TOOLS FOR WINDOW, DOOR JOINERY & FACADES

edition 2025

PROFESSIONAL TOOLS

PRODUCTION | SALES | SERVICE

ITA TOOLS

ITA TOOLS
Company details

ITA TOOLS Company is a Polish manufacturer of professional cutting tools located in Cracow with production and service center in Mielec, Special Industrial Zone and warehouse in Wieliczka. We offer a wide range of tools for woodworking industry, furniture production and processing composite materials.

PRODUCTS

Product range includes:

- Solid carbide spiral bits
- PCD router bits and cutters
- Industrial drills
- Saw blades
- Cutter heads and pre milling cutter heads
- Interchangeable and planer knives
- CNC chuck and accessories
- Other customized tools

WAREHOUSE

Why better than other?

- Industrial tool available on stock!
- B2B system for orders collection 24/7h
- Fast delivery thanks to location in the middle of Europe
- Customized production
- Experienced staff ready to meet your specific needs

PRODUCTION & SERVICE CENTER

Full range of tools' services!

- Sharpening, regeneration, coating
- Modern CNC machine park witch machines from: WALTER®, VOLLMER®, ANCA®, DMG MORI®, HAIMER®
- Certified staff works 24/7 in 3 shifts, 7 days a week
- Perfect service at the highest level appreciated by customers

Scan the QR code and see the newest video presentations about our company!

YouTube

Tool service 24/7

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MADE IN POLAND

EU

Availability & Quality

Worldwide Export

Experience & Knowledge

Innovation: Laser Ablation

PRODUCTION AND SERVICE

PCD and HM Tools

ITA TOOLS company is the supplier of professional industrial cutting tools and solutions for business. Our production center is one of the biggest and most modern machinery parks in Central Europe. Our products are distinguished by high tolerance and best precision. We are proud of our production center and tools, therefore we invite you for an individual visit or live video presentation.

Our company is a pioneer in the technology of PCD sharpening by laser ablation method. Laser ablation works by focusing a laser onto a substrate to remove material that is on its surface. Laser ablation is much more efficient, reliable and cost-effective method.

WE TAKE CARE OF YOUR TOOLS

We work 24h, 3 shifts – 7 days per week for you!

- Each tool is registered in a database on each step of the service
- Ultrasonic cleaning or micro glass grain sandblasting depending on the tool and dirt provide the best quality
- Measurements before and after services on WALTER® ADVANCE, WALTER® HELISET and ZOLLER®
- Measurements after sharpening with an accuracy of 0.01 mm – indicating diameter before and after sharpening.
- Top quality of induction brazing by CEIA® machines
- Sharpening PCD technology provided by modern CNC machines DMG MORI®, WALTER® and VOLLMER®
- High grinding quality thanks to WALTER® machines
- Dynamic balancing with a tolerance of G2.5 thanks to HAIMER® machines

Laser ablation sharpening technology provided by DMG MORI®, unique on European scale.

ITA TOOLS is a braze-welding procedure certified.
Testing standard: **PN-EN ISO 13585:2012**

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15 000 m²

Production centre in Mielec, Poland: brand new facility of tools' manufacturing and sharpening service center.

Brand new and advanced CNC machines from DMG MORI®, Walter®, Vollmer® and ANCA® in combination with professional team of operators and engineers create the NEW quality level of products and services.

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B2B SALES SYSTEM

Cooperation at the highest level

PERMANENT ACCESS TO THE SYSTEM 24/7

Unlimited access to the company ITA TOOLS

ACCESS TO INVOICES AND PAYMENTS

Download invoices directly from your account.

INTUITIVE PROCESS OF PRODUCT ORDERING

Simple way for placing orders independently.

SIMPLE PRODUCT SEARCHING SYSTEM

Wide range of filters enabling the selection of appropriate tools.

INTUITIVE AND USER FRIENDLY SYSTEM

System is based on the most common customer requirements and is constantly being developed.

SCAN THE CODE
AND FILL OUT THE FORM

Further information about the B2B sales system can be found here:

www.b2b-itatools.pl

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SEARCH PRODUCT BY THE TYPE OF MACHINE

Filters enabling the selection of both tools for machines as well as blades for power tools.

ORDER STATUS MONITORING

The ability to check order status on your own.

ACCESS TO THE ORDER HISTORY AND INVOICES

Full history track of your offers, orders, invoices in one place.

ACCESS TO STOCK

Access to actual product stock 24/7.

ACCESS TO ACTUAL PROMOTIONS

Instant information about all current promotions for B2B users.

Database of dedicated tools for Beam Saws and Edgebanders.

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Chapter 1

Tools for production of window and door joinery PVC, ALU & Wood

Circular Saw Blades HM
PVC and Aluminum Profiles

9

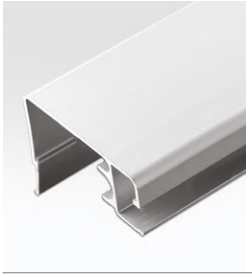
Circular Saw Blades HM
Wood, Wood Derivatives and Laminates

11

Solid Carbide Router Bits Z1
Aluminum, Plastics

12

Solid Carbide Router Bits Z2
Aluminum, Plastics



15

Solid Carbide Router Bits Z3 – Special
PVC Profiles

17

Solid Carbide Spiral Bits Z3 & Z3 with Chipbreaker
Wood, Wood Derivatives and Laminates

19

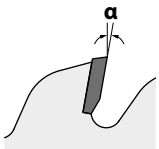
HSS Drill Bits
Handles in PVC Profiles

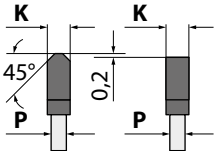
20

HM Drill Bits
Wood, Wood Derivatives and Laminates

21

PA1





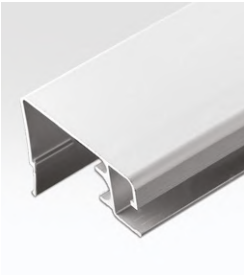
FZ/TR

Technical details:

Circular saw blade with triple chip flat grinded carbide teeth (HW). With negative hook angle and reinforced body for higher resistance to side hits and reduce vibrations. Suited for cutting from above. Blades are silenced.

Application:

Circular saw blade for cutting of non-ferrous profiles, plastic profiles (ex. PVC), etc., with wall thickness up to 7 mm.
The material must always be well clamped to avoid vibration. Narrow toothed saw blades for sawing thin walled non-ferrous and plastic profiles.



Machines:

For double cross cutting machines, CNC machines, mitre cutting machines, etc. Negative hook angle suited for cutting above.

Materials:

For cutting of non-ferrous profiles, plastic profiles (ex. PVC), etc., with wall thickness till 7 mm

HM saw blades for processing non-ferrous & PVC profiles - with a positive rake angle 5°

D mm	F mm	PH	Z	K mm	P mm	α	ARTICLE
300	30	PH03	96	3,2	2,6	5°	PA1.300030096.P00
330	30	PH03	102	3,6	3,0	5°	PA1.330030102.P00

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D mm	F mm	PH	Z	K mm	P mm	α	ARTICLE
350	30	PH03	108	3,6	3,0	5°	PA1.350030108.P00
350	32	2/11/63	108	3,6	3,0	5°	PA1.350032108.P00
400	30	PH03	120	4,0	3,2	5°	PA1.400030120.P00
400	32	2/11/63	120	4,0	3,2	5°	PA1.400032120.P00
450	30	PH03	128	4,0	3,2	5°	PA1.450030128.P00
450	32	2/11/63	128	4,0	3,2	5°	PA1.450032128.P00
500	30	2/10,5/70	140	4,2	3,4	5°	PA1.500030140.P00
550	32	2/11/63	140	4,2	3,4	5°	PA1.500032140.P00
550	30	2/10,5/70	140	4,2	3,4	5°	PA1.550030140.P00
550	30	2/10,5/70	168	4,2	3,4	5°	PA1.550030168.P00
550	32	2/11/63	140	4,2	3,4	5°	PA1.550032140.P00
600	32	2/11/63	144	4,6	4,0	5°	PA1.600032144.P00
600	40	2/11/63	140	4,6	4,0	5°	PA1.600040140.P00

HM saw blades for processing non-ferrous & PVC profiles – with a negatve rake angle -5°

D mm	F mm	PH	Z	K mm	P mm	α	ARTICLE
300	30	PH03	96	3,2	2,6	-5°	PA1.300030096.N00
330	30	PH03	102	3,6	3,0	-5°	PA1.330030102.N00
350	30	PH03	108	3,6	3,0	-5°	PA1.350030108.N00
350	32	4/11/63	108	3,6	3,0	-5°	PA1.350032108.N00
400	30	PH03	120	4,0	3,2	-5°	PA1.400030120.N00
400	32	2/11/63	120	4,0	3,2	-5°	PA1.400032120.N00
450	30	PH03	128	4,0	3,2	-5°	PA1.450030128.N00
450	32	2/11/63	128	4,0	3,2	-5°	PA1.450032128.N00
500	30	2/10,5/70	140	4,2	3,4	-5°	PA1.500030140.N00
500	32	2/11/63	140	4,2	3,4	-5°	PA1.500032140.N00

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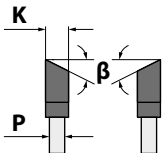
P01
cross-cutting



WZ

Application:

For cross-cutting while maintaining optimum material quality.
The saws have laser cutting silencing to improve the comfort of work.

Machines:

Table saws and mitre saws.

Materials:

Soft, hard and exotic wood, plywood.

D mm	F mm	PH	Z	K mm	P mm	ARTICLE
250	30	PH03	48	3,2	2,2	P01.250030048.00W
250	30	PH03	60	3,2	2,2	P01.250030060.00W
250	30	PH03	80	3,2	2,2	P01.250030080.00W
300	30	PH03	48	3,2	2,2	P01.300030048.00W
300	30	PH03	72	3,2	2,2	P01.300030072.00W
300	30	PH03	96	3,2	2,2	P01.300030096.00W
315	30	PH03	72	3,2	2,2	P01.315030072.00W
350	30	PH03	54	3,5	2,5	P01.350030054.00W
350	30	PH03	84	3,5	2,5	P01.350030084.00W
350	30	PH03	108	3,5	2,5	P01.350030108.00W
400	30	PH03	60	3,5	2,5	P01.400030060.00W
450	30	PH03	66	3,8	2,8	P01.450030066.00W
500	30	PH03	72	4,0	2,8	P01.500030072.00W

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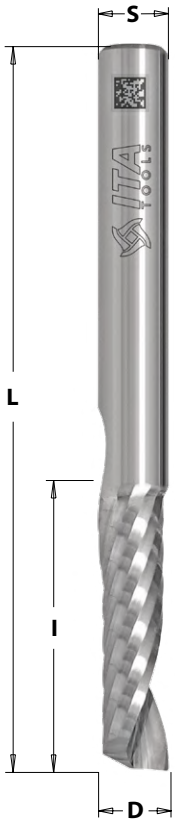
SP01
positive



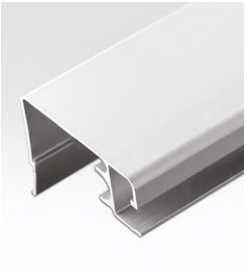
VHM | Z1 | RH

Technical details:

- Single blade cutter, positive,
- Perfect finishing of cutting edge – the polished chip groove and blade
- Chip discharge upward
- Special type of carbide – increased tool life
- Possibility of using variety coatings
- Cutting, grooving
- Spiral angle 30°

Application:

For cutting and milling in aluminum, PVC profiles, DIBOND® composites, an alternative to plastics processing. Designed for use on CNC machines.



ALUMINUM
Work parameters:

- **RPM 16 000-24 000**
- **feed 0,8-2 m/min**

PLASTICS, COMPOSITE BOARDS
Work parameters:

- **RPM 16 000-24 000**
- **feed 2-6 m/min**

D mm	I mm	L mm	S mm	Z	ARTICLE
3	6	60	6	1	SP01.03.006.060.06R
3	12	60	6	1	SP01.03.012.060.06R
4	8	60	6	1	SP01.04.008.060.06R
4	12	60	6	1	SP01.04.012.060.06R
5	15	60	6	1	SP01.05.015.060.06R
6	12	60	6	1	SP01.06.012.060.06R
6	22	60	6	1	SP01.06.022.060.06R
8	12	60	8	1	SP01.08.012.060.08R
8	22	60	8	1	SP01.08.022.060.08R
10	15	60	10	1	SP01.10.015.060.10R
10	35	80	10	1	SP01.10.035.080.10R

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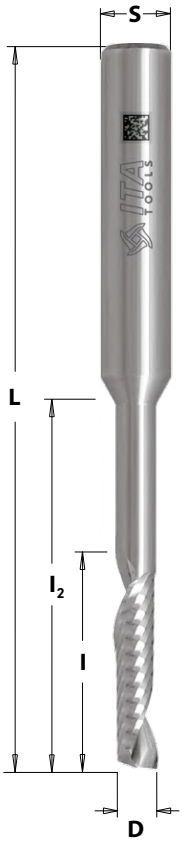
SP02
positive



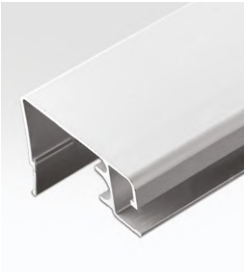
VHM | Z1 | RH

Technical details:

- Single blade cutter, positive with lowering
- Perfect finishing of cutting edge – the polished chip groove
- Chip discharge upward
- Special type of carbide – increased tool life
- Possibility of using variety coatings
- Cutting, grooving
- Spiral angle 30°

Application:

For cutting and milling in aluminum, PVC profiles. Designed for use on CNC machines.



ALUMINUM
Work parameters:

- **RPM 10 000-18 000**
- **feed 0,8-2 m/min**

PLASTICS
Work parameters:

- **RPM 12 000-20 000**
- **feed 2-6 m/min**

D mm	l mm	l_2 mm	L mm	S mm	Z	ARTICLE
3	16	40	80	8	1	SP02.03.016.080.08R
4	16	40	80	8	1	SP02.04.016.080.08R
5	20	40	80	8	1	SP02.05.020.080.08R
6	22	40	80	8	1	SP02.06.022.080.08R
8	25	45	100	8	1	SP02.08.025.100.08R
10	20	40	80	10	1	SP02.10.020.080.10R
10	15	60	100	10	1	SP02.10.015.100.10R
10	22	80	120	10	1	SP02.10.022.120.10R

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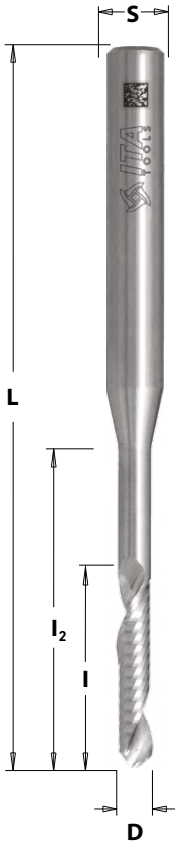
SP15
positive



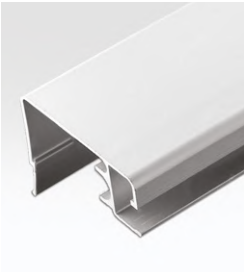
ALUMINUM
Work parameters:
- **RPM 16 000-24 000**
- **feed 0,8-2 m/min**

PLASTICS
Work parameters:
- **RPM 16 000-24 000**
- **feed 2-6 m/min**

VHM **Z1** **RH**

Technical details:
- Single blade cutter, positive with lowering, withdrilling V-point 90°
- Perfect finishing of cutting edge – the polished chip groove and blade
- Chip discharge upward
- Special type of carbide – increased tool life
- Possibility of using variety coatings
- Cutting, grooving
- Spiral angle 30°

Application:
For cutting and milling in aluminum, PVC profiles.
Designed for use on CNC machines.



D mm	l mm	l_2 mm	L mm	S mm	Z	ARTICLE
5	25	35	80	8	1	SP15.05.025.080.08R
5	25	45	100	8	1	SP15.05.025.100.08R
5	35	55	100	8	1	SP15.05.035.100.08R
6	25	45	80	8	1	SP15.06.025.080.08R

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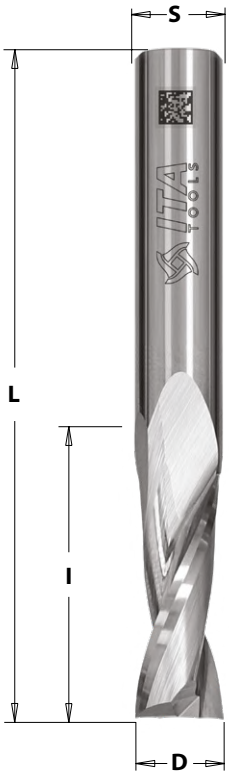
SQ01
positive



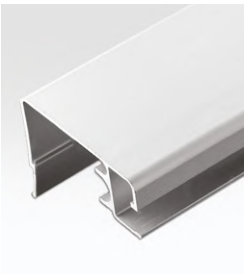
VHM | Z2 | RH

Technical details:

- Two edge blade cutter, positive,
- Prefect finishing of cutting edge – the polished chip groove and blade
- Chip discharge upward
- Special type of carbide – increased tool life
- Possibility of using variety coatings
- Cutting, grooving
- Spiral angle 30°

Application:

For cutting and milling in aluminum and plastics.
Designed for use on CNC machines.



ALUMINUM
Work parameters:

- **RPM 16 000-24 000**
- **feed 0,8-2 m/min**

PLASTICS
Work parameters:

- **RPM 16 000-24 000**
- **feed 2-6 m/min**

D mm	I mm	L mm	S mm	Z	ARTICLE
3	12	60	6	2	SQ01.03.012.060.06R
4	12	60	6	2	SQ01.04.012.060.06R
5	22	60	6	2	SQ01.05.022.060.06R
6	12	60	6	2	SQ01.06.012.060.06R
6	22	60	6	2	SQ01.06.022.060.06R
8	22	60	8	2	SQ01.08.022.060.08R
8	35	80	8	2	SQ01.08.035.080.08R
10	22	60	10	2	SQ01.10.022.060.10R
10	45	100	10	2	SQ01.10.045.100.10R
12	25	70	12	2	SQ01.12.025.070.12R
16	55	110	16	2	SQ01.16.055.110.16R

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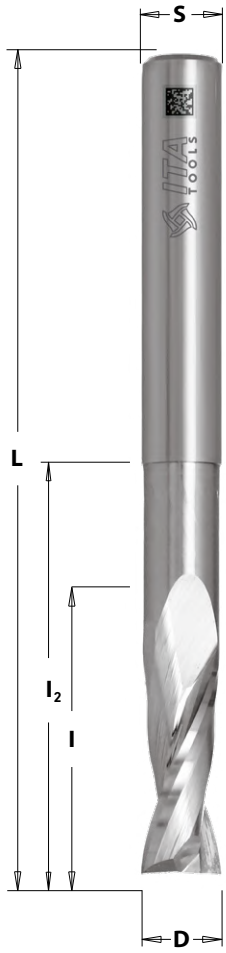
SQ02
positive



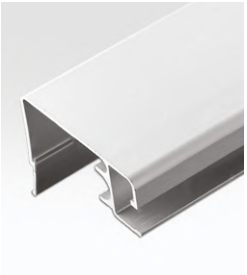
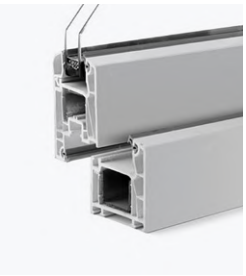
VHM | Z2 | RH

Technical details:

- Two edge blade cutter, positive with lowering
- Prefect finishing of cutting edge – the polished chip groove and blade
- Chip discharge upward
- Special type of carbide – increased tool life
- Possibility of using variety coatings
- Cutting, grooving
- Spiral angle 30°

Application:

For cutting and milling in aluminum and plastics.
Designed for use on CNC machines.

D mm	l mm	l_2 mm	L mm	S mm	Z	SYMBOL
6	22	45	80	6	2	SQ02.06.022.080.06R
7	22	42	100	8	2	SQ02.07.022.100.08R
8	20	45	80	8	2	SQ02.08.020.080.08R
8	22	65	105	8	2	SQ02.08.022.105.08R
10	25	50	90	10	2	SQ02.10.025.090.10R
10	25	50	100	10	2	SQ02.10.025.100.10R
10	25	80	120	10	2	SQ02.10.025.120.10R
11	15	65	110	12	2	SQ02.11.015.110.12R
12	25	65	105	12	2	SQ02.12.025.105.12R
12	25	85	120	12	2	SQ02.12.025.120.12R

ALUMINUM
Work parameters:

- **RPM 10 000-18 000**
- **feed 0,8-2 m/min**

PLASTICS
Work parameters:

- **RPM 16 000-24 000**
- **feed 2-6 m/min**

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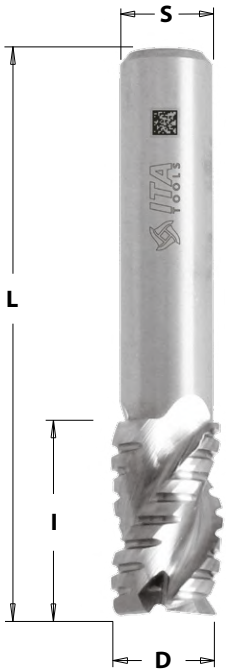
SW03
positive



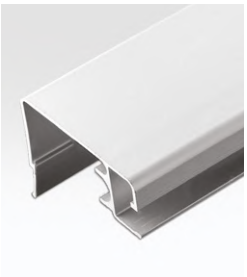
VHM | Z3 | RH LH

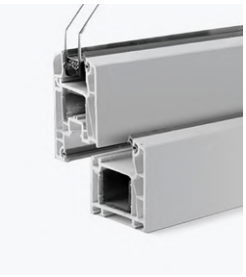
Technical details:

- Three flute router bit with chip breaker
- Right and left rotating cutter
- Polished chip flute prevents material sticking
- Upward chip ejection
- Special type of carbide with increased tool life
- Coating possible

Application:

For milling cross-sections of PVC profiles in machines for shaped, flashless joining of profiles. Designed for use on GRAF SYNERGY® machines V-perfect technology.





D mm	I mm	L mm	S mm	Z	ARTICLE
6	10	30	5	3	SW03.06.010.030.05R
6	10	30	5	3	SW03.06.010.030.05L

HC Coating

D mm	I mm	L mm	S mm	Z	ARTICLE
6	10	30	5	3	SW03.06.010.030.05HR
6	10	30	5	3	SW03.06.010.030.05HL

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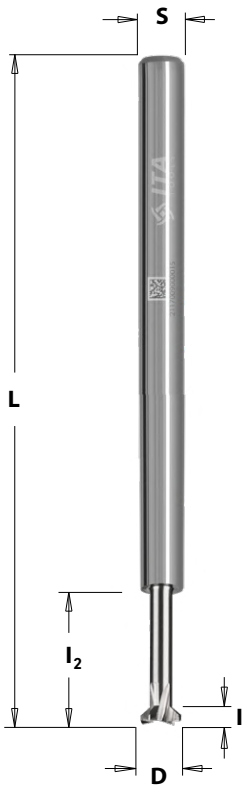
FVH.Rc
T-slot



VHM | Z3 | RH

Technical details:

- Tree flute router bit with T-slots
- Polished chip flute and blade
- Special type of carbide with increased tool life

Application:

For inside corner cleaning, for machining aluminium and PVC profiles.

Work parameters:

- **RPM 8 000-18 000**
- **feed 2-12 m/min**

D mm	l mm	l_2 mm	L mm	S mm	Z	ARTICLE
8	1,5	20	100	8	3	FVH.08.001.100.08Rc1
8	1,5	20	100	8	3	FVH.08.001.100.08Rc2

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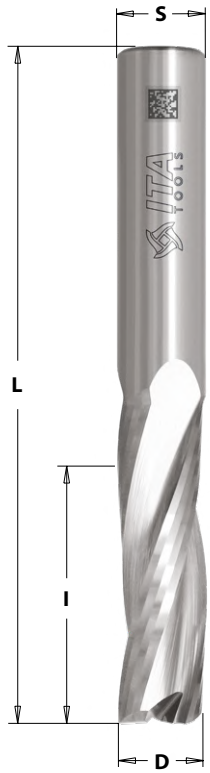
SC01
positive



VHM | Z3 | RH

Technical details:

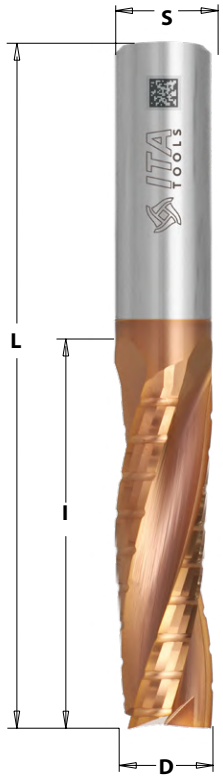
- 3 spiral cutting edges
- Upward chip ejection
- Right-hand / Left-hand rotation
- Premium quality solid carbide
- Excellent finish

Application:

For cutting and milling in solid wood and wood-based materials.
Can be used on machining centres, point to point machines, CNC routers.

D mm	I mm	L mm	S mm	Z	ARTICLE RH
10	42	90	10	3	SC01.10.042.090.10R
12	42	90	12	3	SC01.12.042.090.12R
16	35	90	16	3	SC01.16.035.090.16R
16	55	110	16	3	SC01.16.055.110.16R
20	60	120	20	3	SC01.20.060.120.20R

SC23
positive



VHM | Z3R | RH

Technical details:

- 3 spiral cutting edges
- Upward chip ejection
- Premium quality solid carbide
- Excellent finish with TiSiN coating

Application:

For cutting and milling in solid wood, chipboard , plywood and hard materials. Can be used on machining centres,point to point machines, CNC routers.

D mm	I mm	L mm	S mm	ARTICLE RH
8	22	60	8	SC23.08.022.060.08TR
10	25	70	10	SC23.10.025.070.10TR
12	35	80	12	SC23.12.035.080.12TR
16	55	110	16	SC23.16.055.110.16TR
20	60	120	20	SC23.20.060.120.20TR

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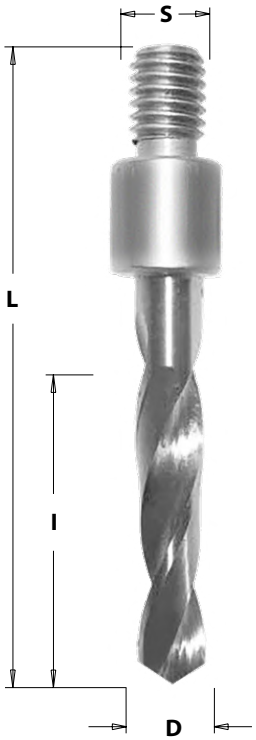
On order



HSS **RH** **LH**

Technical details:

- Right or left rotating drill bits with external thread
- Available with pilot drill bit – reduces the cutting resistance, and makes it possible to achieve a better quality of the processed surface

Application:

For drilling holes for handles in PVC profiles. Drilling in aluminum profiles with or without steel reinforcement installed.

D mm	l mm	L mm	S mm	LH / RH	INFO
10	50	87	M10	LH	
10	50	87	M10	RH	
10	50	87	M10	LH	Pilot drill bit
10	50	87	M10	RH	Pilot drill bit
12	50	87	M10	RH	
12	50	87	M10	LH	
12	50	87	M10	LH	Pilot drill bit
12	50	87	M10	RH	Pilot drill bit
10	65	115	M10	LH	
10	65	115	M10	RH	
12	65	115	M10	RH	
12	65	115	M10	LH	

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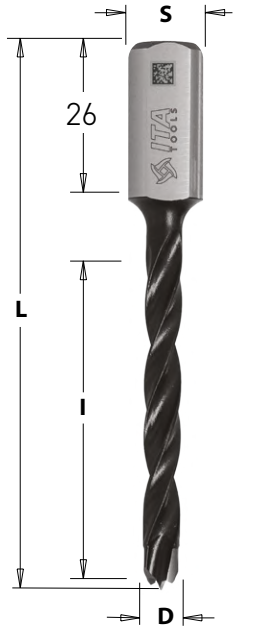
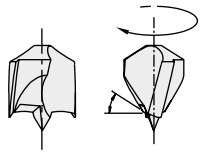
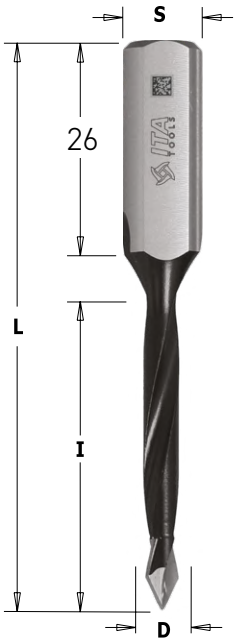
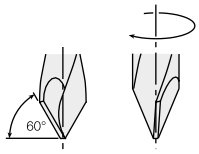
BBH4 | TBH1 | TBH2









HM **Z2** **V2** **RH** **LH**

Technical details:

- Super-strength steel
- Cutter portion coated with black or orange P.T.F.E.
- HW head with precision balanced centre point
- 2 HW precision ground cutting edges [Z2]
- Negatively ground spurs [V2]
- 4 spiral flutes
- Parallel shank with driving flat and length adjusting screw

Application:

Used on boring machines equipped with adapters or chucks.
Used to drill blind holes (BBH4) and trough holes (TBH1, TBH2) in solid wood, wood composites, plastic and laminated materials.

BBH4

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
5	43	70	10x20	BBH4.050.043.070.00R	BBH4.050.043.070.00L
8	43	70	10x20	BBH4.080.043.070.00R	BBH4.080.043.070.00L
10	43	70	10x20	BBH4.100.043.070.00R	BBH4.100.043.070.00L
12	43	70	10x20	BBH4.120.043.070.00R	BBH4.120.043.070.00L
14	43	70	10x20	BBH4.140.043.070.00R	BBH4.140.043.070.00L
15	43	70	10x20	BBH4.150.043.070.00R	BBH4.150.043.070.00L

TBH1 for panels with maximum **20 mm** in thickness

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
5	27	57,5	10x26	TBH1.050.027.057.01R	TBH1.050.027.057.01L
8	27	57,5	10x26	TBH1.080.027.057.01R	TBH1.080.027.057.01L
10	27	57,5	10x26	TBH1.100.027.057.01R	TBH1.100.027.057.01L

TBH2 for panels with maximum **25-30 mm** in thickness

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
5	35	70	10x26	TBH2.050.030.070.01R	TBH2.050.030.070.01L
8	35	70	10x26	TBH2.080.030.070.01R	TBH2.080.030.070.01L
10	35	70	10x26	TBH2.100.030.070.01R	TBH2.100.030.070.01L
12	35	70	10x26	TBH2.120.030.070.01R	TBH2.120.030.070.01L

Spare parts:

BBS1.M5.10	BBS1.M5.11

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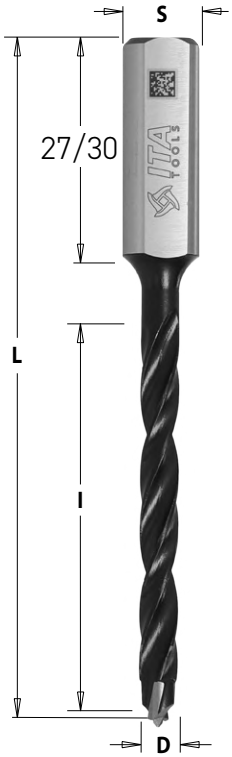
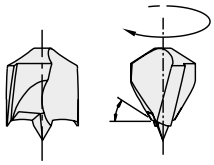
BBH8 | BBH9





HM | Z2 | V2 | RH | LH

Technical details:

- Super-strength steel
- Cutter portion coated with black or orange P.T.F.E.
- HW head with precision balanced centre point
- 2 HW precision ground cutting edges [Z2]
- Negatively ground spurs [V2]
- 4 spiral flutes
- Parallel shank with driving flat and length adjusting screw

Application:

Used on boring machines equipped with adapters or chucks.
Used to drill blind holes in solid wood, wood composites, plastic and laminated materials.

BBH8

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
5	65	105	10x30	BBH8.050.065.105.12R	BBH8.050.065.105.12L
6	65	105	10x30	BBH8.060.065.105.12R	BBH8.060.065.105.12L
7	65	105	10x30	BBH8.070.065.105.12R	BBH8.070.065.105.12L
8	65	105	10x30	BBH8.080.065.105.12R	BBH8.080.065.105.12L
10	65	105	10x30	BBH8.100.065.105.12R	BBH8.100.065.105.12L
12	65	105	10x30	BBH8.120.065.105.12R	BBH8.120.065.105.12L

BBH9

D mm	l mm	L mm	S mm	ARTICLE RH	ARTICLE LH
5	50	85	10x27	BBH9.050.050.085.11R	BBH9.050.050.085.11L
6	50	85	10x27	BBH9.060.050.085.11R	BBH9.060.050.085.11L
7	50	85	10x27	BBH9.070.050.085.11R	BBH9.070.050.085.11L
8	50	85	10x27	BBH9.080.050.085.11R	BBH9.080.050.085.11L
10	50	85	10x27	BBH9.100.050.085.11R	BBH9.100.050.085.11L
12	50	85	10x27	BBH9.120.050.085.11R	BBH9.120.050.085.11L

Spare parts:

BBS1.M5.10	BBS1.M5.11

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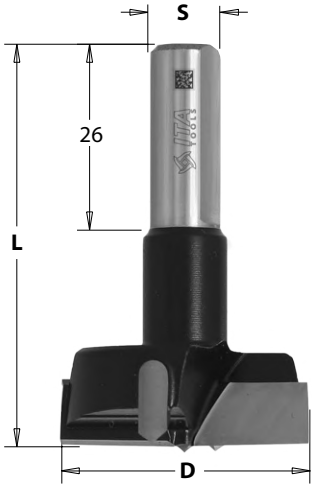
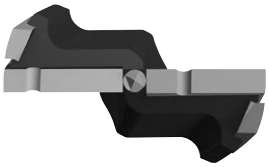
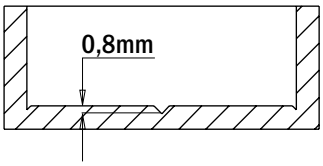
HBH1 | HBH2







HM **Z2** **V2** **RH** **LH**

Technical details:

- Super-strength steel
- Cutter portion coated with orange or black P.T.F.E.
- HW head with precision balanced centre point
- 2 HW precision ground cutting edges [Z2]
- 2 negatively ground spurs [V2]
- Parallel shank with driving flat and length adjusting screw

Application:

Ideal for hinges. Use on boring machines equipped with adapters or chucks. Use for drilling accurate and cleancut blind holes in solid wood, wood composites, plastic and laminated materials.

HBH1

D mm	L mm	S mm	ARTICLE RH	ARTICLE LH
15	57,5	10x26	HBH1.150.057.1R	HBH1.150.057.1L
20	57,5	10x26	HBH1.200.057.1R	HBH1.200.057.1L
25	57,5	10x26	HBH1.250.057.1R	HBH1.250.057.1L
30	57,5	10x26	HBH1.300.057.1R	HBH1.300.057.1L
35	57,5	10x26	HBH1.350.057.1R	HBH1.350.057.1L
40	57,5	10x26	HBH1.400.057.1R	HBH1.400.057.1L

HBH2

D mm	L mm	S mm	ARTICLE RH	ARTICLE LH
15	70	10x26	HBH2.150.070.1R	HBH2.150.070.1L
20	70	10x26	HBH2.200.070.1R	HBH2.200.070.1L
25	70	10x26	HBH2.250.070.1R	HBH2.250.070.1L
30	70	10x26	HBH2.300.070.1R	HBH2.300.070.1L
35	70	10x26	HBH2.350.070.1R	HBH2.350.070.1L
40	70	10x26	HBH2.400.070.1R	HBH2.400.070.1L

Spare parts:

BBS1.M5.10	BBS1.M5.11

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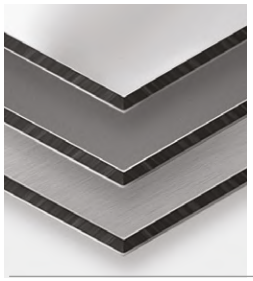
Chapter 2

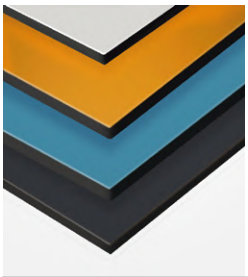
VHM and PCD Tools for Facades – Materials and Tools

Aluminum Plates
Material available in various sizes and thicknesses.
Hot and cold rolled plates, which allows them to maintain their excellent parameters. Aluminum plates are characterized primarily by ease of processing.



Composite Board AL/PE/AL
Material characterized by lightness, stiffness and durability. They are made of two layers of aluminum with a thickness of 0.3 - 0.5 mm, connected by a core made of low-density polyethylene. Materials with names such as **ALUCOBOND®, DIBOND®, STACBOND®,PLABOND®**

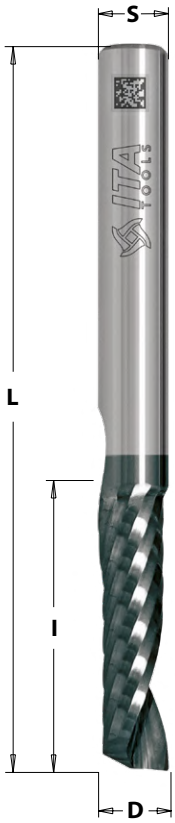
Composite Board A2
Material characterized by lightness, stiffness and durability. They are made of two layers of aluminum with a thickness of 0.3-0.5 mm, connected by a non-flammable mineral core. Materials with names such as **ETALBOND®A2, QBOND®A2**



High Pressure Laminate
Laminate produced under high pressure. This type of boards are made of several or a dozen or so layers of paper impregnated with resin. Under great pressure and high temperature, an extremely resistant material with very good visual properties is created.

Fiber Cement Board
Fiber-cement boards are made of cement, minerals, cellulose fibers and fillers. During the production process, thin layers of material are placed on top of each other and then, after completing the slow hardening process, very tightly compressed.

SP01HR
HC Coating
positive



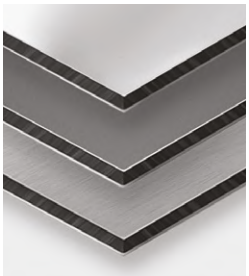
VHM | Z1 | RH

Technical details:

- Single blade cutter, positive,
- Perfect finishing of cutting edge – the polished chip groove
- Chip discharge upward
- Special type of carbide – increased tool life
- HC coating prevents the material from sticking and increases its tool service life
- Cutting, grooving
- Spiral angle 30°

Application:

For cutting, grooving and milling in aluminum, composite board AL/PE/AL, Dibond® composite, an alternative to plastics processing. Designed for use on CNC machines.



ALUMINUM
Work parameters:

- **RPM 16 000-24 000**
- **feed 0,8-2 m/min**

COMPOSITE BOARDS
Work parameters:

- **RPM 16 000-24 000**
- **feed 3-6 m/min**

D mm	I mm	L mm	S mm	Z	ARTICLE
3	6	60	6	1	SP01.03.006.060.06HR
4	8	60	6	1	SP01.04.008.060.06HR
6	12	60	6	1	SP01.06.012.060.06HR
8	12	60	8	1	SP01.08.012.060.08HR

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FVH

VHM | Z1 | Z2

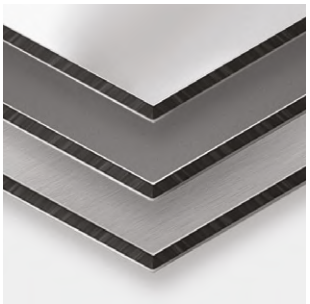
Technical details:

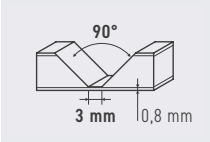
- Dibond bend cutter, 3 different types:
  V-90 (3 mm), V-90 (1,8 mm), V-108 (3 mm), V-135 (2 mm),
- Special type of carbide – increased tool life
- Possibility of using variety coatings

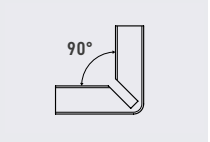
Application:

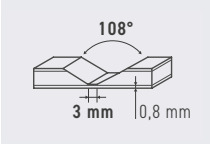
For making bends in composite material of the DIBOND® type. Designed for use on CNC machines.

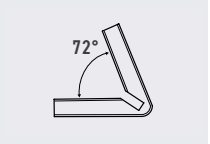
D mm	D_1 mm	I mm	L mm	S mm	α	ARTICLE
16	3	15	60	12	90°	FVH.16.015.060.12Ra1
16	3	15	60	12	108°	FVH.16.015.060.12Ra2
18	2	15	60	12	135°	FVH.18.015.060.12Ra3

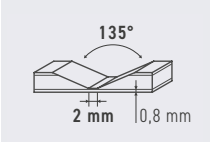






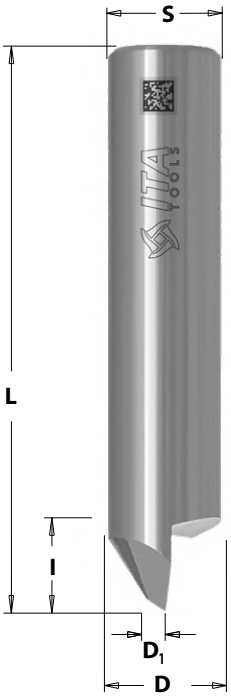






Work parameters:

- **RPM 20 000-22 000**
- **feed 4-8 m/min**

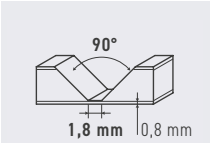


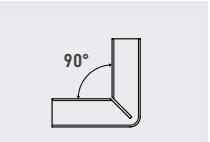
Dibond bend cutter Z1, 1,8 mm:

D mm	D_1 mm	I mm	L mm	S mm	α	ARTICLE
10	1,8	4	50	10	90°	FVH.10.004.050.10Ra1

Work parameters:

- **RPM 20 000-22 000**
- **feed 4-8 m/min**





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FDT | FDH

Z2 RH LASER ABLATION

Technical details:

- Full double PCD tips,
- Body made from stainless steel > 28 HRC
- Approval class of shank H6
- The shank surface roughness Ra ≤0,3 µm
- Height of PCD tip 4 mm
- Can be resharpened (3-4 times)

Application:

For cutting,grooving and milling in aluminum, composite board A2 Etalbond® A2 and for making bends in 90°.
Designed for use on CNC machines.

Advantages:

Excelent finish of machining elements and quiet work.

FDT for Cutting:

D mm	D_1 mm	l mm	L mm	S mm	α	Z	ARTICLE
12	6	6	80	12	45°	2	FDT.12.006.12.1SR
12	7	6,5	80	12	45°	2	FDT.12.006.12.0SR

Work parameters:

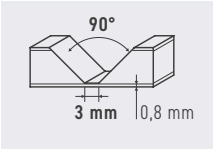
- **RPM 18 000-22 000**
- **feed 4-6 m/min**

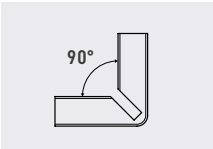
FDH for Bending 90°:

D mm	D_1 mm	l mm	L mm	S mm	α	Z	ARTICLE
12	2	5	55	12	45°	2	FDH.12.005.12.1SR
18	3	7,75	50	16	45°	2	FDH.18.007.16.0SR

Work parameters:

- **RPM 20 000-22 000**
- **feed 4-8 m/min**





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SY26XR
straight

VHM | RH | Z2

Technical details:

- Two edge blade cutter, straight
- Prefect finishing of cutting edge – the polished chip groove
- Chip discharge sideway
- Special type of carbide – increased tool life
- NaDia coating prevents the material from sticking and increases durability of tools
- Cutting, grooving

Application:

For cutting and milling HPL alternatively for plastics processing. Designed for use on CNC machines.

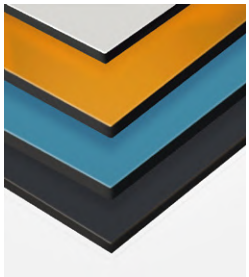
Advantages:

High wear resistance during processing in hard materials. Extended tool life and higher machining quality.

D mm	I mm	L mm	S mm	ARTICLE
4	15	60	4	SY26.04.015.060.04XR
6	15	60	6	SY26.06.015.060.06XR
8	15	60	8	SY26.08.015.060.08XR
10	15	60	10	SY26.10.015.060.10XR

Work parameters:

- **RPM 16,000-18,000**
- **feed 2-4 m/min**



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DTS
positive-negative

Z2 RH LASER ABLATION

Technical details:

- Full double PCD tips or full triple PCD tips, positive-negative / positive-negative-straight
- Chip discharge sideway
- Body made from DENSIMET®
- PCD tip at the bottom to drill
- Approval class of shank H6
- The shank surface roughness Ra ≤0,3 µm
- Height of PCD tip 3,5 mm
- Can be resharpened (3-4 times)

Application:

For cutting and milling HPL. Designed for use on CNC machines.

Advantages:

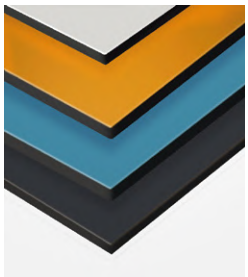
High wear resistance during processing in hard materials. Extended tool life and higher machining quality. Perfect chip ejection, excellent finish of the working edge and quiet work.

D mm	I mm	L mm	S mm	Z	ARTICLE
10	20	65	12	2	DTS.10.020.12.0DR
12	20	66	12	2	DTS.12.020.12.0DR
12	15	70	12	3	DT3.12.015.12.0DR

DT3
positive-negative-straight

Work parameters:

- **RPM 16 000-20 000**
- **feed 4-9 m/min**



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CNR
positive-negative

VHM RH

CNR

Technical details:

- Spherical multi-edge geometry, positive-negative
- Prefect roughing of cutting edge
- Chip discharge sideway
- Version of the tip – CNR – rosette
- Geometry adapted to the processing of composites, preventing delamination and pulling out of glass and carbon fibers
- Special type of carbide – increased tool life
- Possibility of using variety coatings

Application:

For cutting and milling in composite materials GFK, CFK, textolite, composite matrix, HPL, fiber cement board.
Designed for use on CNC machines.

Work parameters:

- **RPM 6 000-16 000**
- **feed 0,8-3 m/min**

D mm	I mm	L mm	S mm	ARTICLE ROSETTE TIP
3	10	45	3	CNR.03.010.045.03R
3	10	60	6	CNR.03.010.060.06R
4	18	60	4	CNR.04.018.060.04R
4	22	60	6	CNR.04.022.060.06R
5	16	50	5	CNR.05.016.050.05R
6	25	70	6	CNR.06.025.070.06R
8	30	80	8	CNR.08.030.080.08R
10	30	90	10	CNR.10.030.090.10R
12	30	90	12	CNR.12.030.090.12R

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DT1/DT2/DT3/DT5

RH

LASER ABLATION

Technical details:

- PCD tips,
- Body made from stainless steel > 28 HRC
- Approval class of shank H6
- The shank surface roughness Ra ≤0,3 µm
- Can be resharpened (3-4 times)

Application:

For cutting and milling in composite materials GFK, CFK, textolite, composite matrix, HPL, fiber cement board.
Designed for use on CNC machines.

Work parameters:

- **RPM 10 000-18 000**
- **feed 4-8 m/min**

D mm	I mm	I_2 mm	L mm	S mm	Z	PCD H mm	ARTICLE
4	8	-	60	6	1	2,5	DT1.04.008.06.0MR
6	11	-	50	6	1	3	DT1.06.011.06.0MR
12	5	-	56	12	2	2,5	DT2.12.005.12.0SR
12	15	35	85	12	3	3	DT3.12.015.12.0SR
16	10	90	130	16	5	3	DT5.16.010.16.2SR
18	22	-	100	20	5	3	DT5.18.022.20.0SR
20	25	50	90	20	5	3	DT5.20.025.20.0SR

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