WEINIG HOLZ-HER

TOOLING & SUPPLY CATALOG

Use the Best on the Best—It Really Makes a Difference

MRO Mirror Reflections Custom Moulding Knives

24th Edition / US 2424

Effective June 2024

Current prices available online at **tooling.weinigusa.com**

WELCOME TO WEINIG TOOLING

Using the Best on the Best

Weinig tooling can improve the performance of any woodworking moulder and, for maximum performance, we recommend all our machines be equipped with original Weinig tooling. We ask only that you try the products shown in this catalog. Once you experience the benefits of using Weinig tooling, we know you'll continue to "Use the Best on the Best – It Really Makes a Difference."

The Weinig Group

For decades, the name Weinig has been synonymous with superior quality. Weinig customers have access to service and technological aptitude that only a company with our capabilities and size can provide. Our customers don't just buy a moulder, grinder, ripsaw or tooling. They buy Weinig.

The Weinig Group maintains its market leadership by concentrating strongly on customer support. A staff of factory-trained, in-house and field service technicians supports new and existing customers with installation, maintenance and training. A comprehensive inventory of spare parts and tooling assures quick delivery to satisfy customer requirements.

We value your business and are continually looking for new innovative products that will help you run your operations more efficiently. While we make every effort to maintain competitive pricing in this ever-changing world economy, cost fluctuations which are beyond our control may occur before our next published catalog. All prices in this catalog and on our website are subject to change without notice.

Pricing Subject to Change

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CONVENIENT WAY TO ORDER:

Phone:1.801.451.5987 **Email: rr@mirror-reflections.com**
Fax: 1.801.451.5987

PowerLock Tooling

Please check our website or call for the most current prices.

PowerLock is Weinig's innovative clamping system for our certified moulder tooling with Hollow Shank Taper (HSK) for locking the tooling rigidly to the HSK receiver. Used initially in the metalworking industry, this quick changeover technology gains its accuracy from positive clamping on three main surfaces: outer taper, internal clamping area, and receiver.

With an actual clamping force even stronger than traditional thread-lock or hydro-lock moulder tooling, PowerLock tooling has an axial and radial positioning accuracy of 0.0001. The axial positioning is determined by face-to-face contact between the cutterhead and the tool-holder, while radial positioning is a result of the high-tolerance mating tapers.

Now used on Weinig's new Powermat moulders, PowerLock tooling allows higher spindle speed (up to 12,000 rpm) with a smaller tool. The result is better product finish quality.

You can depend on PowerLock tooling for the highest rigidity, quick changeover and lowest tool run-out. It is suitable for applications ranging from heavy-duty to high-speed machining, and offers lighter tooling for higher RPM's and ease of handling.

PowerLock is currently used for conventional moulding production. It is available in a large variety of cutting tool configurations and is available from Weinig stock, including:

- Corrugated cutters (pages 4-5)
- Insert planerheads (pages 6-7, 9)
- Profile insert, universal tooling system (page 8)
- For Powermat moulders with reduced spindle rpm at a maximum 8,000 rpm—you also can use your existing conventional tooling on PowerLock spindle adapters (page 9).
- For applications that require specialized custom tooling, we will assist you to provide solutions for your unique applications..

Get the best finish quality available from PowerLock tooling. Contact Weinig today!

THE ORIGINAL WEINIG CUTTERHEADS: Extremely Flexible and Absolutely True to Profile!

Weinig Corrugated PowerLock Tools are superior in construction when compared to other manufacturers. Our stringent manufacturing processes allow for true cutting performance that enables speeds up to 12,000 RPM for faster feed speeds and reduced cost per unit and shortened delivery times—all this and outstanding surface quality.

All PowerLock cutterheads are stocked with clamping wedges for up to 5/16" knife material. Gibs for 3/8" knife material available upon request.

CUSTOM TOOLING AVAILABLE PER REQUEST, INLCUDING 3 & 6 WINGS CONFIGURATIONS

TOOL DIAMETER 90MM

ARTICLE NUMBER	WIDTH		NO. OF KNIFE SLOTS	CUTTING ANGLE	SPINDLE USE	PRICE
	MM	INCHES				
12016432	40	1 9/16	2	20°	L/B	$421
12015148	60	2 23/64	2	20°	L/B	$442
12015151	80	3 9/64	2	20°	L/B	$490
12015153	100	3 15/16	2	20°	L/B	$559
12015154	130	5 1/8	2	20°	L/B	$682
12015156	170	6 11/16	2	20°	L/B	$746
12015160	240	9 29/64	2	20°	Bottom	$916
12016425	310	12 13/64	2	20°	Bottom	$1,235
12016433	40	1 9/16	2	20°	R/T	$421
12015161	60	2 23/64	2	20°	R/T	$442
12015162	80	3 9/64	2	20°	R/T	$490
12015163	100	3 15/16	2	20°	R/T	$559
12015164	130	5 1/8	2	20°	R/T	$682
12015167	170	6 11/16	2	20°	R/T	$746
12015172	240	9 29/64	2	20°	Top	$916
12016426	310	12 13/64	2	20°	Top	$1,235
12016407	40	1 9/16	2	12°	L/B	$421
12015173	60	2 23/64	2	12°	L/B	$442
12015174	80	3 9/64	2	12°	L/B	$490
12015175	100	3 15/16	2	12°	L/B	$559
12015176	130	5 1/8	2	12°	L/B	$682
12015178	170	6 11/16	2	12°	L/B	$746
12015183	240	9 29/64	2	12°	Bottom	$916
12016412	310	12 13/64	2	12°	Bottom	$1,235
12016406	40	1 9/16	2	12°	R/T	$421
12015185	60	2 23/64	2	12°	R/T	$442
12015186	80	3 9/64	2	12°	R/T	$490
12015187	100	3 15/16	2	12°	R/T	$559
12015188	130	5 1/8	2	12°	R/T	$682
12015190	170	6 11/16	2	12°	R/T	$746
12015194	240	9 29/64	2	12°	Top	$916
12016413	310	12 13/64	2	12°	Top	$1,235

Prices Subject to Change

SIZES SHOWN ARE AVAILABLE FROM STOCK. CALL FOR PRICING ON NON-STOCK TOOLS.

PowerLock Cutterhead Type 538

TOOL DIAMETER 90MM

ARTICLE NUMBER	WIDTH		NUMBER OF KNIFE SLOTS	CUTTING ANGLE	SPINDLE USE	PRICE
	MM	INCHES				
538-096-21	60	2 23/64	4	20°	L/B	$810
538-096-23	100	3 15/16	4	20°	L/B	$932
538-096-24	130	5 1/8	4	20°	L/B	$1,140
538-096-26	170	6 11/16	4	20°	L/B	$1,240
538-096-27	240	9 29/64	4	20°	Bottom	$1,528
538-096-31	60	2 23/64	4	20°	R/T	$810
538-096-33	100	3 15/16	4	20°	R/T	$932
538-096-34	130	5 1/8	4	20°	R/T	$1,140
538-096-36	170	6 11/16	4	20°	R/T	$1,165
538-096-37	240	9 29/64	4	20°	Top	$1,528
538-096-61	60	2 23/64	4	12°	L/B	$810
538-096-63	100	3 15/16	4	12°	L/B	$932
538-096-66	170	6 11/16	4	12°	L/B	$1,240
538-096-67	240	9 29/64	4	12°	Bottom	$1,528
538-096-71	60	2 23/64	4	12°	R/T	$810
538-096-73	100	3 15/16	4	12°	R/T	$932
538-096-76	170	6 11/16	4	12°	R/T	$1,240
538-096-77	240	9 29/64	4	12°	Top	$1,528

Weinig's 4-knife versions are manufactured with the same care as all of our PowerLock tooling. Our 4-knife offering allows for higher feed speeds while maintaining the correct chip load and knife mark calculations. All of the stock offering is rated for 12,000 RPM. These are excellent selections for variable RPM machines.

All PowerLock cutterheads are stocked with clamping wedges for up to 5/16" knife material. Gibs for 3/8" knife material available upon request.

CUSTOM TOOLING AVAILABLE PER REQUEST, INLCUDING 3 & 6 WINGS CONFIGURATIONS

SIZES SHOWN ARE AVAILABLE FROM STOCK.
CALL FOR PRICING ON NON-STOCK TOOLS.

Prices Subject to Change

Shear Design For Better Finish

TOOL DIAMETER 110MM

ARTICLE NUMBER	WIDTH		SPINDLE USE	# OF INSERTS	PRICE
	MM	INCHES			
XXX64023	120	4-23/32	L/B	24	$1,330
XXX64026	170	6-11/16	L/B	34	$1,565
XXX64027	240	9-29/64	Bottom	48	$1,915
XXX640281	270	10-5/8	Bottom	54	$2,470
XXX640282	330	13	Bottom	66	$3,640
XXX64033	120	4-23/32	R/T	24	$1,330
XXX64036	170	6-11/16	R/T	34	$1,565
XXX64037	240	9-29/64	Top	48	$1,915
XXX640381	270	10-5/8	Top	54	$2,470
XXX640382	330	13	Top	66	$3,640

SIZES SHOWN ARE AVAILABLE FROM STOCK.

Each cutterhead includes a full set of installed inserts.

Replacement Carbide Insert Knives

XXX637100 (Sold in packs of 10pcs) 15 x 15 x 2.5mm $3.68 ea

Replacement Screws for Insert Knives

XXX637105 $3.00 ea

Using a spiral-cut tool on natural wood can make the cutting process smoother, often dramatically improving finish quality. These advantages are particularly beneficial when cutting material that is cross-grained, knotty, or of a "stringy" layered structure.

- Similar in design to standard spiral planerheads shown on page 14, but with an integrated HSK taper. For exclusive use on all HSK Weinig Powermat moulders.
- Rated for maximum speed of 12,000 rpm up to 240mm width
- Rated for maximum speed of 8,000 rpm over 240mm width
- Noise reduction (up to 20 decibels)
- Reduced cutting pressure (up to 20%)
- Reduced tearing
- Less severe cutting action
- Less tendency to create chip dents
- Less raised grain
- Should a knife nick occur, only a single 4-sided insert knife must be rotated or replaced. No grinding required.
- Insert knives uniquely designed with a slight convex curve on the cutting edge to prevent lines from appearing on the surface.

IMPORTANT NOTE:
Do not mismatch replacement carbide insert knives. All knives must be from the same supplier to ensure that balance is not affected.

Prices Subject to Change

PowerLock CentroLock Planerheads & PowerLock Combi-Head

Weinig is now offering the popular CentroLock planerhead and the versatile Combi-Head with our HSK taper for our PowerMat mounders.

PowerLock CentroLock Planerhead

All diameters 100mm x 2 wing

ARTICLE NUMBER	WIDTH		SPINDLE POSITION	PRICE	REPLACEMENT KNIFE			
	MM	INCHES			HSS		CARBIDE	
XXX65013	100	3-15/16	L/B	$1,150	507920100	$4.73	507921100	$38.55
XXX65023	170	6-11/16	L/B	$1,360	507920170	$10.92	507920170	$59.35
XXX65033	240	9-29/64	L/B	$1,852	507920240	$14.70	507921240	$82.45
XXX66013	100	3-15/16	R/T	$1,150	507920100	$4.73	507921100	$38.55
XXX66023	170	6-11/16	R/T	$1,360	507920170	$10.92	507921170	$59.35
XXX66033	240	9-29/64	R/T	$1,852	507920240	$14.70	507921240	$82.45

PowerLock Combi-Head

All diameters 100mm x 2+2 wing

ARTICLE NUMBER	WIDTH		SPINDLE POSITION	PRICE	REPLACEMENT KNIFE			
	MM	INCHES			HSS		CARBIDE	
XXX672258	230	9	L/B	$1,894	507920230	$4.73	507921230	$38.55
XXX672257	230	9	R/T	$1,894	507920230	$10.92	507921230	$59.35

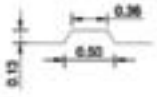
XXX674014

XXX674018

XXX674045

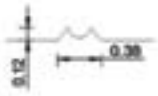
XXX674124

XXX674128



XXX674129

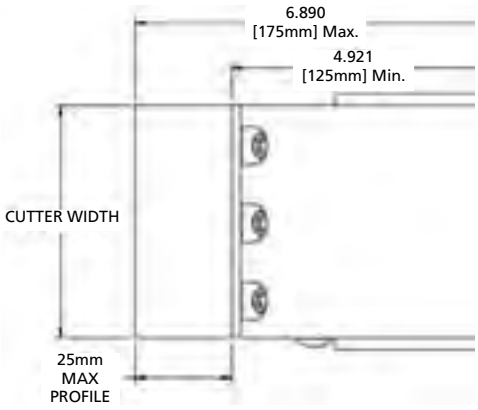
XXX674025



Knife and Gib pricing on page 16

Prices Subject to Change

PowerLock Universal Profile Insert Tooling System



- Similar in design to our standard profile tooling system shown on page 17, but with an integrated HSK taper for exclusive use on all Weinig Powermat moulders.
- Rated for operation up to 12,000 rpm.

Additional Specifications:

- Carbide inserts
- Use on both hardwoods and softwoods
- Profile backers are a one-time purchase. Reusable with new inserts
- Create multiple profiles using inserts with the same tool body
- New design with a positive locking and locating system for insert knives
- Cutting circle: 150mm maximum; 100mm minimum

Custom Tool Bodies, Carbide Profile Inserts and Backs Available
Contact your Weinig Expert for details.

Profile Insert Tool Body

ARTICLE NUMBER	KNIVES PER TOOL BODY	SPINDLE USE	CUTTER WIDTH	PRICE
XXX68435	2	L/B	35mm	$780
XXX68535	2	R/T	35mm	$780
XXX68460	2	L/B	60mm	$920
XXX68560	2	R/T	60mm	$920
XXX68635	3	L/B	35mm	$970
XXX68735	3	R/T	35mm	$970
XXX684603	3	L/B	60mm	$1,095
XXX685603	3	R/T	60mm	$1,095

Carbide Insert Profile Knives and Backers – In stock, available for immediate delivery

XXX662160	Straight knife backer only	$49
XXX662150	Tongue profile backer only	$49
XXX662150MB	Tongue microbevel backer only	$49
XXX662150SQ	Square edge tongue profile backer only	$49
XXX662173	Tongue centermatch backer only	$49
XXX662183	Tongue V-panel backer only	$49
XXX662179	Tongue 1/2" profile backer only	$49
XXX662155	Groove profile backer only	$49
XXX662155MB	Groove microbevel backer only	$49
XXX662155SQ	Square edge groove profile backer only	$49
XXX662171	Groove centermatch backer only	$49
XXX662181	Groove V-panel backer only	$49
XXX662177	Groove 1/2" profile backer only	$49
XXX662131	Straight knife insert knife	$39
XXX662100	Tongue profile insert knife	$39
XXX662100MB	Tongue microbevel profile insert knife	$39
XXX662100SQ	Square edge tongue profile insert knife	$39
XXX662172	Tongue centermatch profile insert knife	$39
XXX662182	Tongue V-panel profile insert knife	$39
XXX662178	Tongue 1/2" profile insert knife	$39
XXX662105	Groove profile insert knife w/0.030" gap	$39
XXX662115	Groove profile insert knife w/0.010" gap	$39
XXX662120	Groove profile insert knife w/0.005" gap	$39
XXX662115MB	Groove microbevel profile insert knife	$39
XXX662115SQ	Square edge groove profile insert knife	$39
XXX662170	Groove centermatch profile insert knife	$39
XXX662180	Groove V-panel profile insert knife	$39
XXX662176	Groove 1/2" profile insert knife	$39

Prints for each profile are available upon request or viewable from our website **tooling.weingusa.com**.

New Improved Knife and Gib System

Alternating shear face planerhead with replaceable knife system—Weinig's solution for a superb finish on difficult materials.

- Standard replaceable carbide inserts that can be exchanged in minutes
- Reduced tearout due to the alternating shear cutting action
- No grinder required
- Certified for usage up to 12,000 rpm

ARTICLE NUMBER	DESCRIPTION	SPINDLE USE	PRICE
XXX64084	Powerlock 125 x 50, Z4	L/B	$1,140
XXX64094	Powerlock 125 x 50, Z4	R/T	$1,140
XXX100260	Replaceable Inserts		$4.95
XXX635506	Replacement Gibs		$39.60
XXX635507	Replacement Gib Screw		$3.50
XXX635050	Original Design Replacement Insert		$5.00

PowerLock Spindle Adapters

—For use with conventional tools on Powermat moulders

Maximum 8,000 rpm
Other sizes available upon request

Equipped with spindle nut and safety ring, without spacers

323-9215411	1 1/4" x 120mm (vertical spindle only)	$897
323-9169486	1 1/2" x 100mm	$850
323-037027	1 1/2" x 170mm	$928
323-027008	1 1/2" x 240mm	$983
323-9143776	40mm x 100mm	$850
323-03752	40mm x 170mm	$928
323-02752	40mm x 240mm	$983
323-9120151	1 13/16" x 100mm	$850
323-9114936	1 13/16" x 170mm	$928
323-027003	1 13/16" x 240mm	$983

Prices Subject to Change

PowerLock Mobile Tool Cart

Mobile tool transporter specifically for PowerLock tools. Comes with one stationary shelf, one adjustable shelf, and three tool-tray holders. Holds a total of 18 PowerLock tools. Identical to the units used in the Weinig demo room.

TOOLCART-HSK63 $2,150

Toolholder - Tray $150

Transport Cart Toolholder Tray
with Mounting Brackets

Toolholder - HSK63 $21.50

Transport Cart Insert

Toolholder - Shelf for HSK63 $95

Transport Cart Adjustable Shelf

PowerLock Mounting Device for Knife Exchange

A solution for easier knife steel installation/removal on PowerLock tooling. This device offers manual clamping and releasing, fastening holes for table mounting, and a 90° swiveling tool receiver.

XXX646085 $985

PowerLock Receiver Taper Cleaning Device

Cleanliness is an absolute necessity when working with PowerLock tooling. Keep the receiver clean with this special taper cleaning device.

006-03226 $64

PowerLock HSK Tool Taper Cleaning Device

Maintain necessary cleanliness on the taper of your PowerLock tool with this special cleaning device.

006-03229 $79

PowerLock Knife Setting Gauge

For proper installation of corrugated knives, as shown on page 65.

507-330001 **For 90mm OD tools** $62
507-330004 **For 115mm OD tools** $104

PowerLock Tool Blank

Dummy plug to be used when HSK spindle is not in use. Also used during calibration.

323-027007 $385

Gib Screw Torque Wrench

Preset at 23 ft/lbs, specifically for use on all Weinig cutterheads. Now includes hex bit.

XXX100428K $387

Gib Screw Allen Wrench M6

Curved with handle for manual tightening of cutterhead gib screws.

006-00210 $15

Prices Subject to Change

Hydro-Cutterhead Type 504

Hydraulic Clamping

- Standard cutting angle 20°, or 12° for selected hardwoods that present tear-out problems.
- Maximum tolerance of concentricity (true running accuracy) 0.005mm (0.000197")
- Hydraulic grease fitting and pressure-release valve located on each side of hydro-head
- Designed for use with 1/4", 5/16"or 3/8" thick knives with 16-60° corrugated back
- Maximum 8,000 rpm
- HydroLock Clamping System produces a more concentric cutting circle
- The result is a deviation of only 0.005mm (0.000197") of the individual knives
- Custom tooling available with different cutting angles and knife configurations
- Outstanding surface quality with top feed speeds

TOOL DIAMETER 150MM (5 29/32")

ARTICLE NUMBER	WIDTH		NUMBER OF KNIFE SLOTS	CUTTING ANGLE	BORE DIAMETER	PRICE
	MM	INCHES				
504-150-83	60	2 23/64	4	20°	1 13/16"	$697
504-150-02	100	3 15/16	4	20°	1 13/16"	$925
504-150-08	150	5 29/32	4	20°	1 13/16"	$1,071
504-150-11	230	9 1/16	4	20°	1 13/16"	$1,325
504-150-84	60	2 23/64	4	20°	2 1/8"	$697
504-150-03	100	3 15/16	4	20°	2 1/8"	$925
504-150-09	150	5 29/32	4	20°	2 1/8"	$1,071
504-150-12	230	9 1/16	4	20°	2 1/8"	$1,325
514-150-21	60	2 23/64	4	12°	1 13/16"	$697
504-150-38	100	3 15/16	4	12°	1 13/16"	$925
504-150-44	150	5 29/32	4	12°	1 13/16"	$1,072
504-150-47	230	9 1/16	4	12°	1 13/16"	$1,325
514-150-39	60	2 23/64	4	12°	2 1/8"	$697
504-150-39	100	3 15/16	4	12°	2 /18"	$925
504-150-45	150	5 29/32	4	12°	2 1/8"	$1,071
504-150-48	230	9 1/16	4	12°	2 1/8"	$1,325
504-150-86	60	2 23/64	6	20°	1 13/16"	$836
504-150-20	100	3 15/16	6	20°	1 13/16"	$1,045
504-150-26	150	5 29/32	6	20°	1 13/16"	$1,136
504-150-29	230	9 1/16	6	20°	1 13/16"	$1,563
504-150-87	60	2 23/64	6	20°	2 1/8"	$836
504-150-21	100	3 15/16	6	20°	2 1/8"	$1,045
504-150-27	150	5 29/32	6	20°	2 1/8"	$1,136
504-150-30	230	9 1/16	6	20°	2 1/8"	$1,563
514-150-22	60	2 23/64	6	12°	1 13/16"	$836
504-150-56	100	3 15/16	6	12°	1 13/16"	$1,045
504-150-62	150	5 29/32	6	12°	1 13/16"	$1,136
504-150-65	230	9 1/16	6	12°	1 13/16"	$1,563
514-150-30	60	2 23/64	6	12°	2 1/8"	$836
504-150-57	100	3 15/16	6	12°	2 1/8"	$1,045
504-150-63	150	5 29/32	6	12°	2 1/8"	$1,136
504-150-66	230	9 1/16	6	12°	2 1/8"	$1,563

SIZES SHOWN ARE AVAILABLE FROM STOCK.

Other dimensions available upon request.

See Weinig Cutterhead Quality Assurance Guarantee on page 21.

Prices Subject to Change

Conventional Cutterhead Type 503

Straight Bore

TOOL DIAMETER 122MM (4 13/16") ON CUTTERHEADS WITH 1 1/2" BORE
TOOL DIAMETER 137MM (5 13/32") ON CUTTERHEADS WITH 1 13/16" BORE

ARTICLE NUMBER	WIDTH		NUMBER OF KNIFE SLOTS	CUTTING ANGLE	BORE DIAMETER	PRICE
	MM	INCHES				
503-122-48	60	2 23/64	2	20°	1 1/2"	$297
503-122-54	100	3 15/16	2	20°	1 1/2"	$340
503-122-57	130	5 1/8	2	20°	1 1/2"	$410
513-123-20	170	6 11/16	2	20°	1 1/2"	$455
503-122-66	230	9 1/16	2	20°	1 1/2"	$495
513-123-03	240	9 29/64	2	20°	1 1/2"	$533
513-122-92	60	2 23/64	2	12°	1 1/2"	$297
513-122-93	100	3 15/16	2	12°	1 1/2"	$340
513-122-94	130	5 1/8	2	12°	1 1/2"	$410
513-123-21	170	6 11/16	2	12°	1 1/2"	$455
513-122-97	230	9 1/16	2	12°	1 1/2"	$495
513-122-98	240	9 29/64	2	12°	1 1/2"	$533
503-137-02	60	2 23/64	4	20°	1 13/16"	$418
503-137-05	100	3 15/16	4	20°	1 13/16"	$477
503-137-08	130	5 1/8	4	20°	1 13/16"	$538
513-137-39	170	6 11/16	4	20°	1 13/16"	$584
503-137-17	230	9 1/16	4	20°	1 13/16"	$743
503-137-86	240	9 29/64	4	20°	1 13/16"	$792
503-137-44	60	2 23/64	4	12°	1 13/16"	$418
503-137-47	100	3 15/16	4	12°	1 13/16"	$477
503-137-50	130	5 1/8	4	12°	1 13/16"	$538
513-137-74	170	6 11/16	4	12°	1 13/16"	$584
503-137-59	230	9 1/16	4	12°	1 13/16"	$743
513-137-51	240	9 29/64	4	12°	1 13/16"	$792

- Standard cutting angle 20°, or 12° for selected hardwoods that present tear-out problems
- Designed for use with 1/4", 5/16"or 3/8" thick knives with 16-60° corrugated back
- Maximum 8,000 rpm
- Our bore tolerance is .0019" (H7) —Highest in the industry!
- Custom tooling available with different cutting angles and knife configurations

SIZES SHOWN ARE AVAILABLE FROM STOCK.

Other dimensions available upon request.

See Weinig Cutterhead Quality Assurance Guarantee on page 21.

Prices Subject to Change

For Non-jointed Applications of 80 FPM or Less

Spiral Planerhead

Using a spiral planerhead on natural wood can make the cutting process smoother, often dramatically improving finish quality. These advantages are particularly beneficial when cutting material that has a cross grain or knotty structure.

- Noise reduction (up to 20 decibels)
- Reduced cutting pressure (up to 20%)
- Reduced tearing and less severe cutting action
- Less impact on spindle bearings
- Less tendency to create chip dents and less raised grain
- Should a knife nick occur, only a single 4-sided insert knife must be rotated or replaced. No grinding required.
- Insert knives uniquely designed with a slight convex curve on the cutting edge to prevent lines from appearing on the wood surface.
- Maximum speed of 10,000 rpm

Each planerhead includes a full set of installed inserts.

Manufactured from Steel or Aluminum

Can be Mounted on Hydro Sleeves

ARTICLE NUMBER	WIDTH		OUTSIDE DIAMETER MM	BORE DIAMETER	# OF INSERTS	PRICE
	MM	INCHES				
XXX630012*	75	2 21/64	110	1 1/2"	14	$567
XXX630013	100	3 15/16	125	1 1/2"	20	$640
XXX630019	170	6 11/16	125	1 1/2"	34	$874
XXX630005	230	9 1/16	125	1 1/2"	46	$1,187
XXX630010	240	9 29/64	125	1 1/2"	48	$1,268
XXX630015	270	10 5/8	125	1 1/2"	54	$1,950
XXX630205	100	3 15/16	140	1 13/16"	20	$764
XXX630214	170	6 11/16	140	1 13/16"	34	$1,015
XXX630220	230	9 1/16	140	1 13/16"	46	$1,297
XXX630225	240	9 29/64	140	1 13/16"	48	$1,300
XXX630230	270	10 5/8	140	1 13/16"	54	$1,995

* Special small diameter for use on left spindle to extend width capacity.

Rebate cutter can be paired with Spiral Cutterhead. Please confirm diameter.

Replacement Parts

XXX637100	Carbide Insert Knives	15 x 15 x 2.5mm	$3.68
XXX637105	Screws for Insert Knives		$3.00

Hydro Spiral Planerhead

Hydro Spiral Planerhead

Specialty safety collar required.

XXX622750	160 x 310 x 1-13/16"	Z4+4	$3,870
XXX637100	15 x 15 x 2.5mm		$3.68

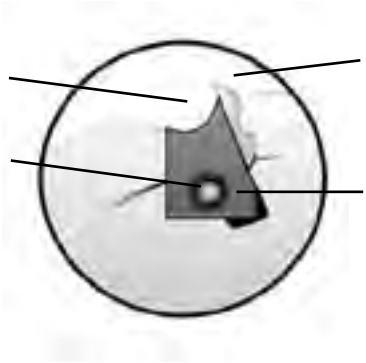
Hydro Helical HSS Solid Knife Planerhead available

Insert Planing Cutterhead Type 530 CentroLock

Featuring Full-length Reversible Insert Knives

Extra large gullet design for exceptional chip removal.

Automatic positioning and two-screw CentroLock clamping design for rapid knife changeover.



Replaceable reversible knives eliminate grinding.

Centrifugal force automatically holds the wedge and knife in the cutterhead.

Maximum speed of 8,000 rpm.

Solid body construction for noise reduction and quiet running.

CentroLock 530 Cutterheads (Steel Body)

ARTICLE NUMBER	WIDTH		OUTSIDE DIAMETER MM	NUMBER OF INSERTS	BORE DIAMETER	PRICE (EACH)
	MM	INCHES				
530-125-33	60	2-23/64	125	2	1-1/2″	$599
530-125-39	100	3-15/16	125	2	1-1/2″	$790
530-125-42	170	6-11/16	125	2	1-1/2″	$910
530-125-54	230	9-1/16	125	2	1-1/2″	$1,095
530-125-67	240	9-29/64	125	2	1-1/2″	$1,195

Each cutterhead comes equipped with a set of HSS knives.

Other dimensions available upon request.

Special Aluminum Body Cutterhead

ARTICLE NUMBER	WIDTH		OUTSIDE DIAMETER MM	NUMBER OF INSERTS	BORE DIAMETER	PRICE
	MM	INCHES				
530-125-71	240	9 29/64	125	2	1 1/2″	$1,270

Replacement Reversible Knives for CentroLock 530 Cutterheads

HSS Knives

ARTICLE NUMBER	WIDTH		PRICE
	MM	INCHES	
507-920060	60	2-23/64	$4.73
507-920100	100	3-15/16	$7.89
507-920130	130	5-1/8	$8.35
507-920150	150	5-29/32	$9.98
507-920170	170	6-11/16	$10.92
507-920190	190	7-31/64	$11.80
507-920230	230	9-1/16	$14.18
507-920240	240	9-29/64	$14.70
507-920270	270	10-5/8	$7.35
507-920310	310	12-13/64	$21.00

Carbide Knives

ARTICLE NUMBER	WIDTH		PRICE
	MM	INCHES	
507-921060	60	2-23/64	$28.30
507-921100	100	3-15/16	$38.55
507-921130	130	5-1/8	$48.30
507-921150	150	5-29/32	$54.10
507-921170	170	6-11/16	$59.35
507-921190	190	7-31/64	$66.15
507-921230	230	9-1/16	$78.25
507-921240	240	9-29/64	$82.45
507-921270	270	10-5/8	$91.35
507-921310	310	12-13/64	$101.60

PRICED PER INDIVIDUAL KNIFE. (Sold in packs of 2)

Designed for exclusive use with Type 530 cutterheads.

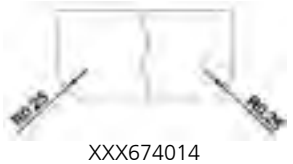
Prices Subject to Change

Available for Powerlock Spindles

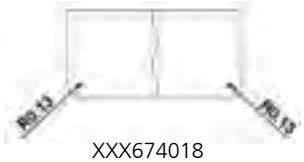
Replacement carbide insert knives for new style cutterhead only

Each CombiHead includes a pair of HSS planer knives. Profile inserts and gibs are additional.

Custom insert profile knives available upon request in 20mm and 50mm widths.



XXX674014



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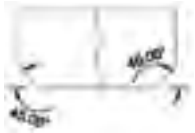

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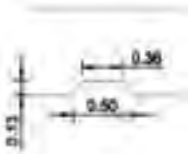


XXX674128

XXX674129

XXX674025

A grinder is no longer required to produce "S4S" material for multiple applications. The CombiHead provides versatility and cost effectiveness with reversible HSS or carbide planer knives. Maximum speed of 8,000 rpm. Single-style gibs for **all** profile knives. Features replaceable profile carbide inserts that can be exchanged in minutes, and standard Centrolock planer knives. *Standard inserts: Profile width 3/4", Max profile depth 1/2"*

ARTICLE NUMBER	OVER ALL WIDTH	USEABLE PROFILE WIDTH (APPROX.)	OUTSIDE DIAMETER	NUMBER OF POCKETS	BORE DIAMETER	PRICE
XXX672255	230mm	200mm	125mm	2+2	1-1/2"	$1,545
XXX672405	230mm	200mm	140mm	2+2	1-13/16"	$1,620

507920230	HSS planer knives 230mm	$14.18
504921230	Carbide planer knives 230mm	$78.25
XXX674014	Carbide 1/4" radius insert	$50
XXX674018	Carbide 1/8" radius insert	$50
XXX674025	Carbide bead insert	$50
XXX674045	Carbide 45° bevel insert	$50
XXX674128	Carbide flooring standard relief cut insert	$50
XXX674129	Carbide flooring round relief cut insert	$50
XXX674124	Carbide 1/4" x 1/2" groove insert	$50
XXX675000	Gib for profile knives	$50

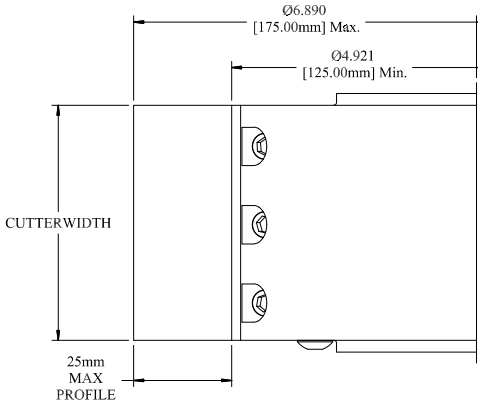
Shear Planerheads with Replaceable Inserts

- Standard replaceable carbide inserts that can be exchanged in minutes
- Reduced tearout due to the alternating shear cutting action
- No grinder required
- Certified for usage up to 8,000 rpm

XXX635269	125 x 50 x 1-1/2", Z4	$596
XXX635271	125 x 50 x 1-13/16", Z4	
XXX100260	Replacement Inserts	$4.95
XXX635506	Replacement Gibs	$39.60
XXX635507	Replacement Gib Screw	$3.50

Prices Subject to Change

Universal Profile Insert Tooling System



Additional Specifications:

- Carbide inserts
- Use on hardwoods and softwoods
- Designed for feed speeds up to 40 FPM for 2-knife tools; 55 FPM for 3-knife tools
- Profile backers are a one-time purchase. Reusable with new inserts of the same profile
- Create multiple profiles using different inserts with the same tool body
- New design provides better economy than previous versions, but with the better performance quality
- Cutting circle: 175mm maximum; 125mm minimum
- Maximum speed of 8,000 rpm
- 15° hook angle from stock
- 35mm tool body width from stock, **now with 60mm width available**
- 1-1/4" bore diameter available

Prints for each profile are available upon request or viewable from our website tooling.weinigusa.com.

Profile Insert Tool Body

ARTICLE NUMBER	KNIVES PER TOOL BODY	BORE DIAMETER	CUTTER WIDTH	PRICE
XXX662312SG	2	1-1/2"	35mm	$450
XXX662314SG	2	40mm	35mm	$450
XXX662313SG	2	1-1/2"	60mm	$595
XXX662309SG	2	40mm	60mm	$595
XXX662311SG	3	1-1/4"	35mm	$630
XXX662315SG	3	1-1/2"	35mm	$630
XXX662319SG	3	40mm	35mm	$630
XXX662316SG	3	1-13/16"	35mm	$630
XXX662317SG	3	1-1/2"	60mm	$750
XXX662320SG	3	40mm	60mm	$750
XXX662321SG	3	1-13/16"	60mm	$750

Carbide Insert Profile Knives and Backers – In stock, available for immediate delivery

XXX662160	Straight knife backer only	$49
XXX662150	Tongue profile backer only	$49
XXX662150MB	Tongue microbevel backer only	$49
XXX662150SQ	Square edge tongue profile backer only	$49
XXX662173	Tongue centermatch backer only	$49
XXX662183	Tongue V-panel backer only	$49
XXX662179	Tongue 1/2" profile backer only	$49
XXX662155	Groove profile backer only	$49
XXX662155MB	Groove microbevel backer only	$49
XXX662155SQ	Square edge groove profile backer only	$49
XXX662171	Groove centermatch backer only	$49
XXX662181	Groove V-panel backer only	$49
XXX662177	Groove 1/2" profile backer only	$49
XXX662131	Straight knife insert knife	$39
XXX662100	Tongue profile insert knife	$39
XXX662100MB	Tongue microbevel profile insert knife	$39
XXX662100SQ	Square edge tongue profile insert knife	$39
XXX662172	Tongue centermatch profile insert knife	$39
XXX662182	Tongue V-panel profile insert knife	$39
XXX662178	Tongue 1/2" profile insert knife	$39
XXX662105	Groove profile insert knife w/0.030" gap	$39
XXX662115	Groove profile insert knife w/0.010" gap	$39
XXX662120	Groove profile insert knife w/0.005" gap	$39
XXX662115MB	Groove microbevel profile insert knife	$39
XXX662115SQ	Square edge groove profile insert knife	$39
XXX662170	Groove centermatch profile insert knife	$39
XXX662180	Groove V-panel profile insert knife	$39
XXX662176	Groove 1/2" profile insert knife	$39

Cube Tooling

The Cube automatic planer impresses with an astonishingly simple operating concept combined with a minimum of work. The Cube automatic planer is the perfect machine for four-sided planing with its plug-and-play technology— just set up, switch on, start planing. It provides intuitive operation from the very first minute, without any time-consuming training.

Featuring Full-length Reversible Insert Knives

ARTICLE NUMBER	DIAMETER MM	WIDTH MM	BORE MM	# OF KNIVES	SPINDLE POSITION	CUTTING ANGLE	PRICE
53012918	125	170	40	2	Right	12°	$695
53012920	125	170	40	2	Left	12°	$695
53012919	125	285	40	2	Top	12°	$1,490
53012917	125	285	40	2	Bottom	12°	$1,490
10025940	125	170	40	2	Right	27°	$695
10025942	125	170	40	2	Left	27°	$695
10025941	125	285	40	2	Top	27°	$1,490
10025939	125	285	40	2	Bottom	27°	$1,490

EasyLock Spirals (rough cut)

ARTICLE NUMBER	DIAMETER MM	WIDTH MM	BORE MM	# OF KNIVES	SPINDLE POSITION	CUTTING ANGLE	PRICE
54212539	125	170	40	2	Right	17°	$1,450
54212537	125	170	40	2	Left	17°	$1,450
54212540	125	285	40	2	Top	17°	$2,235
53012917	125	285	40	2	Bottom	17°	$2,235

EasyLock Knives

12023654	HSS planer knives 170mm	$23.00
12023657	HSS planer knives 285mm	$35.00
507925170	Carbide planer knives 170mm	$90.00
507925285	Carbide planer knives 285mm	$156.00
XXX637100	Carbide inserts 15 x 15 x 2.5mm (for spiral cutters)	$3.68

Steel and Rubber Feed Rollers on Pages 55 and 56

Prices Subject to Change

Helicarb Planerheads

A joint effort between Weinig and Great Lakes Custom Tool has produced a Helical Planerhead with a replaceable, nonsegmental helical carbide blade for cutter widths up to 235mm. Planer cutters wider than 235mm have a 2-piece carbide blades that are sold in sets. Among the distinct advantages of this tool include:

- The helical blade produces an uninterrupted, continuous shearing action which reduces tear-out in all woods especially irregular grain and laminated veneer lumber
- This patented technology allows the planerhead to give a superior smooth finish on all woods, MDF, and plastics
- The Helicarb cutter body is designed to accept carbide blades with different hook angles
- The Helicarb blades can be sharpened and they are "Replaceable". They can be maintained at your facility with the proper grinding equipment keeping downtime to a minimum
- The design of the Helicarb cutter consumes 16% less electrical power and runs 8 decibels quieter than a straight knife cutterhead
- Helicarb is manufactured in conventional straight bore, hydro bore, & PowerLock configurations

HeliCarb® Blades

CUTTER DIAMETER	WINGS	MATERIAL	RPM	FPM	CHIP LOAD
100mm	2	Hard & Softwoods	12,000	60	.030"
100mm	3	Hard & Softwoods	12,000	90	.030"
135 & 160mm	2	Hard & Softwoods	6,000-8,000	30-40	.030"
135 & 160mm	3	Hard & Softwoods	6,000-8,000	45-60	.030"
160mm	4	Hard & Softwoods	6,000-8,000	60-80	.030"
160mm	6	Hard & Softwoods	6,000-8,000	90-120	.030"

This chart serves as a guideline. Feeds and speeds can vary depending on specific material and finish required.

H = Hook Angle: Must specify when ordering blades

5° Hook	Recommended for cutting hard maple, hickory, South American exotics & MDF. This hook will reduce "tear-out" that tends to be problematic.
10° Hook	Recommended for cutting common hardwoods (oak, ash, walnut, cherry, etc.). This hook is an excellent "all around choice" for many hardwoods.
15° Hook	Recommended for cutting soft hardwoods (soft maple, alder, poplar, aspen & fir). This hook is the universal choice for multiple applicaitions.
20° Hook	Recommended for cutting softwoods spruce & pine) and plastics. this hook provides a clean cut, reducing fuzzing in softwoods.

Prices Subject to Change

Straight Bore Helicarb Cutters (135mm Diameter)

Two and three wing cutters listed below. **Up to eight wings are available.**
310mm width available in hydro bore only.

See page 19 for recommended hook

BORE SIZES AVAILABLE	HOOK ANLGES AVAILABLE
1-1/2"	5°
1-13/16"	10°
2-1/8"	15°
40mm	20°
50mm	

Weinig's stock hook angle is 10°. All cutters are steel except 235mm which are aluminum.

Right or Top and Left or Bottom Cutterheads and Blades

1-1/2" BORE						
CUTTER WIDTH	**NO. OF WINGS**	**CUTTER PART NUMBER RIGHT OR TOP**	**CUTTER PART NUMBER LEFT OR BOTTOM**	**PRICE EACH**	**BLADE PART NUMBER 10° STANDARD R/T & L/B**	**PRICE EACH**
75mm	2	XXX62380752R	XXX62380752L	$908	XXX624075R or L	$118
	3	XXX62380753R	XXX62380753L	$1,132	XXX624075R or L	$118
115mm	2	XXX62381152R	XXX62381152L	$1,270	XXX624115R or L	$176
	3	XXX62381153R	XXX62381153L	$1,590	XXX624115R or L	$176
170mm	2	XXX62381702R	XXX62381702L	$1,640	XXX624170R or L	$242
	3	XXX62381703R	XXX62381703L	$2,063	XXX624170R or L	$242
*235mm	2	XXX62382352R	XXX62382352L	$2,312	XXX624235R or L	$333
	3	XXX62382353R	XXX62382353L	$2,912	XXX624235R or L	$333

1-13/16" BORE						
CUTTER WIDTH	**NO. OF WINGS**	**CUTTER PART NUMBER RIGHT OR TOP**	**CUTTER PART NUMBER LEFT OR BOTTOM**	**PRICE EACH**	**BLADE PART NUMBER 10° STANDARD R/T & L/B**	**PRICE EACH**
75mm	2	XXX62460752R	XXX62460752L	$908	XXX624075R or L	$118
	3	XXX62460753R	XXX62460753L	$1,132	XXX624075R or L	$118
115mm	2	XXX62461152R	XXX62461152L	$1,270	XXX624115R or L	$176
	3	XXX62461153R	XXX62461153L	$1,590	XX624115R or L	$176
170mm	2	XXX62461702R	XXX62461702L	$1,640	XXX624170R or L	$242
	3	XXX62461703R	XXX62461703L	$2,063	XXX624170R or L	$242
*235mm	2	XXX62462352R	XXX62462352L	$2,312	XXX624235R or L	$333
	3	XXX62462353R	XXX62462353L	$2,912	XXX624235R or L	$333

Special knife rest for resharpening blades and replacement parts on page 20.

* Aluminum Cutter Body / Also available in 160mm diameter

Hydro Bore Helicarb Cutters (160mm Diameter)

Three and four wing cutters listed below. **Up to 14 wings are available.**
All cutterheads are steel except 235mm and 310mm which are alumium.

See page 19 for recommended hook

BORE SIZES AVAILABLE	HOOK ANLGES AVAILABLE
1-13/16"	5°
2-1/8"	10°
50mm	15°
	20°

Weinig's stock hook angle is 10°.

Right or Top and Left or Bottom Cutterheads and Blades

1-13/16" BORE						
CUTTER WIDTH	NO. OF WINGS	CUTTER PART NUMBER RIGHT OR TOP	CUTTER PART NUMBER LEFT OR BOTTOM	PRICE EACH	BLADE PART NUMBER 10° STANDARD R/T & L/B	PRICE EACH
75mm	3	XXX62460753RH	XXX62460753LH	$1,973	XXX625075R or L	$118
	4	XXX62460754RH	XXX62460754LH	$2,270	XXX625075R or L	$118
115mm	3	XXX62461153RH	XXX62461153LH	$2,547	XXX625115R or L	$176
	4	XXX62461154RH	XXX62461154LH	$2,948	XXX625115R or L	$176
170mm	3	XXX62461703RH	XXX62461703LH	$3,314	XXX625170R or L	$242
	4	XXX62461703RH	XXX62461704LH	$3,843	XXX625170R or L	$242
*235mm	3	XXX62462353RH	XXX62462353LH	$3,965	XXX625235R or L	$333
	4	XXX62462354RH	XXX62462354LH	$4,628	XXX625235R or L	$333
*310mm	3	XXX62463103RH	XXX62463103LH	$5,152	XXX625310R or L	$475
	4	XXX62463104RH	XXX62463104LH	$6,032	XXXX625310R or L	$478

* Aluminum Cutter Body / Also available in 160mm diameter

310mm blades are 2 pieces per wing and only sold in sets

Download Instructions for knife replacement and grinding techniques are available on our website at **www.weinusa.com**.

Prices Subject to Change

Steel HeliCarb PowerLock Cutters (100mm Dia.)

HOOK ANLGES AVAILABLE
5°
10°
15°
20°

Weinig's stock hook angle is 10°.

See page 19 for recommended hook

For Right or Top Spindle

CUTTER WIDTH	NO. OF WINGS	CUTTER PART NUMBER RIGHT OR TOP	PRICE EACH	BLADE PART NUMBER 10° STANDARD R/T	PRICE EACH
75mm	2	XXX64073	$1,528	XXX643075R*	$118
115mm	2	XXX64075	$1,773	XXX643115R*	$176
170mm	2	XXX64077	$2,328	XXX643170R	$242
235mm	2	XXX64079	$3,300	XXX643235R	$333
235mm	3	XXX640793	$4,098	XXX643235R	$333
310mm	2	XXX64080	$4,117	XXX643310R*	$478.50

For Left Spindle only (For Better Chip Flow)

CUTTER WIDTH	NO. OF WINGS	CUTTER PART NUMBER RIGHT OR TOP	PRICE EACH	BLADE PART NUMBER 10° STANDARD R/T	PRICE EACH
75mm	2	XXX640631	$1,528	XXX643075R*	$118
115mm	2	XXX640651	$1,773	XXX643115R*	$176

* These cutters utilize the same blades as the right and top cutter for the corresponding length

For Left or Bottom Spindle

CUTTER WIDTH	NO. OF WINGS	CUTTER PART NUMBER RIGHT OR TOP	PRICE EACH	BLADE PART NUMBER 10° STANDARD L/B	PRICE EACH
75mm**	2	XXX64063	$1,528	XXX643075L	$118
115mm**	2	XXX64065	$1,773	XXX643115L	$176
170mm	2	XXX64067	$2,328	XXX643170L	$242
235mm	2	XXX64069	$3,300	XXX643235L	$333
235mm	3	XXX640693	$4,098	XXX643235L	$333
310mm	2	XXX64070	$4,117	XXX643310L*	$478.50

* To be used on the bottom spindle only

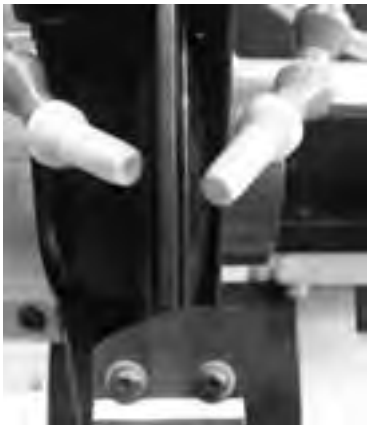
310mm blades are 2 pieces per wing and only sold in sets

Prices Subject to Change

Helicarb Cutter Replacement Parts

	CUTTER DIAMETER	PART NUMBER	DESCRIPTION
	100mm	XXX642105R	R.H. Wedge
	135mm	XXX627135R	R.H. Wedge
	160mm	XXX627160R	R.H. Wedge
	100mm	XXX642105L	L.H. Wedge
	135mm	XXX627135L	L.H. Wedge
	160mm	XXX627160L	L.H. Wedge
	100mm	XXX642100	1/4-28 x 3/4 Differential Wedge Screw
	135mm & 160mm	XXX627160	M8x1.25 x 24mm Differential Wedge Screw
	All Diameters	XXX642SHIM	(10)--.030" thick shims [.135" wide x 9.625" long]
	All Diameters	930-013024hel2*	Helicarb Knife Rest for grinding Helicarb blades. Used in conjunction with Weinig knife rest 930-013024

* Must have the Weinig knife rest holder for replaceable carbide knife rests 930-013024 found on page 46.



Knife rest and grinding wheel for sharpening blade in a Helicarb cutter on a Weinig Rondamat Grinder or equivalent.

Sharpening blade in Helicarb PowerLock Cutter

Prices Subject to Change

OPTI-PCD Tooling Optimum Performance Tooling

Weinig is expanding our Custom Diamond Tooling program, offering a broader line at competitive prices and delivery.

Polycrystalline Diamond (PCD) is diamond grit that has been fused together under high-pressure, high-temperature conditions in the presence of a catalytic metal. The extreme hardness, wear resistance, and thermal conductivity of diamond make it an ideal material for manufacturing cutting tools. PCD tools can machine all non ferrous materials such as chipboards, HDF, and laminated boards as well as materials used to produce aluminium components and light-weight materials such as carbon fiber reinforced plastics (CFRP), metal matrix composites (MMC) and stacks.

PCD tooling can give the user a great ROI when used in the correct application. It is important to consider all the details of the machining application and expectation of the finished part to insure that PCD tools are suitable for the project. There is a wide range of performance and longevity expectations of PCD tools due to the many different application and environmental factors where they may be used. It is recommended that you discuss your project with our knowledgeable Weinig experts to help **you determine if PCD tooling is the right choice for your application.**

For pricing, contact Weinig Tooling at 1-877-548-0929.

Diamond vs. Carbide Tooling

The ROI Formula:

$$\text{Cost per Linear Foot} = \frac{\text{Tool cost} + (\#\text{ of sharpening} \times \text{cost of sharpening})}{1 + \#\text{ of resharpenings} \times \text{tool life (lineal feet)} + \frac{\text{set up time} \times \text{machine cost}}{\text{tool life (lineal feet)}}}$$

Example Data:

	Carbide Tool	Diamond Tool
Initial Tool Cost:	$350.00	$2,995.00
Sharpening Cost:	$35.00	$600.00
Machine Cost/Minute:	$1.67	$1.67
Set-Up Time:	15 minutes	15 minutes
Possible Sharpenings:	10	5
Tool Life:	2,500 lineal ft	125,000 lineal ft

Example Cost Comparison (ROI @ PCD=50 x life of carbide)

Carbide Tool

$$\frac{\$350 + (10 \times \$35)}{(1 + 10) \times 2500} + \frac{11 \times 1.67}{2,500} = \frac{\$700}{27,500} + \frac{\$18.37}{2,500} = \$0.0323/\text{lineal ft.}$$

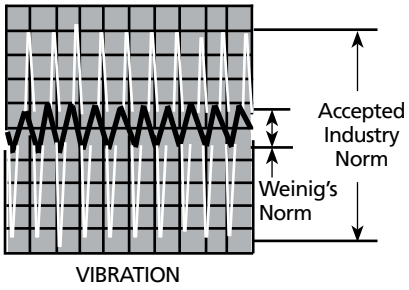
Diamond Tool (PCD)

$$\frac{\$2,995 + (5 \times \$600)}{(1 + 5) \times 125,000} + \frac{7 \times 1.67}{125,000} = \frac{\$5,995}{875,000} + \frac{\$11.69}{125,000} = \$0.0068 \text{ lineal ft.}$$

Weinig Cutterhead Quality Assurance

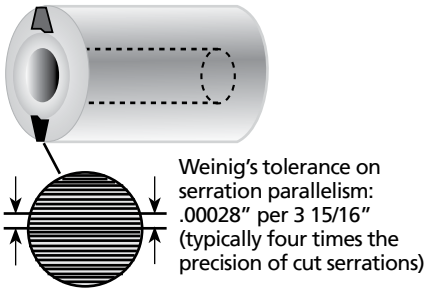
Cutterhead Balance

The dynamic balance of rotating tooling has a big effect on the life and reliability of the moulder. Every facet of product quality is affected by it. The "Q" value is the woodworking industry standard measurement of relative balance quality and a lower value means better balance. A "Q" of 0.0 means perfect balance and a "Q" of 16.0 is acceptable. Most tooling manufacturers use 16.0 as their goal, but Weinig's standard is much higher ("Q" = 2.5). When you use Weinig cutterheads, you get less vibration, longer life and a more accurate finished product with better surface quality.



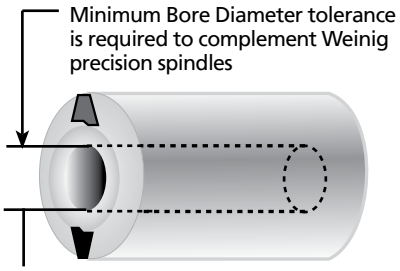
Parallel Knife-slot Serrations

It's accepted practice to create knife-slot serrations on the cutterhead with standard metal-cutting tools. But this can result in a waved surface and less than adequate support for the knife. Weinig creates serrations by broaching the surface using titanium-coated tools. Broaching actually shapes the entire tool surface and provides near-perfect parallelism of individual serrations. This parallelism provides better knife support and exceptional surface quality of the finished profile.



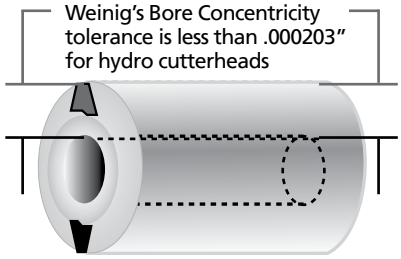
Bore Tolerance

The industry standard ISO-specified tolerance for a cutterhead with a 1 13/16" diameter bore is 0 to +25 microns. But if the tolerance is 0 microns, the cutterhead can be difficult to install on the moulder's spindle shaft and if the tolerance is 25 microns, the tooling can be too loose on the shaft. Weinig avoids these problems by more precisely controlling the bore diameter tolerance at +5 to +20 microns.



Bore Concentricity

If the cutterhead bore is not concentric to the cutterhead body, product dimensional accuracy and surface finish suffer. Weinig hones the bore with two passes (not just one) for near perfect accuracy.

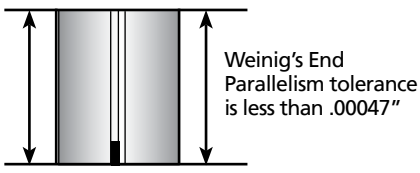


End Parallelism

A large tolerance in cutterhead end parallelism can cause out-of-balance running, less spindle strength, and reduced product accuracy.

The Highest Quality Materials

Tools rotating at high speed are subject to enormous deformation stresses. That's why Weinig cutterheads are manufactured from heat-stabilized steel and then tested at twice the rated RPM. We make sure all components are manufactured from quality materials and meet Weinig's exceptional standards.



Wood Based on Clear / FAS / Face and Better With 6%-8% Moisture Content

Any species containing higher or lower moisture content contact Weinig

WOOD SPECIES	LENGTH OF TOTAL FOOTAGE REQUIRED						HOOK ANGLE	
	<500	500-1000	1000-2500	2500-5000	5000-10,000	>10,000	6000-8000 RPM	10,000-12,000 RPM
Alder	SRS	M2	M3+	M3+	M3+	SUPRE	12	12
Ash	SRS	M2	M3+	M3+	M3+	SUPRE	12	12
Basswood	SRS	M2	M3+	M3+	M3+	SUPRE	12	12
Beech	SRS	M2	M3+	M3+	M3+	SUPRE	12	12
Birch	SRS	M2	M3+	M3+	M3+	SUPRE	12	12
Cedar, Eastern	SRS	M2	M3+	M3+	M3+	SUPRE	12	12
Cherry	M2	M3+	SUPRE	SUPRE	SUPRE	SUPRE	12	12
Cypress	SRS	M2	M3+	M3+	M3+	SUPRE	12	12
Elm	SRS	M2	M3+	M3+	M3+	SUPRE	12	12
Fir, Douglas	SRS	M2	M3+	M3+	M3+	SUPRE	12	12
Hackberry	SRS	M2	M3+	M3+	M3+	SUPRE	12	12
Hemlock	SRS	M2	M3+	M3+	M3+	SUPRE	12	12
Hickory	M3+	SUPRE	Carbide	Carbide	Carbide	Carbide	12	12
Mahogany	M2	M3+	SUPRE	SUPRE	SUPRE	SUPRE	12	12
Maple, Hard	M3+	SUPRE	Carbide	Carbide	Carbide	Carbide	12	12
Maple, Soft	M2	SUPRE	Carbide	Carbide	Carbide	Carbide	12	12
Oak, White	M2	M3+	SUPRE	SUPRE	SUPRE	SUPRE	12	12
Pecan	M3+	SUPRE	Carbide	Carbide	Carbide	Carbide	12	12
Pine, Heart	M3+	SUPRE	SUPRE	SUPRE	SUPRE	SUPRE	12	12
Sapele	SUPRE	SUPRE	SUPRE	SUPRE	SUPRE	SUPRE	12	12
Sycamore	M2	M2	M3+	M3+	M3+	SUPRE	12	12
Walnut	M2	M3+	SUPRE	SUPRE	SUPRE	SUPRE	12	12
Oak, Red	M2	M3+	SUPRE	SUPRE	SUPRE	SUPRE	12/20	12/20
Cottonwood	SRS	M2	M3+	M3+	M3+	SUPRE	20	20
Pine, Eastern White	SRS	M2	M3+	M3+	M3+	SUPRE	20	20
Pine, Radiata	SRS	M2	M3+	M3+	SUPRE	SUPRE	20	20
Pine, Southern Yellow	SRS	M2	M3+	M3+	M3+	SUPRE	20	20
Poplar	SRS	M3+	M3+	M3+	M3+	SUPRE	20	20
Spruce	SRS	M2	M3+	M3+	M3+	SUPRE	20	20
Cedar, Western	SRS	M2	M3+	M3+	M3+	SUPRE	30	20
Redwood	SRS	M2	M3+	M3+	M3+	SUPRE	30	30
All Others	Ask Weinig	Ask Weinig	Ask Weinig	Ask Weinig	Ask Weinig	Ask Weinig	Ask Weinig	Ask Weinig

Knife Steel/Cutterhead Recommendation List

1. First qualify that number of knives and feed speed equal appropriate KMPI. **If fewer KMPI required, then the life of the knife increases. If more KMPI required, then life of knife decreases.** Refer to "Finish Quality & Feed Rates" on page 67 of current Tooling & Supplies catalog.

2. If you have grinding capabilities, you can possibly get by with the next lower grade of knife steel. If you don't have a grinder, it is wise to go to the next higher grade in order to get through the run without the need to regrind. Note: You can always (with the exception of carbide) use a better grade of steel than that recommended. Also, if you have a grinder, you will be able to use 20° cutterheads in many cases where 12° angle is required for those without grinders.

3. We always recommend, or at least discuss, insert tooling when a customer is running "mating" parts, or parts that require a 90° cut in the profile. However, short or one-time runs are okay for running corrugated steel.

4. Knife steel back clearance angles:

HSS (Non-jointed machine)	25/20°
HSS (Jointed machine)	30/27°
Carbide knives	18/15°

5. Cutterheads with 20° hook angle consume up to 30% less HP than lower hook angle cutterheads, so always use these tools when possible. When HP is an issue, you should try using 20° tools with less stock removal. This will reduce the "lifting" action at the cutting tip on wood species that are more dense, although it may mean reducing the feed speed. However, remember that when run too slowly, tools WILL become overheated, causing deterioration in the cutting edge.

6. This list should be used as a recommendation only. If the knife steel currently being used works for your application, then continue with this success.

General Grinding Steps for High-Speed Steel (HSS)

Rough Grind

1. Set back clearance grinding angle.
2. Set wheel RPM.
3. Set proper distance (.020" 0.5mm) between the wheel and the tool rest.
4. Make sure wheel width matches the tracing pin width (use a square tracing pin).
5. Rough grind the knife until the tracing pin contacts the template.
6. Index the wheel toward the tool rest proper distance (.020").
7. Regrind the knife.
8. Repeat steps 1 through 7 for all knives.
9. Make sure all knives are even.
10. Dress the wheel round. Be sure to then rotate the tracing pin to the round side.
11. Regrind all knives while maintaining the proper distance (.020") between the wheel and the tool rest.
12. Set up for side clearance (on any angle over 60°) and grind in areas needed, still at the rough-grind angle.
13. Redress wheel (round). At 0° side clearance, regrind all knives while maintaining the proper wheel/tool rest relationship (.020").

Finish Grind

1. Set proper back clearance grinding angle.
2. Set higher wheel RPM.
3. Set distance (0.20") between wheel and tool rest.
4. Make sure the wheel shape and width match the tracing pin.
5. With coolant off, index wheel toward knife until minimal contact is made. Start coolant and proceed with grind (smaller grind is better).

3 Reasons Why Weinig Knife Steel Is Better

To make exceptional knife steel, you must have the correct raw material composition and heat-treating process, as well as the proper grinding technique. Anything less leads to a finished moulder knife that is just adequate – and just-adequate tooling is not enough to meet Weinig standards. That's why we say "Use the Best on the Best – It Really Makes a Difference."

Raw Material Quality

Weinig uses only the highest quality raw materials from specially selected steel mills. For softwoods or short runs of hardwoods, we suggest Weinig SRS. This material features high levels of carbon for hardness and chrome for toughness. The proper blend of these elements, plus our own specialized processing, produce a knife steel that is tough but ductile.

For medium-size runs, we offer the Weinig M2 high-speed steel, an industry standard. This steel offers ease of grinding, with the strength needed for a quality finish and longer run-time than our short-run steel.

For longer runs or repetitive profiles in most species, Weinig offers M3+ high-speed steel. Increased levels of carbon and vanadium make Weinig M3+ a tougher, more abrasion-resistant material than any standard M2 steel on the market today. Weinig SUPRE-18 knife steel offers increased resistance to heat, acids, and mineral streaks, and can deliver up to double the life of industry-standard knife steel in these applications.

Weinig has developed a revolutionary advanced process for coating our knife steel. Our coated knife steel improves the hardness, increases wear resistance, and prevents residue adhesion by adding a ultra hard thin layer of advanced coating. Our new coated knife can last up to 4 times longer but easier to grind than carbide knives. With the increased run times, you can gain an enormous amount of machine uptime resulting in lower cost moulding.

For extremely abrasive hardwoods, composite wood products, laminated stock or synthetic materials, the choice is Weinig Double Back Carbide Knife System or TCT inlaid. On each, the finest material available for the specific grade of knife provides an exceptionally hard cutting edge.

Precision-ground Corrugations

Have you ever cut pieces from a single bar of steel, balanced them, ground the profile, and then found that you had to balance the knives again? This problem is caused by inconsistent corrugations, and it won't happen with Weinig knife steel. Across the length of a standard 25" bar of Weinig knife steel, corrugation accuracy varies no more than .006". The resulting high levels of precision, accuracy and parallelism are unique to Weinig knife steel. Weinig incorporates a unique manufacturing process using specialized machinery to "crush" grind the corrugations into the knife steel. The precise profile of the 16/60 corrugations is formed on to a carbide roll with special diamond grit impregnated into the roll. The corrugations are slowly transferred on to the knife material. This provides a consistent, and accurate surface finish, creating the prefect corrugation.

Specialized Heat Treating

The best raw material will not perform to optimum levels if it is not correctly heat treated. Weinig uses a special process that takes place in a vacuum. This technique ensures a clean, scale-free and consistent surface to core hardness, thus eliminating soft spots and fracture-causing hard spots. After heat treating, a special drawing procedure is employed. Drawing is the process that relieves metal stress created in the heat-treating operation. Only Weinig repeats this drawing process three times, making Weinig knife steel much less susceptible to breakage as compared to single- or double-draw steel. After drawing, each piece of steel is subjected to multiple quality control checks to guarantee the most stable and consistent knife steel available.

Original WEINIG Steel, Now With Polished Finish!

Aren't you tired of inexpensive knife steel that performs as you would expect a cheap grade of steel to perform? To make exceptional knife steel, you must have the correct raw material composition and heat-treating process, as well as the proper grinding technique.

Weinig SUPRE-18 HSS Knife Steel - Premium Grade for Long Wear

The Weinig SUPRE-18 knife steel is designed to give both the best finish quality attainable and the toughness needed for long run times, even at operating speeds up to 12,000 rpm. With an extra drawing process during heat treating and the highest attainable levels of precision and accuracy, SUPRE-18 knife steel delivers the qualities necessary for continual maximum performance of both moulder and product.

LENGTH: 25", THICKNESS: 5/16"
16-60° PRECISION CRUSH-GROUND CORRUGATIONS

ARTICLE NUMBER	WIDTH	MAXIMUM PROFILE DEPTH	PRICE
VEN700802	1 1/2"	1/8"	$163.50
VEN700804	1 3/4"	3/8"	$189
VEN700806	2"	5/8"	$194
VEN700807	2 1/4"	7/8"	$205
VEN700808	2 1/2"	1 1/8"	$212
VEN700812	2 3/4"	1 3/8"	$215

Weinig M3+ HSS Knife Steel for Long or Short Runs

- Weinig was the first to offer M3+, and it's still a tougher, more abrasion-resistant material than any standard M2 high-speed steel on the market today.
- Weinig M3+ specially formulated high-speed steel contains increased levels of carbon and vanadium for increased wear-resistance, yet it remains easy to grind.
- Recommended for use on both hardwoods and softwoods; for both long and short runs.
- Consistent hardness through entire thickness, not just on the surface.
- Unique heat-treating process eliminates hard and soft spots and greatly reduces the possibility of cracking.

LENGTH: 25", THICKNESS: 5/16"
16-60° PRECISION CRUSH-GROUND CORRUGATIONS

ARTICLE NUMBER	WIDTH	MAXIMUM PROFILE DEPTH	PRICE
VEN700002	1 1/2"	1/8"	$145
VEN700004	1 3/4"	3/8"	$152
VEN700006	2"	5/8"	$158
VEN700008	2 1/4"	7/8"	$161
VEN700010	2 1/2"	1 1/8"	$165
VEN700012	2 3/4"	1 3/8"	$180

Prices Subject to Change

Weinig M2 Knife Steel For Medium to Short Runs

LENGTH: 25", THICKNESS: 1/4" and 5/16"
16-60° PRECISION CRUSH-GROUND CORRUGATIONS

ARTICLE NUMBER	WIDTH	THICKNESS	MAX. PROFILE DEPTH	PRICE
XXX700170	1 1/2"	1/4"	1/8"	$123
XXX700172	1 3/4"	1/4"	3/8"	$132
XXX700174	2"	1/4"	5/8"	$138
XXX700176	2 1/4"	1/4"	7/8"	$147
XXX700270	1 1/2"	5/16"	1/8"	$135
XXX700272	1 3/4"	5/16"	3/8"	$145
XXX700274	2"	5/16"	5/8"	$152
XXX700275	2 1/4"	5/16"	7/8"	$165
XXX700276	2 1/2"	5/16"	1 1/8"	$172
XXX700278	2 3/4"	5/16"	1 3/8"	$177

- Top-quality, high-speed steel at economical prices.
- Designed for grinding ease, but maintains the capacity to grind to a sharp, and jointable, cutting edge.
- Now improved for longer life and better finish quality.
- Available in both 1/4" and 5/16" thickness.
- Now with polished face for better finish quality.

Weinig SRS Economy-grade Knife Steel Designed Specifically for Short-run Applications

LENGTH: 25", THICKNESS: 5/16"
16-60° PRECISION CRUSH-GROUND CORRUGATIONS

ARTICLE NUMBER	WIDTH	MAXIMUM PROFILE DEPTH	PRICE
VEN700017	1 3/4"	3/8"	$94
VEN700019	2"	5/8"	$98
VEN700020	2 1/4"	7/8"	$106
VEN700021	2 1/2"	1 1/8"	$109
VEN700023	2 3/4"	1 3/8"	$112

Weinig Quality Knives at Budget Prices

- Economy-grade for short runs of:
  Approximately 1,000 LF in hardwoods
  Approximately 3,000 LF in softwoods
- Grinds easily to a sharp cutting edge, with guaranteed consistency throughout the knife.

Knife Steel Cut-off Wheel. Offers long wear life and excellent prevention of knife burning

XXX100701 14" x 0.110" x 1" $9.00

Prices Subject to Change

WK-1 Ultra Coat Knife Steel – A New Alternative to Carbide Knives!

Weinig has developed a revolutionary advanced process for coating our knife steel. Our coated knife steel improves the hardness, increases wear resistance, and prevents residue adhesion by adding an ultra hard thin layer of advanced coating. Our new coated knife can last up to 5 times longer but easier to grind than carbide knives. With the increased run times, you can gain an enormous amount of machine uptime resulting in lower cost moulding.

NOTE: Because this is a coated steel, do not use an abrasive stone to debur the ground knife. Instead, use a piece of wood or plastic.

LENGTH: 25", THICKNESS: 5/16"
16-60° PRECISION CRUSH-GROUND CORRUGATIONS

ARTICLE NUMBER	WIDTH	MAXIMUM PROFILE DEPTH	PRICE
VEN700706	50mm	5/8"	$264
VEN700708	60mm	1"	$285
VEN700712	70mm	1 3/8"	$360

- Highly resistant to nicks created by wood acids.
- Reduces friction on the cutting edge, resulting in less heat and longer knife life.
- Offers an average production run of up to five times longer than that of standard M2 HSS knives.
- Can be ground with standard vitrified and CBN grinding wheels.

Filler Strip

Never run a cutterhead with an empty pocket. Always use filler strips or old planing knives that have been balanced.

This precision-ground filler strip is used to balance the cutterhead when not all knife slots are used.

507-301001	5/16" x 1" x 25"	$83
507-301003	1/4" x 1" x 25"	$73
507-301002	10mm x 1" x 25"	$98

Ohaus Portable Electronic Balance Scale

Essential for the production of quality knives, especially in high-RPM applications.

XXX100340	2000g x 0.1g	$495

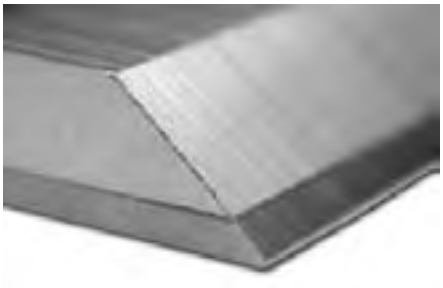
Prices Subject to Change

https://www.mr-moulding-knives.com/information/balance-scale-for-moulding-knives

Carbide-tipped (TCT) Corrugated Back Knife Steel

THICKNESS 3/8" 16-60˚ PRECISION CRUSH-GROUND CORRUGATIONS

ARTICLE NUMBER	WIDTH		WORKING LENGTH		MAXIMUM PROFILE DEPTH		PRICE
	INCHES	MM	INCHES	MM	INCHES	MM	
VEN700179	1 9/16	40	1 9/16	40	3/16	5	$56
VEN700180	1 9/16	40	2 23/64	60	3/16	5	$57
VEN700181	1 9/16	40	3 9/64	80	3/16	5	$69
VEN700182	1 9/16	40	3 15/16	100	3/16	5	$86
VEN700184	1 9/16	40	5 1/8	130	3/16	5	$112
VEN700186	1 9/16	40	5 29/32	150	3/16	5	$127
VEN700187	1 9/16	40	6 11/16	170	3/16	5	$145
VEN700188	1 9/16	40	7 3/32	180	3/16	5	$152
VEN700189	1 9/16	40	8 17/64	210	3/16	5	$193
VEN700190	1 9/16	40	9 1/16	230	3/16	5	$197
VEN700191	1 9/16	40	9 29/64	240	3/16	5	$212
VEN7001915	1 9/16	40	12 13/64	310	3/16	5	$283
VEN700192	1 9/16	40	25	635	3/16	5	$577
VEN700025	2	50	1 9/16	40	1/2"	13	$66
VEN700026	2	50	2 23/64	60	1/2"	13	$67
VEN700027	2	50	3 9/64	80	1/2"	13	$82
VEN700028	2	50	3 15/16	100	1/2"	13	$101
VEN700030	2	50	5 1/8	130	1/2"	13	$130
VEN700032	2	50	5 29/32	150	1/2"	13	$145
VEN700033	2	50	6 11/16	170	1/2"	13	$164
VEN700034	2	50	7 3/32	180	1/2"	13	$175
VEN700035	2	50	8 17/64	210	1/2"	13	$206
VEN700036	2	50	9 1/16	230	1/2"	13	$222
VEN7000372	2	50	9 29/64	240	1/2"	13	$229
VEN7000375	2	50	12 13/64	310	1/2"	13	$322
VEN700037	2	50	25	635	1/2"	13	$630
VEN7000377	2 3/8	60	1 9/16	40	11/16	18	$78
VEN700038	2 3/8	60	2 23/64	60	11/16	18	$79
VEN700039	2 3/8	60	3 9/64	80	11/16	18	$98
VEN700040	2 3/8	60	3 15/16	100	11/16	18	$121
VEN700042	2 3/8	60	5 1/8	130	11/16	18	$154
VEN700044	2 3/8	60	5 29/32	150	11/16	18	$158
VEN700045	2 3/8	60	6 11/16	170	11/16	18	$185
VEN700046	2 3/8	60	7 3/32	180	11/16	18	$203
VEN700047	2 3/8	60	8 17/64	210	11/16	18	$236
VEN700048	2 3/8	60	9 1/16	230	11/16	18	$255
VEN7000485	2 3/8	60	9 29/64	240	11/16	18	$273
VEN700049	2 3/8	60	25	635	11/16	18	$730



- Carbide-tipped steel provides longer run time than high-speed steel because the carbide composition is a much harder and stronger cutting edge.
- Recommended for use on highly abrasive hardwoods, composite wood products, wood with glue lines, and synthetic materials.
- Softer grade of carbide than 2-piece systems, so will not fracture as easily.

Prices Subject to Change

Now With A Polished Finish!

Weinig's Double-Back carbide knife system is the best of the best in the industry. We use the industry's best nano grade carbide to manufacture our knives, coupled with our manufacturing processes of the HSS backer to give our customers a reliable, durable, and economical carbide knife system.

- Polished finish on knife face for better performance
- Extreme accuracy between carbide knife and backer
- Safety feature made into the knife system to insure safe use

Double Back Filler Strip
For inserting between the knife and clamping wedge when performing the initial grind on the backing plate.

VEN700109 $41

Double Back Jointing Stones
Designed exclusively for use when jointing carbide. Can be shaped in the same manner as stones used for high-speed steel, but contain a special bond designed to hold form longer against the hardness of carbide.

Listed on page 54.

MAXIMUM 12,000RPM
SOLID TUNGSTEN CARBIDE BLANK KNIFE AND STEEL BACKING PLATE SET
16-60˚ PRECISION CRUSH-GROUND CORRUGATIONS. THICKNESS 3/8"

ARTICLE NUMBER	WIDTH		WORKING LENGTH		MAXIMUM PROFILE DEPTH		PRICE
	INCHES	MM	INCHES	MM	INCHES	MM	
VEN700631	1 1/2	38	2 23/64	60	Planing only		$90
VEN700633	1 1/2	38	3 15/16	100	Planing only		$152
VEN700635	1 1/2	38	5 1/8	130	Planing only		$198
VEN700637	1 1/2	38	5 29/32	150	Planing only		$227
VEN700639	1 1/2	38	7 3/32	180	Planing only		$269
VEN700641	1 1/2	38	9 1/16	230	Planing only		$339
VEN700642	1 1/2	60	9 1/2	240	Planing only		$345
VEN700650	2	50	1 9/16	40	7/16	11	$65
VEN700651	2	50	2 23/64	60	7/16	11	$97
VEN700652	2	50	3 9/64	80	7/16	11	$128
VEN700653	2	50	3 15/16	100	7/16	11	$163
VEN700655	2	50	5 1/8	130	7/16	11	$210
VEN700657	2	50	5 29/32	150	7/16	11	$243
VEN700659	2	50	7 3/32	180	7/16	11	$319
VEN700661	2	50	9 1/16	230	7/16	11	$375
VEN700670	2 3/8	60	1 9/16	40	3/4	20	$70
VEN700671	2 3/8	60	2 23/64	60	3/4	20	$105
VEN700672	2 3/8	60	3 9/64	80	3/4	20	$137
VEN700673	2 3/8	60	3 15/16	100	3/4	20	$171
VEN700675	2 3/8	60	5 1/8	130	3/4	20	$221
VEN700677	2 3/8	60	5 29/32	150	3/4	20	$253
VEN700679	2 3/8	60	7 3/32	180	3/4	20	$356
VEN700681	2 3/8	60	9 1/16	230	3/4	20	$400

Prices Subject to Change

Now With A Polished Finish!

SOLID TUNGSTEN CARBIDE BLANK KNIFE ONLY

ARTICLE NUMBER	WIDTH		WORKING LENGTH		PRICE
	INCHES	MM	INCHES	MM	
VEN700731	1/12	38	2 23/64	60	$83
VEN700733	1 1/2	38	3 15/16	100	$139
VEN700735	1 1/2	38	5 1/8	130	$178
VEN700737	1 1/2	38	5 29/32	150	$207
VEN700739	1 1/2	38	7 3/32	180	$242
VEN700741	1 1/2	38	9 1/16	230	$310
VEN7007411	1 1/2	38	9 29/64	240	$341
VEN700750	2	50	1 9/16	40	$59
VEN700751	2	50	2 23/64	60	$86
VEN700752	2	50	3 9/64	80	$131
VEN700753	2	50	3 15/16	100	$147
VEN700755	2	50	5 1/8	130	$191
VEN700757	2	50	5 29/32	150	$220
VEN700759	2	50	7 3/32	180	$263
VEN700761	2	50	9 1/16	230	$346
VEN700770	2 3/8	60	1 29/64	40	$62
VEN700771	2 3/8	60	2 23/64	60	$93
VEN700772	2 3/8	60	3 9/64	80	$123
VEN700773	2 3/8	60	3 15/16	100	$153
VEN700775	2 /38	60	5 1/8	130	$200
VEN700777	2 3/8	60	5 29/32	150	$231
VEN700779	2 3/8	60	7 3/32	180	$331
VEN700781	2 3/8	60	9 1/16	230	$367

SIZES SHOWN ARE AVAILABLE FROM STOCK.

Backers Only

These allow you to cut to desired length when backer needs to be replaced.

VEN700110	50 x 330mm	$104
VEN700111	60 x 330mm	$110

Complete operating instructions are available online.

Prices Subject to Change

Common Carbide Insert Knives

Weinig offers a variety of commonly used carbide insert knives for various cutterhead types. We can supply almost any of our competitors' knives at competitive prices and always with the highest German quality.

Standard Reversible Knives

ARTICLE NUMBER	LENGTH	WIDTH	THICKNESS	# OF EDGES	HOLE SPACING	PRICE
006-01656	7.5	12	1.5	2		$1.45
XXX100234	7.7	8	1.5	2		$3.15
XXX100256	9	12	1.5	2		$2.90
XXX100087	9.6	12	1.5	2		$1.70
XXX100235	9.7	8	1.5	2		$3.00
XXX100254	10.5	10.5	1.5	4		$3.35
XXX100231	12	12	1.5	4		$1.95
006-00170	14	14	2	4		$1.95
XXX100236	14.7	8	1.5	2		$3.36
*XXX637100	15	15	2.5	4		$3.68
XXX100240	15	12	1.5	2		$2.05
006-00379	17	17	2	4		$6.00
XXX1002365	19.7	8	1.5	2		$4.00
XXX100241	20	12	1.5	2		$2.60
XXX100237	30	8	1.5	2		$4.54
XXX100232	30	12	1.5	2	14	$3.27
XXX100233	40	8	1.5	2		$4.70
XXX100246	40	12	1.5	2	26	$2.90
***XXX635050	50	12	1.5	2	26	$5.00
**XXX100260	50	8	1.5	2		$4.95
XXX1002381	60	12	1.5	2	26	$3.90
XXX100249	100	13	2.2	2	60	$17.85

*** Used in Weinig Spiral Cutterheads**

**** Used in Weinig Shear Planerheads**

***** Used in Original Design Shear Planerheads**

Prices Subject to Change

Weinig Grinding Template Services

Featuring Precision Profile Knives and Templates Customized to Suit Your Needs

Custom CAD Files

We can scan, import and create a custom CAD file based on your profile sample or sketch. Another option is modification to existing profiles, as shown in the Weinig Profile Catalog.

Templates

Acrylic Templates are made on a CNC machine and usually ship the same day. **Steel Templates** are also available. These are produced on a wire EDM machine and are extremely accurate.

Pre-Hogged HSS Knives

We offer five grades of High Speed Steel. These are cut cool and precise on our water jet with an additional .050" of material at the profile and angle cut to reduce grinding time, with a standard lead time of 1-2 days.

Finish Ground Knives

In addition to the five grades of High Speed Steel, our finish ground knives are also available in two types of Carbide (Double Back and TCT). The standard lead time is 3 days.

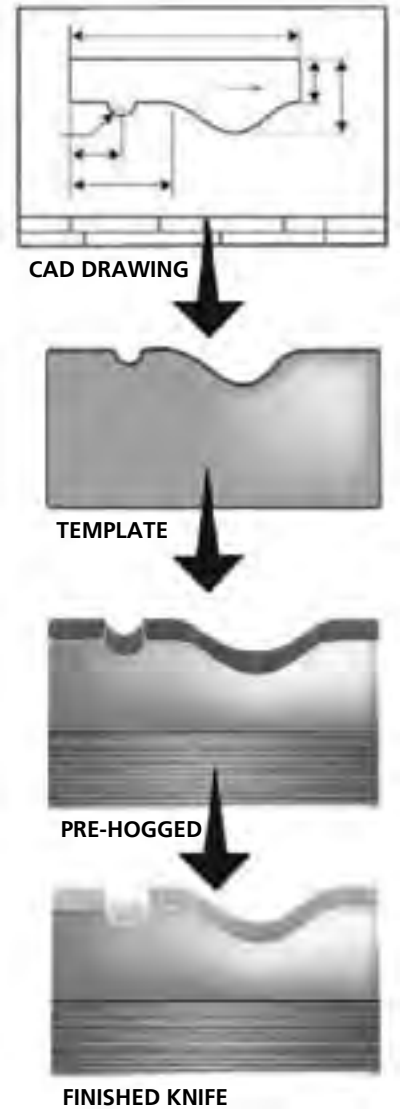
Regrinding

We can regrind your high speed steel, carbide or Helicarb knives. We measure and qualify our regrinds to ensure they are back to the original specifications.

Profile Inserts

Many mating parts (flooring, cabinets, doors, etc.) require knives that are very precise and easily duplicated with each subsequent knife. We can assist you with your profile insert requirements, both knives and tools.

Send us a sample or fax/email a drawing or CAD file, and we will use it to produce an approval drawing within 48 hours. Our staff can recommend a specific knife material and profile orientation for your application. Once drawings are approved and the order received, your order will be put into production.



Prices Subject to Change

Weinig's Comprehensive Profile Catalog
Available on request in hard copy form or downloadable PDF's.

Take the time to browse our online catalog for your next profile and SAVE! Custom profile templates can cost as much as $36.75, so you can save up to $25.00 per template when making your selection from our Profile Catalog.

Templates for each profile included in this book are available for immediate delivery at

Weinig Profile Catalog, 3rd Edition

The Weinig Profile Catalog, 3rd Edition, is for online ordering.
Ordering standard profile knives and templates has never been easier.
Check it out at tooling.weinigusa.com.

VEN160102 **Hard Copy form** **$25**

New Discounted Flat Shipping Rates!

Simple is better, and that's what the Weinig Grinding Service wants to provide for you. For all orders, we now have discounted flat rate shipping charges. This is intended to make your job costing process easier, plus give our valued customers the opportunity to receive reduced shipping costs. Just let us know your preferred shipping method, and we'll handle the rest!

For all new grinding service orders, Including regrinds, the following packing and shipping rates apply for the continental United States.

Orders of $200+	
UPS Ground Service	FREE
UPS 3-day Service	$30.00
UPS 2-day Service	$40.00
UPS 1-day Service	$60.00

Orders less than $200	
UPS Ground Service	Published Rate
UPS 3-day Service	$40.00
UPS 2-day Service	$45.00
UPS 1-day Service	$70.00

GRINDING WHEEL #	KNIFE STEEL TYPE						
	SRS	M2 (Shallow Profile)	M2 (Deep Profile)	M3+ (Shallow Profile)	M3+ (Deep Profile)	SUPRE	DLC
ROUGH GRIND							
#100702 Ceramic					X	X	X
#100712 Ceramic					X	X	X
#100719 Aluminum Oxide (special grain)	X	X	X	X			
#00600182 Aluminum Oxide (std. grain)		X	X				
FINISH GRIND							
Any CBN Wheel	X	X	X	X	X	X	X
#100717 Aluminum Oxide (special grain)	X	X	X	X	X	X	
#00600183 Aluminum Oxide (std. grain)		X	X				

#100702	2400 RPM
#100712	2400 RPM
#100719	2200 RPM
#00600182	2000 RPM
CBN Wheels	3000 RPM
#100717	2800 RPM
#00600183	2800 RPM

Increase RPM speed as the wheel becomes smaller due to wear.

1. Ceramic Wheels #100702 and #100712 are equally effective for heavy stock removal, so they can be used in similar conditions. The primary difference between the two wheels is that #100702 is a cooler cutting wheel, so it should be used when burning of the knife steel could occur during the grinding process.

2. A CBN (Cubic Boron Nitride) grinding wheel is always preferred for use during the final finish grind, as this fine grit wheel provides a micro-finish on your steel. It can be used on any type of high-speed or tool steel, but cannot be used on carbide. Order wheel according to shape required.

3. Since manual grinding results can vary according to the expertise of the operator and condition of the grinder, the wheel RPM often can be adjusted in order to attain better results. Recommended initial wheel RPM speed for a new grinding wheel is as listed to the side.

Weinig ECO-GREEN Ceramic Grinding Wheel

Our ECO-Green ceramic grinding wheel is the benchmark profile grinding wheel in our industry. The ceramic grain combined with the new innovative bond creates a faster metal removing grinding wheel that does not burn.

- Can be used as a finishing wheel
- Best for highly aggressive grinding

XXX100702	54-grit Green Ceramic Wheel	$46

Weinig Blue Ceramic Grinding Wheels

Our best seller, and considered by most to be our best overall grinding wheel across all Weinig HSS knife types. The Weinig Ceramic grinding wheels contain a high-tech abrasive grain that is most effective on the hardest of knife materials, and in high-production applications. The unique bond allows the spent ceramic grain to resharpen itself by constantly exposing new cutting edges, improves production with faster steel removal.

XXX100712	54-grit Ceramic Wheel for rough grinding	$41

Weinig Premium Blue Grinding Wheels

Our premium blues are composed of a very advanced aluminum oxide grain especially formulated for our wheels. These are our best overall grinding wheels for the more finesse grinderman.

- Aggressive grinding not required
- Extended life due to less loading

XXX100719	54-grit Premium Blue Wheel for rough grinding	$25.50
XXX100717	100-grit Premium Blue Wheel for finish grinding	$25.50

Weinig Euro-grinding Wheels

Our Euro-Grinding wheel is manufactured with an aluminum oxide grain. This is our more economical profile grinding wheel but still offers a superior performance. This wheel is for our less aggressive grinderman and gives the operator the opportunity to grind more confidently without burning the knife material.

006-00182	54-grit Euro-wheel for rough grinding	$18
006-00183	100-grit Euro-Wheel for finish grinding	$18

Use the correct wheel for your needs. There is no all-purpose wheel.

Weinig Diamond Grinding Wheels

For Rough Grinding of Tungsten Carbide Knives

PREMIUM		
930-062002	4mm thick with 2mm radius	$366
930-062015	3mm thick with 1.5mm radius	$330
930-062018	2mm thick with 1mm radius	$314
IMPORT		
930-06200215	4mm thick with 2mm radius	$209
930-06201815	2mm thick with 1mm radius	$194

For Simultaneous Rough Grinding of Both Steel and Carbide on TCT Inlaid Profile Knives

PREMIUM		
930-062020	4mm thick with 2mm radius	$366
930-062021	2mm thick with 1mm radius	$314
930-062022	2mm thick with square edge	$314
IMPORT		
930-06202015	4mm thick with 2mm radius	$209
930-06202115	2mm thick with 1mm radius	$194

For Finish Grinding of Tungsten Carbide Knives

PREMIUM		
930-062003	4mm thick with square edge	$366
930-062006	4mm thick with 2mm radius	$366
930-062011	2mm thick with 1mm radius	$314
930-062013	1.5mm thick with 0.75mm radius	$305
930-0620131	1.0mm thick with 0.5mm radius	$362
930-0620132	1.0mm thick with square edge	$362
930-062016	3mm thick with 1.5mm radius	$331
920-072006	10mm thick with square edge (requires small-diameter clamping flange)	$326
IMPORT		
930-06200315	4mm thick with square edge	$209
930-06200615	4mm thick with 2mm radius	$209
930-06201115	2mm thick with 1mm radius	$199

XXX100716	Metal bushing 60mm x 1 1/4" For converting Weinig grinding wheels for use on grinders with 1 1/4" arbors	$68

Weinig CBN (Cubic Boron Nitride) Grinding Wheels

For Finish Grinding of HSS Profile Knives

PREMIUM		
930-062007	4mm thick with 2mm radius	$399
930-062008	4mm thick with square edge	$399
930-0620071	3mm thick with 1.5mm radius	$371
930-062010	2mm thick with 1mm radius	$331
930-062012	1.5mm thick with 0.75mm radius	$324
930-0620121	1.5mm thick with square edge	$324
930-0620122	1.0mm thick with square edge	$394
930-0620123	1.0mm thick with 0.5mm radius	$394
920-072011	10mm thick with square edge (requires small-diameter clamping flange)	$268
IMPORT		
930-06200715	4mm thick with 2mm radius	$265
930-06200815	4mm thick with square edge	$265
930-06201015	2mm thick with 1mm radius	$251

Grinding Wheels for Weinig R912, R909, R980 and R990 Grinders

CBN (Cubic Boron Nitride) Grinding Wheels

912-062002	For face-grinding of HSS solid cutters	$289
912-062001	For back-grinding of HSS planer knives	$272
912-062003	For back-grinding of corrugated-back HSS knives	$272
912-062008	For face-grinding of HSS fingerjoint cutters	$320

Diamond Grinding Wheels

912-062005	For back-grinding of tungsten carbide knives	$278
912-062006	For face-grinding of TCT solid cutters	$261
912-062009	For back-grinding of TCT inlaid knives	$252

Prices Subject to Change

WEINIG CNC R1000 Grinding Wheels

CBN for HSS Knives

Premium

(150 Diameter)

934-067015	6mm thick with 3mm radius	$1,463.49
934-067014	4mm thick with 2mm radius	$1,463.49
934-067013	3mm thick with 1.5mm radius	$1,275.49
934-067012	2mm thick with 1mm radius	$1,463.49
934-067011	10mm thick straight for planing knives	$1,236.83

(200mm Diameter)

934-067001	6mm thick with 3mm radius	$1,440.72
934-067002	4mm thick with 2mm radius	$1,371.38
934-067004	3mm thick with 1.5mm radius	$1,663.25
934-067003	2mm thick with 1mm radius	$1,593.90
934-067016	1mm thick with .5mm radius	$1,688.09
934-067018	10mm thick straight for planing knives	$1,492.50

Import

(200mm Diameter)

934-067020	6mm thick with 3mm radius	$925.00
934-067021	4mm thick with 2mm radius	$850.00
934-067023	2mm thick with 1mm radius	$825.00

R1000 CBN Grinding Wheel Dressing Stick

VEN700067	Dressing Stick, CBN 150 Grit	$16.95
VEN700068	Dressing Stick, CBN 220 Grit	$17.25
VEN700069	Dressing Stick, CBN 320 Grit	$22.50

Weinig offers CNC grinding wheel re-truing. Call for assistance to return grinding wheels for service.

Prices Subject to Change

Diamond for Carbide Knives

Premium

(200mm Diameter)

934-067005	6mm thick with 3mm radius	$1,968.05
934-067006	4mm thick with 2mm radius	$1,789.26
934-067007	3mm thick with 1.5mm radius	$1,587.29
934-067008	2mm thick with 1mm radius	$1,906.47
12013807	1mm thick with .5mm radius	$1,960.20
934-067019	10mm thick straight for planing knives	$1,195.43

Wheel Flanges for Mounting & Shims

934-06401	Grinding Wheel Mounting Flange for 200mm	$958.05
934-06402	Grinding Wheel Mounting Flange for 150mm	$1,680.00
934-06403	Grinding Wheel Mounting Flange for Straight	$1,511.00
934-062001	Shims 135 x 60 x .05mm for 200mm Wheels	$36.91
934-062002	Shims 135 x 60 x .10mm for 200mm Wheels	$29.04
934-602003	Shims 135 x 60 x .20mm for 200mm wheels	$29.88
934-062004	Shims 90 x 60 x .05mm for 150mm Wheels	$20.50
934-062005	Shims 90 x 6 0x .10mm for 150mm Wheels	$17.00
934-062006	Shims 90 x 60 x .20mm for 150mm Wheels	$17.50

Accessories for R1000 CNC Grinder

R1000 High Capacity Filter Paper Roll	Find on page 46
Coolant Refractometer	Find on page 48
Ultra-Cool Grinder Coolant	Find on page 48
T9 Aerosol Lubricant	Find on page 48
10028878 - Dry Lubricant for Measuring Probe	$151.20

Weinig offers CNC grinding wheel re-truing. Call for assistance to return grinding wheels for service.

Tracing Pins for Rondamat 930, 931, 932, 934, 935, 936, 960, 970

The grinder tracing pin, or stylus, is used to transfer a precise copy of the template onto the knife. To enable you to duplicate any pattern, Weinig offers hardened-steel and carbide tracing pins in a variety of sizes and shapes.

ARTICLE NUMBER	UPPER SIDE	LOWER SIDE	PRICE
930-042001	2mm diameter	3mm diameter	$41
930-042002	4mm semicircular	3mm diameter	$41
930-042003	4mm x 45° pointed	4mm diameter	$41
930-042009	2mm semicircular		$41
930-042010	3mm semicircular		$41
930-042013	1.5mm semicircular		$41
930-042014	1.0mm semicircular		$41
930-042015	5mm semicircular		$41

Tracing Pins for Rondamat 925, 950

ARTICLE NUMBER	UPPER SIDE	PRICE
925-034003	4mm diameter	$47
925-034004	2mm diameter	$47
925-034009	3mm diameter	$47

Application is the same as above-listed tracing pins, but threaded by design on the lower side.

In most cases, use a square tracing pin for roughing out a knife profile.

Single-point Diamond Dresser

Custom-designed for use on Weinig profile grinders to precisely dress and shape the grinding wheel.

Non-threaded
VEN700075 $31

Threaded
925-034008 $34

Multi-point Diamond Dresser

This new multi-point dresser contains a group of diamond points on the surface, and is designed for longer life and more effective dress and shaping of ceramic grinding wheels.

Non-threaded
VEN700085 $59.50

Threaded
925-934008 $68

Rondamat Grinder Clamping Flanges

These clamping flanges are used for mounting grinding wheels on most Rondamat knife grinders. Made from top-quality steel, these items are balanced for true running accuracy.

920-07405	Clamping flange for mechanical locking systems	$200
932-07401	Clamping flange for hydraulic locking systems	$175
932-07402	Small-diameter clamping flange for hydraulic locking systems	$196

Rondamat Grinder Knife Rest

A properly machined knife rest is required to precisely grind knives in the cutterhead. This quality is guaranteed on these Weinig knife rests, which are used on most Rondamat knife grinders.

930-013024	Straight knife rest set Used on Rondamat 930, 931, 932, 934, 935, 936, 960, 970	$172
930-013024HM	Replaceable carbide for above-listed set	$76
932-027001	Beveled knife rest Used for auto-grind on Rondamat 935, 936, 970	$179
930-013024HEL2	Replaceable carbide for grinding helicarb planerheads	$69

Rondamat Filter Sheets Now Improved for Better Filtration

Try our New Generation Filter Sheets that replace our original sheets!

Fine mesh filter sheets used to keep abrasive and steel particles from being recirculated in the flow of the coolant system.
Package of 100 filter sheets.

003-06950 $57

Need the ultimate in filtration? These extra thick filters provide this feature. Especially useful when grinding carbide.
Package of 100 filter sheets.

003-06950XL $69

Prefer the "original" style filter sheets? These are still available.
Package of 100 filter sheets

003-06950G $57

R1000 High Capacity Filter Paper Roll 20 x 375m

006-05343 $111

Also avaible for carbide-specific grinding

12033622 $161.43

Grinding Room Accessories

Rondor Wheel Dresser

With the use of this hand-held tool, the blunt grit of the aluminum oxide grinding wheel is broken away, thus improving the cutting capacity.

006-00191 $174

Rondor Replacement Stone

006-00192 $24.50

Cleaning Stick

When the working surface of the diamond or CBN wheel becomes "loaded" with material from the workpiece, it must be cleaned with this special aluminum oxide cleaning stick to remove embedded particles.

XXX100730 $5

Flat Diamond Stone

This 1" x 6" flat diamond stone is designed with a groove for ease in touch-up re-sharpening of straight knives and inserts.

XXX100729 $16

NEW – Diamond and CBN Dresser Attachment Kit

A retrofit kit that will fit most Weinig grinders. Will allow you to dress your standard grinding wheels, plus diamond and CBN wheels. Complete installation and operating instructions included.

VEN700073SMPK
Dresser unit complete $171

CRATEX Knife Dressing and Deburring Set

Rubber-based block and stick set designed for removal of steel burrs remaining on the knife after finish grinding. Also excellent for removal of rust, burn marks, tarnish and stains.

XXX100738 $26.50

Round Edge Slip Stone

For use when manually generating a sharp edge on knife steel, or when polishing out nicks in profile knives.

XXX100732 $14

Diamond and CBN Wheel Dresser

Special metallic pin designed to fit into the wheel-dresser holder on many Weinig profile grinders; used to precisely reshape diamond and CBN grinding wheels.

For use with VEN700073SMPK Dresser Attachment Kit

VEN700070 $52

Plastic Shims

For use when diamond or CBN grinding wheels must be centered in the clamping flange.

XXX100709	0.001" thick (orange)	.70
XXX100708	0.002" thick (red)	.70
XXX100707	0.005" thick (blue)	.75
XXX1007068	0.010" thick (brown)	.783
XXX1007065	0.025" thick (white)	$1.32

Prices Subject to Change

Acmosit 65-62 Ultra-Cool

A new formulation exclusive for Weinig USA!

Our top-of-the-line coolant for all grinding applications.

- Increased lubricity
- Less odor
- More rust inhibitor

Ultra-Cool Grinding Coolant

5 Kg (1.6 gallon) jug	**VEN700056**	$90
20 Kg (6.5 gallon) jug	**VEN700056L**	$340

Ronda Cool XL Grinding Coolant

Time-tested alternative to our premium Ultra-Cool coolant.

Ronda-Cool XL

1-gallon jug	**VEN700054**	$42
5-gallon pail	**VEN700054L**	$185

Coolant Refractometer

Eliminate the guesswork of proper coolant concentration with this refractometer. Better monitoring of your coolant concentration can improve finish on your knives, increase wheel life, prevent strong odors, and control rust.

VEN700052 $132.50

Rust Preventative Spray

Prevent rust with Weinig's NEW RustFree Preventative Spray 8oz! Tools or machinery parts—it's effective on both. Available in gallon jugs.

XXX100085 $16

T-9 Aerosol Spray Lubricant

Use T-9 Lubricant after cleaning machine parts or tooling with our RustFree Preventative Spray 12 oz.

XXX100084 $22.50

Template Material

For best results, Weinig recommends a template material composed of a combination of steel, carbon, chrome and vanadium. This forms a flat distortion-free counter profile that can be hardened, but is easily shaped even by manual methods.

000-80001	2 61/64" (75mm) x 24" x 1/8"	$19
000-80002	3 11/32" (85mm) x 24" x 1/8"	$22
000-80003	3 47/64" (95mm) x 24" x 1/8"	$24
000-80004	4 9/64" (105mm) x 24" x 1/8"	$26

Acrylic Plexiglas™ template material for use with template makers or for quick manual production of custom templates.

4" x 12"	**VEN060096**	$7

Digital Angle Readout

Decrease your set-up time and improve your tool grinding consistency between operators and grinders

Introducing Weinig's Digital Angle Readout for tool grinders. This precision-focused accessory displays the angle of your tool grinder on an easy-to-read LED screen, assuring each operator sets the grinding angle the same way every time. Since the display is mounted on the control panel, it also improves the operator's ease of set up.

The Digital Angle Readout can easily be installed on most Weinig Tool Grinders. The display is offered as a flush-mount or surface mount. The display also includes its own power supply (requiring 110v) so no electrical modification is needed on the machine.

Surface-Mount Display pictured

KEY BENEFITS

- Gain consistency of your tooling between multiple operators and grinders
- Fast and easy set up with a digital readout verses an on-machine scale
- Decrease unnecessary knife and wheel material loss
- Decrease set-up time by quickly matching the existing/preferred angle

PRICING

- Surface-Mount Display Kit (Article # NGK3) $860

Prices Subject to Change

Pressure Release Valve #32365 M10x1

Made of zinc-plated steel, absolutely tight up to 800 bar, complete with special seal.

003-03856 $10.60

Replacement rubber seal ring

003-27332 $2.50

Seal ring for old-style release valve

003-11901 $3.50

Hydraulic Grease Fitting #32319 M10x1

Made of hardened steel, absolutely tight up to 800 bar, complete with special seal.

003-11560 $12

Replacement rubber seal ring

003-27332 $2.50

Seal ring for old-style grease fitting

003-11901 $3.50

International Grade #3 Grease Cartridge

Recommended for use in hydro-clamping systems, the International Grade #3 grease packed into the cartridge is a superior industrial grease for lubrication applications where durability, long life and rust-prevention are essential.

003-17520 $10.60

Grade #2 Grease Cartridge

For use with central lubrication system.

003-17500 $7.50

Special Hydraulic Grease Gun 0-400 Bar

For use in hydro-clamping systems and direct machine lubrication (non-central lube).

003-09103 $567

Individual spare parts available from stock, and listed with prices on website, tooling.weinigusa.com.

Repair Kit for Hydraulic Grease Gun

Contents include six different spare parts that have historically solved approximately 95% of the minor wear problems occurring with the special hydraulic grease gun.

For old-style hydraulic grease gun (#003-09100)

003-09134K $48

For new-style hydraulic grease gun (#003-09103)

003-09139K $117

Grease Gun for Central Lubrication Systems

003-09091 $160

Prices Subject to Change

Waxilit Table Lubricant

Waxilit is the original table lubricant furnished with Weinig moulders worldwide. This product is considered the standard by which all table lubricants are compared. Waxilit qualities include:

- Excellent non-sticking table lubrication
- Will not stain the wood
- Will not adversely affect paints and stains
- Prevents formation of rust
- Will not contaminate pumps, lines or nozzles
- Classified non-hazardous for shipping purposes

WAXILIT

5 Kg (1.6-gal.) can	**XXX100083**	$56
20 Kg (6.5-gal.) can	**XXX100083L**	$208
160 Kg (52-gal.) drum	**XXX100083A**	$1,542
Waxilit Aersol Can (13.5 oz.)	**XXX100082**	$19

Waxiglide Table Lubricant

Available as an alternative to Waxilit, this product is suitable for use as a table lubricant when producing construction or non-paint-grade materials.

WAXIGLIDE

5-gallon can	**XXX100074L**	$190
55-gallon drum	**XXX100074A**	$1,700

Cutter-Guard Tool and Machinery Cleaner

An environmentally safe cleaner for the woodworking industry, Cutter-Guard removes and prevents wood residue deposits while providing a moisture-resistant barrier to prevent rust. This helps your woodworking machinery run more efficiently.

- Chemical tunneling action that gets under the grease and grime for easy removal
- Protects ferrous metals, preventing rust formation on tools and machinery
- Environmentally safe to use, and totally biodegradable for easy disposal after use
- Can be sprayed directly onto machinery, or used in ultrasonic or diptank parts cleaners
- Safe on washable surfaces

CUTTER-GUARD

1-gallon jug	**XXX100380**	$18
5-gallon pail	**XXX100380L**	$74
55-gallon drum	**XXX100380A**	$583

Polyurethane Flex Hose—For Internal Moulder-dust Extraction

Most urethane flex hoses available in North America encapsulate the wire reinforcement in the middle of the hose wall. Hose available from Weinig, however, has a urethane layer extruded around the wire located on the outside of the hose wall. This produces a full internal hose wall, resulting in a more flexible and wear-resistant material. Because Weinig flex hose is manufactured from a clear polyester-based urethane, wear life is increased as much as 30% over industry-standard polyether-based urethane. Although the cost is 2-3 times more expensive than PVC, TPR, or Neoprene, the wear life is 5-10 times longer.

Now available in two styles.

Standard quality and thickness, as delivered with new Weinig moulders and ripsaws
Minimum 10′ length, sold in 5′ increments

ARTICLE NUMBER	HOSE DIAMETER (INSIDE DIAMTER)	PRICE
003-04428	120mm (4 23/32″)	$13.25
003-04456	140mm (5 1/2″)	$14.50
003-04419	160mm (6 9/32″)	$17.25
003-04433	200mm (7 7/8″)	$23.00
003-04418	250mm (9 27/32″)	$27.50
FLX-300	300mm (11 13/16″)	$31.00

Optional heavy-duty quality and thickness, for more abrasion resistance
Minimum 10′ length, sold in 5′ increments

ARTICLE NUMBER	HOSE DIAMETER (INSIDE DIAMTER)	PRICE
003-044281HD	120mm (4 23/32″)	$21.00
003-044561HD	140mm (5 1/2″)	$26.00
003-044191HD	160mm (6 9/32″)	$30.50
003-044331HD	200mm (7 7/8″)	$44.00
003-044181HD	250mm (9 27/32″)	$53.00
FLX-3001HD	300mm (11 13/16″)	$61.00

Safety Locking Collars

For clamping together with less than full-width hydro-clamping cutterheads as a preventative measure against the tool loosening and spinning on the cutting shaft.

WNW-101719	Safety locking collar for 1 13/16″ spindles	$126
WNW-101720	Safety locking collar for 2 1/8″ spindles	$126

Straight Edge

Precision machinist straight edge for use when positioning cutting tools and pressure shoes.

WNW-0287	10″ length	$47

Servolock Tool Wrench

A revolution in clamping of conventional bore tools!

Did you ever have problems with the conventional tool wrench? Our new solution tightens the spindle nut on vertical and horizontal spindles—no adjustments on the machine are necessary! Save time and frustration with Weinig's Servolock Tool Wrench.

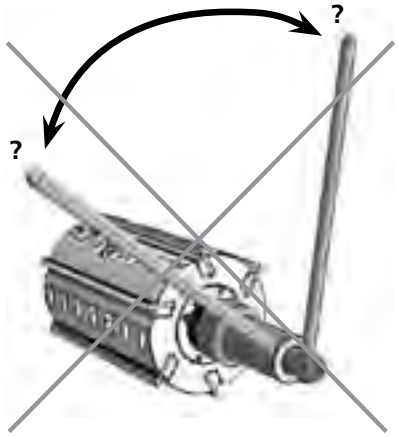
Weinig patented tool offers the following benefits:

- Quick tightening and loosening of the spindle nut
- Operation requires much less effort than conventional tool wrench
- Easy handling due to indication of rotational direction
- Always the correct tightening torque due to friction clutch
- For all moulders with conventional spindles and PowerLock adapters that use SW50 spindle nuts

35036001 Servo Tool Wrench $995

new solution

old method



Watch Servolock in action at https://youtu.be/kg4lk-aD0e4

Prices Subject to Change

High-purity Silicon Carbide Stones Offer Best Choice

After many years of product testing, Weinig moulder operators worldwide have endorsed the following selection of jointing stones. These stones, made of high-purity silicon carbide, provide longer stone life, give a superior finish, and prevent accumulation of steel chips in the stone. They offer the best possible choice for your applications.

Grit Size: The finer (higher number) the grit, the better the finish, because the stone is softer. Coarse grit stones will last longer.

Vitrified Bond: Easier to form, cuts cooler. Now with improved quality!

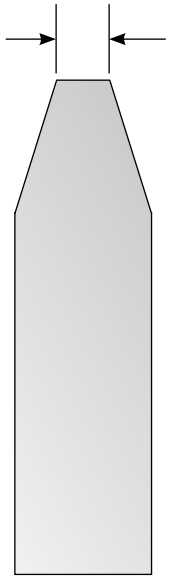
Resin Bond: Provides a better finish quality.

ARTICLE NUMBER	JOINTING STONE FOR	SIZE MM	BOND	COLOR	GRIT	PRICE
006-00187	HSS Profiling	160 x 60 x 15	Vitrified	Blue-Grey	600	$19.60
006-00188	HSS Profiling	160 x 60 x 15	Resin	Green	600	$22.25
006-00377	HSS Profiling	160 x 60 x 15	Resin	Green	500	$20.00
XXX100786	P2400 Profiling	160 x 60 x 15	Resin	Green	500	$29.00
006-00370	HSS Profiling	230 x 60 x 15	Vitrified	Blue-Grey	600	$24.50
006-00095	HSS Profiling	230 x 60 x 15	Resin	Green	600	$28.50
006-02121	HSS Profiling	230 x 60 x 15	Resin	Green	500	$27.00
XXX100727	HSS Profiling	300 x 60 x 15	Resin	Green	600	$39.00
251-362002	HSS Planing	20 x 60 x 15	Resin	Green	500	$7.25
006-01654	HSS Planing	20 x 60 x 15	Vitrified	White	240	$7.25
006-02116	HSS Planing	12 x 38	Vitrified	Blue-Grey	280	$5.00
XXX100787	P2400 Planing	12 x 38	Resin	Green	500	$14.00
WAC501522	HSS Planing	16 x 125	Vitrified	Dark Grey	220	$13.25
WAC501522 SPEC	HSS Planing	16 x 125	Vitrified	White	240	$13.50
006-00186	HSS Planing	20 x 100 x 10	Vitrified	Blue-Grey	280	$5.50
XXX100724	Carbide Profiling	160 x 60 x 15	Special	Blue-Grey	600	$21.00
XXX100720	Carbide Profiling	230 x 60 x 15	Special	Blue-Grey	600	$25.00
XXX100722	Carbide Planing	20 x 60 x 15	Special	Dark Grey	240	$7.00
XXX100731	Carbide Planing	12 x 38	Special	Dark Grey	240	$5.00
WAC501522HM	Carbide Planing	16 x 125	Special	Dark Grey	240	$17.50

PROFILE STONE SIZE:
6 19/64" x 2 23/64" x 19/32",
9 1/16" x 2 23/64" x 19/32", or
12" x 2 23/64" x 19/32"

PLANING STONE SIZE:
25/32" x 2 23/64" x 19/32" or
25/32" x 3 15/16" x 25/64"

ROUND PLANING STONE SIZE:
15/32" x 1 1/2" or
5/8" x 4 59/64"



Finished jointing stone, end view

For the very best attainable finish when straight-knife jointing

ARTICLE NUMBER	JOINTING STONE FOR	SIZE MM	TYPE	PRICE
XXX100703	HSS planing	12 x 32	CBN	$126
XXX100704	Carbide planing	12 x 32	Diamond	$126

Weinig Pointed Tooth Roller 2.0

The standard infeed rollers furnished on all new moulders are the Weinig Pointed Tooth steel tooth rollers 2.0. The main advantages of this style are:

- A primary and secondary tooth work together as a pair, giving the effect of twice as many teeth
- Hard chromed surface on both primary and secondary tooth patterns, resulting in longer service life
- Sloped gullet improves clearing of chips and reduces surface marking
- Still with a maximum "tooth mark" indention of only 3mm (1/8") deep

ARTICLE NUMBER	SIZE	PRICE
340-291001	5 1/2" OD x 2" wide roller for 35mm keyed shaft	$228
023-291112	5 1/2" OD x 1 1/4" wide roller for 35mm keyed shaft	$225
340-291002	5 1/2" OD x 5/8" wide roller for 35mm keyed shaft	$173
023-291115	5 1/2" OD x 3/8" wide roller for 35mm keyed shaft	$180
023-291110	5 1/2" OD x 3/4" wide roller for 35mm keyed shaft with extended hub	$205
143-618002	5 1/2" OD x 5/8" wide roller for 35mm keyed shaft with extended hub	$244
023-291188	5 1/2" OD x 3/4" wide cup (bolt-on) roller for 30mm shaft	$234
023-291183	5 1/2" OD x 5/8" wide cup (bolt-on) roller for 30mm shaft	$197
023-291128	5 1/2" OD x 3/8" wide cup (bolt-on) roller for 30mm shaft	$276
023-291155	5 1/2" OD x 5/16" wide cup (bolt-on) roller for 30mm shaft	$300
023-291127	5 1/2" OD x 3/4" wide cup (bolt-on) roller for 20mm bore	$281
0279251307	100 OD x 50 wide x 35mm keyed shaft for cube	$493.44

Rough and Wet Timber Feed Roller

For use on Weinig moulders during production of difficult-to-feed material. This unique design allows the teeth to penetrate the wood up to 4.2mm (5/32") deep.

023-9082432 5 1/2" OD x 2" wide roller For 35mm keyed shaft $281

Saw Tooth Feed Roller

Primarily for hardwood applications, as an alternative to roller 340-291001.

022-181001 5 1/2" OD x 2" wide roller For 35mm keyed shaft $186

Prices Subject to Change

Steel Knurled Rollers

Alternatives to the tooth-feed rollers are the steel knurled rollers. These rollers are primarily designed for use when only scant material is being removed from the top surface of the workpiece. The teeth on the contact surface have a maximum "tooth mark" indentation of less than 1mm (1/32") deep. As with the tooth feed rollers, the contact surface of this roller is also covered with a layer of hard chrome.

ARTICLE NUMBER	SIZE	PRICE
143-618005	5 1/2" OD x 2" wide roller for 35mm keyed shaft - *New Design*	$205
143-618003	5 1/2" OD x 3/4" wide roller for 35mm keyed shaft with extended hub	$455
143-618004	5 1/2" OD x 5/8" wide roller for 35mm keyed shaft with extended hub	$410
K27-555015	5 1/2" OD x 3/4" wide cup (bolt-on) roller for 30mm shaft	$443
K27-555014	5 1/2" OD x 5/8" wide cup (bolt-on) roller for 30mm shaft	$531
0279235145	100 OD x 50 wide for 35mm keyed shaft for Cube	$266

Solid Urethane Rollers

The Weinig urethane feed rollers are better than ever, combining advanced roller design, the latest materials, and most important, feedback from Weinig customers. With our new urethane compound and roller design, you get the grip of a soft roller with the durability and strength of a hard roller. The new generation feed roller offers these advantages:

- Requires less pressure and provides increased traction without the problem of raised grain
- Consistent wheel material means more resistance to heat and abrasion, and uniform quality from roller to roller
- Rollers for keyed shafts are made with solid aluminum cores; cup rollers have solid urethane cores
- Rollers with higher durometers are harder and run longer. Rollers with lower durometers grip better

ARTICLE NUMBER	SIZE	DURO-METER	PRICE
226-106009	5 1/2" OD x 2" wide for 35mm keyed shaft	80	$90
226-106009V	5 1/2" OD x 2" wide for 35mm keyed shaft	65	$111
143-618007	5 1/2" OD x 1 1/4" wide for 35mm keyed shaft	80	$90
143-618007V	5 1/2" OD x 1 1/4" wide for 35mm keyed shaft	65	$104
042-362006	5 1/2" OD x 3/4" wide for 35mm keyed shaft	80	$70
042-362007	5 1/2" OD x 5/8" wide for 35mm keyed shaft	80	$73
042-362007V	5 1/2" OD x 5/8" wide for 35mm keyed shaft	65	$76
042-36200710	5 1/2" OD x 3/8" wide for 35mm keyed shaft	80	$84
014-192018	5 1/2" OD x 1 1/2" wide cup (bolt-on) for 30mm shaft	80	$50
014-192019	5 1/2" OD x 3/4" wide cup (bolt-on) for 30mm shaft	80	$37
014-192020	5 1/2" OD x 5/8" wide cup (bolt-on) for 30mm shaft	80	$37
014-192021	5 1/2" OD x 1/2" wide cup (bolt-on) for 30mm shaft	80	$35
014-192021V	5 1/2" OD x 1/2" wide cup (bolt-on) for 30mm shaft	65	$35
0279237146	100 OD x 50 wide for 35mm keyed shaft for Cube	80	$195.36

Prices Subject to Change

Replaceable Tire System

For high-speed, high-wear applications, we recommend the Weinig Replaceable Tire System. It offers the convenience and price economy of replaceable tires. After a one-time purchase of the reusable metal feed hubs, the replaceable tires offer a more economical option. Weinig replaceable tires will fit the feed hubs on many moulders and planers currently in operation. Weinig steel feed hubs have a unique new design. A locking setscrew located in a recess in the hub allows the feed wheels to be stacked together flush, without the necessity of locking collars or spacers.

ARTICLE NUMBER	DESCRIPTION	SIZE	DURO-METER	PRICE
XXX100840	Replaceable tire	5 1/2" OD x 2" wide	80	$24.50
XXX100850	Replaceable tire	5 1/2" OD x 2" wide	85	$24.50
XXX100840V	Replaceable tire	5 1/2" OD x 2" wide	65	$24.50
XXX100870	Replaceable tire	6 3/4" OD x 2" wide	80	$52.00
XXX100845	Replaceable tire	5 1/2" OD x 3/4" wide	80	$19.00
XXX100855	Replaceable tire	5 1/2" OD x 3/4" wide	85	$20.00
XXX100845V	Replaceable tire	5 1/2" OD x 3/4" wide	65	$20.00
XXX100900	Keyed steel feed hub	For 2" wide replaceable tire		$138
XXX100902	Keyed steel feed hub	For 3/4" wide replaceable tire		$143
XXX100905	Steel cup feed hub	For 3/4" wide replaceable tire		$169

Center Locking Washer for Stacking Cup Feed Rollers

250-233007	For use with steel cup rollers	$19
250-2330071	For use with urethane and knurled cup rollers	$19

Custom Pressure Shoes

Inconsistent pattern – or "chatter"– can mar a finished product. The problem is caused by movement of the piece during the cut, and can be prevented by making sure the workpiece moves only in the direction of the outfeed.

Weinig's custom nylon pressure shoes can eliminate chatter caused by incorrect or uneven pressure. As a bonus, the special nylon material provides a smooth, non-marking surface that eliminates shiny spots.

To purchase counter profile shoes, contact directly:

Advanced Moulding Technology
Phone: 1-318-544-2370
Email:
amt@advancedmouldingtech.com

Flat Pressure Shoes – Available from stock
Provide smooth, consistent pressure on top-planed surfaces and profiles with even contact points. You can actually allow the profile to slowly "wear into" the flat pressure, or hold-down shoe.

Chipbreaker Shoes – Available from stock
Allows chipbreaker shoes to be brought in close to the cutterhead to help eliminate chatter, without fear of accidental machine damage.

Counter Profile Shoes
Provide consistent pressure on all points of the product profile. Available within a week of receipt of product sample or electronic drawing.

Make sure the longest possible chipbreaker pad is being used. The contact point of the pad on the workpiece should be as close as possible to the cutterhead without interfering with the knives.

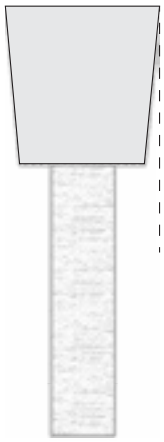
MOULDER BLANK BLADES - 3.5mm (.138”) kerf

Cut Quality

- Higher radial angle grind on the tips results in a rough finish with very distinctive sawing marks.

Blade Characteristics

- Less drag and lower heat generated on the saw tips results in longer run time.
- Less buildup on the body increases the number of available sharpenings.
- Weinig blades have a Triple Chip grind on the teeth.



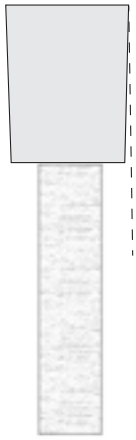
GLUE-LINE BLADES - 4.0mm (.157”) kerf

Cut Quality

- Better finish than moulder blank blades with minimal sawing marks.
- Product is ready for gluing or other secondary processing.

Blade Characteristics

- Reduced radial angles decrease run time, creating more drag, heat and buildup, which means fewer available sharpenings.
- Weinig blades have a Triple Chip grind on the teeth.



THIN KERF BLADES - 2.8mm (.110”) kerf

Cut Quality

- Offer savings on wood consumption.
- Reduced stability, so attaining a glue-line finish is difficult, but not impossible.

Blade Characteristics

- Generally, blade characteristics are similar to those of glue line blades.
- Weinig blades have an ATB grind with corner bevel.
- Now with coated plates for increased stability.

NOW FROM WEINIG
3 Selections to Suit Your Needs

For additional selection guidelines, see page 51

Premium Glue-line Quality Blades

- Improved glue-line quality cut
- Increased stability
- Reduced build-up and heat
- Increased run-time
- Reduced plate thickness for extra regrind area

ARTICLE NUMBER	USAGE	BLADE KERF MM	# OF TEETH	FEED RATE FPM	PRICE
9119153	Alternative blade for low feed rate saws	4.0	28	50-115	$126
9119161	Standard blade supplied with all new KM/KR saws	4.0	36	80-166	$142
9119186	Alternative blade for KR saws with high-speed package	4.0	48	130-260	$171
9119189	Alternative blade for KR saws with high-speed package	4.0	60	260-400	$187
9119272	Optional thin kerf blade	2.8	28	50-115	$144
9119274	Optional thin kerf blade	2.8	36	80-166	$154
9119276	Optional thin kerf blade	2.8	48	130-260	$189

Moulder Blank (Non-guaranteed Glue-line) Blades

- Increased number of available sharpenings
- Longer run-time than glue-line blades, due to less drag and heat
- Less expensive

ARTICLE NUMBER	BLADE KERF MM	# OF TEETH	FEED RATE FPM	PRICE
9119354	3.5	28	50-115	$89
9119362	3.5	36	80-166	$95
9119387	3.5	48	130-260	$100

Special Application Blades

ARTICLE NUMBER	USAGE	BLADE KERF MM	# OF TEETH	FEED RATE FPM	PRICE
9119163	Special 330mm OD blade	4.0	28	50-115	$257
917340	Special 350mm OD blade	4.0	28	50-115	$226
9119165	Special 360mm OD blade	4.0	36	80-130	$194

Prices Subject to Change

Standard Hogcut

Carbide-tipped hogger unit designed for use on Raimann ripsaws. Price includes one trim saw (already attached).Clamping device required.

9121435	300 x 18.6 for RH (inside) position	$1,300
9121425	300 x 18.6 for LH (outside) position	$1,300

Additional Trim Saws

91214352B	300 x 36T for RH (inside) Hogcut #9121435-Standard	$284
9121435B	300 x 48T for RH (inside) Hogcut #9121435-Optional	$299
91214252B	300 x 36T for LH (outside) Hogcut #9121425-Standard	$284
9121425B	300 x 48T for LH (outside) Hogcut #9121425-Optional	$299

Hogfix Fixed Clamping Device for Quickfix Arbor

Fixed clamping flange for Standard TCT Hogcut

349518 $578

Hogfix Fixed Clamping Device for Standard (Non-Quickfix) Arbor

Fixed clamping flange for standard TCT Hogcut

349435 $2,258

Prices Subject to Change

Quickfix Fixed Clamping Device

Clamping flange for a single saw blade

312196	For production of up to 6/4 lumber	$462
312196 SD	For production of 8/4 lumber and larger	$625

Quickfix Movable Clamping Device

Clamping flange for a single saw blade on the movable head

336336	Clamping flange only	$2,336

Standard Locking (Non-Quickfix) Fixed Clamping Device

Clamping flange for a single saw blade $1,885

317778	New Quickfix release clamping flange only	$998
311636	Standard clamping flange only	

Replacement Spikes for Raimann Ripsaw Feed Chains

Sold in packages of 100pcs

903762	6mm	.90 ea.
903761	7mm	.90 ea.
903760	8mm	.90 ea.

Prices Subject to Change

New and Improved Lubrication Accessories

Van-O-Glide lubricant for use with spray mist systems

XXX100073L	5-gallon pail	$230
XXX100073A	55-gallon drum	$2,200

Hydraulic Oil for Quickfix Saw Arbors

349001	$16.50

Lubrication Oil for Feed Chain

New formulation for better lubrication and less run-off

PUS750100	5-gallon pail	$236
PU5750100A	55-gallon drum	$1,890

Oil for Arbor Lubrication

New formulation for better lubrication, eliminates sticking and buildup problems

PUS909715	5-gallon pail	$142
PU5909715A	55-gallon drum	$1,092

Nylon Pressure Boards for Raimann Ripsaws

Boards made from this material have longer life than standard phenolic or laminated wood boards and, due to improved design, they provide better hold-down capabilities. Available in both open and closed designs. Allso available in an aluminum board with replaceable nylon wear strips.

Since applications and sizes vary, please contact the Weinig Parts Department with your machine model.

Crosscut Saws
NEW DESIGN - For the Best Cut Ever!

Grecon Dimter, a member of the Weinig Group since 1993, offers optimizing crosscut saws and fingerjointing machines that let you increase your yield from each piece of wood, minimize your waste, and produce wood that is strong and defect-free. Like Weinig moulders and grinders, the precision machinery produced by Grecon Dimter requires precision tooling for ultimate performance.

Our precision saw blades are designed specifically to provide maximum performance quality for your crosscut saw. Blades are available from stock; simply select the one that fits your production requirements. Note that larger-diameter blades will not fit all crosscut saw models.

Weinig Crosscut Saw Blades

Standard stocking blades for all solid woods

(All blades have 30mm bore unless noted otherwise.)

48032583S	400mm OD	Z114	$378
48033731S	450mm OD	Z132	$410
48033741S	500mm OD	Z144	$541
48033880S	500mm OD *harder carbide for composites*	Z144	$567
48034000S	630mm OD	Z180	$798
48033850S	500mm OD *Special for S35 and S50 saw with 35mm arbor*	Z144	$572

Glue Release Spray

The best seller in the woodworking industry!

Universally functional as a release agent against all glues used in woodworking, including hot melt. Any clean surface treated with this aerosol, even inside a gluepot, will eliminate glue sticking. Can also be used on moving parts, such as pressure rollers.

XXX1002450	400ml Aerosol can	$20

5kg & 20kg Pails Available

Fluorescent Marking Crayons

Designed Specifically for the Woodworking Industry

Are you tired of using optimizer marking crayons that shatter when dropped? That fail to maintain consistent fluorescent marking quality throughout? That crumble, creating transfer marks on the wood? Most marking crayons currently in use were designed for other purposes, so these are just a few of the problems we experience when using them.

Finally, you can avoid these problems. After months of research and development, Weinig now has available from stock a quality marking crayon especially for our industry. Give it a try. Once you experience the many benefits of this marking crayon, you'll never be satisfied with the others.

Fluorescent Optimizing Crayons
(packed 12 pieces per box)
Recommended for maximum efficiency,
especially with older cameras

91062210A	Standard Red	$1.55 ea
91062211A	Optional Orange	$1.55 ea
91062212A	Optional Watermelon	$2.10 ea
8290082286	Invisible Blue	$2.20 ea

For those who still prefer the original Dimter crayon
initially furnished with new saws

91062210	Old Style Red	$1.55 ea
91062220	Pink Chalk	$1.55 ea

Marking Crayons for
Rough-cut and Wet Lumber

(Non-fluorescent, packed 12 pieces per box)

90763320A	Blue	$1.20 ea
90763321A	Black	$1.20 ea

Crayon Holder

91065555A	Standard	$23
85489CH	Special for Invisible Blue Crayon	$23

Spare Parts

Spare parts are a critical aspect of the service and support that sets Weinig apart from other machinery manufacturers.

- Over $8 million in parts inventory located in the United States.
- Online access to Weinig Germany records for quick and accurate research information.
- Over 110 years of combined experience in providing skilled and knowledgeable customer service support.

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Have you looked at the Weinig USA Tooling, Supplies & Replacement Parts Online Shopping Cart lately? If you haven't, then you are missing an incredible opportunity to save money, and order 24/7. We currently have over 2,500 items available with more being added daily. Everything from cutterheads to knife steel to saw blades to spindle belts to bearings—it's now there. Enjoy more availability, plus an automatic 2% discount on all orders placed in the Shopping Cart.

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To express our appreciation, we have a line of quality merchandise that you can get free using Weinig Reward Points. The more you purchase online, the more points you receive, and the more valuable your merchandise.

Prices Subject to Change

Daily Operation Reminders

(Should be copied and posted at the Moulder)

1. No one is allowed to work with this WEINIG POWERMAT moulder without proper training from a certified WEINIG technician, or someone currently within the company who has been trained in similar fashion.

2. Visually inspect the tool before inserting into the moulder. Make sure that the tool and knives are not damaged or dull, and that the tool has the proper rotation and RPM rating. Knife steel taller than 2 ¾" is prohibited.

3. Cleanliness is EXTREMELY important between the PowerLock shank and receiver. Even before release and removal of the tool, you need to remove any existing wood chips and dust from around the tool area. Use of the PowerLock cleaning device #00603226 on the tool receiver is recommended with every tool change. Use of cleaning device #00603229 for additional cleaning of the tool shank is also important. NEVER use compressed air to clean the moulder without having tools in the receiver, as this will blow debris back into the receiver.

4. To ensure that all tools are properly clamped and running, it is important that the connecting surface of both the tool and spindle receiver are perfectly clean, without dust or rust being present. Do not lubricate the clamping fingers.

5. NEVER move the spindle proximity switches. This could reduce your clamping monitoring and safety, and eventually could lead to a catastrophic tool failure. For proper proximity-switch maintenance procedures, refer to section 10.5.5 in the operating manual or at www.weinig.com.

6. It is important that the machine operate at proper feed speeds. Feed speeds that are too slow will cause the tool to transfer heat into the receiver, which could lead to damage in the front spindle bearings.

7. Failure to properly clean tools and spindle receiver could result in broken parts, and a decrease in reliability. Always inspect for contamination of tool taper shank, clamping surface and contact face, as well as the inside area of the tool shank and spindle receiver. Any tool collision could result in some form of damage to the clamping system and/or spindle bearings. The spindle should be properly inspected by a trained Weinig technician to ensure the integrity of the spindle.

8. Review weekly your instruction and safety manuals for both the POWERMAT moulder and PowerLock tooling.

9. This moulder is designed for high precision and accuracy. Treat it with respect and care, and you will receive many years of top-quality operation.

For more information:

Ph: 801.451.5987

Email: rr@mirror-reflections.com

Prices Subject to Change

Daily Operation Reminders

(Should be copied and posted in Grinder and Tool Room)

1. No one is allowed to work with this WEINIG grinder without proper training from a certified WEINIG technician, or someone currently within the company who has been trained in similar fashion.

2. Visually inspect the tool before inserting into the grinder. Make sure that the tool is not damaged, and that the tool has the proper rotation and RPM rating for the application.

3. Cleanliness is EXTREMELY important. It is a good practice to soak cutterheads in Cutterguard (or an ultrasonic cleaner) after each production run in order to remove wood dust and resin from the surface of the tool, bottom of the knife pockets, corrugations, and gibs.

4. Ensure that knives and clamping wedges have the same thickness. The knives MUST be balanced within 0.1 gram (0.0035 oz.) of each other for proper performance. Follow these procedures for balancing knife steel:

    a. After the steel is cut to length, balance to the tolerance listed above.
    b. Complete the rough grind on all the knives.
    c. Remove the knives from the cutterhead, rebalance to the acceptable tolerance, and then reinstall into the cutterhead. Properly torque gib screws at this time.
    d. Complete the finish grind on the knives.

5. For true running accuracy of PowerLock tooling, it is essential that knives be installed according to the leaflet "PowerLock Knife Installation Procedures," as shown in the operator's manual.

6. The runout from one knife to the other should never exceed 0.02mm (0.001"). In addition, the maximum offset that is allowed in regrinds to 90° profiles is 0.030", and only for correct dimensioning. Check this runout with the OCMS or similar measuring stand.

7. Review weekly your instruction and safety manuals for both the Rondamat grinder and PowerLock tooling. Also, review the more specific instructions on the handling of PowerLock tools as shown in the WEINIG Tooling & Supplies Catalog.

For more information:
Phone: 801-451-5987
Email: rr@mirror-reflections.com

Prices Subject to Change

12,000 RPM Powermat Moulders

Q: How should the knives be balanced in PowerLock cutterheads?

A: All knives and filler strips must have the same thickness and length, and MUST be balanced within 0.1 gram (0.0035 oz) of each other for proper performance of the spindle bearings and product finish quality. Balance procedures should be as follow:

1. After the steel is cut to length, balance the knives to the above-listed tolerance. It is recommended that all knives for each profile be cut from the same bar, in order to keep a consistent corrugation match.
2. Complete the rough-grind on the knives.
3. Remove the knives from the cutterhead, rebalance to within 0.1 gram, and then re-install into the cutterhead.
4. Complete the finish grind on the knives. Never assume that someone else has balanced tools. Balance is extremely critical at the higher spindle rpm.

Q: Is it true that cleanliness is more important when running at higher spindle rpm?

A: Cleanliness is EXTREMELY important between the PowerLock shank and receiver. Perform frequent visual inspections for burrs, wood-dust accumulation or damage on the tool taper, as tool breakage can occur if there is contamination. Use of the PowerLock cleaning device #006-03226 and #006-03229 is recommended with every tool change. Use of a suede glove for additional cleaning of the receiver area also is helpful.

Q: We always see an accumulation of wood dust and resin on the tool body. How does this affect the performance of the tool?

A: All PowerLock cutterheads are balanced to a tolerance that allows maximum operating efficiency, without damage to spindle bearings. An excess accumulation of wood dust or resin will cause the tool to become out of balance, thus creating stress on the spindle bearings. It is a good practice to soak cutterheads in CutterGuard after each production run, in order to remove this material from the surface of the tool, bottom of the knife pockets, corrugations, and gibs.

Q: Why are PowerLock tools manufactured with a smaller diameter, as compared with my standard moulder tooling?

A: There are two reasons. (1) Since you do not have a bore in these cutterheads, there is no need for a larger diameter. (2) Due to the HSK locking system used on 12,000 rpm Powermat moulders, there is a weight limitation of 30 lbs. per tool. In order to run 240mm cutterheads, this smaller diameter is needed to meet this weight limitation. More importantly, this permits the chipbreaker shoes, hold-downs, and table plates to be brought closer to the cutterheads, ensuring more rigid control of the material as it moves through the moulder, and resulting in better finish quality.

Q: We already have other moulders that run at 6,000 rpm. Is there anything different in operating procedures on tooling to be used on 12,000 rpm moulders?

A: Definitely YES! Many operators have developed habits that are satisfactory for lower rpm moulders, but are not sufficient for the higher rpm. Retraining for these operators is strongly recommended. To get proper performance for your moulder, tool balance, safety, cleanliness, proper gib screw torque, and weight restrictions are much more critical at 12,000 rpms.

Q: Why can't I run my conventional cutterhead at 12,000 rpm on a spindle adapter?

A: First of all, your standard cutterheads are probably rated for 8,000 rpm maximum, and you should never exceed the rating stamped on the cutterhead. Also, the conventional cutterhead/spindle adapter combination may create a tool that exceeds the weight limitations specified for safe operation on the Powermat moulder.

12,000 RPM Powermat Moulders

Please remember that on combination tools manufactured for your moulder, all components of the tool must be rated for 12,000 rpm operation both individually and collectively, and must be balanced to G2.5 balance rating as a complete unit.

Q: We only have 100mm and 240mm PowerLock cutterheads with our new Powermat. Is it okay to run smaller profiles in these tools?

A: The answer to this question is both yes and no. Although it is possible to run smaller profiles in longer cutterheads, this practice is strongly discouraged. Unless you can guarantee that your knives are perfectly aligned, and that the filler strips used in the balance of the empty slot are perfectly balanced and aligned, then you will create imbalance in your cutterheads. This will, in turn, affect the life of your spindle. Or, if you are grinding a small profile into a knife the length of your cutterhead, you are wasting knife steel, grinding supplies, and grinding time. It is ALWAYS recommended to use the smallest possible cutterhead required for your profile.

Q: Can we offset our knives (aka "split knives") in PowerLock tools running at 12,000 rpm?

A: NO, for reasons of balance and the resulting spindle damage. The maximum offset that is allowed in ground corrugated knives is 0.030". This offset should only be used to correct dimensioning of regrinds of 90° profiles, and never for long knives such as flooring relief cutters.

Q: Many companies supply tooling for standard 6,000 rpm moulders. Is this also true for Powermat moulders?

A: Although this market has been opened to all tooling manufacturers, we urge you to be extremely careful in your selection of tooling suppliers. They MUST be able to furnish a tool-speed test certificate, verifying that the tool has been qualified for safe operation at the fixed spindle rpm. Without this assurance, you can jeopardize the performance of your moulder, voiding any warranty that you might have or causing premature spindle failure. You also should insist on a balance certificate, certifying that the tool is balanced to a G2.5 level, for the same reasons just listed.

Prices Subject to Change

Regarding Operation of Weinig PowerLock Cutterheads #538 and Powermat Moulders

1. For safety reasons, the maximum adjustment of re-ground knives must not exceed four corrugations (1/4") from the bottom. There is a line on the cutterhead that indicates the maximum outward adjustment.

2. Knives and clamping wedges must have the same thickness, and MUST be balanced within 0.1 gram (0.0035 oz.) of each other for proper performance. This is very important, as performance of the moulder and the finished surface of the wood depend on the smooth running of balanced tools.

3. Different clamping wedges are required when 3/8" (10mm) thick knife steel is used.

4. Never exceed the maximum speed specified on the tool.

5. Cleanliness is extremely important between the PowerLock shank and receiver. Perform frequent visual inspections for burrs or damage on the tool taper, as tool breakage can occur if there is contamination. Use of PowerLock taper cleaning device #006-03226 (page 10) is recommended on EVERY cutterhead exchange.

6. Maximum tool weight when running at 10,000 and 12,000 rpm is 30 pounds. This tool is required to be an integrated one-piece tool (no adapters or tool-holders allowed), as technically specified by Weinig.

7. When using PowerLock adapters for conventional tools, the cutting tool dimensions and weights must not exceed the limits specified below. Note that minimum spindle adapter size is 1.5" for all horizontal spindles.

6,000 rpm	77 lbs	240mm tool length
8,000 rpm	44 lbs	240mm tool length on 122mm OD tools
		180mm tool length on 137mm OD tools
		150mm tool length on 150mm OD tools
10,000 rpm+	Use of spindle adapters prohibited	

Remember never to exceed the maximum speed stamped on the tool.

8. Use of non-certified tooling is not recommended. Custom-tooling manufacturers must be able to furnish a tool-speed test AND balance certificate.

Proper Installation of Corrugated Knives

1. Remove dirt and resin from the clamping wedges and cutterhead serrations.
2. Insert the corrugated knife (16-60º corrugations) and clamping wedge.
3. Mount the setting device (Weinig #507-330001) on the tool as shown, and axially press against the shoulder.
4. Axially position the corrugated knife and clamping wedge against the setting device and tension the middle clamping screw. Remove the setting device.
5. Check the knife to ensure proper fit into the cutterhead corrugations.
6. Tighten the clamping bolts from the middle bolt outward (example: for a cutterhead slot requiring five bolts, tighten in the bolt number sequence 3, 2, 4, 1, 5). The required tightening torque on clamping bolts is 22-24 ft/lbs. Make sure each knife is torqued to equal clamping pressure. Do not over-tighten.
7. When using knives that are more than 3/4" (20mm) shorter in length than the cutterhead, either use a clamping wedge according to the length of knife (and remove exposed gib screws) or install a filler strip in the open area of knife slot. Never use fewer than two clamping bolts to clamp knives, filler strips and wedges.
8. Install knives successively opposite each other.
9. Maximum profile depth when using Type #538 PowerLock tools is 1 3/8" (35mm), when using 70mm corrugated knife steel. Do not exceed this limit, as the clamping capacity of the tool cannot safely operate outside this limitation.

10. To remove the knife, release the tension from the clamping bolts, and then remove the knife. Protect yourself from injury by wearing gloves when handling cutterheads and knives. Always undo clamping screws away from the knife cutting edge.
11. Use only original Weinig replacement parts in the cutterhead.
12. For safety reasons, the maximum adjustment of re-ground knives must not exceed four corrugations (1/4") from the bottom. There is a line on the cutterhead that indicates the maximum outward adjustment.
13. Never allow the knife steel to extend past the end (or side) of the cutterhead more than the thickness of the knife steel.

Additional Instructions for PowerLock Cutterheads with Closed Ends

NOTE: Since these tool bodies are closed on the non-clamping end for strength and stability, loose knife placement and removal is slightly different.

There are four holes in the non-clamping end of the tool body. These are sight-holes, allowing you to see the bottom of the knife and ensure that the corrugations are in proper alignment in the pocket with all other installed knives. These holes also are used to ensure that the knives are not beyond the maximum adjustment area. If the bottom edge of the knife is not visible through the sight hole, then the knife must either be moved down in the pocket or a new knife is required. These holes also are used for cleaning purposes, directing airflow off the face of the knife and out through the end of the tool body. This helps keep wood dust and resin from accumulating within the knife pockets.

Before removing knives and wedges, it is important to first use compressed air to blow out all accumulated wood dust. It is also good practice to clean thoroughly with Weinig Cutter-Guard (page 44). Afterward, place the tool body in a secure holder such as a setup or measuring stand. Back out all clamping wedge screws until they are past the inside surface of the knife pocket area.Remove the clamping wedge, pulling it straight up and out of the tool. Then remove the knife in the same way. After all knives and wedges are removed, thoroughly clean the knife slots, corrugations and wedges with a non-abrasive brass brush.

In order to mount new knives in this style of closed tool, first place the knife into the pocket and locate it into the proper corrugation. Then install the clamping wedge and follow the same alignment, tightening sequence and clamping-wedge screw tension procedures as previously listed.

For Components Used in Weinig Cutterheads

(Revised December 1, 2013)

All knives must have the same thickness and, if possible, should be cut from the same length of bar stock. These knives must then be balanced in pairs within 0.1 gram (0.0035 oz.). When installed in the cutterhead, these knives must be installed into opposite pockets. However, we recommend that all knives weigh an equal amount for simplicity and speed when rebuilding the tool at a later date.

Knife steel balance procedures should be as follow:

a) After the steel is cut to length, balance to the tolerance listed above. Make sure the edges are square for consistent axial measurement.

b) Complete the rough grind on the knives.

c) Remove the knives from the cutterhead, rebalance to the acceptable tolerance, and then re-install into the cutterhead. Use of an Optical Measuring Stand (OCMS) is recommended for quick and accurate knife alignment.

d) Complete the finish grind on the knives.

e) In 2008, Weinig changed manufacturing procedures on clamping wedges (gibs), in order to achieve a higher degree of total cutterhead balance and accuracy. All gibs are now weighed on a calibrated high-precision scale, and laser-etched with part number and weight. The gibs with this laser etching that are installed in the cutterhead now will weigh within 0.2 gram (visually verify when the tool is disassembled for cleaning), so there should be no requirement for additional balancing efforts. Non-etched gibs need to be checked for balance, and then should remain with this tool. Should a gib be misplaced or damaged, the replacement gib can be ordered from Weinig by stating the part number and weight required. Do not remove any material from an original gib that has the laser-etched weight.

When the tool is dismantled for cleaning, it is good practice to confirm at this time that all gib screws are the same length. For a more precise balance, it is suggested that all screws be of identical weight.

PowerLock cutterheads are no longer being manufactured with the bolts installed in the end of the tool body. This has no effect on the tool balance.

SPECIFIC TO POWERLOCK CUTTERHEADS – OLD STYLE

PowerLock cutterheads produced prior to 2006 were balanced as an assembly, including gibs and tensioning screws. This cutterhead series can be easily identified, as the pockets and gibs are numbered in order to ensure that the gibs always remain in the correct position.

Do not balance these gibs, since they have been balanced as part of the assembly. If a gib is lost or misplaced, then the entire cutterhead assembly must be re-balanced.

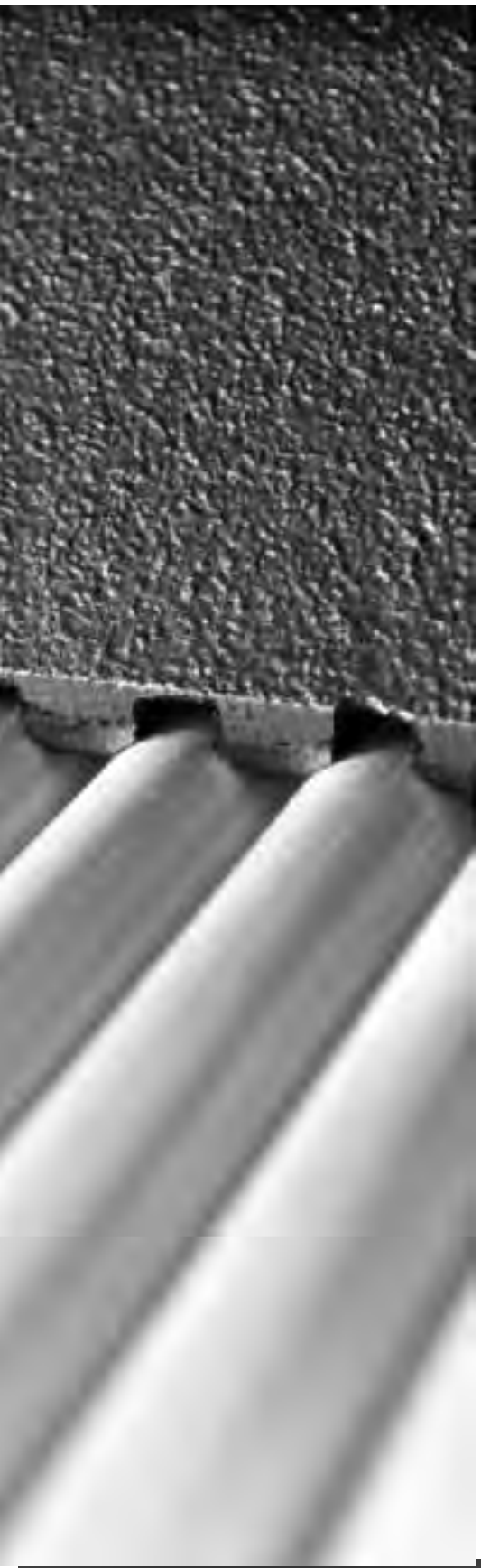
Finish Quality and Feed Rates

RPM	KNIFE MARKS PER INCH	FPM PER NUMBER OF KNIVES FINISH CUTTING					
		1	2	4	6	8	10
6,000	10	50′	100′	200′	300′	400′	500′
	12	41′	83′	166′	250′	333′	416′
	14	35′	71′	142′	214′	285′	357′
	16	31′	62′	125′	187′	254′	312′
	18	27′	55′	111′	166′	222′	277′
	20	25′	50′	100′	150′	200′	250′
8,000	10	66′	133′	266′	400′	533′	666′
	12	55′	111′	222′	333′	444′	555′
	14	47′	95′	190′	285′	300′	476′
	16	41′	83′	166′	250′	333′	416′
	18	37′	74′	148′	222′	296′	370′
	20	33′	66′	133′	200′	266′	333′
10,000	10	83′	167′	333′	500′	-	-
	12	69′	139′	278′	417′	-	-
	14	60′	119′	238′	357′	-	-
	16	52′	104′	208′	313′		
	18	46′	93′	185′	278′		
	20	42′	83′	167′	250′		
12,000	10	100′	-	-	-	-	-
	12	82′	-	-	-	-	-
	14	70′	-	-	-	-	-
	16	62′	-	-	-	-	-
	18	54′	-	-	-	-	-
	20	50′	-	-	-	-	-

For unjointed tools, use the column for "1" knife finish cutting.
For jointed tools, use the appropriate column.

Prices Subject to Change

Other Finish Faults



Following is a convenient checklist of some correctable finish faults. Note, however, that other possible problems also may exist.

Out-of-Balance Mark

An out-of-balance mark is a consistent mark on the finished product that does not equal the number of marks per inch as calculated by the Knife Marks Per Inch formula. Causes for out-of-balance marks:

Tool (cutterhead)-related:

- Knives or gibs in opposite wings are not balanced
- Gib screws in opposite wings are not balanced
- Inside bore of tool is worn
- Tool has burrs on locating sides
- The empty tool itself is not in balance

Moulder-related

- Spindle diameter is worn, or spindle is bent
- Spindle bearings are worn (worn bearings may produce an inconsistent mark)
- Casting that the spindle barrel mounts into is worn
- Spindle slides are loose
- Spindle spacers are burred
- Wood chips between tool and spindle face or spacers
- Belt pulley is loose

Chatter

Chatter, an inconsistently patterned mark on the finished product, is caused by the product moving during the cut. The product must be held in a way that does not permit it to move (except in the direction of feed). Example: A counter-profile pressure shoe may be used to hold an uneven profile being produced by the top cutter.

Causes for chatter marks:

- Pressure shoe not aligned parallel to the bed
- Slides in pressure shoe are too tight or too loose
- Worn bed plates or fences
- Straight knives not ground parallel
- Undersized material

Bench Repair Request Form

WEINIG HOLZHER

DATE: _____

BILL TO: _____

_____

_____

_____

☐ Shipping same as Billing

SHIP TO: _____

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SHIPPING INFORMATION

ATTN: BENCH REPAIR

WEINIG HOLZ-HER USA 124
CROSSLAKE PARK DRIVE
MOORESVILLE, NC 28117

(704) 799-1000 EXT. 7861

BENCH REPAIR SHOP
PHONE: (704) 658-2218

CONTACT: _____

PHONE: _____

EMAIL: _____

MACHINE TYPE:

SERIAL NUMBER:

PO#:

ITEMS FOR REPAIR:

_____

_____

_____

_____

_____

NOTE: For Cutterheads, please REMOVE Tooling and Gibs!

Do you need an emailed quote of the repair estimate? ☐ YES ☐ NO

How would you like this shipped back to you?

☐ UPS GROUND ☐ UPS NEXT DAY ☐ UPS 2DAY ☐ OTHER _____

A BENCH REPAIR REQUEST FORM MUST ACCOMPANY ANY ITEM SENT IN FOR REPAIR

Please insure high value items being shipped.

Tooling Order Form

Fax: 1-704-799-7400
Email: weinig.partsales@weinig.com

Please photocopy before completing

COMPANY _____

ADDRESS _____

_____

CITY _____ **STATE** _____ **ZIP** _____

PHONE (_____) _____ **FAX** (_____) _____

EMAIL _____

SHIPPING INFORMATION (if different) _____

CITY _____ **STATE** _____ **ZIP** _____

PHONE (_____) _____ **FAX** (_____) _____

CUSTOMER PURCHASE ORDER _____

SHIP VIA _____ **URGENT?** ☐ **YES** ☐ **NO**

ORDER APPROVED BY _____

SPECIAL NOTES _____

QUANTITY	ITEM NUMBER	COMMENTS or DESCRIPTION (if necessary)

You can order by fax at 1-704-799-7400 or order online at www.weinig.com and use our convenient shopping cart.

Weinig Grinding Services Order Form

WEINIG

GRINDING SERVICES

Contact Person: _____

Company Name: _____

Telephone Number: _____

Email Address / Fax Number: _____

Please Select Services & Material Required:

Profile Drawing Number(s): _____

_____

Templates Only: _____	SRS: _____	DLC: _____
Rough Knife Only: _____	M2: _____	Double: _____
Template and Rough Knife: _____	M3+: _____	Back: _____
Template and Finish Knife: _____	Supre18: _____	TCT: _____
Straight Knife Only: _____	W&H: _____	
Regrind / Resharpening Only: _____		

Desired Lineal Footage (Optional)

_____

Number of Knives per Head:	2 _____	3 _____	4 _____
	6 _____	8 _____	Other: _____

For Finished Grind Orders Please Indicate the Following:

Please Note: If tooling information is not provided, Weinig will use the information in your account history

Tool Diameter:	90 _____	122 _____	150 _____
	115 _____	137 _____	Other: _____
Hook Angle:	12° _____		Jointed: _____
	20° _____		Non-Jointed: _____

Weinig Machine: Yes _____ No _____

Weinig Machine Model: _____

Customer Signature: _____ or check box for approval ☐

Date: _____

All information listed above must be completed, signed and returned prior to any order being processed.

For further information, please contact our Grinding Service Department at 1.877.548.0929 or by email at grinding@weinig.com

WEINIG QUALITY | Machines and Systems for Solid Wood Processing

WEINIG is synonymous with technological advancement—and has been for more than 100 years. WEINIG quality allows our partners in both handcrafts and industry around the world to stand out above the competition. We deliver machines and systems that set standards in performance and economy; intelligent production concepts for optimal value creation; and customized solutions for every operation from application through parts and service.

WEINIG offers more

WEINIG HOLZHER MRO Mirror Reflections Custom Moulding Knives