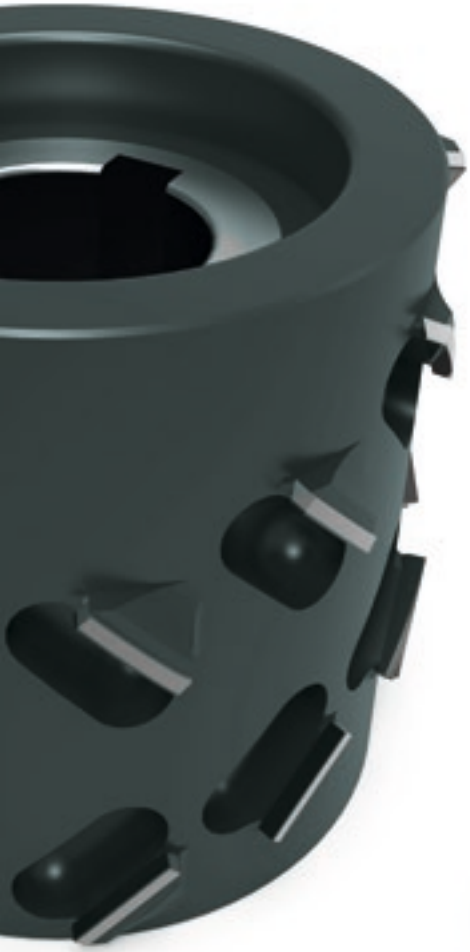
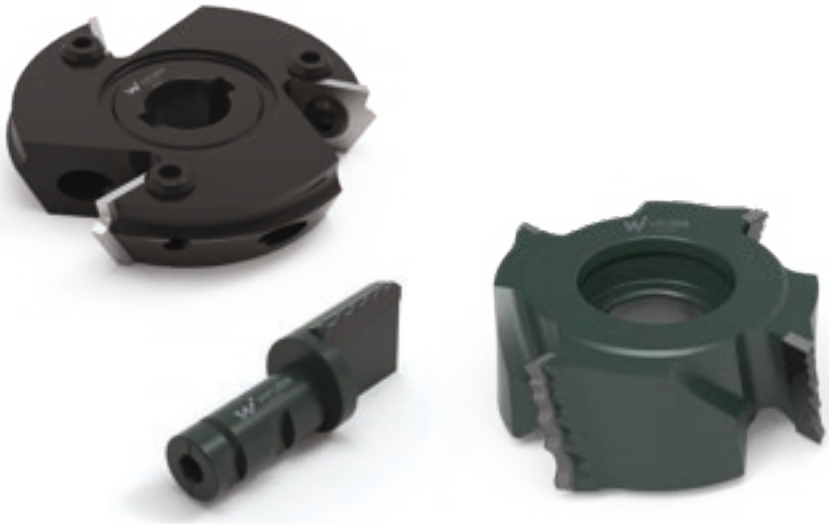
wirutex
hi-tech tools



Catalogue

Tools for Biesse Edgebanding and Squaring-edgebanding machines



P2024

Wirutex designs, manufactures and distributes polycrystalline diamond and tungsten carbide tools for woodworking machines and machines for processing plastic material and aluminium. Founded in 1980, it is now the leading company in the development of high-tech products for quality craftsmanship and large-scale industry applications.

Wirutex and Biesse, a consolidated partnership

The partnership between Wirutex and Biesse dates back to the nineties, when the first tools to be installed on woodworking machines entered production; over time, this synergy has led to the development of a range of specific tools for Biesse machinery.

Wirutex tools for edgebanding and square edgebanding lines are the result of daily interaction between tool technicians and the manufacturer, and are designed to integrate perfectly with modern BIESSE technologies.

Summary

AKRON 1300	p. 5
AKRON 1400	p. 15
AKRON 1100	p. 27
AKRON 400	p. 33
STREAM A	p. 43
STREAM A SMART	p. 55
STREAM B MDS	p. 65
JADE 200 - JADE 300	p. 86

Symbols and abbreviations

DP	POLYCRYSTALLINE DIAMOND	D	DIAMETER
HW	TUNGSTEN CARBIDE	B	CUTTING THICKNESS
HWM	SOLID TUNGSTEN CARBIDE	d	BORE/CENTRAL BORE
HSS	HIGH SPEED STEEL	KN	KEYWAYS
MEC	MECHANICAL FEED	R	RADIUS

Wirutex Id-No.	Wirutex product code
BIESSE Id-No.	BIESSE design code
DP	Polycrystalline diamond
HW	Tungsten carbide
HWM	Solid tungsten carbide
HSS	High Speed Steel

Range

AKRON 1300

RT02 Pre-milling unit

LOW-NOISE 45° pre-milling cutter

DP

MEC

MACHINES / APPLICATIONS

AKRON 1300.

Machining operations on chipboard and MDF with melamine and its composites.

DESIGN

DP tips.

Axiality 45°.

Tips height: 2,5 mm

*Tips height: 4,3 mm

Symmetrical.

LOW-NOISE with significant noise reduction.

NOTES

Pre-milling cutter
for single-sided edgebanding machines.

Max. rpm: 9,000 /12,000

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.
80	49	30+2KN	3+3	S13165	CSEN350085
80	65	30+2KN	3+3	S13164	CSEN350086
80	49	30+2KN	3+3	*S16131	
80	65	30+2KN	3+3	*S17425	
80	49	30+2KN	2+2	S13076	
80	65	30+2KN	2+2	S12805	

RT02 Pre-milling unit

LOW-NOISE 30° pre-milling cutter

DP

MEC

MACHINES / APPLICATIONS

AKRON 1300.

Machining operations on chipboard and MDF with melamine and its composites.

DESIGN

DP tips.

Axiality 30°

Symmetrical.

LOW-NOISE with significant noise reduction.

NOTES

Pre-milling cutter for single-sided edgebanding machines.

Max. rpm: 9,000 /12,000

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.
80	48	30+2KN	2+2	S16442	CCEN350128
80	65	30+2KN	2+2	S16330	CCEN350127

IT03 End trimming unit

End cutting saw blade

HW

MEC

MACHINES / APPLICATIONS

AKRON 1300.

Machining operations on supported and plastic edges.

DESIGN

HW tips.

ATB tooth 20°

NOTES

End cutting of glued edges.

Max. rpm: 12,000

Always include the code marked on the tool currently being used or machine serial number.

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.
150	3.0	55+4	32+4	C06635	CCEN750060

RS02 Top and bottom trimming unit

Overlapped trimmer with interchangeable knives

HW

MEC

MACHINES / APPLICATIONS

AKRON 1300.

Machining operations on supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge trimming.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.	Spare parts
70	12	16+2KN	3	D03219	3401A0357	
				C00405	N3402N0120	Knife in HW 12x12x1.5

RF02 Fine trimming unit

Tilted trimmer with mechanical fixing and interchangeable multiprofile knives

HW

MEC

MACHINES / APPLICATIONS

AKRON 1300.

Machining operations on edges in solid wood, supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge trimming on tilted engines.

Max. rpm: 12,000

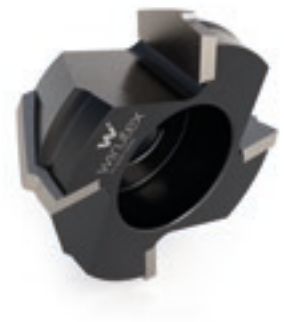
D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.	Spare parts
72	30	16+2KN	25°	3	CW.	D03647	CSEN350013	
						D03648	CSEN700013	Knife in HW 25°
72	30	16+2KN	25°	3	CCW.	D03649	CSEN350014	
						D03650	CSEN700014	Knife in HW 25°
72	30	16+2KN	1	3	CW.	D03651	CSEN350015	
						D03652	CSEN700015	Knife in HW R=1
72	30	16+2KN	1	3	CCW.	D03653	CSEN350016	
						D03654	CSEN700016	Knife in HW R=1
72	30	16+2KN	1.5	3	CW.	D03655	CSEN350017	
						D03656	CSEN700017	Knife in HW R=1.5
72	30	16+2KN	1.5	3	CCW.	D03657	CSEN350018	
						D03658	CSEN700018	Knife in HW R=1.5
72	30	16+2KN	2	3	CW.	D03659	CSEN350019	
						D03660	CSEN700019	Knife in HW R=2
72	30	16+2KN	2	3	CCW.	D03661	CSEN350020	
						D03662	CSEN700020	Knife in HW R=2
72	30	16+2KN	3	3	CW.	D03663	CSEN350021	
						D03664	CSEN700021	Knife in HW R=3
72	30	16+2KN	3	3	CCW.	D03665	CSEN350022	
						D03666	CSEN700022	Knife in HW R=3
72	35	16+2KN	1/1.5/25°	4	CW.	D03667	CSEN350023	
						D03668	CSEN700023	Knife in HW R=1/1.5/25°
72	35	16+2KN	1/1.5/25°	4	CCW.	D03669	CSEN350024	
						D03670	CSEN700024	Knife in HW R=1/1.5/25°
72	35	16+2KN	1/2/25°	4	CW.	D03671	CSEN350025	
						D03672	CSEN700025	Knife in HW R=1/2/25°
72	35	16+2KN	1/2/25°	4	CCW.	D03673	CSEN350026	
						D03674	CSEN700026	Knife in HW R=1/2/25°
72	35	16+2KN	1.5/2/25°	4	CW.	D03675	CSEN350027	
						D03676	CSEN700027	Knife in HW R=1.5/2/25°
72	35	16+2KN	1.5/2/25°	4	CCW.	D03677	CSEN350028	
						D03678	CSEN700028	Knife in HW R=1.5/2/25°
72	35	16+2KN	1.5/3/25°	4	CW.	D03679	CSEN350029	
						D03680	CSEN700029	Knife in HW R=1.5/3/25°
72	35	16+2KN	1.5/3/25°	4	CCW.	D03681	CSEN350030	
						D03682	CSEN700030	Knife in HW R=1.5/3/25°
72	35	16+2KN	2/3/25°	4	CW.	D03683	CSEN350031	
						D03684	CSEN700031	Knife in HW R=2/3/25°
72	35	16+2KN	2/3/25°	4	CCW.	D03685	CSEN350032	
						D03686	CSEN700032	Knife in HW R=2/3/25°

RF02 Fine trimming unit
Trimmer

new

HW

MEC



MACHINES / APPLICATIONS

AKRON 1300.

Machining operations on edges
in solid wood, supported and plastic edges.

DESIGN

Braze-welded tips in HW.

NOTES

Edge trimming on tilted engines.

Max. rpm: 18,000

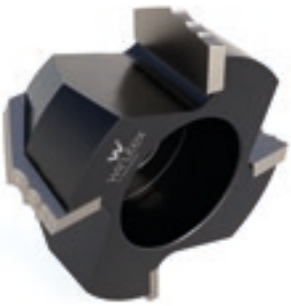
D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
71.61	30	16+2KN	1.2/15°/0°	4	CW.	S18494	CCEN350241
71.61	30	16+2KN	1.2/15°/0°	4	CCW.	S18495	CCEN350240
71.61	30	16+2KN	1.7/15°/0°	4	CW.	S18285	CCEN350239
71.61	30	16+2KN	1.7/15°/0°	4	CCW.	S18286	CCEN350238
71.61	30	16+2KN	2.2/15°/0°	4	CW.	S18287	CCEN350237
71.61	30	16+2KN	2.2/15°/0°	4	CCW.	S18288	CCEN350235
71.61	30	16+2KN	3.2/15°/0°	4	CW.	S18568	CCEN350236
71.61	30	16+2KN	3.2/15°/0°	4	CCW.	S18569	CCEN350234

RF03 Fine trimming unit
Trimmer

new

HW

MEC



MACHINES / APPLICATIONS

AKRON 1300.

Machining operations on edges
in solid wood, supported and plastic edges.

DESIGN

Braze-welded tips in HW.

NOTES

Edge trimming on tilted engines.

Max. rpm: 18,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
71.26	33.5	16+2KN	1.2/1.7/2.2/45°/0°	4	CW.	S18257	CCEN350269
71.26	33.5	16+2KN	1.2/1.7/2.2/45°/0°	4	CCW.	S18258	CCEN350270
71.61	33.5	16+2KN	1.2/2.2/3.2/25°/0°	4	CW.	S16407	CCEN350114
71.61	33.5	16+2KN	1.2/2.2/3.2/25°/0°	4	CCW.	S16408	CCEN350115

AR02 Corner rounding unit

Rounding cutter with mechanical fixing and interchangeable knives

HW

MEC

MACHINES / APPLICATIONS

AKRON 1300.

Machining operations on supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge radiusing.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.	Spare parts
60/70	16	16+2KN	1	4	CW.	D03255	3401A0355	
60/70	16	16+2KN	1	4	CCW.	D03256	3401A0356	
						D03257	3402A0087	Knife in HW 16x17x2 R=1
60/70	16	16+2KN	1.5	4	CW.	D03252	3401A0353	
60/70	16	16+2KN	1.5	4	CCW.	D03253	3401A0354	
						D03254	3402A0086	Knife in HW 16x17x2 R=1.5
60/70	16	16+2KN	2	4	CW.	D03246	3401A0349	
60/70	16	16+2KN	2	4	CCW.	D03247	3401A0350	
						D03248	3402A0084	Knife in HW 16x17x2 R=2
60/70	16	16+2KN	3	4	CW.	D03249	3401A0351	
60/70	16	16+2KN	3	4	CCW.	D03250	3401A0352	
						D03251	3402A0085	Knife in HW 16x17x2 R=3

AR02 Corner rounding unit

Rounding cutter

new

HW

MEC

MACHINES / APPLICATIONS

AKRON 1300.

Machining operations on supported and plastic edges.

DESIGN

Braze-welded tips in HW.

NOTES

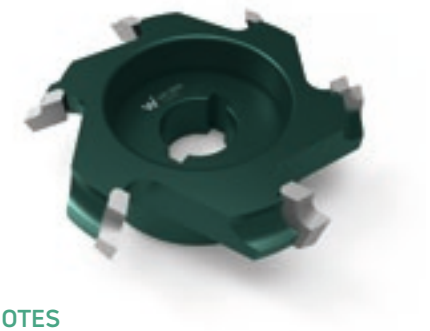
Radiusing and chamfering of edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
60/70	9	16+2KN	1.2	4	CW.	S17567	CCEN350223
60/70	9	16+2KN	1.2	4	CCW.	S17568	CCEN350224
60/70	9	16+2KN	1.7	4	CW.	S17565	CCEN350221
60/70	9	16+2KN	1.7	4	CCW.	S17566	CCEN350222
60/70	9	16+2KN	2.2	4	CW.	S17561	CCEN350217
60/70	9	16+2KN	2.2	4	CCW.	S17562	CCEN350218
60/70	9	16+2KN	3.2	4	CW.	S17563	CCEN350219
60/70	9	16+2KN	3.2	4	CCW.	S17564	CCEN350220

AR02 Corner rounding unit

Rounding cutter



HW

MEC

MACHINES / APPLICATIONS

AKRON 1300.

Machining operations on supported and plastic edges.

DESIGN

Braze-welded tips in HW.

NOTES

Radiusing and chamfering of edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
60/68	9	16+2KN	1	6	CW.	D01578	N3401N0112
60/68	9	16+2KN	1	6	CCW.	D01579	N3401N0113
60/68	9	16+2KN	1.5	6	CW.	D01529	N3401N0107
60/68	9	16+2KN	1.5	6	CCW.	D01580	N3401N0108
60/68	9	16+2KN	2	6	CW.	D01482	N3401N0105
60/68	9	16+2KN	2	6	CCW.	D01483	N3401N0106
60/68	9	16+2KN	3	6	CW.	D01527	N3401N0103
60/68	9	16+2KN	3	6	CCW.	D01528	N3401N0104
60/68	9	16+2KN	25°	6	CW.	D01522	N3401N0101
60/68	9	16+2KN	25°	6	CCW.	D01523	N3401N0102

DP

DESIGN

DP tips.

NOTES

Radiusing and chamfering of edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
60	11	16+2KN	1	6	CW.	S14451	N3401N0110
60	11	16+2KN	1	6	CCW.	S14450	N3401N0111
60	11	16+2KN	1.5	6	CW.	S13811	N3401N0095
60	11	16+2KN	1.5	6	CCW.	S13810	N3401N0096
60	11	16+2KN	2	6	CW.	S14234	N3401N0093
60	11	16+2KN	2	6	CCW.	S14233	N3401N0094
60	11	16+2KN	3	6	CW.	S14453	N3401N0091
60	11	16+2KN	3	6	CCW.	S14452	N3401N0092
58.8/67	9	16+2KN	25°	6	CW.	S06800	N3401N0089
58.8/67	9	16+2KN	25°	6	CCW.	S06801	N3401N0090
59.3/68	4.5	16+2KN	45°	6	CW.	S14143	N3401N0457
59.3/68	4.5	16+2KN	45°	6	CCW.	S14144	N3401N0458

RB02 Edge scraper unit
Edge scraper

HWM

MEC

MACHINES / APPLICATIONS
AKRON 1300.
Machining operations on ABS edges.

DESIGN
HWM insert.

NOTES
For edge finishing.

Features/Dimensions	Wirutex Id-No.	BIESSE Id-No.
25°	D03413	3402A0083
R=1	D03607	3402A0124
R=1,5	D03608	3402A0125
R=2	D03609	3402A0126
R=3	D03222	3402A0082

RB02 Edge scraper unit
Edge scraper

new

HWM

MEC

MACHINES / APPLICATIONS
AKRON 1300.
Machining operations on ABS edges.

DESIGN
HWM insert.

NOTES
For edge finishing.

Features/Dimensions	Wirutex Id-No.	BIESSE Id-No.
R=1.2/1.7 UPPER	D05417	CCEN720024
R=1,2/1,7 LOWER	D05418	CCEN720029
R=1.2/2.2 UPPER	D05419	CCEN720032
R=1.2/2.2 LOWER	D05420	CCEN720030
R=1.2/2.2 UPPER	D05413	CCEN720022
R=1.2/2.2 LOWER	D05414	CCEN720027
R=1.7/3.2 UPPER	D05415	CCEN720023
R=1.7/3.2 LOWER	D05416	CCEN720028
R=2.2/3.2 UPPER	D05421	CCEN720021
R=2.2/3.2 LOWER	D05422	CCEN720026

RB03 Edge scraper unit

Edge scraper

new

HWM

MEC

MACHINES / APPLICATIONS

AKRON 1300.
Machining operations on ABS edges.

DESIGN

HWM insert.

NOTES

For edge finishing.

Features/Dimensions	Wirutex Id-No.	BIESSE Id-No.
R=1.2/1.7/2.2/3.2 UPPER	D05291	CCEN720015
R=1.2/1.7/2.2/3.2 LOWER	D05290	CCEN720014
R=1.2/1.7/2.2/45° UPPER	D05550	CCEN720037
R=1.2/1.7/2.2/45° LOWER	D05549	CCEN720036

RC02 Glue scraper unit

Glue scraper

HW

MEC

MACHINES / APPLICATIONS

AKRON 1300.
Machining operations on supported and plastic edges.

DESIGN

Triangular insert
with 3 cutting edges in HW.

NOTES

Removal of glue residues from the edge.

Features / Dimensions	Z	Wirutex Id-No.	BIESSE Id-No.
22.86x2.5	3	C00626	E3401E0117

Range

AKRON 1400

RT02 Pre-milling unit
LOW-NOISE 45° pre-milling cutter

DP

MEC

MACHINES / APPLICATIONS

AKRON 1400.

Machining operations on chipboard and MDF with melamine and its composites.

DESIGN

DP tips.

Axiality 45°.

Tips height: 2,5 mm

*Tips height: 4,3 mm

Symmetrical.

LOW-NOISE with significant noise reduction.

NOTES

Pre-milling cutter for single-sided edgebanding machines.

Max. rpm: 9,000 /12,000

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.
80	49	30+2KN	3+3	S13165	CSEN350085
80	65	30+2KN	3+3	S13164	CSEN350086
80	49	30+2KN	3+3	*S16131	
80	65	30+2KN	3+3	*S17425	
80	49	30+2KN	2+2	S13076	
80	65	30+2KN	2+2	S12805	

RT02 Pre-milling unit
LOW-NOISE 30° pre-milling cutter

DP

MEC

MACHINES / APPLICATIONS

AKRON 1400.

Machining operations on chipboard and MDF with melamine and its composites.

DESIGN

DP tips.

Axiality 30°

Symmetrical.

LOW-NOISE with significant noise reduction.

NOTES

Pre-milling cutter for single-sided edgebanding machines.

Max. rpm: 9,000 /12,000

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.
80	48	30+2KN	2+2	S16442	CCEN350128
80	65	30+2KN	2+2	S16330	CCEN350127

IN-801 End trimming unit

End cutting saw blade

HW

MEC

MACHINES / APPLICATIONS

AKRON 1400.

Machining operations on supported and plastic edges.

DESIGN

HW tips.

Alternate tooth.

NOTES

End cutting of glued edges.

Max. rpm: 12,000

Always include the code marked on the tool currently being used or machine serial number.

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.
140	3.6	55+4	36	D04050	CSEN750035

IT70-S End trimming unit

End cutting saw blade

HW

MEC

MACHINES / APPLICATIONS

AKRON 1400.

Machining operations on supported and plastic edges.

DESIGN

HW tips.

Inclined tooth.

NOTES

End cutting of glued edges.

Max. rpm: 12,000

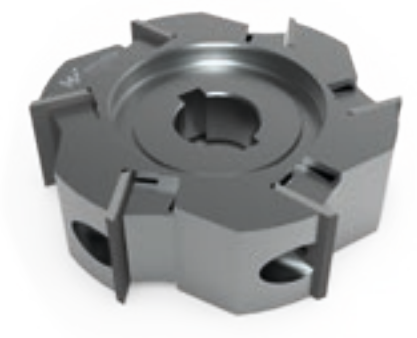
D (mm)	B (mm)	d (mm)	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
150	3.2	55+4	36	RH	D05122	CCEN750047
150	3.2	55+4	36	LH	D05123	CCEN750046

RS-502 Top and bottom trimming unit

Overlapped trimmer with interchangeable knives

HW

MEC



MACHINES / APPLICATIONS

AKRON 1400.

Machining operations on supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge trimming.

Max. rpm: 12,000

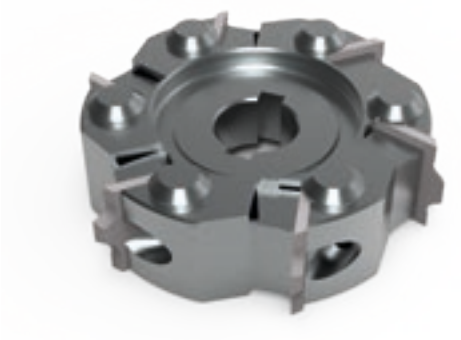
D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.	Spare parts
70	20	16+2KN	6	D02126	N3401N0430	
				C00403	N3402N0040	Knife in HW 20x12x1.5

RI-501 Fine trimming unit

Tilted trimmer with interchangeable knives

HW

MEC



MACHINES / APPLICATIONS

AKRON 1400.

Machining operations on supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge trimming on tilted engines.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Wirutex Id-No.	BIESSE Id-No.	Spare parts
70	20	16+2KN	-	6	D02126	N3401N0430	
					C00403	N3402N0040	Knife in HW 20x12x1.5
75	20	16+2KN	1	6	D02368	N3401N0431	
					D02372	N3402N0123	Knife in HW R=1
75	20	16+2KN	1.5	6	D02369	N3401N0432	
					D02373	N3402N0124	Knife in HW R=1.5
75	20	16+2KN	2	6	D02370	N3401N0433	
					D02374	N3402N0125	Knife in HW R=2
75	20	16+2KN	3	6	D02127	N3401N0434	
					D02134	N3402N0126	Knife in HW R=3

RF02 Fine trimming unit

Tilted trimmer with mechanical fixing and interchangeable multiprofile knives

HW

MEC

MACHINES / APPLICATIONS

AKRON 1400.

Machining operations on edges in solid wood, supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge trimming on tilted engines.

Max. rpm: 12,000

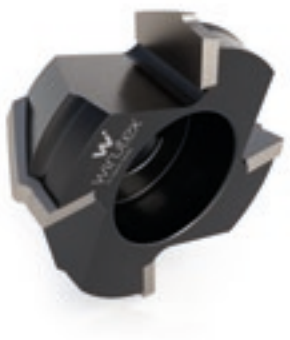
D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.	Spare parts
72	30	16+2KN	25°	3	CW.	D03647	CSEN350013	
						D03648	CSEN700013	Knife in HW 25°
72	30	16+2KN	25°	3	CCW.	D03649	CSEN350014	
						D03650	CSEN700014	Knife in HW 25°
72	30	16+2KN	1	3	CW.	D03651	CSEN350015	
						D03652	CSEN700015	Knife in HW R=1
72	30	16+2KN	1	3	CCW.	D03653	CSEN350016	
						D03654	CSEN700016	Knife in HW R=1
72	30	16+2KN	1.5	3	CW.	D03655	CSEN350017	
						D03656	CSEN700017	Knife in HW R=1.5
72	30	16+2KN	1.5	3	CCW.	D03657	CSEN350018	
						D03658	CSEN700018	Knife in HW R=1.5
72	30	16+2KN	2	3	CW.	D03659	CSEN350019	
						D03660	CSEN700019	Knife in HW R=2
72	30	16+2KN	2	3	CCW.	D03661	CSEN350020	
						D03662	CSEN700020	Knife in HW R=2
72	30	16+2KN	3	3	CW.	D03663	CSEN350021	
						D03664	CSEN700021	Knife in HW R=3
72	30	16+2KN	3	3	CCW.	D03665	CSEN350022	
						D03666	CSEN700022	Knife in HW R=3

RF02 Fine trimming unit
Trimmer

new

HW

MEC



MACHINES / APPLICATIONS

AKRON 1400.

Machining operations on edges
in solid wood, supported and plastic edges.

DESIGN

Braze-welded tips in HW.

NOTES

Edge trimming on tilted engines.

Max. rpm: 18,000

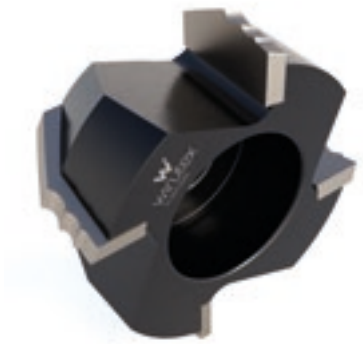
D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
71.61	30	16+2KN	1.2/15°/0°	4	CW.	S18494	CCEN350241
71.61	30	16+2KN	1.2/15°/0°	4	CCW.	S18495	CCEN350240
71.61	30	16+2KN	1.7/15°/0°	4	CW.	S18285	CCEN350239
71.61	30	16+2KN	1.7/15°/0°	4	CCW.	S18286	CCEN350238
71.61	30	16+2KN	2.2/15°/0°	4	CW.	S18287	CCEN350237
71.61	30	16+2KN	2.2/15°/0°	4	CCW.	S18288	CCEN350235
71.61	30	16+2KN	3.2/15°/0°	4	CW.	S18568	CCEN350236
71.61	30	16+2KN	3.2/15°/0°	4	CCW.	S18569	CCEN350234

RF03 Fine trimming unit
Trimmer

new

HW

MEC



MACCHINE / APPLICAZIONI

AKRON 1400.

Machining operations on edges
in solid wood, supported and plastic edges.

DESIGN

Braze-welded tips in HW.

NOTE

Edge trimming on tilted engines.

Max. rpm: 18,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
71.26	33.5	16+2KN	1.2/1.7/2.2/45°/0°	4	CW.	S18257	CCEN350269
71.26	33.5	16+2KN	1.2/1.7/2.2/45°/0°	4	CCW.	S18258	CCEN350270
71.61	33.5	16+2KN	1.2/2.2/3.2/25°/0°	4	CW.	S16407	CCEN350114
71.61	33.5	16+2KN	1.2/2.2/3.2/25°/0°	4	CCW.	S16408	CCEN350115

RI-501 Multiprofile fine trimming unit

Tilted trimmer with mechanical fixing and interchangeable multiprofile knives

HW

MEC

MACHINES / APPLICATIONS

AKRON 1400.

Machining operations on edges in solid wood, supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge trimming on tilted engines.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.	Spare parts
72	35	16+2KN	1/1.5/25°	4	CW.	D03667	CSEN350023	
						D03668	CSEN700023	Knife in HW R=1/1.5/25°
72	35	16+2KN	1/1.5/25°	4	CCW.	D03669	CSEN350024	
						D03670	CSEN700024	Knife in HW R=1/1.5/25°
72	35	16+2KN	1/2/25°	4	CW.	D03671	CSEN350025	
						D03672	CSEN700025	Knife in HW R=1/2/25°
72	35	16+2KN	1/2/25°	4	CCW.	D03673	CSEN350026	
						D03674	CSEN700026	Knife in HW R=1/2/25°
72	35	16+2KN	1.5/2/25°	4	CW.	D03675	CSEN350027	
						D03676	CSEN700027	Knife in HW R=1.5/2/25°
72	35	16+2KN	1.5/2/25°	4	CCW.	D03677	CSEN350028	
						D03678	CSEN700028	Knife in HW R=1.5/2/25°
72	35	16+2KN	1.5/3/25°	4	CW.	D03679	CSEN350029	
						D03680	CSEN700029	Knife in HW R=1.5/3/25°
72	35	16+2KN	1.5/3/25°	4	CCW.	D03681	CSEN350030	
						D03682	CSEN700030	Knife in HW R=1.5/3/25°
72	35	16+2KN	2/3/25°	4	CW.	D03683	CSEN350031	
						D03684	CSEN700031	Knife in HW R=2/3/25°
72	35	16+2KN	2/3/25°	4	CCW.	D03685	CSEN350032	
						D03686	CSEN700032	Knife in HW R=2/3/25°

AR02-E Corner rounding unit

Rounding cutter with mechanical fixing and interchangeable knives

HW

MEC

MACHINES / APPLICATIONS

AKRON 1400.

Machining operations on supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge radiusing.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.	Spare parts
60/70	16	16+2KN	1	4	CW.	D03255	3401A0355	
60/70	16	16+2KN	1	4	CCW.	D03256	3401A0356	
						D03257	3402A0087	Knife in HW 16x17x2 R=1
60/70	16	16+2KN	1.5	4	CW.	D03252	3401A0353	
60/70	16	16+2KN	1.5	4	CCW.	D03253	3401A0354	
						D03254	3402A0086	Knife in HW 16x17x2 R=1.5
60/70	16	16+2KN	2	4	CW.	D03246	3401A0349	
60/70	16	16+2KN	2	4	CCW.	D03247	3401A0350	
						D03248	3402A0084	Knife in HW 16x17x2 R=2
60/70	16	16+2KN	3	4	CW.	D03249	3401A0351	
60/70	16	16+2KN	3	4	CCW.	D03250	3401A0352	
						D03251	3402A0085	Knife in HW 16x17x2 R=3

AR02-E Corner rounding unit

Rounding cutter

new

HW

MEC

MACHINES / APPLICATIONS

AKRON 1400.

Machining operations on supported and plastic edges.

DESIGN

Braze-welded tips in HW.

NOTES

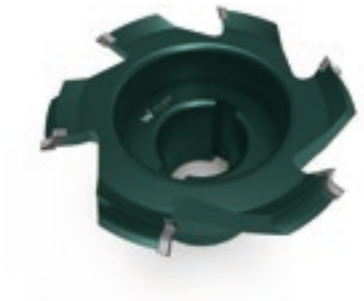
Radiusing and chamfering of edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
60/70	9	16+2KN	1.2	4	CW.	S17567	CCEN350223
60/70	9	16+2KN	1.2	4	CCW.	S17568	CCEN350224
60/70	9	16+2KN	1.7	4	CW.	S17565	CCEN350221
60/70	9	16+2KN	1.7	4	CCW.	S17566	CCEN350222
60/70	9	16+2KN	2.2	4	CW.	S17561	CCEN350217
60/70	9	16+2KN	2.2	4	CCW.	S17562	CCEN350218
60/70	9	16+2KN	3.2	4	CW.	S17563	CCEN350219
60/70	9	16+2KN	3.2	4	CCW.	S17564	CCEN350220

AR02-E Corner rounding unit

Rounding cutter



HW

MEC

MACHINES / APPLICATIONS

AKRON 1400.

Machining operations on supported and plastic edges.

DESIGN

Braze-welded tips in HW.

NOTES

Radiusing and chamfering of edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
60/68	9	16+2KN	1	6	CW.	D01578	N3401N0112
60/68	9	16+2KN	1	6	CCW.	D01579	N3401N0113
60/68	9	16+2KN	1.5	6	CW.	D01529	N3401N0107
60/68	9	16+2KN	1.5	6	CCW.	D01580	N3401N0108
60/68	9	16+2KN	2	6	CW.	D01482	N3401N0105
60/68	9	16+2KN	2	6	CCW.	D01483	N3401N0106
60/68	9	16+2KN	3	6	CW.	D01527	N3401N0103
60/68	9	16+2KN	3	6	CCW.	D01528	N3401N0104
60/68	9	16+2KN	25°	6	CW.	D01522	N3401N0101
60/68	9	16+2KN	25°	6	CCW.	D01523	N3401N0102

DP

DESIGN

DP tips.

NOTES

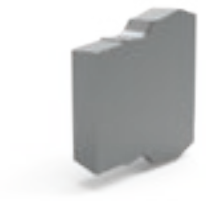
Radiusing and chamfering of edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Id-No. Wirutex	Id-No. BIESSE
60	11	16+2KN	1	6	CW.	S14451	N3401N0110
60	11	16+2KN	1	6	CCW.	S14450	N3401N0111
60	11	16+2KN	1.5	6	CW.	S13811	N3401N0095
60	11	16+2KN	1.5	6	CCW.	S13810	N3401N0096
60	11	16+2KN	2	6	CW.	S14234	N3401N0093
60	11	16+2KN	2	6	CCW.	S14233	N3401N0094
60	11	16+2KN	3	6	CW.	S14453	N3401N0091
60	11	16+2KN	3	6	CCW.	S14452	N3401N0092
58.8/67	9	16+2KN	25°	6	CW.	S06800	N3401N0089
58.8/67	9	16+2KN	25°	6	CCW.	S06801	N3401N0090
59.3/68	4.5	16+2KN	45°	6	CW.	S14143	N3401N0457
59.3/68	4.5	16+2KN	45°	6	CCW.	S14144	N3401N0458

RB02 Edge scraper unit

Edge scraper with anti-bleaching profile



HWM

MEC

MACHINES / APPLICATIONS

AKRON 1400.

Machining operations on ABS edges.

DESIGN

Insert in HWM with anti-bleaching profile.

NOTES

For edge finishing.

Features / Dimensions	Wirutex Id-No.	BIESSE Id-No.
25°	D03413	3402A0083
R=1	D03607	3402A0124
R=1.5	D03608	3402A0125
R=2	D03609	3402A0126
R=3	D03222	3402A0082

RB02 Edge scraper unit

Edge scraper

new

HWM

MEC

MACHINES/APPLICATIONS

AKRON 1400.
Machining operations on ABS edges.

DESIGN

HWM insert.

NOTES

For edge finishing.

Features / Dimensions	Wirutex Id-No.	BIESSE Id-No.
R=1.2/1.7 UPPER	D05417	CCEN720024
R=1.2/1.7 LOWER	D05418	CCEN720029
R=1.2/2.2 UPPER	D05419	CCEN720032
R=1.2/2.2 LOWER	D05420	CCEN720030
R=1.7/2.2 UPPER	D05413	CCEN720022
R=1.7/2.2 LOWER	D05414	CCEN720027
R=1.7/3.2 UPPER	D05415	CCEN720023
R=1.7/3.2 LOWER	D05416	CCEN720028
R=2.2/3.2 UPPER	D05421	CCEN720021
R=2.2/3.2 LOWER	D05422	CCEN720026

RB03 Edge scraper unit

Edge scraper

new

HWM

MEC

MACHINES / APPLICATIONS

AKRON 1400.
Machining operations on ABS edges.

DESIGN

HWM insert.

NOTES

For edge finishing.

Features / Dimensions	Wirutex Id-No.	BIESSE Id-No.
R=1.2/1.7/2.2/3.2 UPPER	D05291	CCEN720015
R=1.2/1.7/2.2/3.2 LOWER	D05290	CCEN720014
R=1.2/1.7/2.2/45° UPPER	D05550	CCEN720037
R=1.2/1.7/2.2/45° LOWER	D05549	CCEN720036

RC02 Glue scraper unit

Glue scraper

HW

MEC

MACHINES / APPLICATIONS

AKRON 1400.

Machining operations on supported and plastic edges.

DESIGN

Triangular insert
with 3 cutting edges in HW.

NOTES

Removal of glue residues from the edge.

Features / Dimensions	Z	Wirutex Id-No.	BIESSE Id-No.
22.86x2.5	3	C00626	E3401E0117

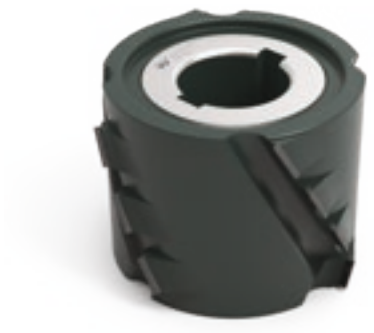
Range

AKRON 1100

RT01 Pre-milling unit
Pre-milling cutter

DP

MEC



MACHINES / APPLICATIONS

AKRON 1100.

Machining operations on chipboard and MDF with melamine and its composites.

DESIGN

DP tips.

Axiality 30°

NOTES

Max. rpm: 9,000 /12,000

D (mm)	B (mm)	d (mm)	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
80	55	30+2KN	2+2	CW.	S15317	CCEN350035
80	55	30+2KN	2+2	CCW.	S15318	CCEN350036

RT01 Pre-milling unit
LOW-NOISE 30° pre-milling cutter

DP

MEC

MACHINES / APPLICATIONS

AKRON 1100.

Machining operations on chipboard and MDF with melamine and its composites.

DESIGN

DP tips.

Axiality 30°

Symmetrical.

LOW-NOISE with significant noise reduction.

NOTES

Pre-milling cutter for single-sided edgebanding machines.

Max. rpm: 9,000 /12,000

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.
80	48	30+2KN	2+2	S16442	CCEN350128
80	65	30+2KN	2+2	S16330	CCEN350127

IT01 End trimming unit

End cutting saw blade

HW

MEC

MACHINES / APPLICATIONS

AKRON 1100.

Machining operations on supported and plastic edges.

DESIGN

HW tips.

Alternate tooth 10°

NOTES

End cutting of glued edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.
100	3.2	30	20	C05790	CSEN750069

RF01 Fine trimming unit

Trimmer with interchangeable knives

HW

MEC

MACHINES / APPLICATIONS

AKRON 1100.

Machining operation on supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge trimming.

Max. rpm: 12,500

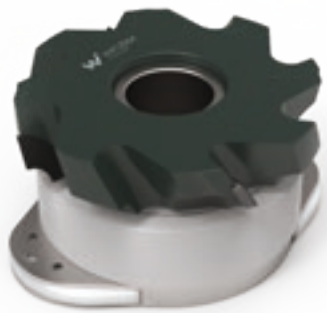
D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.	Spare parts
73.21/69.8	16	16+2KN	1	3	LH	S16406	CCEN350130	
						S16406PHM	CCEN700013	Knife in HW 16.5x16x2 R=1
73.21/69.8	16	16+2KN	1.5	3	LH	S16405	CCEN350129	
						S16405PHM	CCEN700012	Knife in HW 16.5x16x2 R=1,5
73.21/69.8	16	16+2KN	2	3	LH	S15166	CCEN350057	
						S15166PHM	CCEN700007	Knife in HW 16.5x16x2 R=2
73.21/69.8	16	16+2KN	3	3	LH	S16194	CCEN350094	
						S16194PHM	CCEN700010	Knife in HW 16.5x16x2 R=3

AR01 Corner rounding unit

Rounding cutter

DP

MEC



MACHINES / APPLICATIONS

AKRON 1100.

Machining operations on supported and plastic edges.

DESIGN

Revolver unit.

DP tips.

NOTES

Radiusing and chamfering of edges.

Max. rpm: 18,000

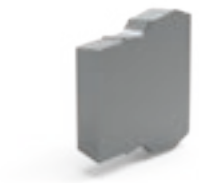
D (mm)	B (mm)	d (mm)	R	Z	Rot.	Id-No. Wirutex	Id-No. BIESSE
58	10.5	16	1	4	CCW.	S16920	CCEN350170
58	10.5	16	1.5	4	CCW.	S16921	CCEN350171
58	10.5	16	2	4	CCW.	S16922	CCEN350169
58	10.5	16	3	4	CCW.	S16924	CCEN350168

RB01 Edge scraper unit

Edge scraper with anti-bleaching profile

HWM

MEC



MACHINES / APPLICATIONS

AKRON 1100.

Machining operations on ABS edges.

DESIGN

Insert in HWM with anti-bleaching profile.

NOTES

For edge finishing.

Features / Dimensions	Wirutex Id-No.	BIESSE Id-No.
25°	D03413	3402A0083
R=1	D03607	3402A0124
R=1.5	D03608	3402A0125
R=2	D03609	3402A0126
R=3	D03222	3402A0082

RC01 Glue scraper unit

Glue scraper

HW

MEC

MACHINES / APPLICATIONS

AKRON 1100.

Machining operations on supported and plastic edges.

DESIGN

Triangular insert with 3 cutting edges in HW.

NOTES

Removal of glue residues from the edge.

Features / Dimensions	Z	Wirutex Id-No.	BIESSE Id-No.
22.86x2.5	3	C00626	E3401E0117

Range

AKRON 400

FI-502 Pre-milling unit

LOW-NOISE 45° pre-milling cutter

DP

MEC

MACHINES / APPLICATIONS

AKRON 400.

Machining operations on chipboard and MDF with melamine and its composites.

DESIGN

DP tips.

Axiality 45°.

Tips height: 2,5 mm

*Tips height: 4,3 mm

Symmetrical.

LOW-NOISE with significant noise reduction.

NOTES

Pre-milling cutter for single-sided edgebanding machines.

Max. rpm: 9,000 /12,000

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.
80	49	30+2KN	3+3	S13165	CSEN350085
80	65	30+2KN	3+3	S13164	CSEN350086
80	49	30+2KN	3+3	*S16131	
80	65	30+2KN	3+3	*S17425	
80	49	30+2KN	2+2	S13076	
80	65	30+2KN	2+2	S12805	

FI-502 Pre-milling unit

LOW-NOISE 30° pre-milling cutter

DP

MEC

MACHINES / APPLICATIONS

AKRON 400.

Machining operations on chipboard and MDF with melamine and its composites.

DESIGN

DP tips.

Axiality 30°

Symmetrical.

LOW-NOISE with significant noise reduction.

NOTES

Pre-milling cutter for single-sided edgebanding machines.

Max. rpm: 9,000 /12,000

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.
80	48	30+2KN	2+2	S16442	CCEN350128
80	65	30+2KN	2+2	S16330	CCEN350127

IN-801 End trimming unit

End cutting saw blade

HW

MEC

MACHINES / APPLICATIONS

AKRON 400.
VERSIONS UP UNTIL DECEMBER 2016.

Machining operations on supported and plastic edges.

DESIGN

HW tips.

Alternate tooth.

NOTES

End cutting of glued edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.
140	3.6	30+3+3	36	D02543	N3401N0503

RS-502 Top and bottom trimming unit

Overlapped trimmer with interchangeable knives

HW

MEC

MACHINES / APPLICATIONS

AKRON 400.

Machining operations on supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge trimming.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.	Spare parts
70	20	16+2KN	6	D02126	N3401N0430	
				C00403	N3402N0040	Knife in HW 20x12x1.5

DP

DESIGN

Cutter with braze-welded tips in DP.

NOTES

Edge trimming.

Max. rpm: 12,000

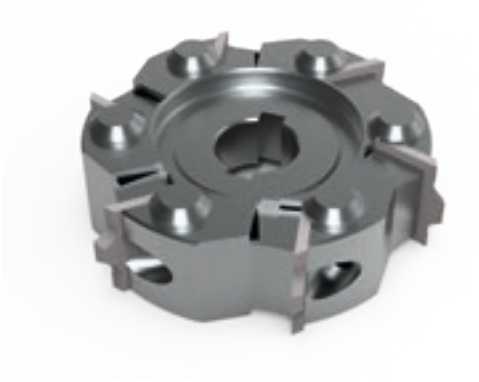
D (mm)	B (mm)	d (mm)	Z	Id-No. Wirutex	Id-No. BIESSE
70	8	16+2KN	6	S09643	-
70	20	16+2KN	6	S08913	N3401N0435

RI-501 Fine trimming unit

Tilted trimmer with interchangeable knives

HW

MEC



MACHINES / APPLICATIONS

AKRON 400.

Machining operations on supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge trimming on tilted engines.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Wirutex Id-No.	BIESSE Id-No.	Spare parts
70	20	16+2KN	-	6	D02126	N3401N0430	
					C00403	N3402N0040	Knife in HW 20x12x1.5
75	20	16+2KN	1	6	D02368	N3401N0431	
					D02372	N3402N0123	Knife in HW R=1
75	20	16+2KN	1.5	6	D02369	N3401N0432	
					D02373	N3402N0124	Knife in HW R=1.5
75	20	16+2KN	2	6	D02370	N3401N0433	
					D02374	N3402N0125	Knife in HW R=2
75	20	16+2KN	3	6	D02127	N3401N0434	
					D02134	N3402N0126	Knife in HW R=3

RI-501 Fine trimming unit

Tilted trimmer with mechanical fixing and interchangeable multiprofile knives

HW

MEC

MACHINES / APPLICATIONS

AKRON 400.

Machining operations on edges in solid wood, supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge trimming on tilted engines.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.	Spare parts
72	35	16+2KN	1/1.5/25°	4	CW.	D03667	CSEN350023	
						D03668	CSEN700023	Knife in HW R=1/1.5/25°
72	35	16+2KN	1/1.5/25°	4	CCW.	D03669	CSEN350024	
						D03670	CSEN700024	Knife in HW R=1/1.5/25°
72	35	16+2KN	1/2/25°	4	CW.	D03671	CSEN350025	
						D03672	CSEN700025	Knife in HW R=1/2/25°
72	35	16+2KN	1/2/25°	4	CCW.	D03673	CSEN350026	
						D03674	CSEN700026	Knife in HW R=1/2/25°
72	35	16+2KN	1.5/2/25°	4	CW.	D03675	CSEN350027	
						D03676	CSEN700027	Knife in HW R=1.5/2/25°
72	35	16+2KN	1.5/2/25°	4	CCW.	D03677	CSEN350028	
						D03678	CSEN700028	Knife in HW R=1.5/2/25°
72	35	16+2KN	1.5/3/25°	4	CW.	D03679	CSEN350029	
						D03680	CSEN700029	Knife in HW R=1.5/3/25°
72	35	16+2KN	1.5/3/25°	4	CCW.	D03681	CSEN350030	
						D03682	CSEN700030	Knife in HW R=1.5/3/25°
72	35	16+2KN	2/3/25°	4	CW.	D03683	CSEN350031	
						D03684	CSEN700031	Knife in HW R=2/3/25°
72	35	16+2KN	2/3/25°	4	CCW.	D03685	CSEN350032	
						D03686	CSEN700032	Knife in HW R=2/3/25°

CR-200V Corner rounding unit

Rounding cutter with mechanical fixing and interchangeable knives

HW

MEC

MACHINES / APPLICATIONS

AKRON 400.

Machining operations on supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge radiusing.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.	Spare parts
60/70	16	16+2KN	1	4	CW.	D03255	3401A0355	
60/70	16	16+2KN	1	4	CCW.	D03256	3401A0356	
						D03257	3402A0087	Knife in HW 16x17x2 R=1
60/70	16	16+2KN	1.5	4	CW.	D03252	3401A0353	
60/70	16	16+2KN	1.5	4	CCW.	D03253	3401A0354	
						D03254	3402A0086	Knife in HW 16x17x2 R=1.5
60/70	16	16+2KN	2	4	CW.	D03246	3401A0349	
60/70	16	16+2KN	2	4	CCW.	D03247	3401A0350	
						D03248	3402A0084	Knife in HW 16x17x2 R=2
60/70	16	16+2KN	3	4	CW.	D03249	3401A0351	
60/70	16	16+2KN	3	4	CCW.	D03250	3401A0352	
						D03251	3402A0085	Knife in HW 16x17x2 R=3

CR-200V Corner rounding unit

Rounding cutter

new

HW

MEC

MACHINES / APPLICATIONS

AKRON 400.

Machining operations on supported and plastic edges.

DESIGN

Braze-welded tips in HW.

NOTES

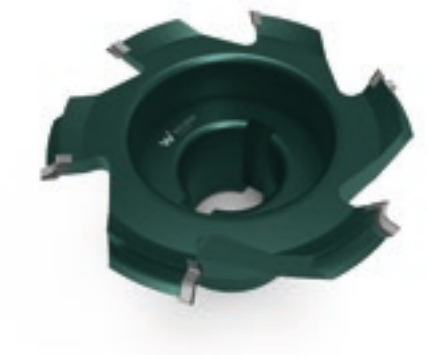
Radiusing and chamfering of edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R (mm)	Z (mm)	Rot.	Wirutex Id-No.	BIESSE Id-No.
60/70	9	16+2KN	1.2	4	CW.	S17567	CCEN350223
60/70	9	16+2KN	1.2	4	CCW.	S17568	CCEN350224
60/70	9	16+2KN	1.7	4	CW.	S17565	CCEN350221
60/70	9	16+2KN	1.7	4	CCW.	S17566	CCEN350222
60/70	9	16+2KN	2.2	4	CW.	S17561	CCEN350217
60/70	9	16+2KN	2.2	4	CCW.	S17562	CCEN350218
60/70	9	16+2KN	3.2	4	CW.	S17563	CCEN350219
60/70	9	16+2KN	3.2	4	CCW.	S17564	CCEN350220

CR-200V Corner rounding unit

Rounding cutter



HW

MEC

MACHINES / APPLICATIONS

AKRON 400.

Machining operations on supported and plastic edges.

DESIGN

Braze-welded tips in HW.

NOTES

Radiusing and chamfering of edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	Id-No. BIESSE
60/68	9	16+2KN	1	6	CW.	D01578	N3401N0112
60/68	9	16+2KN	1	6	CCW.	D01579	N3401N0113
60/68	9	16+2KN	1.5	6	CW.	D01529	N3401N0107
60/68	9	16+2KN	1.5	6	CCW.	D01580	N3401N0108
60/68	9	16+2KN	2	6	CW.	D01482	N3401N0105
60/68	9	16+2KN	2	6	CCW.	D01483	N3401N0106
60/68	9	16+2KN	3	6	CW.	D01527	N3401N0103
60/68	9	16+2KN	3	6	CCW.	D01528	N3401N0104
60/68	9	16+2KN	25°	6	CW.	D01522	N3401N0101
60/68	9	16+2KN	25°	6	CCW.	D01523	N3401N0102

DP

DESIGN

DP tips.

NOTES

Radiusing and chamfering of edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Id-No. Wirutex	Id-No. BIESSE
60	11	16+2KN	1	6	CW.	S14451	N3401N0110
60	11	16+2KN	1	6	CCW.	S14450	N3401N0111
60	11	16+2KN	1.5	6	CW.	S13811	N3401N0095
60	11	16+2KN	1.5	6	CCW.	S13810	N3401N0096
60	11	16+2KN	2	6	CW.	S14234	N3401N0093
60	11	16+2KN	2	6	CCW.	S14233	N3401N0094
60	11	16+2KN	3	6	CW.	S14453	N3401N0091
60	11	16+2KN	3	6	CCW.	S14452	N3401N0092
58.8/67	9	16+2KN	25°	6	CW.	S06800	N3401N0089
58.8/67	9	16+2KN	25°	6	CCW.	S06801	N3401N0090
59.3/68	4.5	16+2KN	45°	6	CW.	S14143	N3401N0457
59.3/68	4.5	16+2KN	45°	6	CCW.	S14144	N3401N0458

RBK-503 Edge scraper unit

Edge scraper

HWM

MEC

MACHINES / APPLICATIONS

AKRON 400.

DESIGN

Rounding insert in HWM.

NOTES

For edge finishing.

Features / Dimensions	Wirutex Id-No.	BIESSE Id-No.
R=1.0	D02329	N3402N0056
R=1.5	D01536	N3402N0055
R=2.0	D01535	N3402N0054
R=3.0	D01553	N3402N0053
25°	D01548	N3402N0097

RCC-701 Glue scraper unit

Glue scraper

HW

MEC

MACHINES / APPLICATIONS

AKRON 400.

Machining operations on supported and plastic edges.

DESIGN

Triangular insert
with 3 cutting edges in HW.

NOTES

Removal of glue residues from the edge.

Features / Dimensions	Z	Wirutex Id-No.	BIESSE Id-No.
22.86x2.5	3	C00626	E3401E0117

Range

STREAM A

RT20/RT30 Pre-milling unit

LOW-NOISE "ECO" pre-milling cutter

DP

MEC

MACHINES / APPLICATIONS

STREAM A.

Machining operations on chipboard and MDF with melamine and its composites.

DESIGN

DP tips.

Axiality 45°.

*Axiality 30°.

LOW-NOISE with significant noise reduction.

NOTES

Pre-milling cutter for single-sided edgebanding machines.

Max. rpm: 9,000 /12,000

D (mm)	B (mm)	d (mm)	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
125	47,5	30+2KN	3+3	RH	S17223	CCEN350185
125	47,5	30+2KN	3+3	LH	S17224	CCEN350186
125	64	30+2KN	3+3	RH	S13047	CSEN350073
125	64	30+2KN	3+3	LH	S13048	CSEN350074
125	97	30+2KN	3+3	RH	S05237	N3401N0316
125	97	30+2KN	3+3	LH	S05236	N3401N0317
125	44	30+2KN	3+3	Symm.	*S12886	CSEN350048
125	64	30+2KN	3+3	Symm.	*S13191	CSEN350087
125	44	30+2KN	3+3	Symm.	S12896	CSEN350049

IN-801 End trimming unit

End cutting saw blade

HW

MEC

MACHINES / APPLICATIONS

STREAM A.

Machining operations on supported and plastic edges.

DESIGN

HW tips.

Alternate tooth.

NOTES

End cutting of glued edges.

Max. rpm: 12,000

Always include the code marked on the tool currently being used or machine serial number.

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.
140	3.6	55+4	36	D04050	CSEN750035

IT70-P End trimming unit

End cutting saw blade

HW

MEC

MACHINES / APPLICATIONS

STREAM A.

Machining operations on supported and plastic edges.

DESIGN

HW tips.

Tilted tooth.

NOTES

End cutting of glued edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	Z	Rot.	Id-No. Wirutex	Id-No. BIESSE
150	3,2	55+4	36	RH	D05122	CCEN750047
150	3,2	55+4	36	LH	D05123	CCEN750046

IT90-S End trimming unit

End cutting saw blade

HW

MEC

MACHINES / APPLICATIONS

STREAM A.

Machining operations on supported and plastic edges.

DESIGN

HW tips.

Alternate tooth + smoothing.

NOTES

End cutting of glued edges.

Max. rpm: 12,000

Always include the code marked on the tool currently being used or machine serial number.

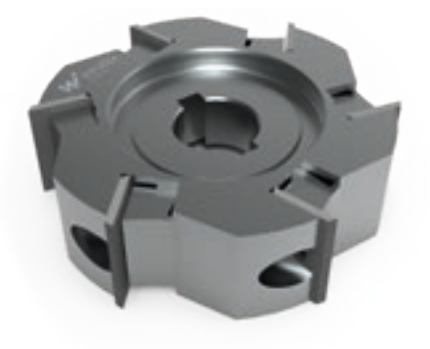
D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.
130	3.6	45+4	16+4	D04047	CSEN750031

RS-701/RS-100 Top and bottom trimming unit

Overlapped trimmer with interchangeable knives

HW

MEC



MACHINES / APPLICATIONS

STREAM A.

Machining operations on supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge trimming.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.	Spare parts
80	25	16+2KN	6	D02125	N3401N0428	
				D02135	N3402N0127	Knife in HW 25X12X1.5

RF100 Fine trimming unit

Tilted trimmer with interchangeable knives

HW

MEC

MACHINES / APPLICATIONS

STREAM A.

Machining operations on supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge trimming on tilted engines.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Wirutex Id-No.	BIESSE Id-No.	Spare parts
70	20	16+2KN	-	6	D02126	N3401N0430	
					C00403	N3402N0040	Knife in HW 20x12x1.5
75	20	16+2KN	1	6	D02368	N3401N0431	
					D02372	N3402N0123	Knife in HW R=1
75	20	16+2KN	1.5	6	D02369	N3401N0432	
					D02373	N3402N0124	Knife in HW R=1.5
75	20	16+2KN	2	6	D02370	N3401N0433	
					D02374	N3402N0125	Knife in HW R=2
75	20	16+2KN	3	6	D02127	N3401N0434	
					D02134	N3402N0126	Knife in HW R=3

RF300/RF400 Fine trimming unit

Tilted fine trimmer/trimmer with mechanical fixing and interchangeable multiprofile knives

HW

MEC

MACHINES / APPLICATIONS

STREAM A.

Machining operations on supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge trimming on tilted engines.

Max. rpm: 12,000

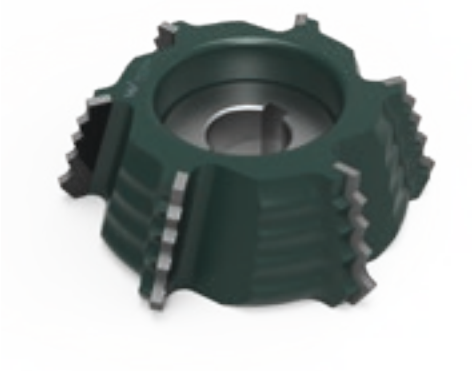
D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.	Spare parts
75	25	16+2KN	1.5/2/3/25°	4	CW.	D02128	N3401N0391	
						D01540	N3402N0035	Knife in HW 25x19.6x2 R=1.5/2/3
75	25	16+2KN	1.5/2/3/25°	4	CCW.	D02129	N3401N0392	
						D01541	N3402N0036	Knife in HW 25x19.6x2 R=1.5/2/3
75	25	16+2KN	1/2/3/25°	4	CW.	D02378	N3401N0393	
						D01700	N3402N0084	Knife in HW 25x19.6x2 R=1/2/3
75	25	16+2KN	1/2/3/25°	4	CCW.	D02379	N3401N0394	
						D01701	N3402N0085	Knife in HW 25x19.6x2 R=1/2/3
75	25	16+2KN	1/1.5/2/25°	4	CW.	D02380	N3401N0395	
						D01999	N3402N0083	Knife in HW 25x19.6x2 R=1/1.5/2
75	25	16+2KN	1/1.5/2/25°	4	CCW.	D02381	N3401N0396	
						D01998	N3402N0082	Knife in HW 25x19.6x2 R=1/1.5/2

RF300/RF400 Fine trimming unit

Tilted multiradius fine trimmer/trimmer

DP

MEC



MACHINES / APPLICATIONS

STREAM A.

Machining operations on ABS edges.

DESIGN

DP tips.

NOTES

Edge trimming on tilted engines.

Max. rpm: 18,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
75.4	25	16+2KN	1/2/3/25°	6	CW.	S10540	N3401N0397
75.4	25	16+2KN	1/2/3/25°	6	CCW.	S10541	N3401N0398
75.4	25	16+2KN	1.5/2/3/25°	6	CW.	S09784	N3401N0399
75.4	25	16+2KN	1.5/2/3/25°	6	CCW.	S09785	N3401N0400
75.4	25	16+2KN	1/1.5/2/25°	6	CW.	S09760	N3401N0401
75.4	25	16+2KN	1/1.5/2/25°	6	CCW.	S09761	N3401N0402

RF300/RF400 Fine trimming unit

Tilted trimmer with interchangeable knives

HW

MEC

MACHINES / APPLICATIONS

STREAM A.
Machining operations on edges in solid wood, supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge trimming on tilted engines.
Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.	Spare parts
72	35	16+2KN	1/1.5	4	CW.	D02843	N3401N0564	
						D02844	N3402N0159	Knife in HW R=1/1.5
72	35	16+2KN	1/1.5	4	CCW.	D02845	N3401N0565	
						D02846	N3402N0160	Knife in HW R=1/1.5
72	35	16+2KN	1/2	4	CW.	D02847	N3401N0566	
						D02848	N3402N0161	Knife in HW R=1/2
72	35	16+2KN	1/2	4	CCW.	D02849	N3401N0567	
						D02850	N3402N0162	Knife in HW R=1/2
72	35	16+2KN	1.5/2	4	CW.	D02851	N3401N0568	
						D02852	N3402N0163	Knife in HW R=1.5/2
72	35	16+2KN	1.5/2	4	CCW.	D02853	N3401N0569	
						D02854	N3402N0164	Knife in HW R=1.5/2
72	35	16+2KN	1.5/3	4	CW.	D02855	N3401N0570	
						D02856	N3402N0165	Knife in HW R=1.5/3
72	35	16+2KN	1.5/3	4	CCW.	D02857	N3401N0571	
						D02858	N3402N0166	Knife in HW R=1.5/3
72	35	16+2KN	2/3	4	CW.	D02859	N3401N0572	
						D02860	N3402N0167	Knife in HW R=2/3
72	35	16+2KN	2/3	4	CCW.	D02861	N3401N0573	
						D02862	N3402N0168	Knife in HW R=2/3

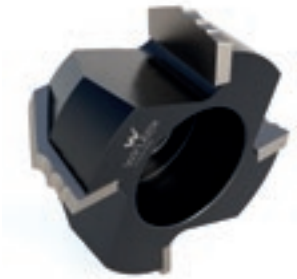
RF300/RF400 Fine trimming unit

Trimmer

new

HW

MEC



MACHINES / APPLICATIONS

STREAM A.
Machining operations on edges in solid wood, supported and plastic edges.

DESIGN

Braze-welded tips in HW.

NOTES

Edge trimming on tilted engines.
Max. rpm: 18,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
71.26	33.5	16+2KN	1.2/1.7/2.2/45°/0°	4	CW.	S18257	CCEN350269
71.26	33.5	16+2KN	1.2/1.7/2.2/45°/0°	4	CCW.	S18258	CCEN350270
71.61	33.5	16+2KN	1.2/2.2/3.2/25°/0°	4	CW.	S16407	CCEN350114
71.61	33.5	16+2KN	1.2/2.2/3.2/25°/0°	4	CCW.	S16408	CCEN350115

AR70 Single tool corner rounding unit

Multiprofile rounding cutter

DP

MEC

MACHINES / APPLICATIONS

STREAM A.

Machining operations on edges of different materials.

Also suitable for Softforming operations.

DESIGN

Multiprofile cutter with DP tips.

NOTES

Radiusing and chamfering of edges.

Max. rpm: 18,000

AR70 corner rounding unit is equipped with one tool.

D (mm)	B (mm)	Connection	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
60	20.5	HSK25R	1.2/1.7/2.2/3.2/25°	4	CCW.	S18614	CCEN350255
60	20.5	HSK25R	1.2/1.7/2.2/3.2/45°	4	CCW.	S18613	CCEN350271

AR30/AR34 Corner rounding unit

Rounding cutter with mechanical fixing and interchangeable knives

HW

MEC

MACHINES / APPLICATIONS

STREAM A.

Machining operations on supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge radiusing.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.	Spare parts
60/70	16	16+2KN	1	4	CW.	D03255	3401A0355	
60/70	16	16+2KN	1	4	CCW.	D03256	3401A0356	
						D03257	3402A0087	Knife in HW 16x17x2 R=1
60/70	16	16+2KN	1.5	4	CW.	D03252	3401A0353	
60/70	16	16+2KN	1.5	4	CCW.	D03253	3401A0354	
						D03254	3402A0086	Knife in HW 16x17x2 R=1.5
60/70	16	16+2KN	2	4	CW.	D03246	3401A0349	
60/70	16	16+2KN	2	4	CCW.	D03247	3401A0350	
						D03248	3402A0084	Knife in HW 16x17x2 R=2
60/70	16	16+2KN	3	4	CW.	D03249	3401A0351	
60/70	16	16+2KN	3	4	CCW.	D03250	3401A0352	
						D03251	3402A0085	Knife in HW 16x17x2 R=3

AR30/AR34 Corner rounding unit

Rounding cutter

new

HW

MEC

MACHINES / APPLICATIONS

STREAM A.

Machining operations on edges
in solid wood, supported and plastic edges.

DESIGN

Braze-welded tips in HW.

NOTES

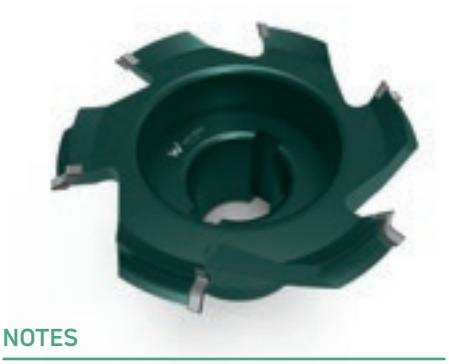
Edge trimming on tilted engines.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
60/70	9	16+2KN	1.2	4	CW.	S17567	CCEN350223
60/70	9	16+2KN	1.2	4	CCW.	S17568	CCEN350224
60/70	9	16+2KN	1.7	4	CW.	S17565	CCEN350221
60/70	9	16+2KN	1.7	4	CCW.	S17566	CCEN350222
60/70	9	16+2KN	2.2	4	CW.	S17561	CCEN350217
60/70	9	16+2KN	2.2	4	CCW.	S17562	CCEN350218
60/70	9	16+2KN	3.2	4	CW.	S17563	CCEN350219
60/70	9	16+2KN	3.2	4	CCW.	S17564	CCEN350220

AR30/AR34 Corner rounding unit

Rounding cutter



HW

MEC

MACHINES / APPLICATIONS

STREAM A.

Machining operations on supported and plastic edges.

DESIGN

Braze-welded tips in HW.

NOTES

Radiusing and chamfering of edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
60/68	9	16+2KN	1	6	CW.	D01578	N3401N0112
60/68	9	16+2KN	1	6	CCW.	D01579	N3401N0113
60/68	9	16+2KN	1.5	6	CW.	D01529	N3401N0107
60/68	9	16+2KN	1.5	6	CCW.	D01580	N3401N0108
60/68	9	16+2KN	2	6	CW.	D01482	N3401N0105
60/68	9	16+2KN	2	6	CCW.	D01483	N3401N0106
60/68	9	16+2KN	3	6	CW.	D01527	N3401N0103
60/68	9	16+2KN	3	6	CCW.	D01528	N3401N0104
60/68	9	16+2KN	25°	6	CW.	D01522	N3401N0101
60/68	9	16+2KN	25°	6	CCW.	D01523	N3401N0102

DP

DESIGN

DP tips.

NOTES

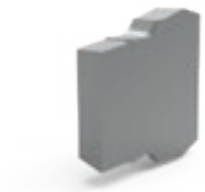
Radiusing and chamfering of edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
60	11	16+2KN	1	6	CW.	S14451	N3401N0110
60	11	16+2KN	1	6	CCW.	S14450	N3401N0111
60	11	16+2KN	1.5	6	CW.	S13811	N3401N0095
60	11	16+2KN	1.5	6	CCW.	S13810	N3401N0096
60	11	16+2KN	2	6	CW.	S14234	N3401N0093
60	11	16+2KN	2	6	CCW.	S14233	N3401N0094
60	11	16+2KN	3	6	CW.	S14453	N3401N0091
60	11	16+2KN	3	6	CCW.	S14452	N3401N0092
58.8/67	9	16+2KN	25°	6	CW.	S06800	N3401N0089
58.8/67	9	16+2KN	25°	6	CCW.	S06801	N3401N0090
59.3/68	4.5	16+2KN	45°	6	CW.	S14143	N3401N0457
59.3/68	4.5	16+2KN	45°	6	CCW.	S14144	N3401N0458

RB02 Edge scraper unit

Edge scraper with anti-bleaching profile



HWM

MEC

MACHINES / APPLICATIONS

STREAM A.

Machining operations on ABS edges.

DESIGN

Insert in HWM with anti-bleaching profile.

NOTES

For edge finishing.

Features / Dimensions	Wirutex Id-No.	BIESSE Id-No.
25°	D03413	3402A0083
R=1	D03607	3402A0124
R=1.5	D03608	3402A0125
R=2	D03609	3402A0126
R=3	D03222	3402A0082

RB02 Edge scraper unit

Edge scraper

new

HWM

MEC

MACHINES / APPLICATIONS

STREAM A.
Machining operations on ABS edges.

DESIGN

HWM insert.

NOTES

For edge finishing.

Features / Dimensions	Wirutex Id-No.	BIESSE Id-No.
R=1.2/1.7 UPPER	D05417	CCEN720024
R=1.2/1.7 LOWER	D05418	CCEN720029
R=1.2/2.2 UPPER	D05419	CCEN720032
R=1.2/2.2 LOWER	D05420	CCEN720030
R=1.7/2.2 UPPER	D05413	CCEN720022
R=1.7/2.2 LOWER	D05414	CCEN720027
R=1.7/3.2 UPPER	D05415	CCEN720023
R=1.7/3.2 LOWER	D05416	CCEN720028
R=2.2/3.2 UPPER	D05421	CCEN720021
R=2.2/3.2 LOWER	D05422	CCEN720026

RB300/RB400 Edge scraper unit

Edge scraper

new

HWM

MEC

MACHINES / APPLICATIONS

STREAM A.

Machining operations on ABS edges.

DESIGN

HWM insert.

NOTES

For edge finishing.

Features / Dimensions	Wirutex Id-No.	BIESSE Id-No.
R=1,2/1,7/2,2/3,2 UPPER	D05291	CCEN720015
R=1,2/1,7/2,2/3,2 LOWER	D05290	CCEN720014
R=1,2/1,7/2,2/45° UPPER	D05550	CCEN720037
R=1,2/1,7/2,2/45° LOWER	D05549	CCEN720036

RB300/RB400 Edge scraper unit

Edge scraper

HWM

MEC

MACHINES / APPLICATIONS

STREAM A.

Machining operations on ABS edges.

DESIGN

Insert in HWM.

NOTES

For edge finishing.

Features / Dimensions	Wirutex Id-No.	BIESSE Id-No.
R=1/1.5/2	D03545	3402A0116
R=1.5/2/3	D03556	3402A0117
R=1/2/3	D03557	3402A0118

RCC-701 Glue scraper unit

Glue scraper

HW

MEC

MACHINES / APPLICATIONS

STREAM A.

Machining operations on supported and plastic edges.

DESIGN

Triangular insert with 3 cutting edges in HW.

NOTES

Removal of glue residues from the edge.

Features / Dimensions	Z	Wirutex Id-No.	BIESSE Id-No.
22.86x2.5	3	C00626	E3401E0117

Range

STREAM A SMART

FI-502 Pre-milling unit

LOW-NOISE 45° pre-milling cutter

DP

MEC

MACHINES / APPLICATIONS

STREAM A SMART.

Machining operations on chipboard and MDF with melamine and its composites.

DESIGN

DP tips.

Axiality 45°.

Tips height: 2,5 mm

*Tips height: 4,3 mm

Symmetrical.

LOW-NOISE with significant noise reduction.

NOTES

Pre-milling cutter for single-sided edgebanding machines.

Max. rpm: 9,000 /12,000

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.
80	49	30+2KN	3+3	S13165	CSEN350085
80	65	30+2KN	3+3	S13164	CSEN350086
80	49	30+2KN	3+3	*S16131	
80	65	30+2KN	3+3	*S17425	
80	49	30+2KN	2+2	S13076	
80	65	30+2KN	2+2	S12805	

IN-801 End trimming unit

End cutting saw blade

HW

MEC

MACHINES / APPLICATIONS

STREAM A SMART.

Machining operations on supported and plastic edges.

DESIGN

HW tips.

Alternate tooth.

NOTES

End cutting of glued edges.

Max. rpm: 12,000

Always include the code marked on the tool currently being used or machine serial number.

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.
140	3.6	55+4	36	D04050	CSEN750035

IT-70S End trimming unit

End cutting saw blade

HW

MEC

MACHINES / APPLICATIONS

STREAM A SMART.

Machining operations on supported and plastic edges.

DESIGN

HW tips.

Inclined tooth.

NOTES

End cutting of glued edges.

Max. rpm: 12,000

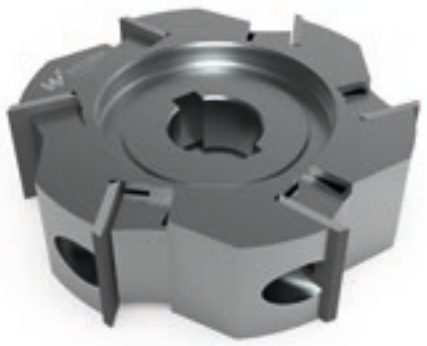
D (mm)	B (mm)	d (mm)	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
150	3.2	55+4	36	RH	D05122	CCEN750047
150	3.2	55+4	36	LH	D05123	CCEN750046

RS-502 Top and bottom trimming unit

Overlapped trimmer with interchangeable knives

HW

MEC



MACHINES / APPLICATIONS

STREAM A SMART.

Machining operations on supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge trimming.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.	Spare parts
70	20	16+2KN	6	D02126	N3401N0430	
				C00403	N3402N0040	Knife in HW 20x12x1.5

RI-501 Fine trimming unit

Tilted trimmer with mechanical fixing and interchangeable multiprofile knives

HW

MEC

MACHINES / APPLICATIONS

STREAM A SMART.

Machining operations on edges in solid wood, supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge trimming on tilted engines.

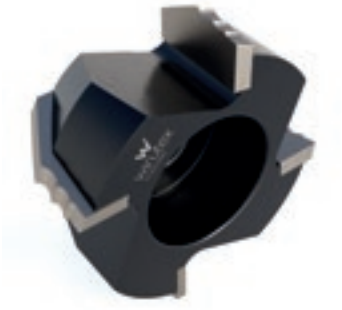
Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.	Spare parts
72	30	16+2KN	25°	3	CW.	D03647	CSEN350013	
						D03648	CSEN700013	Knife in HW 25°
72	30	16+2KN	25°	3	CCW.	D03649	CSEN350014	
						D03650	CSEN700014	Knife in HW 25°
72	30	16+2KN	1	3	CW.	D03651	CSEN350015	
						D03652	CSEN700015	Knife in HW R=1
72	30	16+2KN	1	3	CCW.	D03653	CSEN350016	
						D03654	CSEN700016	Knife in HW R=1
72	30	16+2KN	1.5	3	CW.	D03655	CSEN350017	
						D03656	CSEN700017	Knife in HW R=1.5
72	30	16+2KN	1.5	3	CCW.	D03657	CSEN350018	
						D03658	CSEN700018	Knife in HW R=1.5
72	30	16+2KN	2	3	CW.	D03659	CSEN350019	
						D03660	CSEN700019	Knife in HW R=2
72	30	16+2KN	2	3	CCW.	D03661	CSEN350020	
						D03662	CSEN700020	Knife in HW R=2
72	30	16+2KN	3	3	CW.	D03663	CSEN350021	
						D03664	CSEN700021	Knife in HW R=3
72	30	16+2KN	3	3	CCW.	D03665	CSEN350022	
						D03666	CSEN700022	Knife in HW R=3

RI-501 Fine trimming unit

Trimmer

new



HW

MEC

MACHINES / APPLICATIONS

STREAM A SMART.

Machining operations on edges in solid wood, supported and plastic edges.

DESIGN

Braze-welded tips in HW.

NOTES

Edge trimming on tilted engines.

Max. rpm: 18,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
71.26	33.5	16+2KN	1.2/1.7/2.2/45°/0°	4	CW.	S18257	CCEN350269
71.26	33.5	16+2KN	1.2/1.7/2.2/45°/0°	4	CCW.	S18258	CCEN350270
71.61	33.5	16+2KN	1.2/2.2/3.2/25°/0°	4	CW.	S16407	CCEN350114
71.61	33.5	16+2KN	1.2/2.2/3.2/25°/0°	4	CCW.	S16408	CCEN350115

RI-501 Multiprofile fine trimming unit

Tilted trimmer with mechanical fixing and interchangeable multiprofile knives

HW

MEC

MACHINES / APPLICATIONS

STREAM A SMART.

Machining operations on edges in solid wood, supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge trimming on tilted engines.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.	Spare parts
72	35	16+2KN	1/1.5/25°	4	CW.	D03667	CSEN350023	
						D03668	CSEN700023	Knife in HW R=1/1.5/25°
72	35	16+2KN	1/1.5/25°	4	CCW.	D03669	CSEN350024	
						D03670	CSEN700024	Knife in HW R=1/1.5/25°
72	35	16+2KN	1/2/25°	4	CW.	D03671	CSEN350025	
						D03672	CSEN700025	Knife in HW R=1/2/25°
72	35	16+2KN	1/2/25°	4	CCW.	D03673	CSEN350026	
						D03674	CSEN700026	Knife in HW R=1/2/25°
72	35	16+2KN	1.5/2/25°	4	CW.	D03675	CSEN350027	
						D03676	CSEN700027	Knife in HW R=1.5/2/25°
72	35	16+2KN	1.5/2/25°	4	CCW.	D03677	CSEN350028	
						D03678	CSEN700028	Knife in HW R=1.5/2/25°
72	35	16+2KN	1.5/3/25°	4	CW.	D03679	CSEN350029	
						D03680	CSEN700029	Knife in HW R=1.5/3/25°
72	35	16+2KN	1.5/3/25°	4	CCW.	D03681	CSEN350030	
						D03682	CSEN700030	Knife in HW R=1.5/3/25°
72	35	16+2KN	2/3/25°	4	CW.	D03683	CSEN350031	
						D03684	CSEN700031	Knife in HW R=2/3/25°
72	35	16+2KN	2/3/25°	4	CCW.	D03685	CSEN350032	
						D03686	CSEN700032	Knife in HW R=2/3/25°

AR70 Single tool corner rounding unit

Multiprofile rounding cutter

DP

MEC

MACHINES / APPLICATIONS

STREAM A SMART.

Machining operations on edges of different materials.

Also suitable for Softforming operations.

DESIGN

Multiprofile cutter with DP tips.

NOTES

Radiusing and chamfering of edges.

Max. rpm: 18,000

AR70 corner rounding unit is equipped with one tool.

D (mm)	B (mm)	Connection	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
60	20.5	HSK25R	1.2/1.7/2.2/3.2/25°	4	CCW.	S18614	CCEN350255
60	20.5	HSK25R	1.2/1.7/2.2/3.2/45°	4	CCW.	S18613	CCEN350271

AR30 Corner rounding unit

Rounding cutter with mechanical fixing and interchangeable knives

HW

MEC

MACHINES / APPLICATIONS

STREAM A SMART.

Machining operations on supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge radiusing.

Max. rpm: 12,000

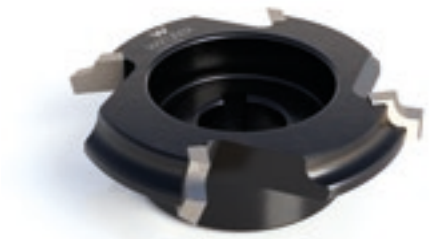
D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.	Spare parts
60/70	16	16+2KN	1	4	CW.	D03255	3401A0355	
60/70	16	16+2KN	1	4	CCW.	D03256	3401A0356	
						D03257	3402A0087	Knife in HW 16x17x2 R=1
60/70	16	16+2KN	1.5	4	CW.	D03252	3401A0353	
60/70	16	16+2KN	1.5	4	CCW.	D03253	3401A0354	
						D03254	3402A0086	Knife in HW 16x17x2 R=1.5
60/70	16	16+2KN	2	4	CW.	D03246	3401A0349	
60/70	16	16+2KN	2	4	CCW.	D03247	3401A0350	
						D03248	3402A0084	Knife in HW 16x17x2 R=2
60/70	16	16+2KN	3	4	CW.	D03249	3401A0351	
60/70	16	16+2KN	3	4	CCW.	D03250	3401A0352	
						D03251	3402A0085	Knife in HW 16x17x2 R=3

AR30 Corner rounding unit
Rounding cutter

new

HW

MEC



MACHINES / APPLICATIONS

STREAM A SMART.

Machining operations on supported and plastic edges.

DESIGN

Braze-welded tips in HW.

NOTES

Radiusing and chamfering of edges.

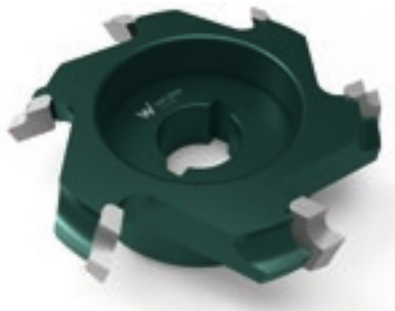
Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
60/70	9	16+2KN	1.2	4	CW.	S17567	CCEN350223
60/70	9	16+2KN	1.2	4	CCW.	S17568	CCEN350224
60/70	9	16+2KN	1.7	4	CW.	S17565	CCEN350221
60/70	9	16+2KN	1.7	4	CCW.	S17566	CCEN350222
60/70	9	16+2KN	2.2	4	CW.	S17561	CCEN350217
60/70	9	16+2KN	2.2	4	CCW.	S17562	CCEN350218
60/70	9	16+2KN	3.2	4	CW.	S17563	CCEN350219
60/70	9	16+2KN	3.2	4	CCW.	S17564	CCEN350220

AR30 Corner rounding unit
Rounding cutter

HW

MEC



MACHINES / APPLICATIONS

STREAM A SMART.

Machining operations on supported and plastic edges.

DESIGN

Braze-welded tips in HW.

NOTES

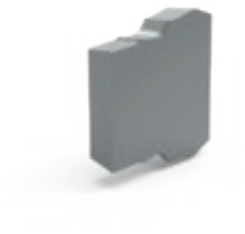
Radiusing and chamfering of edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
60/68	9	16+2KN	25°	6	CW.	D01522	N3401N0101
60/68	9	16+2KN	25°	6	CCW.	D01523	N3401N0102

RB02 Edge scraper unit

Edge scraper with anti-bleaching profile



HWM

MEC

MACHINES / APPLICATIONS

STREAM A SMART.

Machining operations on ABS edges.

DESIGN

Insert in HWM with anti-bleaching profile.

NOTES

For edge finishing.

Features / Dimensions	Wirutex Id-No.	BIESSE Id-No.
25°	D03413	3402A0083
R=1	D03607	3402A0124
R=1.5	D03608	3402A0125
R=2	D03609	3402A0126
R=3	D03222	3402A0082

RB02 Edge scraper unit

Edge scraper

new

HWM

MEC

MACHINES / APPLICATIONS

STREAM A SMART.
Machining operations on ABS edges.

DESIGN

HWM insert.

NOTES

For edge finishing.

Features / Dimensions	Wirutex Id-No.	BIESSE Id-No.
R=1.2/1.7 UPPER	D05417	CCEN720024
R=1.2/1.7 LOWER	D05418	CCEN720029
R=1.2/2.2 UPPER	D05419	CCEN720032
R=1.2/2.2 LOWER	D05420	CCEN720030
R=1.7/2.2 UPPER	D05413	CCEN720022
R=1.7/2.2 LOWER	D05414	CCEN720027
R=1.7/3.2 UPPER	D05415	CCEN720023
R=1.7/3.2 LOWER	D05416	CCEN720028
R=2.2/3.2 UPPER	D05421	CCEN720021
R=2.2/3.2 LOWER	D05422	CCEN720026

RB03 Edge scraper unit

Edge scraper

new

HWM

MEC

MACHINES / APPLICATIONS

STREAM A SMART.
Machining operations on ABS edges.

DESIGN

HWM insert.

NOTES

For edge finishing.

Features / Dimensions	Wirutex Id-No.	BIESSE Id-No.
R=1.2/1.7/2.2/3.2 UPPER	D05291	CCEN720015
R=1.2/1.7/2.2/3.2 LOWER	D05290	CCEN720014
R=1.2/1.7/2.2/45° UPPER	D05550	CCEN720037
R=1.2/1.7/2.2/45° LOWER	D05549	CCEN720036

RCC-701 Glue scraper unit

Glue scraper

HW

MEC

MACHINES / APPLICATIONS

STREAM A SMART.

Machining operations on supported and plastic edges.

DESIGN

Triangular insert with 3 cutting edges in HW.

NOTES

Removal of glue residues from the edge.

Features / Dimensions	Z	Wirutex Id-No.	BIESSE Id-No.
22.86x2.5	3	C00626	E3401E0117

Range

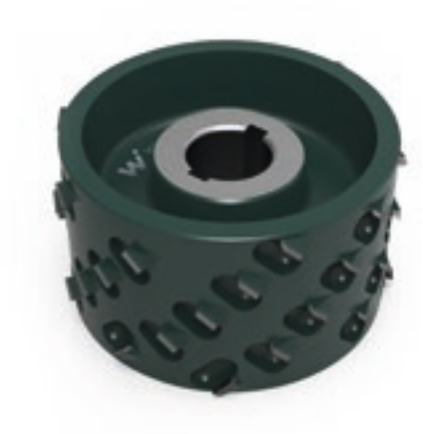
STREAM B MDS

RT20/RT30 Pre-milling unit

LOW-NOISE "ECO" pre-milling cutter

DP

MEC



MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on chipboard and MDF with melamine and its composites.

DESIGN

DP tips.

Axiality 45°.

*Axiality 30°.

LOW-NOISE with significant noise reduction.

NOTES

Pre-milling cutter for single-sided edgebanding machines.

Max. rpm: 9,000 /12,000

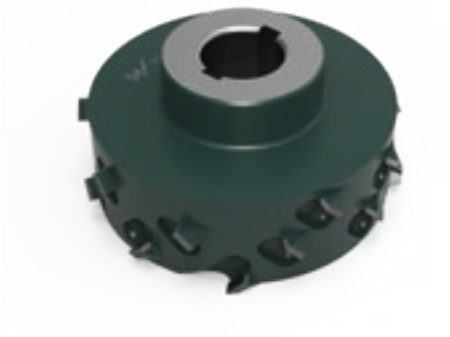
D (mm)	B (mm)	d (mm)	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
125	47,5	30+2KN	3+3	RH	S17223	CCEN350185
125	47,5	30+2KN	3+3	LH	S17224	CCEN350186
125	64	30+2KN	3+3	RH	S13047	CSEN350073
125	64	30+2KN	3+3	LH	S13048	CSEN350074
125	97	30+2KN	3+3	RH	S05237	N3401N0316
125	97	30+2KN	3+3	LH	S05236	N3401N0317
125	44	30+2KN	3+3	Symm.	*S12886	CSEN350048
125	64	30+2KN	3+3	Symm.	*S13191	CSEN350087
125	44	30+2KN	3+3	Symm.	S12896	CSEN350049

RT20/RT30 Pre-milling unit

LOW-NOISE "HIGH-PERFORMANCE" pre-milling cutter

DP

MEC



MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on chipboard and MDF with melamine and its composites.

DESIGN

DP tips.

Axiality 45°.

LOW-NOISE with significant noise reduction.

NOTES

Pre-milling cutter for single-sided edgebanding machines.

Max. rpm: 9,000 /12,000

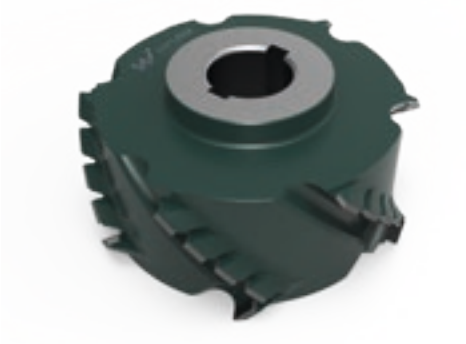
D (mm)	B (mm)	d (mm)	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
125	34	30+2KN	3+3	RH	S14343	
125	34	30+2KN	3+3	LH	S14344	
125	47	30+2KN	3+3	RH	S14086	CSEN350137
125	47	30+2KN	3+3	LH	S14087	CSEN350138
125	67	30+2KN	3+3	RH	S14324	CSEN350139
125	67	30+2KN	3+3	LH	S14325	CSEN350140

RT20/RT30 Pre-milling unit

"HIGH-PERFORMANCE" pre-milling cutter

DP

MEC



MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on chipboard and MDF with melamine and its composites, honeycomb wood and veneer.

DESIGN

DP tips.

Axiality 45°.

NOTES

Pre-milling cutter for single-sided edgebanding machines.

Max. rpm: 9,000 /12,000

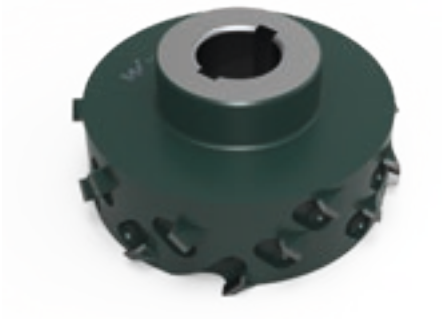
D (mm)	B (mm)	d (mm)	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
125	33	30+2KN	3+3	RH	S14347	
125	33	30+2KN	3+3	LH	S14348	
125	47	30+2KN	3+3	RH	S14345	
125	47	30+2KN	3+3	LH	S14346	
125	63	30+2KN	3+3	RH	S12216	3401A0457
125	63	30+2KN	3+3	LH	S12217	3401A0458

External pre-milling unit

LOW-NOISE "HIGH-PERFORMANCE" pre-milling cutter

DP

MEC



MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on chipboard and MDF with melamine and its composites.

DESIGN

DP tips.

Axiality 45°.

LOW-NOISE with significant noise reduction.

NOTES

Pre-milling cutter for single-sided edgebanding machines.

Max. rpm: 9,000 /12,000

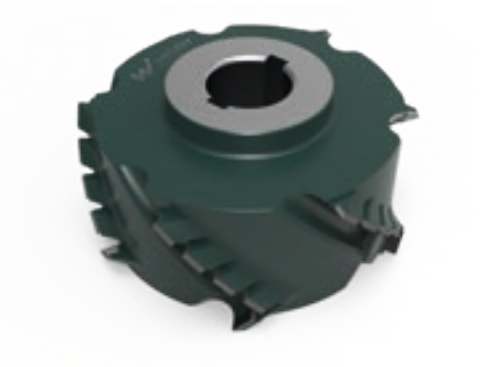
D (mm)	B (mm)	d (mm)	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
125	34	30+2KN	3+3	RH	S14343	
125	34	30+2KN	3+3	LH	S14344	
125	47	30+2KN	3+3	RH	S14086	CSEN350137
125	47	30+2KN	3+3	LH	S14087	CSEN350138
125	67	30+2KN	3+3	RH	S14324	CSEN350139
125	67	30+2KN	3+3	LH	S14325	CSEN350140

External pre-milling unit

"HIGH-PERFORMANCE" pre-milling cutter

DP

MEC



MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on chipboard and MDF with melamine and its composites, honeycomb wood and veneer.

DESIGN

DP tips.

Axiality 45°.

NOTES

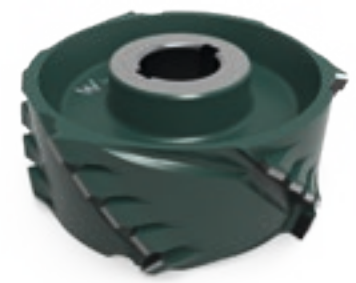
Pre-milling cutter for single-sided edgebanding machines.

Max. rpm: 9,000 /12,000

D (mm)	B (mm)	d (mm)	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
125	33	30+2KN	3+3	RH	S14347	
125	33	30+2KN	3+3	LH	S14348	
125	47	30+2KN	3+3	RH	S14345	
125	47	30+2KN	3+3	LH	S14346	
125	63	30+2KN	3+3	RH	S12216	3401A0457
125	63	30+2KN	3+3	LH	S12217	3401A0458

External pre-milling unit and RT20 / RT30

GLADIO pre-milling cutter



DP

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on chipboard and MDF with melamine and its composites, decorative and cross grain materials.

DESIGN

DP tips.

Multiaxiality.

NOTES

Feed: up to 40 m/min

Max Rpm: 12,000

Min. recommended removal: 1 mm

Max. recommended removal: 5 mm

D (mm)	B (mm)	d (mm)	Z	Rot.	Wirutex Id-No.
125	38	30+2KN	3+3	RH	S16416
125	38	30+2KN	3+3	LH	S16417
125	47	30+2KN	3+3	RH	S17191
125	47	30+2KN	3+3	LH	S17192
125	65	30+2KN	3+3	RH	S15076
125	65	30+2KN	3+3	LH	S15077

D (mm)	B (mm)	d (mm)	Z	Rot.	Wirutex Id-No.
125	38	30+2KN	4+4	RH	S16236
125	38	30+2KN	4+4	LH	S16237
125	47	30+2KN	4+4	RH	S14776
125	47	30+2KN	4+4	LH	S14777
125	65	30+2KN	4+4	RH	S16361
125	65	30+2KN	4+4	LH	S16362

External pre-milling unit and RT20 / RT30

SMART Pit Stop System pre-milling cutter

DP

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on chipboard and MDF with melamine and its composites.

DESIGN

Adjustable cutter set, consisting of 2 independently adjustable cutter elements. Adjustment can be done on site.

DP tips.

35° axiality.

NOTES

Feed: up to 30 m/min

Max. rpm: 12,000

Machinable panel thickness: 10÷50

Min. recommended removal: 1 mm
Max. recommended removal: 2 mm

SMART Pit Stop System leaves the factory equipped with a torque screwdriver.

D (mm)	B (mm)	d (mm)	Z	Rot.	Wirutex Id-No.
125	25÷36	30+2KN	5+5	RH	S15124
125	25÷36	30+2KN	5+5	LH	S16414
125	42÷53	30+2KN	5+5	RH	S17183
125	42÷53	30+2KN	5+5	LH	S17184
125	54÷65	30+2KN	5+5	RH	S17193
125	54÷65	30+2KN	5+5	LH	S17194

OPEN CUTTER	CLOSED CUTTER

Scan the QR Code and watch the video

IT90 End trimming unit

End cutting saw blade

HW

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on supported and plastic edges.

DESIGN

HW tips.

30° inclined tooth.

NOTES

End cutting of glued edges.

Max. rpm: 12,000

Always include the code marked on the tool currently being used or machine serial number.

D (mm)	B (mm)	d (mm)	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
130	3.6	45+4	20+4	RH	D04045	CSEN750029
130	3.6	45+4	20+4	LH	D04046	CSEN750030

IT90 End trimming unit

Negative alternate tooth end cutting saw blade

HW

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on supported and plastic edges.

DESIGN

HW tips.

Negative alternate tooth -20°.

NOTES

End cutting of glued edges.

Max. rpm: 12,000

Always include the code marked on the tool currently being used or machine serial number.

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.
140	3.6	45+4	16+4	D04051	CSEN750037

IT90 End trimming unit

Alternate tooth end cutting saw blade

HW

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on edges in solid wood.

DESIGN

HW tips.

Alternate tooth + smoothing.

NOTES

End cutting of glued edges.

Max. rpm: 12,000

Always include the code marked on the tool currently being used or machine serial number.

D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.
130	3.6	45+4	16+4	D04047	CSEN750031

IT90 End trimming unit

Alternate tooth end cutting saw blade

HW

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on edges in solid wood H. 90.

DESIGN

HW tips.

Alternate tooth.

NOTES

End cutting of glued edges.

Max. rpm: 12,000

Always include the code marked on the tool currently being used or machine serial number.

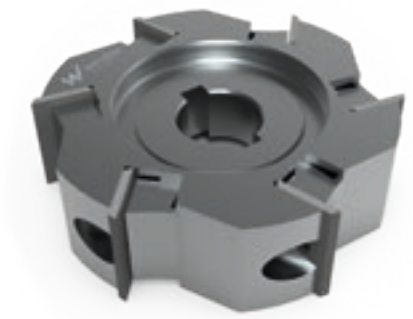
D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.
140	3.6	45+4	16+4	D04052	CSEN750032

RS10 Rough trimming unit

Overlapped trimmer with interchangeable knives

HW

MEC



MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge trimming.

Max. rpm: 12,000

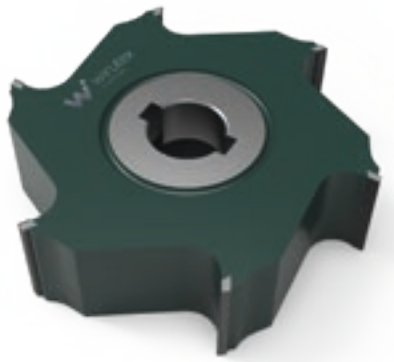
D (mm)	B (mm)	d (mm)	Z	Wirutex Id-No.	BIESSE Id-No.	Spare parts
80	25	16+2KN	6	D02125	N3401N0428	
				D02135	N3402N0127	Knife in HW 25x12x1.5

RS10 Rough trimming unit

Overlapped trimmer

DP

MEC



MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on supported and plastic edges.

DESIGN

DP tips.

NOTES

Edge trimming.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
80	22	16+2KN	6	CW.	S12343	N3401N0363
80	22	16+2KN	6	CCW.	S12344	N3401N0364

RF10 Fine trimming unit

Tilted trimmer with interchangeable knives

HW

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

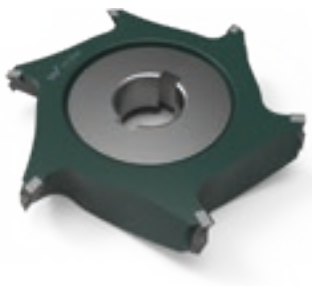
Edge trimming on tilted engines.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Wirutex Id-No.	BIESSE Id-No.	Spare parts
70	20	16+2KN	-	6	D02126	N3401N0430	
					C00403	N3402N0040	Knife in HW 20x12x1.5
75	20	16+2KN	1	6	D02368	N3401N0431	
					D02372	N3402N0123	Knife in HW R=1
75	20	16+2KN	1.5	6	D02369	N3401N0432	
					D02373	N3402N0124	Knife in HW R=1.5
75	20	16+2KN	2	6	D02370	N3401N0433	
					D02374	N3402N0125	Knife in HW R=2
75	20	16+2KN	3	6	D02127	N3401N0434	
					D02134	N3402N0126	Knife in HW R=3

RF10 Fine trimming unit

Tilted trimmer



DP

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on supported and plastic edges.

DESIGN

DP tips.

NOTES

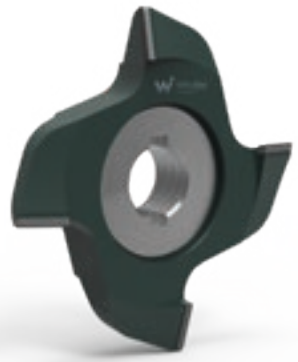
Radiusing and chamfering of edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
70	6.5	16+2KN	1	6	CW.	S12350	N3401N0377
70	6.5	16+2KN	1	6	CCW.	S12351	N3401N0378
70	6.5	16+2KN	1.5	6	CW.	S13052	N3401N0379
70	6.5	16+2KN	1.5	6	CCW.	S13053	N3401N0380
70	6.5	16+2KN	2	6	CW.	S13054	N3401N0381
70	6.5	16+2KN	2	6	CCW.	S13055	N3401N0382
70	6.5	16+2KN	3	6	CW.	S13056	N3401N0383
70	6.5	16+2KN	3	6	CCW.	S13057	N3401N0384
70	8	16+2KN	-	6	-	S09643	N3401N0581
70	8	16+2KN	-	12	-	S13726	CSEN350122
70	20	16+2KN	-	6	-	S08913	N3401N0435

RF12 Fine trimming unit

Fine trimmer



DP

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on aluminium edges.

DESIGN

DP tips.

NOTES

Edge chamfering.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
80	10	16+2KN	15°	4	CW.	S08782	N3401N0436
80	10	16+2KN	15°	4	CCW.	S08783	N3401N0437

RF30/RF40 Fine trimming unit

Tilted fine trimmer/trimmer with mechanical fixing and interchangeable multiprofile knives

HW

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge trimming on tilted engines.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.	Spare parts
75	25	16+2KN	1,5/2/3/25°	4	CW.	D02128	N3401N0391	
						D01540	N3402N0035	Knife in HW 25x19.6x2 R=1.5/2/3
75	25	16+2KN	1,5/2/3/25°	4	CCW.	D02129	N3401N0392	
						D01541	N3402N0036	Knife in HW 25x19.6x2 R=1.5/2/3
75	25	16+2KN	1/2/3/25°	4	CW.	D02378	N3401N0393	
						D01700	N3402N0084	Knife in HW 25x19.6x2 R=1/2/3
75	25	16+2KN	1/2/3/25°	4	CCW.	D02379	N3401N0394	
						D01701	N3402N0085	Knife in HW 25x19.6x2 R=1/2/3
75	25	16+2KN	1/1,5/2/25°	4	CW.	D02380	N3401N0395	
						D01999	N3402N0083	Knife in HW 25x19,6x2 R=1/1,5/2
75	25	16+2KN	1/1,5/2/25°	4	CCW.	D02381	N3401N0396	
						D01998	N3402N0082	Knife in HW 25x19,6x2 R=1/1,5/2
75	25	16+2KN	1/1,5/2/45°	4	CW.	D03820	N3401N0077	
						D03821	N3402N0172	Knife in HW 25x19.6x2 R=1/1.5/2
75	25	16+2KN	1/1,5/2/45°	4	CCW.	D03822	N3401N0078	
						D03823	N3402N0173	Knife in HW 25x19.6x2 R=1/1.5/2

RF30/RF40 Fine trimming unit

Tilted multiradius fine trimmer/trimmer

DP

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on ABS edges.

DESIGN

DP tips.

NOTES

Edge trimming on tilted engines.

Max. rpm: 18,000

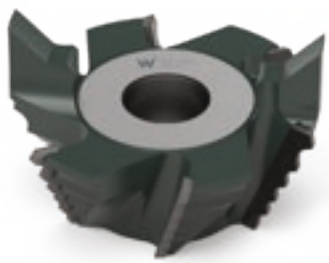
D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
75.4	25	16+2KN	1/2/3/25°	6	CW.	S10540	N3401N0397
75.4	25	16+2KN	1/2/3/25°	6	CCW.	S10541	N3401N0398
75.4	25	16+2KN	1.5/2/3/25°	6	CW.	S09784	N3401N0399
75.4	25	16+2KN	1.5/2/3/25°	6	CCW.	S09785	N3401N0400
75.4	25	16+2KN	1/1.5/2/25°	6	CW.	S09760	N3401N0401
75.4	25	16+2KN	1/1.5/2/25°	6	CCW.	S09761	N3401N0402

RF50 Fine trimming unit

Tilted multiradius fine trimmer/trimmer

DP

MEC



MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on ABS edges.

DESIGN

DP tips.

NOTES

Edge trimming on tilted engines.

Max. rpm: 18,000

D (mm)	B (mm)	Connection	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
68.8	26	HSK25R	0.5/1/1.5/2/3	6	CW.	S14210	AS50100033
68.8	26	HSK25R	0.5/1/1.5/2/3	6	CCW.	S14211	AS50100032

RF30/RF40 Fine trimming unit

Tilted trimmer with interchangeable knives

HW

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on edges
in solid wood, supported and plastic edges.

DESIGN

Cutter with mechanical fixing
and interchangeable knives in HW.

NOTES

Edge trimming on tilted engines.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.	Spare parts
72	35	16+2KN	1/1.5	4	CW.	D02843	N3401N0564	
						D02844	N3402N0159	Knife in HW R=1/1.5
72	35	16+2KN	1/1.5	4	CCW.	D02845	N3401N0565	
						D02846	N3402N0160	Knife in HW R=1/1.5
72	35	16+2KN	1/2	4	CW.	D02847	N3401N0566	
						D02848	N3402N0161	Knife in HW R=1/2
72	35	16+2KN	1/2	4	CCW.	D02849	N3401N0567	
						D02850	N3402N0162	Knife in HW R=1/2
72	35	16+2KN	1.5/2	4	CW.	D02851	N3401N0568	
						D02852	N3402N0163	Knife in HW R=1.5/2
72	35	16+2KN	1.5/2	4	CCW.	D02853	N3401N0569	
						D02854	N3402N0164	Knife in HW R=1.5/2
72	35	16+2KN	1.5/3	4	CW.	D02855	N3401N0570	
						D02856	N3402N0165	Knife in HW R=1.5/3
72	35	16+2KN	1.5/3	4	CCW.	D02857	N3401N0571	
						D02858	N3402N0166	Knife in HW R=1.5/3
72	35	16+2KN	2/3	4	CW.	D02859	N3401N0572	
						D02860	N3402N0167	Knife in HW R=2/3
72	35	16+2KN	2/3	4	CCW.	D02861	N3401N0573	
						D02862	N3402N0168	Knife in HW R=2/3

AR30/AR34 Corner rounding unit

Rounding cutter with mechanical fixing and interchangeable knives

HW

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on supported and plastic edges.

DESIGN

Cutter with mechanical fixing and interchangeable knives in HW.

NOTES

Edge radiusing.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.	Spare parts
60/70	16	16+2KN	1	4	CW.	D03255	3401A0355	
60/70	16	16+2KN	1	4	CCW.	D03256	3401A0356	
						D03257	3402A0087	Knife in HW 16x17x2 R=1
60/70	16	16+2KN	1.5	4	CW.	D03252	3401A0353	
60/70	16	16+2KN	1.5	4	CCW.	D03253	3401A0354	
						D03254	3402A0086	Knife in HW 16x17x2 R=1.5
60/70	16	16+2KN	2	4	CW.	D03246	3401A0349	
60/70	16	16+2KN	2	4	CCW.	D03247	3401A0350	
						D03248	3402A0084	Knife in HW 16x17x2 R=2
60/70	16	16+2KN	3	4	CW.	D03249	3401A0351	
60/70	16	16+2KN	3	4	CCW.	D03250	3401A0352	
						D03251	3402A0085	Knife in HW 16x17x2 R=3

AR30/AR34 Corner rounding unit

Rounding cutter

new

HW

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on supported and plastic edges.

DESIGN

Braze-welded tips in HW.

NOTES

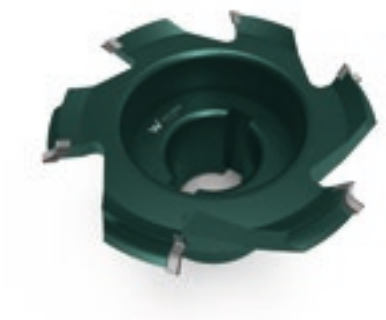
Radiusing and chamfering of edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
60/70	9	16+2KN	1.2	4	CW.	S17567	CCEN350223
60/70	9	16+2KN	1.2	4	CCW.	S17568	CCEN350224
60/70	9	16+2KN	1.7	4	CW.	S17565	CCEN350221
60/70	9	16+2KN	1.7	4	CCW.	S17566	CCEN350222
60/70	9	16+2KN	2.2	4	CW.	S17561	CCEN350217
60/70	9	16+2KN	2.2	4	CCW.	S17562	CCEN350218
60/70	9	16+2KN	3.2	4	CW.	S17563	CCEN350219
60/70	9	16+2KN	3.2	4	CCW.	S17564	CCEN350220

AR30/AR34 Corner rounding unit

Rounding cutter



HW

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on supported and plastic edges.

DESIGN

Braze-welded tips in HW.

NOTES

Radiusing and chamfering of edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
60/68	9	16+2KN	1	6	CW.	D01578	N3401N0112
60/68	9	16+2KN	1	6	CCW.	D01579	N3401N0113
60/68	9	16+2KN	1.5	6	CW.	D01529	N3401N0107
60/68	9	16+2KN	1.5	6	CCW.	D01580	N3401N0108
60/68	9	16+2KN	2	6	CW.	D01482	N3401N0105
60/68	9	16+2KN	2	6	CCW.	D01483	N3401N0106
60/68	9	16+2KN	3	6	CW.	D01527	N3401N0103
60/68	9	16+2KN	3	6	CCW.	D01528	N3401N0104
60/68	9	16+2KN	25°	6	CW.	D01522	N3401N0101
60/68	9	16+2KN	25°	6	CCW.	D01523	N3401N0102
60/68	9	16+2KN	45°	6	CW.	D01251	N3401N0161
60/68	9	16+2KN	45°	6	CCW.	D01252	N3401N0162

DP

DESIGN

DP tips.

NOTES

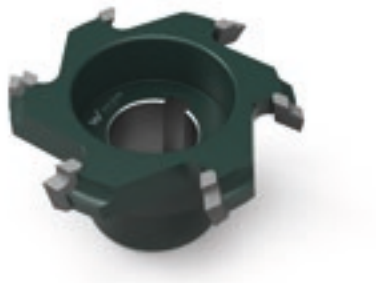
Radiusing and chamfering of edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
60	11	16+2KN	1	6	CW.	S14451	N3401N0110
60	11	16+2KN	1	6	CCW.	S14450	N3401N0111
60	11	16+2KN	1.5	6	CW.	S13811	N3401N0095
60	11	16+2KN	1.5	6	CCW.	S13810	N3401N0096
60	11	16+2KN	2	6	CW.	S14234	N3401N0093
60	11	16+2KN	2	6	CCW.	S14233	N3401N0094
60	11	16+2KN	3	6	CW.	S14453	N3401N0091
60	11	16+2KN	3	6	CCW.	S14452	N3401N0092
58.8/67	9	16+2KN	25°	6	CW.	S06800	N3401N0089
58.8/67	9	16+2KN	25°	6	CCW.	S06801	N3401N0090
59.3/68	4.5	16+2KN	45°	6	CW.	S14143	N3401N0457
59.3/68	4.5	16+2KN	45°	6	CCW.	S14144	N3401N0458

AR80 Corner rounding unit

Rounding cutter



HW

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on supported and plastic edges.

DESIGN

Braze-welded tips in HW.

NOTES

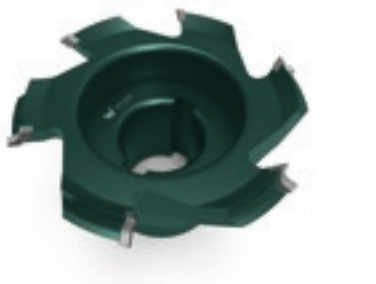
Radiusing and chamfering of edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
60	9	20+2KN	3	6	CW.	D01474	N3401N0232
60	9	20+2KN	3	6	CCW.	D01475	N3401N0233
60	9	20+2KN	2	6	CW.	D01530	N3401N0280
60	9	20+2KN	2	6	CCW.	D01531	N3401N0281
60	9	20+2KN	1.5	6	CW.	D01476	N3401N0282
60	9	20+2KN	1.5	6	CCW.	D01477	N3401N0283
60	9	20+2KN	1	6	CW.	D01532	N3401N0284
60	9	20+2KN	1	6	CCW.	D01533	N3401N0285
60	9	20+2KN	25°	6	CW.	D01478	N3401N0286
60	9	20+2KN	25°	6	CCW.	D01479	N3401N0287
60	9	20+2KN	45°	6	CW.	D01967	N3401N0319
60	9	20+2KN	45°	6	CCW.	D01968	N3401N0320

AR80 Corner rounding unit

Rounding cutter



DP

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on supported and plastic edges.

DESIGN

DP tips.

NOTES

Radiusing and chamfering of edges.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	R	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
60	9	20+2KN	3	6	CW.	S13873	N3401N0288
60	9	20+2KN	3	6	CCW.	S13872	N3401N0289
60	9	20+2KN	2	6	CW.	S13875	N3401N0290
60	9	20+2KN	2	6	CCW.	S13874	N3401N0291
60	9	20+2KN	1.5	6	CW.	S14242	N3401N0292
60	9	20+2KN	1.5	6	CCW.	S14241	N3401N0293
60	9	20+2KN	1	6	CW.	S14104	N3401N0294
60	9	20+2KN	1	6	CCW.	S14103	N3401N0295
60	9	20+2KN	25°	6	CW.	S13877	N3401N0296
60	9	20+2KN	25°	6	CCW.	S13876	N3401N0297
60	9	20+2KN	45°	6	CW.	S14244	N3401N0321
60	9	20+2KN	45°	6	CCW.	S14243	N3401N0322

SF10 Soft unit

Cutter for IN-LAY machining operations

DP

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on various types of surface.

DESIGN

DP tips.

NOTES

IN-LAY processing on SOFT-FORMING edgebanding.

Max. rpm: 12,000

D (mm)	B (mm)	d (mm)	Z	Rot.	Wirutex Id-No.	BIESSE Id-No.
80	20	16+2KN	8+2	CW.	S07122	N3401N0421
80	20	16+2KN	8+2	CCW.	S07123	N3401N0422

RBK-503 Edge scraper unit

Edge scraper

HWM

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on ABS edges.

DESIGN

Rounding insert in HWM.

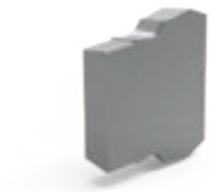
NOTES

For edge finishing.

Features / Dimensions	Wirutex Id-No.	BIESSE Id-No.
R=1	D02329	N3402N0056
R=1.5	D01536	N3402N0055
R=2	D01535	N3402N0054
R=3	D01553	N3402N0053
25°	D01548	N3402N0097

RB02 Edge scraper unit

Edge scraper with anti-bleaching profile



HWM

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on ABS edges.

DESIGN

Insert in HWM with anti-bleaching profile.

NOTES

For edge finishing.

Features / Dimensions	Wirutex Id-No.	BIESSE Id-No.
25°	D03413	3402A0083
R=1	D03607	3402A0124
R=1.5	D03608	3402A0125
R=2	D03609	3402A0126
R=3	D03222	3402A0082

RB30/RB40 Edge scraper unit

Multiradius edge scraper

HWM

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on ABS edges.

DESIGN

Insert in HWM.

NOTES

For edge finishing.

Features / Dimensions	Wirutex Id-No.	BIESSE Id-No.
R=1/1.5/2	D03545	3402A0116
R=1.5/2/3	D03556	3402A0117
R=1/2/3	D03557	3402A0118

RB50 Edge scraper unit

Multiradius edge scraper tool

DP

MEC

MACHINES / APPLICATIONS

STREAM B MDS.
Machining operations on ABS edges.

DESIGN

Multiradius edge scraper tool in DP.

NOTES

For edge finishing.

Features / Dimensions	Shank (mm)	Wirutex Id-No.	BIESSE Id-No.
R=1/1.5/2/3/45° LOWER	20x45	S14298	CSEN750039
R=1/1.5/2/3/45° UPPER	20x45	S14299	CSEN750040

RC10/SF Glue scraper unit

Glue scraper

HW

MEC

MACHINES / APPLICATIONS

STREAM B MDS.
VERSIONS UP UNTIL MAY 2017.

Machining operations on supported and plastic edges.

DESIGN

Insert in HW.

NOTES

Removal of glue residues from the edge.

Features / Dimensions	Wirutex Id-No.	BIESSE Id-No.
16x16x4.7	D02489	N3402N0057

RC05/SF Glue scraper unit

Glue scraper

HSS

MEC

MACHINES / APPLICATIONS

STREAM B MDS.
VERSIONS UP UNTIL MAY 2017.

Machining operations on supported and plastic edges.

DESIGN

Insert in HSS.

NOTES

Removal of glue residues from the edge.

Features / Dimensions	Wirutex Id-No.	BIESSE Id-No.
40x25x3 upper LH	D01556	N3402N0075
40x25x3 upper RH	D01557	N3402N0076

RC20/RC20 SOFT/RC40 Glue scraper unit

Glue scraper

HW

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on supported and plastic edges.

DESIGN

Triangular insert with 3 cutting edges in HW.

NOTES

Removal of glue residues from the edge.

Features / Dimensions	Z	Wirutex Id-No.	BIESSE Id-No.
22.86x2.5	3	C00626	E3401E0117

RL10 Soft unit

Glue scraper

HSS

MEC

MACHINES / APPLICATIONS

STREAM B MDS.

Machining operations on supported and plastic edges.

DESIGN

Insert in HSS.

NOTES

Removal of glue residues from the edge on IN-LAY processing.

Features / Dimensions	Wirutex Id-No.	BIESSE Id-No.
21x15x2.5 UPPER LH /LOWER RH	D02357	N3402N0037
21x15x2.5 LOWER LH /UPPER RH	D02358	N3402N0038

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JADE 300

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062024

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