



PRECISION IN BEST TIME



For the perfect edge:

## Konstantin® jointing and radius milling tools from Aigner

Aigner Konstantin® milling tools meet the highest demands on milling quality and enable breathtaking milling results, even with difficult board qualities. Starting with the C424 jointing cutter, easily recognizable by the inserted half cutting edges in the lower jointing area, we enable our customers to enter the economical Konstantin® cutting system. Developed as a jointing cutter system for smaller machines without height adjustment, this cutter can even work without tear-out at 8mm plate thickness. With the C434, Aigner Werkzeuge serves larger machine series and ensures long milling distances and top edge quality here. The absolute top class, however, is the C444! Equipped with the Speedy system with up to 54° axis angle, tear-out-intensive panel materials can be machined in unprecedented quality. In addition to the jointing cutters, Aigner can present the C560-1 and the C560-2. The DIA rounding cutters, which can be equipped with different radius knives, leave nothing to be desired when profiling and flush milling edge materials.

# C424 DP-Jointing cutterhead „Konstantin®“

The C424 DP jointing cutterhead Konstantin® in aluminum design is suitable for edge banding machines without height adjustment. Due to the inserted half cutting edge in the lower jointing area of the cutter, panel thicknesses up to 8mm can be milled without tear-out. With the aluminum support body, low-noise and spindle-friendly milling is possible. Equipped with the Konstantin® DIA interchangeable blade system, users can independently change the cutting blades and a recalibration like competitor systems is not necessary with us! A torque wrench with 11Nm torque should be used for the change process to ensure the required repeatability.

## Design:

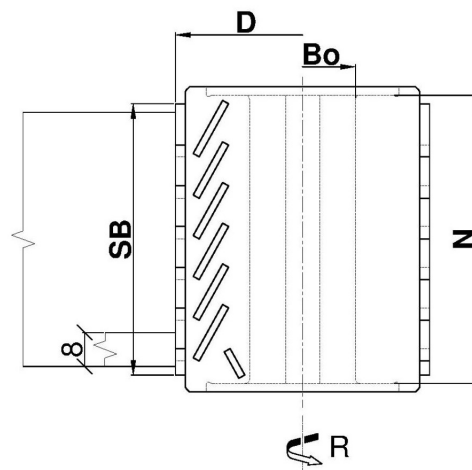
Mechanical feed; supporting body in aluminum version; Z2 or Z3 version; DIA interchangeable cutting edges; 2x resharpenable; chip flow and noise optimized

## Application:

For joint milling on counter and synchronous units on KAL machines; Suitable for machining common panel materials

## Usage:

Suitable from 15000-18000 rpm depending on the diameter; Feed Z=2 from 6-12m/min; Feed rate from 12-20m/min use Z=3



YES = C434



1.) for type S = symmetrical blade arrangement

→ NO

NO = C434



2.) for type AS = asymmetric cutter arrangement  
Are plates with 8mm machined?

→ YES

YES = C434



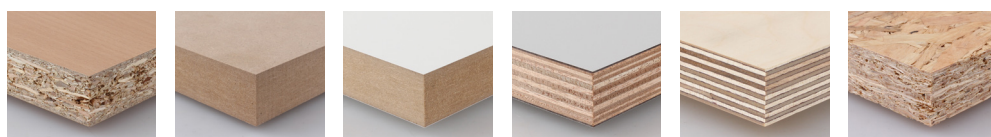
3.) Can and will the customer adjust the spindle between 8mm and max HD (40 or 60)?

→ NO = C424  
with half  
cutter

4.) Feed rate up to 11 m/min = number of teeth Z2  
from 12 to 20 m/min = number of teeth Z3



Article no.	D	SB	N	BO	MA	Z	N-MAX	R/L
C424-060FA54L	60	54	60	25	Felder	2x6	15500	L
C424-060FA54R	60	54	60	25	Felder	2x6	15500	R
C424-060FA64L	60	64	68	25	Felder	2x7	15500	L
C424-060FA64R	60	64	68	25	Felder	2x7	15500	R
C424-060RA45L	60	45.5	29.2	16	Bi-Matic	3x5	15500	L
C424-060RA45R	60	45.5	29.2	16	Bi-Matic	3x5	15500	R
C424-070EA45L	70	45.5	62	25	Hebrock	2x5	18000	L
C424-070EA45R	70	45.5	62	25	Hebrock	2x5	18000	R
C424-070EA64L	70	64.5	71.7	25	Hebrock	2x7	18000	L
C424-070EA64R	70	64.5	71.7	25	Hebrock	2x7	18000	R
C424-080FA64L	80	64	63	25	Felder	2x7	15500	L
C424-080FA64R	80	64	63	25	Felder	2x7	15500	R
C424-080FB64L	80	64	63	25	Felder	3x7	15500	L
C424-080FB64R	80	64	63	25	Felder	3x7	15500	R
C424-085PA45L	85	45.5	42	30	OTT	3x5	15500	L
C424-085PA45R	85	45.5	42	30	OTT	3x5	15500	R
C424-085PA64L	85	64	42	30	OTT	3x7	15500	L
C424-085PA64R	85	64	42	30	OTT	3x7	15500	R
C424-100DA55L	100	55	37	30	IMA	3x6	15200	L
C424-100DA55R	100	55	37	30	IMA	3x6	15200	R
C424-100EA45L	100	45.5	61	30	Hebrock	2x5	15200	L
C424-100EA45R	100	45.5	61	30	Hebrock	2x5	15200	R
C424-100EA64L	100	64.6	80.8	30	Hebrock	2x7	15200	L
C424-100EA64R	100	64.6	80.8	30	Hebrock	2x7	15200	R
C424-100GA47L	100	47.7	25	30	Holzher	2x5	15200	L
C424-100GA47R	100	47.7	25	30	Holzher	2x5	15200	R
C424-100SA64L	100	64.6	60	30	SCM-Stefani	3x7	15200	L
C424-100SA64R	100	64.6	60	30	SCM-Stefani	3x7	15200	R



# C434 DP-Jointing cutterhead „Konstantin®“

The C434 DP-jointing cutterhead Konstantin® in aluminum design is suitable for edge banding machines with height adjustment. Different cutter arrangements in asymmetrical and symmetrical design are possible. In addition, with symmetrical designs and an adjustment of the wood thickness over the center, a slight crowning of the milled edge can be produced with the help of the support head. This technique is a guarantee of minimal little visible glue joints on the surfaces of the boards. Equipped with the Konstantin® DIA interchangeable blade system, users can independently change the cutting blades and recalibration as with competitor systems is not necessary! A torque wrench with 11Nm should be used for the change process to ensure the required repeatability.

## Design:

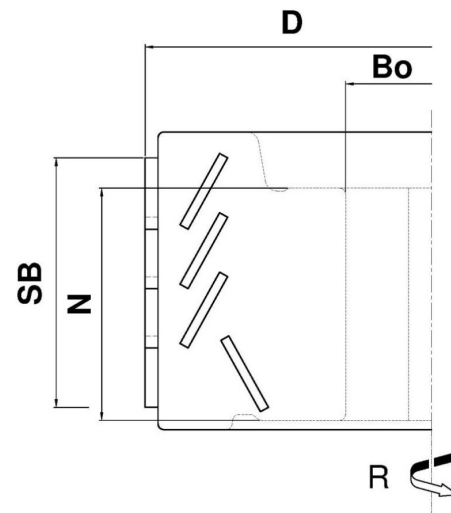
Mechanical feed; supporting body in aluminum version; Z2 or Z3 version; DIA interchangeable cutting edges; 2x resharpenable; Chip flow and noise optimized

## Application:

For joint milling on counter and synchronous units on KAL machines; Suitable for machining common panel materials

## Usage:

Suitable from 12000-18000 rpm depending on the diameter; Feed Z=2 from 6-12m/min; Feed rate from 12-20m/min use Z=3; Feed rate over 20m/min use Z=4



Blade arrangement = "SA"		
<p>Type „s“ = symmetric</p>	<p>Type „s*“ = symmetric crowned</p>	<p>Type „as“ = asymmetric</p>

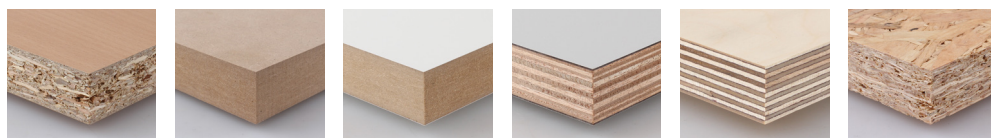
Article no.	D	SB	N	BO	MA	N-MAX	Z	SA	R/L
C434-060FA54L	60	54	62	25	Felder	15500	2x5	as	L
C434-060FA54R	60	54	62	25	Felder	15500	2x5	as	R
C434-060FA64L	60	64	68	25	Felder	15500	2x6	as	L
C434-060FA64R	60	64	68	25	Felder	15500	2x6	as	R
C434-060RB54L	60	54	39.2	16	Bi-Matic Prima	15500	2x5	as	L
C434-060RB54R	60	54	39.2	16	Bi-Matic Prima	15500	2x5	as	R
C434-070EA43L	70	43.6	61	25	Hebrock	18000	2x4	as	L
C434-070EA43R	70	43.6	61	25	Hebrock	18000	2x4	as	R
C434-070EA64L	70	64.5	81	25	Hebrock	18000	2x6	as	L
C434-070EA64R	70	64.5	81	25	Hebrock	18000	2x6	as	R
C434-070GA43L	70	43.7	29.5	30	Holzher	18000	2x4	as	L
C434-070GA43R	70	43.7	29.5	30	Holzher	18000	2x4	as	R
C434-070GA54L	70	54	29.5	30	Holzher	18000	2x5	as	L
C434-070GA54R	70	54	29.5	30	Holzher	18000	2x5	as	R
C434-070GA64L	70	64.5	35.5	30	Holzher	18000	2x6	as	L
C434-070GA64R	70	64.5	35.5	30	Holzher	18000	2x6	as	R
C434-070GB43L	70	43.7	35.5	30	Holzher	18000	3x4	as	L
C434-070GB43R	70	43.7	35.5	30	Holzher	18000	3x4	as	R
C434-070GB64L	70	64.5	35.5	30	Holzher Prolock	18000	3x6	as	L
C434-070GB64R	70	64.5	35.5	30	Holzher Prolock	18000	3x6	as	R
C434-070GC64L	70	64.5	35.5	30	Holzher	18000	3x6	as	L
C434-070GC64R	70	64.5	35.5	30	Holzher	18000	3x6	as	R
C434-080FA64L	80	64.6	66.6	25	Felder	15500	3x6	as	L
C434-080FA64R	80	64.6	66.6	25	Felder	15500	3x6	as	R
C434-080FB54L	80	54	66.6	25	Felder	15500	2x5	as	L
C434-080FB54R	80	54	66.6	25	Felder	15500	2x5	as	R
C434-080FB64L	80	64.6	66.6	25	Felder	15500	2x6	as	L
C434-080FB64R	80	64.6	66.6	25	Felder	15500	2x6	as	R
C434-080RA64L	80	64.6	30	20	Bi-Matic	15500	3x6	s	L
C434-080RA64R	80	64.6	30	20	Bi-Matic	15500	3x6	s	R
C434-085PA43L	85	43.6	45	30	Ott	15500	3x4	as	L

Article no.	D	SB	N	BO	MA	N-MAX	Z	SA	R/L
C434-085PA43R	85	43.6	45	30	Ott	15500	3x4	as	R
C434-085PA54L	85	54	45	30	Ott	15500	3x5	as	L
C434-085PA54R	85	54	45	30	Ott	15500	3x5	as	R
C434-085PA64L	85	64.6	45	30	Ott	15500	3x6	as	L
C434-085PA64R	85	64.6	45	30	Ott	15500	3x6	as	R
C434-100BA43L	100	43.6	40.6	30	Brandt/ Homag	15200	3x4	as	L
C434-100BA43R	100	43.6	40.6	30	Brandt/ Homag	15200	3x4	as	R
C434-100BA64L	100	64.6	40.6	30	Brandt/ Homag	15200	3x6	as	L
C434-100BA64R	100	64.6	40.6	30	Brandt/ Homag	15200	3x6	as	R
C434-100BB43R	100	43.6	40.6	25	Brandt/ Homag	15200	2x4	as	R
C434-100DA54L	100	54.1	37	30	IMA	15200	3x5	as	L
C434-100DA54R	100	54.1	37	30	IMA	15200	3x5	as	R
C434-100DB43L	100	43.6	41	30	IMA / Brandt	15200	3x4	s	L
C434-100DB43R	100	43.6	41	30	IMA / Brandt	15200	3x4	s	R
C434-100EA43L	100	43.6	61	30	Hebrock	15200	2x4	as	L
C434-100EA43R	100	43.6	61	30	Hebrock	15200	2x4	as	R
C434-100EA64L	100	64.6	80.8	30	Hebrock	15200	2x6	as	L
C434-100EA64R	100	64.6	80.8	30	Hebrock	15200	2x6	as	R
C434-100GA43L	100	43.6	25	30	Holzher	15200	3x4	as	L
C434-100GA43R	100	43.6	25	30	Holzher	15200	3x4	as	R
C434-100GA54L	100	54	25	30	Holzher	15200	3x5	as	L
C434-100GA54R	100	54	25	30	Holzher	15200	3x5	as	R
C434-100GA64L	100	64.6	39.5	30	Holzher	15200	3x6	as	L
C434-100GA64R	100	64.6	39.5	30	Holzher	15200	3x6	as	R
C434-100GB64L	100	64.6	39.5	30	Holzher	15200	3x6	s	L
C434-100GB64R	100	64.6	39.5	30	Holzher	15200	3x6	s	R
C434-100GC43L	100	43.6	25	30	Holzher	15200	2x4	as	L
C434-100GC43R	100	43.6	25	30	Holzher	15200	2x4	as	R
C434-100GC54L	100	54	25	30	Holzher	15200	2x5	as	L
C434-100GC54R	100	54	25	30	Holzher	15200	2x5	as	R



Article no.	D	SB	N	BO	MA	N-MAX	Z	SA	R/L
C434-100PA43L	100	43.6	45	30	Ott	15200	3x4	as	L
C434-100PA43R	100	43.6	45	30	Ott	15200	3x4	as	R
C434-100PA64L	100	64.6	44	30	Ott	15200	3x6	as	L
C434-100PA64R	100	64.6	44	30	Ott	15200	3x6	as	R
C434-125DA54L	125	54	37	30	IMA 08.378	12200	3x5	as	L
C434-125DA54R	125	54	37	30	IMA 08.378	12200	3x5	as	R
C434-125DA64L	125	64.6	37	30	IMA 08.378	12200	3x6	as	L
C434-125DA64R	125	64.6	37	30	IMA 08.378	12200	3x6	as	R
C434-125DB43L	125	43.6	37	30	IMA 08.378	12200	4x4	as	L
C434-125DB43R	125	43.6	37	30	IMA 08.378	12200	4x4	as	R
C434-125DC64L	125	64.6	57	30	IMA 08.379	12200	3x6	as	L
C434-125DC64R	125	64.6	57	30	IMA 08.379	12200	3x6	as	R
C434-125HA43L	125	43.6	40.6	30	Homag/ Biesse	12200	3x4	s	L
C434-125HA43R	125	43.6	40.6	30	Homag/ Biesse	12200	3x4	s	R
C434-125HA64L	125	64.6	40.6	30	Homag/ Biesse	12200	3x6	s	L
C434-125HA64R	125	64.6	40.6	30	Homag/ Biesse	12200	3x6	s	R
C434-125HA64LC	125	64.6	40.6	30	Homag/ Biesse	12200	3x6	s*	L
C434-125HA64RC	125	64.6	40.6	30	Homag/ Biesse	12200	3x6	s*	R
C434-125HB33L	125	33.2	40	30	Homag	12200	3x3	as	L
C434-125HB33R	125	33.2	40	30	Homag	12200	3x3	as	R
C434-125HB43L	125	43.6	40	30	Homag	12200	3x4	as	L
C434-125HB43R	125	43.6	40	30	Homag	12200	3x4	as	R
C434-125HB64L	125	64.6	40	30	Homag	12200	3x6	as	L
C434-125HB64R	125	64.6	40	30	Homag	12200	3x6	as	R

**Additional dimensions available in the online catalog or on request for your machine type!**



# C444 DP-Jointing cutterhead „Konstantin®“ Speedy

The C444 DP-jointing cutterhead Konstantin® in aluminum design is suitable for edge banding machines with height adjustment. Due to the Speedy cutter arrangement with a breast axis angle of up to 54°, tear-outs in cross grain areas are minimized and even structured - or veneered panel materials can be processed without damaging the surfaces. In addition, this type of milling cutter rewards the user with an extremely long milling distance compared to a conventional jointing system. Due to the aluminum support body, noise-reduced and spindle-friendly milling is possible. Equipped with the Konstantin® DIA interchangeable blade system, users can independently change the cutting blades and recalibration like competitor systems is not required! For the change process a torque wrench with 11Nm should be used to ensure the required repeatability.

## Design:

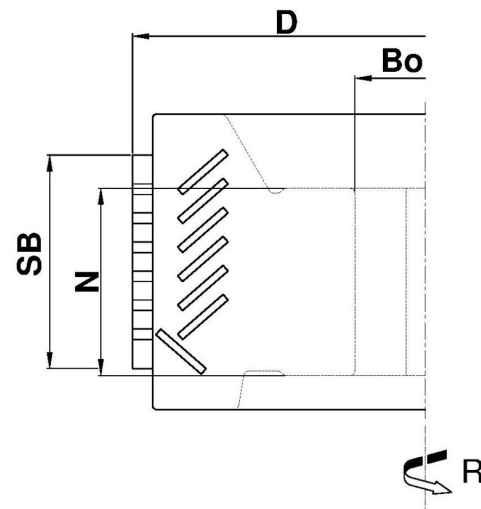
Mechanical feed; Supporting body in aluminum version; Z2 or Z3 version; DIA interchangeable cutting edges; 2x resharpenable; Chip flow and noise optimized

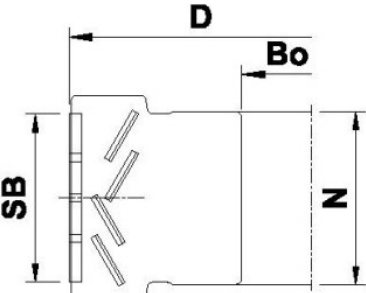
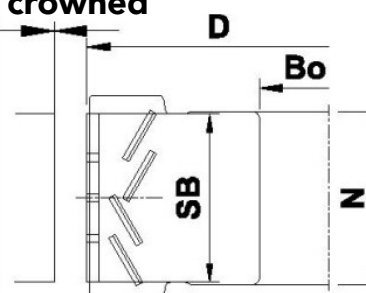
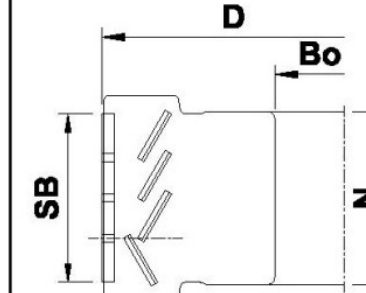
## Application:

For joint milling on counter and synchronous units on KAL machines; Ideally suited for machining panel materials with high tear-out intensity

## Usage:

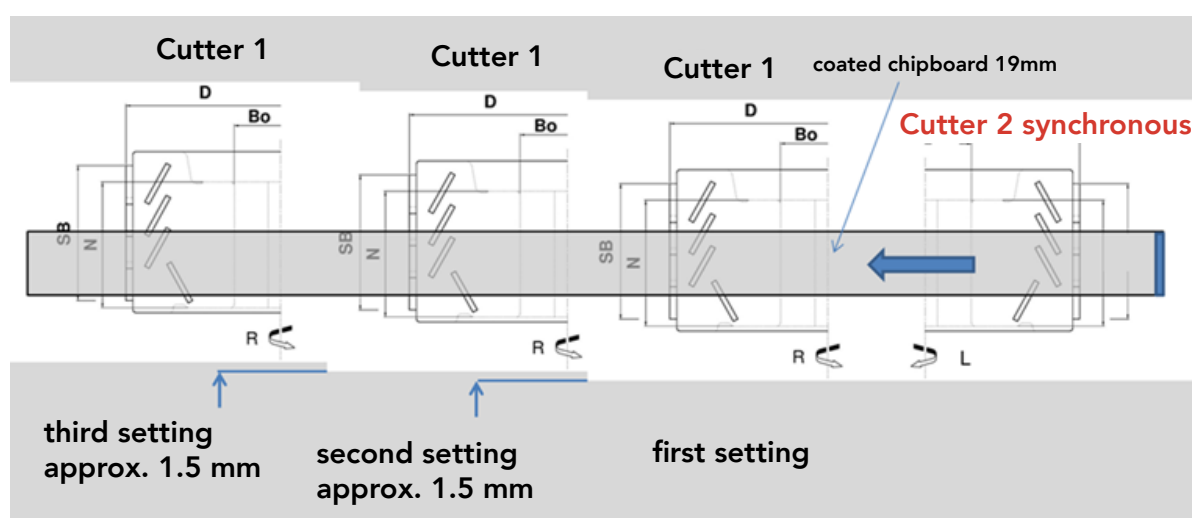
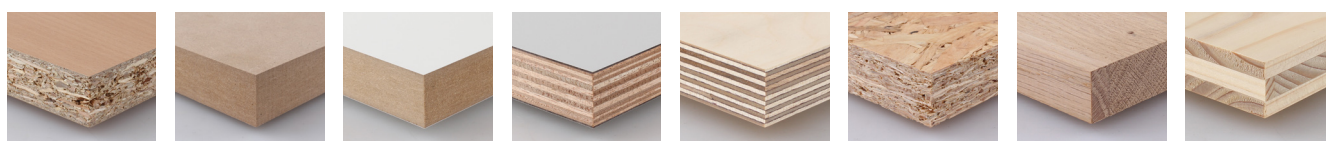
Suitable from 12000-15500 rpm depending on the diameter; Feed Z=2 from 6-12m/min; Feed rate from 12-20m/min use Z=3;



Blade arrangement = "SA"		
<b>Type „s“ = symmetric</b> 	<b>Type „s*“ = symmetric crowned</b> 	<b>Type „as“ = asymmetric</b> 



Article no.	D	SB	N	BO	MA	N-MAX	Z	SA	R/L
C444-080CA65L	80	65	53	30	Biesse	15500	3x10	s	L
C444-080CA65R	80	65	53	30	Biesse	15500	3x10	s	R
C444-100BA45L	100	45.6	40.6	30	Brandt	15200	3x7	as	L
C444-100BA45R	100	45.6	40.6	30	Brandt	15200	3x7	as	R
C444-125DB45L	125	45.6	37	30	IMA 08.378	12200	4x7	as	L
C444-125DB45R	125	45.6	37	30	IMA 08.378	12200	4x7	as	R
C444-125DC65L	125	65	57	30	IMA 08.379	12200	3x10	as	L
C444-125DC65R	125	65	57	30	IMA 08.379	12200	3x10	as	R
C444-125HA45L	125	45.6	40	30	Homag	12200	3x7	as	L
C444-125HA45R	125	45.6	40	30	Homag	12200	3x7	as	R
C444-125HA58L	125	58	40	30	Homag	12200	3x9	as	L
C444-125HA58R	125	58	40	30	Homag	12200	3x9	as	R
C444-125HB65L	125	65	36.6	30	Homag	12200	3x10	s	L
C444-125HB65R	125	65	36.6	30	Homag	12200	3x10	s	R



# C560-1 DP-Edge Rounding Cutter

## Konstantin®-Mini for KAM

A special coup has been achieved with the new C560-1 Edge Rounding Cutter. A DIA radius profile cutter equipped with the Konstantin® Mini interchangeable blade system is available especially for Holzher edge banding machines. Revolutionary; these profile cutters with different radii 1.0/1.3/2.0/2.5/3.0mm can be exchanged by the operators themselves while maintaining the same trailing edge! Very economical; a new purchase of many different radius cutter-sets can be avoided by using the C560-1! If the DIA one-way cutters have to be replaced after the end of the tool life, there is no need for readjustment due to the constant diameter change system. For other common manufacturers the DIA radius profile cutter is also already available on request!

### Design:

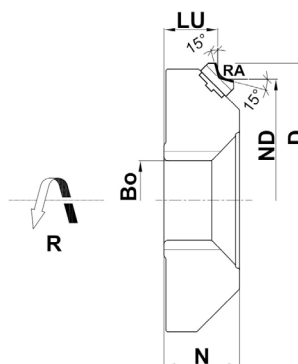
Mechanical feed; supporting body in steel version; Z4 design; DIA changeable cutting edges; chip flow and noise optimized

### Application:

For rounding and corner copying on aggregates KAL machines; For processing veneer and plastic (ABS) edge; Plastic (ABS) edging material best suited

### Usage:

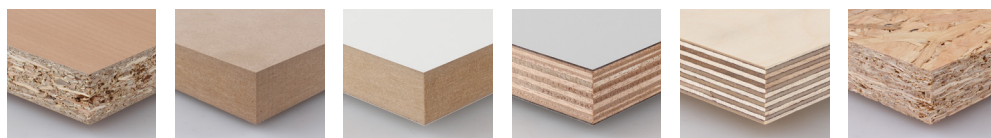
Depending on the diameter suitable up to 15500U/min; feed rate from 12-20m/min use Z=4



Article no.	D	ND	BO	LU	Z	RA	P	R/L	MA
C560-1AL	69	61	20	13,5	4	R2	R1-R3	L	Holz-Her(1833)
C560-1AR	69	61	20	13,5	4	R2	R1-R3	R	Holz-Her(1833)

## SPAREPARTS

Article no.	
KW.15714.7	Spare clamping screw 60° - M3x6 / Torx10
KW.21679.7/B25	Replaceable DP cutters "Mini" - R1.0
KW.21680.7/B25	Replaceable DP cutters "Mini" - R1.3
KW.21681.7/B25	Replaceable DP cutters "Mini" - R1.5
KW.21682.7/B25	Replaceable DP cutters "Mini" - R2.0
KW.21683.7/B25	Replaceable DP cutters "Mini" - R2.5
KW.21684.7/B25	Replaceable DP cutters "Mini" - R3.0
C986-FT1810	Torque wrench for „Konstantin-Mini“, 1.8Nm, incl. Torx-Bit / T10



# C560-2 DP-Rounding-/Edge Trimming Cutter Konstantin®-Mini for KAM

The cutter type C560-2 has been developed for edge banding machines that are capable of rounding/longitudinal profiling and flush milling of solid wood glues, as well as veneer and plastic glues on one milling spindle. The DIA flush rounding cutter is equipped with the Konstantin® Mini interchangeable cutter system, in which the profile cutting edges with different radii optionally 1.3/2.0/bevel 45° can be interchanged by the user. For the user this means in plain language: No more new purchase of several cutter sets with different radii! If the DIA radius profile knives are changed after the end of the tool life, there is no need for readjustment of the trailing edge due to the diameter-constant one-way knife system. For many other common manufacturers, the C560-2 is also already available on request!

## Design:

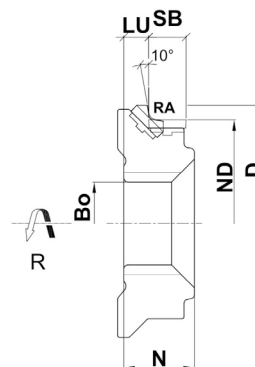
Mechanical feed; steel design support body;  
Z2/2 design; DIA interchangeable cutting edges;  
Chip flow and noise optimized

## Application:

For rounding/flush milling on aggregates on KAL machines; For processing veneer and plastic (ABS) edging material best suited;

## Usage:

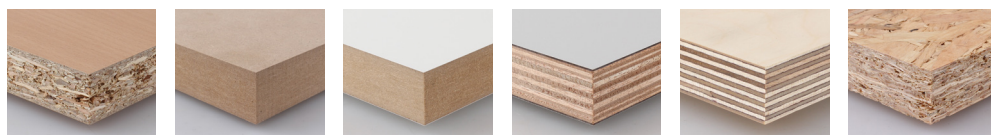
Depending on the diameter suitable up to 15500U/min  
feed rate from 6-12m/min use Z=2/2



Article no.	D	ND	SB	BO	LU	Z	RA	P	R/L	MA
C560-2A09L	57	50	9	20	6	2+2	R2	R1.3-R2/45°	L	Holz-Her(1827)
C560-2A09R	57	50	9	20	6	2+2	R2	R1.3-R2/45°	R	Holz-Her(1827)

## SPAREPARTS

Article no.	
KW.15714.7	Spare clamping screw 60° - M3x6 / Torx10
KW.22331.7/B25	Replaceable DP cutters "Mini" -Füge
KW.25762.7/B25	Replaceable DP cutters "Mini" - R1.3
KW.24489.7/B25	Replaceable DP cutters "Mini" - R2.0
KW.22331.7/B25	Replaceable DP cutters "Mini" - Fase 0.6x45°
C986-FT1810	Torque wrench for „Konstantin-Mini“, 1.8Nm, incl. Torx-Bit / T10



## Advantages Konstantin® DIA-Jointing cutterhead

### Many different advantages

+ Constant tool diameter due to exchange of blades, thus no time-consuming adjustment of the joining units necessary.

+ **Do it yourself:** Change the cutting edges yourself without a stop gauge and never give the diamond tool out of the house again.

+ Use high jointing cutters without hesitation, therefore more heavily loaded cutting edges can be exchanged for less heavily loaded cutting edges.

+ Cutting edges can be interchanged as required between the counter-rotating and synchronizing spindles.

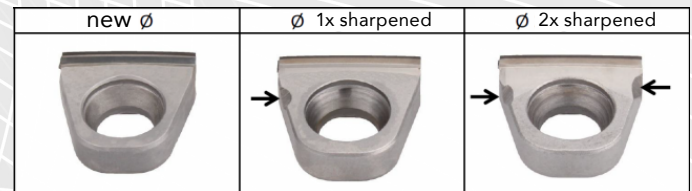
+ Spindle-friendly milling due to aluminum support body for noise-reduced and low-vibration milling.

+ Available for almost all common edge banding machines.

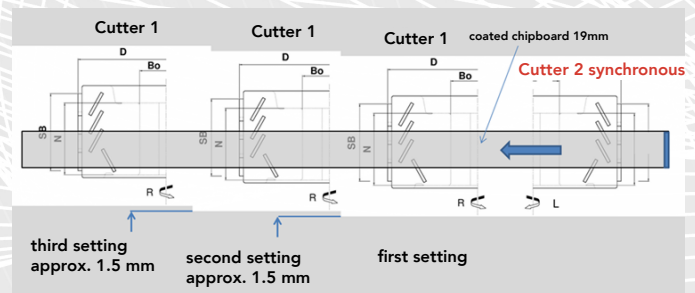


Highly sustainable due to reusable base bodies

### Resharpener scheme with notches



### Tool life extension due to height adjustment of the jointing cutter



### Change all knives yourself on site!

See also a video on YouTube:



**Do-it-yourself**



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**Aigner**  
PRECISION IN BEST TIME