



Leitz Tooling UK Spiral Routing Range

German Engineering, British Manufacture.

Edition 2, 2025



leitz TR44x1.5
6663
80 Nm
L36





Your benefits due to ...



PRODUCTIVITY

Top performance with the help of Real-Z3

- Up to 50 % higher feed speed due to engineered arrangement of the Real-Z3 knives
- Higher throughput by reducing cutting time
- Up to 50 % longer lifetime due to the constant work of the complete number of teeth
- Diamaster PLUS³ is resharpenable up to 12 times due to the extended resharpening area



EFFICIENCY

Production costs can significantly be reduced

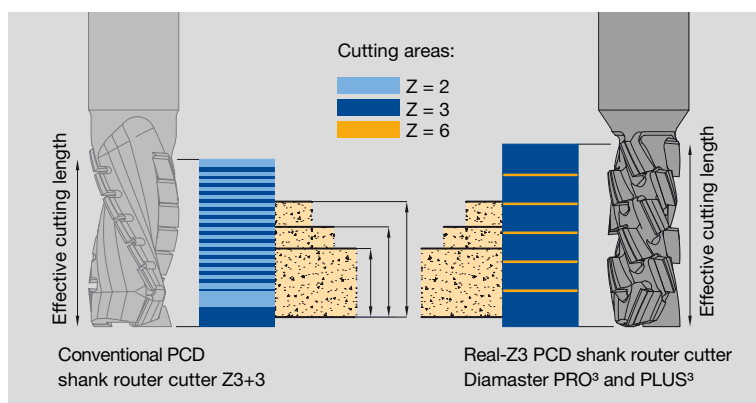
- Less rework and fewer rejects with chip-/tear-free laminates and smooth edges
- Efficient chip removal results in less edge-prep before edge-banding
- The Real-Z3 knife arrangement eliminates the need for tool position adjustment or correction



QUALITY

More effective cutting edges, better machining quality

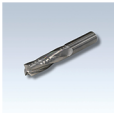
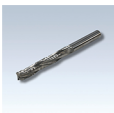
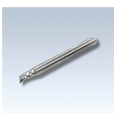
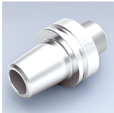
- Continuous arrangement of the Real-Z3 knives yields excellent cut quality: chip-free edges and smooth sides
- Optimized chip flow reduces dust residue on the workpieces
- Continuous engagement the knives reduces vibration and increases cut quality



Diamaster PRO³
Diamaster PLUS³
... no compromises
during cutting!



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1.1 Roughing Finishing Routers



Z2 Roughing Finishing Router, Up Cut:

Application:

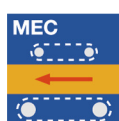
Router cutter for sizing and grooving in roughing/finishing quality.

Machinery:

Stationary routers with or without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Solid tungsten carbide. Short design for increased stability. Long design for increased cutting depth (recommended in several steps). Higher feed speeds than conventional roughing cutters. Extremely smooth running. Manufactured from high-grade carbide.



Materials:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).

Material	Suitability
Softwood - Dry	◆
Softwood - Wet	◆
Hardwood - Dry	◆
Hardwood - Wet	◆
Plywood	◆
Chipboard	◆
MDF	◆
WPC (Wood -Plastic-Composite)	◆

◆ = Suitable ◇ = Partially Suitable

Spiral Roughing Finishing Router, Z2 POS

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
6	70	15	6	Z2	RH	807010002
6	70	20	6	Z2	RH	807010003
6	70	25	6	Z2	RH	807010004
6	70	30	6	Z2	RH	807010005
8	80	20	8	Z2	RH	807010006
8	80	25	8	Z2	RH	807010007
8	80	30	8	Z2	RH	807010008
8	80	35	8	Z2	RH	807010009
8	80	40	8	Z2	RH	807010010
10	80	25	10	Z2	RH	807010011
10	80	30	10	Z2	RH	807010012
10	80	35	10	Z2	RH	807010013
10	80	40	10	Z2	RH	807010014
12	80	25	12	Z2	RH	807010302
12	80	30	12	Z2	RH	807010015
12	80	35	12	Z2	RH	807010016
12	80	40	12	Z2	RH	807010017
12	80	45	12	Z2	RH	807010018
12	80	50	12	Z2	RH	807010019
16	100	40	16	Z2	RH	807010020
16	100	50	16	Z2	RH	807010021
16	100	55	16	Z2	RH	807010022
16	100	60	16	Z2	RH	807010023
20	120	55	20	Z2	RH	807010024
20	120	60	20	Z2	RH	807010025

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$
Feed Speed: 5 m/min - 30m/min

The listed parameters are guidelines. For tailored running parameters and technical support please contact Leitz Tooling directly, use the machining calculator on xpert.leitz.org or download the app.

Tool & Saw Sharpening?

Leitz sharpens tooling from all manufacturers, including HSS, Carbide & diamond (PCD) tools.

01279 454530
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1.2 Roughing Finishing Routers



Z3 Roughing Finishing Router, Up Cut:

Application:

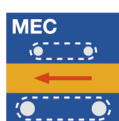
Router cutter for sizing and grooving in roughing/finishing quality.

Machinery:

Stationary routers with or without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Solid tungsten carbide. Short design for increased stability. Long design for increased cutting depth (recommended in several steps). Higher feed speeds than conventional roughing cutters. Extremely smooth running. Manufactured from high-grade carbide.



Spiral Roughing Finishing Router, Z3 POS

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
6	70	15	6	Z3	RH	807010050
6	70	20	6	Z3	RH	807010051
6	70	25	6	Z3	RH	807010052
6	70	30	6	Z3	RH	807010053
8	80	20	8	Z3	RH	807010054
8	80	25	8	Z3	RH	807010055
8	80	30	8	Z3	RH	807010056
8	80	35	8	Z3	RH	807010057
8	80	40	8	Z3	RH	807010058
10	80	25	10	Z3	RH	807010059
10	80	30	10	Z3	RH	807010060
10	80	35	10	Z3	RH	807010061
10	80	40	10	Z3	RH	807010062
12	80	25	12	Z3	RH	807010303
12	80	30	12	Z3	RH	807010063
12	80	35	12	Z3	RH	807010064
12	80	40	12	Z3	RH	807010065
12	80	45	12	Z3	RH	807010066
12	80	50	12	Z3	RH	807010067
16	100	40	16	Z3	RH	807010068
16	100	50	16	Z3	RH	807010069
16	100	55	16	Z3	RH	807010070
16	100	60	16	Z3	RH	807010071
20	120	55	20	Z3	RH	807010072
20	120	60	20	Z3	RH	807010073

Materials:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).

Material	Suitability
Softwood - Dry	◆
Softwood - Wet	◆
Hardwood - Dry	◆
Hardwood - Wet	◆
Plywood	◆
Chipboard	◆
MDF	◆
WPC (Wood -Plastic-Composite)	◆

◆ = Suitable ◆ = Partially Suitable

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$
Feed Speed: 5 m/min - 30m/min

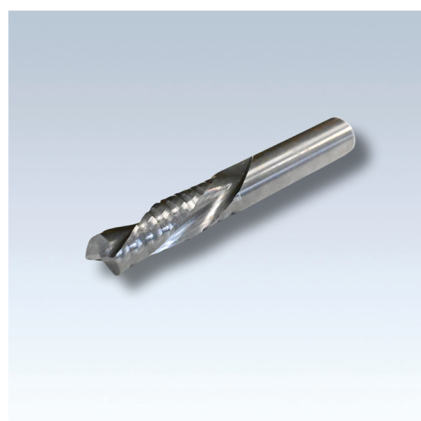
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Tool & Saw Sharpening?

Leitz sharpens tooling from all manufacturers, including HSS, Carbide & diamond (PCD) tools.

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1.3 Roughing Finishing Routers



Z2 Roughing Finishing Router, Down Cut:

Application:

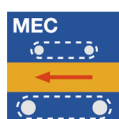
Router cutter for sizing and grooving in roughing/finishing quality.

Machinery:

Stationary routers with or without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Solid tungsten carbide. Short design for increased stability. Long design for increased cutting depth (recommended in several steps). Higher feed speeds than conventional roughing cutters. Extremely smooth running. Manufactured from high-grade carbide.



Materials:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).

Spiral Roughing Finishing Router, Z2 NEG

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
6	70	15	6	Z2	RH	807010026
6	70	20	6	Z2	RH	807010027
6	70	25	6	Z2	RH	807010028
6	70	30	6	Z2	RH	807010029
8	80	20	8	Z2	RH	807010030
8	80	25	8	Z2	RH	807010031
8	80	30	8	Z2	RH	807010032
8	80	35	8	Z2	RH	807010033
8	80	40	8	Z2	RH	807010034
10	80	25	10	Z2	RH	807010035
10	80	30	10	Z2	RH	807010036
10	80	35	10	Z2	RH	807010037
10	80	40	10	Z2	RH	807010038
12	80	25	12	Z2	RH	807010304
12	80	30	12	Z2	RH	807010039
12	80	35	12	Z2	RH	807010040
12	80	40	12	Z2	RH	807010041
12	80	45	12	Z2	RH	807010042
12	80	50	12	Z2	RH	807010043
16	100	40	16	Z2	RH	807010044
16	100	50	16	Z2	RH	807010045
16	100	55	16	Z2	RH	807010046
16	100	60	16	Z2	RH	807010047
20	120	55	20	Z2	RH	807010048
20	120	60	20	Z2	RH	807010049

Material	Suitability
Softwood - Dry	◆
Softwood - Wet	◆
Hardwood - Dry	◆
Hardwood - Wet	◆
Plywood	◆
Chipboard	◆
MDF	◆
WPC (Wood -Plastic-Composite)	◆

◆ = Suitable ◇ = Partially Suitable

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$
Feed Speed: 5 m/min - 30m/min

The listed parameters are guidelines. For tailored running parameters and technical support please contact Leitz Tooling directly, use the machining calculator on xpert.leitz.org or download the app.

Tool & Saw Sharpening?

Leitz sharpens tooling from all manufacturers, including HSS, Carbide & diamond (PCD) tools.

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1.4 Roughing Finishing Routers



Z3 Roughing Finishing Router, Down Cut:

Application:

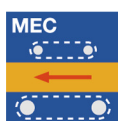
Router cutter for sizing and grooving in roughing/finishing quality.

Machinery:

Stationary routers with or without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Solid tungsten carbide. Short design for increased stability. Long design for increased cutting depth (recommended in several steps). Higher feed speeds than conventional roughing cutters. Extremely smooth running. Manufactured from high-grade carbide.



Spiral Roughing Finishing Router, Z3 NEG

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
6	70	15	6	Z3	RH	807010074
6	70	20	6	Z3	RH	807010075
6	70	25	6	Z3	RH	807010076
6	70	30	6	Z3	RH	807010077
8	80	20	8	Z3	RH	807010078
8	80	25	8	Z3	RH	807010079
8	80	30	8	Z3	RH	807010080
8	80	35	8	Z3	RH	807010081
8	80	40	8	Z3	RH	807010082
10	80	25	10	Z3	RH	807010083
10	80	30	10	Z3	RH	807010084
10	80	35	10	Z3	RH	807010085
10	80	40	10	Z3	RH	807010086
12	80	25	12	Z3	RH	807010305
12	80	30	12	Z3	RH	807010087
12	80	35	12	Z3	RH	807010088
12	80	40	12	Z3	RH	807010089
12	80	45	12	Z3	RH	807010090
12	80	50	12	Z3	RH	807010091
16	100	40	16	Z3	RH	807010092
16	100	50	16	Z3	RH	807010093
16	100	55	16	Z3	RH	807010094
16	100	60	16	Z3	RH	807010095
20	120	55	20	Z3	RH	807010096
20	120	60	20	Z3	RH	807010097

Materials:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).

Material	Suitability
Softwood - Dry	◆
Softwood - Wet	◆
Hardwood - Dry	◆
Hardwood - Wet	◆
Plywood	◆
Chipboard	◆
MDF	◆
WPC (Wood -Plastic-Composite)	◆

◆ = Suitable ◇ = Partially Suitable

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$
Feed Speed: 5 m/min - 30m/min

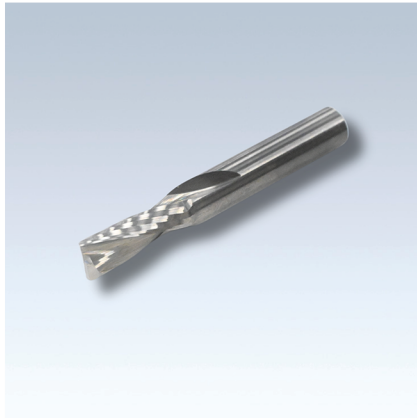
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Tool & Saw Sharpening?

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2.1 Finishing Routers



Z2 Finishing Router, Up Cut:

Application:

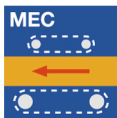
Router cutter for sizing, grooving and finish cutting. For high demands on finish quality.

Machinery:

Stationary routers with or without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Ideally used after roughing cutters, finish cut allowance approx. 1-2 mm. Check twist direction for good top layer quality. Short design for increased stability and reduced vibration. Long design for larger material thickness at reduced feed speeds. Manufactured from high-grade carbide.



Spiral Finishing Router, Z2 POS

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
6	70	15	6	Z2	RH	807010098
6	70	20	6	Z2	RH	807010099
6	70	25	6	Z2	RH	807010100
6	70	30	6	Z2	RH	807010101
8	80	20	8	Z2	RH	807010102
8	80	25	8	Z2	RH	807010103
8	80	30	8	Z2	RH	807010104
8	80	35	8	Z2	RH	807010105
8	80	40	8	Z2	RH	807010106
10	80	25	10	Z2	RH	807010107
10	80	30	10	Z2	RH	807010108
10	80	35	10	Z2	RH	807010109
10	80	40	10	Z2	RH	807010110
12	80	25	12	Z2	RH	807010298
12	80	30	12	Z2	RH	807010111
12	80	35	12	Z2	RH	807010112
12	80	40	12	Z2	RH	807010113
12	80	45	12	Z2	RH	807010114
12	80	50	12	Z2	RH	807010115
16	100	40	16	Z2	RH	807010116
16	100	50	16	Z2	RH	807010117
16	100	55	16	Z2	RH	807010118
16	100	60	16	Z2	RH	807010119
20	120	55	20	Z2	RH	807010120
20	120	60	20	Z2	RH	807010121

Materials:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).

Material	Suitability
Softwood - Dry	◆
Softwood - Wet	◆
Hardwood - Dry	◆
Hardwood - Wet	◆
Plywood	◆
Chipboard	◆
MDF	◆
WPC (Wood -Plastic-Composite)	◆

◆ = Suitable ◇ = Partially Suitable

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$
Feed Speed: 5 m/min - 30m/min

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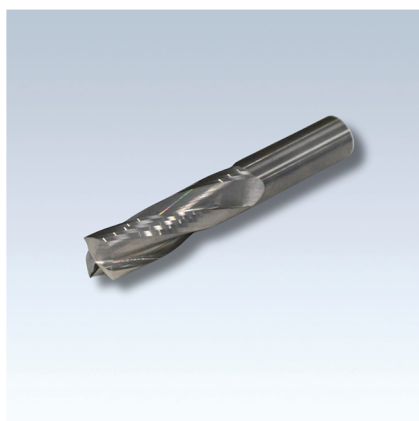
Tool & Saw Sharpening?

Leitz sharpens tooling from all manufacturers, including HSS, Carbide & diamond (PCD) tools.

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2.2 Finishing Routers



Z3 Finishing Router, Up Cut:

Application:

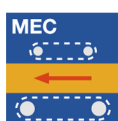
Router cutter for sizing, grooving and finish cutting. For high demands on finish quality.

Machinery:

Stationary routers with or without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Ideally used after roughing cutters, finish cut allowance approx. 1-2 mm. Check twist direction for good top layer quality. Short design for increased stability and reduced vibration. Long design for larger material thickness at reduced feed speeds. Manufactured from high-grade carbide.



Materials:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).

Spiral Finishing Router, Z3 POS

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
6	70	15	6	Z3	RH	807010146
6	70	20	6	Z3	RH	807010147
6	70	25	6	Z3	RH	807010148
6	70	30	6	Z3	RH	807010149
8	80	20	8	Z3	RH	807010150
8	80	25	8	Z3	RH	807010151
8	80	30	8	Z3	RH	807010152
8	80	35	8	Z3	RH	807010153
8	80	40	8	Z3	RH	807010154
10	80	25	10	Z3	RH	807010155
10	80	30	10	Z3	RH	807010156
10	80	35	10	Z3	RH	807010157
10	80	40	10	Z3	RH	807010158
12	80	25	12	Z3	RH	807010299
12	80	30	12	Z3	RH	807010159
12	80	35	12	Z3	RH	807010160
12	80	40	12	Z3	RH	807010161
12	80	45	12	Z3	RH	807010162
12	80	50	12	Z3	RH	807010163
16	100	40	16	Z3	RH	807010164
16	100	50	16	Z3	RH	807010165
16	100	55	16	Z3	RH	807010166
16	100	60	16	Z3	RH	807010167
20	120	55	20	Z3	RH	807010168
20	120	60	20	Z3	RH	807010169

Material	Suitability
Softwood - Dry	◆
Softwood - Wet	◆
Hardwood - Dry	◆
Hardwood - Wet	◆
Plywood	◆
Chipboard	◆
MDF	◆
WPC (Wood -Plastic-Composite)	◆

◆ = Suitable ◇ = Partially Suitable

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$
Feed Speed: 5 m/min - 30m/min

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Tool & Saw Sharpening?

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contact-uk@leitz.org

2.3 Finishing Routers



Z2 Finishing Router, Down Cut:

Application:

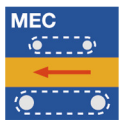
Router cutter for sizing, grooving and finish cutting. For high demands on finish quality.

Machinery:

Stationary routers with or without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Ideally used after roughing cutters, finish cut allowance approx. 1-2 mm. Check twist direction for good top layer quality. Short design for increased stability and reduced vibration. Long design for larger material thickness at reduced feed speeds. Manufactured from high-grade carbide.



Materials:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).

Spiral Finishing Router, Z2 NEG

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
6	70	15	6	Z2	RH	807010122
6	70	20	6	Z2	RH	807010123
6	70	25	6	Z2	RH	807010124
6	70	30	6	Z2	RH	807010125
8	80	20	8	Z2	RH	807010126
8	80	25	8	Z2	RH	807010127
8	80	30	8	Z2	RH	807010128
8	80	35	8	Z2	RH	807010129
8	80	40	8	Z2	RH	807010130
10	80	25	10	Z2	RH	807010131
10	80	30	10	Z2	RH	807010132
10	80	35	10	Z2	RH	807010133
10	80	40	10	Z2	RH	807010134
12	80	25	12	Z2	RH	807010300
12	80	30	12	Z2	RH	807010135
12	80	35	12	Z2	RH	807010136
12	80	40	12	Z2	RH	807010137
12	80	45	12	Z2	RH	807010138
12	80	50	12	Z2	RH	807010139
16	100	40	16	Z2	RH	807010140
16	100	50	16	Z2	RH	807010141
16	100	55	16	Z2	RH	807010142
16	100	60	16	Z2	RH	807010143
20	120	55	20	Z2	RH	807010144
20	120	60	20	Z2	RH	807010145

Material	Suitability
Softwood - Dry	◆
Softwood - Wet	◆
Hardwood - Dry	◆
Hardwood - Wet	◆
Plywood	◆
Chipboard	◆
MDF	◆
WPC (Wood -Plastic-Composite)	◆

◆ = Suitable ◇ = Partially Suitable

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$
Feed Speed: 5 m/min - 30m/min

The listed parameters are guidelines. For tailored running parameters and technical support please contact Leitz Tooling directly, use the machining calculator on xpert.leitz.org or download the app.

Tool & Saw Sharpening?

Leitz sharpens tooling from all manufacturers, including HSS, Carbide & diamond (PCD) tools.

01279 454530

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2.4 Finishing Routers



Z3 Finishing Router, Down Cut:

Application:

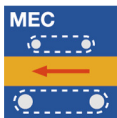
Router cutter for sizing, grooving and finish cutting. For high demands on finish quality.

Machinery:

Stationary routers with or without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Ideally used after roughing cutters, finish cut allowance approx. 1-2 mm. Check twist direction for good top layer quality. Short design for increased stability and reduced vibration. Long design for larger material thickness at reduced feed speeds. Manufactured from high-grade carbide.



Spiral Finishing Router, Z3 NEG

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
6	70	15	6	Z3	RH	807010170
6	70	20	6	Z3	RH	807010171
6	70	25	6	Z3	RH	807010172
6	70	30	6	Z3	RH	807010173
8	80	20	8	Z3	RH	807010174
8	80	25	8	Z3	RH	807010175
8	80	30	8	Z3	RH	807010176
8	80	35	8	Z3	RH	807010177
8	80	40	8	Z3	RH	807010178
10	80	25	10	Z3	RH	807010179
10	80	30	10	Z3	RH	807010180
10	80	35	10	Z3	RH	807010181
10	80	40	10	Z3	RH	807010182
12	80	25	12	Z3	RH	807010301
12	80	30	12	Z3	RH	807010183
12	80	35	12	Z3	RH	807010184
12	80	40	12	Z3	RH	807010185
12	80	45	12	Z3	RH	807010186
12	80	50	12	Z3	RH	807010187
16	100	40	16	Z3	RH	807010188
16	100	50	16	Z3	RH	807010189
16	100	55	16	Z3	RH	807010190
16	100	60	16	Z3	RH	807010191
20	120	55	20	Z3	RH	807010192
20	120	60	20	Z3	RH	807010193

Materials:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).

Material	Suitability
Softwood - Dry	◆
Softwood - Wet	◆
Hardwood - Dry	◆
Hardwood - Wet	◆
Plywood	◆
Chipboard	◆
MDF	◆
WPC (Wood -Plastic-Composite)	◆

◆ = Suitable ◇ = Partially Suitable

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$
Feed Speed: 5 m/min - 30m/min

The listed parameters are guidelines. For tailored running parameters and technical support please contact Leitz Tooling directly, use the machining calculator on xpert.leitz.org or download the app.

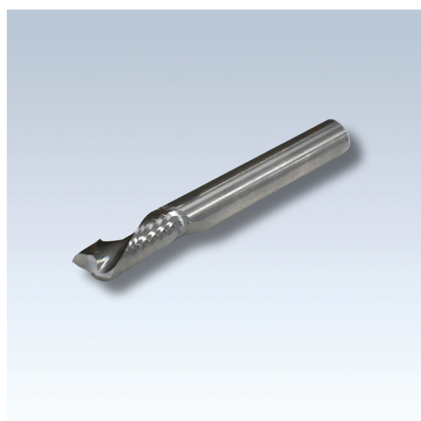
Tool & Saw Sharpening?

Leitz sharpens tooling from all manufacturers, including HSS, Carbide & diamond (PCD) tools.

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3.1 G-Tec Compression Routers



G-Tec Compression Router, Z1+1:

Application:

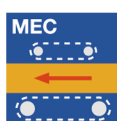
Router for sizing, grooving and finish cutting. For high demands on finish quality and tear-free cut edges on both sides. Specially formulated carbide for long tool life and high performance cutting.

Machinery:

Stationary routers with or without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Solid carbide router, made from specially formulated carbide for long tool life. Alternate twist for tear-free cutting edges on top and bottom surfaces. Especially suitable to cut coated chip and fibre boards, glulam, abrasive materials as well as composite materials with aluminium top layer.



G-Tec Compression Router, Z1+1

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
12	80	30	12	Z1+1	RH	807010282
12	80	35	12	Z1+1	RH	807010283
12	80	40	12	Z1+1	RH	807010284
12	80	50	12	Z1+1	RH	807010285
12.7	89	30	12.7	Z1+1	RH	807010286
12.7	89	35	12.7	Z1+1	RH	807010287
12.7	89	40	12.7	Z1+1	RH	807010288
12.7	89	50	12.7	Z1+1	RH	807010289

Materials:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).

Material	Suitability
Softwood - Dry	◆
Softwood - Wet	◆
Hardwood - Dry	◆
Hardwood - Wet	◆
Plywood	◆
Chipboard	◆
MDF	◆
WPC (Wood-Plastic-Composite)	◆

◆ = Suitable ◇ = Partially Suitable

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$
Feed Speed: 5 m/min - 40m/min

The listed parameters are guidelines. For tailored running parameters and technical support please contact Leitz Tooling directly, use the machining calculator on xpert.leitz.org or download the app.

Tool & Saw Sharpening?

Leitz sharpens tooling from all manufacturers, including HSS, Carbide & diamond (PCD) tools.

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3.2 G-Tec Compression Routers



G-Tec Compression Router, Z2+2:

Application:

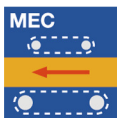
Router for sizing, grooving and finish cutting. For high demands on finish quality and tear-free cut edges on both sides. Specially formulated carbide for long tool life and high performance cutting.

Machinery:

Stationary routers with or without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Solid carbide router, made from specially formulated carbide for long tool life. Alternate twist for tear-free cutting edges on top and bottom surfaces. Especially suitable to cut coated chip and fibre boards, glulam, abrasive materials as well as composite materials with aluminium top layer.



G-Tec Compression Router, Z2+2

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
12	80	30	12	Z2+2	RH	807010308
12	80	35	12	Z2+2	RH	807010309
12	80	40	12	Z2+2	RH	807010310
12	80	50	12	Z2+2	RH	807010311
12.7	89	30	12.7	Z2+2	RH	807010312
12.7	89	35	12.7	Z2+2	RH	807010313
12.7	89	40	12.7	Z2+2	RH	807010314
12.7	89	50	12.7	Z2+2	RH	807010315

Materials:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).

Material	Suitability
Softwood - Dry	◆
Softwood - Wet	◆
Hardwood - Dry	◆
Hardwood - Wet	◆
Plywood	◆
Chipboard	◆
MDF	◆
WPC (Wood -Plastic-Composite)	◆

◆ = Suitable ◇ = Partially Suitable

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$
Feed Speed: 5 m/min - 40m/min

The listed parameters are guidelines. For tailored running parameters and technical support please contact Leitz Tooling directly, use the machining calculator on xpert.leitz.org or download the app.

Tool & Saw Sharpening?

Leitz sharpens tooling from all manufacturers, including HSS, Carbide & diamond (PCD) tools.

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3.3 G-Tec Compression Routers



G-Tec Compression Router, Z3+3:

Application:

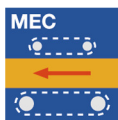
Router for sizing, grooving and finish cutting. For high demands on finish quality and tear-free cut edges on both sides. Specially formulated carbide for long tool life and high performance cutting.

Machinery:

Stationary routers with or without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Solid carbide router, made from specially formulated carbide for long tool life. Alternate twist for tear-free cutting edges on top and bottom surfaces. Especially suitable to cut coated chip and fibre boards, glulam, abrasive materials as well as composite materials with aluminium top layer.



G-Tec Compression Router, Z3+3

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
12	80	30	12	Z3+3	RH	807010334
12	80	35	12	Z3+3	RH	807010335
12	80	40	12	Z3+3	RH	807010336
12	80	50	12	Z3+3	RH	807010337
12.7	89	30	12.7	Z3+3	RH	807010338
12.7	89	35	12.7	Z3+3	RH	807010339
12.7	89	40	12.7	Z3+3	RH	807010340
12.7	89	50	12.7	Z3+3	RH	807010341

Materials:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).

Material	Suitability
Softwood - Dry	◆
Softwood - Wet	◆
Hardwood - Dry	◆
Hardwood - Wet	◆
Plywood	◆
Chipboard	◆
MDF	◆
WPC (Wood -Plastic-Composite)	◆

◆ = Suitable ◇ = Partially Suitable

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$
Feed Speed: 5 m/min - 40m/min

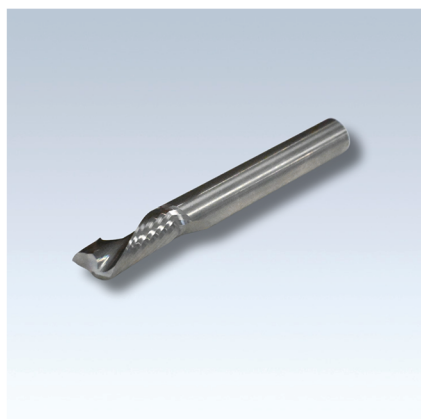
The listed parameters are guidelines. For tailored running parameters and technical support please contact Leitz Tooling directly, use the machining calculator on xpert.leitz.org or download the app.

Tool & Saw Sharpening?

Leitz sharpens tooling from all manufacturers, including HSS, Carbide & diamond (PCD) tools.

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4.1 Compression Routers



Z1+1 Compression Router:

Application:

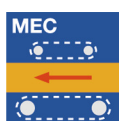
Router cutter for sizing, grooving and finish cutting. For high demands on finish quality and tear-free cut edges on both sides.

Machinery:

Stationary routers with or without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Alternate twist for tear-free cutting edges on top and bottom surfaces. Especially suitable to cut coated chip and fibre boards, glulam, abrasive materials as well as composite materials with aluminium top layer. Manufactured from high-grade carbide.



Materials:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).

Material	Suitability
Softwood - Dry	◆
Softwood - Wet	◆
Hardwood - Dry	◆
Hardwood - Wet	◆
Plywood	◆
Chipboard	◆
MDF	◆
WPC (Wood -Plastic-Composite)	◆

◆ = Suitable ◇ = Partially Suitable

Spiral Compression Router, Z1+1

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
6	70	15	6	Z1+1	RH	807010194
6	70	20	6	Z1+1	RH	807010195
6	70	25	6	Z1+1	RH	807010196
8	70	20	8	Z1+1	RH	807010197
8	70	25	8	Z1+1	RH	807010198
8	70	30	8	Z1+1	RH	807010199
8	70	35	8	Z1+1	RH	807010276
10	80	25	10	Z1+1	RH	807010200
10	80	30	10	Z1+1	RH	807010201
10	80	35	10	Z1+1	RH	807010277
10	80	40	10	Z1+1	RH	807010202
10	80	50	10	Z1+1	RH	807010203
12	80	25	12	Z1+1	RH	807010272
12	80	30	12	Z1+1	RH	807010204
12	80	35	12	Z1+1	RH	807010205
12	80	40	12	Z1+1	RH	807010206
12	80	45	12	Z1+1	RH	807010275
12	80	50	12	Z1+1	RH	807010207
12.7	88.9	25	12.7	Z1+1	RH	807010273
12.7	88.9	30	12.7	Z1+1	RH	807010208
12.7	88.9	35	12.7	Z1+1	RH	807010209
12.7	88.9	40	12.7	Z1+1	RH	807010210
12.7	88.9	45	12.7	Z1+1	RH	807010274
12.7	88.9	50	12.7	Z1+1	RH	807010211
16	100	40	16	Z1+1	RH	807010212
16	100	45	16	Z1+1	RH	807010213
16	100	50	16	Z1+1	RH	807010214
16	100	55	16	Z1+1	RH	807010215
16	100	60	16	Z1+1	RH	807010216
20	120	50	20	Z1+1	RH	807010217
20	120	55	20	Z1+1	RH	807010218
20	120	60	20	Z1+1	RH	807010219

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$
Feed Speed: 5 m/min - 30m/min

The listed parameters are guidelines. For tailored running parameters and technical support please contact Leitz Tooling directly, use the machining calculator on xpert.leitz.org or download the app.

Tool & Saw Sharpening?

Leitz sharpens tooling from all manufacturers, including HSS, Carbide & diamond (PCD) tools.

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4.2 Compression Routers



Z2+2 Compression Router:

Application:

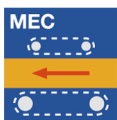
Router cutter for sizing, grooving and finish cutting. For high demands on finish quality and tear-free cut edges on both sides.

Machinery:

Stationary routers with or without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Alternate twist for tear-free cutting edges on top and bottom surfaces. Especially suitable to cut coated chip and fibre boards, glulam, abrasive materials as well as composite materials with aluminium top layer. Manufactured from high-grade carbide.



Materials:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).

Material	Suitability
Softwood - Dry	◆
Softwood - Wet	◆
Hardwood - Dry	◆
Hardwood - Wet	◆
Plywood	◆
Chipboard	◆
MDF	◆
WPC (Wood -Plastic-Composite)	◆

◆ = Suitable ◇ = Partially Suitable

Spiral Compression Router, Z2+2

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
6	70	15	6	Z2+2	RH	807010220
6	70	20	6	Z2+2	RH	807010221
6	70	25	6	Z2+2	RH	807010222
8	70	20	8	Z2+2	RH	807010223
8	70	25	8	Z2+2	RH	807010224
8	70	30	8	Z2+2	RH	807010225
8	70	35	8	Z2+2	RH	807010290
10	80	25	10	Z2+2	RH	807010226
10	80	30	10	Z2+2	RH	807010227
10	80	35	10	Z2+2	RH	807010291
10	80	40	10	Z2+2	RH	807010228
10	80	50	10	Z2+2	RH	807010229
12	80	25	12	Z2+2	RH	807010278
12	80	30	12	Z2+2	RH	807010230
12	80	35	12	Z2+2	RH	807010231
12	80	40	12	Z2+2	RH	807010232
12	80	45	12	Z2+2	RH	807010281
12	80	50	12	Z2+2	RH	807010233
12.7	88.9	25	12.7	Z2+2	RH	807010279
12.7	88.9	30	12.7	Z2+2	RH	807010234
12.7	88.9	35	12.7	Z2+2	RH	807010235
12.7	88.9	40	12.7	Z2+2	RH	807010236
12.7	88.9	45	12.7	Z2+2	RH	807010280
12.7	88.9	50	12.7	Z2+2	RH	807010237
16	100	40	16	Z2+2	RH	807010238
16	100	45	16	Z2+2	RH	807010239
16	100	50	16	Z2+2	RH	807010240
16	100	55	16	Z2+2	RH	807010241
16	100	60	16	Z2+2	RH	807010242
20	120	50	20	Z2+2	RH	807010243
20	120	55	20	Z2+2	RH	807010244
20	120	60	20	Z2+2	RH	807010245

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$
Feed Speed: 5 m/min - 30m/min

The listed parameters are guidelines. For tailored running parameters and technical support please contact Leitz Tooling directly, use the machining calculator on xpert.leitz.org or download the app.

Tool & Saw Sharpening?

Leitz sharpens tooling from all manufacturers, including HSS, Carbide & diamond (PCD) tools.

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4.3 Compression Routers



Z3+3 Compression Router:

Application:

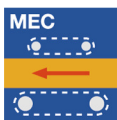
Router cutter for sizing, grooving and finish cutting. For high demands on finish quality and tear-free cut edges on both sides.

Machinery:

Stationary routers with or without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Alternate twist for tear-free cutting edges on top and bottom surfaces. Especially suitable to cut coated chip and fibre boards, glulam, abrasive materials as well as composite materials with aluminium top layer. Manufactured from high-grade carbide.



Spiral Compression Router, Z3+3

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
6	70	15	6	Z3+3	RH	807010246
6	70	20	6	Z3+3	RH	807010247
6	70	25	6	Z3+3	RH	807010248
8	70	20	8	Z3+3	RH	807010249
8	70	25	8	Z3+3	RH	807010250
8	70	30	8	Z3+3	RH	807010251
8	70	35	8	Z3+3	RH	807010296
10	80	25	10	Z3+3	RH	807010252
10	80	30	10	Z3+3	RH	807010253
10	80	35	10	Z3+3	RH	807010297
10	80	40	10	Z3+3	RH	807010254
10	80	50	10	Z3+3	RH	807010255
12	80	25	12	Z3+3	RH	807010292
12	80	30	12	Z3+3	RH	807010256
12	80	35	12	Z3+3	RH	807010257
12	80	40	12	Z3+3	RH	807010258
12	80	45	12	Z3+3	RH	807010295
12	80	50	12	Z3+3	RH	807010259
12.7	88.9	25	12.7	Z3+3	RH	807010293
12.7	88.9	30	12.7	Z3+3	RH	807010260
12.7	88.9	35	12.7	Z3+3	RH	807010261
12.7	88.9	40	12.7	Z3+3	RH	807010262
12.7	88.9	45	12.7	Z3+3	RH	807010294
12.7	88.9	50	12.7	Z3+3	RH	807010263
16	100	40	16	Z3+3	RH	807010264
16	100	45	16	Z3+3	RH	807010265
16	100	50	16	Z3+3	RH	807010266
16	100	55	16	Z3+3	RH	807010267
16	100	60	16	Z3+3	RH	807010268
20	120	50	20	Z3+3	RH	807010269
20	120	55	20	Z3+3	RH	807010270
20	120	60	20	Z3+3	RH	807010271

Materials:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).

Material	Suitability
Softwood - Dry	◆
Softwood - Wet	◆
Hardwood - Dry	◆
Hardwood - Wet	◆
Plywood	◆
Chipboard	◆
MDF	◆
WPC (Wood -Plastic-Composite)	◆

◆ = Suitable ◇ = Partially Suitable

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$
Feed Speed: 5 m/min - 30m/min

The listed parameters are guidelines. For tailored running parameters and technical support please contact Leitz Tooling directly, use the machining calculator on xpert.leitz.org or download the app.

Tool & Saw Sharpening?

Leitz sharpens tooling from all manufacturers, including HSS, Carbide & diamond (PCD) tools.

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5.1 Keyhole Cutter



Keyhole Router, Z2 & Z3:

Application:

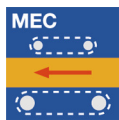
Router cutter for sizing and cutting spyholes and keyholes in roughing/finishing quality.

Machinery:

Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Solid tungsten carbide. Extra long design for increased cutting depth (in several steps).
Manufactured from high-grade carbide.



Keyhole Router Cutter, Z2

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
12	155	25	12	Z2	RH	807010350
12	155	30	12	Z2	RH	807010351
12	155	35	12	Z2	RH	807010352
12	155	50	12	Z2	RH	807010353
16	155	30	16	Z2	RH	807010354
16	155	35	16	Z2	RH	807010355
16	170	50	16	Z2	RH	807010356

Keyhole Router Cutter, Z3

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
12	155	25	12	Z3	RH	807010357
12	155	30	12	Z3	RH	807010358
12	155	35	12	Z3	RH	807010359
12	155	50	12	Z3	RH	807010360
16	155	30	16	Z3	RH	807010361
16	155	35	16	Z3	RH	807010362
16	170	50	16	Z3	RH	807010363

Materials:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).

Material	Suitability
Softwood - Dry	◆
Softwood - Wet	◆
Hardwood - Dry	◆
Hardwood - Wet	◆
Plywood	◆
Chipboard	◆
MDF	◇
WPC (Wood -Plastic-Composite)	◇

◆ = Suitable ◇ = Partially Suitable

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$
Feed Speed: 10m/min - 18m/min

The listed parameters are guidelines. For tailored running parameters and technical support please contact Leitz Tooling directly, use the machining calculator on xpert.leitz.org or download the app.

Tool & Saw Sharpening?

Leitz sharpens tooling from all manufacturers, including HSS, Carbide & diamond (PCD) tools.

01279 454530
contact-uk@leitz.org

5.2 Lockcase Router



Lockcase Router, Z2 & Z3:

Application:

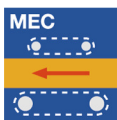
Router cutter for sizing and cutting lockcases in roughing/finishing quality.

Machinery:

Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Solid tungsten carbide. Extra long design for increased cutting depth (in several steps).
Manufactured from high-grade carbide.



Lockcase Router Cutter, Z2

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
12	155	25	12	Z2	RH	807010364
12	155	30	12	Z2	RH	807010365
12	155	35	12	Z2	RH	807010366
12	155	50	12	Z2	RH	807010367
16	155	30	16	Z2	RH	807010368
16	155	35	16	Z2	RH	807010369
16	170	50	16	Z2	RH	807010370

Lockcase Router Cutter, Z3

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
12	155	25	12	Z3	RH	807010371
12	155	30	12	Z3	RH	807010372
12	155	35	12	Z3	RH	807010373
12	155	50	12	Z3	RH	807010374
16	155	30	16	Z3	RH	807010375
16	155	35	16	Z3	RH	807010376
16	170	50	16	Z3	RH	807010377

Materials:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).

Material	Suitability
Softwood - Dry	◆
Softwood - Wet	◆
Hardwood - Dry	◆
Hardwood - Wet	◆
Plywood	◆
Chipboard	◆
MDF	◇
WPC (Wood -Plastic-Composite)	◇

◆ = Suitable ◇ = Partially Suitable

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$
Feed Speed: 10m/min - 18m/min

The listed parameters are guidelines. For tailored running parameters and technical support please contact Leitz Tooling directly, use the machining calculator on xpert.leitz.org or download the app.

Tool & Saw Sharpening?

Leitz sharpens tooling from all manufacturers, including HSS, Carbide & diamond (PCD) tools.

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6.0 Ball Nose Routers



Ball Nose Router, Z2:

Application:

versatile tool for creating smooth curves, 3D carvings, and decorative edges. Ideal for shaping intricate details, producing clean cuts, and leaving a polished finish on various materials.

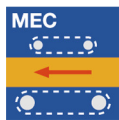
Machinery:

Stationary routers with or without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Solid tungsten carbide. Extra long design for increased cutting depth.

Manufactured from high-grade carbide. Two flute design for improved chip clearance.



Ball Nose Router Cutter, Z2 Short

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
8	80	20	8	Z2	RH	807010378
10	80	20	10	Z2	RH	807010379
12	80	25	12	Z2	RH	807010380
16	100	35	16	Z2	RH	807010381
20	120	55	20	Z2	RH	807010382

Ball Nose Router Cutter, Z2 Long

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
8	100	30	8	Z2	RH	807010383
10	100	40	10	Z2	RH	807010384
12	120	55	12	Z2	RH	807010385
16	120	60	16	Z2	RH	807010386
20	150	60	20	Z2	RH	807010387

Materials:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).

Material	Suitability
Softwood - Dry	◆
Softwood - Wet	◆
Hardwood - Dry	◆
Hardwood - Wet	◆
Plywood	◆
Chipboard	◆
MDF	◆
WPC (Wood-Plastic-Composite)	◆

◆ = Suitable ◇ = Partially Suitable

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$
Feed Speed: 5 m/min - 30m/min

The listed parameters are guidelines. For tailored running parameters and technical support please contact Leitz Tooling directly, use the machining calculator on xpert.leitz.org or download the app.

Tool & Saw Sharpening?

Leitz sharpens tooling from all manufacturers, including HSS, Carbide & diamond (PCD) tools.

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7.0 Milling Routers



Z1 Milling Routers For Aluminium

Application:

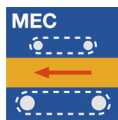
Router cutter for sizing, grooving and finish cutting. For high demands on finish quality.

Machinery:

Stationary routers with or without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Large twist angle for high shear cut. Check twist direction for good top layer cut quality. Maximum cutting depth 1.0 - 1.5 x D. Short design for increased stability and reduced vibration. Long design for increased cutting depth (recommended in several steps). When machining aluminium, carbide tools should be operated using cooling lubricants (emulsion or minimum quantity lubrication MQL).



Milling Router Cutters, Z1

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
6	60	15	6	Z1	RH	807010388
6	60	20	6	Z1	RH	807010389
6	60	25	6	Z1	RH	807010390
8	60	20	8	Z1	RH	807010391
8	80	20	8	Z1	RH	807010306
8	60	25	8	Z1	RH	807010392
8	60	30	8	Z1	RH	807010393
8	80	30	8	Z1	RH	807010316
8	100	30	8	Z1	RH	807010307
8	70	35	8	Z1	RH	807010394
8	70	40	8	Z1	RH	807010395
10	70	20	10	Z1	RH	807010396
10	70	25	10	Z1	RH	807010397
10	70	30	10	Z1	RH	807010398
10	70	35	10	Z1	RH	807010399
10	70	40	10	Z1	RH	807010400
10	70	45	10	Z1	RH	807010401
12	80	30	12	Z1	RH	807010402
12	80	35	12	Z1	RH	807010403
12	80	40	12	Z1	RH	807010404
12	80	45	12	Z1	RH	807010405
12	80	50	12	Z1	RH	807010406

Materials:

Aluminium and non-ferrous metals.

Material	Suitability
Aluminium	◆
Non-Ferrous Metals	◆

◆ = Suitable ◇ = Partially Suitable

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$
Feed Speed: 2m/min - 10m/min

The listed parameters are guidelines. For tailored running parameters and technical support please contact Leitz Tooling directly, use the machining calculator on xpert.leitz.org or download the app.

Tool & Saw Sharpening?

Leitz sharpens tooling from all manufacturers, including HSS, Carbide & diamond (PCD) tools.

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8.1 Diamond Routers (PCD)



Diamaster Pro Router, Z2+2

Application:

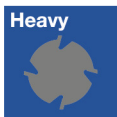
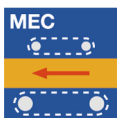
Router cutter for sizing and grooving (Nesting) at high feed speeds. For tear-free cut edges on both sides of the workpiece.

Machinery:

Stationary routers with or without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Spiral cutting edge arrangement with alternate shear angle and real - Z 2 over the complete cutting length, with DP plunging tip. Resharpenable up to 3 times with normal wear. Tool body made from high-tensile material. Important to follow the application data parameters.



Diamaster Pro Router Cutter, Z2+2

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
10	65	19	10	Z2+2	RH	191059
12	70	24	12	Z2+2	RH	191060
12	75	28	12	Z2+2	RH	191061
14	90	35	14	Z2+2	RH	191101
16	105	45	16	Z2+2	RH	191105

Materials:

Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

Material	Suitability
Softwood - Dry	◆
Softwood - Wet	◆
Hardwood - Dry	◆
Hardwood - Wet	◆
Plywood	◆
Chipboard	◆
MDF	◆
WPC (Wood -Plastic-Composite)	◆

◆ = Suitable ◇ = Partially Suitable

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$

To calculate your cutting speeds, use the Leitz machining calculator. visit xpert.leitz.org or download the Leitz Xpert app on Google Play or the App Store.

Need Diamond Errosion?

Leitz sharpen a large range of diamond tooling. With advanced EDM erosion machines.

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8.2 Diamond Routers (PCD)



Diamaster Pro³ Router, Z3+3

Application:

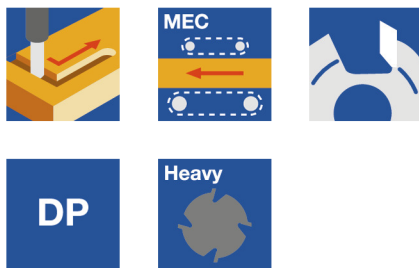
Router cutter for sizing and grooving (Nesting) at high feed speeds. For tear-free cut edges on both sides of the workpiece.

Machinery:

Stationary routers with or without CNC control, machining centres, milling machines with spindles to mount shank tools.

Technical Information:

Spiral cutting edge arrangement with alternate shear angle and real - Z 3 over the complete cutting length, with DP plunging tip. Resharpenable up to 3 times with normal wear. Tool body made from high-tensile material. Important to follow the application data parameters.



Diamaster Pro³ Router Cutter, Z3+3

Diameter mm	Total Length mm	Cutting Length mm	Shank Size mm	No. Wings	Rotation	Product ID
12	65	19	12	Z3+3	RH	191030
12	70	24	12	Z3+3	RH	191031
12	75	28	12	Z3+3	RH	191032
14	90	33	16	Z3+3	RH	191133

Materials:

Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

Material	Suitability
Softwood - Dry	◆
Softwood - Wet	◆
Hardwood - Dry	◆
Hardwood - Wet	◆
Plywood	◆
Chipboard	◆
MDF	◆
WPC (Wood-Plastic-Composite)	◆

◆ = Suitable ◆ = Partially Suitable

RPM & Cutting Speeds:

RPM: $n = 18,000 - 24,000 \text{ min}^{-1}$

To calculate your cutting speeds, use the Leitz machining calculator. visit xpert.leitz.org or download the Leitz Xpert app on Google Play or the App Store.

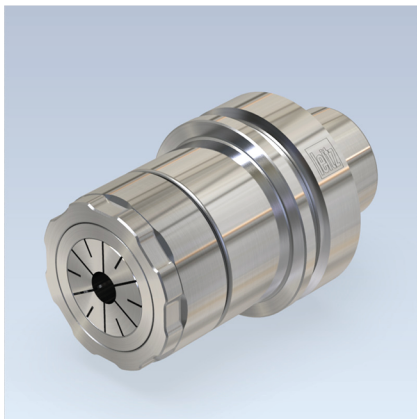
Need Diamond Erosion?

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9.1 Clamping Systems - NiRo Collet chuck



NiRo Collet Chuck Premium With Hollow Taper Shank HSK-F 63

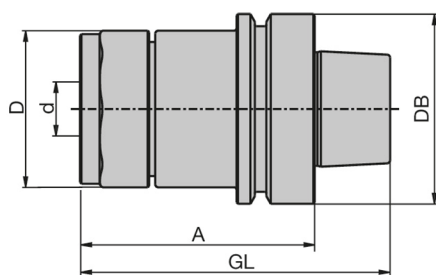
Application:

Precision tool chuck especially for use in difficult climatic conditions with collet for clamping shank tools with cylindrical shank and shank diameters up to $d_{max} = 25.4 \text{ mm}$ (1").

Technical Information:

Suitable for left- and right-hand rotation. Even clamping due to ball bearing nut allows easy tool removal. Advanced design and hardened material improve concentricity and reduce deflection. Slim design for improved material accessibility and extraction. compared to monobloc design. Tool chuck and collet nut fine balanced. Suitable mounting device VN 799 0 see section Knives and Spare Parts. Easy and safe.

HSK-F 63, DIN 69893, A = 78, diameter range 6-25.4 mm



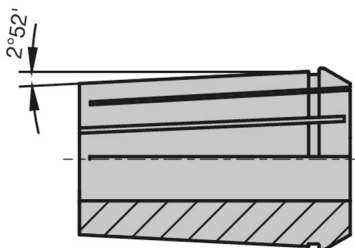
NiRo Collet chuck Premium HSK-F 63

Diameter	Cutting Circle Diameter	Shoulder Diameter	Clamping Length	Total Length	Weight	Product ID
6 - 25.4 mm	52mm	63mm	78mm	103mm	1.1 KG	679043

Sales unit consisting of clamping chuck with ball bearing collet nut, without collet or clamping key.

Spare Parts:

Spare Part:	Dimensions mm	For S mm	Product ID
Collet (2"52")		6	037429
Collet (2"52")		8	037430
Collet (2"52")		10	037431
Collet (2"52")		12	037432
Collet (2"52")		14	037433
Collet (2"52")		16	037434
Collet (2"52")		18	037435
Collet (2"52")		20	037436
Collet (2"52")		25	037437
Collet (2"52")		6.35 (1/4")	037438
Collet (2"52")		9.53 (3/8")	037495
Collet (2"52")		12.7 (1/2")	037505
Collet (2"52")		15.88 (5/8")	037496
Collet (2"52")		19.05 (3/4")	037508
Collet (2"52")	9x12, 20-100 Nm	25.4 (1")	117540
Clamping Key	9x12		117541
Insert For Torque Wrench	R44x1,5		117542
Collet Chuck Nut NiRo With Ball Bearing			006663
Chip-Balluf	511 Bytes		081309
Chip-Balluf	2047 Bytes		081330



Collet Angle 2"52" : ISO 10897, Form B



Special Key Uniquely For The NiRo Collet Chuck Premium

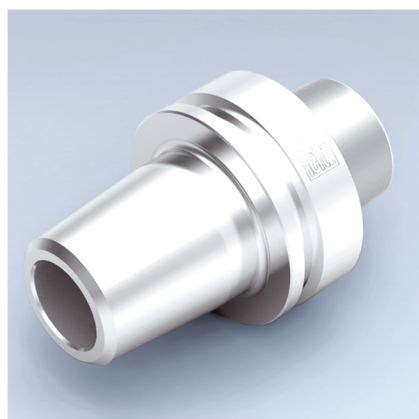


Looking for SK30 or ISO30 Clamping Systems?

Leitz tooling manufacturers a large range of ISO and SK collet chucks. Please contact Leitz Tooling to discuss your requirements or visit us online lexicon to explore the full range.

Web: Lexicon.leitz.org
Email: Contact-uk@leitz.org
Phone: 012179 454530

9.2 Clamping Systems - ThermoGrip® Chuck



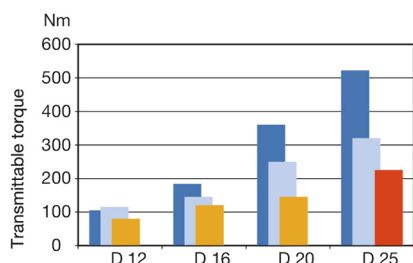
Shrink-Fit Chuck ThermoGrip® With Hollow Taper Shank

Application:

High precision tool chuck for clamping shank tools by thermal shrinking. Has the highest stability and rigidity of all shank tools clamping systems, suitable for HSC and HPC machining.

Technical Information:

Tool chuck for high performance. Precision-balanced for speeds up to 36000 min⁻¹. Short, slim design for improved chip flow extraction. For clamping tungsten carbide and steel shanks. Clamping eccentricity within ≤ 0.01 mm



ThermoGrip® shrink-fit chuck

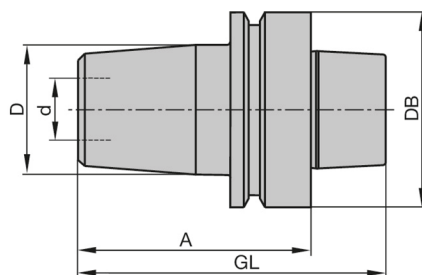
Collet DIN ISO 10897-B25,
75 Nm Tightening torque

Collet DIN ISO 15488-B32 (ER32),
75 Nm Tightening torque

Hydro clamping chuck

The clamping range of collet chucks and hydro clamping chucks includes shank tolerances g7 and h6.

Leitz ThermoGrip® chucks are designed for a shank tolerance h6 for clamping diameters $d < 12$ mm and a shank tolerance g6 for clamping diameters $d \geq 12$ mm.



HSK-E 63, DIN 69893

Diameter	Cutting Circle Diameter	Shoulder Diameter	Clamping Length	Total Length	Weight	Chuck Tolerance	Product ID
8	27	63	75	107	0.9	h6	670002
9.53	34	63	75	107	0.9	h6	670023
10	32	63	75	107	0.9	g6	670003
12	34	63	75	107	0.9	g6	670004
12.7	34	63	75	107	0.9	g6	670024
14	34	63	75	107	0.9	g6	670005
16	34	63	75	107	0.9	g6	670006
18	42	63	75	107	1.0	g6	670007
20	42	63	75	107	1.0	g6	670008
25	42	63	75	107	1.0	g6	670009
32	53	63	75	122	1.2	g6	670016

HSK-F 63, DIN 69893

Diameter	Cutting Circle Diameter	Shoulder Diameter	Clamping Length	Total Length	Weight	Chuck Tolerance	Product ID
6	27	63	75	100	0.8	h6	037713
8	27	63	75	100	0.8	h6	037714
9.35 (3/8")	32	63	75	100	0.9	h6	670010
10	32	63	75	100	0.9	h6	037715
10	32	63	120	145	1.0	h6	670017
12	32	63	75	100	0.9	g6	037712
12	34	63	90	115	1.0	g6	670018
12	34	63	120	145	1.1	g6	670019
12.7 (1/2")	34	63	75	100	0.9	h6	670011
14	34	63	75	100	0.9	g6	037716
16	34	63	75	100	0.9	g6	037709
16	34	63	95	120	1.0	g6	670020
16	34	63	120	145	1.0	g6	670021
18	42	63	75	100	1.0	g6	037718
19.05 (3/4")	42	63	75	100	0.9	h6	670012
20	42	63	75	100	1.0	g6	037710
20	42	63	100	125	1.2	g6	670022
25	42	63	75	100	0.9	g6	037711
32	42	63	90	115	1.2	g6	670000



Looking for SK30 or ISO30 Clamping Systems?

Leitz tooling manufacturers a large range of ISO and SK collet chucks. Please contact Leitz Tooling to discuss your requirements or visit us online lexicon to explore the full range.

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Phone: 012179 454530

9.3 Clamping Systems - Collet Chucks



Collet Chuck With Hollow Taper Shank HSK-F 63

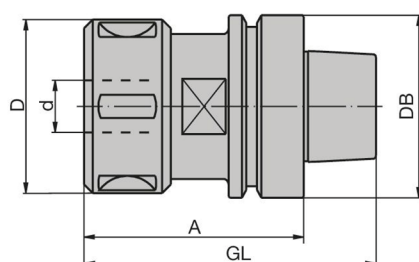
Application:

Precision tool chuck with collet for clamping shank tools with cylindrical shank and shank diameters up to $d_{max} = 25.4 \text{ mm}$ (1").

Technical Information:

Hollow taper shank as per DIN 69893. Exact concentric running through hardened, ground and double slotted collets. Easy handling as loosening the ball bearing collet nut automatically opens the collet. Suitable for right hand and left hand rotation because of ball bearing collet nut.

Ball bearing collet nut for increased clamping forces and improved concentricity compared to monobloc design. Tool chuck and collet nut fine balanced.

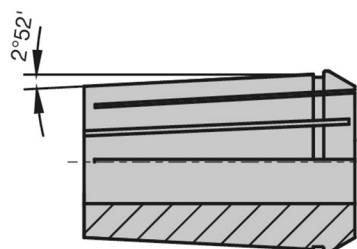


HSK-F 63, DIN 69893, A = 78, diameter range 6-25.4 mm

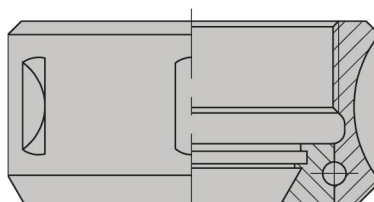
Diameter	Cutting Circle Diameter	Shoulder Diameter	Clamping Length	Total Length	Weight	Product ID
6-25.4	60	63	78	103	1.1 kg	037412
6-25.4	60	63	105	130	1.5 kg	037924

Sales unit consisting of clamping chuck with ball bearing collet nut, without collet or spanner. All dimensions are in mm.

Collet chuck HSK-F 63



Collet Angle 2°52' : ISO 10897, Form B



Ball Bearing Collet Nut

Spare Parts:

Spare Part:	Dimensions mm	For S mm	Product ID
Collet (2°52')		6	037429
Collet (2°52')		8	037430
Collet (2°52')		10	037431
Collet (2°52')		12	037432
Collet (2°52')		14	037433
Collet (2°52')		16	037434
Collet (2°52')		18	037435
Collet (2°52')		20	037436
Collet (2°52')		25	037437
Collet (2°52')		6.35 (1/4")	037438
Collet (2°52')		9.53 (3/8")	037495
Collet (2°52')		12.7 (1/2")	037505
Collet (2°52')		15.88 (5/8")	037496
Collet (2°52')		19.05 (3/4")	037502
Collet (2°52')		25.4 (1")	037497
Collet (2°52')	9x12, 20-100 Nm		037508
Sickle Spanner	58/62		005458
Collet Chuck Nut NiRo With Ball Bearing	M48x2		005714
Chip-Balluf	511 Bytes		081309
Chip-Balluf	2047 Bytes		081330

Looking for SK30 or ISO30 Clamping Systems?

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Email: Contact-uk@leitz.org
Phone: 012179 454530



9.4 Clamping Systems - Mounting Devices



Collet Chuck Mounting Devices

Application:

For the assembly of shank tools in clamping chucks or tools with borehole on arbors with adaptors for automatic tool change

- Reduced risk of injury when mounting tools
- Quick clamping levers and fixing pins secure the clamped taper axially as well as against twisting“).

Mounting Device - VN 799 0

BEZ	Product ID
Mounting device for SK 30/BT30 with grooves and notches	079000
Mounting device for SK40	079001
Mounting device for HSK-F50	079002
Mounting device for HSK-E63 and HSK-F63	079044
Mounting device for SCM/Morbidelli ISO30	079004
Mounting device for CMS ISO30	079005
Mounting device for Alberti HSK-E 40	079006



Universal Collet Chuck Mounting Device

Application:

For mounting saws, tools, tool sets and cutterheads.

- Reduced risk of injury when mounting tools
- Quick clamping levers and fixing pins secure the clamped taper axially as well as against twisting“).

Suitable for the majority of modern collet chucks including HSK-F63 and NiRo chucks.

Mounting Device - VN 799 0

BEZ	Product ID
Mounting device EASY-Hold (HSK-F 63 / HSK-E 63)	L79009

Customer Testimonials

Real reviews from real companies!



“

I've dealt with Leitz for 20yrs+ and the reasons are very simple. Their products are great quality and their reps know the products well.

One example are the helical planing blocks which have been a game changer for my business in saving time and money. Why would I go anywhere else.



Adrian Sams, Via Google

”

“

We have used Leitz for close to 10 years, since we upgraded to a cnc machine for our staircase company. They are always very professional and advice has always been spot on. Would highly recommend anyone who needs sharpening or new tooling to definitely try Leitz



Beadles Joinery, Via Google

”

“

Always very impressed with Leitz and our rep who we have worked with for over 25 years.

Their product knowledge has helped with choosing manual and CNC tooling. Avoiding us wasting money on incorrect products. Leitz fully deliver on their reputation for industry leading quality



Andrew Clark, Via Google

”

“

We've been using Leitz Tooling for the last 35+ years for our sharpening and tooling.

I have dealt with the same representative for the last 20 + years. I cannot fault him, he turns up every week, is always reachable on the phone and his knowledge is exceptionally good. All round great service.



Dalton Joinery, Via Google

”

“

I've been using the services of Leitz Tooling for 10+ years and have never even considered going else where.

Leitz sell high quality tooling and provide an equally reliable high quality sharpening service.



Greg Welch, Via Google

”

“

Leitz Tooling have been extremely helpful in getting us set up with the correct window tooling, CNC tooling and saw blades.

With their high quality sharpening, and great customer service by their sales rep, we have increased our manufacturing significantly. We would highly recommend Leitz to other joinery businesses that are looking for tooling



MB Design & Construct, Via Google

”

“

A great company with high quality CNC tooling. The transition to shirk fits for our factory has been a real benefit. Quick turnaround. Very reliable and Leitz have got us out of a bind on many occasions.



Rob Hart, Via Google

”

“

We highly recommend the Leitz Harlow team to any joineries in search of professional support. The ideas and tools they provide are truly exceptional.

We were thoroughly impressed by the level of professionalism displayed during the Leitz seminar about sash windows.



Skylon Joinery, Via Google

”

“

5 Star service from Leitz, they are always efficient, fast and very knowledgeable when we need advice. Our rep is very friendly and knowledgeable and if we ever need any information always goes out of his way to give us the answer. 5 Stars without question.

Thanks from all of us at PG Doors



PG Doors, Via Google

”



High-Quality Tool & Saw Sharpening:

Leitz Tooling is the global leader in saw and tool sharpening. Our continuous investments in the latest grinding and diamond erosion technology ensure we offer a high quality service that is accurate to under 10 microns.

With 8 service centers across the UK, Leitz is uniquely positioned to be your dedicated partner for tool service & sharpening.



What Do We Sharpen?

Leitz can sharpen most tooling on the market including saw blades, knives, router cutters, drills, tooling blocks, profile tools, chainsaws, high shear tools and more...

We also sharpen the following materials:

- High Speed Steel.
- Tungsten Carbide.
- Diamond (PCD / DP).



Our Locations - Find A Service Centre Near You:

Head Office / Harlow:

01245 454530
contact-uk@leitz.org

Bristol:

01179 778808
bristol@leitz.org

Leeds:

01132 761532
leeds@leitz.org

Basingstoke:

01256 397209
basingstoke@leitz.org

Durham:

01388 722571
durham@leitz.org

Manchester:

01616 540494
bristol@leitz.org

Belfast:

02890 776482
belfast@leitz.org

Glasgow:

01698 843117
glasgow@leitz.org



Shank Tools

The flexible, multi-talented tools

High-Performance Shank Tools For Improved Productivity

The processing of wood, wood-derived materials, and plastics on CNC machining centers relies entirely on shank tools for tasks such as sizing, jointing, rebating, profiling, and boring.

Leitz offers an extensive selection of shank tools to meet diverse needs. From standard applications to custom solutions and high-performance demands, Leitz shank tools are designed for precision and reliability.

Leitz shank tool range includes:

- Jointing, rebating and bevelling.
- Face milling and finishing.
- Profiling.
- Sizing and grooving.

Leitz shank tool range features:

- ProfilCut Q and RipTec system for flawless solid wood profiling.
- Marathon cutters for solid wood and plywood.
- Tooling for all wood, wood-derived and advanced materials.
- Single, double, triple-edged tools.
- Solutions for precise jointing.
- Portable routers for grooving, edge trimming, radius, rounding, bevelling and more.
- Supplemented by extensive boring tools programme.





HeliCut Copy Shaping, Grooving & Rebating Cutter

Achieve perfect edges and surfaces with tear-free cutting results thanks to optimised cutting angles. Quick and easy knife changes, along with a long tool life from the tungsten carbide knives mean less machine downtime.



HeliCut Monoblock

The HeliCut Monoblock offers processing flexibility with application for drilling, pockets, tenons and rebates in perfect quality. The monolithic design ensures tool stability and dampens vibrations.



Leitz UK-Made Compression Cutters

Wide range of locally made compression routers covering all common material sizes and applications. Produced using the high-grade carbide for superior performance and productivity.



Multi-purpose Profile Cutterhead Z2

For cutting decorative grooves, internal profiles and combined external and internal profiles. Features changeable knives allowing a variety of profiles on one tool body. Special profiles ground onto blank knives on request.



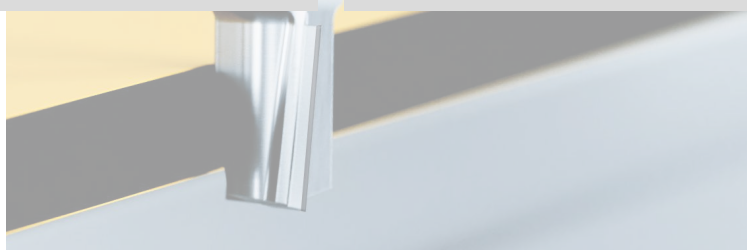
Router Cutter Diamaster PLUS³ EdgeExpert

High-performance Z 3+3 routers for sizing and grooving engineered wood boards. Tear-free cutting on both sides, ideal for sensitive decorative papers, laminating foils and veneers. Perfect for large batches and faster feed rates.



Turnblade Finishing Cutter

Cutter for machining V-Groove profiles and for multi-purpose carving operations. Features exchangeable turnblades, with up to 3x performance time by turning the knife. Extra long design particularly suitable for 5-axis machining.





Your Local Contact:
Scan QR code or visit
www.leitz.org



www.leitz.org

