



Length of the chips	Blade type		
10 - 15 mm	3/104 *		* Only in special case
15 - 25 mm	2/80		
20 - 30 mm	2/104		
20 - 30 mm	3/160	HS 21	LS 21
35 - 50 mm	1/80	HS 25	LS 25
35 - 50 mm	2/160	HS 28	LS 28
50 - 70 mm	1/104		HS 300
80 - 115 mm	1/160		
45 - 70 mm	2/220		
105 - 160 mm	1/220		LS 400 and LS 50

	Chips Standards				Screw choice				
	Std.	< 4 %	< 20 %	60-100 %	Chips length	80	104	160	220
1.	G30	< 1 mm	1-3 mm	3-16 mm	10-15 mm	---	(3/104)	---	---
2.	G50	< 1 mm	1-6 mm	6-32 mm	15-25 mm	2/80			
3.	G50	< 1 mm	1-6 mm	6-32 mm	20-30 mm		2/104	3/160	
4.	G50	< 1 mm	1-6 mm	6-63 mm	25-40 mm				3/220
5.	G100	< 1 mm	1-11 mm	11-63 mm	35-50 mm	1/80		2/160	
6.	G100	< 1 mm	1-11 mm	11-63 mm	45-70 mm				2/220
7.	G100	< 1 mm	1-11 mm	11-63 mm	50-70 mm		1/104		
8.	G120	< 1 mm	1-63 mm	63-100 mm	80-115 mm			1/160	
9.	G150	< 1 mm	1-100 mm	100-130 mm	105-160 mm				1/220