

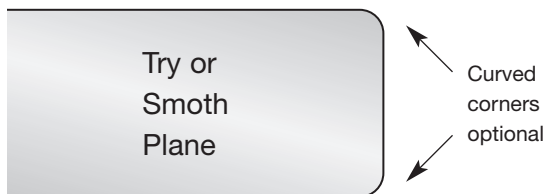
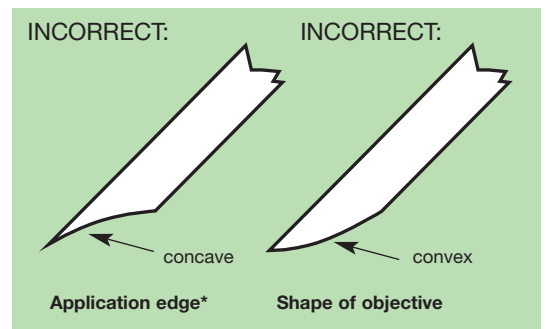
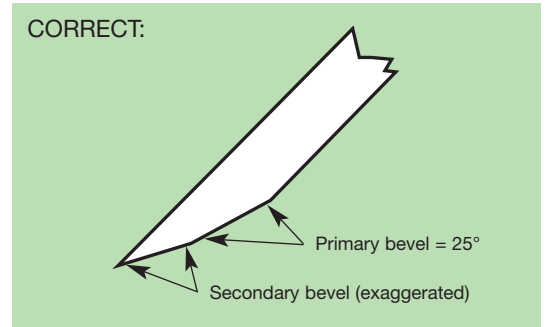
Grinding Angles

Slight Secondary Bevel Strengthens Cutting Edge

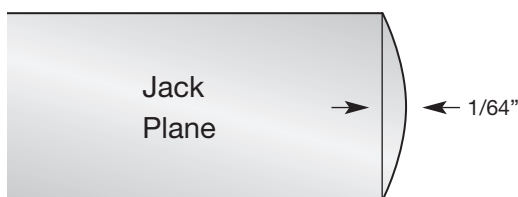
Secondary bevel must be acute to allow back clearance. Back clearance reduces friction. When cutting edge presses down, it compresses the wood. But wood immediately in back of the cutting edge is not compressed. Back clearance provides space for this expansion. Without it, friction heats the cutting edge and dulls it. The amount of back clearance corresponds to the depth of cut.

Grinding bevel on small-diameter wheel weakens the edge. A secondary bevel is necessary.

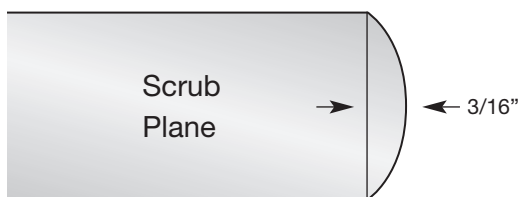
If secondary bevel becomes wide or rounded, back clearance is lost. Rounded bevel prevents cutting edge from biting in. Blade heats up and it dulls further.



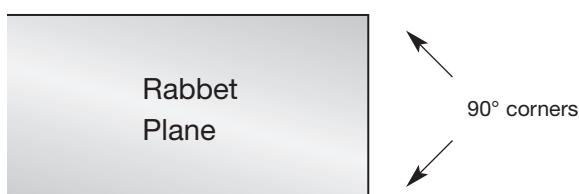
Slightly rounded corners eliminates cutting hard lines at blade edges assuring a smooth surface.



A slightly curved edge speeds wood removal. Especially applicable on blades reserved for cleaning up rough sawn lumber, and other heavy duty applications.



Blades ground with pronounced curve permit rapid removal of waste wood. The primary angle may be ground at 30° or even 35° to strengthen edge.



Grind and hone Rabbet plane iron perfectly square with sharp corners.

*** Edge curves are exaggerated to illustrate concept.**

Plane Irons

Double iron (with cap iron)



No.	Type	Iron width mm	Weight ca. kg	EAN-Number 4016650...	Per Box
1612.45	Double Iron	45	0,30	...016137	1
1612.48	Double Iron	48	0,30	...012481	1
1612.60	Double Iron	60	0,40	...012603	1
1612 R	HSS, for No. 104 ER	48	0,30	...016144	1

Single iron (without cap iron)



No.	Type	Iron width mm	Weight ca. kg	EAN-Number 4016650...	Per Box
1602.45	Single Iron	45	0,10	...002451	1
1602.48	Single Iron	48	0,15	...002482	1
1602.60	Single Iron	60	0,20	...002604	1
1602 R	HSS, for No. 104 ER	48	0,15	...000129	1

Plane irons with replaceable cutter edges (also suitable for E.C.E. PRIMUS-Planes)



No.	Type	Iron width mm	Weight ca. kg	EAN-Number 4016650...	Per Box
1602 W	Single iron with 3 replaceable cutters	48	0,20	...060284	1
1612 W	Double iron with 3 replaceable cutters	48	0,30	...061281	1
12 KW	PRIMUS-Double iron with 3 replaceable cutters	48	0,30	...001218	1
1600 W	Pack of 5 replaceable cutters	48	0,05	...001287	5

Single iron for Rabbet Plane No. 9 S (without cap iron)



No.	Type	Iron width mm	Weight ca. kg	EAN-Number 4016650...	Per Box
1608.15		15	0,10	...008309	1
1608.18		18	0,10	...016083	1
1608.21		21	0,10	...016052	1
1608.24		24	0,10	...160823	1
1608.30		30	0,10	...016069	1

Double iron for Rabbet Plane No. 10 S (with cap iron)



No.	Type	Iron width mm	Weight ca. kg	EAN-Number 4016650...	Per Box
1609.27		27	0,10	...009306	1
1609.30		30	0,15	...016090	1

Single iron for Rabbet Plane No. 10 S (without cap iron)



No.	Type	Iron width mm	Weight ca. kg	EAN-Number 4016650...	Per Box
1609.27a		27	0,10	...016007	1
1609.30a		30	0,10	...016106	1



Iron for No. 111 S

No.	Type	Iron width mm	Weight ca. kg	EAN-Number 4016650...	Per Box
1727	Single iron	48	0,15	...027485	1
1726	Double iron	48	0,30	...026488	1



Nr. 1606



Nr. 1604



Nr. 1714

Plane Irons for Specialty Planes

No.	Type	Iron width mm	Weight ca. kg	EAN-Number 4016650...	Per Box
1606	Iron for Scrub Plane	33	0,10	...006336	1
1603	Iron for Moving Fillister Plane	33	0,10	...016038	1
1604	Iron for Dovetail Plane	33	0,10	...016045	1
1607	New knife spur for No. 23 S and No. 48 S	14 x 14	0,05	...016076	1
1605	Iron for Expert Plane	48	0,15	...160502	1
1101	Iron for small German Gent's Plane	39	0,10	...011019	1
1649	Iron for Block Plane	39	0,05	...004905	1
1705	Iron for Tooothing Plane	48	0,30	...017059	1
1714	Irons for Router Plane	10, 15, 20	0,30	...017141	1
1738-3	Irons for Plow Plane	5, 7, 9	0,30	...017387	1
1738-6	Irons for Plow Plane	4, 5, 7, 9, 12, 14	0,70	...017394	1
1694	Iron for Inletting Plane	16	0,05	...016946	1
1655	Iron for Tee Rabbet Plane	48	0,10	...016557	1

Plane Irons for Metal Planes



Nr. 1751



Nr. 1755

No.	Type	Iron width mm	Weight ca. kg	EAN-Number 4016650...	Per Box
1702	Single iron for Compass Plane without cap iron	44	0,10	...017028	1
1712	Double iron for Compass Plane with cap iron	44	0,25	...017127	1
1751	Iron for Spokeshave straight	52	0,05	...017516	1
1755	Iron for Spokeshave concave	52	0,05	...017554	1
1750	Iron for Spokeshave convex	52	0,05	...017509	1
1760	Iron for Low Angle Block Plane	41	0,10	...017608	1
1780	Iron for Cabinet Scraper Plane	70	0,05	...017806	1
1775	Iron for Bullnose Plane	27	0,05	...017752	1

Plane Irons for PRIMUS-Planes



Nr. 12 K



Nr. 2709 K

No.	Type	Iron width mm	Weight ca. kg	EAN-Number 4016650...	Per Box
12.48 K 12.60 K	Complete iron for PRIMUS-Planes	48 60	0,30 0,40	...124849 ...124863	1 1
12.48 12.60	Single iron for PRIMUS-Plane without cap iron	48 60	0,15 0,20	...001201 ...126003	1 1
12 R	PRIMUS-Single iron without cap iron	48	0,15	...000136	1
12 RK	Complete PRIMUS-iron, HSS for No. 704 ER	48	0,30	...000143	1
12.48 D 12.60 D	PRIMUS-cap iron	48 60	0,10 0,15	...001225 ...001263	1 1
2709 K	Complete iron for-PRIMUS-Rabbet Plane	30	0,15	...027096	1
2709	Single iron for PRIMUS-Rabbet Plane	30	0,10	...027034	1