



MASTERIO FOR CNC



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RUBBER SEALS FOR VACUUM SUCTION CUPS

Rubber seals for vacuum suction cups (blocks) used on beam tables of CNC machining centers

APPLICATION

Used in blocks on single- or dual-circuit vacuum beam tables for CNC machines. Suitable for machining centers by Homag, Weeke, Biesse, IMA, Felder, SCM, Masterwood, Holz-Her, Busellato, and others.

ADVANTAGES

Excellent vibration resistance. High material durability. Easy installation. Soft rubber ensures strong adhesion to the workpiece. Improves machining precision. Compatible with most CNC machining centers. Compatible with OEM Homag and Schmalz products.

METHOD OF USE

The rubber seals are mounted on the vacuum block according to the mounting hole pattern.



MASTERIO **GG 001**

Used in CNC machines: Homag, Weeke, IMA

OEM No.: 4.011.11.0192

Compatible vacuum block height: 100 mm



160 MM



115 MM



MASTERIO **GG 002**

Used in CNC machines: Homag, Weeke, IMA, Felder, Holz-Her, Busellato, Reichenbacher, and others

OEM No.: 10.01.12.00488

Compatible vacuum block heights: 100, 85, 75, and 50 mm



140 MM



115 MM



MASTERIO **GG 003(+)**

Used in CNC machines: Homag, Weeke

OEM No.: 4.011.11.0196

Compatible vacuum block height: 100 mm



125 MM



75 MM



MASTERIO **GG 004(x)**

Used in CNC machines: Homag, Weeke, IMA, Felder, Holz-Her, Busellato, Reichenbacher, and others

OEM No.: 4.011.11.0196

Compatible vacuum block heights: 100, 85, 75, and 50 mm



125 MM



75 MM



MASTERIO **GG 005**

Used in CNC machines: Homag, Weeke, IMA, Felder, Holz-Her, Busellato, Reichenbacher, and others

OEM No.: 4.011.11.0196

Compatible vacuum block heights: 100, 85, 75, and 50 mm



120 MM



50 MM



MASTERIO **GG 011**

Used in CNC machines: Homag, Felder, SCM

OEM No.: 4.011.11.0196

Compatible vacuum block heights: 100 and 50 mm



140 MM



130 MM



MASTERIO **GG 006**

Used in CNC machines: Homag, Weeke, IMA, Felder, Holz-Her, Busellato, Reichenbacher, and others

OEM No. of the kit 10.01.12.00723 (Schmalz), 4-011-11-0249 (Homag).

OEM No. of the elements: rubber seal 10.01.12.00804, 10.01.12.00805 (Schmalz), 300-05-987 (Felder), suction rubber 10.01.12.01438 (Schmalz)

Compatible vacuum block heights: 100 and 50 mm



130 MM



30 MM



MASTERIO **GG 009**

Used in CNC machines: Homag, Weeke, IMA, Felder, Holz-Her, Busellato, Reichenbacher, and others (bottom rubber)

OEM No.: 10.01.12.00798 (Schmalz)

Compatible vacuum block heights: 125, 100, 85, 75, and 50 mm



140 MM



115 MM



CNC BLOCKS

Vacuum blocks (suction cups) for precise clamping of workpieces in CNC machining centers.

APPLICATION

Used on single- or dual-circuit vacuum beam tables in CNC machines. Suitable for machining centers by Homag, Weeke, Biesse, IMA, Felder, SCM, Masterwood, Holz-Her, Busellato, and others.

ADVANTAGES

Durable, high-precision construction manufactured using injection molding technology. Fast availability and cost-effective compared to original OEM components. Easy installation. Ensure precise clamping of workpieces.

METHOD OF USE

The blocks (suction cups) are mounted on vacuum beams, secured with a mechanical clamp, and held in place by vacuum through the lower rubber seal. The upper rubber seal uses vacuum to firmly secure the workpiece.



MASTERIO **BLOCK 10.01.12.00644**

Upper rubber suction surface: 125 × 75 mm

Lower rubber suction surface: 140 × 115 × 16.5 mm

OEM No.: 10.01.12.00644 (Schmalz), VN 000010 (Masterwood)

Height: 50 mm

Orientation: transverse

Compatible with: Homag, Weeke

Type: VCBL K2 125×75×50 Q

Compatible seals: upper suction rubber 10.01.12.00011, lower suction rubber 10.01.12.00798



MASTERIO **BLOCK 10.01.12.00447**

Upper rubber suction surface: 125 × 75 mm

Lower rubber suction surface: 140 × 115 × 16.5 mm

OEM No.: 10.01.12.00447 (Schmalz, Felder), 4-011-11-0073 (Homag), 4-011-11-0106 (Homag), 547 270 (Reichenbacher), VN 000020 (Masterwood)

Height: 100 mm

Orientation: transverse

Compatible with: Homag, Weeke, Felder

Type: VCBL K2 125×75×100 Q

Compatible seals: upper suction rubber 10.01.12.00011, lower suction rubber 10.01.12.00798



MASTERIO **BLOCK 10.01.12.00949**

Upper rubber suction surface: 160 × 115 mm

Lower rubber suction surface: 160 × 115 mm

OEM No.: 10.01.12.00949 (Schmalz), 2-056-017-0920 (Homag), 10-560-210 (IMA)

Height: 100 mm

Orientation: longitudinal

Compatible with: Homag, Weeke, IMA, Felder

Type: VCBL K2 160×115×100

Compatible seals: upper suction rubber 10.01.12.00921, lower suction rubber 10.01.12.00922



MASTERIO **BLOCK 10.01.12.00211**

Upper rubber suction surface: 125 × 75 mm

Lower rubber suction surface: 140 × 115 mm

OEM No.: 10.01.12.00211 (Schmalz), 4-011-11-0368 (Homag)

Height: 50 mm

Orientation: transverse

Compatible with: Homag, Weeke

Type: VCBL K2 125×75×50 Q

Compatible seals: upper suction rubber 10.01.12.00011, lower suction rubber 10.01.12.00228



MASTERIO **BLOCK 10.01.12.00210**

Upper rubber suction surface: 140 × 115 mm

Lower rubber suction surface: 140 × 115 mm

OEM No.: 10.01.12.00210 (Schmalz), 4-011-11-0367 (Homag)

Height: 50 mm

Orientation: longitudinal

Compatible with: Masterwood, Homag, Weeke, IMA, Felder, Holz-Her, Busellato

Type: VCBL K1 140×115×50

Compatible seals: upper suction rubber 10.01.12.00488, lower suction rubber 10.01.12.00228



MASTERIO **BLOCK 10.01.12.00770**

Upper rubber suction surface: 120 × 50 mm

Lower rubber suction surface: 140 × 115 mm

OEM No.: 10.01.12.00770 (Schmalz, Masterwood, Holz-Her), 4-011-11-0388 (Homag)

Height: 50 mm

Orientation: transverse

Compatible with: Masterwood, Homag, Weeke, IMA, Felder, Holz-Her, Busellato

Type: VCBL K1 120×50×50 Q

Compatible seals: upper suction rubber 10.01.12.00012, lower suction rubber 10.01.12.00228

CNC BLOCKS

Vacuum blocks (suction cups) for precise clamping of workpieces in Biesse CNC machining centers.

APPLICATION

Used on vacuum beam tables in Biesse CNC machining centers.

ADVANTAGES

Durable, high-precision construction manufactured using injection molding technology. Fast availability and cost-effective compared to original OEM components. Easy installation. Ensure precise clamping of workpieces.

METHOD OF USE

The blocks (suction cups) are mounted on vacuum beams using the 1405A0013 block holder and inserted into CTS, ATS, or EPS type sockets. The upper suction seal uses vacuum to securely hold the workpiece in place.



MASTERIO **BLOCK AS24M00360**

Upper rubber dimensions: 132 × 75 mm

Bottom mounting: block holder 1405A0013

OEM No.: AS24M00360 (Biesse)

Orientation: transverse

Height: 74 mm

Compatible with: Biesse Rover (various models), ATS beam tables

Compatible seals: 132 × 75 mm seal GG 013 and 4 mm sealing profile



MASTERIO **BLOCK 6308A0157**

Upper rubber dimensions: 132 × 146 mm

Bottom mounting: block holder 1405A0013

OEM No.: 6308A0157; 1614A0118 (Biesse)

Orientation: transverse

Height: 48 mm

Compatible with: Biesse, CTS, ATS, and EPS beam tables



MASTERIO **BLOCK 6308A0159**

Upper rubber dimensions: 132 × 75 mm

Bottom mounting: block holder 1405A0013

OEM No.: 6308A0159 (Biesse)

Orientation: transverse

Height: 48 mm

Compatible with: Biesse, CTS, ATS, and EPS beam tables

Compatible seals: 132 × 75 mm seal GG 013



MASTERIO **BLOCK AS24M00075**

Upper rubber dimensions: 132 × 54 mm

Bottom mounting: block holder 1405A0013

OEM No.: AS24M00075 (Biesse)

Orientation: transverse

Height: 74 mm

Compatible with: Biesse Rover A-S, Rover C9, Rover A Edge, Rover A Smart, and similar models; CTS, ATS, and EPS beam tables

Compatible seals: 132 × 54 mm seal GG 012



MASTERIO **BLOCK AS24M00421**

Upper rubber dimensions: 132 × 75 mm

Bottom mounting: block holder 1405A0013

OEM No.: AS24M00421 (Biesse)

Orientation: transverse

Height: 74 mm

Compatible with: Biesse Rover (various models), CTS, ATS, and EPS beam tables

Compatible seals: 132 × 75 mm seal GG 013



MASTERIO **BLOCK AS24M00361**

Upper rubber dimensions: 132 × 146 mm

Bottom mounting: block holder 1405A0013

OEM No.: AS24M00361 (Biesse)

Orientation: transverse

Height: 74 mm

Compatible with: Biesse Rover (various models), ATS beam tables

Compatible seals: 132 × 146 mm seal GG 014



MASTERIO **BLOCK 6308A0160**

Upper rubber dimensions: 132 × 54 mm

Bottom mounting: block holder 1405A0013

OEM No.: 6308A0160 (Biesse)

Orientation: transverse

Height: 48 mm

Compatible with: Biesse Rover (various models), ATS beam tables

Compatible seals: 132 × 54 mm seal GG 012



MASTERIO **BLOCK HOLDER 1405A0013**

Dimensions: 98 × 60 × 15 mm

Material: ABS plastic

Application: CTS, ATS, and EPS sockets in Biesse machining centers

Mounting method: hex socket screws

OEM No.: 1405A0013 (Biesse)

Compatible suction cups: 6308A0157, 6308A0159, 6308A0160, AS24M00360, AS24M00361, AS24M00421, AS24M00075

Packaging: 10 pcs

CNC BLOCK SEALS

Seals for vacuum suction cups (blocks) used on beam tables of CNC machining centers.

APPLICATION

Used in blocks on vacuum beam tables of types CTS, ATS, EPS (Biesse) as well as TVN, TV Flex, TV FlexMatic (SCM, Morbidelli). Suitable for Biesse, SCM, and Morbidelli CNC machining centers.

ADVANTAGES

Excellent vibration resistance. High material durability. Easy installation. Soft rubber ensures strong adhesion to the workpiece. Improve machining precision. Designed to fit most Biesse CNC machining centers.

METHOD OF USE

The seals are installed in the upper part of the vacuum block according to the mounting groove pattern.

MASTERIO **GG 012**



OEM No.: FNAW550127

Compatible with: Biesse Rover A / B / C CNC machining centers

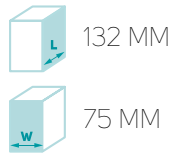
MASTERIO **GG 007**



OEM No.: 0390320645C

Compatible with: Morbidelli Accord, Record, Tech Z and SCM Author, Universal, Planet CNC machining centers

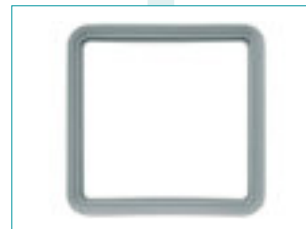
MASTERIO **GG 013**



OEM No.: FNAW550128

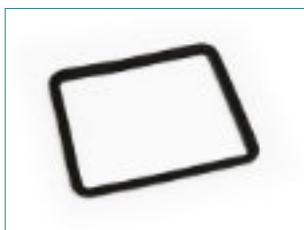
Compatible with: Biesse Rover A / B / C CNC machining centers

MASTERIO **GG 008**



Compatible with: Morbidelli Accord, Record, Tech Z and SCM Author, Universal, Planet CNC machining centers

MASTERIO **GG 014**



OEM No.: FNAW550129

Compatible with: Biesse Rover A / B / C CNC machining centers

MASTERIO **GG 010**



OEM No.: 0390320651E

Compatible with: Morbidelli Accord, Record, Tech Z and SCM Author, Universal, Planet CNC machining centers

SEALING PROFILES



Sealing profiles — flexible seals made of foamed rubber for sealing fixtures on CNC worktables.

APPLICATION

Used as seals in suction plates and vacuum blocks, as well as for creating clamping templates in the furniture industry.

ADVANTAGES

Closed-cell micro rubber — flexible and durable, good compensation of surface irregularities, ensures effective vacuum sealing.

METHOD OF USE

Installed by pressing the profile into dedicated grooves, allowing tight sealing with compensation of surface irregularities. Available in lengths from 1 to 50 running meters.

Cross-section	Dimensions	SKU
	dia. 4 mm	MAS-C-44-4
	dia. 6 mm	MAS-C-44-6
	dia. 6 mm	MAS-C-44-8
	6 × 8 mm	MAS-C-44-6x8
	6 × 10 mm	MAS-C-44-6x10
	8 × 10 mm	MAS-C-44-8x10

RBO SUCTION CUPS



RBO suction cup — a vacuum cup used for handling elements in the production process, applied in CNC machining centers and on RBO robot arms (stackers).

APPLICATION

Used in CNC centers and stackers for gripping and transferring panels and furniture boards after machining. Compatible with RBO Selecta, RBO Magnum, RBO Tornado, RBO Winner, and RBO Lifter machines.

ADVANTAGES

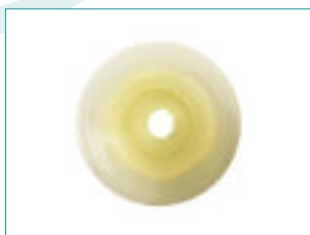
Large diameter ensures stable vacuum and secure grip. Simple design, compatible with various RBO models.

METHOD OF USE

Mounted directly on the vacuum block on the RBO robot arm (stacker).

SPARE PARTS

Body and suction rubber.



MASTERIO PRESSURE BEAM TAPE FOR PANEL SAW 20 × 6 MM



Self-adhesive polyurethane foam for stabilizing the pressure beam of a panel saw.

APPLICATION

Used to stabilize the pressure of laminated boards on the worktable of a panel saw. The foam is designed for Homag, Holzma, KDT, and Nanxing panel saws.

OEM No.: 4-699-95-0759.

ADVANTAGES

Flexible and resilient. Stabilizes pressure and reduces vibrations. Compensates for surface irregularities and protects against air or dust leakage.

METHOD OF USE

The foam is applied to the edges of the pressure beam and to the worktable of the panel saw.

LAMELLAS FOR HOLZMA



Protective lamellas for Holzma panel saws.

APPLICATION

Protection of the panel saw table, securing the entry point of the workpiece into the machine. Width: 30 mm; lengths: 230, 235, and 270 mm.

OEM Nos.: 2-032-65-4050, 2-035-65-4060, 3-416-01-3460, 3-401-01-6230.

ADVANTAGES

Improved operator safety. Increased machining precision and cleanliness.

METHOD OF USE

Installed directly at the entry point of the workpiece into the machine, forming a curtain.

AIR FLOTATION BALL VALVES FOR PANEL SAWS

APPLICATION

Air flotation ball valves for the movement and positioning of panels on air flotation tables used in the processing of furniture panels and wood, particularly on panel saws.

ADVANTAGES

Enable smooth and uniform movement of panels on the air flotation table. The ball valve design ensures low-friction movement and helps reduce contact and wear on the panel surface. Facilitate the efficient handling and processing of furniture panels. Easy to install. Simple and reliable construction.

METHOD OF USE

Installed in the air flotation table. The ball valves are fitted into the table openings to allow unobstructed airflow and facilitate smooth movement of panels across the table surface.

				
SKU	MAS-P-72-18x123	MAS-P-72-18x123	MAS-P-72-18x123	MAS-P-72-18x123
for saws	Homag, Holzma, KDT	Selco, Scheling, Biesse, Holzher, Giben	Homag, Holzma, SCM, Biesse, KDT, Felder	SCM, Gabbiani, Sigma
OEM No.	2-052-66-1281, 2-052-66-2590, 2-052-66-2600, 60170200035	L9402403100	no data available	29L0426330G, 2714159700E
outer diameter	15 mm	15 mm	14 mm	14 mm
height	20 mm	14 mm	20 mm	15 mm
flange diameter	18 mm	14 mm	14 mm	16 mm

MASTERIO OIL CGLP/CNC 68



Specialized oil for centralized lubrication of CNC machines.

APPLICATION

For lubrication of slideways and bearings in CNC machines, printing machines, textile machines, bed guides, as well as hydraulic gears and chains.

Equivalents: Homag 4 017 01 1038, Turmogearoil CGLP 68, MagLube LD-300L.

ADVANTAGES

Contains adhesive additives that eliminate stick-slip effect and oil runoff. Maintains a stable low-friction lubricating film, improving the performance of precision guides. Supports both hydraulic and centralized lubrication systems.

Viscosity grade: ISO VG 68.

METHOD OF USE

Applied through centralized lubrication systems—pumped and dosed directly to lubrication points of guides and gear systems.

MASTERIO GREASE 2015

High-speed grease for CNC applications.

APPLICATION

Designed for high-speed spindle bearings in CNC machines, milling machines, grinders, textile machines, and electric motors.

Equivalents: Isoflex NBU15, Turmogrease Highspeed L252.

ADVANTAGES

Low friction coefficient reduces bearing heating. Excellent lubrication at very low temperatures. Oxidation-resistant and corrosion-protective. Water-resistant.

Operating temperature range: -55 to +120°C (short-term up to +140°C).

METHOD OF USE

Apply a thin layer with a brush to cleaned and degreased moving parts—spindles, rolling and sliding bearings. In centralized systems, apply via grease nipple into the lubrication system.



MASTERIO GREASE 3035

Lithium-calcium grease for linear, rolling, and sliding applications in CNC machines.

APPLICATION

For lubrication of guides, drive mechanisms, rolling and sliding bearings, and other CNC machine components.

Equivalents: Homag 4-017-02-0035, 30115 Super Lube XYZ.

ADVANTAGES

Excellent wear and corrosion resistance. High mechanical stability. Plastic grease with good penetration. Provides long-term protection against wear. Suitable for demanding industrial conditions.

Operating temperature range: -50 to +150°C.

METHOD OF USE

Apply a thin layer to moving parts using a grease gun, brush, or appropriate application tools.





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- › Rubber seals for CNC vacuum blocks
- › CNC vacuum block seals
- › CNC beam table blocks
- › CNC sealing profiles
- › Suction cups for stackers (RBO robots)
- › Lamellas for panel saw curtains
- › Feed rollers (ball transfer units)
- › Greases and oils for CNC