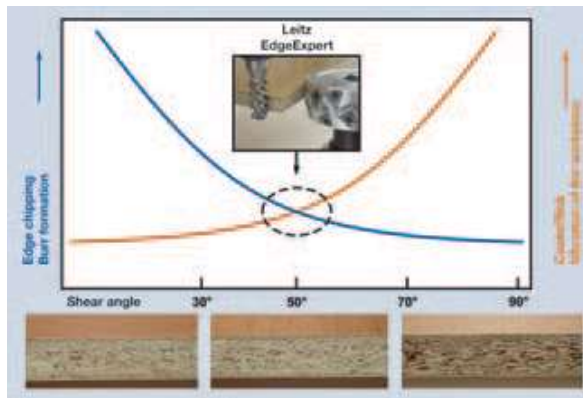


#### Diamaster EdgeExpert



Diamaster EdgeExpert – The expert for top edge performance especially in case of demanding decors.

In interior design and furniture manufacture, the use of processed material surfaces is increasing in both use and importance. This requires new tool concepts such as the Diamaster EdgeExpert program from Leitz. Whether very thin paper decors, veneers or foil- and high-gloss coating, the Diamaster EdgeExpert enables tear-free edges and even middle layer on continuous machines and CNC machining centres. Especially suitable for zero-joint edging technology with laser, plasma or hot air.

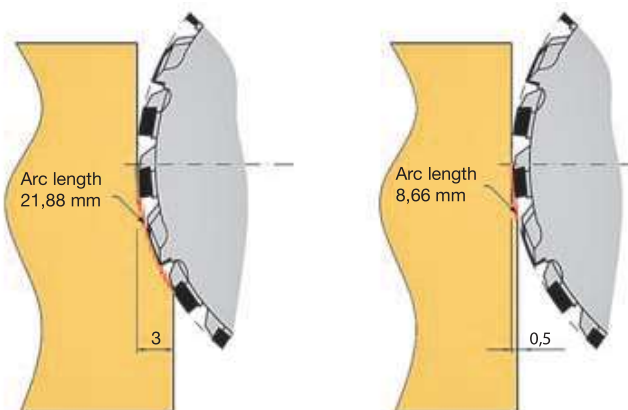


#### Dust collection

The tool characteristics of the joint cutter Diamaster PRO low noise model range have DFC gullet for delayed chip ejection and are suitable for i-system.

#### Chip removal

The chip removal has an important influence on the machining quality and on the tool life. Through a reduction of the chip removal, the arched length of the tool positioned in the interference is decreased, causing the tool to cut less material and to increase the tool life.



## 2. Panel processing

### 2.1 Edge processing 2.1.2 Jointing cutters

#### Noise emission

For noise reduction, LowNoise tools Diamaster PRO with its low knife protrusion, staggered edge and shear can be used. See section Edge Processing - Jointing Cutters.

#### Service

The Diamaster WhisperCut knives either can be serviced by Leitz Service or by the user on site.

#### Resharpener Diamaster WhisperCut



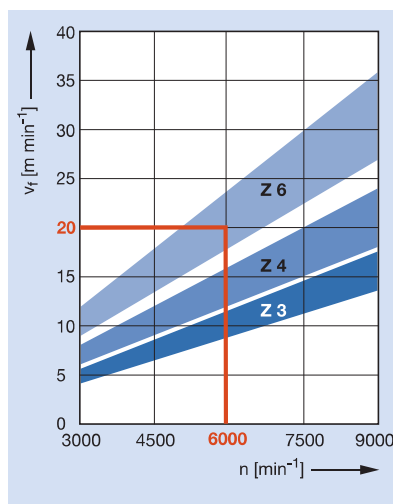
WhisperCut: Diamond knives are resharpenable in the tool body up to 3 times  
WhisperCut PLUS: Diamond knives are resharpenable in the tool body up to 10 times

#### Diamaster WhisperCut – The jointing cutterhead with exchan- geable knives

- constant diameter
- quick and easy knife change by the user on site
- no costly adjustment at the machine
- no interchangeable tool required
- optimal knife utilization with small material thicknesses

#### Feed speed related to RPM and number of teeth Z

Material: Chipboard with melamine  
resin coating





**WhisperCut jointing / milling cutter - cutterhead design**

**Application:**

For tear-free and low noise jointing of workpiece edges side with and against feed (jump cutting).

**Machine:**

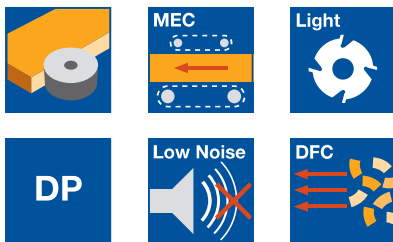
Edgebanding machines, copy shaping machines, double-end tenoners etc.

**Workpiece material:**

Chip and fibre board (MDF etc.) uncoated, veneered, plastic and paper coated, fibre reinforced plastics (GFRP, CFRP etc.).

**Technical information:**

DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surfaces. Tool with knife arrangement S can be used left and right and produces hollow cut for tightly closing edgebanding. Low noise design with up to 5 dB(A) noise reduction and highly efficient chip collection (>95%) by DFC. Significant weight reduction by using an aluminium alloy tool body. Carrier body for multiple use with exchangeable knives. 0.6 mm resharpening area.

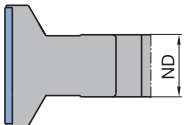


**Diamaster WhisperCut - DFC, LowNoise, aluminium alloy tool body**

WF 230 2 DP, WM 230 2 01



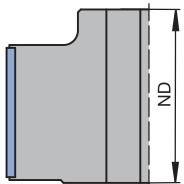
Position of boss (NAL) 1



Position of boss (NAL) 2



Position of boss (NAL) 3



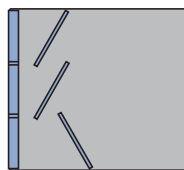
Position of boss (NAL) 4

Machine	D	SB	ND	BO	NAL	Z	Knife Type	Type	ID LH	ID RH
	mm	mm	mm	mm						
Biesse	80	45	53	30	DKN	1	2x4	8xB	S	192127 ● 192127 ●
Biesse	80	65	53	30	DKN	2	2x6	12xB	S	192128 ● 192128 ●
Biesse	100	43	75	30	DKN	1	3x4	12xA	S	192088 ● 192088 ●
Biesse	100	65	75	30	DKN	1	3x6	18xA	S	192089 ● 192089 ●
Biesse	125	43	40	30	DKN	2	3x4	12xE	S	075627 ● 075627 ●
Biesse	125	63	40	30	DKN	2	3x6	18xE	S	075626 ● 075626 ●
Brandt	100	43.6	40.6	25	DKN	3	2x4	8xA	AS	192211 ● 192212 ●
Brandt	100	43.6	40.6	30	DKN	3	3x4	12xA	AS	090885 ● 090886 ●
Brandt	100	65.2	40.6	30	DKN	3	3x6	18xA	AS	090887 ● 090888 ●
Brandt	100	85	85	30	DKN	3	3x8	24xA	AS	090889 ● 090890 ●
Brandt	100	105	85	30	DKN	3	3x10	30xA	AS	090891 ● 090892 ●
Cehisa	100	54	25	20	DKN	2	2x5	10xA	AS	192078 ● 192079 ●
Felder	60	63	63.5	25	DKN	3	2x7	12xC	AS°	192278 ●
Felder	60	63	63.5	25	DKN	3	2x7	12xC1		
Felder	60	63	63.5	25	DKN	3	2x7	12xC AS°		192277 ●
Felder	80	48.5	64	25	DKN	3	3x6	12xB AS°		192281 ● 192282 ●
Felder	80	64	64	25	DKN	3	3x7	18xB AS°		192279 ●
Felder	80	64	64	25	DKN	3	3x7	18xB AS°		192280 ●
Fraval	60	63	63.5	25	DKN	3	2x7	12xC AS°		192248 ●
Fraval	60	63	63.5	25	DKN	3	2x7	12xC AS°		192247 ●
Fraval	60	84	61	25	DKN	3	2x8	14xC AS°		192242 ●
Fraval	60	84	61	25	DKN	3	2x8	14xC AS°		192241 ●
Fraval	100	65	56.5	30	DKN	3	2x6	12xA	AS	192243 ● 192244 ●
Fraval	100	124	96	30	DKN	2	2x11	22xA	AS	192245 ● 192246 ●
Hebrock/EBM	70	43	61	25	DKN	4	2x4	8xB	AS	192237 ● 192238 ●
Hebrock/EBM	70	63	81	25	DKN	4	2x6	12xB	AS	192239 ● 192240 ●
Hebrock/EBM	100	43	61	30	DKN	3	2x4	8xB	AS	192233 ● 192234 ●
Hebrock/EBM	100	63	81	30	DKN	3	2x6	12xB	AS	192235 ● 192236 ●
Holz-Her	70	48	41	30	DKN	4	2x5	8xD	AS°	192222 ●
1801/1802								2xD1		

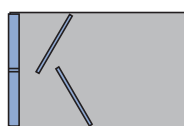
## 2. Panel processing

### 2.1 Edge processing

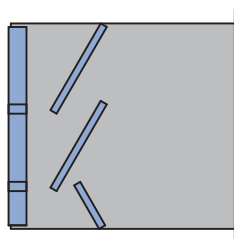
#### 2.1.2 Jointing cutters



Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement



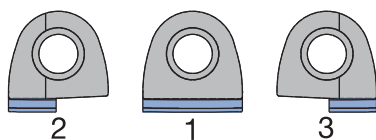
Type AS° = asymmetric tip arrangement with a narrow row of teeth below

Machine	D mm	SB mm	ND mm	BO mm	NAL	Z	Knife Type	Type	ID LH	ID RH
Holz-Her 1801/1802	70	48	41	30	DKN	4	2x5	8xD	AS°	<b>192221</b> ●
Holz-Her 1801/1802	70	64	41	30	DKN	4	2x7	12xD	AS°	<b>192224</b> ●
Holz-Her 1801/1802	70	64	41	30	DKN	4	2x7	12xD	AS°	<b>192223</b> ●
Holz-Her 1804	100	63	39.5	30	DKN	2	3x6	18xB	S	<b>192147</b> ● <b>192148</b> ●
Holz-Her 1891	100	43	25	30	DKN	2	2x4	8xA	AS	<b>192082</b> ● <b>192083</b> ●
Holz-Her 1891	100	65	25	30	DKN	2	2x6	12xA	AS	<b>192084</b> ● <b>192085</b> ●
Homag	125	43	40	30	DKN	2	3x4	12xE	S	<b>075627</b> ● <b>075627</b> ●
Homag	125	63	40	30	DKN	2	3x6	18xE	S	<b>075626</b> ● <b>075626</b> ●
IMA	125	32	34	30	DKN	1	3x4	12xD	AS	<b>192092</b> ● <b>192093</b> ●
IMA	125	43	42	30	DKN	2	3x5	15xD	AS	<b>192094</b> ● <b>192095</b> ●
IMA	125	63	42	30	DKN	3	3x7	21xD	AS	<b>192096</b> ● <b>192097</b> ●
IMA Advantage	125	43	57	30	DKN	4	3x5	15xD	AS	<b>192098</b> ● <b>192099</b> ●
IMA Advantage	125	65	57	30	DKN	4	3x7	21xD	AS	<b>192100</b> ● <b>192101</b> ●
Ott	85	48	50	30	DKN	3	3x5	12xB	AS°	<b>192209</b> ●
Ott	85	48	50	30	DKN	3	3x5	3xB1		
Ott	85	48	50	30	DKN	3	3x5	12xB	AS°	<b>192210</b> ●
Ott	85	48	50	30	DKN	3	3x5	3xB2		
Ott	85	65	45	30	DKN	2	3x6	18xB	AS	<b>192227</b> ● <b>192228</b> ●
Ott	85	85	50	30	DKN	3	3x8	24xB	AS	<b>192229</b> ● <b>192230</b> ●
SCM	100	51	60	30	DKN	3	2x6	8xB	AS°	<b>192215</b> ● <b>192216</b> ●
SCM	100	51	60	30	DKN	3	2x6	2xB1		
SCM	100	51	60	30	DKN	3	2x6	2xB2		
SCM	100	51	60	30	DKN	3	3x6	12xB	AS°	<b>192217</b> ● <b>192218</b> ●
SCM	100	51	60	30	DKN	3	3x6	3xB1		
SCM	100	51	60	30	DKN	3	3x6	3xB2		
SCM	100	66	60	30	DKN	3	2x7	12xB	AS°	<b>192213</b> ●
SCM	100	66	60	30	DKN	3	2x7	2xB1		
SCM	100	66	60	30	DKN	3	2x7	12xB	AS°	<b>192214</b> ●
SCM	100	66	60	30	DKN	3	2x7	2xB2		
SCM	100	66	60	30	DKN	3	3x7	18xB	AS°	<b>192219</b> ●
SCM	100	66	60	30	DKN	3	3x7	3xB1		
SCM	100	66	60	30	DKN	3	3x7	18xB	AS°	<b>192220</b> ●
SCM	100	66	60	30	DKN	3	3x7	3xB2		
Stefani	100	51	60	30	DKN	3	2x6	8xB	AS°	<b>192215</b> ● <b>192216</b> ●
Stefani	100	51	60	30	DKN	3	2x6	2xB1		
Stefani	100	51	60	30	DKN	3	2x6	2xB2		
Stefani	100	51	60	30	DKN	3	3x6	12xB	AS°	<b>192217</b> ● <b>192218</b> ●
Stefani	100	51	60	30	DKN	3	3x6	3xB1		
Stefani	100	51	60	30	DKN	3	3x6	3xB2		
Stefani	100	66	60	30	DKN	3	2x7	12xB	AS°	<b>192213</b> ●
Stefani	100	66	60	30	DKN	3	2x7	2xB1		
Stefani	100	66	60	30	DKN	3	2x7	12xB	AS°	<b>192214</b> ●
Stefani	100	66	60	30	DKN	3	2x7	2xB2		
Stefani	100	66	60	30	DKN	3	3x7	18xB	AS°	<b>192219</b> ●
Stefani	100	66	60	30	DKN	3	3x7	3xB1		
Stefani	100	66	60	30	DKN	3	3x7	18xB	AS°	<b>192220</b> ●
Stefani	100	66	60	30	DKN	3	3x7	3xB2		
Törk Makine	100	65.2	40.6	30	DKN	3	3x6	18xA	AS	<b>090887</b> ● <b>090888</b> ●

## 2. Panel processing

### 2.1 Edge processing

#### 2.1.2 Jointing cutters



Shape of WhisperCut spare knives  
SB 6.7 / 14 mm

#### Spare knives:

BEZ	ABM mm	QAL	Type	Shape	ID
WhisperCut-knife SB14	14x14.2x4.3	DP	A	1	<b>091052</b> ●
WhisperCut-knife SB14	14x14.2x4.3	DP	B	1	<b>091066</b> ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	B1	2	<b>091067</b> ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	B2	3	<b>091068</b> ●
WhisperCut-knife SB14	14x14.2x4.3	DP	D	1	<b>091071</b> ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	D2	2	<b>091072</b> ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	D1	3	<b>091073</b> ●
WhisperCut-knife SB14	14x14.2x4.3	DP	E	1	<b>091074</b> ●
WhisperCut-knife SB14	14x14.2x4.3	DP	C	1	<b>091077</b> ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	C1	2	<b>091079</b> ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	C2	3	<b>091078</b> ●

Eroded spare knives for quick and easy knife change.

#### Spare parts:

BEZ	ABM mm	Machine	ID
Securing part set	40/30x8 M12	Holz-Her 1801/1802	<b>116011</b> ●
Spindle nut	38x28 M25x1.5	Felder, Fraval	<b>066566</b> ●