Locking torques
Leitz cutting systems
Planing and profiling

HeliPlan

VariPlan, VariPlan Plus

Planerhead wedge-type system

VariPlan:
M8, ISK 5.0 = 15 Nm
VariPlan Plus:
M8, ISK 5.0 = 12 Nm

Aluminium tool body:
M10x1, ISK 5.0 = 18 Nm
Steel tool body:
M10x1, ISK 5.0 = 25 Nm

Hydro planerhead
RotaPlan

Profile and planer head with
HSK 85 WS adaptor or hydro
clamping, PowerKnife system

Minifinger cutterhead
with changeable knives

Aluminium tool body:
M10x1, ISK 5.0 = 18 Nm
Steel tool body:
M10x1, ISK 5.0 = 25 Nm

M5, T20 = 5 Nm

M10x1, ISK 5.0 = 17 Nm

M10, ISK 5.0 = 17 Nm
Planing and profiling

Minifinger cutterhead with turnblade knives

M6, T20 = 6 Nm

Minifinger cutterhead TurboHawk

M8, ISK 6.0 = 20 Nm
Jointing, rebating and bevelling

**Turnblade knife jointing cutterheads**

- **Turnblade knife 4.1 / 5.5 mm**
  - M5, T20 = 6 Nm

- **Turnblade knife 12 mm**
  - M5, ISK 2.5 = 4 Nm
  - M6, ISK 3.0 = 5 Nm
  - M8, ISK 4.0 = 6 Nm

- **Turnblade knife 8 mm**
  - M5, T15 = 5.5 Nm
  - M6, T25 = 14 Nm

**HeliCut Diamaster WhisperCut**

- **Turnblade knife 4.1 / 5.5 mm**
  - M2.5, T8 = 1.5 Nm
  - M3, T8 = 2 Nm
  - M4, T15 = 3 Nm

- **HeliCut**
  - M5, T20 = 5 Nm

- **Diamaster WhisperCut**
  - M5, T20 = 7 Nm
Jointing, rebating and bevelling

Spur

Aluminium tool body:
M5, T20 = 6 Nm

Steel tool body:
M6, T20 = 6 Nm

Lamello turnblade knife and spur

M4x0.5, T9 = 2 Nm

Grooving knife, rhomboid turnblade knife

M6, T20 = 6 Nm
M6, T20 = 6 Nm
M6, T25 = 14 Nm
M12, ISK 6.0 = 14 Nm

Edging knife

M6, T20 = 6 Nm

Variangel bevel cutterhead

M6, ISK 3.0 = 5 Nm
M8, ISK 8.0 = 20 Nm
Profile tool systems

ProfilCut Q, ProfilCut Q Premium, ProfilCut, ProfilCut Plus

M5, T15 = 5.5 Nm
M6, T25 = 14 Nm

ProfilCut Q Diamond, ProfilCut Q PLUS

M5, T15 = 5.5 Nm
M6, T25 = 14 Nm

ProFix-Plus, ProFix F, ProFix C

M5, ISK 2.5 = 2.5 Nm
M6, ISK 3.0 = 5 Nm
M6, ISK 4.0 = 5 Nm
M8, ISK 4.0 = 10 Nm

VariForm

M5, T25 = 6 Nm
M10, ISK 5.0 = 15 Nm

FinCut

M5, ISK 2.5 = 4 Nm
M8, ISK 4.0 = 12 Nm

Multi purpose profile cutterhead

M10, ISK 5.0 = 15 Nm
M16, SW 17 = 15 Nm
**Other**

Screwed sets with bore, standard and hydro sleeve

- M6, ISK 5.0 = 9 Nm

Srewed sets with cutter arbors

- M5, ISK 4.0 = 6 Nm
- M8, ISK 6.0 = 14 Nm
- M10, ISK 6.0 = 30 Nm
- M16, ISK 10/14 = 65 Nm

Activation clamping system hydro sleeve

- M8x1, ISK 6.0 = 10 Nm

Hogger on sleeve

- M8, ISK 6.0 = 14 Nm

Sawblade on hogger

- M6, T20 = 6 Nm