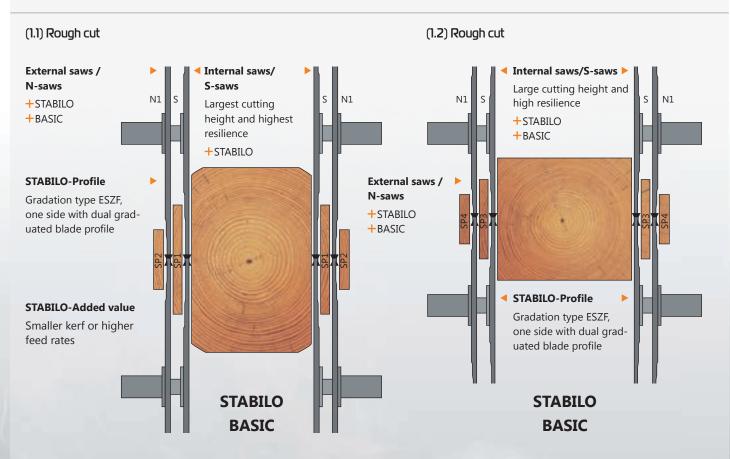


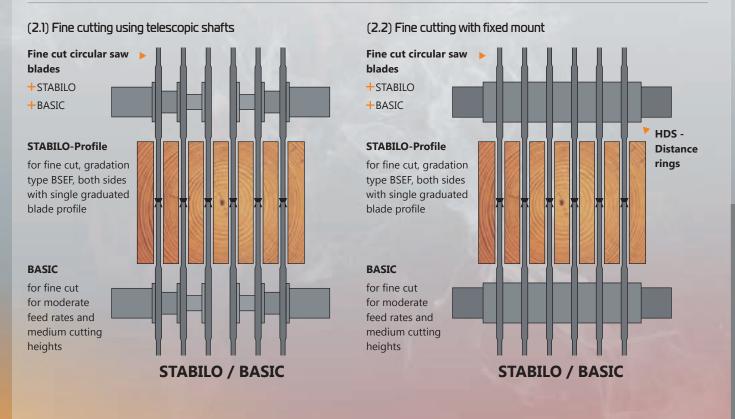




Profiler line with HDS circular saw blades



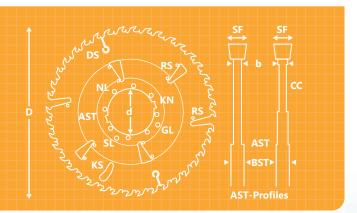




Body of circular saw blade

A circular saw blade for heavy duty use in sawmills is the result of constructing countless design characteristics to the exact conditions at your sawmill based on the specific cutting program, machine type and the type of wood. It requires a precise analysis of the application for us to design a circular saw blade optimal for its subsequent ap-

Here we will briefly introduce you to the key design characteristics of the saw body.



Surface style





Grinding style 🔺

Spiral style

Polished (optional) The surface finish is a result of the last step in machining the saw body. Here the grinding type design is our standard surface.

The resin-repelling spiral style reduces the contact area between the circular saw blade and the wood, which reduces heating.

Grinding and spiral style surfaces and additionally also be polished, making the surface even smoother and resin-repelling.

Coating

Surface



Oxide-coating is standard for our saw bodies. This makes the surface smoother, reducing frictional heat. This keeps the heating of the saw body low and it does not need to be overly compensated by internal tensioning. The stability and service life are increased whilst reducing the risk of deflection.

Similar advantages result from chrome plating, which further ensures a hard surface.

In conventional straight-set CV saws the highly stressed tooth flanks can be protected by an extremely hard chrome layer. The reduced wear also increases the service life.

Chip clearance slots

Our special HDS geometry of chip clearance slots and being TC-tipped reduces heating of the saw body. Our chip clearance slot shape is optimised so that little sawdust can collect. The mechanically machined contour of the chip clearance slot further adds to it.

Bore

Our circular saw blades are customised to you. We therefore customise the bore, key ways, pin holes, countersunk and threaded holes as well as the flange or collar diameter precisely to your machine type. These specifications alone impact the actual construction of the saw body and must be incorporated in the design.

Cylindrical bore



Spline bore 1



Spline bore 2

STABILO Hexa CC

Dimensions 510 x 4.7/3.5/4.9 x 150 mm

18 TCT teeth . Tooth form flat tooth . Tooth type 4 Plus Teeth

Hexa style with 6 chip clearance slots

Features AST Graduated Saw Blade Technology,

> gradation type ESEF one side with single gradation from 4.9 to 3.5 mm. CoolCut CC





STABILO for rough cut

Gradation type ESZI

Individual blade profile

The blade profile crucial for dynamic rigidity is calculated specifically to your cutting program according to "SoWa Sawmill Optimised Tool Design" for each STABILO circular saw blade, incorporating over 30 factors. Here we offer two basic designs, the blade profile graduated on one side or on both sides.

For rough cut: STABILO featuring one side with graduated blade profile

The profile with single or dual gradation on one side is usually used in rough cutting. The different cutting heights result in lateral, varying secondary forces. The blade profile gradation on one side compensates this imbalance so the extreme dynamic rigidity has a positive effect.

For fine cut: STABILO featuring both sides with graduated blade profile

The reduced and nearly even cutting heights in fine cutting result in a more balanced relative strength. The high dynamic rigidity also has an extremely positive effect here, allowing for a reduction of the kerf.

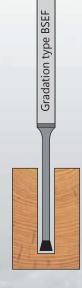
fine cut

STABILO for

+ Individual blade profile is crucial for the dynamic rigidity and is designed and calculated individually considering all factors

The HDS plus factors of STABILO

- + Smaller kerf or higher feed rate by dynamic rigidity of the tried and tested "AST Graduated Saw Blade Technology"
- + Energy saving compared to straight circular saw blades by reducing the kerf
- + Long service life due to the extremely massive saw body, hence suitable for several regeneration cycles
- + Reduced bearing load through the use of smaller distance rings
- + Lower level of heating in the tooth area, which is the thinnest area of the circular saw blade, thus minimising the frictional heat of sawdust
- + Chip clearance slots facing, protecting the collar from excessive heating, thus burns, on the model end



AST-Gradation types

ESEF: single gradation on one side ESZF: dual gradation on one side

AST-Gradation types

BSEF: single gradation on both sides BSZF: dual gradation on both sides

CoolCut CC

CoolCut >

Our BASIC and STABILO circular saw blades are available with "CoolCut" option on request. Here a slight reduction is added to the outside of the circular saw blade.

Just as AST, CoolCut provides thermal relief of the saw body, allowing a reduction in the kerf or selecting very high feed rates.

The reduction at the tooth base can be scaled back, enlarging the solder area for TCT and stellit teeth, thus ensuring more sturdy tooth tipping.

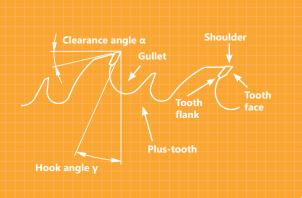
The "double CoolCut" option is available to increase the CoolCut effect.

double CoolCut dCC

Tooth geometry

There's a lot happening at the tooth area of a circular saw blade. The small tungsten carbide or stellit saw teeth chip away the shavings which then seemingly storm about the gullet, are again broken up by the Plus-tooth and then hastily ejected by the spin of the circular saw blade.

The better the cutting material, tooth form, tooth type and tooth geometry are coordinated for the subsequent application, the higher the performance of the circular saw blade.





Cutting materials

In the sawmill industry, tungsten carbide (TC), stellit (ST) and chromium-vanadium steel (CV) are three cutting materials used for saw teeth, where an inexpensive CV tooth comes directly from the straight-set circular saw body and therefore cannot be tipped. Available for HDS circular saw blades:

- + TC application-optimised tungsten carbide styles in three quality levels HWQ: HDS01 to HDS03
- + ST stellit, particularly tough and robust cutting material
- + CV chromium-vanadium steel for inexpensive straight-set standard circular saw blades



Tooth forms

HDS circular saw blades primarily feature universal, easy to sharpen flat teeth. Other shapes are available of special applications.

- + F Flat tooth
- W Alternate top bevel tooth
- + H Hollow tooth
- + TF Triple chip flat tooth
- + TT Triple chip triple chip tooth
- + FS Flat tooth with protective chamfer

General tooth types



General tooth types

In addition to tipping and the construction of the saw body, the tooth type is an important factor in optimising the cutting performance and cutting quality as well as stability and service life.

- + KV tooth type (peg tooth)
 Long- and cross-cut, tungsten carbide/stellit tipped
- PV tooth type (curved tooth)
 Long- and cross-cuts, primarily stellit tipped
- NV Tooth type (pointed tooth) mostly for cross-cuts and for straight-set circular saw blades

The KV tooth type was greatly modified for high-performance areas at the sawmill. This resulted in special, extremely powerful sawmill tooth types.

Saw tooth

STABILO Hexa CC

Dimensions 510 x 4.7/3.5/4.9 x 150 mm

Teeth 18 TCT teeth . Tooth form flat tooth . Tooth type 4 Plus

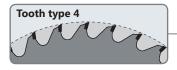
Hexa style with 6 chip clearance slots

Features AST Graduated Saw Blade Technology,

gradation type ESEF one side with single gradation from 4.9 to 3.5 mm . CoolCut CC

CIRCULAR SAW BLADES

TECHNOLOG



HDS-standard

Tooth type 4

The universal tooth type 4 suitable for rough and fine cuts as well as long and cross cuts is the standard tooth type and characterised by the particularly large gullet. The gullet is even able to collect and eject and adequate amount of sawdust with high feed rates or large cutting heights. The radial shape of the gullet aids in ejecting the sawdust.

Profile

- + Consistent tooth heights
- + Consistent pitch
- + Large gullet



HT High-Low

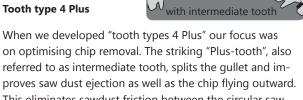
The modified tooth type 4 allows for different cutting heights to be processed with greatly varying feed rates using a single circular saw blade type. This eliminates the blade change and the associated set-up costs. It further reduces the expenditure of acquisition and storage, since a limited cutting area only uses one specific circular saw blade type. The tooth type therefore greatly contributes to the profitability of your production line.

Profile

- + Varying tooth heights
- + Consistent pitch
- + Large gullet

Sawmill tooth types

Tooth type 4 Plus



Tooth type 4 Plus

This eliminates sawdust friction between the circular saw blade and material being cut, as well as the sawdust clumping together in the gullet. Reducing the strain on the circular saw blade allows for a smaller kerf.

- + Consistent tooth heights
- + Consistent pitch
- + Plus-tooth for improved chip ejection & chipping



HT High-Low Plus

Profile

The "HT Plus" tooth type combines the strengths of HT teeth and the "Plus-tooth". On one hand this allows a wide range of different cutting heights and different feed rates to be processed without changing the circular saw blade, and on the other hand the intermediate tooth the improved sawdust ejection from the additional tooth in the gullet minimises the thermal strain on the circular saw blade.

Profile

- + Varying tooth heights
- + Consistent pitch
- + Plus-tooth for improved chip ejection & chipping



UZ Varying tooth pitch

The UZ tooth type is of particular interest for trim- and fine cutting units. The alternating tooth heights and the uneven pitch allow the UZ tooth type to be used efficiently for fine cuts for large cutting heights with low feed rates as well as for trimming with significantly lower cutting heights at high feed rates.

- + Varying tooth heights
- + Varying pitches
- + Large gullet



UZ Plus

Tooth type "UZ Plus" combines the advantages of this tooth type with the benefits of the "Plus-tooth". The effective chip ejection and the improved chip break reduce friction and heat so the circular saw blade allows a reduced kerf.

Profile

- Varying tooth heights
- Varying pitches
- Plus-tooth for improved chip

ejection & chipping

HDS CIRCULAR SAW BLADE

		BASIC	STABILO	TRIMCUT	CROSSCUT
sw SoWa		•	•		•
SAWMILL OPTIMISED TOOL DESIGN	Diameter max.	1.200 mm	900 mm	1.900 mm	2.800 mm
	Rough cut	0	•		
Application	Fine cut	•		0	
	Trimm/cross cut		0		
GRADUATED SAWGI ACK	AST one side				
GRADUATED SAW BLADE TECHNOLOGY AST	AST both sides		•		
	CoolCut CC		•		
CoolCut CC	double CoolCut dCC		•		
TCT Chip clearance slots	Without chip clearance slots	0	0	•	•
2 Duo / 3 Tria / 4 Tetra / 6 He	exa / 8 Octo / 10 Deka		•		
	Expansion slots		•		•
Vibration and Noise Reduction	Copper rivets	0		•	•
	Noise reduction slots	0		•	•
14/4	Tooth type 4		•		•
Sawmill tooth types	HT High-Low	0	0		
	UZ Variyng tooth pitch	0	0		
Plus-Tooth	Intermediate tooth ZZ	0	0		
W [//	CV chromium-vanadium	0		0	
	TC tungsten carbide	•	•	•	•
Cutting material	ST stellit	•	•	0	
	TC tipped insert				•
	Grinding style	•	•	•	•
Surface style	Spiral style	•	•	0	
	Polished	0	0	0	
	Oxide	•	•	•	
Surface coating	Chrome	0	0	0	

Very suitable / absolutely true

O Somewhat suitable / sometimes true

REGENERATION

A second life for your used sawmill tools

Used doesn't mean used up, since your sawmill tool can often be repaired or regenerated, which is much more economical compared to a new purchase.

Sawmill tools can be repaired to HDS quality standards straight at our factory. For particularly high quality circular saw blades, segments and sizing rings, usually equipped with a particularly robust "AST Graduated Saw Blade Technology" saw body, complete

regeneration is usually wise and offers great economic benefits. This process can be repeated several times, increasing the life of your sawmill tool by x-fold.

Let us repair or regenerate your sawmill tool. In most cases this will delay a new purchase and we will return your "used ones" like new!

ATTACHMENT

- + Dimensions
- + Operating times
- + Sharpening cycles
- + Regeneration cycles

SAWMILL

- Circular saw blades
- Segments
- Sizing rings
- Inserts

Regeneration

REVIEW

- + Chip characteristics
- + Wear level saw body
- + Wear level cutting material
- + Straightening state
- + Tensioning state

QUALITY CONTROL

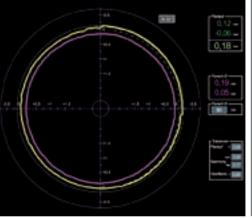
+ Inspect to HDS regeneration standards

REGENERATION

- 1. Sort and clean
- 2. Remove old cutting material
- 3. Prepare tip seat
- 4. Solder on new cutting material
- 5. Level and grind
- 6. Straight and tension









Our BASIC already defines the HDS quality standard

BASIC is the result of decades of experience which continuously impacted the development process of the technologies used. So you now have a highly optimised, and tried and tested circular saw blade with numerous optional refinements.

We already draw on the highest quality materials when manufacturing the saw body. The respective heat treatments we select support the high HDS standard.

BASIC is manufactured precisely to your needs, so every piece of information about the specific operating conditions at your sawmill impacts the construction of your BASIC.

The additional application of our CoolCut option further perfects the performance of the circular saw blade with regard to optimal chip transport, preventing excess heating, reducing the kerf, extending the service life and/or increasing the feed rate.

The HDS plus factors of BASIC

+ Extremely smooth running

Even our BASIC is extremely smooth running, achieved by incorporating the internal tensioning in the special saw body style. These exemplary running properties contribute to increasing the stability of the circular saw blade.

Deflection-free cuts

Even at a peak load our BASIC keeps its shape, since the optional expansion slots with optional end hole or expansion slots with copper rivets limit thermal expansion. This ensures deflection-free cuts.

+ Reduced blade heating

In most cases the BASIC blade features TCT chip clearance slots, significantly reducing heating of the saw body. Our special geometry and the machined contour of the chip clearance slots ensure very little sawdust collects.

+ Reduced kerf

Select the option "CoolCut" or "double CoolCut" to reduce the kerf. A reduction is then applied to the outside of the saw blade, reducing excessive heating to the point the overall construction can be designed with an even thinner kerf.

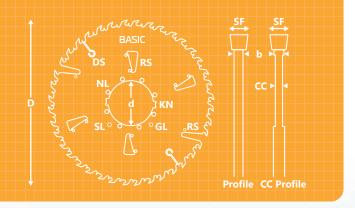






The "SoWa Sawmill Optimised Tool Design" make for maximum level circular saw blades for industrial sawmill use. Your circular saw blades are coordinated to your specific requirements and operating conditions. Using the technical data in our database and 3D CAD models production of your circular saw blades can always be automated and is reproducible.

b Saw body thickness . CC CoolCut . D Diameter . d Bore DS Expansion slot . GL Threaded hole . KN Key way . NL Pin hole RS Chip clearance slot . SF Kerf . SL Countersunk hole





BASIC

Dimensions 350.0 mm Diameter Kerf 4.8 mm Saw body thickness 3.2 mm Bore 100.0 mm

0 Key ways Pin-/countersunk holes

Cutting material TCT Number of teeth 62 Tooth form FS Tooth type 4

HDS-No. 15020

Features Expansion slots 4



BASIC

Dimensions 355.0 mm Diameter Kerf 3.2 mm Saw body thickness 2.2 mm Bore 75.0 mm Key ways 2+2 Pin-/countersunk holes

Cutting material TCT Number of teeth 40 Tooth form Tooth type 4

HDS-No. 14198

Features 4 **Expansion slots**



BASIC

Dimensions 445.0 mm Diameter 3.6 mm Kerf Saw body thickness 2.6 mm 80.0 mm Bore Key ways 0 Pin-/countersunk holes 6 **Cutting material** TCT Number of teeth 36 F Tooth form Tooth type

HDS-No. 13269

HDS-No. 15432

6+6

Cooling slots/holes



BASIC

Dimensions 610.0 mm Diameter 4.0 mm Saw body thickness 2.8 mm Spline-Bore 139.7 mm Pin-/countersunk holes 0

Cutting material TCT Features

Number of teeth 32 **Expansion slots** Tooth form Tooth type

TCT- and ST-Circular saw blades



HDS-No. 10868



BASIC Duo

Dimensions

Cutting material TCT

300.0 mm Diameter Kerf 3.6 mm Saw body thickness 2.4 mm 80.0 mm Bore Key ways 2+2 Pin holes 0

Number of teeth 16+2 Tooth form Tooth type 4



BASIC Duo

HDS-No. 13254

2

Dimensions Diameter 450.0 mm Kerf 4.6 mm Saw body thickness 3.2 mm Bore 105.0 mm Key ways 2+2 Pin-/countersunk holes

Cutting material TCT Number of teeth 44+2 Tooth form Tooth type 4 **Features**

Expansion slots



BASIC Tria

HDS-No. 14338

Dimensions 470.0 mm Diameter Kerf 3.2 mm Saw body thickness 2.0 mm Bore 150.0 mm Key ways 2+2 Pin-/countersunk holes

Cutting material TCT Number of teeth 30+3 Tooth form Tooth type



BASIC Tria

HDS-No. 14673

Dimensions Diameter 500.0 mm Kerf 5.8 mm Saw body thickness 4.0 mm Bore 140.0 mm Key ways 0 Pin-/countersunk holes

Cutting material ST Number of teeth 48+3 Tooth form W Tooth type



BASIC Tria Plus

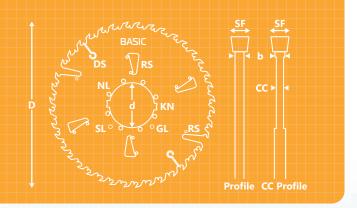
HDS-No. 10077

Dimensions Diameter 535.0 mm 2.8 mm Saw body thickness 1.8 mm 150.0 mm Bore Pin-/countersunk holes

Cutting material TCT Number of teeth 36+3 Tooth form Tooth type 4 Plus

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b Saw body thickness . CC CoolCut . D Diameter . d Bore
DS Expansion slot . GL Threaded hole . KN Key way . NL Pin hole
RS Chip clearance slot . SF Kerf . SL Countersunk hole



Features

Bevelled gullet



BASIC Tetra

Dimensions
Diameter 470.0 mm
Kerf 5.0 mm
Saw body thickness 3.4 mm
Bore 130.0 mm
Key ways 2
Pin-/countersunk holes 12

Cutting material TCT
Number of teeth 52+4
Tooth form W
Tooth type 4

HDS-No. 15416



BASIC Tetra Plus

Dimensions

Diameter 490.0 mm
Kerf 4.4 mm
Saw body thickness 3.0 mm
Bore 150.0 mm
Key ways 2+2
Pin-/countersunk holes 0

Cutting materialTCTNumber of teeth36+4Tooth formFTooth type4 Plus

HDS-No. 16885

HDS-No. 10423



BASIC Tetra Plus

Dimensions

 $\begin{array}{ccc} {\rm Diameter} & 507.0 \ {\rm mm} \\ {\rm Kerf} & 5.0 \ {\rm mm} \\ {\rm Saw body thickness} & 3.6 \ {\rm mm} \\ {\rm Bore} & 120.0 \ {\rm mm} \\ {\rm Key ways} & 0 \\ {\rm Pin holes} & 2 \ {\rm x \ oval+4} \\ \end{array}$

Cutting materialTCTNumber of teeth18+4Tooth formFTooth typePV Plus



BASIC Hexa Plus

Dimensions

Diameter 450.0 mm

Kerf 4.4 mm

Saw body thickness 3.0 mm

Bore 115.2 mm

Key ways 0

Pin-/countersunk holes 2+16

Cutting materialTCTNumber of teeth30+6Tooth formFTooth type4 Plus

HDS-No. 15454

TCT- and ST-Circular saw blades





BASIC Hexa Plus

HDS-No. 10413

Dimensions		Cutting material
Diameter	490.0 mm	Number of teeth
Saw body thickness	5.6 mm	Tooth form
Kerf	4.2 mm	Tooth type
Bore	150.0 mm	

ber of teeth 36+6 h form h type 4 Plus

TCT

Key ways 2+2 Pin-/countersunk holes



BASIC Hexa dCC Plus

HDS-No. 14287

Features

Features

Expansion slots

Expansion slots

Dimensions Diameter 545.0 mm Kerf 4.6 mm Saw body thickness 3.1 mm Bore 150.0 mm Key ways 2+2 **Cutting material TCT** Number of teeth 18+6 Tooth form Tooth type 4 Plus

double CoolCut dCC



BASIC Hexa Plus

Pin-/countersunk holes

HDS-No. 11264

Dimensions Diameter 550.0 mm Kerf 4.8 mm Saw body thickness 3.4 mm 60.0 mm Bore Key ways Pin-/countersunk holes 0

Cutting material TCT Number of teeth 24+6 Tooth form Tooth type 4 Plus



BASIC Octo dCC Plus

HDS-No. 13817

Dimensions	
Diameter	780.0 mm
Kerf	6.0 mm
Saw body thickness	4.1 mm
Bore	160.0 mm
Key ways	2
Pin-/countersunk holes 6	

Cutting material TCT 20+8 Number of teeth Tooth form W Tooth type 4 Plus

double CoolCut dCC



BASIC Deka

HDS-No. 11162

Dimensions		
Diameter	695.0	mm
Kerf	5.9	mm
Saw body thickness	4.0	mm
Bore	120.0	mm
Key ways		0
Pin-/countersunk h	oles	8

Cutting material 28+10 Number of teeth Tooth form Tooth type



CIRCULAR SAW BLADES

STABILO CIRCULAR SAW BLADES



STABILO. Graduated to the advanced technology saw class

Developing the Graduated Saw Blade Technology AST first allowed sawmills to optimise their productivity long term. Now, high-capacity reducing and profiling lines primarily use the Graduated Saw Blade Technology AST.

The striking STABILO circular saw blades allow for small kerfs in rough and fine cutting, particularly with markedly high feed rates and large cutting heights, and feature a high durability to

convince you. Renowned machine manufacturers therefore equip their particularly strong rough cutting aggregates, and increasingly even fine cutting units, with graduated circular saw blades. Just as our BASIC circular saw blades, we can additionally integrate CoolCut into the STABILO graduated blade profile.

The HDS plus factors of STABILO

Individual blade profile

No two STABILO are alike, since each circular saw blade has a custom blade profile taking your cutting program into account, with single or dual gradation on one or both sides. This always ensures the optimal dynamic rigidity which the outstanding performance of the STABILO class is based on.

+ Reduced kerf or increased feed rate

The particularly high dynamic rigidity of the core achieved using the Graduated Saw Blade Technology yields two particularly beneficial options. For one, the kerf can be reduced whilst maintaining the feed rate, and on the other hand the feed rate can be reduced whilst maintaining the kerf. Both result in a significant increase in efficiency.

+ Energy saving

Compared to a straight circular saw blade, STABILO is a true energy saved, since the kerf reduction generates less pressure, which in turn results in energy savings for you.

+ Long service life

The name "STABILO" alone suggests the extremely solid and robust saw body, which in and of itself already means a long life and further allows for multiple regenerations.

+ Low level of heating

With the thinnest point of the STABILO circular saw blade being at the tooth area, the frictional heat generated by sawdust here is reduced significantly. This factor, which is so critical in stability, can be further enhanced by the CoolCut option.

Chip clearance slots facing

The STABILO can optionally also use facing chip clearance slots, which protects the collar from excessive heating, thus burns, on the model end.

+ Reduced bearing load

Using smaller distance rings significantly reduces strain on the bearing load on the shaft. In addition it makes it easier to handle when changing the circular saw blade, since it only requires distance rings in the machine flange diameter.



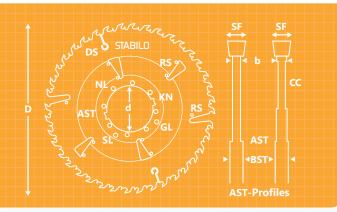






Our "SoWa Sawmill Optimised Tool Design" ensures you will have a top class STABILO circular saw blade customised for industrial use at your sawmill. Here we draw on our decades of experience and incorporate every single detail of your requirements such as machine model, cutting program, and the type of wood. This optimisation process ensures you receive a STABILO which is best matched to your cutting production, thus extremely efficient.

b Saw body thickness . BST Collar thickness . CC CoolCut . D Diameter d Bore . DS Expansion slot . GL Threaded hole . KN Key way NL Pin hole . RS Chip clearance slot . SF Kerf . SL Countersunk hole





STABILO Tetra CC

2 IABILO TELLA CC

Diameter 490.0 mm

Kerf 3.3 mm

Saw body thickness 2.3 mm

Bore 150.0 mm

Key ways 2+2

Pin-/countersunk holes 0

Cutting material	ST
Number of teeth	32+4
Tooth form	F
Tooth type	4

CoolCut CC





STABILO Tetra dCC

Dimensions

Dimensions

Diameter 520.0 mm

Kerf 4.0 mm

Saw body thickness 2.6 mm

Bore 125.0 mm

Key ways 0

Pin-/countersunk holes 4+8

Cutting materialTCTNumber of teeth36+4Tooth formWTooth type4

double CoolCut dCC

HDS-No. 13617

HDS-No. 14899

AST-Type	ESEF
Collar diameter	190.0 mm
Collar thickness	6.0 mm
Features	
Expansion slots	2



STABILO Tetra

Dimensions

Diameter 540.0 mm
Kerf 4.0 mm
Saw body thickness 2.6 mm
Bore 150.0 mm
Key ways 2+2
Pin-/countersunk holes 0

Cutting materialTCTNumber of teeth18+4Tooth formFTooth type4

AST-Type BSEF
Collar diameter 260.0 mm

Collar thickness

Features
Expansion slots

4.0 mm

HDS-No. 13029



STABILO Tetra

Dimensions

Diameter 540.0 mm

Kerf 3.6 mm

Saw body thickness 2.3 mm

Bore 150.0 mm

Key ways 2+2

Pin-/countersunk holes 0

Cutting material TCT Number of teeth 46+4 Tooth form F Tooth type 4

AST-Type ESEF

Collar diameter 324.0 mm

Collar thickness 4.6 mm

CoolCut CC



TCT- and ST-Circular saw blades



HDS-No. 11657

HDS-No. 13745

HDS-No. 16452

HDS-No. 14316



STABILO Hexa

Pin-/countersunk holes

Dimensions

Diameter

Key ways

Pin holes

Key ways

Kerf

Bore Key ways

Cutting material TCT 505.0 mm Number of teeth 38+6 5.0 mm Tooth form Tooth type Saw body thickness 3.6 mm

ESEF AST-Type Collar diameter 285.0 mm Collar thickness 6.8 mm



STABILO Hexa CC Plus

2 oval + 4 SL

120.0 mm

Dimensions Cutting material TCT 505.0 mm Diameter Number of teeth 24+6 Kerf 5.4 mm Tooth form Saw body thickness 3.8 mm Tooth type PV Plus Bore 120.0 mm

AST-Type ESEF Collar diameter 190.0 mm Collar thickness 6.8 mm **Features Expansion slots** 2





STABILO Hexa Plus

Dimensions Cutting material TCT Diameter 507.0 mm Number of teeth 18+6 Kerf 5.2 mm Tooth form Saw body thickness 3.65 mm 4 Plus Tooth type 120.0 mm Bore

AST-Type ESZF Collar diameter 186.5 mm Collar thickness 6.8 mm **Features Expansion slots** 2



STABILO Hexa CC

Pin-/countersunk holes 4+8

Dimensions Diameter 540.0 mm Kerf 5.0 mm Saw body thickness 3.7 mm 160.0 mm Bore Key ways Pin-/countersunk holes

Cutting material TCT Number of teeth 50+6 Tooth form Tooth type

AST-Type ESEF Collar diameter 310.0 mm Collar thickness 6.8 mm





STABILO Hexa CC Plus

Dimensions Cutting material TCT Diameter 540.0 mm Number of teeth 46+6 4.0 mm Tooth form 2.5 mm Tooth type 4 Plus Saw body thickness Bore 150.0 mm

CoolCut CC

HDS-No. 11478 **ESFE**

285.0 mm

4.5 mm

AST-Type

Collar diameter

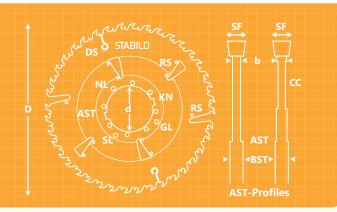
Collar thickness

Pin-/countersunk holes



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b Saw body thickness . BST Collar thickness . CC CoolCut . D Diameter d Bore . DS Expansion slot . GL Threaded hole . KN Key way NL Pin hole . RS Chip clearance slot . SF Kerf . SL Countersunk hole





STABILO Hexa

Dimensions

Diameter 565.0 mm
Kerf 5.2 mm
Saw body thickness 3.4 mm
Bore 160.0 mm
Key ways 2
Pin-/threaded holes 6+12

Cutting materialTCTNumber of teeth42+6Tooth formFTooth type4

AST-Type BSEF
Collar diameter 205.0 mm
Collar thickness 7.0 mm
Features

HDS-No. 11614

HDS-No. 15320

HDS-No. 13999

reatures

Expansion slots 2



STABILO Hexa CC

Dimensions

Diameter 570.0 mm

Kerf 2.7 mm

Saw body thickness 1.7 mm

Bore 150.0 mm

Key ways 2+2

Pin-/countersunk holes 0

Cutting materialTCTNumber of teeth57+6Tooth formFTooth type4

AST-Type ESEF
Collar diameter 425.0 mm
Collar thickness 4.1 mm

CoolCut CC



STABILO Hexa CC

Dimensions

Diameter 585.0 mm
Kerf 5.0 mm
Saw body thickness 3.6 mm
Bore 145.0 mm
Key ways 0
Pin-/countersunk holes 16

Cutting materialTCTNumber of teeth18+6Tooth formFTooth type4

AST-Type ESEF
Collar diameter 200.0 mm
Collar thickness 6.0 mm
Features
Expansion slots 2

CoolCut CC



STABILO Hexa

Dimensions

Diameter 643.0 mm
Kerf 5.8 mm
Saw body thickness 3.8 mm
Bore 160.0 mm
Key ways 2
Countersunk-/
threaded holes 6+12

HDS-No. 10930

ΖF

nm

nm

Cutting material	TCT	AST-Type	ESZ
Number of teeth	24+6	Collar diameter	205.0 m
Tooth form	F	Collar thickness	7.0 m
Tooth type	4		



TCT- and ST-Circular saw blades





STABILO Octo dCC

HDS-No. 14045

Dimensions	
Diameter	555.0 mm
Kerf	5.5 mm
Saw body thicknes	s 4.1 mm
Bore	120.0 mm
Key ways	0
Pin-/countersunk h	noles 8

Cutting material	TCT	AST	
Number of teeth	20+8	Colla	
Tooth form	F	Colla	
Tooth type	4		
CoolCut dCC			

AST-Type ESEF
Collar diameter 220.0 mm
Collar thickness 7.0 mm



STABILO Octo dCC Plus

HDS-No. 10014

Dimensions	
Diameter	595.0 mm
Kerf	5.4 mm
Saw body thickness	4.2 mm
Bore	150.0 mm
Key ways	0
Countersunk-/	
threaded holes	6+6

Cutting material	TCT	AS
Number of teeth	22+8	Co
Tooth form	F	Co
Tooth type	4 Plus	

AST-Type ESEF
Collar diameter 200.0 mm
Collar thickness 7.2 mm





STABILO Octo

HDS-No. 12190

Dimensions	
Diameter	630.0 mm
Kerf	5.4 mm
Saw body thickness	s 3.8 mm
Bore	150.0 mm
Key ways	2
Pin-/threaded hole	s 2+8

Cutting material	TCT
Number of teeth	20+8
Tooth form	F
Tooth type	4

AST-Type ESZF
Collar diameter 200.0 mm
Collar thickness 7.0 mm



STABILO Deca Plus

HDS-No. 11235

Dimensions		Cutting material	тст	AST-Type	ESZF
Diameter	648.0 mm	Number of teeth	14+10	Collar diameter	220.0 mm
Kerf	5.4 mm	Tooth form	W	Collar thickness	6.8 mm
Saw body thickness	ss 3.65 mm	Tooth type	4 Plus	Features	
Bore	160.0 mm			Expansion slots	2
Key ways	0				
Pin-/countersunk l	holes 8				







Dimensions

660 v 6 0 / 4 5 v 3 0 mm

Tooth

80 TCT teeth . Tooth form alternate top bevel tooth

Tooth type 4

Features

5 expansion slots

9 noise reduction slots

TRIMCUT CIRCULAR SAW BLADES

Trimmed for cutting precision and stability

TRIMCUT is a very robust circular saw blade designed specifically for trimming. TRIMCUT delivers outstanding cutting precision with particularly high stability in trimming square timber and slab timber as well as trimming round timbers.

Along with it, the special saw body and the purposefully incorporated internal tension ensure extremely smooth operation. With the tooth geometry adapted specifically for trimming and cross cutting prevent the bottom of the wood from fraying.

The expansion slots near the tooth area, copper riveted or with end hole, prevent deflection of the circular saw blade on heating, ensuring maximum cutting precision. Additional, optionally copper riveted, vibration-reducing laser patterns in the saw body ensure lasting noise reduction.

The HDS plus factors of TRIMCUT

+ Extremely smooth running

The internal tensioning incorporated into the special saw body styles is the reason for the extremely smooth operation of TRIMCUT. And the smoothness has a positive impact on the stability of the circular saw blade.

+ Tear-free cutting results

Torn edges are a thing of the past; our TRIMCUT not only cuts the top but also the bottom clean without tearing, guaranteeing a perfect cut in trimming and cutting to length.

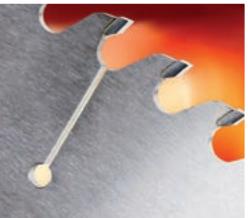
+ Deflection-free cuts

Even with the circular saw blade running at maximum load at full speed and expanding from the frictional heat which occurs, expansion slots with end holes or optionally copper riveted, keep TRIMCUT in shape. This effectively eliminates the risk of deflection.

+ Maximum noise reduction

Riveted laser patterns specifically spread across the saw body and directly absorbing the majority of vibration responsible for the noise level, ensure noise reduction.



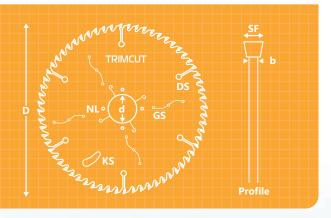




Our "SoWa Sawmill Optimised Tool Design" ensures you will receive a TRIMCUT customised to your specific requirements.

When designing the blade, in addition to the technical characteristics such as machine model, bore and bore pattern, we particularly incorporate your desired cutting quality. Your TRIMCUT will therefore provide maximum efficiency cuts at your sawmill.

b Saw body thickness . D Diameter . d Bore . DS Expansion slot GS Noise reduction slot . KS Cooling slot . NL Pin hole . SF Kerf



with copper rivet

Cooling slots



TRIMCUT

Dimensions
Diameter 550.0 mm
Kerf 4.0 mm
Saw body thickness 2.8 mm
Bore 30.0 mm
Key ways 0
Pin-/countersunk holes 0

Cutting material	тст	Features
Number of teeth	96	Expansion slots
ooth form	W	with copper rivet
ooth type	4	Noise reduction slots



TRIMCUT

Dimensions
Diameter 600.0 mm
Kerf 5.7 mm
Saw body thickness 4.0 mm
Bore 30.0 mm
Key ways 0
Pin-/countersunk holes 4

Cutting material	TCT
Number of teeth	108
Tooth form	W
Tooth type	PV

HDS-No. 13968

HDS-No. 12193

6

0

12

0

0

Features	
Expansion slots	8
with copper rivet	0
Noise reduction slots	4
with copper rivet	0
Cooling slots	0

CIRCULAR SAW BLADES



TRIMCUT CIRCULAR SAW BLADES

TCT- and ST-Circular saw blades



HDS-No. 11604

HDS-No. 12081

HDS-No. 13249



TRIMCUT

DimensionsDiameter600.0 mmKerf5.6 mmSaw body thickness4.0 mmBore30.0 mmKey ways0Pin-/countersunk holes0

Cutting material	TCT	Features	
Number of teeth	102	Expansion slots	6
Tooth form	F	with copper rivet	6
Tooth type	4	Noise reduction slots	12
		with copper rivet	0
		Cooling slots	0



TRIMCUT

Dimensions
Diameter 650.0 mm
Kerf 5.8 mm
Saw body thickness 4.0 mm
Bore 30.0 mm
Key ways 0
Pin-/countersunk holes 2

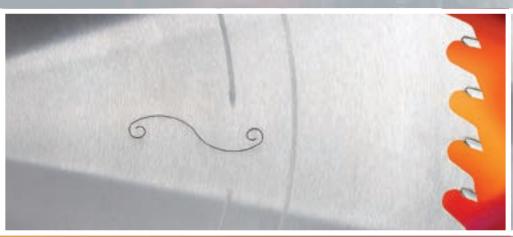
Cutting material	TCT	Features	
Number of teeth	72	Expansion slots	6
Tooth form	W	with copper rivet	0
Tooth type	4	Noise reduction slots	0
		with copper rivet	0
		Cooling slots	6

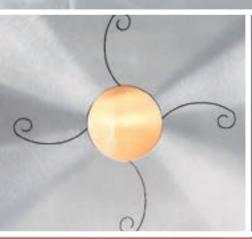


TRIMCUT

DimensionsDiameter730.0 mmKerf6.5 mmSaw body thickness4.6 mmBore30.0 mmKey ways0Pin-/countersunk holes2

Cutting material	TCT	Features	
Number of teeth	96	Expansion slots	6
Tooth form	W	with copper rivet	0
Tooth type	4	Noise reduction slots	0
		with copper rivet	0
		Cooling slots	0







CROSSCUT

2000 x 12.90/9.0 x 75 mm

66 interchangeable TCT inserts
Tooth form Hollow tooth . Tooth type 4

6 expansion slots with copper rivets 6 noise reduction slots with copper rivets

CIRCULAR SAW BLADES

CROSSCUT CIRCULAR SAW BLADES

Designed for rough log yard applications

CROSSCUT is designed for log yard chopping using interchangeable tungsten carbide tipped inserts. The standard hollow-ground tungsten carbide tooth has a cutting width of 12.9 mm. Varying inserts with ground bevel angle, yielding the classic Alternate Top Bevel tooth, may optionally be used.

Its robust 9 mm thick saw body ensures the CROSSCUT also remains stable under cross forces. It is further true-running and smooth, yielding a significantly longer service life.

The positive locking saw body connection with only one rivet each delivers quick and easy inserts changes. Copper riveted expansion slots and triple copper riveted, vibration-reducing laser patterns yield maximum noise reduction.

The HDS plus factors of CROSSCUT

+ Improved performance under cross-forces

The very robust, 9 mm thick saw body style increases stability to cross-forces which may occur in chopping. Its stability allows CROSSCUT to effectively absorb these impacts.

+ Improved true-running precision

The single piece inserts milled using CNC precision, which accurately fit the precisely milled pockets in the saw body with guide, result in particularly high accuracy, ensuring improved true-running. This significantly extends the service life of CROSSCUT.

Quick and easy tooth carrier unriveting

Only one copper rivet guarantees the positive locking saw body connection of each individual inserts. This allows for quick and easy inserts changes.

+ Maximum noise reduction

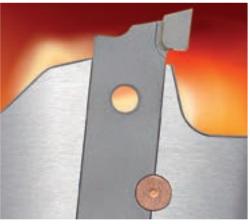
The expansion slots with copper rivets at the end and the triple copper riveted laser patterns, which effectively absorb a majority of the vibration which occurs, effectively lessen noise in the CROSSCUT.

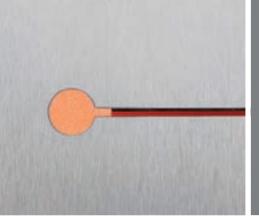
+ HDS-Regeneration

We will regenerate your inserts to our strict quality specifications or – in a hurry – we will exchange them for regenerated inserts.

We manufacture CROSSCUT saw blades Springer, Holtec, and Linck machines, among others.



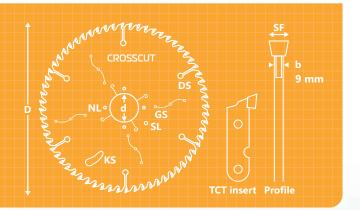




Our "SoWa Sawmill Optimised Tool Design" ensures you receive a CROSSCUT customised for use in your log yard.

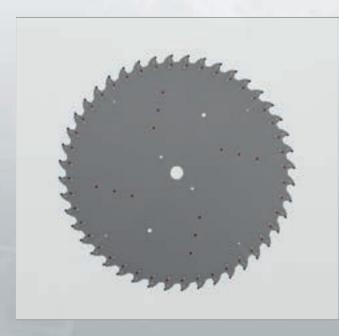
The design not only incorporates the technical characteristics such as machine model, bore and bore pattern, but of course also the logs which will be cut. The robust CROSSCUT therefore "works" with exceptionally high stability.

b Saw body thickness . D Diameter . d Bore . DS Expansion slot GS Noise reduction slot . KS Cooling slot . NL Pin hole . SF Kerf SI Countersunk hole

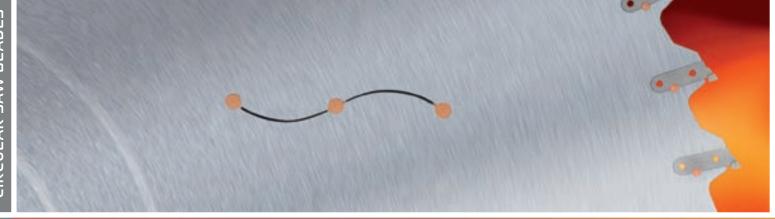


TCT-Circular saw blades





CROSSCU		HDS-No.	1086
Dimensions		Cutting material	тст
Diameter	1300.0 mm	Number of teeth	44
Kerf	12.9 mm	Tooth form	Н
Saw body thickness	s 9.0 mm	Tooth type	4
Bore	75.0 mm	71	
Key ways	0		
Pin-/countersunk l	noles 2		
Features			
Expansion slots	4	Noise reduction slots	4
with copper rivet	4	with copper rivet	4
Cooling slots	0		



TCT-Circular saw blades

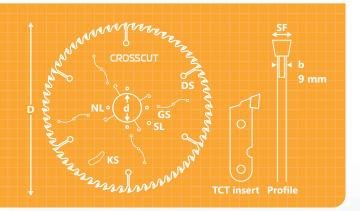




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The design not only incorporates the technical characteristics such as machine model, bore and bore pattern, but of course also the logs which will be cut. The robust CROSSCUT therefore "works" with exceptionally high stability.

b Saw body thickness . D Diameter . d Bore . DS Expansion slot GS Noise reduction slot . KS Cooling slot . NL Pin hole . SF Kerf SL Countersunk hole



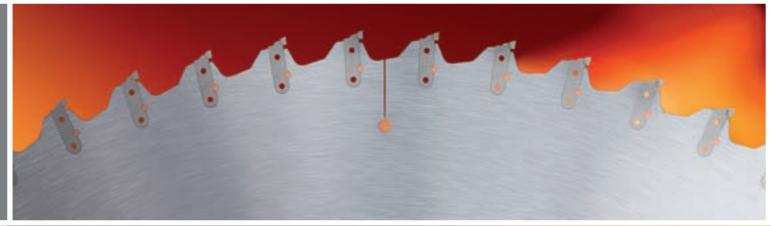
TCT-Circular saw blades





CROSSCUT HDS-No. 11736 Dimensions **Cutting material** TCT Diameter 2000.0 mm Number of teeth 66 Kerf 12.9 mm Tooth form Н Saw body thickness 9.0 mm Tooth type 75.0 mm Bore Key ways 0 Pin-/countersunk holes 2 **Features Expansion slots** 6 Noise reduction slots with copper rivet with copper rivet 6 Cooling slots

Standard-Dimension for Springer



TCT-Circular saw blades

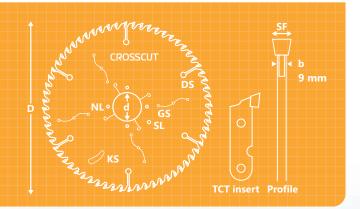




Our "SoWa Sawmill Optimised Tool Design" ensures you receive a CROSSCUT customised for use in your log yard.

The design not only incorporates the technical characteristics such as machine model, bore and bore pattern, but of course also the logs which will be cut. The robust CROSSCUT therefore "works" with exceptionally high stability.

b Saw body thickness . D Diameter . d Bore . DS Expansion slot GS Noise reduction slot . KS Cooling slot . NL Pin hole . SF Kerf



TCT-Circular saw blades





CROSSCUT

Dimensions 2500.0 mm Diameter Kerf 12.9 mm Saw body thickness 9.0 mm Bore 120.0 mm Key ways Pin-/countersunk holes 1+6

Features

with copper rivet Cooling slots

HDS-No. 10464

Cutting material TCT Number of teeth 88 Tooth form Н Tooth type 4

Expansion slots 8 8

Noise reduction slots 4 4 with copper rivet



CROSSCUT

HDS-No. 15434 TCT **Cutting material**

Dimensions	
Diameter	2500.0 mm
Kerf	14.0 mm
Saw body thi	ckness 9.0 mm
Bore	120.0 mm
Key ways	0
Pin-/counters	sunk holes 12+3

Number of teeth	
Tooth form	
Tooth type	

90 Н

4

Features

Expansion slots with copper rivet 6 Cooling slots

Noise reduction slots	
with comparation	

3 with copper rivet

TCT-Insert

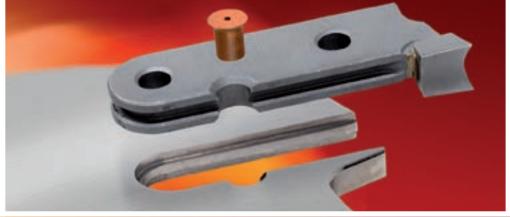
	TCT-Insert			TCT-Insert	
	Kerf	12.9 mm		Kerf	14.0 mm
	Tooth form	Н		Tooth form	Н
	Saw body	9 mm		Saw body	9 mm
Vice.	System	HDS		System	HDS
	HDS-No.	10117		HDS-No.	13455
	TCT-Insert			TCT-Insert	
	Kerf	13.0 mm		Kerf	13.0 mm
	Tooth form	W left		Tooth form	W right
	Saw body	9 mm		Saw body	9 mm
	System	HDS	1100000	System	HDS
	HDS-No.	12682		HDS-No.	12681
	TCT-Insert			Hollow rivet system	HDS
	Kerf	12.9 mm		Length	11 mm
000	Tooth form	Н		Diameter	8 mm
	Saw body	7 mm		Saw body	9 mm
	System	Felde	8 11	HDS-No. Copper	10118
	HDS-No.	11229		Steel	26057

REGENERATION

A second life for your used inserts

Used doesn't mean used up, since your insert can often be repaired or regenerated, which is much more economical compared to a new purchase.

Let us repair or regenerate your insert. In most cases this will delay a new purchase and we will return your "used ones" like new!







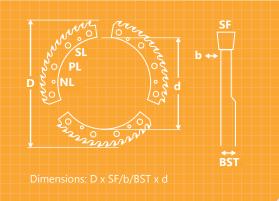


CHIPPER SEGMENTS AND SIZING RINGS

The same quality parameters as for our tried and tested circular saw blades also apply to chipper segments and sizing rings. Only high-quality tool steels are used, ensuring the segments and sizing rings feature the required stability. Of course they can also be regenerated.

They are manufactured conventionally with straight saw body, same as our BASIC circular saw blades, or with gradation and thinner blade at the tooth area.

b Saw body thickness . BST Collar thickness . D Diameter . d Bore NL Pin hole . PL Fit hole . SF Kerf . SL Countersunk hole





CHIPPER SEGMENTS AND SIZING RINGS

L left and/or R right Chipper segments and sizing rings **TCT-Sizing ring for HewSaw TCT-Sizing ring for SAB** $|R\rangle$ $|R\rangle$ 345 x 5.0/4.0/10.7 x 144 mm, Z36 480 x 5.0/4.0/6.0 x 330 mm, Z60 AST: from Ø 276 mm one side grada-AST: from Ø 400 mm one side gradation to 4.0 mm. tion to 4.0 mm, 18 countersunk holes 10 threaded holes M16 11 mm one side HDS-No. 24200 R HDS-No. 16939 R HDS-No. 24199 L HDS-No. 16938 L **TCT-Sizing ring for EWD TCT-Sizing ring for EWD** $\langle L \rangle$ $|R\rangle$ $\langle L \rangle$ $|R\rangle$ 555 x 5.8/5.0 x 450 mm, Z22 555 x 6.2/5.0 x 450 mm, Z19 6 countersunk holes 16 mm 6 countersunk holes 16 mm both sides both sides HDS-No. 11664 HDS-No. 10547 **TCT-Sizing ring for Linck TCT-Sizing ring for SAB** $|R\rangle$ $|R\rangle$ 570 x 4.5/3.5 x 430 mm, Z12 630 x 4.0/3.0/6.0 x 480 mm, Z72 19 countersunk holes 11 mm one side, AST: from Ø 550 mm one side grada-3 pin holes 19 mm tion to 3.0 mm, 18 countersunk holes 11 mm one side HDS-No. 17227 R HDS-No. 18220 R HDS-No. 17226 L HDS-No. 18219 L **TCT-Sizing ring for Linck TCT-Sizing ring for Linck** $|R\rangle$ 728 x 4.5/3.5 x 590 mm, Z14 850 x 4.5/3.5/6.0 x 695 mm, Z78 18 countersunk holes 11.5 mm one AST: from Ø 804 mm one side gradation to 3.5 mm, 30 countersunk holes, side, 4 pin holes 20 mm 18 pin holes HDS-No. 11033 R HDS-No. 11744 R HDS-No. 11034 L HDS-No. 11743 L **TCT-Sizing ring for Linck TCT-Sizing ring for Linck** $|R\rangle$ 850.5 x 4.5/3.5 x 697.04 mm, Z13 858 x 4.5/3.5/7.4 x 695 mm, Z60 17 countersunk holes 11 mm AST: from Ø 804 mm one side gradaone side, 3 pin holes 20 mm tion to 3.5 mm, 36 countersunk holes, 15 pin holes HDS-No. 15549 R HDS-No. 11364 R HDS-No. 11363 L HDS-No. 15547 L

SoWa Sawmill Optimised Tool Design

All HDS-Sawmill Tools pass through our "SoWa Sawmill Optimised Tool Design". Your chipper segments and sizing rings therefore precisely match the application in your sawmill. In addition, once we have designed and manufactured sawmill tools for you, manufacturing in the future can be automated and reproducible with the same quality.

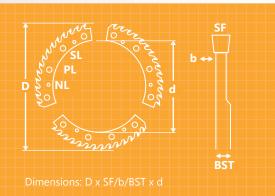


CUTTER SEGMENTS AND SIZING CUTTERS

We supply HDS cutter segments with straight saw body or gradation style with the blade thinner at the tooth area. Of course all segments are designed and manufactured to our strict quality parameters.

Once your cutter segments manufactured for you have been added to our database, we can supply you with segments at any time, automated and with reproducible quality. We therefore guarantee outstanding and consistent product quality.

b Saw body thickness . BST Collar thickness . D Diameter . d Bore





CUTTER SEGMENTS AND SIZING CUTTERS

Cutter segments and sizing cutters $\mathbb{R} \setminus \mathbb{O}$ top right and $\langle L \mid U \rangle$ bottom left $\mathbb{R} \setminus \mathbb{U}$ bottom right and $\langle L \mid \mathbb{O} \rangle$ top left TCT-Sizing cutter for HewSaw **TCT-Sizing cutter for HewSaw** \mathbb{R} R O 316 x 4.0/3.5/6.9 x 70 mm, Z28 316 x 4.2/3.5/6.9 x 70 mm, Z30 AST: from Ø 256 mm one side AST: from Ø 256 mm one side graduated to 3.5 mm, 2 key ways, graduated to 3.5 mm, 1 key way 4 pin holes 26.2 mm HDS-No. 11770 RO/LU HDS-No. 25334 RO/LU (L [U] $\langle L | U \rangle$ HDS-No. 11772 RU/LO HDS-No. 25335 RU/LO TCT-Sizing cutter for HewSaw **TCT-Cutter segment for EWD** R0 \mathbb{R} 330 x 4.2/3.5/6.9 x 70 mm, Z35 360 x 4.8/3.6 x 184 mm, Z12 AST: from Ø 266 mm one side 2 pin holes 17 mm graduated to 3.5 mm, 1 key way HDS-No. 25582 RO/LU (L [U] HDS-No. 25583 RU/LO \mathbb{R} \mathbb{U} HDS-No. 12185 RU/LO + RO/LU **TCT-Cutter segment for Linck TCT-Cutter segment for Linck** (L 0 401 x 3.5/2.5/8.0 x 200.4 mm, Z10 403 x 4.5/3.5/5.0 x 305 mm, Z10 AST: from Ø 350 mm one side AST: from Ø 366 mm one side graduated to 2.5 mm, 3 pin holes graduated to 2.5 mm, 4 countersunk 11 mm one side flat countersink holes 12 mm one side HDS-No. 10342 RU/LO HDS-No. 11623 RU/LO RU HDS-No. 10305 RO/LU RU HDS-No. 11622 RO/LU **TCT-Cutter segment for Linck TCT-Cutter segment for Linck** 411 x 4.0/3.0/5.0 x 317 mm, Z7 411.5 x 3.5/2.5/8.0 x 210 mm, Z10 AST: from Ø 361 mm one side AST: from Ø 354 mm one side graduated to 3.0 mm, 4 countersunk graduated to 2.5 mm, 5 pin holes holes 12 mm one side 9 mm one side flat countersink HDS-No. 10808 RU/LO HDS-No. 11192 RU/LO R U HDS-No. 10807 RO/LU R U HDS-No. 11191 RO/LU **TCT-Cutter segment for Linck HW-Cutter segment für Linck** 413.5 x 3.5/2.5/7.0 x 202 mm, Z9 414 x 3.5/2.5/7.0 x 202 mm, Z11 AST: from Ø 372 mm one side AST: from Ø 372 mm one side graduated to 2.5 mm, 5 pin holes graduated to 2.5 mm, 5 pin holes 9 mm one side flat countersink 9 mm one side flat countersink HDS-No. 13893 RU/LO HDS-No. 19831 RU/LO HDS-No. 13894 RO/LU \mathbb{R} \mathbb{U} \mathbb{R} \mathbb{U} HDS-No. 19832 RO/LU **HW-Cutter segment for Linck HW-Cutter segment for Linck** 414 x 3.5/2.5/8.0 x 210 mm, Z10 415 x 3.5/2.5/8.0 x 210 mm, Z11 AST: from Ø 354.6 mm one side AST: from Ø 354.6 mm one side graduated to 2.5 mm, 5 pin holes graduated to 2.5 mm, 5 pin holes 9 mm one side flat countersink 9 mm one side flat countersink HDS-No. 12399 RU/LO HDS-No. 17225 RU/LO R U HDS-No. 12398 RO/LU R U HDS-No. 17224 RO/LU

CUTTER SEGMENTS AND SIZING CUTTERS

Cutter segments and sizing cutters

 $\mathbb{R} \setminus \mathbb{O}$ top right and $\langle L \mid U \rangle$ bottom left $\mathbb{R} \setminus \mathbb{U}$ bottom right and $\langle L \mid \mathbb{O} \rangle$ top left



TCT-Cutter segment for Linck

415 x 4.5/3.5/9.0 x 210 mm, Z11 AST: from Ø 354.6 mm one side graduated to 3.5 mm, 5 pin holes 9 mm one side flat countersink

Reinforced version!

HDS-No. 22202 RU/LO HDS-No. 22203 RO/LU



TCT-Cutter segment for Linck

415 x 3.5/2.5/7.0 x 202 mm, Z24 AST: from Ø 370 mm one side graduated to 2.5 mm, 18 pin holes 9 mm one side flat countersink

Reinforced version!

HDS-No. 28650 RO/LU HDS-No. 28651 RU/LO



TCT-Cutter segment for Linck

497 x 3.5/2.5/8.0 x 200.4 mm, Z8 AST: from Ø 446 mm one side graduated to 2.5 mm, 4 pin holes 13.5 mm



TCT-Cutter segment for Linck

497 x 3.5/2.5/8.0 x 200.4 mm, Z8 AST: from Ø 446 mm one side graduated to 2.5 mm, 4 pin holes 13.5 mm, of which 1 one side flat countersink



RU

HDS-No. 10031 RU/LO HDS-No. 10030 RO/LU



 \mathbb{R} U

RU

HDS-No. 16650 RU/LO HDS-No. 16649 RO/LU

TCT-Cutter segment for Linck

499 x 3.5/2.5/7.0 x 232 mm, Z10 AST: from Ø 446 mm one side graduated to 2.5 mm, 5 pin holes 9 mm one side flat countersink



TCT-Cutter segment for Linck

501 x 3.5/2.5/8.0 x 200.4 mm, Z10 AST: from Ø 438.6 mm one side graduated to 2.5 mm, 6 pin holes 9 mm, of which 1 one side flat countersink



HDS-No. 14224 RU/LO HDS-No. 14223 RO/LU



HDS-No. 17223 RU/LO HDS-No. 17222 RO/LU



TCT-Cutter segment for Linck

501 x 4.5/3.5/9.0 x 200.4 mm, Z10 AST: from Ø 438.6 mm one side graduated to 3.5 mm, 6 pin holes 9 mm, of which 1 one side flat countersink



TCT-Cutter segment for Linck

566 x 5.0/4.0 x 160 mm, Z27 4 pin holes 46 mm, 4 pin holes 25 mm



Reinforced version!

HDS-No. 22204 RU/LO HDS-No. 22205 RO/LU



HDS-No. 28649 RU/LO + RO/LU



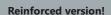
TCT-Cutter segment for Linck

566 x 5.0/4.0 x 160 mm, Z36 4 pin holes 46 mm, 6 pin holes 22 mm



TCT-Cutter segment for Linck

566 x 5.0/4.0/6.0 x 160 mm, Z36 AST: from Ø 490 mm one side graduated to 4 mm, 4 pin holes 46 mm, 6 pin holes 22 mm



HDS-No. 25088 RO/LU HDS-No. 25089 RU/LO



HDS-No. 19202 RU/LO + RO/LU

All HDS-Sawmill Tools pass through our "SoWa Sawmill Optimised Tool Design". Your cutter segments and sizing cutters therefore precisely match the application in your sawmill. In addition, once we have designed and manufactured sawmill tools for you, manufacturing in the future can be automated and reproducible with the same quality.

SoWa Sawmill Optimised Tool Design



REGENERATION

A second life for your used sawmill tools

Used doesn't mean used up, since your sawmill tool can often be repaired or regenerated, which is much more economical compared to a new purchase.

Sawmill tools can be repaired to HDS quality standards straight at our factory. For particularly high quality circular saw blades, segments and sizing rings, usually equipped with a particularly robust "AST Graduated Saw Blade Technology" core, complete

regeneration is usually wise and offers great economic benefits. This process can be repeated several times, increasing the life of your sawmill tool by x-fold.

Let us repair or regenerate your sawmill tool. In most cases this will delay a new purchase and we will return your "used ones" like new!

ATTACHMENT

- **Dimensions**
- Operating times
- Sharpening cycles
- Regeneration cycles

SAWMILL

- Circular saw blades
- Segments
- Sizing rings
- Inserts

Regeneration

- 1. Sort and clean
- 2. Remove old cutting material
- 3. Prepare tip seat

REVIEW

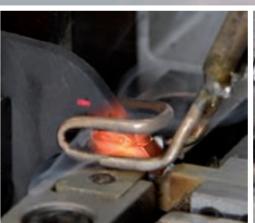
- + Chip characteristics
- + Wear level saw body
- + Wear level cutting material
- + Straightening state
- + Tensioning state



- 4. Solder on new cutting material
- 5. Level and grind
- 6. Straight and tension

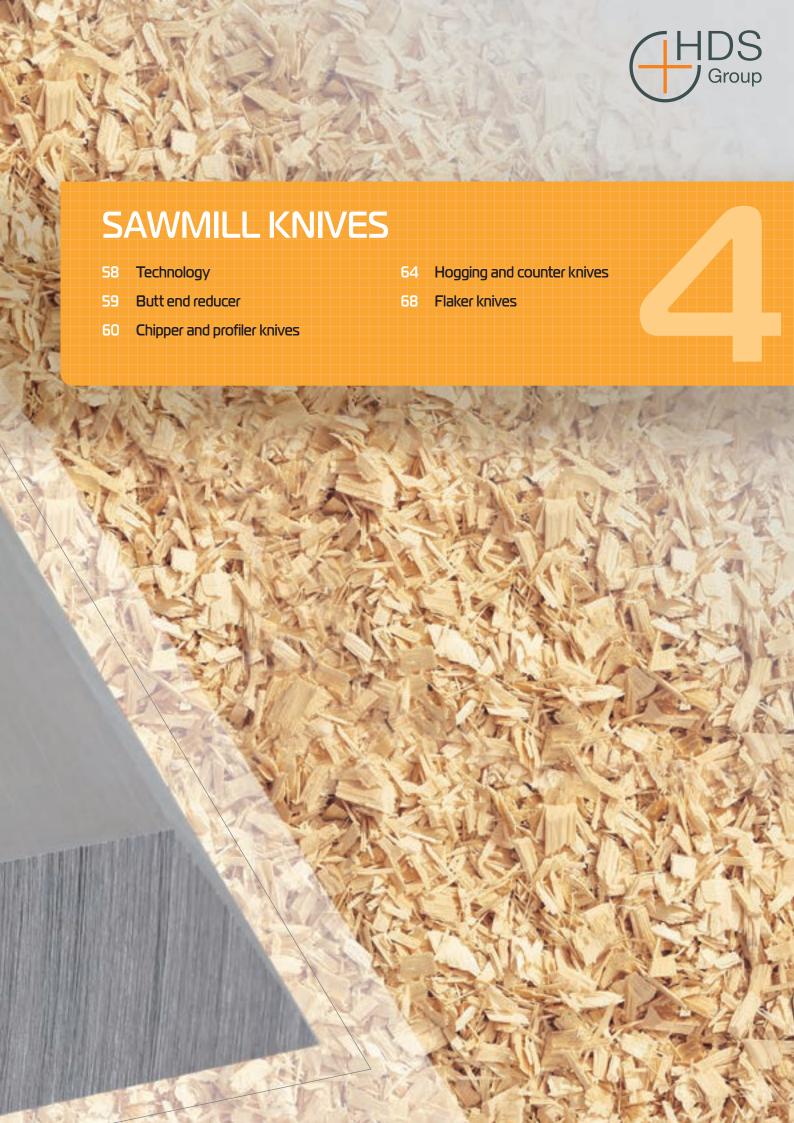


Inspect to HDS regeneration







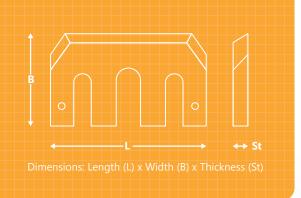


TECHNOLOGY

More than just making the cut ...

HDS-Sawmill knives are excellent for all cutting systems in the sawmill industry. Our sawmill knives are manufactured using high-quality speciality tool steels. Carefully customised heat treatment during the manufacturing process optimise the knife's properties for the various applications.

Benefit from our expertise in cutting technology. Even the HDS standard style "BasicCut" will convince you.





BasicCut

All HDS-Sawmill knives supplied are the BasicCut type. For special or particularly abrasive conditions we have four additional options which can also be combined.



PitchCut

PitchCut style sawmill knives yield an absolutely perfect cut; with this option the cutting angle of the primary chamfer is adapted to the various wood properties, and a pre-chamber and/or a counter chamfer will be added. PitchCut knives therefore feature the optimal cutting edge for a perfect cut.



GeoCut

A lot of things can often be even better. Here we pull out all the stops of constructional knife tuning and modify the geometry of the knife contours, and much more. With GeoCut style you receive a top class high-end knife customised for maximum cutting power in high performance applications.



ThermoCut the Red Ones

We offer ThermoCut style sawmill knives for normal operating conditions, but also specifically for use in dirty wood or in severe climates such as processing very dry or frozen wood. The special heat treatment modifies the hardness, bending strength and fracture resistance for extreme conditions. Recognizable are our ThermoCut by their reddish discoloration.



SteelCut

Our particularly robust SteelCut style sawmill knives provide an extra plus in terms of service life to the next sharpening cycle and the entire life of the knife. Here we use quite special heavy duty, premium quality chromium steels or wear-resistant tipped cutting edges. SteelCut knives are particularly tough, which pays in the long run.





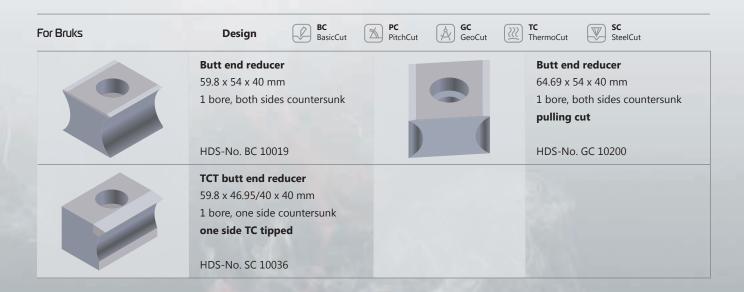
Use our "SoWa Sawmill Optimised Tool Design" for sawmill knives "tailored" to your applications.



BUTT END REDUCER



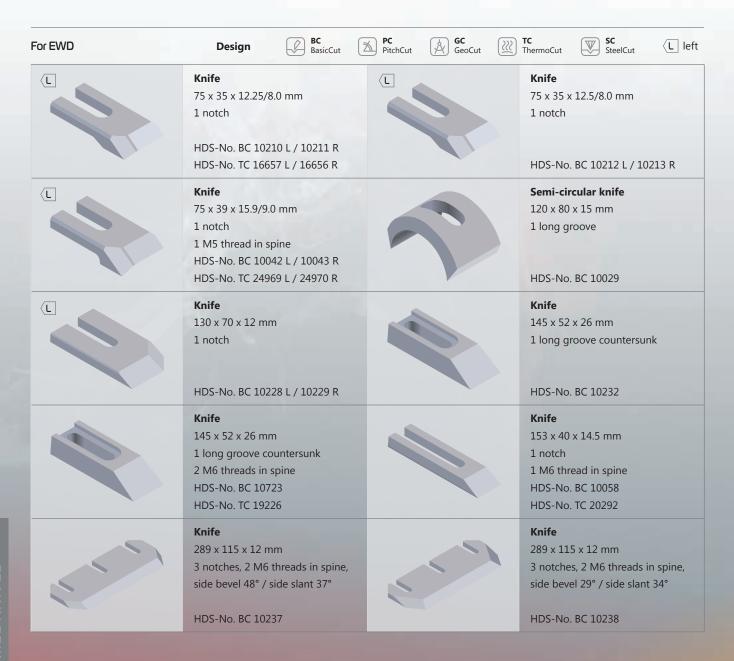
For SPINCUT milling shaft butt end reducers please see page 80





CHIPPER AND PROFILER KNIVES





CHIPPER AND PROFILER KNIVES

For Linck	Design BC BasicCut	PC PitchCut GC GeoCut	TC ThermoCut Sc SteelCut L left
	Knife 76 x 35 x 20 mm 1 x M6 thread in spine with 20 mm / 8° cant and 2 side slants HDS-No. BC 10044 HDS-No. TC 20100		Knife 76 x 35 x 20 mm 1 M6 thread in spine with a cant of 20 mm / 8°, straight sides HDS-No. BC 10006 HDS-No. TC 20101
	Knife 100 x 40 x 12 mm 1 notch 2 M6 threads in spine HDS-No. BC 10049		Knife 100 x 50 x 10 mm 1 open long groove 2 open bores, both sides countersunk HDS-No. BC 10223
	Knife 105 x 41 x 8 mm 1 long groove 1 M5 thread in spine HDS-No. BC 10007 HDS-No. TC 16736		Knife 105 x 45/32.8 x 8 mm 2 side recesses, 1 long groove, 1 M5 thread in spine HDS-No. BC 10053 HDS-No. TC 24273
	Knife 105 x 68/55 x 8 mm 1 long groove 2 Gewinde M5 im Rücken HDS-No. BC 12214		Knife 105 x 92 x 12 mm 1 notch 2 M6 threads in spine HDS-No. BC 10005 HDS-No. TC 19296
	Knife 107 x 45 x 22.07/12 mm 1 notch 2 M6 threads in spine HDS-No. BC 16043 L / 16044 R		Knife 120 x 95 x 10 mm 2 side recesses 2 open long grooves, 3 open bores, both sides countersunk HDS-No. BC 10056
	Knife 120 x 95 x 10 mm 2 side recesses 2 open long grooves 2 M5 threads in spine HDS-No. BC 10057		Knife 184 x 108 x 14 mm 2 notches 2 M6 threads in spine HDS-No. BC 10059







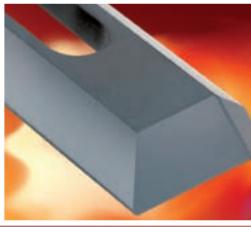
CHIPPER AND PROFILER KNIVES

TC ThermoCut BC BasicCut PC PitchCut For Linck ⟨L left Design Knife Knife 216 x 152 x 12 mm 270 x 152 x 12 mm 3 notches, 2 M6 threads in spine, 3 notches side bevel 32° / side slant 31.26° 2 M6 threads in spine HDS-No. BC 10696 HDS-No. BC 10028 Knife Knife 270 x 152 x 12 mm 330 x 152 x 12 mm 3 notches, 2 M6 threads in spine, 3 notches side bevel 41° / side slant 31.26° 2 M6 threads in spine HDS-No. BC 10520 HDS-No. BC 17179



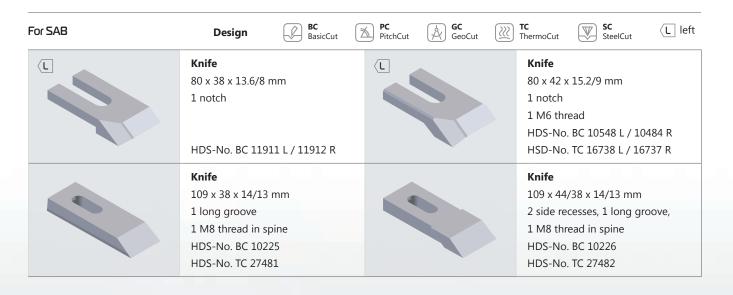




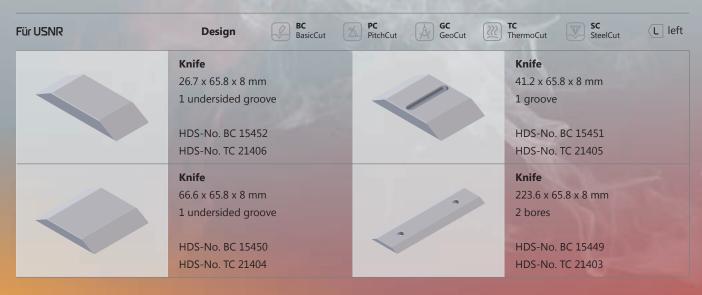




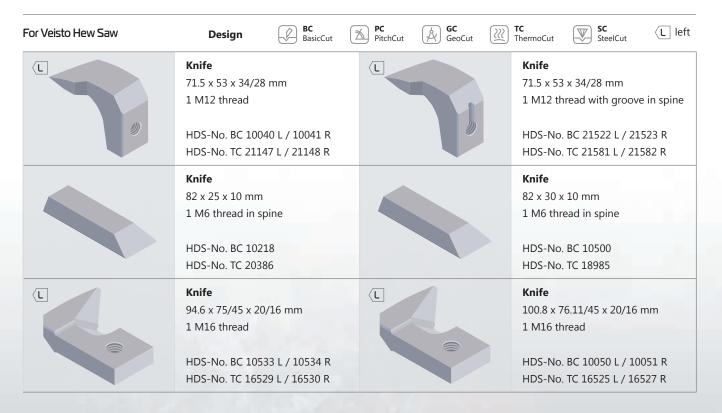
CHIPPER AND PROFILER KNIVES



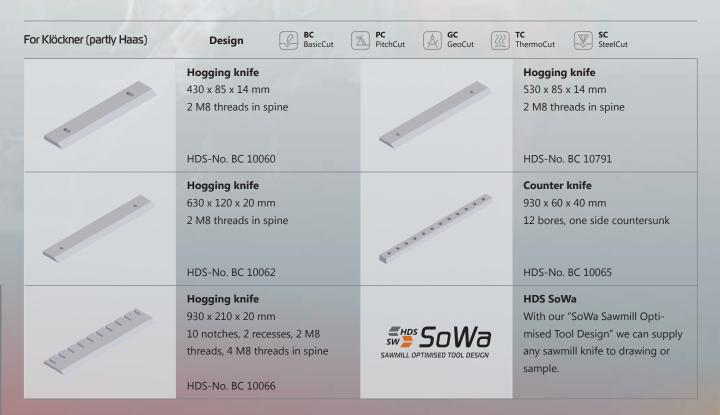




CHIPPER AND PROFILER KNIVES



HOGGING AND COUNTER KNIVES



HOGGING AND COUNTER KNIVES

BC BasicCut PC PitchCut For Pallmann TC ThermoCut Design **Hogging knife Hogging knife** 600 x 100 x 20 mm 665 x 295 x 25 mm 7 notches 6 long grooves 5 M10 threads in spine 2 recesses in spine 2 M12 threads in spine HDS-No. BC 15347 HDS-No. BC 17455 **Hogging knife Hogging knife** 765 x 295 x 25 mm 780 x 220 x 20 mm 8 notches 9 notches 2 recesses in spine 2 recesses in spine 2 M12 threads in spine 2 M10 threads in spine HDS-No. BC 26734 HDS-No. BC 11438 **Hogging knife Hogging knife** 870 x 295 x 25 mm 930 x 220 x 20 mm 9 notches 10 notches 2 recesses in spine 2 recesses in spine 2 M12 threads in spine 2 M10 threads in spine HDS-No. BC 10008 HDS-No. BC 13587 Hogging knife Hogging knife 930 x 295 x 25 mm 1130 x 220 x 20 mm 10 notches 12 notches 2 recesses in spine 2 recesses in spine 2 M12 threads in spine 2 M10 threads in spine HDS-No. BC 14170 HDS-No. BC 11390 **HDS SoWa Hogging knife** 1530 x 220 x 25 mm With our "SoWa Sawmill Opti-3 bores, one side countersunk mised Tool Design" we can supply 3 M16 threads in spine any sawmill knife to drawing or sample. HDS-No. BC 11065



HOGGING AND COUNTER KNIVES

For Rudnick & Enners	Design BC BasicCut	PC PitchCut GeoCut GeoCut	TC ThermoCut SC SteelCut
	Hogging knife 220 x 220 x 20 mm 3 notches 2 M10 threads in spine HDS-No. BC 12840		Hogging knife 530 x 130 x 12 mm 6 notches 2 recesses in spine 2 M8 threads in spine HDS-No. BC 11448
	Hogging knife 630 x 130 x 12 mm 7 notches 2 recesses in spine 2 M8 threads in spine HDS-No. BC 10027	ELILIE LIE	Hogging knife 630 x 160 x 15 mm 7 notches 2 recesses in spine 2 M10 threads in spine HDS-No. BC 10009
CI-TILL TO THE STATE OF THE STA	Hogging knife 780 x 160 x 15 mm 9 notches 2 recesses in spine 2 M10 threads in spine HDS-No. BC 10026		Hogging knife 780 x 220 x 20 mm 9 notches 2 recesses in spine 2 M10 threads in spine HDS-No. BC 10266
E-HILLHITHE	Hogging knife 930 x 220 x 20 mm 10 notches 2 recesses in spine 2 M10 threads in spine HDS-No. BC 10067		Counter knife 1020 x 80 x 15 mm HDS-No. BC 10271
	Counter knife 1040 x 120 x 20 mm HDS-No. BC 10674	initiality	Counter knife 1250 x 145 x 29 mm 12 long grooves HDS-No. BC 10276
THE	Counter knife 1450 x 145 x 29 mm 15 long grooves	SAWMILL OPTIMISED TOOL DESIGN	HDS SoWa With our "SoWa Sawmill Optimised Tool Design" we can supply any sawmill knife to drawing or sample.
	HDS-No. BC 13424		

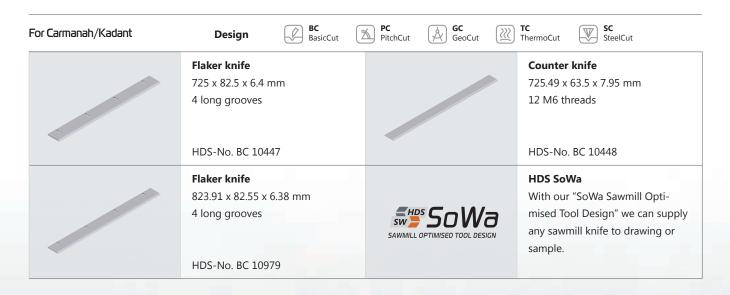


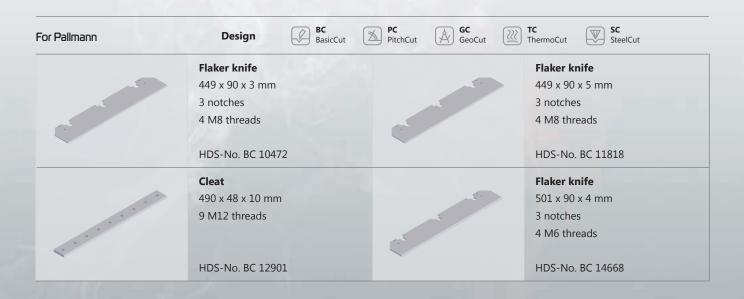
HOGGING AND COUNTER KNIVES

For Vecoplan	Design BC BasicCut	PC GeoCut	TC ThermoCut Sc SteelCut
e n	Hogging knife 580 x 90 x 14 mm 4 M8 threads in spine	4.4	Hogging knife 580 x 120 x 14 mm 4 M8 threads in spine
	HDS-No. BC 11696		HDS-No. BC 17458
	Counter knife 585 x 25 x 5 mm		Hogging knife 680 x 120 x 14 mm 4 M8 threads in spine
	HDS-No. BC 15340		HDS-No. BC 13763
	Counter knife 685 x 25 x 5 mm		Hogging knife 780 x 120 x 14 mm 2 M8 threads in spine
	HDS-No. BC 12606		HDS-No. BC 10265
44	Hogging knife 780 x 160 x 20 mm 4 M12 threads in spine		Counter knife 785 x 25 x 5 mm
	HDS-No. BC 14364		HDS-No. BC 12818



FLAKER KNIVES







FLAKER KNIVES

For Pallmann	Design BC BasicCut	PC GeoCut GeoCut	TC SC SteelCut
	Flaker knife 501 x 90 x 5 mm		Flaker knife 678 x 83 x 5 mm
	3 notches		1 side recess
	4 M6 threads	-	8 M6 threads
	HDS-No. BC 13297		HDS-No. BC 10343
	Flaker knife	_	Flaker knife
	728 x 80 x 5 mm		803 x 81.5 x 5 mm
	1 side recess		1 side recess
	6 M6 threads		8 M6 threads
	HDS-No. BC 10244		HDS-No. BC 10092
	Flaker knife		
	803 x 83 x 5 mm		
	1 side recess		
	8 M6 threads		
	HDS-No. BC 10091		

SoWa Sawmill Optimised Tool Design

Just as you need it for your production, because it's just as it fits best! We design sawmill knives specifically to the conditions at your plant – or in other words: Our sawmill knives are "cut" specifically to your application.

Our "SoWa Sawmill Optimised Tool Design" allows us to supply cutting tools which leave nothing to be desired and define the standard in performance.









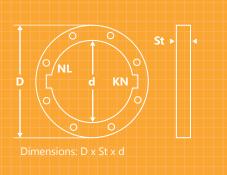
DISTANCE RINGS

It's only as good as the sum of all parts

High-precision, very elaborately produced circular saw blades are optimal combined with distance rings of the same level quality. Only combining perfectly coordinated circular saws blades and distance rings will yield optimal efficiency.

And you will benefit long term, since we only use tempered steels or high-strength aluminium for our distance rings.

D Diameter . d Bore . DKN Double key way . NL Pin hole KN Key way . St Thickness . TK Pitch circle



SoWa Sawmill Optimised Tool Design

We manufacture distance rings matched to your exact cutting programs and machine model (bore, key ways, pin holes etc.), ranging from 80 to 390 mm in diameter, 0.3 to 175.0 mm thick in 0.1 mm increments and a bore tolerance of + 0.05 to + 0.10 mm (upon request also H7). For ground sizing rings we guarantee the following tolerances: Gauge tolerance +/- 0.01 mm (< 1.0 mm +/- 0.03 mm), parallelism and levelness within 0.02 mm. Mostly aluminium rings are precision turned with gauge tolerance +/- 0.02 mm.

HDS-No. 17275





HDS-No. 17276

COMPONENTS

DISTANCE RINGS

Distance rings

Design







Steel distance ring

for Linck CSMK 375 ... 220 x 3.6 x 170 mm DKN 20.5 x 180 mm 12 NL 12.5 mm TK 195 mm

HDS-No. 17277



Steel distance ring

for Linck CSMK 425 ... 220 x 36.5 x 170 mm DKN 20.5 x 180 mm 12 NL 14.5 mm TK 192 mm

HDS-No. 17278



Aluminium distance ring

for Linck MKV ... 270 x 55.2 x 150 mm DKN 36.5 x 168 mm



Aluminium distance ring

for Linck CSMK 375 ... 290 x 40.2 x 170 mm 2+2 KN 20.5 x 181 mm 6 NL 12.5 mm TK 195 mm 12 NL 12.5 mm TK 256 mm HDS-No. 17280



Aluminium distance ring

HDS-No. 17279

for Linck MKV ... 320 x 23.7 x 150 mm DKN 36.5 x 168 mm both sides excluded

HDS-No. 17029



Steel distance ring

for Linck MKV ... 350 x 0.5 x 150 mm DKN 36.5 x 168 mm

HDS-No. 12527



Steel distance ring

for Linck MKV ... 350 x 70.2 x 150 mm DKN 36.5 x 168 mm



Aluminium distance ring

for Linck CSMK 375 ... 375 x 23.0 x 170 mm, 2+2 KN 20.5 x 181 mm, 12 NL 12.5 mm TK 195 mm, 12 NL 12.5 mm TK 339 mm, one side countersunk HDS-No. 17282



Aluminium distance ring

HDS-No. 17281

for Linck CSMK 375 ... 375 x 54.9 x 170 mm 2+2 KN 20.5 x 181 mm 12 NL 12.5 mm TK 195 mm 12 NL 12.5 mm TK 339 mm HDS-No. 17283



Steel distance ring

for Linck MKV ... 390 x 30.5 x 150 mm DKN 36.5 x 168 mm

HDS-No. 17284







Quality across all components

Those who prefer premium products doesn't need to pass on the decades of experience HDS-Group has to offer with regard to complementary system components. Experience which is reflected in extremely durable and steady machine parts of the highest international industry standard. We therefore manufacture all machine components from high-strength speciality steels using state-of-the-art 5 axis CNC machines in a reproducible quality.

Here you will find select HDS system components for chippers and cutters from our product line. Please contact us if your machine manufacturer or the tool component is not listed.

SoWa Sawmill Optimised Tool Design

Our product line includes all system components associated with sawmill tools, ranging from knife-, sizing ring- and segment carriers to pressure plates, chip breakers and chip deflectors all the way to feed plates and feed sheets, sawmill tools.

Just as with all HDS products, you will also benefit from our "SoWa Sawmill Optimised Tool Design" in system components. We therefore not only deliver outstanding material and manufacturing quality in our system components, but their construction and functionality are also optimised.



System components for chipper canters L left and/or R right **Smoothing knife carrier** Knife carrier adapter $\langle \mathsf{L} |$ $\langle \mathsf{L} |$ 300 x 151 x 53 mm 275 x 133 x 41 mm for knife holder, dual (10017L/10018R) HDS-No. 17423 L HDS-No. 10167 L HDS-No. 17422 R HDS-No. 10168 R **Chip arrester** Sizing ring carrier $\langle L \rangle$ $\langle \mathsf{L}$ 72 x 65 x 41 mm 804 x 15 x 695 mm 18 countersunk holes 36 threaded holes 6 fit holes HDS-No. 22381 L HDS-No. 10483 L HDS-No. 22382 R HDS-No. 10482 R **Hogging and smoothing Hogging and smoothing** $\langle L \rangle$ (L knife carrier knife carrier 160 x 143 x 124 mm, for 160 x 141 x 122 mm for 105 x 92 x 12 mm knife and 105 x 92 x 12 mm knife and knife holder, single (10138L/10139R) 100 x 40 x 12 mm HDS-No. 10152 L HDS-No. 10150 L HDS-No. 10153 R HDS-No. 10151 R

Usually approx. dimensions

L left System components for chipper canters Side and/or R right Hogging and smoothing knife Knife holder $\langle L \rangle$ $\langle L \rangle$ 155 x 129 x 110 mm for 105 x 92 x 12 mm knife 160 x 169 x 122 mm for 105 x 92 x 12 mm knife and 100 x 40 x 12 mm HDS-No. 22574 L HDS-No. 10148 L HDS-No. 22575 R HDS-No. 10149 R Knife holder Knife holder $\langle L \rangle$ $\langle L \rangle$ 155 x 160 x 125 mm 159 x 130 x 92 mm for 105 x 92 x 12 mm knife for 105 x 92 x 12 mm knife HDS-No. 17659 L HDS-No. 23970 L HDS-No. 17660 R HDS-No. 23969 R Knife holder **HDS SoWa** $\langle L \rangle$ 199 x 164 x 165 mm Using our "SoWa Sawmill Optifor 184 x 108 x 14 mm knife mised Tool Design" we are able to manufacture your machine parts to drawing or sample in HDS-No. 10155 L outstanding HDS quality. HDS-No. 10156 R Knife holder, dual Knife holder, single $\langle \mathsf{L} |$ $\langle L \rangle$ 99 x 89 x 61 mm 64 x 56 x 48 mm for 76 x 35 x 20 mm knife for 76 x 35 x 20 mm knife HDS-No. 10017 L HDS-No. 10138 L HDS-No. 10018 R HDS-No. 10139 R Knife holder, symmetrical Pressure plate, symmetrical $\langle L \rangle$ $|R\rangle$ (L $|R\rangle$ 107 x 68 x 31 mm for knife 107 x 68 x 28 mm 105 x 68/55 x 8 mm, only in first for 105 x 68/55 x 8 mm knife stage with knife holder carrier (26354L/26355R)



Usually approx. dimensions



HDS-No. 22603

HDS-No. 22604

System components for chipper canters

Side

L left and/or

 $|\mathbf{R}\rangle$ right



Chip arrester 93 x 59 x 34/17 mm

HDS-No. 22605 L HDS-No. 22606 R C A

Knife holder carrier

 $88 \times 77 \times 41 \text{ mm}$ for first stage with knife holder, symmetrical (22604)

HDS-No. 26354 L HDS-No. 26355 R



Pressure plate with hollow bevel

92 x 80 x 22 mm for 105 x 92 x 12 mm knife

HDS-No. 10097 L

HDS-No. 10098 R

L

Pressure plate with side bevel

79 x 39 x 22 mm for 100 x 40 x 12 mm knife

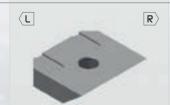
HDS-No. 10140 L HDS-No. 10141 R



Pressure plate with side bevel

92 x 80 x 22 mm for 105 x 92 x 12 mm knife

HDS-No. 10144 L HDS-No. 10145 R



Pressure plate, symmetrical

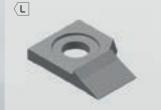
92 x 80 x 22 mm for 105 x 92 x 12 mm knife

HDS-No. 10099



Pressure plate, symmetrical

184 x 84 x 20 mm for 184 x 108 x 14 mm knife



Chip breaker

47 x 34 x 8/6 mm 1 bore 13.5 mm flat countersunk

HDS-No. 10106 L HDS-No. 10107 R

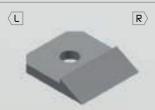


Chip breaker

HDS-No. 10154

50 x 41 x 12/6 mm 1 bore 15 mm

HDS-No. 11875 L HDS-No. 11876 R

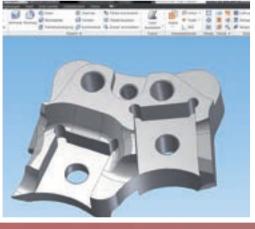


Chip breaker, symmetrical

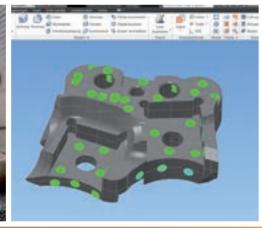
79 x 69 x 14/9 mm 1 bore 18 mm

HDS-No. 10722

Usually approx. dimensions







System components for chipp	er canters		Side 〈L left and/or R right
L C	Chip deflector for sizing ring carrier 70 x 17/13 x 25/16 mm	(L	Chip deflector for sizing ring carrier 70 x 17/14 x 25/13 mm
	HDS-No. 12228 L HDS-No. 12227 R		HDS-No. 10104 L HDS-No. 10105 R
C C	Chip deflector for sizing ring carrier 71 x 17/14 x 25/16 mm	C C	Buffer sheet, long 279 x 67 x 16 mm
	HDS-No. 11279 L HDS-No. 11280 R	3	HDS-No. 10159 L HDS-No. 10160 R
(L	Buffer sheet, short 161 x 63 x 16 mm		Filler piece 60 x 11 x 24/14 mm for knife holder, dual (10017L/10018R)
	HDS-No. 10100 L HDS-No. 10101 R		HDS-No. 10136 L HDS-No. 10137 R
L	Buffer plate 40 x 35 x 17.8 mm HDS-No. 10134 L HDS-No. 10135 R	SAWMILL OPTIMISED TOOL DESIGN	HDS SoWa Using our "SoWa Sawmill Optimised Tool Design" we are able to manufacture your machine parts to drawing or sample in outstanding HDS quality.
C C	Knife holder part 1/2 72 x 37 x 36 mm for 82 x 25 x 10 mm knife HDS-No. 10811 L HDS-No. 10809 R	C Co	Knife holder part 2/2 61 x 36 x 22 mm for 82 x 25 x 10 mm knife HDS-No. 10812 L HDS-No. 10810 R
L	Knife holder part 1/2 64 x 41 x 40 mm for 82 x 30 x 10 mm knife HDS-No. 23744 L HDS-No. 23745 R	C S	Knife holder part 2/2 60 x 39 x 25 mm for 82 x 30 x 10 mm knife HDS-No. 23741 L HDS-No. 23742 R
L	Knife holder part 1/2 66 x 63 x 40 mm for 82 x 30 x 10 mm knife HDS-No. 20810 L HDS-No. 20808 R	(L	Knife holder part 2/2 63 x 28 x 22 mm for 82 x 30 x 10 mm knife HDS-No. 20811 L HDS-No. 20809 R

System components for profiler cutters $\mathbb{R} \setminus \mathbb{O}$ top right / $\setminus \mathbb{U}$ bottom left and/or $\setminus \mathbb{R} \setminus \mathbb{U}$ bottom right / $\setminus \mathbb{U}$ $\setminus \mathbb{O}$ top left **Segment carrier** Segment carrier (L 0 (L 0 178 x 54 x 18 mm 382 x 382 x 25 mm, for knife holder, 3-stage, 10131 RU/LO, 10132 RO/LU or 21003 RU/LO, 21002 RO/LU HDS-No. 10102 RU/LO HDS-No. 10129 RU/LO R U R U HDS-No. 10103 RO/LU HDS-No. 10130 RO/LU Segment / knife carrier Knife holder, 3-stage (L 0 (L 0 411 x 411 x 50 mm 137 x 125 x 81 mm, for 76 x 35 x 20 mm knife for 76 x 35 x 20 mm knife, for segment carrier 10129 RU/LO or 10130 RO/LU HDS-No. 10128 RU/LO HDS-No. 10131 RU/LO RU RU HDS-No. 10127 RO/LU HDS-No. 10132 RO/LU Knife holder, 3-stage Knife holder, 5-stage (L 0 (L 0 137 x 125 x 81 mm, 183 x 175 x 78 mm for 76 x 35 x 20 mm knife, for segfor 76 x 35 x 20 mm knife ment carrier 10129 RU/LO or 10130 RO/LU HDS-No. 21003 RU/LO HDS-No. 23964 RU/LO RU \mathbb{R} \mathbb{U} HDS-No. 21002 RO/LU HDS-No. 23965 RO/LU Knife holder with side bevel Pressure plate, symmetrical (L 0 \mathbb{R} 89 x 41 x 27 mm 97 x 41 x 30 mm for 105 x 41 x 8 mm knife for 105 x 41 x 8 mm knife HDS-No. 10142 RU/LO RU RU $\langle L | U \rangle$ HDS-No. 10146 HDS-No. 10143 RO/LU Knife holder, symmetrical Pressure plate, symmetrical \mathbb{R} \mathbb{R} 106 x 43 x 51 mm 109 x 43 x 28 mm for 105 x 45/32.8 x 8 mm knife for 105 x 45/32.8 x 8 mm knife $\langle L | U \rangle$ \mathbb{R} U (L [U] RU HDS-No. 26387 HDS-No. 15572 **Knife holder Pressure plate** 107 x 44/38 x 51 mm 109 x 41 x 27 mm for 105 x 45/32.8 x 8 mm knife for 105 x 45/32.8 x 8 mm knife HDS-No. 15642 RU/LO HDS-No. 15574 RU/LO R U R U HDS-No. 23599 RO/LU HDS-No. 15573 RO/LU Knife holder, symmetrical Pressure plate, symmetrical (L O R O R0 107 x 43 x 35 mm 108 x 43 x 28 mm for 105 x 45/32.8 x 8 mm knife for 105 x 45/32.8 x 8 mm knife \mathbb{R} U LU \mathbb{R} U HDS-No. 27540 HDS-No. 27539

System components for profiler cutters $\mathbb{R} \setminus \mathbb{O}$ top right / $\setminus \mathbb{L} \setminus \mathbb{U}$ bottom left and/or $\setminus \mathbb{R} \setminus \mathbb{U}$ bottom right / $\setminus \mathbb{L} \setminus \mathbb{O}$ top left Knife holder **Pressure plate** 107 x 44/38 x 35 mm 109 x 41 x 27 mm for 105 x 45/32.8 x 8 mm knife for 105 x 45/32.8 x 8 mm knife HDS-No. 24350 RU/LO HDS-No. 24352 RU/LO R U $|R\rangle$ HDS-No. 24151 RO/LU HDS-No. 24353 RO/LU Knife holder, symmetrical Pressure plate, symmetrical \mathbb{R} \mathbb{R} 107 x 43 x 31 mm 103 x 43 x 27 mm for 105 x 45/32.8 x 8 mm knife for 105 x 45/32.8 x 8 mm knife $\langle L | U \rangle$ \mathbb{R} \mathbb{U} \mathbb{R} \mathbb{U} HDS-No. 24444 HDS-No. 24445 Knife holder **Pressure plate** (L 0 (L 0 106 x 44/38 x 31 mm 104 x 41 x 28 mm for 105 x 45/32.8 x 8 mm knife for 105 x 45/32.8 x 8 mm knife HDS-No. 24441 RU/LO HDS-No. 24442 RU/LO \mathbb{R} \mathbb{U} \mathbb{R} U HDS-No. 24440 RO/LU HDS-No. 24443 RO/LU Pressure plate, symmetrical **HDS SoWa** \mathbb{R} 120/110 x 85 x 18/16 mm Using our "SoWa Sawmill Optifor 120 x 95 x 10 mm knife mised Tool Design" we are able to manufacture your machine parts to drawing or sample in outstanding HDS quality. (L [U] \mathbb{R} U HDS-No. 10147 Knife holder, first stage Knife holder, from second stage 59 x 43 x 42 mm 59 x 39 x 42 mm for 62.4 x 47.3/34.5 x 13.7 mm with T-sloted base plate for 62.4 x 44.5 x 13.7 mm knife knife



Usually approx. dimensions





HDS-No. 12060 RU/LO

HDS-No. 23529 RO/LU

 $|R\rangle |U|$

 \mathbb{R} \mathbb{U}

HDS-No. 12058 RU/LO

HDS-No. 12059 RO/LU

SPINCUT MILLING SHAFT BUTT END REDUCER

Reduce with tried and tested SPINCUT stability

Leading machine manufacturers already trust in our tried and tested SPINCUT milling shaft butt end reducer for their original equipment. Of course we design and manufacture the shaft for reducers by all well-known manufacturers. Depending on the application we can modify the diameter, shaft length, chip limiter, knife count and knife type accordingly to provide you with the SPINCUT milling shaft butt end reducer in the precise style optimised for you.

In addition, we can also design a style with labyrinth for the bearing seal.

In the field the SPINCUT reducer shaft has demonstrated a particularly high stability. This is particularly due to the tool steel HDS uses and of course the quality of the tried and tested milling shaft butt end reducer available in several styles.

The HDS plus factors of SPINCUT

+ Robust tool steel construction

The SPINCUT milling shaft butt end reducer is turned and milled from tool steel. This makes the shaft particularly durable. The modern CNC production at HDS ensures outstanding production precision.

Left or right rotation

SPINCUT is made for left or right rotation with a length up to 2 metres. It can therefore be used with all reducers by leading manufacturers such as Baljer & Zembrod, Bruks, Hombak, Springer, TC-Maschinenbau, etc.

+ Optional knife optimisation

SPINCUT cutting tools can be customised for use with your reducer. We can for example modify the geometry of the knives. In addition, we offer milling shaft butt end reducers with pulling cut or high-quality TCT knives.

+ Interchangeable chip limiters

For different chip sizes the SPINCUT milling shaft butt end reducer is also available with interchangeable chip limiters.

SoWa Sawmill Optimised Tool Design

Even our SPINCUT milling shaft butt end reducers, CANTERCUT chipper canters and PROFILCUT profiler cutters, just as all other HDS products, are designed and manufactured according to our "SoWA Sawmill Optimised Tool Design" concept.

You will therefore receive sawmill tools in exactly the style for your precise application at your sawmill, thus yielding optimum efficiency.





TNANOGMON

CANTERCUT CHIPPER CANTER

First class chipping with CANTERCUT

Our CANTERCUT chipper canters feature up to 8 stages depending on the width to be chipped, with the number of knives per stage varying by feed rate, speed and the desired wood chip length. Mounted guides are available for the optimal wood feed.

Depending on your needs, HDS chipper canters may be equipped with sizing rings or smoothing knives. This allows it to respond to different requirements with respect to the cutting surface and

wood chips. Optimised, large chip ejection openings ensure gentle wood chip ejection. For easy mounting all wear parts can be replaced with the chipper canter mounted. Depending on requirements all CANTERCUT chipper canters mass can be reduced (high dynamics) or increased (smooth operation with flywheel mass).

The HDS plus factors of CANTERCUT

+ Robust tool steel construction

The CANTERCUT chipper canter is milled from tool steel with the usual precision. This ensures low wear and prevents damage. The particularly robust CANTERCUT is therefore already designed for a long tool life.

+ Modular design

All HDS chipper canters have a modular design. The basic construction of the CANTERCUT can easily be modified to fit various manufacturers. In the field, CANTERCUT can be seen in chippers of leading manufacturers such as Linck, EWD, SAB, Söderhamn, Veisto Hew Saw, Prechtl, etc.

High resharpening section and long knife life

HDS knives are used in the tried and tested quality with a long service life. In addition, the construction provides a large resharpening section to extend the life of the knives.

+ Quick set-up times

CANTERCUT chippers feature easy replacement of all wear parts and quick tool change. For example the knife holders, among other things, can be replaced individually. Optimised screws guarantee all connections can quickly be undone.

+ Consistently high wood chip quality

The structural tool arrangement allows CANTERCUT to deliver a consistently high wood chip quality.

Rough and fine cut type

CANTERCUT chipper canters are available in rough and fine cut styles.

+ Optional knife optimisation

The geometry of the smoothing knives, the knife steel quality or the style sizing ring used can be adapted to the specific application at the sawmill.







Chipper canter



CANTERCUT Compact 480

Design

Outer diameter 480 mm
Sizing ring diameter 480 mm
Chip removal depth 115 mm

2-edged / 7-stage

+ The compact design allow the wood to be guided very close to the chipper canter.



CANTERCUT Compact 550 / I

Design

Outer diameter 547 mm
Sizing ring diameter 345 mm
Chip removal depth 105 mm

2-edged / 6-stage

Original manufacturer dimension

+ By changing the guide plate and the two 2-part knife holders you can also use these chipper canter 2-edged / 8-stage without a sizing ring.

Guide plate for 8 stages



CANTERCUT Compact 550 / II

Design

Outer diameter 553 mm
Sizing ring diameter 345 mm
Chip removal depth 120 mm

2-edged / 7-stage

For the highly stressed area around the stages 1 and 2 in these modified version replaceable dual knife holders are used.

Knife holder, dual

Chipper canter



CANTERCUT Compact 580

Design

Outer diameter 580 mm
Sizing ring diameter 490 mm
Chip removal depth 120 mm

3-edged / 2-stage

Original manufacturer dimension



CANTERCUT 875

Design

Outer diameter 875 mm
Sizing ring diameter 465 mm
Chip removal depth 140 mm
3-edged / 2-stage

+ The CANTERCUT 875 chipper canter can be used for rough and fine cuts.



CANTERCUT 880 / I

Design

Outer diameter 882 mm

Using without sizing ring

Chip removal depth 200 mm

3-edged / 13-stage

Original manufacturer dimension

The highly stressed dual knife holders for knives in stage 1 + 2 can simply be replaced when attrited.

Knife holder, dual

Chipper canter



CANTERCUT 880 / II

Design

Outer diameter 882 mm
Sizing ring diameter 460 mm
Chip removal depth 190 mm

3-edged / 11-stage

Original manufacturer dimension

+ By changing the knife holders with knive holder adapters and using 2-part knife holders for sizing knives and an other guide plate you can also use the CANTERCUT 880 / I for working with a sizing ring as CANTERCUT 880 / II.

Knife carrier adapter



CANTERCUT 880 / III

Design

Outer diameter 882 mm
Sizing ring diameter 460 mm
Chip removal depth 190 mm

3-edged / 11-stage

+ For the highly stressed area around the stages 1 and 2 of the CANTERCUT 880 / II by the CANTERCUT 880 / III optimising a replaceable dual knife holder is used.

Knife holder, dual



CANTERCUT 950

Design

Outer diameter 950 mm
Sizing ring diameter 3-teilig 566 mm
Chip removal depth 180 mm

3-edged / 2-stage

Chipper canter



CANTERCUT 960 / I

Design

Outer diameter 960 mm Sizing ring diameter 630 mm Chip removal depth 165 mm

2-edged / 3-stage

+ The CANTERCUT 960 / I delivers a high chip removal depth and features a particularly high flywheel mass.



CANTERCUT 960 / II

Design

967 mm Outer diameter Sizing ring diameter 620 mm Chip removal depth 150 mm

3-edged / 4-stage

+ To extend the chip removal depth by the CANTERCUT 960 / II two more stages exteriors are integrated.



CANTERCUT 1200

Design

Outer diameter 1220 mm Sizing ring diameter 850 mm Chip removal depth 160 mm 4-edged / 2-stage

The particularly large chipper canter can also be construct each stage 6-edged.

PROFILCUT PROFILER CUTTER

High-quality wood chips with an almost tear-free wood surface

HDS designs and manufactures profiler cutters for machines by leading manufacturers such as Linck, EWD, Veisto Hew Saw and Prechtl. We supply standard replacement cutters as well as PRO-FILCUT profiler cutters with an optimised shape and function. Here the focus is on achieving a virtually to even completely tearfree wood surface. In addition, we focus on an equal structure on the left and right, long service lives, replaceable knife holders, as well as a quick knife change.

The modular construction yields cutting widths of up to 200 mm per cutter head. Depending on the desired wood chip size, feet rate and blade diameter, PROFILCUT can hold up to 8 knives.

We can even manufacture special purely tungsten carbide tipped cutter heads which only product wood shavings.

Optimised geometries

The enhanced shape yields an optimal wood surface which is virtually tear-free.

+ Modular design

The modular design of PROFILCUT allows it to easily be modified to profiler machines of different manufacturers.

+ High resharpening section and long knife life

HDS knives are used in the tried and tested quality with a long service life. In addition, the construction allows for a large resharpening section.

Quick set-up times

PROFILCUT features simple replacement of all wear parts and quick tool change. The knife holders can be replaced individually, with the right and left usually being identical.

+ Demand-oriented optimisation

The following options are available for PROFILCUT: Knife geometries and knife steel qualities matched to the application, optimised sizing ring kerf and varied sawdust-wood chip ratio.

Profiler cutter



PROFILCUT 310

Design

2-edged / 4-stage

Segment diameter 310 mm Profiling depth 180 mm

4 Cutter discs 2-edged

 All parts are symmetrically and thus can be used bottom right / top left and top right / bottom left.



PROFILCUT 401

Design

3-edged / 4-stage

Segment diameter 401 mm Profiling depth 125 mm

1 Cutter head 3-edged

Original manufacturer dimension

PROFILCUT PROFILER CUTTER

Profiler cutter



PROFILCUT 403

Design

2-edged / 2-stage

Segment diameter 403 mm
Profiling depth 90 mm

2 Cutter discs 2-edged



PROFILCUT 411

Design

3-edged / 1-stage

Segment diameter 411 mm Profiling depth 35 mm

1 Cutter disc 3-edged

Original manufacturer dimension



PROFILCUT 414

Design

3-edged / 3-stage

Segment diameter 414 mm
Profiling depth 100 mm

1 Cutter head 3-edged

Original manufacturer dimension



PROFILCUT 415

Design

3-edged / 3-stage

Segment diameter 415 mm

Profiling depth 130 mm

3 Cutter discs 3-edged

Original manufacturer dimension

+ By applying of 3 further knife holders and pressure plates instead of the knife holder adapters the PROFILCUT 415 can be used 6-edged.



PROFILCUT 497

Design

4-edged / 4-stage

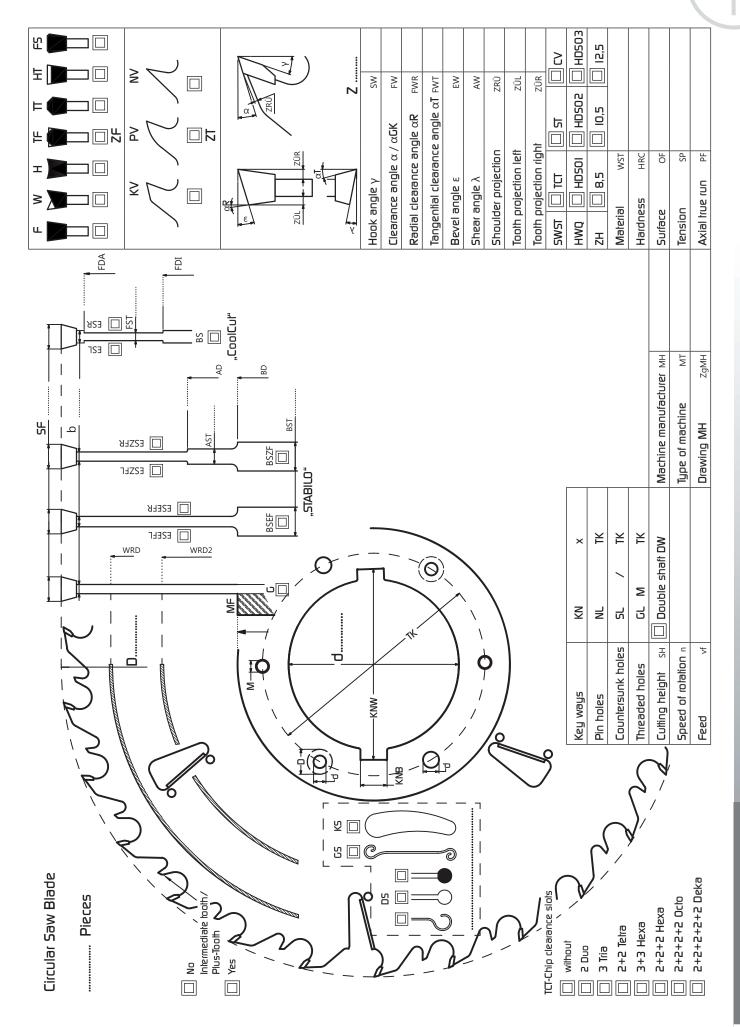
Segment diameter 497 mm Profiling depth 135 mm

1 Cutter head 4-edged

Original manufacturer dimension

ABBREVIATIONS

4.0	Consideration discusses		1 - 64
AD	Gradation diameter	L	Left
AST	Gradation thickness	LO	Top left
AT	Gradation type	LU	Bottom left
AW	Shear angle λ	L/R	Position
b	Saw body thickness	M	Thread size
BD	Collar diameter	MF	Machine flange
BS	Both sides	MH	Machine manufaturer
BSEF	Single on both sides	MT	Machine type
BST	Collar thickness	n	Speed of rotation
BSZF	Dual on both sides	NL	Pin hole
CC	CoolCut	NL _A	Pin hole count
		**	
CU	With Cupper rivet	NL _d	Pin hole diameter
CV	Chrome-vanadium	NL _{TK}	Pin hole pitch circle
D	Diameter	NV	Pointet tooth
d	Bore	Octo	8 TCT-chip clearance slots
Deka	10 TCT-chip clearance slots	OF	Surface
DKN	Double key way	PF	Axial true run
DS	Expansion slots	PL	Fit hole
Duo	2 TCT-chip clearance slots	Plus	Saw body with intermediate teeth
DW	Double shaft	PV	Curved tooth
ESEF	Single on one side	R	Right
	•	RO	_
ESEFL	Single on one side left		Top right
ESEFR	Single on one side right	RS	TCT-Chip clearance slotz
ES	One side	RS _A	Chip clearance slots count
ESL	One side left	RS _B	Chip clearance slots width
ESR	One side right	RS _L	Chip clearance slots length
ESZF	Dual on one side	RS _ü	Chip clearance slots projection
ESZFL	Dual on one side left	RU	Bottom right
ESZFR	Dual on one side right	SF	Kerf
EW	Bevel angle ε	SH	Cutting height
F	Flat tooth	SL	Countersunk hole
			Countersunk hole count
FD _A	CoolCut diameter interiorly	SL _A	
FD ₁	CoolCut diameter exteriorly	SL _d	Countersunk hole diameter interiorly
FS	Flat tooth with protective chamfer	SL_{D}	Countersunk hole diameter exteriorly
FST	CoolCut thickness	SL_{TK}	Countersunk hole pitch circle
FT	CoolCut type	SP	Tension
FW	Clearance angle α	ST	Stellite
FW_GK	Clearance angle saw body $\alpha_{_{GK}}$	STABILO	Graduated saw body
FW _R	Radial clearance angle α _s	SW	Hook angle γ
FW _T	Tangential clearance and α_{τ}	SWST	Cutting material
G	Straight saw body	Tetra	2+2 TCT-chip clearance slots
GL	Threaded holes	TF	Trapeze-flat tooth
	Threaded hole count	TK	pitch circle
GL _A			·
GL _{TK}	Threaded pitch circle	Tria	3 TCT-chip clearance slots
GS	Noise reduction slots	TT	Trapeze-trapeze tooth
Н	Hollow saw tooth	UZ	Varying tooth pitch
HDS01	Tungsten carbide quality I (standard)	V_{f}	Feed
HDS02	Tungsten carbide quality II	W	Alternate top bevel tooth
HDS03	Tungsten carbide quality III	WRD	Roll ring diameter
Hexa	2+2+2 or 3+3 TCT-chip clearance slots	WST	Material
HRC	Hardness	Z	Number of teeth
HT	High-Low tooth	ZF	Tooth form
HW	Tungsten carbide	ZgMH	Drawing no.
	Tungsten carbide quaylity	ZH	Tooth height
HWQ			
KN	Key way	ZH _{GK}	Tooth height saw body
KN _A	Key way count	ZRÜ	Shoulder prjection
KN _B	Key way with	ZÜ	Tooth projection
KN _T	Key way depth	ZÜL	Tooth projection left
KN_w	Key way size	ZÜR	Tooth projection right
KS	Cooling slots	ZT	Tooth type saw body
KV	Peg tooth (standard)	ZZ "Plus"	Intermediate tooth



NOTES



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