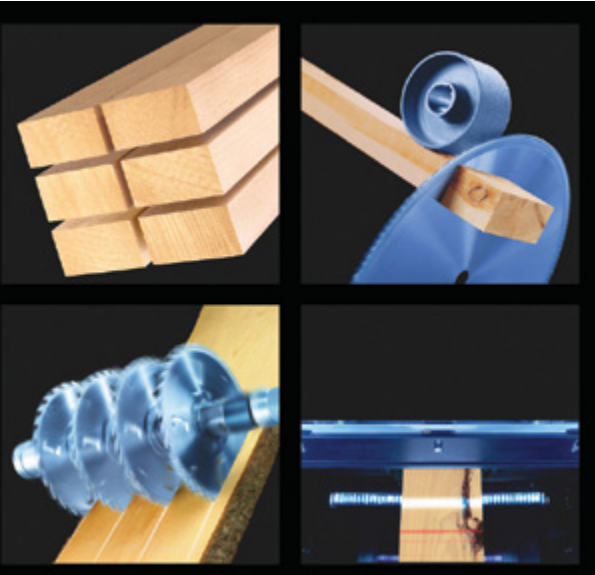
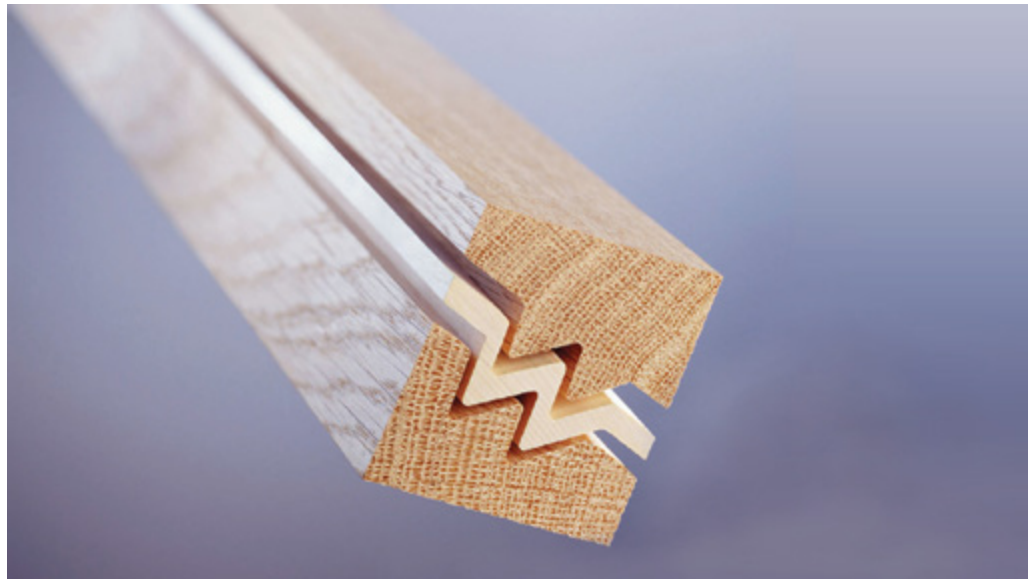
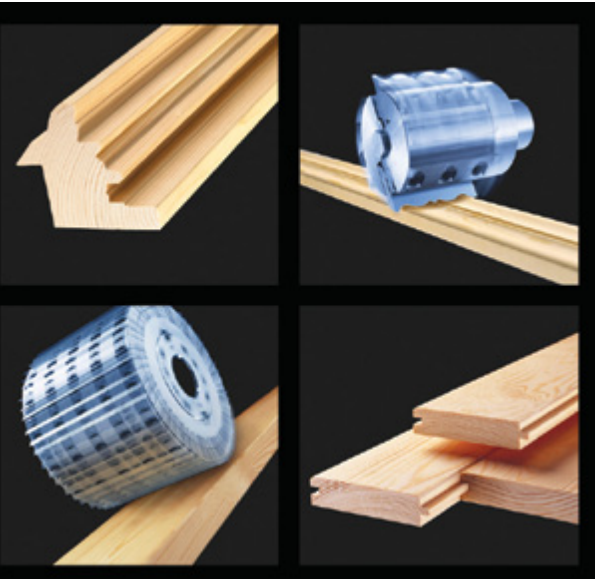


# TOOLING & SUPPLIES CATALOG

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



22nd Edition | US 2219



## 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, rip saw 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.

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PowerLock is Weinig's moulder tooling with Hollow Taper Shank (HSK) locking. Used initially in the metalworking industry, this quick changeover technology gains its accuracy from positive clamping on three main surfaces: taper, clamping area, and flange face.

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 cutting conditions ranging from heavy-duty to high-speed machining, and offers the lowest weight for the most tool-holder.

PowerLock is currently used for conventional moulding production. It is available in most styles of tooling and is available from Weinig stock, including:

- Corrugated cutters (pages 4-5)
- Insert planerheads (pages 6-7, 9)
- Custom profile insert cuttersets (page 8)
- For Powermat moulders with reduced spindle rpm (maximum 8,000 rpm) you also can use your existing conventional tooling on PowerLock spindle adapters (page 9).
- For applications that require specialized tooling, we will work with you to supply your needs.

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

### CONVENIENT WAYS TO ORDER:

Phone: 1.877.548.0929

Email: [partsales@weinig.com](mailto:partsales@weinig.com)

Fax: 1.704.799.7400

Online: [www.weinigusa.com](http://www.weinigusa.com) (Save 2%)

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

# PowerLock Cutterhead Type 538

# PowerLock Cutterhead Type 538

## Be Part of the New Evolution of PowerLock Tools!

Beginning mid-2019, all PowerLock tools have been enhanced to provide increased stability and strength. The new closed-end style is similar to Powerlock tools with 4-wing construction. Also, new style clamping wedges will provide a more positive clamping of the knife steel.



### TOOL DIAMETER 90MM

ARTICLE NUMBER	WIDTH		NO. OF KNIFE SLOTS	CUTTING ANGLE	SPINDLE USE	PRICE
	MM	INCHES				
538-098-31	40	1 9/16	2	20°	L/B	\$339
538-090-21	60	2 23/64	2	20°	L/B	\$366
538-090-22	80	3 9/64	2	20°	L/B	\$395
538-090-23	100	3 15/16	2	20°	L/B	\$443
538-090-24	130	5 1/8	2	20°	L/B	\$504
538-090-26	170	6 11/16	2	20°	L/B	\$586
538-090-27	240	9 29/64	2	20°	Bottom	\$713
538-098-34	310	12 13/64	2	20°	Bottom	\$1,053
538-098-32	40	1 9/16	2	20°	R/T	\$339
538-090-31	60	2 23/64	2	20°	R/T	\$366
538-090-32	80	3 9/64	2	20°	R/T	\$395
538-090-33	100	3 15/16	2	20°	R/T	\$443
538-090-34	130	5 1/8	2	20°	R/T	\$504
538-090-36	170	6 11/16	2	20°	R/T	\$586
538-090-37	240	9 29/64	2	20°	Top	\$713
538-098-35	310	12 13/64	2	20°	Top	\$1,053
538-098-73	40	1 9/16	2	12°	L/B	\$339
538-090-41	60	2 23/64	2	12°	L/B	\$366
538-090-42	80	3 9/64	2	12°	L/B	\$395
538-090-43	100	3 15/16	2	12°	L/B	\$443
538-090-44	130	5 1/8	2	12°	L/B	\$504
538-090-46	170	6 11/16	2	12°	L/B	\$586
538-090-47	240	9 29/64	2	12°	Bottom	\$713
538-098-13	310	12 13/64	2	12°	Bottom	\$1,053
538-098-74	40	1 9/16	2	12°	R/T	\$339
538-090-51	60	2 23/64	2	12°	R/T	\$366
538-090-52	80	3 9/64	2	12°	R/T	\$395
538-090-53	100	3 15/16	2	12°	R/T	\$443
538-090-54	130	5 1/8	2	12°	R/T	\$504
538-090-56	170	6 11/16	2	12°	R/T	\$586
538-090-57	240	9 29/64	2	12°	Top	\$713
538-098-18	310	12 13/64	2	12°	Top	\$1,053

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

### 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	\$544
538-096-23	100	3 15/16	4	20°	L/B	\$645
538-096-24	130	5 1/8	4	20°	L/B	\$760
538-096-26	170	6 11/16	4	20°	L/B	\$835
538-096-27	240	9 29/64	4	20°	Bottom	\$1,116
538-096-31	60	2 23/64	4	20°	R/T	\$544
538-096-33	100	3 15/16	4	20°	R/T	\$645
538-096-34	130	5 1/8	4	20°	R/T	\$760
538-096-36	170	6 11/16	4	20°	R/T	\$835
538-096-37	240	9 29/64	4	20°	Top	\$1,116
538-096-61	60	2 23/64	4	12°	L/B	\$544
538-096-63	100	3 15/16	4	12°	L/B	\$645
538-096-66	170	6 11/16	4	12°	L/B	\$835
538-096-67	240	9 29/64	4	12°	Bottom	\$1,116
538-096-71	60	2 23/64	4	12°	R/T	\$544
538-096-73	100	3 15/16	4	12°	R/T	\$645
538-096-76	170	6 11/16	4	12°	R/T	\$835
538-096-77	240	9 29/64	4	12°	Top	\$1,116

- Cutting angle 20° for both softwoods and hardwoods, or 12° for selected hardwoods that present tear-out problems on lower-RPM moulders
- High-tensile steel body
- Designed for use with 1/4", 5/16" or 3/8" thick knives with 16-60° corrugated back (different gibs required for 3/8" thick knives)
- Rated for operation up to 12,000 rpm
- Designed for Weinig's Axial-constant Setup System
- 6-knife cutterheads also available

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





# PowerLock Spiral Planerheads

## Shear Design For Better Finish



### TOOL DIAMETER 110MM

ARTICLE NUMBER	WIDTH		SPINDLE USE	PRICE
	MM	INCHES		
XXX64023	120	4 23/32	L/B	\$1,070
XXX64026	170	6 11/16	L/B	\$1,260
XXX64027	240	9 29/64	Bottom	\$1,550
XXX640281	270	10 5/8	Bottom	\$1,990
XXX640282	330	13	Bottom	\$2,930
XXX64033	120	4 23/32	R/T	\$1,070
XXX64036	170	6 11/16	R/T	\$1,260
XXX64037	240	9 29/64	Top	\$1,550
XXX640381	270	10 5/8	Top	\$1,990
XXX640382	330	13	Top	\$2,930

**SIZES SHOWN ARE AVAILABLE FROM STOCK.**

**Each cutterhead includes a full set of installed inserts.**

#### Replacement Carbide Insert Knives

XXX637100	15 x 15 x 2.5mm	\$3.05
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#### Replacement Screws for Insert Knives

XXX637105		\$2.50
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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 shank. For exclusive use on all 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.

# PowerLock Helicarb Planerheads

## Now Available With More Regrind Area

A joint effort between Weinig and Great Lakes Custom Tool has produced a Helical Planerhead with a non-segmented knife! Among the distinct advantages of this tool are:

- Eliminates tearout in hardwoods and knotty material
- One continuous, uninterrupted cutting edge
- Inserts can be resharpened on a Weinig R960 grinder
- True running accuracy within 0.0005"
- Can be jointed to attain a multi-knife finish

ARTICLE NUMBER	WIDTH		SPINDLE USE	PRICE
	MM	INCHES		
XXX640631	75	2 61/64	Left	\$1,400
XXX64063	75	2 61/64	Bottom	\$1,400
XXX640651	115	4 17/32	Left	\$1,625
XXX64065	115	4 17/32	Bottom	\$1,625
XXX64067	170	6 11/16	L/B	\$2,160
XXX64069	235	9 1/4	Bottom	\$3,060
XXX64070	310	12 13/64	Bottom	\$3,805
XXX64073	75	2 61/64	R/T	\$1,400
XXX64075	115	4 17/32	R/T	\$1,625
XXX64077	170	6 11/16	R/T	\$2,160
XXX64079	235	9 1/4	Top	\$3,060
XXX64080	310	12 13/64	Top	\$3,805

**Each cutterhead includes a full set of installed carbide inserts.**  
All cutterheads 100mm OD.

#### Replacement Knives – Standard 10° Grind

(Purchase and install in sets of 2)

ARTICLE NUMBER	DIMENSIONS	SPINDLE USE	PRICE
	MM		
XXX643075R	75	L/R/T	\$99
XXX643075L	75	Bottom	\$99
XXX643115R	115	L/R/T	\$151
XXX643115L	115	Bottom	\$151
XXX643170L	170	L/B	\$222
XXX643170R	170	R/T	\$222
XXX643235L	235	Bottom	\$304
XXX643235R	235	Top	\$304

#### Shim required for additional regrind area

XXX642SHIM (Pack of 10)	\$10
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#### Special knife rest for grinding helical planerheads

For use on most Weinig Rondamat Grinders: **930-013024HEL2** \$61  
Replaceable carbide for use with standard knife rest 930-013024, as shown on page 39.



NOTE: You can download instructions for insert tooling knife replacement and grinding from our website at [www.weinigusa.com](http://www.weinigusa.com).

Optional 5° and 15° replacement knives available for use with softwoods or extremely dense hardwoods.



- Similar in design to our standard profile tooling system shown on page 18, but with an integrated HSK shank 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.
- Maximum profile depth: 25mm (0.984)
- Maximum profile width 35mm (1.378). Larger sizes available upon request
- Cutting circle: 150mm maximum; 100mm minimum

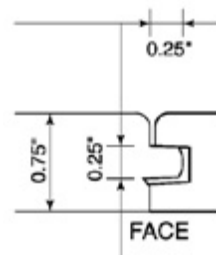
**Custom Carbide Insert Profile Knives and Backers**  
—Approximate one-week delivery

This insert tooling system from Weinig is the answer for woodworking businesses that require an economic tooling solution for the production of small precision profiles. This system offers the following advantages:

- Eliminates the requirement for a dedicated tool body. Multiple profiles using inserts can now be accomplished with the same tool body.
- New design provides a positive locking and locating system for insert knives at a more economical price.

### Profile Insert Tool Body

ARTICLE NUMBER	KNIVES PER TOOL BODY	SPINDLE USE	PRICE
XXX68435	2	L/B	\$747
XXX68535	2	R/T	\$747
XXX68635	3	L/B	\$979
XXX68735	3	R/T	\$979



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

XXX662160	Straight knife backer only	\$46
XXX662150	Tongue profile backer only	\$46
XXX662150MB	Tongue microbevel backer only	\$46
XXX662173	Tongue centermatch backer only	\$46
XXX662183	Tongue V-panel backer only	\$46
XXX662179	Tongue 1/2" profile backer only	\$46
XXX662155	Groove profile backer only	\$46
XXX662155MB	Groove microbevel backer only	\$46
XXX662171	Groove centermatch backer only	\$46
XXX662181	Groove V-panel backer only	\$46
XXX662177	Groove 1/2" profile backer only	\$46
XXX662131	Straight knife insert knife	\$27
XXX662100	Tongue profile insert knife	\$36
XXX662100MB	Tongue microbevel profile insert knife	\$36
XXX662172	Tongue centermatch profile insert knife	\$36
XXX662182	Tongue V-panel profile insert knife	\$36
XXX662178	Tongue 1/2" profile insert knife	\$36
XXX662105	Groove profile insert knife w/0.030" gap	\$36
XXX662115	Groove profile insert knife w/0.010" gap	\$36
XXX662120	Groove profile insert knife w/0.005" gap	\$36
XXX662115MB	Groove microbevel profile insert knife	\$36
XXX662170	Groove centermatch profile insert knife	\$36
XXX662180	Groove V-panel profile insert knife	\$36
XXX662176	Groove 1/2" profile insert knife	\$36

## Shear Planerheads with Replaceable Inserts

**An economical solution for wood species that present tearout issues!**

- 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



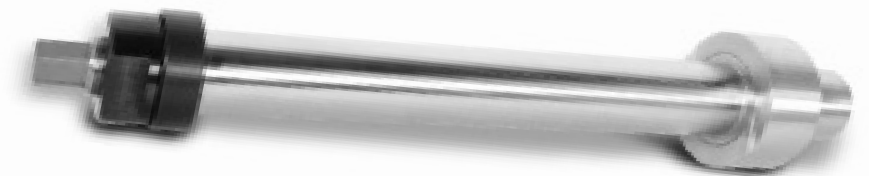
ARTICLE NUMBER	DESCRIPTION	SPINDLE USE	PRICE
XXX64083	Powerlock 125 x 50, Z4	L/B	\$1,045
XXX64093	Powerlock 125 x 50, Z4	R/T	\$1,045
XXX635050	Replaceable Inserts		\$4.25
XXX635500	Replacement Gibs		\$37.50

## 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)	\$825
323-9169486	1 1/2" x 100mm	\$775
323-037027	1 1/2" x 170mm	\$850
323-027008	1 1/2" x 240mm	\$900
323-9143776	40mm x 100mm	\$775
323-03752	40mm x 170mm	\$850
323-02752	40mm x 240mm	\$900
323-9120151	1 13/16" x 100mm	\$775
323-9114936	1 13/16" x 170mm	\$850
323-027003	1 13/16" x 240mm	\$900



**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** \$1,315



**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** \$895



**PowerLock Receiver Taper Cleaning Device**  
\* New Improved Version!

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

**006-03226** \$58



**PowerLock HSK Tool Taper Cleaning Device**

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

**006-03229** \$72



**PowerLock Knife Setting Gauge**

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

**507-330001 For 90mm OD tools** \$57  
**507-330004 For 115mm OD tools** \$95



**PowerLock Tool Carrier**

Improve efficiency and safety during installation and removal of PowerLock tools on your moulder. (Only tools with outside bolt holes can use this carrier set).

**507-35007US Handle Cpl (2-pc unit)** \$175  
**507-35008US Tool Body Bolts**  
**Remains in cutterhead at all times**  
(Use of Loctite recommended) \$25



**PowerLock Tool Blank**

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

**323-027007** \$350



**Gib Screw Torque Wrench**

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

**XXX100428K** \$305



**Gib Screw Allen Wrench M6**

Curved with handle for manual tightening of cutterhead gib screws.

**006-00210** \$10



# Hydro-Cutterhead Type 504

# Conventional Cutterhead Type 503

## 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")
- Body of high-tensile steel
- 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
- Designed for Weinig's Axial Constant Setup System
- Two-piece clamping sleeve ensures tolerance-free center clamping on spindles with or without keyways
- Maximum 6,000 rpm
- 8-24 knife cutterheads also available

### 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"	\$632
504-150-02	100	3 15/16	4	20°	1 13/16"	\$839
504-150-08	150	5 29/32	4	20°	1 13/16"	\$972
504-150-11	230	9 1/16	4	20°	1 13/16"	\$1,200
504-150-84	60	2 23/64	4	20°	2 1/8"	\$632
504-150-03	100	3 15/16	4	20°	2 1/8"	\$839
504-150-09	150	5 29/32	4	20°	2 1/8"	\$972
504-150-12	230	9 1/16	4	20°	2 1/8"	\$1,200
514-150-21	60	2 23/64	4	12°	1 13/16"	\$632
504-150-38	100	3 15/16	4	12°	1 13/16"	\$839
504-150-44	150	5 29/32	4	12°	1 13/16"	\$972
504-150-47	230	9 1/16	4	12°	1 13/16"	\$1,200
514-150-39	60	2 23/64	4	12°	2 1/8"	\$632
504-150-39	100	3 15/16	4	12°	2 1/8"	\$839
504-150-45	150	5 29/32	4	12°	2 1/8"	\$972
504-150-48	230	9 1/16	4	12°	2 1/8"	\$1,200
504-150-86	60	2 23/64	6	20°	1 13/16"	\$758
504-150-20	100	3 15/16	6	20°	1 13/16"	\$946
504-150-26	150	5 29/32	6	20°	1 13/16"	\$1,031
504-150-29	230	9 1/16	6	20°	1 13/16"	\$1,418
504-150-87	60	2 23/64	6	20°	2 1/8"	\$758
504-150-21	100	3 15/16	6	20°	2 1/8"	\$946
504-150-27	150	5 29/32	6	20°	2 1/8"	\$1,031
504-150-30	230	9 1/16	6	20°	2 1/8"	\$1,418
514-150-22	60	2 23/64	6	12°	1 13/16"	\$758
504-150-56	100	3 15/16	6	12°	1 13/16"	\$946
504-150-62	150	5 29/32	6	12°	1 13/16"	\$1,031
504-150-65	230	9 1/16	6	12°	1 13/16"	\$1,418
514-150-30	60	2 23/64	6	12°	2 1/8"	\$758
504-150-57	100	3 15/16	6	12°	2 1/8"	\$946
504-150-63	150	5 29/32	6	12°	2 1/8"	\$1,031
504-150-66	230	9 1/16	6	12°	2 1/8"	\$1,418

### SIZES SHOWN ARE AVAILABLE FROM STOCK.

Other dimensions available upon request.

See Weinig Cutterhead Quality Assurance Guarantee on page 21.

## 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"	\$276
503-122-54	100	3 15/16	2	20°	1 1/2"	\$316
503-122-57	130	5 1/8	2	20°	1 1/2"	\$378
513-123-20	170	6 11/16	2	20°	1 1/2"	\$422
503-122-66	230	9 1/16	2	20°	1 1/2"	\$460
513-123-03	240	9 29/64	2	20°	1 1/2"	\$515
513-122-92	60	2 23/64	2	12°	1 1/2"	\$276
513-122-93	100	3 15/16	2	12°	1 1/2"	\$316
513-122-94	130	5 1/8	2	12°	1 1/2"	\$378
513-123-21	170	6 11/16	2	12°	1 1/2"	\$422
513-122-97	230	9 1/16	2	12°	1 1/2"	\$460
513-122-98	240	9 29/64	2	12°	1 1/2"	\$515
503-137-02	60	2 23/64	4	20°	1 13/16"	\$388
503-137-05	100	3 15/16	4	20°	1 13/16"	\$443
503-137-08	130	5 1/8	4	20°	1 13/16"	\$499
513-137-39	170	6 11/16	4	20°	1 13/16"	\$543
503-137-17	230	9 1/16	4	20°	1 13/16"	\$690
503-137-86	240	9 29/64	4	20°	1 13/16"	\$736
503-137-44	60	2 23/64	4	12°	1 13/16"	\$388
503-137-47	100	3 15/16	4	12°	1 13/16"	\$443
503-137-50	130	5 1/8	4	12°	1 13/16"	\$499
513-137-74	170	6 11/16	4	12°	1 13/16"	\$543
503-137-59	230	9 1/16	4	12°	1 13/16"	\$690
513-137-51	240	9 29/64	4	12°	1 13/16"	\$736



- Standard cutting angle 20°, or 12° for selected hardwoods that present tear-out problems
- High-tensile steel body
- Maximum tolerance of concentricity (true running accuracy) 0.05mm (0.00197")
- Designed for use with 1/4", 5/16" or 3/8" thick knives with 16-60° corrugated back
- Designed for Weinig's Axial-constant Setup System
- Maximum 8,000 rpm

### SIZES SHOWN ARE AVAILABLE FROM STOCK.

Other dimensions available upon request.

See Weinig Cutterhead Quality Assurance Guarantee on page 21.

## For Non-jointed Applications of 80 FPM or Less



### New Design for Better Finish Quality

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.

- 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

ARTICLE NUMBER	WIDTH		OUTSIDE DIAMETER MM	BORE DIAMETER	PRICE
	MM	INCHES			
XXX630012*	75	2 21/64	110	1 1/2"	\$510
XXX630013	100	3 15/16	125	1 1/2"	\$515
XXX630019	170	6 11/16	125	1 1/2"	\$705
XXX630005	230	9 1/16	125	1 1/2"	\$955
XXX630010	240	9 29/64	125	1 1/2"	\$1,020
XXX630015	270	10 5/8	125	1 1/2"	\$1,580
XXX630205	100	3 15/16	140	1 13/16"	\$615
XXX630214	170	6 11/16	140	1 13/16"	\$815
XXX630220	230	9 1/16	140	1 13/16"	\$1,045
XXX630225	240	9 29/64	140	1 13/16"	\$1,050
XXX630230	270	10 5/8	140	1 13/16"	\$1,605

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

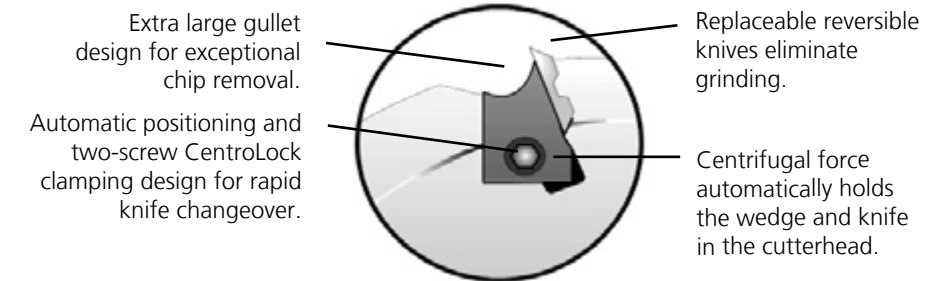
### Replacement Parts

XXX637100	Carbide Insert Knives	15 x 15 x 2.5mm	\$3.05
XXX637105	Screws for Insert Knives		\$2.50

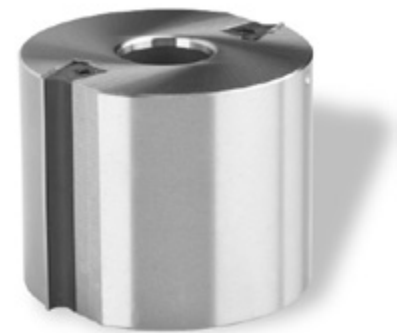
### Rebate Cutter Turnblades

006-00379	Turnblade Knife	17 x 17 x 2mm	\$5.00
006-00170	Turnblade spur	14 x 14 x 2mm	\$1.60

## Featuring Full-length Reversible Insert Knives



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
	MM	INCHES				
530-125-33	60	2 23/64	125	2	1 1/2"	\$490
530-125-39	100	3 15/16	125	2	1 1/2"	\$675
530-125-54	230	9 1/16	125	2	1 1/2"	\$910
530-125-67	240	9 29/64	125	2	1 1/2"	\$925

### 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"	\$986

### Replacement Reversible Knives for CentroLock 530 Cutterheads

HSS Knives				Carbide Knives			
ARTICLE NUMBER	WIDTH		PRICE	ARTICLE NUMBER	WIDTH		PRICE
	MM	INCHES			MM	INCHES	
507-920060	60	2 23/64	\$4.00	507-921060	60	2 23/64	\$19.55
507-920100	100	3 15/16	\$6.60	507-921100	100	3 15/16	\$30.70
507-920130	130	5 1/8	\$7.00	507-921130	130	5 1/8	\$38.50
507-920150	150	5 29/32	\$8.10	507-921150	150	5 29/32	\$43.50
507-920170	170	6 11/16	\$9.15	507-921170	170	6 11/16	\$49.60
507-920190	190	7 31/64	\$9.55	507-921190	190	7 31/64	\$54.70
507-920230	230	9 1/16	\$12.40	507-921230	230	9 1/16	\$65.80
507-920240	240	9 29/64	\$12.90	507-921240	240	9 29/64	\$68.80
507-920270	270	10 5/8	\$14.55	507-921270	270	10 5/8	\$76.90
507-920310	310	12 13/64	\$15.60	507-921310	310	12 13/64	\$86.10

Each cutterhead comes equipped with a set of HSS knives.

Other dimensions available upon request.

PRICED PER INDIVIDUAL KNIFE.

Designed for exclusive use with Type 530 cutterheads.

CONFIRM APPROPRIATE TOOL DIAMETER WHEN USING WITH REBATE CUTTER.

Each planerhead includes a full set of installed inserts.





## For Moulders Using Conventional Tooling



### Now Available With More Regrind Area

## Helicarb Planerheads

A joint effort between Weinig and Great Lakes Custom Tool has produced a Helical Planerhead with a nonsegmented knife! Among the distinct advantages of this tool are:

- Eliminates tearout in hardwoods and knotty material
- One continuous, uninterrupted cutting edge
- Inserts can be resharpened on a Weinig R960 grinder
- True running accuracy within 0.0005"
- Hydro-cutterheads can be jointed to attain a multi-knife finish

**Call for current pricing, or visit our online shopping cart.**

### Straight-bore planerheads available in the following sizes

MM	WIDTH		NUMBER OF KNIFE SLOTS
	INCHES		
75	2 21/64		2 or 3
115	4 17/32		2 or 3
170	6 11/16		2 or 3
235	9 1/4		2 or 3

All straight-bore cutterheads 135mm OD.  
All hydro-cutterheads 160mm OD.

Each cutterhead includes full set of installed carbide inserts.

Spindle usage (RH or LH) required when ordering.  
Maximum 9,000 rpm

Special small diameter tool for use on left spindle to extend width capacity. Uses same replacement knives as currently used in PowerLock tools (page 7).

**XXX62380752LSD** 100 x 75 x 1 1/2", Z2 \$820

### Hydro planerheads available in the following sizes

MM	WIDTH		NUMBER OF KNIFE SLOTS
	INCHES		
75	2 21/64		3, 4, 6
115	4 17/32		3, 4, 6
170	6 11/16		3, 4, 6
235	9 1/4		3, 4, 6
310	12 13/64		3

### Special knife rest for grinding helical planerheads

For use on most Weinig Rondamat Grinders

**930-013024HEL2** \$61

Replaceable carbide for use with standard knife rest 930-013024, as shown on page 39.

NOTE: Download instructions for insert tooling knife replacement and grinding are available on our website at [www.weinigusa.com](http://www.weinigusa.com).

### Replacement Knives for 135mm OD Heads Standard 10° Grind

ARTICLE NUMBER	DIMENSIONS	SPINDLE USE	PRICE
	MM		
XXX624075L	75	L/B	\$99
XXX624075R	75	R/T	\$99
XXX624115L	115	L/B	\$151
XXX624115R	115	R/T	\$151
XXX624170L	170	L/B	\$222
XXX624170R	170	R/T	\$222
XXX624235L	235	Bottom	\$304
XXX624235R	235	Top	\$304

### Replacement Knives for 160mm OD Heads Standard 10° Grind

ARTICLE NUMBER	DIMENSIONS	SPINDLE USE	PRICE
	MM		
XXX625075L	75	L/B	\$99
XXX625075R	75	R/T	\$99
XXX625115L	115	L/B	\$151
XXX625115R	115	R/T	\$151
XXX625170L	170	L/B	\$222
XXX625170R	170	R/T	\$222
XXX625235L	235	Bottom	\$304
XXX625235R	235	Top	\$304

### Shim required for additional regrind area

**XXX642SHIM** (Pack of 10) \$10

Optional 5° and 15° replacement knives available for use with softwoods or extremely dense hardwoods

## Optional 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

### 2" wide tool for use on vertical spindles

<b>XXX635268</b>	125 x 50 x 1 1/2", Z4	\$548
<b>XXX635270</b>	125 x 50 x 1 13/16", Z4	\$548
<b>XXX635050</b>	Replaceable Inserts	\$4.25
<b>XXX635500</b>	Replacement Gibs	\$37.50



# Custom Profile Insert Tooling System

## Featuring In-stock Axial-constant Tongue-and-Groove Inserts

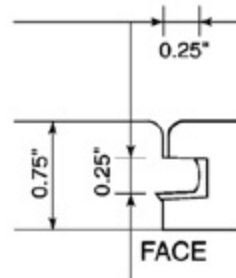
This insert tooling system from Weinig is the answer for woodworking businesses that require an economic tooling solution for the production of small precision profiles. This new system offers the following advantages:

- Eliminates the requirement for a dedicated tool body. Multiple profiles using inserts can now be accomplished with the same tool body.
- New design provides better economy than previous versions, but with the same performance quality.



### Profile Insert Tool Body

ARTICLE NUMBER	KNIVES PER TOOL BODY	BORE DIAMETER	PRICE
XXX662312	2	1 1/2"	\$413
XXX662314	2	40mm	\$413
XXX662311	3	1 1/4"	\$495
XXX662315	3	1 1/2"	\$495
XXX662319	3	40mm	\$495
XXX662316	3	1 13/16"	\$495



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

XXX662160	Straight knife backer only	\$46
XXX662150	Tongue profile backer only	\$46
XXX662150MB	Tongue microbevel backer only	\$46
XXX662173	Tongue centermatch backer only	\$46
XXX662183	Tongue V-panel backer only	\$46
XXX662179	Tongue 1/2" profile backer only	\$46
XXX662155	Groove profile backer only	\$46
XXX662155MB	Groove microbevel backer only	\$46
XXX662171	Groove centermatch backer only	\$46
XXX662181	Groove V-panel backer only	\$46
XXX662177	Groove 1/2" profile backer only	\$46
XXX662131	Straight knife insert knife	\$27
XXX662100	Tongue profile insert knife	\$36
XXX662100MB	Tongue microbevel profile insert knife	\$36
XXX662172	Tongue centermatch profile insert knife	\$36
XXX662182	Tongue V-panel profile insert knife	\$36
XXX662178	Tongue 1/2" profile insert knife	\$36
XXX662105	Groove profile insert knife w/0.030" gap	\$36
XXX662115	Groove profile insert knife w/0.010" gap	\$36
XXX662120	Groove profile insert knife w/0.005" gap	\$36
XXX662115MB	Groove microbevel profile insert knife	\$36
XXX662170	Groove centermatch profile insert knife	\$36
XXX662180	Groove V-panel profile insert knife	\$36
XXX662176	Groove 1/2" profile insert knife	\$36

**Custom Carbide Insert Profile Knives and Backers – Approximate one-week delivery**

### Additional Specifications:

- Carbide inserts
- Use on both 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.
- Maximum profile depth: 25mm (0.984)
- Maximum profile width: 35mm (1.378)
- Cutting circle: 175mm maximum; 125mm minimum
- Maximum speed of 8,000 rpm

# Custom Profile Insert Tooling System

## For Use on Wider Material

Similar to the tooling system shown on previous page, but available in optional 60mm (2 23/64"), 105mm (4 1/8") or 150mm (5 29/32") working width.

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

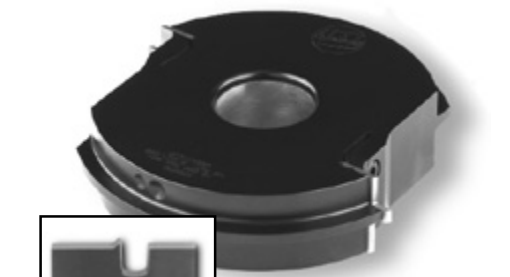


## Tongue-and-Groove Cutter Insert (Old Style)

NOTE: The standard old-style insert knives still available from stock are for the 3/4" pattern as shown on page 18. Depending on moisture content and board length, you have the option of standard, slightly looser or slightly tighter fit.

### Replacement Carbide Insert Profile Knives For Old Style #650038 and #650113, as shown (2<sup>nd</sup> photo)

XXX6581001	Tongue profile	\$30
XXX6581001MB	Tongue microbevel profile	\$30
XXX6581051	Special groove profile with 0.030" gap	\$33
XXX6581151	Special groove profile with 0.010" gap	\$33
XXX6581151MB	Special groove microbevel profile with 0.010" gap	\$33



### Replacement Carbide Insert Profile Knives For Old Style #650015 and #650046, as shown (3<sup>rd</sup> photo)

XXX658100	Tongue profile	\$46
XXX658105	Special groove profile with 0.030" gap	\$41
XXX658115	Special groove profile with 0.010" gap	\$41
XXX658120	Special groove profile with 0.005" gap	\$41



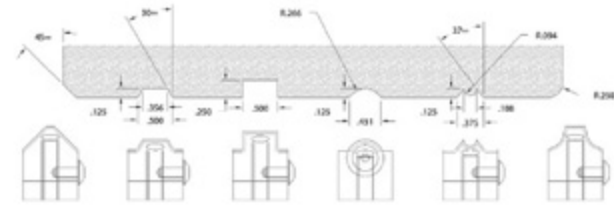
## Cutterhead T-Bushings

For use when moulder tooling is to be used on a shaper. Each item listed contains a set of 2 pieces.

XXX6623100	Bush 1 1/2" bore to 1"	\$66
XXX6623125	Bush 1 1/2" bore to 1 1/4"	\$66
XXX662346125	Bush 1 13/16" bore to 1 1/4"	\$102
XXX662346150	Bush 1 13/16" bore to 1 1/2"	\$102



## New Design, and New Low Prices!



A grinder is no longer required to produce "S45" material for multiple applications. The CombiHead provides versatility and cost effectiveness with reversible

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"

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.

Custom inserts and gibs for 2" wide x 1/4" deep profiles also available.

ARTICLE NUMBER	OVER ALL WIDTH	USEABLE PROFILE WIDTH (APPROX.)	OUTSIDE DIAMETER	NUMBER OF POCKETS	BORE DIAMETER	PRICE	
XXX672255	230	9 1/16	200 7 7/8	125	2/2	1 1/2"	\$1,425
XXX672405	230	9 1/16	200 7 7/8	140	2/2	1 13/16"	\$1,475
507920100	HSS planer knives 100mm					\$6.60	
507921100	Carbide planer knives 100mm					\$30.70	
507920230	HSS planer knives 230mm					\$12.40	
507921230	Carbide planer knives 230mm					\$65.80	
XXX674014	Carbide 1/4" radius insert					\$44	
XXX674018	Carbide 1/8" radius insert					\$44	
XXX674025	Carbide bead insert					\$44	
XXX674045	Carbide 45° bevel insert					\$44	
XXX674128	Carbide flooring standard relief cut insert					\$44	
XXX674129	Carbide flooring round relief cut insert					\$44	
XXX674124	Carbide 1/4" x 1/2" groove insert					\$44	
XXX675000	Gib for profile knives					\$44	

## U818 Special Insert Planerheads

### Hydro Spiral Planerhead

Similar in design to the spiral planerheads shown on page 14, but in a hydro version for full working width. Includes a full set of installed carbide inserts.

XXX622640	160 x 330 x 1 13/16"	Z3/3	\$2,275
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### Hydro Helic Planerhead

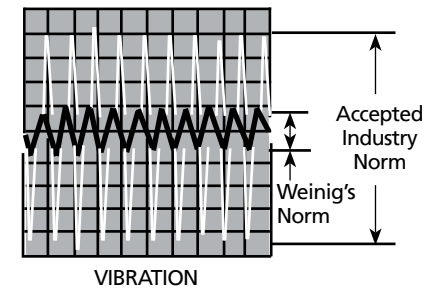
Newly developed planerhead for use as a roughing tool on first bottom or first top spindles. Inserts can be resharpened on a Weinig R960 series grinder. Includes a full set of installed HSS inserts.

XXX6463103	160 x 310 x 1 13/16"	Z3	\$1,885
Replacement knives:	XXX64310	HSS	\$72
	XXX64310RW	Coated	\$76



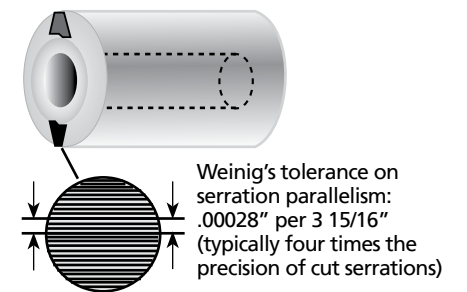
## Cutterhead Balance

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.



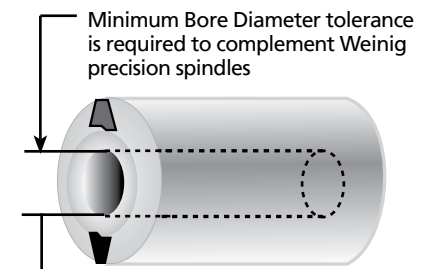
## Parallel Knife-slot Serrations

It's accepted practice to create knife-slot serrations on the cutterhead with standard metal-cutting tools. But this can result in a wavy 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.



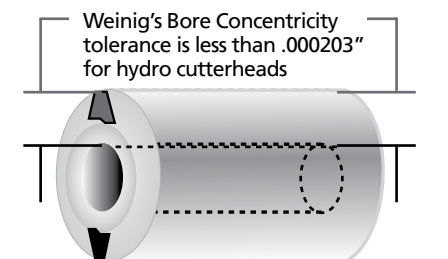
## Bore Tolerance

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.



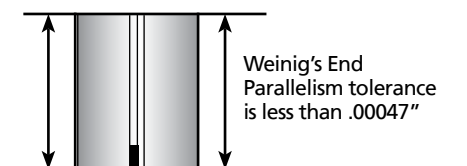
## Bore Concentricity

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.



**Based on Clear / FAS / Facegrade or Better Wood  
With 6%-8% Moisture Content**

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	20	20
Ash	SRS	M2	M3+	M3+	M3+	SUPRE	12	12
Basswood	SRS	M2	M3+	M3+	M3+	SUPRE	20	20
Beech	SRS	M2	M3+	M3+	M3+	SUPRE	12	12
Birch	SRS	M2	M3+	M3+	M3+	SUPRE	12	20
Cedar, Eastern	SRS	M2	M3+	M3+	M3+	SUPRE	12	12
Cedar, Western	SRS	M2	M3+	M3+	M3+	SUPRE	30	20
Cherry	M2	M3+	SUPRE	SUPRE	SUPRE	SUPRE	12	12
Cottonwood	SRS	M2	M3+	M3+	M3+	SUPRE	12	20
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	5	12
Maple, Soft	M2	SUPRE	Carbide	Carbide	Carbide	Carbide	12	12
Oak, Red	M2	M3+	SUPRE	SUPRE	SUPRE	SUPRE	12 & 20	12 & 20
Oak, White	M2	M3+	SUPRE	SUPRE	SUPRE	SUPRE	12	12
Pecan	M3+	SUPRE	Carbide	Carbide	Carbide	Carbide	12	12
Pine, Eastern White	SRS	M2	M3+	M3+	M3+	SUPRE	20	20
Pine, Heart	M3+	SUPRE	SUPRE	SUPRE	SUPRE	SUPRE	12 & 20	12 & 20
Pine, Radiata	SRS	M2	M3+	M3+	M3+	SUPRE	20	20
Pine, Southern Yellow	SRS	M2	M3+	M3+	M3+	SUPRE	20	20
Poplar	SRS	M3+	M3+	M3+	M3+	SUPRE	20	20
Redwood	SRS	M2	M3+	M3+	M3+	SUPRE	30	20
Sapele	M3+	M3+	SUPRE	SUPRE	SUPRE	SUPRE	12	12
Spruce	SRS	M2	M3+	M3+	M3+	SUPRE	20	20
Sycamore	M2	M2	M3+	M3+	M3+	SUPRE	12	12
Walnut	M2	M3+	SUPRE	SUPRE	SUPRE	SUPRE	12	12
All Others	Ask Weinig	Ask Weinig	Ask Weinig	Ask Weinig	Ask Weinig	Ask Weinig	Ask Weinig	Ask Weinig

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:
 

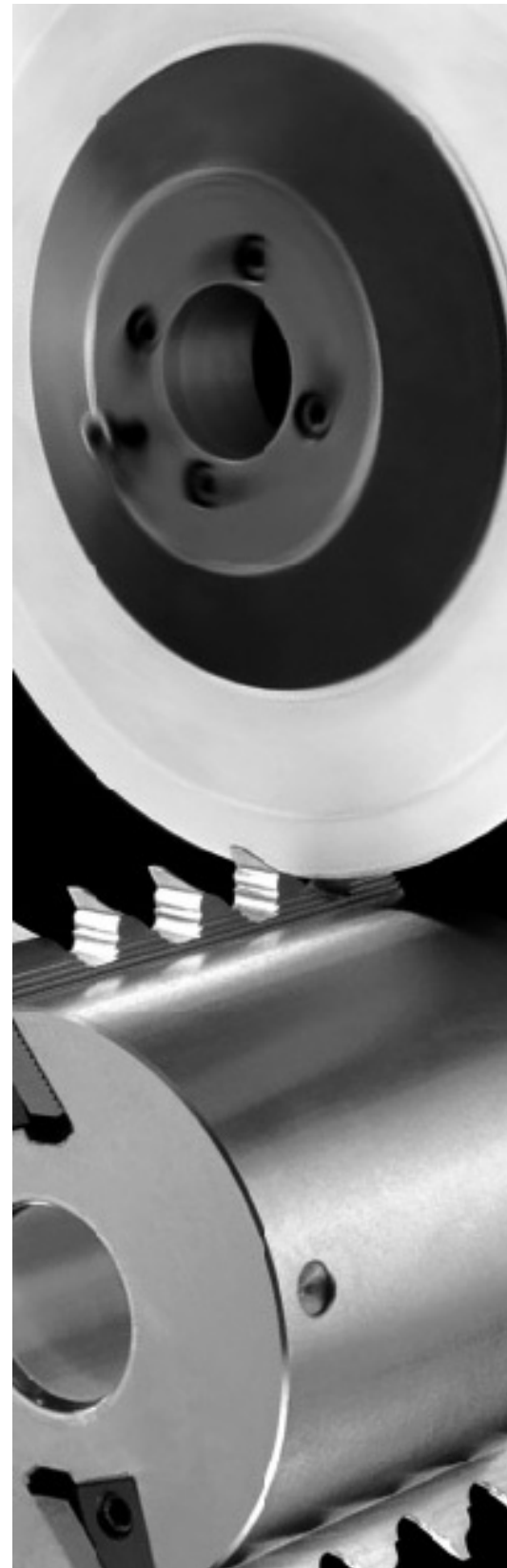
HSS (Non-jointed machine)	25/20°
HSS (Jointed machine)	30/27°
Carbide knives	18/15°
5. Cutterheads with 20° hook angle consume up to 30% less HP than lower hook angle cutterheads, so always use these tools when possible. When HP is an issue, you should try using 20° tools with less stock removal. This 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.

## 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 Weing 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 Weing standards. That's why we say "Use the Best on the Best – It Really Makes a Difference."

### Raw Material Quality

Weing uses only the highest quality raw materials from specially selected steel mills. For softwoods or short runs of hardwoods, we suggest Weing 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 Weing 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, Weing offers M3+ high-speed steel. Increased levels of carbon and vanadium make Weing M+ a tougher, more abrasion-resistant material than any standard M2 steel on the market today. Weing 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. A new addition to the Weing line of knife steel is the DLC Hy-Val Knives. With a diamond-like coating on an M2 base, you can get up to five times longer knife life in certain applications.

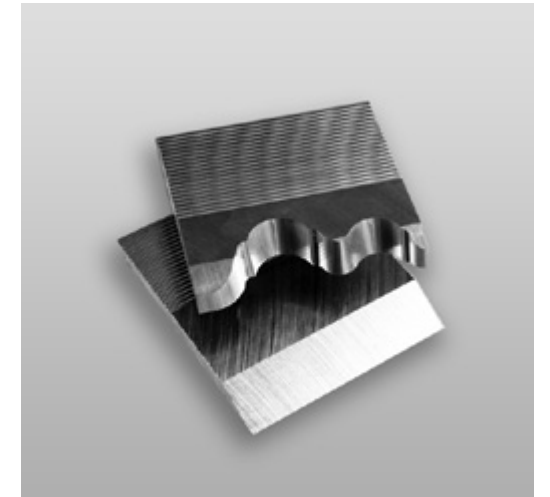
For extremely abrasive hardwoods, composite wood products, laminated stock or synthetic materials, the choice is Weing Double Back Carbide Knife System or TCT inlaid. On each, the finest material available for the specific grade of knife provides an exceptionally hard cutting edge.

### Precision-ground Corrugations

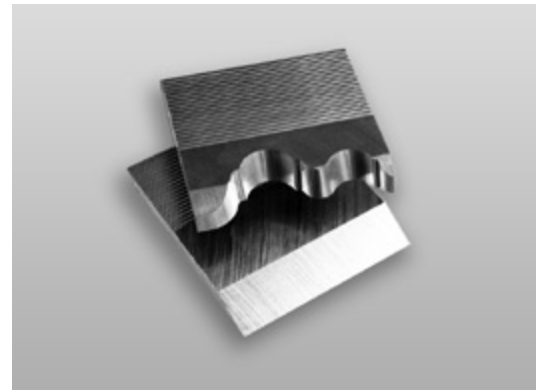
Have you ever cut pieces from a single bar of steel, balanced them, ground the profile, and then found that you had to balance the knives again? This problem is caused by inconsistent corrugations, and it won't happen with Weing knife steel. Across the length of a standard 25" bar of Weing knife steel, corrugation accuracy varies no more than .006". Weing's specially designed equipment creates more consistent corrugations by dressing the grinding wheel after each pass. The resulting high levels of precision, accuracy and parallelism are unique to Weing knife steel.

### Specialized Heat Treating

The best raw material will not perform to optimum levels if it is not correctly heat treated. Weing 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 Weing repeats this drawing process three times, making Weing 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"	\$150
VEN700804	1 3/4"	3/8"	\$173
VEN700806	2"	5/8"	\$178
VEN700807	2 1/4"	7/8"	\$188
VEN700808	2 1/2"	1 1/8"	\$194
VEN700812	2 3/4"	1 3/8"	\$196

## 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"	\$132
VEN700004	1 3/4"	3/8"	\$139
VEN700006	2"	5/8"	\$145
VEN700008	2 1/4"	7/8"	\$148
VEN700010	2 1/2"	1 1/8"	\$153
VEN700012	2 3/4"	1 3/8"	\$166

## 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"	\$110
XXX700172	1 3/4"	1/4"	3/8"	\$117
XXX700174	2"	1/4"	5/8"	\$122
XXX700176	2 1/4"	1/4"	7/8"	\$131
XXX700270	1 1/2"	5/16"	1/8"	\$121
XXX700272	1 3/4"	5/16"	3/8"	\$129
XXX700274	2"	5/16"	5/8"	\$136
XXX700275	2 1/4"	5/16"	7/8"	\$147
XXX700276	2 1/2"	5/16"	1 1/8"	\$153
XXX700278	2 3/4"	5/16"	1 3/8"	\$159

- 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"	\$83
VEN700019	2"	5/8"	\$87
VEN700020	2 1/4"	7/8"	\$92
VEN700021	2 1/2"	1 1/8"	\$94
VEN700023	2 3/4"	1 3/8"	\$98

### 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" \$6.50





## DLC Coated Hy-Val Knife Steel – A New Alternative to Carbide Knives!

Designed primarily for use on plastic composites and other synthetics, this steel can be used in short runs of MDF, long runs of local and exotic hardwoods, and hard-to-run knotty material.

**NOTE:** Because this is a coated steel, do not use on abrasive stone to debur the ground knife. 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
VEN700704	1 3/4"	3/8"	\$242
VEN700706	2"	5/8"	\$251
VEN700708	2 3/8"	1"	\$268
VEN700712	2 3/4"	1 3/8"	\$363

Using a diamond-like coating on an M2 base material, the DLC Hy-Val knife steel provides the following advantages:

- 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



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"	\$72
507-301003	1/4" x 1" x 25"	\$63
507-301002	10mm x 1" x 25"	\$87

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

## Ohaus Portable Electronic Balance Scale

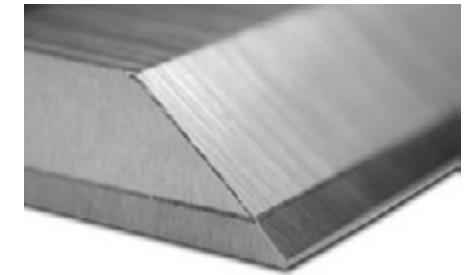


Essential for the production of quality knives, especially in high-RPM applications.

<b>XXX100340</b>	2000g x 0.1g	\$475
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### 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	\$49
VEN700180	1 9/16	40	2 23/64	60	3/16	5	\$50
VEN700181	1 9/16	40	3 9/64	80	3/16	5	\$62
VEN700182	1 9/16	40	3 15/16	100	3/16	5	\$77
VEN700184	1 9/16	40	5 1/8	130	3/16	5	\$100
VEN700186	1 9/16	40	5 29/32	150	3/16	5	\$113
VEN700187	1 9/16	40	6 11/16	170	3/16	5	\$128
VEN700188	1 9/16	40	7 3/32	180	3/16	5	\$135
VEN700189	1 9/16	40	8 17/64	210	3/16	5	\$171
VEN700190	1 9/16	40	9 1/16	230	3/16	5	\$175
VEN700191	1 9/16	40	9 29/64	240	3/16	5	\$188
VEN7001915	1 9/16	40	12 13/64	310	3/16	5	\$252
VEN700192	1 9/16	40	25	635	3/16	5	\$517
VEN700025	2	50	1 9/16	40	1/2"	13	\$57
VEN700026	2	50	2 23/64	60	1/2"	13	\$58
VEN700027	2	50	3 9/64	80	1/2"	13	\$72
VEN700028	2	50	3 15/16	100	1/2"	13	\$89
VEN700030	2	50	5 1/8	130	1/2"	13	\$115
VEN700032	2	50	5 29/32	150	1/2"	13	\$128
VEN700033	2	50	6 11/16	170	1/2"	13	\$145
VEN700034	2	50	7 3/32	180	1/2"	13	\$156
VEN700035	2	50	8 17/64	210	1/2"	13	\$182
VEN700036	2	50	9 1/16	230	1/2"	13	\$199
VEN7000372	2	50	9 29/64	240	1/2"	13	\$205
VEN7000375	2	50	12 13/64	310	1/2"	13	\$288
VEN700037	2	50	25	635	1/2"	13	\$566
VEN7000377	2 3/8	60	1 9/16	40	11/16	18	\$67
VEN700038	2 3/8	60	2 23/64	60	11/16	18	\$68
VEN700039	2 3/8	60	3 9/64	80	11/16	18	\$85
VEN700040	2 3/8	60	3 15/16	100	11/16	18	\$105
VEN700042	2 3/8	60	5 1/8	130	11/16	18	\$134
VEN700044	2 3/8	60	5 29/32	150	11/16	18	\$137
VEN700045	2 3/8	60	6 11/16	170	11/16	18	\$162
VEN700046	2 3/8	60	7 3/32	180	11/16	18	\$179
VEN700047	2 3/8	60	8 17/64	210	11/16	18	\$209
VEN700048	2 3/8	60	9 1/16	230	11/16	18	\$227
VEN7000485	2 3/8	60	9 29/64	240	11/16	18	\$243
VEN700049	2 3/8	60	25	635	11/16	18	\$649

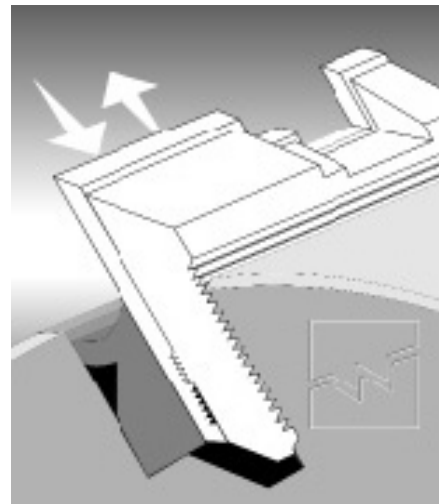


- Carbide-tipped steel provides longer run time than high-speed steel because the carbide composition is a much harder and stronger cutting edge.
- Recommended for use on highly abrasive hardwoods, composite wood products, wood with glue lines, and synthetic materials.
- Softer grade of carbide than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

## Now With A Polished Finish!

For years, the Weinig Double-Back carbide knife system was the industry leader in high-production planing and molding of abrasive materials. Now the cost of using top-quality carbide becomes less. As before, you still receive the following standards from Weinig:

- Micrograin carbide, with polished grind, for better finish quality
- Extreme accuracy between carbide knife and backing piece
- Safety design to prevent unsafe radial movement



### Double Back Filler Strip

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

**VEN700109** \$38.50

### 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 47.

### 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		\$83
VEN700633	1 1/2	38	3 15/16	100	Planing only		\$140
VEN700635	1 1/2	38	5 1/8	130	Planing only		\$182
VEN700637	1 1/2	38	5 29/32	150	Planing only		\$208
VEN700639	1 1/2	38	7 3/32	180	Planing only		\$247
VEN700641	1 1/2	38	9 1/16	230	Planing only		\$312
VEN700650	2	50	1 9/16	40	7/16	11	\$60
VEN700651	2	50	2 23/64	60	7/16	11	\$89
VEN700652	2	50	3 9/64	80	7/16	11	\$118
VEN700653	2	50	3 15/16	100	7/16	11	\$149
VEN700655	2	50	5 1/8	130	7/16	11	\$193
VEN700657	2	50	5 29/32	150	7/16	11	\$223
VEN700659	2	50	7 3/32	180	7/16	11	\$293
VEN700661	2	50	9 1/16	230	7/16	11	\$345
VEN700670	2 3/8	60	1 9/16	40	3/4	20	\$64
VEN700671	2 3/8	60	2 23/64	60	3/4	20	\$96
VEN700672	2 3/8	60	3 9/64	80	3/4	20	\$125
VEN700673	2 3/8	60	3 15/16	100	3/4	20	\$157
VEN700675	2 3/8	60	5 1/8	130	3/4	20	\$203
VEN700677	2 3/8	60	5 29/32	150	3/4	20	\$233
VEN700679	2 3/8	60	7 3/32	180	3/4	20	\$327
VEN700681	2 3/8	60	9 1/16	230	3/4	20	\$368

## 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	\$72
VEN700733	1 1/2	38	3 15/16	100	\$122
VEN700735	1 1/2	38	5 1/8	130	\$158
VEN700737	1 1/2	38	5 29/32	150	\$183
VEN700739	1 1/2	38	7 3/32	180	\$214
VEN700741	1 1/2	38	9 1/16	230	\$273
VEN7007411	1 1/2	38	9 29/64	240	\$294
VEN700750	2	50	1 9/16	40	\$52
VEN700751	2	50	2 23/64	60	\$76
VEN700752	2	50	3 9/64	80	\$101
VEN700753	2	50	3 15/16	100	\$130
VEN700755	2	50	5 1/8	130	\$169
VEN700757	2	50	5 29/32	150	\$194
VEN700759	2	50	7 3/32	180	\$233
VEN700761	2	50	9 1/16	230	\$292
VEN700770	2 3/8	60	1 29/64	40	\$55
VEN700771	2 3/8	60	2 23/64	60	\$82
VEN700772	2 3/8	60	3 9/64	80	\$109
VEN700773	2 3/8	60	3 15/16	100	\$136
VEN700775	2 3/8	60	5 1/8	130	\$177
VEN700777	2 3/8	60	5 29/32	150	\$204
VEN700779	2 3/8	60	7 3/32	180	\$292
VEN700781	2 3/8	60	9 1/16	230	\$332

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 \$93

**VEN700111** 60 x 330mm \$98

Complete operating instructions are available online.



## 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.

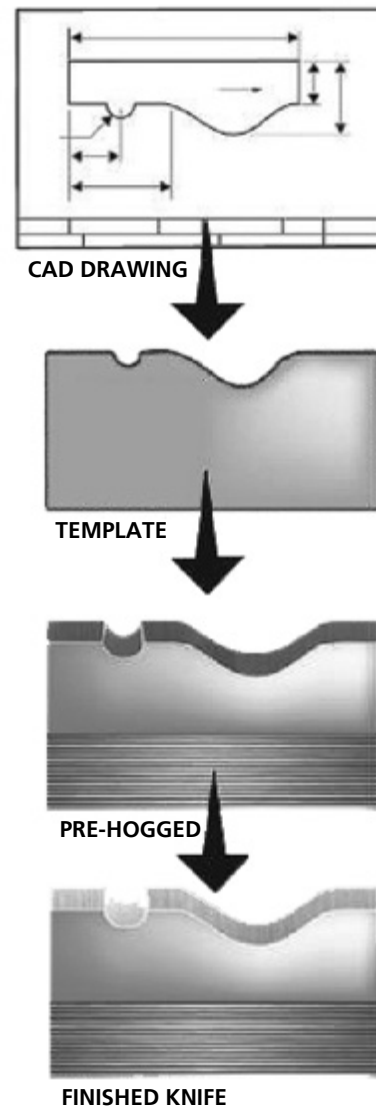
### Regrinding

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.

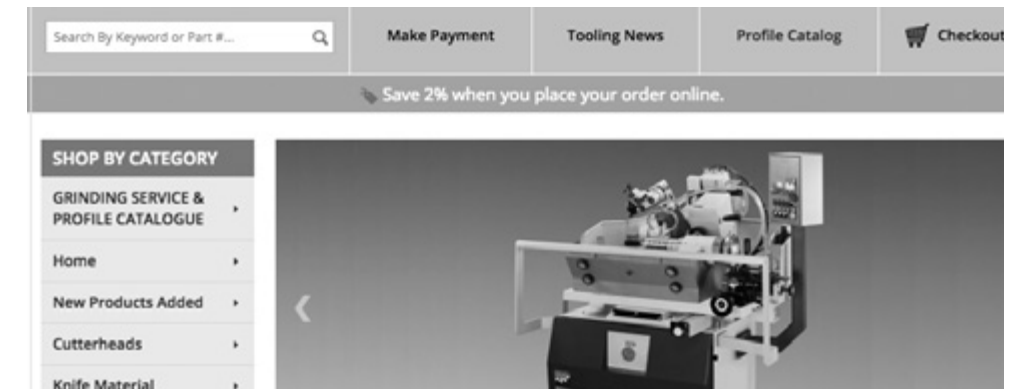


## Weinig's Online Profile Catalog

Now Available for Viewing at [www.weinigusa.com](http://www.weinigusa.com)

Take the time to browse our online catalog for your next profile and SAVE! Custom profile templates can cost as much as \$35.00, so you can save up to \$25.00 per template when making your selection from our Profile Catalog.

All templates chosen From the Online Profile Catalog are only \$10.00 Each!



## 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, the following packing and shipping rates will apply:

Orders of \$200+		Orders less than \$200	
UPS Ground Service	FREE	UPS Ground Service	\$15.00
UPS 3-day Service	\$10.00	UPS 3-day Service	\$20.00
UPS 2-day Service	\$20.00	UPS 2-day Service	\$25.00
UPS 1-day Service	\$40.00	UPS 1-day Service	\$50.00

## Weinig Profile Catalog, 3rd Edition

The Weinig Profile Catalog, 3rd Edition, is now also available for online ordering, viewing or downloading. Ordering standard profile knives and templates has never been easier. Check it out at [www.weinigusa.com](http://www.weinigusa.com).

Templates for each profile included in this book are available for immediate delivery at only \$10.00 per template.

**VEN160102 \$50**



GRINDING WHEEL #	KNIFE STEEL TYPE						DLC
	SRS	M2 (Shallow Profile)	M2 (Deep Profile)	M3+ (Shallow Profile)	M3+ (Deep Profile)	SUPRE	
<b>ROUGH GRIND</b>							
#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				
<b>FINISH GRIND</b>							
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 (Borazon) 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

This new ecologically friendly grinding wheel is a true advancement in the evolution of ceramic grain. See the differences for yourself.

- Will NOT burn the knife, even during heavy metal removal.
- Unlike current ceramic grain, can be used as a finish wheel also.
- Faster metal removal than available with any other grinding wheel on the market today.

**XXX100702** 54-grit Green Ceramic Wheel \$39



## Weinig Blue Ceramic Grinding Wheels

The Weinig Ceramic grinding wheels contain a high-tech abrasive grain that is most effective and cost-efficient on harder high-speed steels, and in high-production applications. The grain structure, which resharpens itself by constantly exposing new cutting edges, improves production with faster steel removal.

**XXX100712** 54-grit Ceramic Wheel for rough grinding \$33

## Weinig Premium Blue Grinding Wheels

Our biggest seller, and considered by most to be our best overall grinding wheel. The Premium Blue grinding wheel uses a special advanced aluminum oxide grain that fractures continuously during grinding, constantly revealing new sharp cutting edges. This feature provides a faster cutting wheel, with extended life due to less loading.

**XXX100719** 54-grit Premium Blue Wheel for rough grinding \$20  
**XXX100717** 100-grit Premium Blue Wheel for finish grinding \$20

## Weinig Euro-grinding Wheels

The Euro-grinding wheel is a new grinding wheel manufactured from a combination aluminum oxide grain. This wheel offers improved performance over our previous version, and at a more economical price.

**006-00182** 54-grit Euro-wheel for rough grinding \$12.50  
**006-00183** 100-grit Euro-Wheel for finish grinding \$12.50

## Weinig Diamond Grinding Wheels



### For Rough Grinding of Tungsten Carbide Knives

PREMIUM		
930-062002	4mm thick with 2mm radius	\$325
930-062015	3mm thick with 1.5mm radius	\$293
930-062018	2mm thick with 1mm radius	\$279
IMPORT		
930-06200215	4mm thick with 2mm radius	\$186
930-06201815	2mm thick with 1mm radius	\$173

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

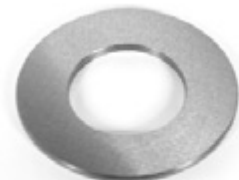
PREMIUM		
930-062020	4mm thick with 2mm radius	\$325
930-062021	2mm thick with 1mm radius	\$279
930-062022	2mm thick with square edge	\$279
IMPORT		
930-06202015	4mm thick with 2mm radius	\$186
930-06202115	2mm thick with 1mm radius	\$173

### For Finish Grinding of Tungsten Carbide Knives

PREMIUM		
930-062003	4mm thick with square edge	\$325
930-062006	4mm thick with 2mm radius	\$325
930-062011	2mm thick with 1mm radius	\$279
930-062013	1.5mm thick with 0.75mm radius	\$269
930-0620131	1.0mm thick with 0.5mm radius	\$321
930-0620132	1.0mm thick with square edge	\$321
930-062016	3mm thick with 1.5mm radius	\$293
920-072006	10mm thick with square edge (requires small-diameter clamping flange)	\$287
IMPORT		
930-06200315	4mm thick with square edge	\$186
930-06200615	4mm thick with 2mm radius	\$186
930-06201115	2mm thick with 1mm radius	\$173

### Prefer to select from the more varied offering of Weinig grinding wheels?

<b>XXX100716</b>	Metal bushing 60mm x 1 1/4" For converting Weinig grinding wheels for use on grinders with 1 1/4" arbors	\$60
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## Weinig CBN (Cubic Boron Nitride) Grinding Wheels

### For Finish Grinding of HSS Profile Knives

PREMIUM		
930-062007	4mm thick with 2mm radius	\$353
930-062008	4mm thick with square edge	\$353
930-0620071	3mm thick with 1.5mm radius	\$329
930-062010	2mm thick with 1mm radius	\$296
930-062012	1.5mm thick with 0.75mm radius	\$288
930-0620121	1.5mm thick with square edge	\$288
930-0620122	1.0mm thick with square edge	\$349
930-0620123	1.0mm thick with 0.5mm radius	\$349
920-072011	10mm thick with square edge (requires small-diameter clamping flange)	\$237
IMPORT		
930-06200715	4mm thick with 2mm radius	\$235
930-06200815	4mm thick with square edge	\$235
930-06201015	2mm thick with 1mm radius	\$223



### 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	\$257
912-062001	For back-grinding of HSS planer knives	\$241
912-062003	For back-grinding of corrugated-back HSS knives	\$241
912-062008	For face-grinding of HSS fingerjoint cutters	\$279

#### Diamond Grinding Wheels

912-062005	For back-grinding of tungsten carbide knives	\$205
912-062006	For face-grinding of TCT solid cutters	\$232
912-062009	For back-grinding of TCT inlaid knives	\$221



## Grinding Room Accessories

### 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, Weing offers hardened-steel tracing pins in a variety of sizes and shapes.

### Tracing Pins for Rondamat 925, 950



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 Weing profile grinders to precisely dress and shape the grinding wheel.

Non-threaded

**VEN700075** \$25

Threaded

**925-034008** \$28



#### 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** \$53

Threaded

**925-934008** \$59

ARTICLE NUMBER	UPPER SIDE	LOWER SIDE	PRICE
930-042001	● 2mm diameter	● 3mm diameter	\$37
930-042002	▭ 4mm semicircular	● 3mm diameter	\$37
930-042003	▭ 4mm x 45° pointed	● 4mm diameter	\$37
930-042009	▭ 2mm semicircular		\$37
930-042010	▭ 3mm semicircular		\$37
930-042013	▭ 1.5mm semicircular		\$37
930-042014	▭ 1.0mm semicircular		\$37
930-042015	▭ 5mm semicircular		\$37

ARTICLE NUMBER	UPPER SIDE	PRICE
925-034003	● 4mm diameter	\$42
925-034004	● 2mm diameter	\$42
925-034009	● 3mm diameter	\$42

## Grinding Room Accessories

### 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	\$179
932-07401	Clamping flange for hydraulic locking systems	\$152
932-07402	Small-diameter clamping flange for hydraulic locking systems	\$171



### Rondamat Grinder Knife Rest

A properly machined knife rest is required to precisely grind knives in the cutterhead. This quality is guaranteed on these Weing 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	\$150
930-013024HM	Replaceable carbide for above-listed set	\$66
932-027001	Beveled knife rest Used for auto-grind on Rondamat 935, 936, 970	\$155
930-013024HEL2	Replaceable carbide for grinding helicarb planerheads	\$61



### Rondamat Filter Sheets Now Improved for Better Filtration

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** \$50

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

**003-06950XL** \$60

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

**003-06950G** \$50







### 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** \$152

### Rondor Replacement Stone

**006-00192** \$21



### 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** \$21.50



### Round Edge Slip Stone

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

**XXX100732** \$10.75



### Diamond and CBN Wheel Dresser

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

For use with VEN700073SMPK Dresser Attachment Kit

**VEN700070** \$46

### Plastic Shims



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

XXX100709	0.001" thick (orange)	.60
XXX100708	0.002" thick (red)	.60
XXX100707	0.005" thick (blue)	.65
XXX1007068	0.010" thick (brown)	.75
XXX1007065	0.025" thick (white)	\$1.10

### 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** \$3

### 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** \$13.25

### NEW – Diamond and CBN Dresser Attachment Kit

A retrofit kit that will fit most Weing 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** \$155

### NEW!

### Acmosit 65-62 Ultra-Cool

A new formulation exclusive for Weing USA!

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

- Increased lubricity
- Less odor
- More rust inhibitor

### Ultra-Cool Grinding Coolant

<b>5 Kg (1.6 gallon) jug</b>	<b>VEN700056</b>	\$70
<b>20 Kg (6.5 gallon) jug</b>	<b>VEN700056L</b>	\$280



### Ronda Cool XL Grinding Coolant

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

### Ronda-Cool XL

<b>1-gallon jug</b>	<b>VEN700054</b>	\$36
<b>5-gallon pail</b>	<b>VEN700054L</b>	\$144



### 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** \$116



### Rust Preventative Spray

Prevent rust with a new Rust Preventative Spray! Tools or machinery parts—it's effective on both.

**XXX100081** \$24



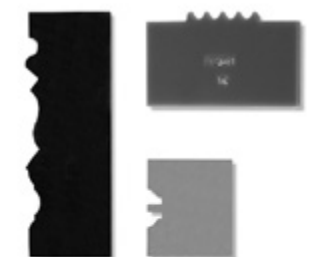
### Template Material

For best results, Weing 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"	\$16.50
000-80002	3 11/32" (85mm) x 24" x 1/8"	\$19
000-80003	3 47/64" (95mm) x 24" x 1/8"	\$20.50
000-80004	4 9/64" (105mm) x 24" x 1/8"	\$22

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

**4" x 12"** **VEN060096** \$5.75



## 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.

### 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

- Flush-Mount Display Kit \$465.00 (Part: NGK1)
- Surface-Mount Display Kit \$550.00 (Part: NGK2)



Surface-Mount Display pictured

### Pressure Release Valve #32365 M10x1

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

**003-03856** \$9.75

Replacement rubber seal ring  
**003-27332** \$1.80

Seal ring for old-style release valve  
**003-11901** \$2.60



### Hydraulic Grease Fitting #32319 M10x1

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

**003-11560** \$10.25

Replacement rubber seal ring  
**003-27332** \$1.80

Seal ring for old-style grease fitting  
**003-11901** \$2.60

### 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** \$9

### Grade #2 Grease Cartridge

For use with central lubrication system.

**003-17500** \$6



### Special Hydraulic Grease Gun 0-400 Bar

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

**003-09103** \$485

Individual spare parts available from stock, and listed with prices on website, [www.weinigusa.com](http://www.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** \$40

For new-style hydraulic grease gun (#003-09103)  
**003-09139K** \$105



### Grease Gun for Central Lubrication Systems

**003-09091** \$139

## 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

<b>5 Kg (1.6-gal.) can</b>	<b>XXX100083</b>	\$48
<b>20 Kg (6.5-gal.) can</b>	<b>XXX100083L</b>	\$180
<b>160 Kg (52-gal.) drum</b>	<b>XXX100083A</b>	\$1,335
<b>Waxilit Paste 70g tin</b>	<b>XXX100082</b>	\$10.25



## 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

<b>5-gallon can</b>	<b>XXX100074L</b>	\$143
<b>55-gallon drum</b>	<b>XXX100074A</b>	\$1,280

## 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.

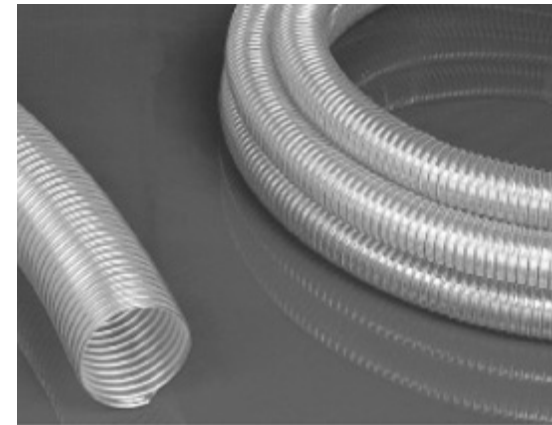
- Chemical tunneling action that gets under the grease and grime for easy removal
- Protects ferrous metals, preventing rust formation on tools and machinery
- Environmentally safe to use, and totally biodegradable for easy disposal after use
- Can be sprayed directly onto machinery, or used in ultrasonic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

### CUTTER-GUARD

<b>1-gallon jug</b>	<b>XXX100380</b>	\$16
<b>5-gallon pail</b>	<b>XXX100380L</b>	\$67
<b>55-gallon drum</b>	<b>XXX100380A</b>	\$518



## 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 rip saws**

Minimum 10' length, sold in 5' increments

ARTICLE NUMBER	HOSE DIAMETER	PRICE
	(INSIDE DIAMETER)	
003-04428	120mm (4 23/32")	\$11.40
003-04456	140mm (5 1/2")	\$12.40
003-04419	160mm (6 9/32")	\$15.00
003-04433	200mm (7 7/8")	\$20.00
003-04418	250mm (9 27/32")	\$23.85
FLX-300	300mm (11 13/16")	\$26.90

**Optional heavy-duty quality and thickness, for more abrasion resistance**

Minimum 10' length, sold in 5' increments

ARTICLE NUMBER	HOSE DIAMETER	PRICE
	(INSIDE DIAMETER)	
003-044281HD	120mm (4 23/32")	\$18.35
003-044561HD	140mm (5 1/2")	\$22.35
003-044191HD	160mm (6 9/32")	\$26.30
003-044331HD	200mm (7 7/8")	\$37.80
003-044181HD	250mm (9 27/32")	\$45.50
FLX-3001HD	300mm (11 13/16")	\$52.60



## 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.

<b>WNW-101719</b>	Safety locking collar for 1 13/16" spindles	\$107
<b>WNW-101720</b>	Safety locking collar for 2 1/8" spindles	\$107

## Straight Edge

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

<b>WNW-0287</b>	10" length	\$42
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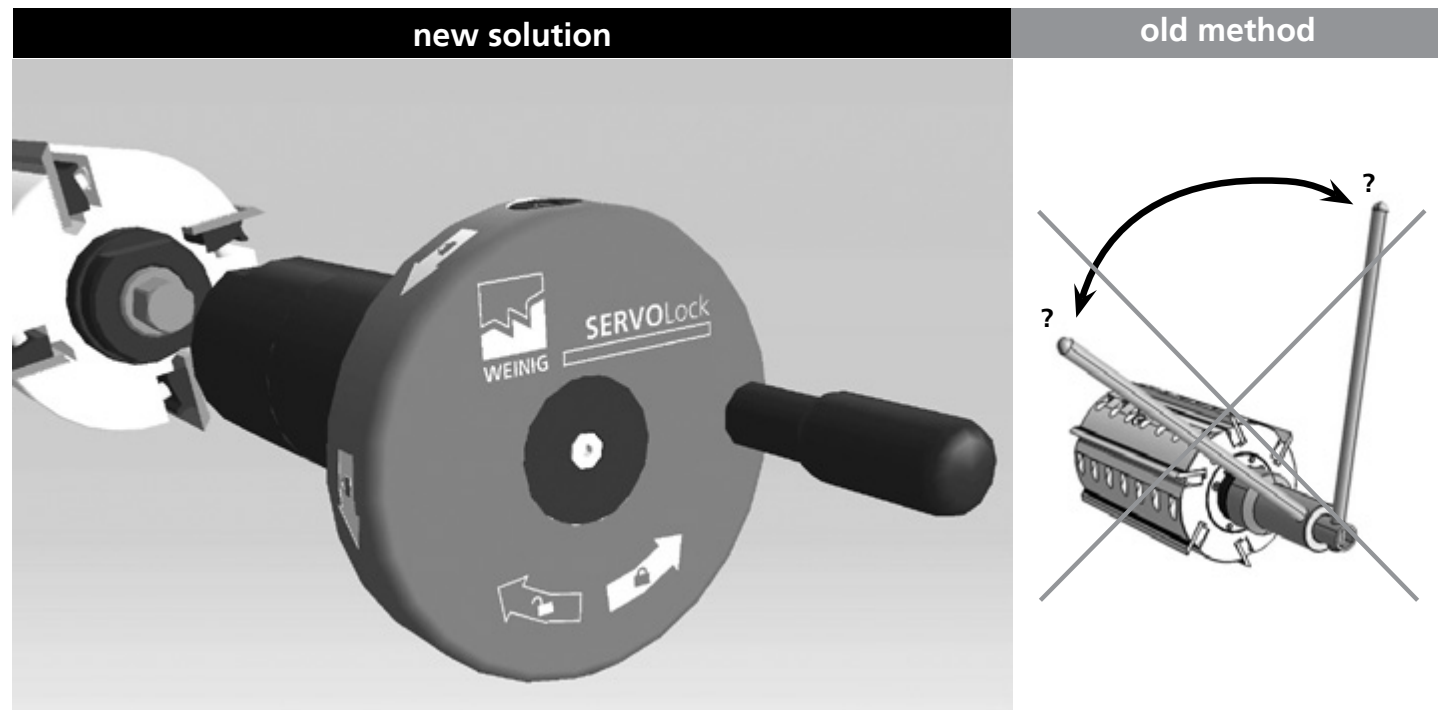
## A revolution in clamping of conventional bore tools!

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
- Now being offered at an introductory low price

**35036001** Servo Tool Wrench \$995



## 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!

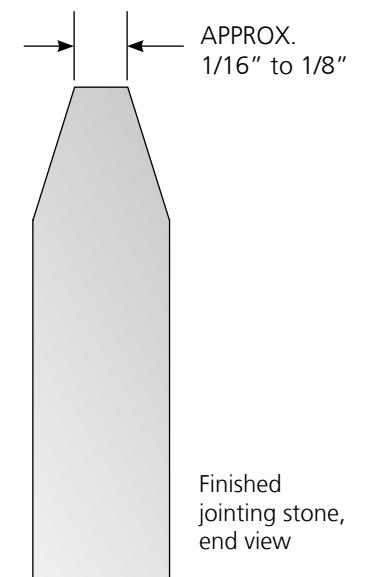
**Resin Bond:** Provides a better finish quality.

ARTICLE NUMBER	JOINTING STONE FOR	SIZE MM	BOND	COLOR	GRIT	PRICE
006-00187	HSS Profiling	160 x 60 x 15	Vitrified	Blue-Grey	600	\$17.00
006-00188	HSS Profiling	160 x 60 x 15	Resin	Green	600	\$19.50
006-00377	HSS Profiling	160 x 60 x 15	Resin	Green	500	\$17.50
XXX100786	P2400 Profiling	160 x 60 x 15	Resin	Green	500	\$24.50
006-00370	HSS Profiling	230 x 60 x 15	Vitrified	Blue-Grey	600	\$21.00
006-00095	HSS Profiling	230 x 60 x 15	Resin	Green	600	\$25.00
006-02121	HSS Profiling	230 x 60 x 15	Resin	Green	500	\$23.50
XXX100727	HSS Profiling	300 x 60 x 15	Resin	Green	600	\$34.50
251-362002	HSS Planing	20 x 60 x 15	Resin	Green	500	\$6.00
006-01654	HSS Planing	20 x 60 x 15	Vitrified	White	240	\$6.00
006-02116	HSS Planing	12 x 38	Vitrified	Blue-Grey	280	\$3.75
XXX100787	P2400 Planing	12 x 38	Resin	Green	500	\$11.50
WAC501522	HSS Planing	16 x 125	Vitrified	Dark Grey	220	\$11.25
WAC501522 SPEC	HSS Planing	16 x 125	Vitrified	White	240	\$11.25
006-00186	HSS Planing	20 x 100 x 10	Vitrified	Blue-Grey	280	\$4.50
XXX100724	Carbide Profiling	160 x 60 x 15	Special	Blue-Grey	600	\$18.00
XXX100720	Carbide Profiling	230 x 60 x 15	Special	Blue-Grey	600	\$22.00
XXX100722	Carbide Planing	20 x 60 x 15	Special	Dark Grey	240	\$6.00
XXX100731	Carbide Planing	12 x 38	Special	Dark Grey	240	\$3.75
WAC501522HM	Carbide Planing	16 x 125	Special	Dark Grey	240	\$15.00

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"



### For the very best attainable finish when straight-knife jointing

ARTICLE NUMBER	JOINTING STONE FOR	SIZE INCHES	TYPE	PRICE
XXX100703	HSS planing	12 x 32	CBN	\$110
XXX100704	Carbide planing	12 x 32	Diamond	\$110

## NEW! Pointed Tooth Roller 2.0

The standard infeed rollers furnished on all new Weinig moulders are the NEW steel tooth rollers 2.0. The main advantages of this new 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" indentation of only 3mm (1/8") deep.



ARTICLE NUMBER	SIZE	PRICE
340-291001	5 1/2" OD x 2" wide roller for 35mm keyed shaft	\$201
023-291112	5 1/2" OD x 1 1/4" wide roller for 35mm keyed shaft	\$198
340-291002	5 1/2" OD x 5/8" wide roller for 35mm keyed shaft	\$151
023-291115	5 1/2" OD x 3/8" wide roller for 35mm keyed shaft	\$161
023-291110	5 1/2" OD x 3/4" wide roller for 35mm keyed shaft with extended hub	\$182
143-618002	5 1/2" OD x 5/8" wide roller for 35mm keyed shaft with extended hub	\$216
023-291188	5 1/2" OD x 3/4" wide cup (bolt-on) roller for 30mm shaft	\$207
023-291183	5 1/2" OD x 5/8" wide cup (bolt-on) roller for 30mm shaft	\$174
023-291128	5 1/2" OD x 3/8" wide cup (bolt-on) roller for 30mm shaft	\$244
023-291155	5 1/2" OD x 5/16" wide cup (bolt-on) roller for 30mm shaft	\$269
023-291127	5 1/2" OD x 3/4" wide cup (bolt-on) roller for 20mm bore	\$248

## 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 \$235

## Saw Tooth Feed Roller

Primarily for hardwood applications, as an alternative to roller 023-291104.

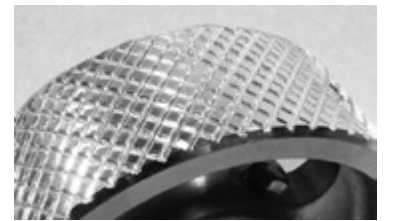
**022-181001** 5 1/2" OD x 2" wide roller For 35mm keyed shaft \$158



## 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 - <i>New Design</i>	\$168
143-618003	5 1/2" OD x 3/4" wide roller for 35mm keyed shaft with extended hub	\$418
143-618004	5 1/2" OD x 5/8" wide roller for 35mm keyed shaft with extended hub	\$377
K27-555015	5 1/2" OD x 3/4" wide cup (bolt-on) roller for 30mm shaft	\$408
K27-555014	5 1/2" OD x 5/8" wide cup (bolt-on) roller for 30mm shaft	\$489



## 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	\$77.00
226-106009V	5 1/2" OD x 2" wide for 35mm keyed shaft	65	\$94.50
143-618007	5 1/2" OD x 1 1/4" wide for 35mm keyed shaft	80	\$76.50
143-618007V	5 1/2" OD x 1 1/4" wide for 35mm keyed shaft	65	\$88.75
042-362006	5 1/2" OD x 3/4" wide for 35mm keyed shaft	80	\$60.75
042-362007	5 1/2" OD x 5/8" wide for 35mm keyed shaft	80	\$61.75
042-362007V	5 1/2" OD x 5/8" wide for 35mm keyed shaft	65	\$65.00
042-36200710	5 1/2" OD x 3/8" wide for 35mm keyed shaft	80	\$71.00
014-192018	5 1/2" OD x 1 1/2" wide cup (bolt-on) for 30mm shaft	80	\$41.50
014-192019	5 1/2" OD x 3/4" wide cup (bolt-on) for 30mm shaft	80	\$30.00
014-192020	5 1/2" OD x 5/8" wide cup (bolt-on) for 30mm shaft	80	\$29.75
014-192021	5 1/2" OD x 1/2" wide cup (bolt-on) for 30mm shaft	80	\$28.75
014-192021V	5 1/2" OD x 1/2" wide cup (bolt-on) for 30mm shaft	65	\$28.75



## 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 are 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	\$21
XXX100850	Replaceable tire	5 1/2" OD x 2" wide	85	\$21
XXX100840V	Replaceable tire	5 1/2" OD x 2" wide	65	\$21
XXX100870	Replaceable tire	6 3/4" OD x 2" wide	80	\$45
XXX100845	Replaceable tire	5 1/2" OD x 3/4" wide	80	\$17
XXX100855	Replaceable tire	5 1/2" OD x 3/4" wide	85	\$18
XXX100845V	Replaceable tire	5 1/2" OD x 3/4" wide	65	\$18
XXX100900	Keyed steel feed hub	For 2" wide replaceable tire		\$103
XXX100902	Keyed steel feed hub	For 3/4" wide replaceable tire		\$127
XXX100905	Steel cup feed hub	For 3/4" wide replaceable tire		\$148

### Center Locking Washer for Stacking Cup Feed Rollers

<b>250-233007</b>	For use with steel cup rollers	\$17
<b>250-2330071</b>	For use with urethane and knurled cup rollers	\$17



## 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.

### 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. Blank shoes now available for profiling in-house.

To purchase counter profile shoes, contact directly:

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

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

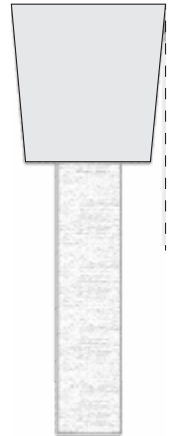
### Cut Quality

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

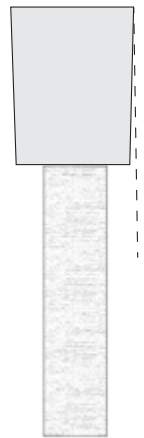
### Blade Characteristics

- 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.

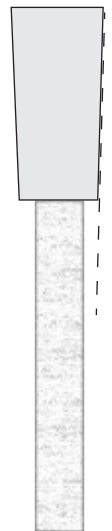
Moulder Blank Blades



Glue-line Blades



Thin Kerf Blades





## 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 buildup 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	\$109
9119161	Standard blade supplied with all new KM/KR saws	4.0	36	80-166	\$123
9119186	Alternative blade for KR saws with high-speed package	4.0	48	130-260	\$148
9119189	Alternative blade for KR saws with high-speed package	4.0	60	260-400	\$162
9119272	Optional thin kerf blade	2.8	28	50-115	\$124
9119274	Optional thin kerf blade	2.8	36	80-166	\$137
9119276	Optional thin kerf blade	2.8	48	130-260	\$164

### 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	\$72
9119362	3.5	36	80-166	\$78
9119387	3.5	48	130-260	\$85

### 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	\$230
917340	Special 350mm OD blade	4.0	28	50-115	\$166
9119165	Special 360mm OD blade	4.0	36	80-130	\$169

## 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	\$1,195
9121425	300 x 18.6 for LH (outside) position	\$1,195



## Additional Trim Saws

91214352B	300 x 36T for RH (inside) Hogcut #9121435-Standard	\$260
9121435B	300 x 48T for RH (inside) Hogcut #9121435-Optional	\$271
91214252B	300 x 36T for LH (outside) Hogcut #9121425-Standard	\$260
9121425B	300 x 48T for LH (outside) Hogcut #9121425-Optional	\$271

## Hogfix Fixed Clamping Device for Quickfix Arbor

Fixed clamping flange for Standard TCT Hogcut

<b>349518</b>	\$505
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## Hogfix Fixed Clamping Device for Standard (Non-Quickfix) Arbor

Fixed clamping flange for standard TCT Hogcut

<b>349435</b>	\$2,074
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## Quickfix Fixed Clamping Device

Clamping flange for a single saw blade

<b>312196</b>	For production of up to 6/4 lumber	\$425
<b>312196 SD</b>	For production of 8/4 lumber and larger	\$575



## Quickfix Movable Clamping Device

Clamping flange for a single saw blade on the movable head

<b>349014</b>	Clamping flange only	\$2,235
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## Standard Locking (Non-Quickfix) Fixed Clamping Device

Clamping flange for a single saw blade

<b>317778</b>	New Quickfix release clamping flange only	\$1,732
<b>311636</b>	Standard clamping flange only	\$920



## Replacement Spikes for Raimann Ripsaw Feed Chains

<b>903762</b>	6mm	.80
<b>903761</b>	7mm	.80
<b>903760</b>	8mm	.80



## Hydraulic Oil Fitting for Quickfix Arbors

<b>900120</b>	M10 x 1, cpl with special seal ring	\$18.50
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## New and Improved Lubrication Accessories

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

<b>XXX100073L</b>	5-gallon pail	\$194
<b>XXX100073A</b>	55-gallon drum	\$1,857

Hydraulic Oil for Quickfix Saw Arbors

<b>349001</b>		\$15
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## Lubrication Oil for Feed Chain

New formulation for better lubrication and less run-off

<b>PUS750100</b>	5-gallon pail	\$200
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## Oil for Arbor Lubrication

New formulation for better lubrication, eliminates sticking and buildup problems

<b>PUS909715</b>	5-gallon pail	\$124
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## 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. Now, also 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.



## Dimter Crosscut Saws

### NEW DESIGN - For the Best Cut Ever!

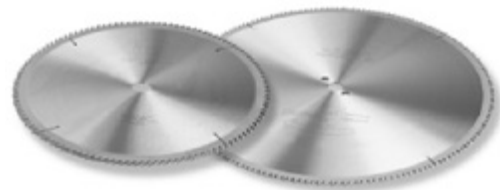
Grecon Dimter, a member of the Weinig Group since 1993, offers optimizing crosscut saws and fingerjointing machines that let you increase your yield from each piece of wood, minimize your waste, and produce wood that is strong and defect-free. Like Weinig moulders and grinders, the precision machinery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

Dimter 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.

### Dimter Crosscut Saw Blades

Standard stocking blades for all solid woods  
(All blades have 30mm bore unless noted otherwise.)

48032583S	400mm OD	Z114	\$325
48033731S	450mm OD	Z132	\$350
48033741S	500mm OD	Z144	\$475
48033880S	500mm OD	Z144	\$475
<i>harder carbide for composites</i>			
48034000S	630mm OD	Z180	\$720
48033850S	500mm OD	Z144	\$510
<i>Special for S35 and S50 saw with 35mm arbor</i>			



## 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	\$17.50
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## 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	\$1.35
91062211A	Optional Orange	\$1.35
91062212A	Optional Watermelon	\$1.85
8290082286	Invisible Blue	\$1.95

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

91062210	Old Style Red	\$1.35
91062220	Pink Chalk	\$1.35

### Marking Crayons for Rough-cut and Wet Lumber

(Non-fluorescent, packed 12 pieces per box)

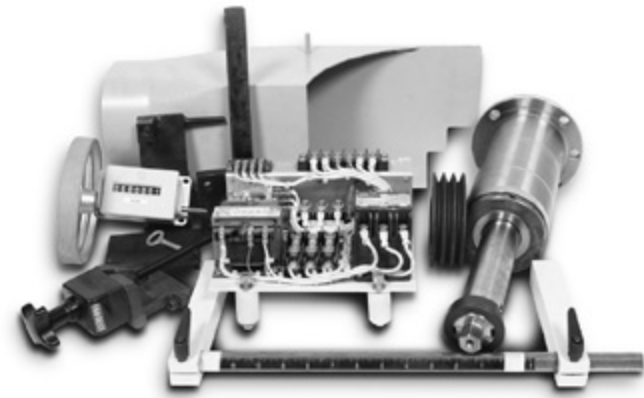
90763320A	Blue	\$1.00
90763321A	Black	\$1.00

### Crayon Holder

91065555A	Standard	\$19.25
85489CH	Special for Invisible Blue Crayon	\$19.25



## Spare Parts



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

- Over \$6 million in parts inventory located in the United States.
- Online access to Weing Germany records for quick and accurate research information.
- Over 110 years of combined experience in providing skilled and knowledgeable customer service support.

### NOW, available online:

Easily identified spare parts for ease of ordering 24/7.

Contact us at [partsales@weinig.com](mailto:partsales@weinig.com) or phone 877-548-0929, ext. 7720

Have you looked at the Weing America 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 2,000 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.

## Weing Values Your Business

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



## The HOLZ-HER Group Success Through Specialization



HOLZ-HER machines can be found all over the world wherever wood is professionally machined or processed. Being globally active while providing the best possible up-to-date solutions for our customers has been one of the basic principles of HOLZ-HER since the establishment of the company by Karl Matthias Reich in 1914.

Companies investing in HOLZ-HER products have a need for high precision and productivity in their machining processes. At HOLZ-HER, we recognize these needs and strive to exceed them by offering real-time customer service from knowledgeable and experienced woodworking technology professionals. The management team at HOLZ-HER has recognized the special ingredient necessary to keep the company at the top – a commitment to service that has made us a leader in customer satisfaction.

In 2010, WEINIG AG purchased HOLZ-HER. The acquisition unites two great industry names that stand for quality, reliability and dynamic German engineering in machine construction. This combination of companies will ensure that the service received will become even better, more effective, and more efficient. This is an extremely positive step toward stability in our currently difficult market.

The Weing credo, "Use the Best on the Best," also has become the HOLZ-HER credo. Watch as our combined efforts bring even better tooling and supply products to our customers in the future.



For more information about parts:  
Phone: 877-548-0929, ext. 7423  
Email: [parts@holzher.com](mailto:parts@holzher.com)

## 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.weinigusa.com](http://www.weinigusa.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:**

**Phone: 877-548-0929**

**Email: [service@weinig.com](mailto:service@weinig.com)**

## 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 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 at [www.weinigusa.com](http://www.weinigusa.com).
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: 877-548-0929**

**Email: [service@weinig.com](mailto:service@weinig.com)**

## 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.

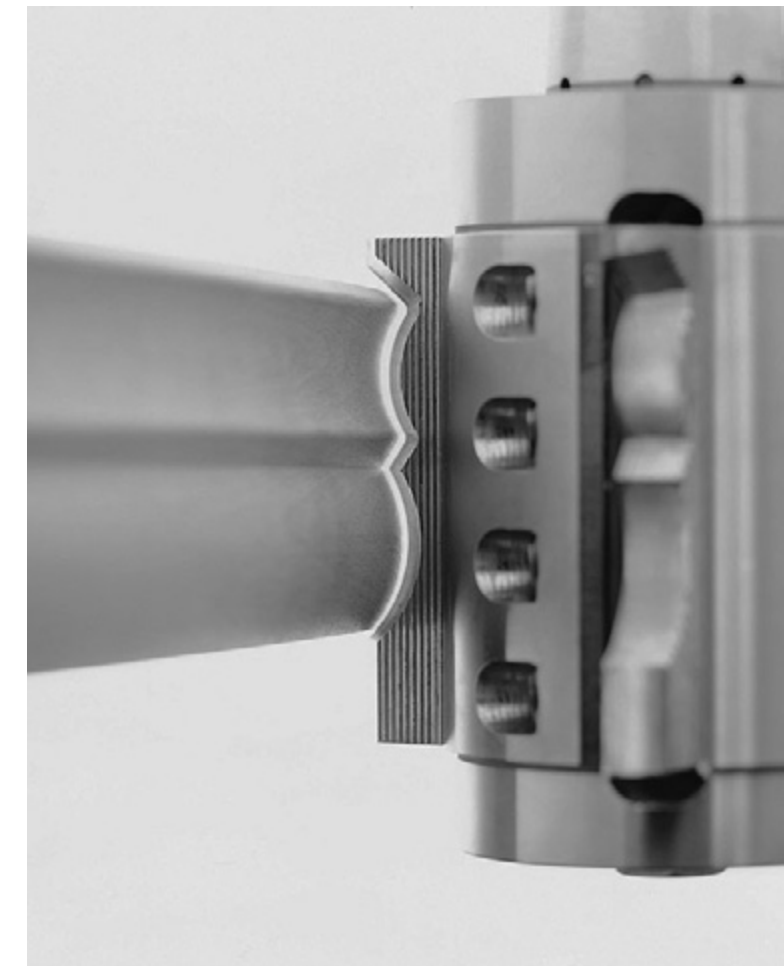
### Q: Can we offset our knives (aka "split knives") in PowerLock tools running at 12,000 rpm?

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.





## Regarding Operation of Weinig PowerLock Cutterheads #538 and Powermat Moulders



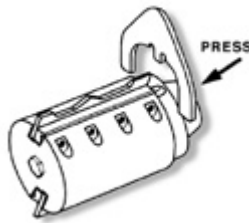
1. For safety reasons, the maximum adjustment of re-ground knives must not exceed four corrugations (1/4") from the bottom. There is a line on the cutterhead that indicates the maximum outward adjustment.
2. Knives and clamping wedges must have the same thickness, and MUST be balanced within 0.1 gram (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.
 

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

1. Remove dirt and resin from the clamping wedges and cutterhead serrations.
2. Insert the corrugated knife (16-60° 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

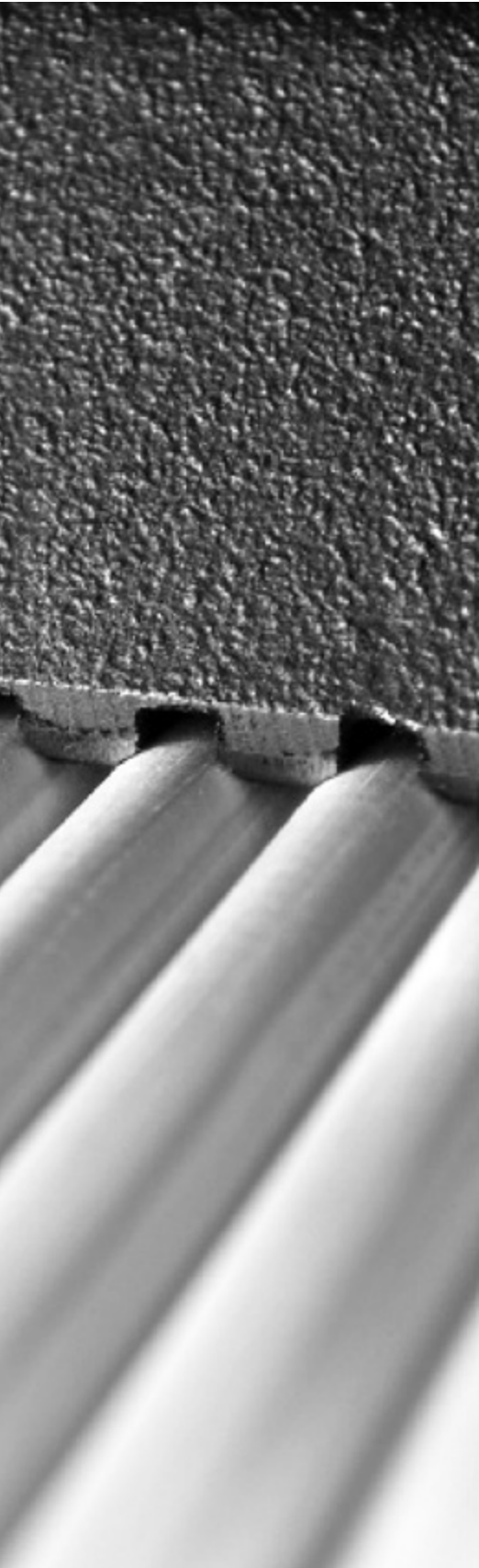
PowerLock cutterheads produced prior to 2006 were balanced as an assembly, including gibs and tensioning screws. This cutterhead series can be easily identified, as the pockets and gibs are numbered in order to ensure that the gibs always remain in the correct position.

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.

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'
8,000	20	25'	50'	100'	150'	200'	250'
	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'
10,000	18	37'	74'	148'	222'	296'	370'
	20	33'	66'	133'	200'	266'	333'
	10	83'	167'	333'	500'	-	-
	12	69'	139'	278'	417'	-	-
	14	60'	119'	238'	357'	-	-
12,000	16	52'	104'	208'	313'	-	-
	18	46'	93'	185'	278'	-	-
	20	42'	83'	167'	250'	-	-
	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.





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

## Now Available— HSK Spindle Repair!

Cutterheads are an important and valuable component of your operation. What do you do when one becomes damaged? Weinig's repair service can help. We can re-sleeve hydro-heads, check and re-balance damaged cutterheads, and perform general overall reconditioning. We also repair hydro grease guns, and moulder and grinder spindles.

For more information, call  
**The Weinig Repair  
 Service Department**  
 1-877-548-0929, ext. 7861

Please photocopy before completing



## Bench Repair Request

DATE: \_\_\_\_\_ P.O. NUMBER: \_\_\_\_\_ MACHINE TYPE: \_\_\_\_\_

BILL TO: \_\_\_\_\_

SHIP TO: \_\_\_\_\_

CONTACT: \_\_\_\_\_

PHONE: ( \_\_\_\_\_ ) \_\_\_\_\_ FAX: ( \_\_\_\_\_ ) \_\_\_\_\_

ITEMS FOR REPAIR (DETAILS): \_\_\_\_\_

\_\_\_\_\_

**NOTE: For cutterheads, please remove tooling and gibs.**

Do you need a return fax quote of repair estimate? YES  NO

Return shipment (please advise): REGULAR UPS  UPS RED  OTHER

**BENCH REPAIR REQUEST FORM MUST ACCOMPANY ITEM FOR REPAIR.**  
 Please insure high-value items.



# Tooling Order Form



## Notes

Fax: 1-704-799-7400

Email: 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)



## **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**



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