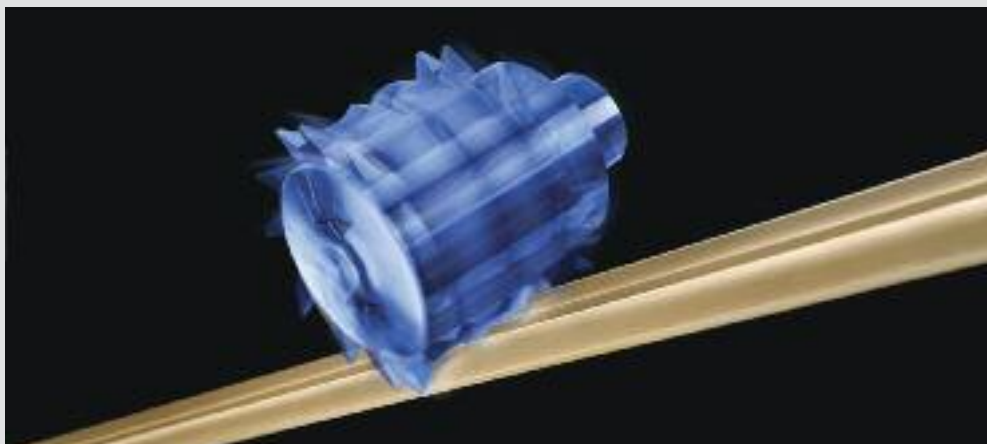


2011 - 2012 Tooling & Supplies Catalog

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



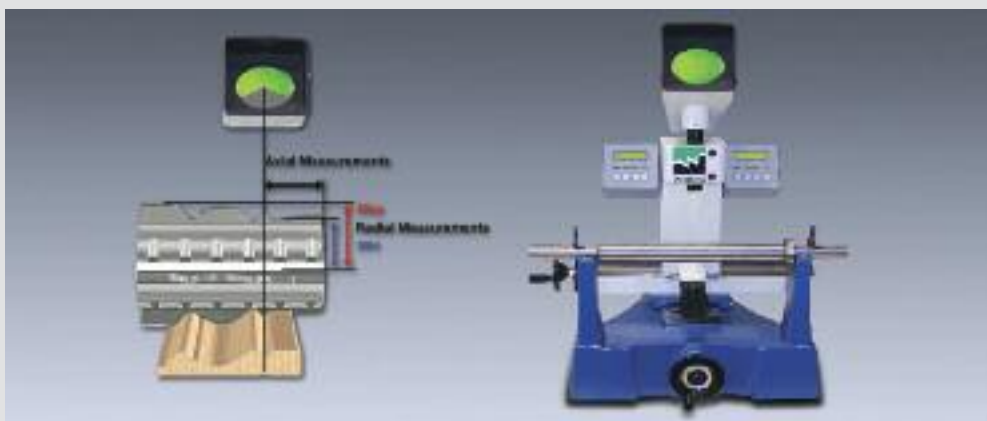
Featured New Items:

Made in USA corrugated knife steel.
Weinig quality for less.

Additional products available from
Weinig Grinding Service.

Additional products added to stan-
dard lines of knife steel, grinding
wheels, feed rollers and flex hose.

Small machines, such as CNC
template makers and Weinig
tool measuring systems.



Effective August 1, 2011
US1711

17th Edition



What's in a Name?

For decades, the name Weinig has been synonymous with superior quality. Weinig customers have access to service and technological prowess 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

Michael Weinig Inc. began American operations in 1976 as a wholly owned subsidiary of Michael Weinig AG, founded in 1905 and headquartered in Tauberbischofsheim, Germany. World market leader for each of its products, the Weinig Group specializes primarily in marketing moulders, planers, tool grinders, tooling, rip saws, optimizing crosscut saws, fingerjointing machines and material-handling equipment. In 2010, Weinig purchased Holz-Her, which expanded our range of products to include CNC machining centers, edge banders, CNC beam saws, vertical panel saws, and sanders.

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.

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."



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To place an order

Phone: 1-877-548-0929

Fax: 1-704-799-7400

Email: partsales@weinigusa.com



Due to the volatility of foreign exchange rates and petroleum prices, Weinig reserves the right to change prices without prior notice. Please check our Website or call for the most current prices.

PowerLock is Weinig's new word for moulder tooling with Hollow Taper Shank (HSK) locking. Used initially in the metal-working 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. PowerLock tooling is suitable for cutting conditions ranging from heavy-duty to high-speed machining. And it offers the lowest weight for the most tool-holder.

PowerLock tooling is available in most styles of tooling currently used for conventional moulding production. As you will see in this catalog, PowerLock tooling available from Weinig stock includes:

- Corrugated cutters (pages 4-5)
- Insert planerheads (pages 6-7)
- 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.

If you want the finish quality available from PowerLock tooling, you can get it from Weinig.

PowerLock Cutterhead Type 538 (2 Knife Slots)



TOOL DIAMETER 90MM

ARTICLE NUMBER	WIDTH		NUMBER OF KNIFE SLOTS	CUTTING ANGLE	SPINDLE USE	PRICE U.S. \$
	MM	INCHES				
538-098-31	40	1 9/16	2	20°	L/B	384.00
538-090-21	60	2 23/64	2	20°	L/B	414.00
538-090-22	80	3 9/64	2	20°	L/B	438.00
538-090-23	100	3 15/16	2	20°	L/B	472.00
538-090-24	130	5 1/8	2	20°	L/B	516.00
538-090-26	170	6 11/16	2	20°	L/B	586.00
538-090-29	210	8 17/64	2	20°	Bottom	652.00
538-090-27	240	9 29/64	2	20°	Bottom	704.00
538-098-34	310	12 13/64	2	20°	Bottom	974.00
538-098-32	40	1 9/16	2	20°	R/T	384.00
538-090-31	60	2 23/64	2	20°	R/T	414.00
538-090-32	80	3 9/64	2	20°	R/T	438.00
538-090-33	100	3 15/16	2	20°	R/T	472.00
538-090-34	130	5 1/8	2	20°	R/T	516.00
538-090-36	170	6 11/16	2	20°	R/T	586.00
538-090-39	210	8 17/64	2	20°	Top	652.00
538-090-37	240	9 29/64	2	20°	Top	704.00
538-098-35	310	12 13/64	2	20°	Top	974.00
538-090-41	60	2 23/64	2	12°	L/B	414.00
538-090-42	80	3 9/64	2	12°	L/B	438.00
538-090-43	100	3 15/16	2	12°	L/B	472.00
538-090-44	130	5 1/8	2	12°	L/B	516.00
538-090-46	170	6 11/16	2	12°	L/B	586.00
538-090-49	210	8 17/64	2	12°	Bottom	652.00
538-090-47	240	9 29/64	2	12°	Bottom	704.00
538-098-13	310	12 13/64	2	12°	Bottom	974.00
538-090-51	60	2 23/64	2	12°	R/T	414.00
538-090-52	80	3 9/64	2	12°	R/T	438.00
538-090-53	100	3 15/16	2	12°	R/T	472.00
538-090-54	130	5 1/8	2	12°	R/T	516.00
538-090-56	170	6 11/16	2	12°	R/T	586.00
538-090-59	210	8 17/64	2	12°	Top	652.00
538-090-57	240	9 29/64	2	12°	Top	704.00
538-098-18	310	12 13/64	2	12°	Top	974.00

- Standard cutting angle 20°, 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
- For exclusive use on Weinig Powermat Moulders
- Rated for operation up to 12,000 rpm on tools up to 240mm, 8,000 rpm on tools over 240mm
- Designed for Weinig Axial Constant Setup System

Visit Our Website:
www.weinigusa.com

**2% discount on
 online orders**

SIZES SHOWN ARE AVAILABLE FROM STOCK.

PowerLock Cutterhead Type 538 (3 and 4 Knife Slots) 4 | 5

TOOL DIAMETER 90MM

ARTICLE NUMBER	WIDTH		NUMBER OF KNIFE SLOTS	CUTTING ANGLE	SPINDLE USE	PRICE U.S. \$
	MM	INCHES				
538-099-05	60	2 23/64	3	20°	L/B	505.00
538-098-71	100	3 15/16	3	20°	L/B	597.00
538-098-95	150	5 29/32	3	20°	L/B	677.00
538-098-97	210	8 17/64	3	20°	L/B	819.00
538-098-78	240	9 29/64	3	20°	L/B	952.00
538-099-06	60	2 23/64	3	20°	R/T	505.00
538-098-70	100	3 15/16	3	20°	R/T	597.00
538-098-96	150	5 29/32	3	20°	R/T	677.00
538-098-98	210	8 17/64	3	20°	R/T	819.00
538-098-77	240	9 29/64	3	20°	R/T	952.00
538-096-21	60	2 23/64	4	20°	L/B	532.00
538-096-22	80	3 9/64	4	20°	L/B	590.00
538-096-23	100	3 15/16	4	20°	L/B	652.00
538-096-24	130	5 1/8	4	20°	L/B	732.00
538-096-26	170	6 11/16	4	20°	L/B	874.00
538-096-29	210	8 17/64	4	20°	Bottom	1013.00
538-096-27	240	9 29/64	4	20°	Bottom	1042.00
538-096-31	60	2 23/64	4	20°	R/T	532.00
538-096-32	80	3 9/64	4	20°	R/T	590.00
538-096-33	100	3 15/16	4	20°	R/T	652.00
538-096-34	130	5 1/8	4	20°	R/T	732.00
538-096-36	170	6 11/16	4	20°	R/T	874.00
538-096-39	210	8 17/64	4	20°	Top	1013.00
538-096-37	240	9 29/64	4	20°	Top	1042.00
538-096-61	60	2 23/64	4	12°	L/B	532.00
538-096-63	100	3 15/16	4	12°	L/B	652.00
538-096-66	170	6 11/16	4	12°	L/B	874.00
538-096-69	210	8 17/64	4	12°	Bottom	1013.00
538-096-67	240	9 29/64	4	12°	Bottom	1042.00
538-096-71	60	2 23/64	4	12°	R/T	532.00
538-096-73	100	3 15/16	4	12°	R/T	652.00
538-096-76	170	6 11/16	4	12°	R/T	874.00
538-096-79	210	8 17/64	4	12°	Top	1013.00
538-096-77	240	9 29/64	4	12°	Top	1042.00



- 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 10,000 rpm
- Designed for Weinig's Axial Constant Setup System
- 6-knife cutterheads also available

SIZES SHOWN ARE AVAILABLE FROM STOCK.

Be receptive to new technology.

PowerLock Spiral Planerheads



TOOL DIAMETER 100MM

ARTICLE NUMBER	WIDTH		SPINDLE USE	NUMBER OF INSERTS	PRICE U.S. \$
	MM	INCHES			
XXX64023	115	4 33/64	L/B	18	1066.00
XXX64026	170	6 11/16	L/B	26	1370.00
XXX64027	240	9 29/64	Bottom	38	1670.00
XXX640282	325	12 51/64	Bottom	50	2272.00
XXX64033	115	4 33/64	R/T	18	1066.00
XXX64036	170	6 11/16	R/T	26	1370.00
XXX64037	240	9 29/64	Top	38	1670.00
XXX640382	325	12 51/64	Top	50	2272.00

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	\$3.00
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Replacement Screws for Insert Knives

XXX637105	\$3.25
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- Similar in design to standard spiral planerheads shown on page 18, 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

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
- 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 wood surface.

IMPORTANT NOTE:

Do not mismatch replacement carbide insert knives. All knives must be from the same supplier, in order not to affect balance.

PowerLock Helical Planerheads

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 constructed in PowerLock or conventional tooling
- Can be jointed to attain a multi-knife finish

ARTICLE NUMBER	DESCRIPTION	WIDTH		SPINDLE USE	PRICE U.S. \$
		MM	INCHES		
XXX640631	PowerLock Helical	75	2 61/64	L/B	1277.00
XXX640651	PowerLock Helical	115	4 17/32	L/B	1482.00
XXX64067	PowerLock Helical	170	6 11/16	L/B	1968.00
XXX64069	PowerLock Helical	235	9 1/4	Bottom	2787.00
XXX64073	PowerLock Helical	75	2 61/64	R/T	1277.00
XXX64075	PowerLock Helical	115	4 17/32	R/T	1482.00
XXX64077	PowerLock Helical	170	6 11/16	R/T	1968.00
XXX64079	PowerLock Helical	235	9 1/4	Top	2787.00

Each cutterhead includes a full set of installed carbide inserts.

All cutterheads 100mm OD.

Replacement Knives Standard 5° Grind

ARTICLE NUMBER	DIMENSIONS	SPINDLE USE	PRICE U.S. \$
	MM		
XXX642075R	75	L/B/R/T	87.00
XXX642115R	115	L/B/R/T	133.00
XXX642170L	170	L/B	196.00
XXX642170R	170	R/T	196.00
XXX642235L	235	Bottom	269.00
XXX642235R	235	Top	269.00

Optional 15° replacement knives available for use with softwoods.

Special knife rest for grinding helical planerheads

- For use on most Weinig Rondamat Grinders

930-013024HEL \$55.00

Replaceable carbide for use with standard knife rest 930-013024, as shown on page 43.



NOTE: You can download instructions for insert tooling knife replacement and grinding from our Website at www.weinigusa.com. Go to <http://www.weinigusa.com/toolingdocs/> and click on "Helicarb Blade Replacement – PDF" or "Helicarb Grinding – PDF."

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PowerLock Custom Profile Insert Tooling System

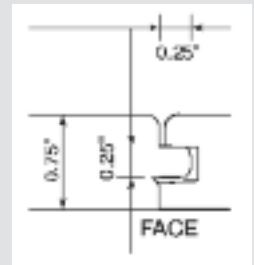


This new insert tooling system from Weinig is the answer for woodworking businesses that require an economic tooling solution for the production of small precision profiles. This new system offers the following advantages:

- Eliminates the requirement for a dedicated tool body. Multiple profiles using inserts can now be accomplished with the same tool body.
- New design provides the industry's most positive locking and locating system for insert knives.

Profile Insert Tool Body

ARTICLE NUMBER	KNIVES PER TOOL BODY	SPINDLE USE	PRICE U.S. \$ PER BODY
XXX66435	2	L/B	985.00
XXX66535	2	R/T	985.00
XXX66635	3	L/B	1140.00
XXX66735	3	R/T	1140.00



- Similar in design to our standard profile tooling system shown on page 16, 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)
- Cutting circle: 185mm maximum; 135mm minimum

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

XXX662160	Straight knife backer only	\$41.00
XXX662150	Tongue profile backer only	\$41.00
XXX662150MB	Tongue microbevel backer only	\$41.00
XXX662173	Tongue centermatch backer only	\$41.00
XXX662183	Tongue V-panel backer only	\$41.00
XXX662155	Groove profile backer only	\$41.00
XXX662155MB	Groove microbevel backer only	\$41.00
XXX662171	Groove centermatch backer only	\$41.00
XXX662181	Groove V-panel backer only	\$41.00
XXX662131	Straight knife insert knife	\$21.20
XXX662100	Tongue profile insert knife	\$26.75
XXX662100MB	Tongue microbevel profile insert knife	\$26.00
XXX662172	Tongue centermatch profile insert knife	\$27.45
XXX662182	Tongue V-panel profile insert knife	\$34.70
XXX662105	Groove profile insert knife w/0.030" gap	\$30.75
XXX662115	Groove profile insert knife w/0.010" gap	\$30.75
XXX662120	Groove profile insert knife w/0.005" gap	\$30.75
XXX662115MB	Groove microbevel profile insert knife	\$30.05
XXX662170	Groove centermatch profile insert knife	\$31.50
XXX662180	Groove V-panel profile insert knife	\$35.10

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

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

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



323-9169486K	1 1/2" x 100mm	\$720.00
323-037027K	1 1/2" x 170mm	\$790.00
323-027008K	1 1/2" x 240mm	\$850.00
323-9143774K	40mm x 100mm	\$720.00
323-03752	40mm x 170mm	\$790.00
323-02752	40mm x 240mm	\$850.00
323-9120151K	1 13/16" x 100mm	\$720.00
323-9114936K	1 13/16" x 170mm	\$790.00
323-027003K	1 13/16" x 240mm	\$850.00
323-027013K	1 13/16" x 247mm	\$850.00

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 Weing demo room.

TOOLCART-HSK63

\$1050.00



Stationary Tool Carousels

For storing PowerLock cutterheads and adapters in your grinding room. Includes load-bearing bottom plate, tool carousel, rubber gaskets, and wooden top mounting block.

TOOLCAROUSEL-HSK63

\$1750.00

For storing conventional and hydro-cutterheads in your grinding room. Includes load-bearing bottom plate, tool carousel, pegs complete with rubber tubing, and wooden top mounting block.

TOOLCAROUSEL-BORE

\$975.00



PowerLock Cutterhead Accessories



PowerLock Receiver Taper Cleaning Device

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

006-03226 \$51.00



PowerLock HSK Tool Taper Cleaning Device

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

006-03229 \$59.00



Gib Screw Torque Wrench

Preset at 23 ft/lbs, specifically for use on all Weing cutterheads.

XXX100428 \$220.00



Cutterhead Gib Screws

M12x20, for use with 6mm wrench

002-06944 \$0.75



PowerLock Knife Setting Gauge

For proper installation of corrugated knives, as shown on page 69.

507-330001 For 90mm OD tools \$44.00

507-330004 For 115mm OD tools \$37.00



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 \$790.00

Cutterhead Balance

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

Parallel Knife-slot Serrations

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

Bore Tolerance

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

Bore Concentricity

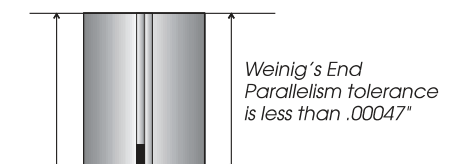
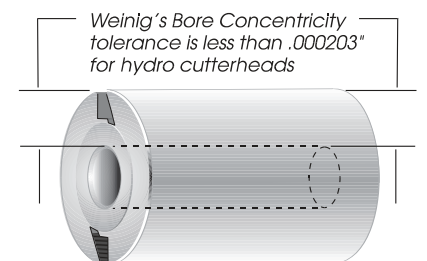
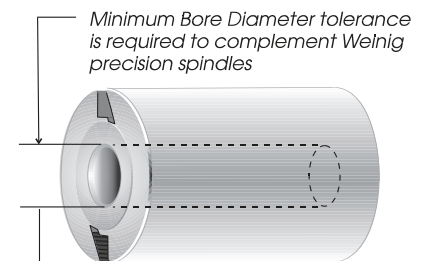
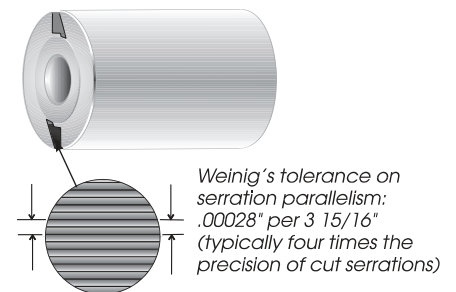
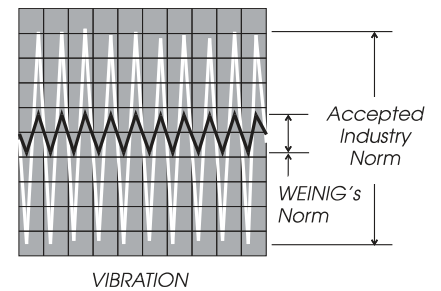
If the cutterhead bore is not concentric to the cutterhead body, product dimensional accuracy and surface finish suffer. Weinig hones the bore with two passes (not just one) for near perfect accuracy.

End Parallelism

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

The Highest Quality Materials

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



Hydro-Cutterhead Type 504

Hydraulic Clamping



TOOL DIAMETER 150MM (5 29/32")

ARTICLE NUMBER	WIDTH		NUMBER OF KNIFE SLOTS	CUTTING ANGLE	BORE DIAMETER	PRICE U.S. \$
	MM	INCHES				
504-150-83	60	2 23/64	4	20°	1 13/16"	556.00
504-150-02	100	3 15/16	4	20°	1 13/16"	696.00
504-150-08	150	5 29/32	4	20°	1 13/16"	740.00
504-150-11	230	9 1/16	4	20°	1 13/16"	918.00
514-150-89	240	9 29/64	4	20°	1 13/16"	1154.00
504-150-17	310	12 13/64	4	20°	1 13/16"	1336.00
514-151-74	330	13	4	20°	1 13/16"	1608.00
514-151-84	330	13	2/2	12°/20°	1 13/16"	1880.00
504-150-84	60	2 23/64	4	20°	2 1/8"	556.00
504-150-03	100	3 15/16	4	20°	2 1/8"	696.00
504-150-09	150	5 29/32	4	20°	2 1/8"	740.00
504-150-12	230	9 1/16	4	20°	2 1/8"	918.00
514-150-63	240	9 29/64	4	20°	2 1/8"	1154.00
504-150-18	310	12 13/64	4	20°	2 1/8"	1336.00
514-150-21	60	2 23/64	4	12°	1 13/16"	556.00
504-150-38	100	3 15/16	4	12°	1 13/16"	696.00
504-150-44	150	5 29/32	4	12°	1 13/16"	740.00
504-150-47	230	9 1/16	4	12°	1 13/16"	918.00
514-150-78	240	9 29/64	4	12°	1 13/16"	1154.00
514-150-39	60	2 23/64	4	12°	2 1/8"	556.00
504-150-39	100	3 15/16	4	12°	2 1/8"	696.00
504-150-45	150	5 29/32	4	12°	2 1/8"	740.00
504-150-48	230	9 1/16	4	12°	2 1/8"	918.00
514-150-67	240	9 29/64	4	12°	2 1/8"	1154.00
504-150-86	60	2 23/64	6	20°	1 13/16"	638.00
504-150-20	100	3 15/16	6	20°	1 13/16"	740.00
504-150-26	150	5 29/32	6	20°	1 13/16"	874.00
504-150-29	230	9 1/16	6	20°	1 13/16"	1152.00
514-150-75	240	9 29/64	6	20°	1 13/16"	1228.00

- 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 8,000 rpm
- 8-24 knife cutterheads also available

SIZES SHOWN ARE AVAILABLE FROM STOCK.

Other dimensions available upon request.

See Weinig Cutterhead Quality Assurance Guarantee on page 11.

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 online orders**

TOOL DIAMETER 150MM (5 29/32")

ARTICLE NUMBER	WIDTH		NUMBER OF KNIFE SLOTS	CUTTING ANGLE	BORE DIAMETER	PRICE U.S. \$
	MM	INCHES				
504-150-87	60	2 23/64	6	20°	2 1/8"	638.00
504-150-21	100	3 15/16	6	20°	2 1/8"	740.00
504-150-27	150	5 29/32	6	20°	2 1/8"	874.00
504-150-30	230	9 1/16	6	20°	2 1/8"	1152.00
514-150-64	240	9 29/64	6	20°	2 1/8"	1228.00
514-150-22	60	2 23/64	6	12°	1 13/16"	638.00
504-150-56	100	3 15/16	6	12°	1 13/16"	740.00
504-150-62	150	5 29/32	6	12°	1 13/16"	874.00
504-150-65	230	9 1/16	6	12°	1 13/16"	1152.00
514-150-85	240	9 29/64	6	12°	1 13/16"	1228.00
514-150-30	60	2 23/64	6	12°	2 1/8"	638.00
504-150-57	100	3 15/16	6	12°	2 1/8"	740.00
504-150-63	150	5 29/32	6	12°	2 1/8"	874.00
504-150-66	230	9 1/16	6	12°	2 1/8"	1152.00
514-150-68	240	9 29/64	6	12°	2 1/8"	1228.00

SIZES SHOWN ARE AVAILABLE FROM STOCK.

Other dimensions available upon request.

See Weinig Cutterhead Quality Assurance Guarantee on page 11.

Gib Screw Torque Wrench

Preset at 23 ft/lbs, specifically for use on all Weinig cutterheads.

XXX100428 \$220.00



Cutterhead Gib Screws

M12x20, for use with 6mm wrench

002-06944 \$0.75



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Conventional Cutterhead Type 503

Straight Bore



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

ARTICLE NUMBER	WIDTH		NUMBER OF KNIFE SLOTS	CUTTING ANGLE	BORE DIAMETER	PRICE U.S. \$
	MM	INCHES				
503-122-48*	60	2 23/64	2	20°	1 1/2 "	206.00
503-122-54*	100	3 15/16	2	20°	1 1/2 "	268.00
503-122-57*	130	5 1/8	2	20°	1 1/2 "	296.00
513-123-20*	170	6 11/16	2	20°	1 1/2 "	366.00
513-123-26*	210	8 1/4	2	20°	1 1/2 "	396.00
503-122-66*	230	9 1/16	2	20°	1 1/2 "	412.00
513-123-03*	240	9 29/64	2	20°	1 1/2 "	438.00
513-122-92*	60	2 23/64	2	12°	1 1/2 "	206.00
513-122-93*	100	3 15/16	2	12°	1 1/2 "	268.00
513-122-94*	130	5 1/8	2	12°	1 1/2 "	296.00
513-123-21	170	6 11/16	2	12°	1 1/2 "	366.00
513-123-25	210	8 1/4	2	12°	1 1/2 "	396.00
513-122-97*	230	9 1/16	2	12°	1 1/2 "	412.00
513-122-98*	240	9 29/64	2	12°	1 1/2 "	438.00
503-122-03	60	2 23/64	4	20°	1 1/2 "	254.00
503-122-06	100	3 15/16	4	20°	1 1/2 "	302.00
513-122-38	170	6 11/16	4	20°	1 1/2 "	418.00
503-122-18	230	9 1/16	4	20°	1 1/2 "	598.00
503-122-78	240	9 29/64	4	20°	1 1/2 "	622.00
503-122-21	60	2 23/64	4	12°	1 1/2 "	254.00
503-122-24	100	3 15/16	4	12°	1 1/2 "	302.00
503-122-30	150	5 29/32	4	12°	1 1/2 "	418.00
503-122-36	230	9 1/16	4	12°	1 1/2 "	598.00
513-122-73	240	9 29/64	4	12°	1 1/2 "	622.00
503-137-02	60	2 23/64	4	20°	1 13/16 "	314.00
503-137-05	100	3 15/16	4	20°	1 13/16 "	386.00
503-137-08	130	5 1/8	4	20°	1 13/16 "	404.00
513-137-39	170	6 11/16	4	20°	1 13/16 "	528.00
503-137-17	230	9 1/16	4	20°	1 13/16 "	640.00
503-137-86	240	9 29/64	4	20°	1 13/16 "	670.00

* DENOTES METRIC BORE CUTTERHEADS ALSO AVAILABLE FROM STOCK.

SIZES SHOWN ARE AVAILABLE FROM STOCK.

Other dimensions available upon request.

See Weinig Cutterhead Quality Assurance Guarantee on page 11.

Do not use larger cutterheads than necessary for the job.

Straight 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 U.S. \$
	MM	INCHES				
503-137-44	60	2 23/64	4	12°	1 13/16"	314.00
503-137-47	100	3 15/16	4	12°	1 13/16"	386.00
503-137-50	130	5 1/8	4	12°	1 13/16"	404.00
513-137-74	170	6 11/16	4	12°	1 13/16"	528.00
503-137-59	230	9 1/16	4	12°	1 13/16"	640.00
513-137-51	240	9 29/64	4	12°	1 13/16"	670.00

DUAL-ANGLE CUTTERHEAD TYPE 513

One cutterhead does both hardwoods and softwoods by offering 12° and 20° cutting angles.

TYPE 513

Straight-bore cutterheads with two knives at 20° cutting angle, or with two knives at 12° cutting angle. Otherwise, similar to type 503, as shown above.

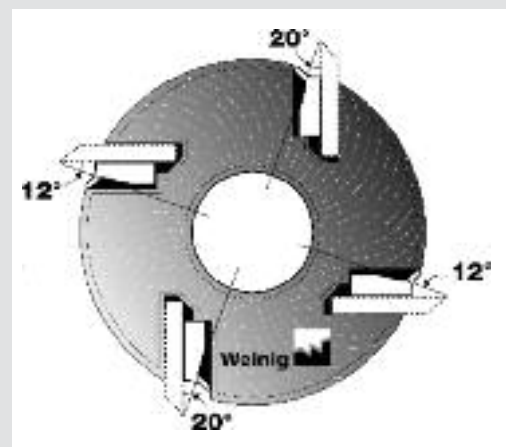
TOOL DIAMETER 122MM (4 13/16") ON CUTTERHEADS WITH 1 1/2" BORE TOOL DIAMETER 137MM (5 13/32") ON CUTTERHEADS WITH 1 13/16" BORE

ARTICLE NUMBER	WIDTH		NUMBER OF KNIFE SLOTS	CUTTING ANGLE	BORE DIAMETER	PRICE U.S. \$
	MM	INCHES				
513-122-22*	60	2 23/64	2/2	12/20°	1 1/2 "	282.00
513-122-23*	100	3 15/16	2/2	12/20°	1 1/2 "	326.00
513-122-24*	150	5 29/32	2/2	12/20°	1 1/2 "	442.00
513-122-25*	230	9 1/16	2/2	12/20°	1 1/2 "	608.00
513-122-74*	240	9 29/64	2/2	12/20°	1 1/2 "	624.00
513-137-26	60	2 23/64	2/2	12/20°	1 13/16 "	354.00
513-137-27	100	3 15/16	2/2	12/20°	1 13/16 "	412.00
513-137-28	150	5 29/32	2/2	12/20°	1 13/16 "	528.00
513-137-29	230	9 1/16	2/2	12/20°	1 13/16 "	700.00
513-137-30	240	9 29/64	2/2	12/20°	1 13/16 "	716.00

* DENOTES METRIC BORE CUTTERHEADS ALSO AVAILABLE FROM STOCK.

SIZES SHOWN ARE AVAILABLE FROM STOCK.

Other dimensions available upon request.



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Custom Profile Insert Tooling System

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

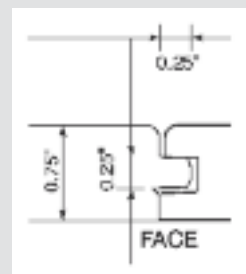
This new insert tooling system from Weinig is the answer for woodworking businesses that require an economic tooling solution for the production of small precision profiles. This new system offers the following advantages:

- Eliminates the requirement for a dedicated tool body. Multiple profiles using inserts can now be accomplished with the same tool body.
- New design provides the industry's most positive locking and locating system for insert knives.



Profile Insert Tool Body

ARTICLE NUMBER	KNIVES PER TOOL BODY	BORE DIAMETER	PRICE U.S. \$ PER BODY
XXX662312	2	1 1/2"	480.00
XXX662314	2	40mm	480.00
XXX662315	3	1 1/2"	635.00
XXX662316	3	1 13/16"	635.00



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

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

XXX662160	Straight knife backer only	\$41.00
XXX662150	Tongue profile backer only	\$41.00
XXX662150MB	Tongue microbevel backer only	\$41.00
XXX662173	Tongue centermatch backer only	\$41.00
XXX662183	Tongue V-panel backer only	\$41.00
XXX662155	Groove profile backer only	\$41.00
XXX662155MB	Groove microbevel backer only	\$41.00
XXX662171	Groove centermatch backer only	\$41.00
XXX662181	Groove V-panel backer only	\$41.00
XXX662131	Straight knife insert knife	\$21.20
XXX662100	Tongue profile insert knife	\$26.75
XXX662100MB	Tongue microbevel profile insert knife	\$26.00
XXX662172	Tongue centermatch profile insert knife	\$27.45
XXX662182	Tongue V-panel profile insert knife	\$34.70
XXX662105	Groove profile insert knife w/0.030" gap	\$30.75
XXX662115	Groove profile insert knife w/0.010" gap	\$30.75
XXX662120	Groove profile insert knife w/0.005" gap	\$30.75
XXX662115MB	Groove microbevel profile insert knife	\$30.05
XXX662170	Groove centermatch profile insert knife	\$31.50
XXX662180	Groove V-panel profile insert knife	\$35.10

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

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

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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.

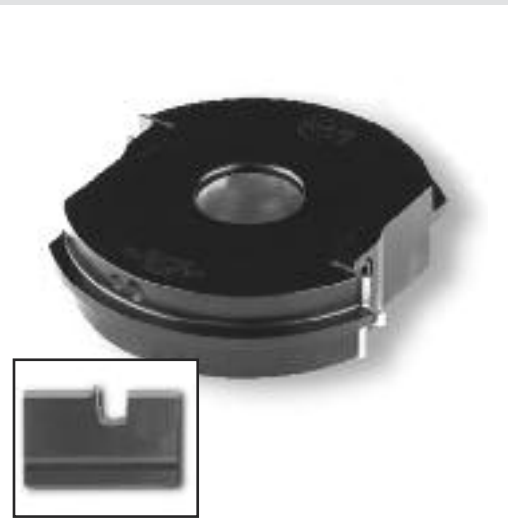


Tongue-and-Groove Cutter Insert (Old Style)

NOTE: The standard old-style insert knives still available from stock are for the 3/4" pattern as shown on page 8. 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 (top photo)

XXX6581001	Tongue profile	\$26.10
XXX6581051	Special groove profile with 0.030" gap	\$29.40
XXX6581151	Special groove profile with 0.010" gap	\$29.40
XXX6581201	Special groove profile with 0.005" gap	\$29.40



Replacement Carbide Insert Profile Knives For Old Style #650015 and #650046, as shown (bottom photo)

XXX658100	Tongue profile	\$44.00
XXX658105	Special groove profile with 0.030" gap	\$38.00
XXX658115	Special groove profile with 0.010" gap	\$38.00
XXX658120	Special groove profile with 0.005" gap	\$38.00



Spiral Cutterheads

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
- Less severe cutting action
- Less impact on spindle bearings
- 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 wood surface.
- Maximum speed of 10,000 rpm

**SIZES SHOWN ARE
AVAILABLE FROM STOCK.**

**CONFIRM APPROPRIATE
TOOL DIAMETER WHEN USING
WITH REBATE CUTTER.**

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

ARTICLE NUMBER	WIDTH		OUTSIDE DIAMETER MM	NUMBER OF INSERTS	BORE DIAMETER	PRICE U.S. \$
	MM	INCHES				
XXX630013	100	3 15/16	125	18	1 1/2"	560.00
XXX630019	170	6 11/16	125	28	1 1/2"	952.00
XXX630005	230	9 1/16	125	38	1 1/2"	1282.00
XXX630010	240	9 29/64	125	38	1 1/2"	1302.00
XXX630105	100	3 15/16	140	18	1 1/2"	560.00
XXX630110	130	5 1/8	140	22	1 1/2"	712.00
XXX630114	170	6 11/16	140	28	1 1/2"	952.00
XXX630120	230	9 1/16	140	38	1 1/2"	1282.00
XXX630125	240	9 29/64	140	38	1 1/2"	1302.00
XXX630205	100	3 15/16	140	18	1 13/16"	560.00
XXX630210	130	5 1/8	140	22	1 13/16"	712.00
XXX630214	170	6 11/16	140	28	1 13/16"	952.00
XXX630220	230	9 1/16	140	38	1 13/16"	1282.00
XXX630225	240	9 29/64	140	38	1 13/16"	1302.00

Replacement Carbide Insert Knives

XXX637100	15 x 15 x 2.5mm	\$3.00
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Replacement Screws for Insert Knives

XXX637105	\$3.25
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For Non-jointed Applications of Up to 200 FPM

Similar in characteristics to the spiral cutterheads shown on page 18, but with the following additional benefits:

- Mounted on a hydro sleeve for true running accuracy
- Higher feed speeds attainable
- No grinding required
- Maximum speed of 8,000 rpm

TOOL DIAMETER 160MM (6 19/64")

BORE DIAMETER 1 13/16", 2 1/8" OR 50MM

WIDTH		NUMBER OF EFFECTIVE KNIVES	TOTAL NUMBER OF INSERTS	PRICE U.S. \$
MM	INCHES			
60	2 23/64	4	16	589.00
100	3 15/16	4	28	814.00
130	5 1/8	4	36	996.00
150	5 29/32	4	40	1239.00
180	7 3/32	4	48	1492.00
230	9 1/16	4	64	1840.00
240	9 29/64	4	68	2053.00
310	12 13/64	4	88	2526.00
330	13	4	96	2603.00
60	2 23/64	6	24	707.00
100	3 15/16	6	42	1085.00
130	5 1/8	6	54	1414.00
150	5 29/32	6	60	1646.00
180	7 3/32	6	72	2102.00
230	9 1/16	6	96	2595.00
240	9 29/64	6	102	2760.00
310	12 13/64	6	132	3708.00



Each cutterhead includes a full set of installed inserts.

Delivery: Approximately 4 weeks

Replacement Carbide Insert Knives

XXX637100	15 x 15 x 2.5mm	\$3.00
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Replacement Screws for Insert Knives

XXX637105	\$3.25
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Helicarb Planerheads

For Moulders Using Conventional Tooling



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

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online orders**

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"
- Can be constructed in PowerLock or conventional tooling
- Hydro-cutterheads can be jointed to attain a multi-knife finish

STRAIGHT-BORE PLANERHEADS WITH 1 1/2", 40MM, 1 13/16" BORE HYDRO-PLANERHEADS WITH 1 13/16", 50MM, 2 1/8" BORE

WIDTH		NUMBER OF KNIFE SLOTS	STRAIGHT BORE PRICE U.S. \$	HYDRO BORE PRICE U.S. \$
MM	INCHES			
75	2 61/64	2	856.00	N/A
115	4 17/32	2	1221.00	N/A
170	6 11/16	2	1624.00	N/A
235	9 1/4	2	2339.00	N/A
75	2 61/64	3	1226.00	1860.00
115	4 17/32	3	1751.00	2386.00
170	6 11/16	3	2339.00	2973.00
235	9 1/4	3	2967.00	3707.00
75	2 61/64	4	N/A	2350.00
115	4 17/32	4	N/A	2696.00
170	6 11/16	4	N/A	3410.00
235	9 1/4	4	N/A	4300.00
75	2 61/64	6	N/A	2681.00
115	4 17/32	6	N/A	3046.00
170	6 11/16	6	N/A	3888.00
235	9 1/4	6	N/A	5208.00

NOTE: You can download instructions for insert tooling knife replacement and grinding from our Website at www.weinigusa.com. Go to <http://www.weinigusa.com/toolingdocs/> and click on "Helicarb Blade Replacement – PDF" or "Helicarb Grinding – PDF."

Replacement Knives for 135mm OD Heads Standard 5° Grind

ARTICLE NUMBER	DIMENSIONS	SPINDLE USE	PRICE U.S. \$
	MM		
XXX628075L	75	L/B	87.00
XXX628075R	75	R/T	87.00
XXX628115L	115	L/B	133.00
XXX628115R	115	R/T	133.00
XXX628170L	170	L/B	196.00
XXX628170R	170	R/T	196.00
XXX628235L	235	Bottom	269.00
XXX628235R	235	Top	269.00

Replacement Knives for 160mm OD Heads Standard 5° Grind

ARTICLE NUMBER	DIMENSIONS	SPINDLE USE	PRICE U.S. \$
	MM		
XXX627075L	75	L/B	87.00
XXX627075R	75	R/T	87.00
XXX627115L	115	L/B	133.00
XXX627115R	115	R/T	133.00
XXX627170L	170	L/B	196.00
XXX627170R	170	R/T	196.00
XXX627235L	235	Bottom	269.00
XXX627235R	235	Top	269.00

Optional 15° replacement knives available for use with softwoods

SHAPER CUTTERHEADS NEW FROM WEINIG!

Corrugated cutterheads for use on shapers

- Weinig precision
- Weinig expertise
- Weinig quality

TOOL DIAMETER: 100MM (3.94")

BORE DIAMETER: 1 1/4"

NUMBER OF KNIFE SLOTS: 4

FOR USE WITH 1/4" AND 5/16" THICK KNIFE STEEL ONLY

ARTICLE NUMBER	WIDTH		PRICE U.S. \$
	MM	INCHES	
503-100-040	40	1 9/16	141.00
503-100-060	60	2 23/64	204.00
503-100-100	100	3 15/16	345.00
503-100-130	130	5 1/8	446.00

SIZES SHOWN ARE AVAILABLE FROM STOCK.



Insert Planing Cutterhead Type 530 CentroLock

Featuring Full-length Reversible Insert Knives



Solid body construction for noise reduction and quiet running.

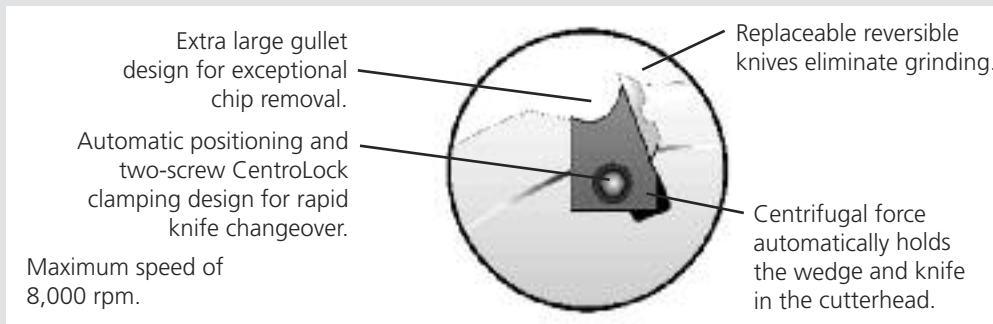
Each cutterhead comes equipped with a set of HSS knives.

SIZES SHOWN ARE AVAILABLE FROM STOCK.

Other dimensions available upon request.

PRICED PER INDIVIDUAL KNIFE.

Designed for exclusive use with Type 530 Cutterheads.



CentroLock 530 Cutterheads (Steel Body)

ARTICLE NUMBER	WIDTH		OUTSIDE DIAMETER MM	NUMBER OF INSERTS	BORE DIAMETER	PRICE U.S. \$
	MM	INCHES				
530-125-33	60	2 23/64	125	2	1 1/2"	376.00
530-125-39	100	3 15/16	125	2	1 1/2"	458.00
530-125-45	130	5 1/8	125	2	1 1/2"	512.00
530-125-42	170	6 11/16	125	2	1 1/2"	604.00
530-125-54	230	9 1/16	125	2	1 1/2"	668.00
530-125-67	240	9 29/64	125	2	1 1/2"	702.00
530-127-06	100	3 15/16	125	4	1 13/16"	796.00
530-127-07	230	9 1/16	125	4	1 13/16"	1196.00
530-140-24	240	9 29/64	140	4	1 13/16"	1456.00

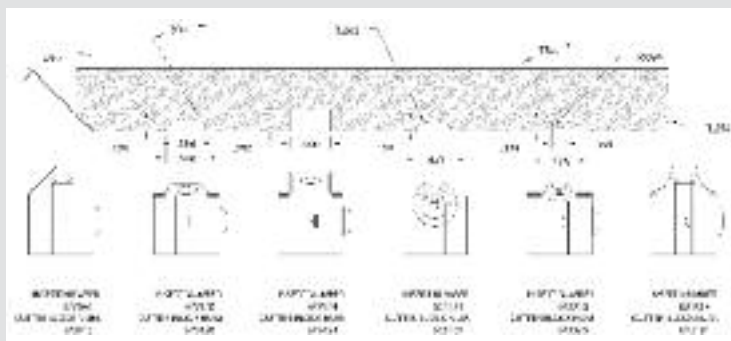
Special Aluminum Body Cutterhead

ARTICLE NUMBER	WIDTH		OUTSIDE DIAMETER MM	NUMBER OF INSERTS	BORE DIAMETER	PRICE U.S. \$
	MM	INCHES				
530-125-71	240	9 29/64	125	2	1 1/2"	886.00

Replacement Reversible Knives for CentroLock 530 Cutterheads

WIDTH		HSS KNIVES		CARBIDE KNIVES	
MM	INCHES	ARTICLE NUMBER	PRICE U.S. \$	ARTICLE NUMBER	PRICE U.S. \$
60	2 23/64	507-920060	4.85	507-921060	28.20
100	3 15/16	507-920100	8.10	507-921100	43.80
130	5 1/8	507-920130	8.50	507-921130	54.60
150	5 29/32	507-920150	9.90	507-921150	62.00
170	6 11/16	507-920170	11.25	507-921170	70.60
190	7 31/64	507-920190	12.55	507-921190	77.80
230	9 1/16	507-920230	15.20	507-921230	93.60
240	9 29/64	507-920240	15.90	507-921240	97.80
270	10 5/8	507-920270	17.85	507-921270	109.60

No grinder is required now to produce "S4S" material with radius or bevel corners, small grooves, backside relief cuts on flooring products, or even a limited number of small custom profiles. The CombiHead combines the versatility and cost effectiveness of movable insert profile knives in the same cutterhead with reversible carbide planer knives. Maximum speed of 8,000 rpm.



ARTICLE NUMBER	OVERALL WIDTH		USABLE PROFILE WIDTH (APPROX.)		OUTSIDE DIAMETER MM	NUMBER OF POCKETS	BORE DIAMETER INCHES	PRICE U.S. \$
	MM	INCHES	MM	INCHES				
XXX671251	100	3 15/16	70	2 3/4	125	2/2	1 1/2	1535.00
XXX671255	230	9 1/16	200	7 7/8	125	2/2	1 1/2	2079.00
XXX671405	230	9 1/16	200	7 7/8	140	2/2	1 13/16	2259.00

Replacement Carbide Insert Knives

XXX672100	Carbide planer knives 100mm	\$ 40.00
XXX672230	Carbide planer knives 230mm	\$ 67.00
XXX672014	Carbide 1/4" radius insert	\$ 24.90
XXX672018	Carbide 1/8" radius insert	\$ 25.60
XXX672025	Carbide bead insert	\$ 23.25
XXX672045	Carbide 45° bevel insert	\$ 24.90
XXX672128	Carbide flooring standard relief cut insert	\$ 23.40
XXX672129	Carbide flooring round relief cut insert	\$ 11.50
XXX672124	Carbide 1/4" x 1/2" groove insert	\$ 21.00

SIZES SHOWN ARE AVAILABLE FROM STOCK.

Each CombiHead includes a pair of carbide planer knives. Support blocks and profile inserts are additional.

Custom profile support blocks and insert knives available upon request.

Reusable Profile Support Blocks

XXX673184	Support block for radius insert	\$150.00
XXX673025	Support block for bead insert	\$150.00
XXX673045	Support block for bevel insert	\$150.00
XXX673128	Support block for standard relief cut insert	\$150.00
XXX673129	Support block for round relief cut insert	\$160.00
XXX673124	Support block for groove	\$150.00

Visit Our Website:
www.weinigusa.com

2% discount on online orders

Corrugated Back Knife Steel

NOW MADE IN THE USA!



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.

When you tie all of these properties together, and keep the manufacturing in the USA and under the quality control of Weing, you get an exceptional grade of steel at an exceptional price. Experience the same Weing quality – now for less!

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

The Weing 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	LIST PRICE U.S. \$
VEN700802	1 1/2 "	1/8 "	113.00
VEN700804	1 3/4 "	3/8 "	118.00
VEN700806	2 "	5/8 "	122.00
VEN700807	2 1/4 "	7/8 "	129.00
VEN700808	2 1/2 "	1 1/8 "	143.00
VEN700812	2 3/4 "	1 3/8 "	146.00

Weing M3+

HSS Knife Steel for Long or Short Runs

American-made M3+ steel not available until November 1

- Weing 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.
- Weing 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	LIST PRICE U.S. \$
VEN700002	1 1/2 "	1/8 "	96.00
VEN700004	1 3/4 "	3/8 "	101.00
VEN700006	2 "	5/8 "	105.00
VEN700008	2 1/4 "	7/8 "	108.00
VEN700010	2 1/2 "	1 1/8 "	112.00
VEN700012	2 3/4 "	1 3/8 "	121.00

VEN700013	3 "	1 5/8 "	127.00
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WARNING: This item is prohibited from use in Power-Lock cutterheads, due to insufficient clamping depth!

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	MAXIMUM PROFILE DEPTH	LIST PRICE U.S. \$
XXX700170	1 1/2"	1/4"	1/8"	66.00
XXX700172	1 3/4"	1/4"	3/8"	70.00
XXX700174	2"	1/4"	5/8"	80.00
XXX700176	2 1/4"	1/4"	7/8"	89.00
XXX700177	2 1/2"	1/4"	1 1/8"	99.00
XXX700270	1 1/2"	5/16"	1/8"	75.00
XXX700272	1 3/4"	5/16"	3/8"	83.00
XXX700274	2"	5/16"	5/8"	86.00
XXX700275	2 1/4"	5/16"	7/8"	99.00
XXX700276	2 1/2"	5/16"	1 1/8"	103.00
XXX700278	2 3/4"	5/16"	1 3/8"	106.00

- 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.

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	LIST PRICE U.S. \$
VEN700017	1 3/4"	3/8"	60.00
VEN700019	2"	5/8"	63.00
VEN700020	2 1/4"	7/8"	66.00
VEN700021	2 1/2"	1 1/8"	71.00
VEN700023	2 3/4"	1 3/8"	75.00

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.

XXX100701	Knife Steel Cut-off Wheel 14" x 0.110" x 1" Offers long wear life and excellent prevention of knife burning	\$15.25
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Corrugated Back Knife Steel and Accessories

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	LIST PRICE U.S. \$
VEN700702	1 1/2"	1/8"	182.00
VEN700704	1 3/4"	3/8"	184.00
VEN700706	2"	5/8"	185.00
VEN700708	2 1/4"	7/8"	208.00
VEN700712	2 1/2"	1 1/8"	217.00

ALSO AVAILABLE IN 1/4" THICKNESS

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



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

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

5/16" x 1 3/16" x 25"

507-301001 \$42.00

1/4" x 1 3/16" x 25"

507-301003 \$40.00

3/8" x 1 3/16" x 25"

507-301002 \$47.00

Ohaus Portable Electronic Balance Scale



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

2000g x 0.1g

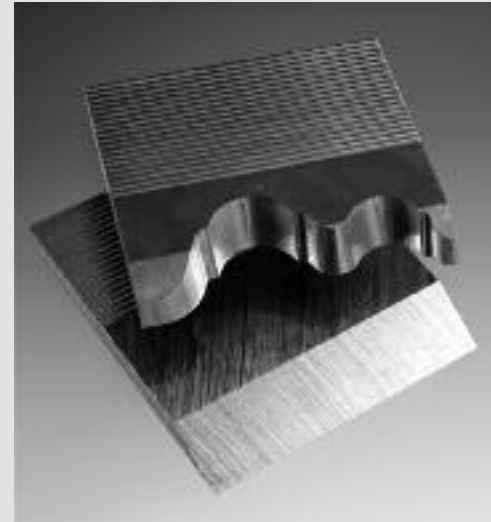
XXX100340 \$368.00

3 Reasons Why Weinig Knife Steel Is Better

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

Raw Material Quality

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



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

For longer runs or repetitive profiles in most species, Weinig offers M3+ high-speed steel. Increased levels of carbon and vanadium make Weinig M+ a tougher, more abrasion-resistant material than any standard M2 steel on the market today. Weinig SUPRE-18 knife steel offers increased resistance to heat, acids, and mineral streaks, and can deliver up to double the life of industry-standard knife steel in these applications. A new addition to the Weinig 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 Weinig Double Back +3 Carbide Knife System or TCT inlaid. On each, the finest material available for the specific grade of knife provides an exceptionally hard cutting edge.

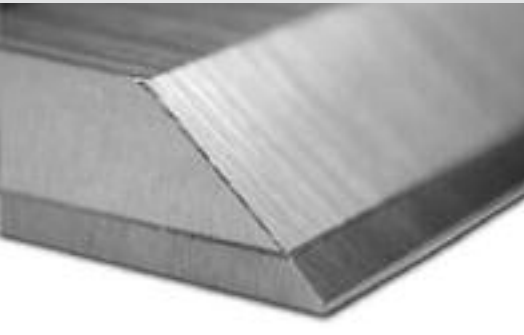
Precision-ground Corrugations

Have you ever cut pieces from a single bar of steel, balanced them, ground the profile, and then found that you had to balance the knives again? This problem is caused by inconsistent corrugations, and it won't happen with Weinig knife steel. Across the length of a standard 25" bar of Weinig knife steel, corrugation accuracy varies no more than .006". Weinig'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 Weinig knife steel.

Specialized Heat Treating

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

Carbide-tipped (TCT) Corrugated Back Knife Steel



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

ARTICLE NUMBER	WIDTH		WORKING LENGTH		MAXIMUM PROFILE DEPTH		PRICE U.S. \$
	INCHES	MM	INCHES	MM	INCHES	MM	
VEN700180	1 9/16	40	2 23/64	60	3/16	5	46.00
VEN700182	1 9/16	40	3 15/16	100	3/16	5	71.00
VEN700184	1 9/16	40	5 1/8	130	3/16	5	92.00
VEN700186	1 9/16	40	5 29/32	150	3/16	5	103.00
VEN700187	1 9/16	40	6 11/16	170	3/16	5	117.00
VEN700188	1 9/16	40	7 3/32	180	3/16	5	124.00
VEN700190	1 9/16	40	9 1/16	230	3/16	5	154.00
VEN700191	1 9/16	40	9 29/64	240	3/16	5	165.00
VEN7001915	1 9/16	40	12 13/64	310	3/16	5	213.00
VEN700192	1 9/16	40	25	635	3/16	5	438.00
VEN700026	2	50	2 23/64	60	1/2	13	53.00
VEN700027	2	50	3 9/64	80	1/2	13	66.00
VEN700028	2	50	3 15/16	100	1/2	13	81.00
VEN700030	2	50	5 1/8	130	1/2	13	106.00
VEN700032	2	50	5 29/32	150	1/2	13	118.00
VEN700033	2	50	6 11/16	170	1/2	13	133.00
VEN700034	2	50	7 3/32	180	1/2	13	143.00
VEN700036	2	50	9 1/16	230	1/2	13	175.00
VEN7000372	2	50	9 29/64	240	1/2	13	181.00
VEN7000375	2	50	12 13/64	310	1/2	13	244.00
VEN700037	2	50	25	635	1/2	13	479.00
VEN700038	2 3/8	60	2 23/64	60	11/16	18	63.00
VEN700039	2 3/8	60	3 9/64	80	11/16	18	78.00
VEN700040	2 3/8	60	3 15/16	100	11/16	18	96.00
VEN700042	2 3/8	60	5 1/8	130	11/16	18	126.00
VEN700044	2 3/8	60	5 29/32	150	11/16	18	139.00
VEN700045	2 3/8	60	6 11/16	170	11/16	18	148.00
VEN700046	2 3/8	60	7 3/32	180	11/16	18	164.00
VEN700048	2 3/8	60	9 1/16	230	11/16	18	200.00
VEN700049	2 3/8	60	25	635	11/16	18	549.00

- 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.

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www.weinigusa.com

**2% discount on
online orders**

The Weinig Double-Back™ carbide knife system is the industry leader in high-production planing and molding of abrasive materials. With the introduction of the Weinig Double-Back +3™, our carbide knife system became even better. A modification in the system's micro-corrugations provides three additional knife movements, making available a total of nine knife movements.

COMPETITIVE ADVANTAGES

Grade of Carbide

The Weinig system provides approximately 30% more run time between regrinds than competitive systems using a standard C3 grade. This special-design carbide knife is furnished with a "mirror grind" on the cutting-edge side, which combined with the micrograin structure, provides a cutting edge that rivals the sharpness of top-quality, high-speed steel.

Precision Grind

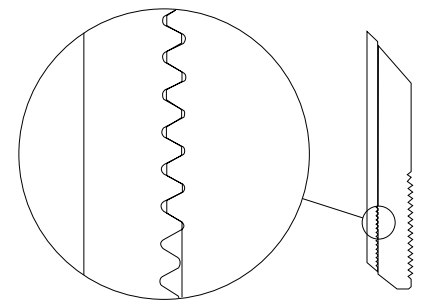
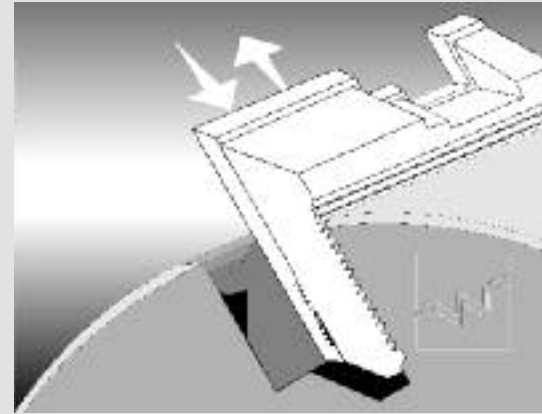
The Weinig Double-Back system is built to exacting ISO 9001 standards. The extreme accuracy employed during the grinding process on Weinig's micro-corrugations and mating surfaces results in a carbide knife and backing piece matched with near-perfect precision. Competitive systems do not have this precision grind, and that causes a tendency toward excessive movement between the two pieces. This movement – or "slop" – contributes to poor product-finish quality and unnecessary knife breakage.

Safety Design

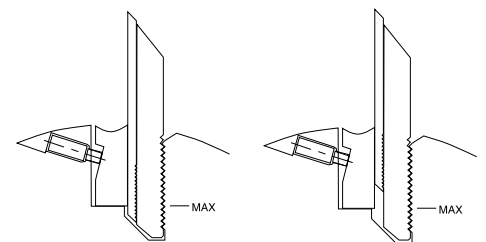
The steel backing plate of the Weinig Double-Back system is designed to prevent radial movement in the cutterhead and provide sufficient support for the carbide knife. Other systems do not provide this safety feature and, without proper clamping support, that makes unsafe knife movement possible. Movement of any part of the knife (carbide and/or backer plate) beyond the maximum adjustment line marked on the cutterhead allows knife-flex during operation. This knife-flex not only adversely affects finish quality but can contribute to breakage and a potentially dangerous situation.

Operating Speed

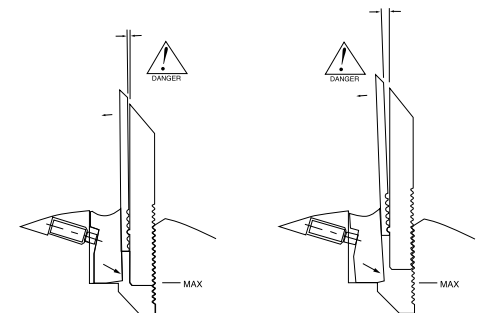
The Weinig Double-Back system has been modified to safely operate at speeds up to 12,000 rpm. Because of the extreme amount of centrifugal force generated at these speeds, many of the competitive systems are not certified for operation at 12,000 rpm. Failure to use properly certified knives can create spindle failure, in addition to poor product-finish.



No knife movement can occur with near-perfect precision grind of micro-corrugations.

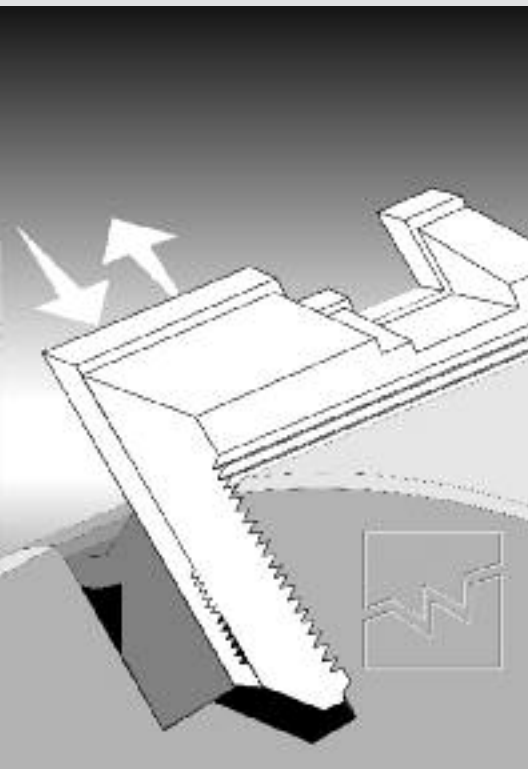


Proper knife support always maintained, permitting no knife movement during production.



Knife breakage and poor finish quality can result from lack of safety design in other systems.

Weinig Double-Back +3™ Carbide Knife System



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 U.S. \$
	INCHES	MM	INCHES	MM	INCHES	MM	
VEN700430	1 1/2	38	1 9/16	40	Planing only		79.00
VEN700431	1 1/2	38	2 23/64	60	Planing only		96.00
VEN700432	1 1/2	38	3 9/64	80	Planing only		126.00
VEN700433	1 1/2	38	3 15/16	100	Planing only		154.00
VEN700435	1 1/2	38	5 1/8	130	Planing only		190.00
VEN700437	1 1/2	38	5 29/32	150	Planing only		221.00
VEN700439	1 1/2	38	7 3/32	180	Planing only		267.00
VEN700441	1 1/2	38	9 1/16	230	Planing only		341.00
VEN700450	2	50	1 9/16	40	7/16	11	91.00
VEN700451	2	50	2 23/64	60	7/16	11	103.00
VEN700452	2	50	3 9/64	80	7/16	11	137.00
VEN700453	2	50	3 15/16	100	7/16	11	164.00
VEN700455	2	50	5 1/8	130	7/16	11	213.00
VEN700457	2	50	5 29/32	150	7/16	11	250.00
VEN700459	2	50	7 3/32	180	7/16	11	305.00
VEN700461	2	50	9 29/64	240	7/16	11	384.00
VEN700470	2 3/8	60	1 9/16	40	3/4	20	100.00
VEN700471	2 3/8	60	2 23/64	60	3/4	20	126.00
VEN700472	2 3/8	60	3 9/64	80	3/4	20	159.00
VEN700473	2 3/8	60	3 15/16	100	3/4	20	201.00
VEN700475	2 3/8	60	5 1/8	130	3/4	20	245.00
VEN700477	2 3/8	60	5 29/32	150	3/4	20	290.00
VEN700479	2 3/8	60	7 3/32	180	3/4	20	348.00

Double-Back Filler Strip

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

VEN700109

\$29.50

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 contains a special bond designed to hold form longer against the hardness of carbide.

Listed on page 50.

SOLID TUNGSTEN CARBIDE BLANK KNIFE ONLY

ARTICLE NUMBER	WIDTH		WORKING LENGTH		PRICE U.S. \$
	INCHES	MM	INCHES	MM	
VEN700530	1 1/2	38	1 9/16	40	47.00
VEN700531	1 1/2	38	2 23/64	60	59.00
VEN700532	1 1/2	38	3 9/64	80	84.00
VEN700533	1 1/2	38	3 15/16	100	101.00
VEN700535	1 1/2	38	5 1/8	130	132.00
VEN700537	1 1/2	38	5 29/32	150	149.00
VEN700539	1 1/2	38	7 3/32	180	185.00
VEN700541	1 1/2	38	9 1/16	230	285.00
VEN7005411	1 1/2	38	9 29/64	240	285.00
VEN700550	2	50	1 9/16	40	53.00
VEN700551	2	50	2 23/64	60	65.00
VEN700552	2	50	3 9/64	80	83.00
VEN700553	2	50	3 15/16	100	106.00
VEN700555	2	50	5 1/8	130	145.00
VEN700557	2	50	5 29/32	150	171.00
VEN700559	2	50	7 3/32	180	213.00
VEN700561	2	50	9 29/64	240	274.00
VEN700570	2 3/8	60	1 29/64	40	61.00
VEN700571	2 3/8	60	2 23/64	60	82.00
VEN700572	2 3/8	60	3 9/64	80	101.00
VEN700573	2 3/8	60	3 15/16	100	136.00
VEN700575	2 3/8	60	5 1/8	130	171.00
VEN700577	2 3/8	60	5 29/32	150	204.00
VEN700579	2 3/8	60	7 3/32	180	251.00

SIZES SHOWN ARE AVAILABLE FROM STOCK.

Complete operating instructions are available at:

<http://www.weinigusa.com/toolingdocs/Double Back Grinding Instructions.pdf>

Visit Our Website:
www.weinigusa.com

**2% discount on
 online orders**

Do You Need Weinig's Custom Grinding Service?

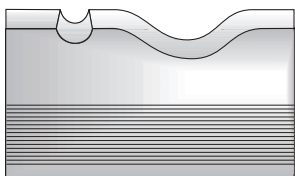
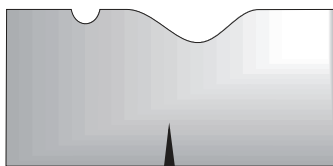
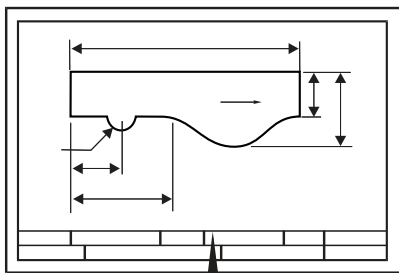
It's Something To Think About

If you thought you didn't need the Weinig Custom Grinding Service, we invite you to reconsider. Do you have a moulder or shaper, but no knife grinding capabilities? Or maybe you have a grinder but need help because of personnel shortages, seasonal work overloads, or special applications such as carbide knives or new profiles? Perhaps you already use a template-making service, but it lacks production experience on either moulders or grinders. Or maybe you need precision templates and/or knives to ensure exact product duplication. Even if none of this applies, you may still need Weinig's grinding and template-making service – for a new company startup or to assist inexperienced operators. Now that you've given it a second thought, shouldn't you consider using the Weinig Custom Grinding Service?

Featuring Precision Profile Knives and Templates Customized to Suit Your Needs

When it comes to customized, precision profile knives and templates, Weinig offers major advantages that may not be available anywhere else. These advantages include:

1. Product layout, template and knife production by Weinig technicians experienced in the operation of both moulders and grinders. In addition, we can recommend the proper knife steel for your application.
2. We use only Weinig corrugated knife steel, which has been proven to hold the cutting edge longer than comparable knife steels. We urge you to be cautious with offers of "cheaper" pricing, because this generally means that you are being quoted a lower grade of steel or that you will sacrifice precision and accuracy on the knife grind.
3. The woodworking industry is constantly changing, and new applications seem to appear every day. As the industry leader, Weinig can provide quicker answers and provide more effective solutions to your problems.
4. We guarantee our work 100%. Should there ever be a problem, we promise to correct it immediately and to your satisfaction.



Here's How the Service Works

- Send us a product sample or drawing.
- We will produce a precision dimensioned CAD drawing, which will be sent for your approval.
- When we receive your approval, Weinig will produce your templates and knives quickly and accurately, and in accordance with your time schedule requirement.
- Your made-to-order product layout, profile knives and templates will be shipped to you by two-day delivery or other method of your choice.
- When your knives need sharpening, you'll get the same thorough and timely service.

For more information, contact:
Weinig Grinding Service Department
Email: grinding@weinigusa.com
Grinding Service fax: 1-704-663-2468

Template Production

Profile template / Plexiglas™ Custom Profile	\$30.00
Profile template / Plexiglas™ Existing Profile	\$20.00
Profile template / steel	Price dependent upon profile
Profile template / Plexiglas™ when ordering knives	FREE

New Profile and Straight Knives

– Complete with finish grind, ready for production

Price Per Lineal Inch
(Calculated to nearest 1/2")

SRS profile knife (up to and including 2" width)	\$16.00
SRS profile knife (2 1/4" and 2 1/2" width)	\$18.00
SRS profile knife (2 3/4" width)	\$20.00
M2 1/4" HSS profile knife (up to and including 2" width)	\$16.50
M2 1/4" HSS profile knife (2 1/4" and 2 1/2" width)	\$18.50
M2 1/4" HSS straight knife (1 1/2" width)	\$ 7.00
M2 5/16" HSS profile knife (up to and including 2" width)	\$17.00
M2 5/16" HSS profile knife (2 1/4" and 2 1/2" width)	\$19.00
M2 5/16" HSS profile knife (2 3/4" width)	\$21.00
M2 5/16" HSS straight knife (1 1/2" width)	\$ 7.50
M3+ HSS profile knife (up to and including 2" width)	\$18.00
M3+ HSS profile knife (2 1/4" and 2 1/2" width)	\$20.00
M3+ HSS profile knife (2 3/4" width)	\$22.00
M3+ HSS profile knife (3" width)	\$25.00
M3+ HSS straight knife (1 1/2" width)	\$ 8.00
SUPRE-18 profile knife (up to and including 2" width)	\$19.00
SUPRE-18 profile knife (2 1/4" and 2 1/2" width)	\$21.00
SUPRE-18 profile knife (2 3/4" width)	\$23.00
SUPRE-18 straight knife (1 1/2" width)	\$ 9.00
DLC Hy-Val profile knife (up to and including 2" width)	\$22.00
DLC Hy-Val profile knife (2 1/4" width)	\$25.00
DLC Hy-Val profile knife (2 1/2" width)	\$28.00
DLC Hy-Val profile knife (1 1/2" width)	\$13.00
TCT carbide inlaid profile knife (2" width)	\$37.00
TCT carbide inlaid profile knife (2 3/8" width)	\$45.00
TCT carbide inlaid straight knife (1 9/16" width)	\$25.00
Double-Back profile knife (2" width / backer plate and knife blank)	\$56.00
Double-Back profile knife (2 3/8" width / backer plate and knife blank)	\$64.00
Double-Back straight knife (1 1/2" width / backer plate and knife blank)	\$47.00
Double-Back profile knife (2" width / knife blank only)	\$44.00
Double-Back profile knife (2 3/8" width / knife blank only)	\$52.00
Double-Back straight knife (1 1/2" width / knife blank only)	\$34.00

Online viewing or downloading of standard profiles is now available.

Visit our Website to take advantage of this new opportunity from Weinig Grinding Service.

NEW!

We now resharpen CentroLock knives and custom-design router bits.

Knife Regrinding Price Per Lineal Inch

HSS profile	\$ 6.00
HSS straight knife	\$ 2.50
TCT inlaid profile	\$13.00
TCT inlaid straight knife	\$ 6.50
Double-Back profile	\$13.00
Double-Back straight knife	\$ 6.50

From Weinig's Custom Knife-grinding Service

Pre-hogged Profile Knives



- Less wear and tear on your grinder, since we do over 95% of the steel removal.
- Fewer grinding supplies (grinding wheels, tracing pins, etc.) needed, since you do only a quick rough and finish grind.
- Reduced workload on your grinding department, especially when grinding multiple-knife hydro-heads.
- All knives are ground from high-quality Weinig knife steel.

Price Per Lineal Inch

SRS profile knife (up to and including 2" width)	\$10.50
SRS profile knife (2 1/4" and 2 1/2" width)	\$11.50
SRS profile knife (2 3/4" width)	\$13.00
M2 1/4 HSS profile knife (up to and including 2" width)	\$11.00
M2 1/4 HSS profile knife (2 1/4" and 2 1/2" width)	\$12.00
M2 5/16" HSS profile knife (up to and including 2" width)	\$11.00
M2 5/16" HSS profile knife (2 1/4" and 2 1/2" width)	\$12.50
M2 5/16" HSS profile knife (2 3/4" width)	\$13.50
M3+ HSS profile knife (up to and including 2" width)	\$12.00
M3+ HSS profile knife (2 1/4" and 2 1/2" width)	\$13.00
M3+ HSS profile knife (2 3/4" width)	\$14.50
M3+ HSS profile knife (3" width)	\$16.50
SUPRE-18 profile knife (up to and including 2" width)	\$12.50
SUPRE-18 profile knife (2 1/4" and 2 1/2" width)	\$14.00
SUPRE-18 profile knife (2 3/4" width)	\$15.50
DLC Hy-Val profile knife (up to and including 2" width)	\$14.50
DLC Hy-Val profile knife (2 1/4" width)	\$16.50
DLC Hy-Val profile knife (2 1/2" width)	\$18.50
Double Back profile knife (2" width / backer and knife)	\$43.00
Double Back profile knife (2 3/8" width / backer and knife)	\$51.00
Double Back profile knife (2" width / knife blank only)	\$31.00
Double Back profile knife (2 3/8" width / knife blank only)	\$39.00



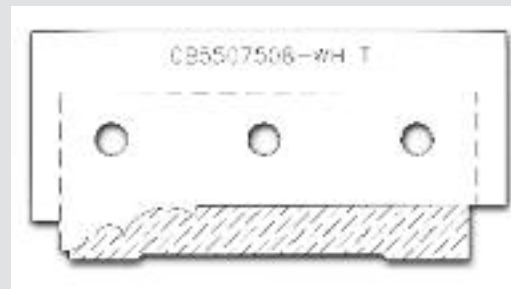
All of our Pre-hogged Profile Knives are cut by our Flow Waterjet. Using this technology allows us to provide you with knives that are completely squared on the ends, and have no burn on the pre-profiled edges.

NOW AVAILABLE!

Standard and Customized Precision Profile Knives and Templates for Williams & Hussey Molders.

Same procedures as used for the production of knives for Weinig moulders, with the quality and accuracy you would expect from the Weinig Grinding

We use only Weinig quality M2 knife steel. Available in either standard non-corrugated or with corrugations. Priced per lineal inch. Standard profile setup charges also apply.



**Of course, we also
resharpen these knives.**

Rates shown on page 33.

M2 HSS corrugated profile knife (2 1/4" width)	\$25.00
M2 HSS non-corrugated profile knife (2 1/4" width)	\$23.50
M2 HSS corrugated profile knife (2 1/2" width)	\$26.00
M2 HSS non-corrugated profile knife (2 1/2" width)	\$24.50



If you prefer to grind your own knives, we also offer Williams & Hussey knife blanks.

CORRUGATED KNIFE BLANKS

VEN700905	Pair of 2 knives 2 1/4" x 2"	\$ 32.00
VEN700910	Pair of 2 knives 2 1/4" x 4"	\$ 64.00
VEN700915	Pair of 2 knives 2 1/4" x 6"	\$ 96.00
VEN700920	Single Bar 2 1/4" x 25"	\$174.00
VEN701905	Pair of 2 knives 2 1/2" x 2"	\$ 36.00
VEN701910	Pair of 2 knives 2 1/2" x 4"	\$ 71.00
VEN701915	Pair of 2 knives 2 1/2" x 6"	\$107.00
VEN701920	Single Bar 2 1/2" x 25"	\$187.00

NON-CORRUGATED KNIFE BLANKS

VEN702905	Pair of 2 knives 2 1/4" x 2"	\$ 26.00
VEN702910	Pair of 2 knives 2 1/4" x 4"	\$ 52.00
VEN702915	Pair of 2 knives 2 1/4" x 6"	\$ 78.00
VEN702920	Single Bar 2 1/4" x 25"	\$147.00
VEN703905	Pair of 2 knives 2 1/2" x 2"	\$ 29.00
VEN703910	Pair of 2 knives 2 1/2" x 4"	\$ 58.00
VEN703915	Pair of 2 knives 2 1/2" x 6"	\$ 87.00
VEN703920	Single Bar 2 1/2" x 25"	\$159.00

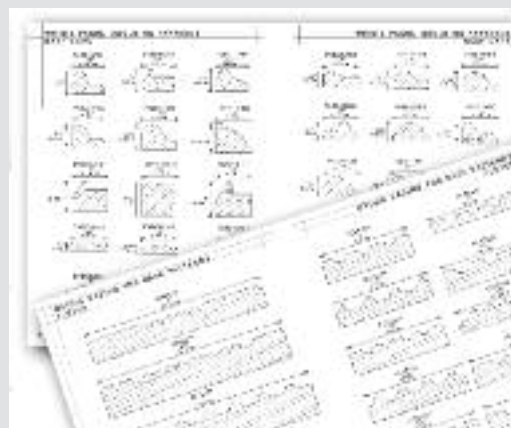
Weinig Profile Catalog, 3rd Edition

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.

The 100+ additional profiles added after the 2nd edition include new sections on door stiles, stair profiles, glue joints, and shutter profiles.

Templates for each profile included in this book are available for immediate delivery at only \$20.00 per template.

VEN160102 \$50.00



Weinig's Updated Online Profile Catalog

Now Available for Viewing and Profile Downloads at www.weinigusa.com

Home | Contact | Site Map

PRODUCTS SERVICES COMPANY TOOLING/PARTS NEWS & EVENTS USED MACHINES

WEINIG America Profile Catalog

Search Profiles In Lower Left Corner

Profile Catalog Home | Log In

Technical Information

- ▢ Rough Grind Price List
- ▢ Ready To Run Price List
- ▢ Frequently Asked Questions
- ▢ Important Safety Information
- ▢ Knife Material
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- ▢ Cofferhead Instructions
- ▢ Grinding Instructions

Profile Catalog

- ▢ Backcuts
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- ▢ Brick Moulds & Drip Cases
- ▢ Ballrods
- ▢ Casting & Base
- ▢ Chair Rails
- ▢ Deer Parts
- ▢ Cover-Strip Shoes
- ▢ Cores
- ▢ Bevel Edge & Radius
- ▢ Edge Beads & Profiles
- ▢ Flooring Profiles
- ▢ Furniture Legs
- ▢ Glue Joints
- ▢ Hand Rails
- ▢ Novelty Objects
- ▢ Outside Corners
- ▢ Panel Moulds
- ▢ Panel Edging
- ▢ Penning & Drilling T&G
- ▢ Panel Profiles
- ▢ Picture Frames
- ▢ Rounds
- ▢ Shutter Parts
- ▢ Siding & Shiplap
- ▢ Window Stools

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Enter search keywords here

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We have changed the format of our Profile Catalog to give you more choices than ever before!

How long would it take you to hog out this knife?

Can you do it for less than \$4.99 per inch?

Let us do it for you. Save time and money with our rough grinding service. We use a FLOW water-jet cutter to remove 90% of the knife material without overheating the cutting edge.

Diamond grinding wheels for carbide are expensive. The removal of the excess material in advance can be very cost-effective in both time and grinding wheels.

See the Rough Ground Price List menu item at the top left.

Order your knives and get the plastic templates FREE!

Standard or Custom profiles. Finish ground and ready-to-run or roughed out for your finish grind - any profile - any steel. Any grade of High Speed Steel or Carbide knives!

Select from the Online Profile Catalog or send us your custom profile sample or drawing for layout. Choose either Ready-To-run or Rough Ground knife sets, and we will send along the polycarbonate templates absolutely free.

This is a deal too good to pass up for even companies that have their own grinding rooms and staff. Get roughed out knives, guaranteeing superior knife stock quality and saving a lot of time and labor for most profiles, and you get the time-consuming template work done for nothing!

Still want to make your own templates? Download Profiles For \$3!

If you have a template maker or a router, you may download the DWG file for use in making your own templates. The cost for each profile is \$3. It does not matter whether the profile has a single template, or all 4 sides. The price is still \$3! This value cannot be beaten anywhere download is available immediately after checkout. We accept credit cards only for these downloads. [Visa - Mastercard - American Express]

When you sign up for an account, you will receive a coupon good for one FREE profile download of your choice! No strings attached!

Free No-Obligation Quote!

When browsing the catalog, you may also select only "Quote Knives" on any of the profiles. In many cases, it's faster for you to grind the shallow profiles and let us use our water-jet cutter on the big ones. There is no charge or obligation to get a price quote, but you must Check Out your cart to relay the information to Weinig. We will contact you using the email provided in sign-up or telephone to determine the type of knife material required and details of the quote.

Have a project coming up? Discounts available for large orders!

Don't allow cheap advertised prices to cloud your judgment without first talking to the people that made the machinery! We can do the parts of a large job that you don't want to!

Custom Profiles? Send Us Your Drawing or Sample - Here's how it works -

If you already have a drawing, CAD file or an existing sample, send it to us and we will produce a dimensional CAD drawing and send it to you for approval. When we receive your approval we produce your templates and knives and send them to you using the delivery method of your choice.

Custom Grinding Service

Only the Weinig Custom Grinding Service offers product layout, template and knife production by Weinig technicians experienced in the operation of both routers and grinders. All of our precision profile knives are produced according to the Weinig Aerial Constant Systems, which can reduce setup time by 50% on any through-feed router.

As a benefit to your business, Weinig now offers precision rough-ground corrugated knives at greatly reduced prices. Just put these into a cofferhead, make a quick rough and finish grind on the coffer, and you're ready for production.

Lead Time

Lead time for custom or stock ground knives & templates is typically 3 days from the time of order confirmation. Templates & rough ground knives have a 24 hour turn around from the time of order confirmation.

Weinig America Grinding Service
124 Drexelkirk Park Drive
Mooresville, NC 28117
Phone: 1-800-343-4644
Fax: 1-704-663-2466
Email: grinding@weinigusa.com

CAD DRAWING

TEMPLATE

PRE-HOGGED

FINISHED KNIFE

Why Are you Still Making Templates by Hand? There Is a Better Way!

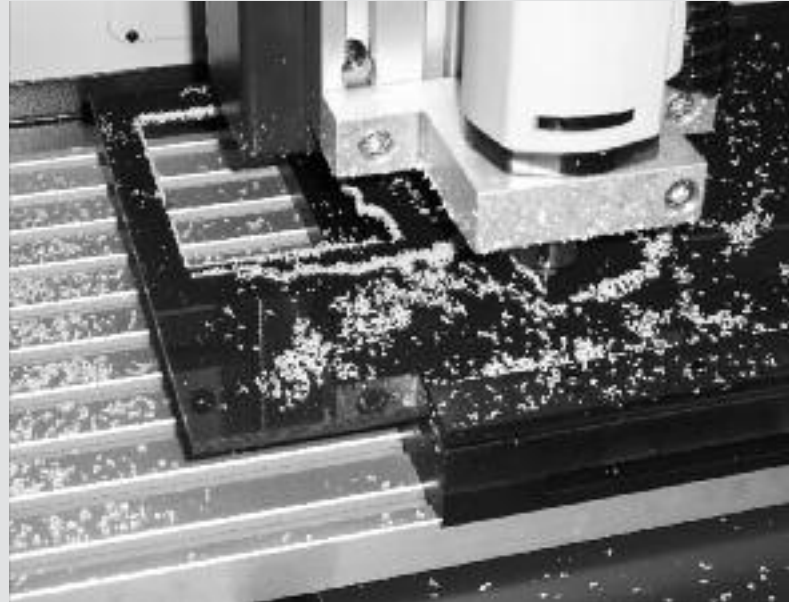
The AUTOTEMP 2000 TEMPLATE MAKING SYSTEM provides:

- Perfect templates, fast and accurate
- Pressure shoes that match the moulding perfectly
- Customer approval CAD drawings
- Checking gauges
- Vacuum coater plates/gates
- Weinig profile catalog library included

The AutoTemp 2000 Template Making System is the complete solution for moulding manufacturers. With the combination of a CNC router, wood scanner, specially designed CAM, and customized CAD software (complete with profile library), the AutoTemp 2000 has revolutionized the template creation process for moulding knives.

Gone are the endless hours of filing templates by hand. You can now simply scan the wood sample, and then trace the scanned image. This two-step process can produce a template in less than 25% of the time of traditional methods. In addition, since the template drawings are stored in your computer, you always have immediate access to these templates.

With the AutoTemp system, you can also add the AutoShoe option, which allows you to manufacture your own nylon or wooden counter profile pressure shoes. In only a few minutes, you can convert the system to allow you to make pressure shoes that will match your profile exactly. In the time it takes you to grind your knives for a specific profile, the router can cut the pressure shoe. In no time, you'll be able to run your product efficiently – even hard-to-run profiles with uneven points or deep profiles.



For more information, call

Phone; 800-759-6268

Email: sales@templatemakers.com

Grinding Wheels

NEW – Available Exclusively From Weinig The 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 Cubitron Ceramic Wheel	\$32.50
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Weinig Blue Ceramic Grinding Wheels

The Weinig Cubitron 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 Cubitron Ceramic wheels for rough grinding	\$28.75
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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 wheels for rough grinding	\$18.25
XXX100717	100-grit Premium Blue wheels for finish grinding	\$18.25

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-wheels for rough grinding	\$10.25
006-00183	100-grit Euro-wheels for finish grinding	\$10.25

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

Grinding Wheels for Non-Weinig Grinders

WADKIN GRINDERS

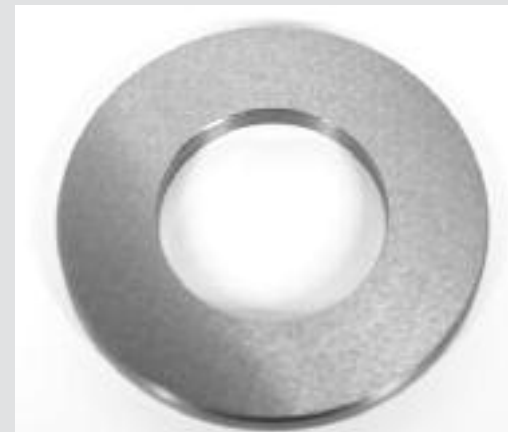
XXX100715	Aluminum oxide wheel for rough grinding of HSS 9" x 3/16" x 1 1/4" bore	\$ 17.00
930062010W	CBN wheel for finish grinding of HSS 10" x 1/16" x 1 1/4" bore	\$217.00
930062018W	Diamond wheel for rough grinding of carbide 10" x 1/16" x 1 1/4" bore	\$175.00
930062021W	Diamond wheel for rough grinding of TCT 10" x 1/16" x 1 1/4" bore	\$199.00
930062011W	Diamond wheel for finish grinding of carbide 10" x 1/16" x 1 1/4" bore	\$175.00

FOLEY/UNITED GRINDERS

XXX100714	Aluminum oxide wheel for rough grinding of HSS 10" x 1/4" x 1 1/4" bore	\$ 22.00
930062010F	CBN wheel for finish grinding of HSS 8" x 1/16" x 1 1/4" bore	\$190.00
930062018F	Diamond wheel for rough grinding of carbide 8" x 1/16" x 1 1/4" bore	\$148.00
930062021F	Diamond wheel for rough grinding of TCT 8" x 1/16" x 1 1/4" bore	\$172.00
930062011F	Diamond wheel for finish grinding of carbide 8" x 1/16" x 1 1/4" bore	\$148.00

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

XXX100716	Metal bushing 60mm x 1 1/4" For converting Weinig grinding wheels for use on grinders with 1 1/4" arbors	\$40.00
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Grinding Wheels

Weinig CBN (Cubic Boron Nitride) Grinding Wheels

– Now with 1/4" CBN depth, for extra value.

Weinig CBN wheels use a fine-grit bonded abrasive grain to improve surface quality by providing a microfinish on tool and high-speed steel. The special bonding allows heat to dissipate more quickly and the cooler cutting action extends wheel life.

For finish grinding of HSS profile knives



930-062007	4mm thick with 2mm radius	\$336.00
930-062008	4mm thick with square edge	\$336.00
930-0620071	3mm thick with 1.5mm radius	\$306.00
930-062010	2mm thick with 1mm radius	\$276.00
930-062012	1.5mm thick with 0.75mm radius	\$264.00
930-0620121	1.5mm thick with square edge	\$264.00
930-0620122	1.0mm thick with square edge	\$286.00
920-072011	10mm thick with square edge (requires small-diameter clamping flange)	\$264.00

Weinig Diamond Grinding Wheels –

Now with 1/4" diamond depth, for extra value.

For rough grinding of tungsten carbide knives

930-062002	4mm thick with 2mm radius	\$296.00
930-062015	3mm thick with 1.5mm radius	\$268.00
930-062018	2mm thick with 1mm radius	\$241.00

For simultaneous rough grinding of both steel and carbide on TCT inlaid profile knives

930-062020	4mm thick with 2mm radius	\$296.00
930-062021	2mm thick with 1mm radius	\$241.00
930-062022	2mm thick with square edge	\$241.00

For finish grinding of tungsten carbide knives

930-062003	4mm thick with square edge	\$304.00
930-062005	Pointed tip for V-shape patterns and small radii	\$335.00
930-062006	4mm thick with 2mm radius	\$304.00
930-062011	2mm thick with 1mm radius	\$247.00
930-062013	1.5mm thick with 0.75mm radius	\$252.00
930-062016	3mm thick with 1.5mm radius	\$274.00
920-072006	10mm thick with square edge (requires small-diameter clamping flange)	\$230.00

Visit Our Website:
www.weinigusa.com

**2% discount on
online orders**

UNILINE SUPERABRASIVE WHEELS

NEW From Weing! A second tier line of super-abrasive wheels!

This selection of quality grinding wheels provides good wheel life and cutting capacity at an economical price. Thoroughly tested, these wheels give you the quality expected from a wheel from Weing.

CBN (Cubic Boron Nitride) grinding wheels for finish grinding of HSS profile knives

930-06200715	4mm thick with 2mm radius	\$237.00
930-06200815	4mm thick with square edge	\$237.00
930-06201015	2mm thick with 1mm radius	\$208.00

Diamond grinding wheels for simultaneous rough grinding of both steel and carbide on TCT inlaid profile knives

930-06202015	4mm thick with 2mm radius	\$213.00
930-06202115	2mm thick with 1mm radius	\$197.00

Diamond grinding wheels for rough grinding of tungsten carbide knives

930-06200215	4mm thick with 2mm radius	\$187.00
930-06201815	2mm thick with 1mm radius	\$167.00

Diamond grinding wheels for finish grinding of tungsten carbide knives

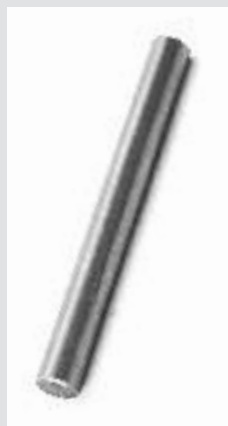
930-06200315	4mm thick with square edge	\$187.00
930-06200615	4mm thick with 2mm radius	\$187.00
930-06201115	2mm thick with 1mm radius	\$167.00



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 \$120.00



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 \$43.00

Plastic Shims

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

XXX100709	0.001" thick (orange)	\$0.50 each
XXX100708	0.002" thick (red)	\$0.50 each
XXX100707	0.005" thick (blue)	\$0.50 each
XXX1007068	0.010" thick (brown)	\$0.60 each
XXX1007065	0.025" thick (white)	\$0.90 each



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

ARTICLE NUMBER	UPPER SIDE	LOWER SIDE	PRICE U.S. \$
930-042001	● 2mm diameter	● 3mm diameter	43.00
930-042002	▭ 4mm semicircular	● 3mm diameter	43.00
930-042003	▭ 4mm x 45° pointed	● 4mm diameter	43.00
930-042009	▭ 2mm semicircular		43.00
930-042010	▭ 3mm semicircular		43.00
930-042013	▭ 1.5mm semicircular		60.00
930-042014	▭ 1.0mm semicircular		77.00
930-042015	▭ 5mm semicircular		43.00

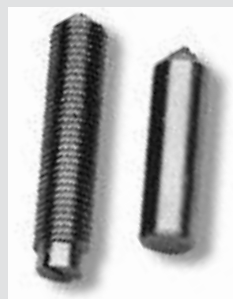
Tracing Pins for Rondamat 925, 950



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

ARTICLE NUMBER	UPPER SIDE	PRICE U.S. \$
925-034003	● 4mm diameter	57.00
925-034004	● 2mm diameter	57.00
925-034009	● 3mm diameter	57.00

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



Single-Point Diamond Dresser

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

Non-threaded for use on Rondamat 930, 931, 932, 934, 935, 936

VEN700075

\$23.00

Threaded for use on Rondamat 925, 934N, 950, 960, 970

925-034008

\$27.00



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. Can also be used to precisely reshape diamond and CBN wheels.

Non-threaded for use on Rondamat 930, 931, 932, 934, 935, 936

VEN700085

\$45.00

Threaded for use on Rondamat 925, 934N, 950, 960, 970

925-934008

\$54.00

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	\$139.00
932-07401	Clamping flange for hydraulic locking systems	\$133.00
932-07402	Small diameter clamping flange for hydraulic locking systems	\$160.00



Rondamat Grinder Knife Rest

A properly machined knife rest is required to precisely grind knives in the cutter-head. 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	\$141.00
930-013024HM	Replaceable carbide for above-listed set	\$ 45.00
932-027001	Beveled knife rest Used for auto-grind on Rondamat 935, 936, 970	\$141.00
930-013024HEL	Replaceable carbide for grinding Helical planerheads	\$ 55.00



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 \$60.00

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

Package of 100 filter sheets

003-06950G \$60.00



Grinding Room Accessories

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. 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
- Excellent for use with saw spray-mist lubrication systems

CUTTER-GUARD	XXX100380
1-gallon jug	\$14.25
5-gallon pail	\$62.00
55-gallon drum	\$470.00



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 \$95.00

Rondor Replacement Stone

006-00192 \$12.75



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.

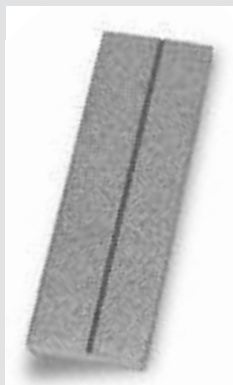
XXX100730 \$3.25



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 \$15.50



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 \$11.95



Round Edge Slip Stone

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

XXX100732 \$8.75

To reduce diamond dresser wear, dress wheels at 1,600 to 2,000 rpm.



Pressure Release Valve

#32365 M10x1

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

003-03856 \$9.00

Replacement rubber seal ring

003-27332 \$1.30

Seal ring for old-style release valve

003-11901 \$3.25



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 \$1.30

Seal ring for old-style grease fitting

003-11901 \$3.25

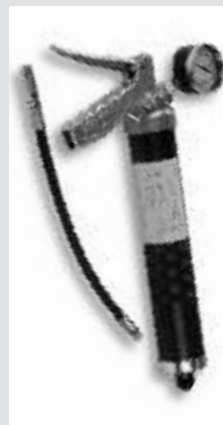


International Grade

#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 \$7.15



Special Hydraulic

Grease Gun 0-400 Bar **NEW STYLE**

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

003-09102 \$450.00

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

Grade #2 Grease Cartridge

For use with central lubrication system.

003-17500 \$4.95

Grease Gun for Central

Lubrication Systems

003-09091 \$111.00



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 \$33.00

For new-style hydraulic grease gun (#003-09102)

003-09139K \$75.00



Rebate Cutter Turnblades

These carbide turnblades have four cutting edges, are easy to change and to locate into seatings, and are preset to give a constant cutting circle.

Turnblade knife 17 x 17 x 2mm
006-00379 \$4.95

Turnblade spur 14 x 14 x 2mm
006-00170 \$1.50

Grinding Room Accessories

NEW

Two-Cool Grinding Coolant



Double the Life, Double the Protection!

This is a new formulation with better grinding lubricant and more rust-inhibitor for longer coolant life. Now also includes a carbide grinding additive. Get the benefits of a superior surface finish on your tool with this new, improved grinding coolant.

TWO-COOL	VEN700050
1-gallon jug	\$30.00
5-gallon pail	\$125.00



Ronda Cool XL Grinding Coolant

A time-tested alternative to our standard Two-Cool coolant, back by popular demand.

Ronda-Cool XL	VEN700054
1-gallon jug	\$22.00
5-gallon pail	\$103.00



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	\$175.00
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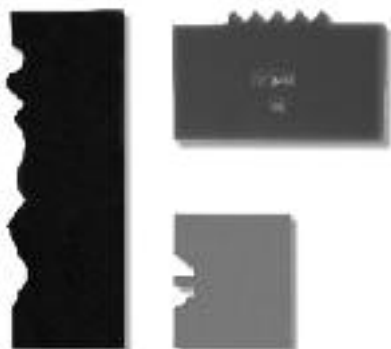
Template Material

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"	\$14.75
000-80002	3 11/32" (85mm) x 24" x 1/8"	\$17.00
000-80003	3 47/64" (95mm) x 24" x 1/8"	\$18.50
000-80004	4 9/64" (105mm) x 24" x 1/8"	\$21.00

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

VEN060096	4" x 12"	\$ 5.50
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Steel-tooth Rollers

The standard infeed rollers furnished on all new Weinig moulders are the steel-tooth rollers. These conical-shaped rollers are a patented Weinig design made specifically to properly through-feed most dry materials. For superior gripping power, the teeth on the contact surface are located at an angle, with a maximum "tooth mark" indentation of only 3mm (1/8") deep. The contact surface of the roller is covered with a layer of hard chrome to provide longer roller life.

ARTICLE NUMBER	SIZE	PRICE U.S. \$
143-618006	5 1/2" OD x 2" wide roller for 35mm keyed shaft	118.00
143-618010	5 1/2" OD x 1 1/4" wide roller for 35mm keyed shaft	145.00
023-291017	5 1/2" OD x 5/8" wide roller for 35mm keyed shaft	117.00
023-9052923	5 1/2" OD x 3/8" wide roller for 35mm keyed shaft	160.00
143-618001	5 1/2" OD x 3/4" wide roller for 35mm keyed shaft with extended hub	131.00
143-618002	5 1/2" OD x 5/8" wide roller for 35mm keyed shaft with extended hub	141.00
143-618008	5 1/2" OD x 3/4" wide cup (bolt-on) roller for 30mm shaft	118.00
143-618009	5 1/2" OD x 5/8" wide cup (bolt-on) roller for 30mm shaft	109.00
143-9011984	5 1/2" OD x 3/8" wide cup (bolt-on) roller for 30mm shaft	153.00
123-258002	5 1/2" OD x 5/16" wide cup (bolt-on) roller for 30mm shaft	209.00
123-258003	5 1/2" OD x 3/4" wide cup (bolt-on) roller for 20mm bore	228.00



Special Weinig patented tooth design on the feed rollers is self-cleaning and provides positive feeding and reduced surface penetration.

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	\$170.00
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Sawtooth Feed Roller

Primarily for hardwood applications, as an alternative to roller 143-618006.

022-181001	5 1/2" OD x 2" wide roller For 35mm keyed shaft	\$169.00
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Knurled and Smooth Urethane Feed Rollers

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 are small diamond points, with 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 U.S. \$
143-618005	5 1/2" OD x 2" wide roller for 35mm keyed shaft	197.00
143-618016	5 1/2" OD x 5/8" wide roller for 35mm keyed shaft	370.00
143-618003	5 1/2" OD x 3/4" wide roller for 35mm keyed shaft with extended hub	234.00
143-618004	5 1/2" OD x 5/8" wide roller for 35mm keyed shaft with extended hub	238.00
K27-555015	5 1/2" OD x 3/4" wide cup (bolt-on) roller for 30mm shaft	255.00
K27-555014	5 1/2" OD x 5/8" wide cup (bolt-on) roller for 30mm shaft	329.00

Solid Urethane Rollers Now Available With Different Hardness

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 U.S. \$
226-106009	5 1/2" OD x 2" wide for 35mm keyed shaft	80	53.25
226-106009V	5 1/2" OD x 2" wide for 35mm keyed shaft	65	64.50
143-618007	5 1/2" OD x 1 1/4" wide for 35mm keyed shaft	80	55.75
143-618007V	5 1/2" OD x 1 1/4" wide for 35mm keyed shaft	65	80.75
042-362006	5 1/2" OD x 3/4" wide for 35mm keyed shaft	80	45.00
042-362007	5 1/2" OD x 5/8" wide for 35mm keyed shaft	80	49.00
042-36200710	5 1/2" OD x 3/8" wide for 35mm keyed shaft	80	54.00
042-362007V	5 1/2" OD x 3/8" wide for 35mm keyed shaft	65	54.00
014-192018	5 1/2" OD x 1 1/2" wide cup (bolt-on) for 30mm shaft	80	39.50
014-192019	5 1/2" OD x 3/4" wide cup (bolt-on) for 30mm shaft	80	28.75
014-192020	5 1/2" OD x 5/8" wide cup (bolt-on) for 30mm shaft	80	28.00
014-192021	5 1/2" OD x 1/2" wide cup (bolt-on) for 30mm shaft	80	27.00
014-192021V	5 1/2" OD x 1/2" wide cup (bolt-on) for 30mm shaft	65	27.00

Replaceable Tire System Now Available With Different Hardness

For high-speed, high-wear applications, we recommend the Weinig Replaceable Tire System. This system 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	DUROMETER	PRICE U.S. \$
XXX100840	Replaceable tire	5 1/2" OD x 2" wide	80	26.50
XXX100850	Replaceable tire	5 1/2" OD x 2" wide	85	29.00
XXX100840V	Replaceable tire	5 1/2" OD x 2" wide	65	29.00
XXX100870	Replaceable tire	6 3/4" OD x 2" wide	80	44.50
XXX100845	Replaceable tire	5 1/2" OD x 3/4" wide	80	16.25
XXX100855	Replaceable tire	5 1/2" OD x 3/4" wide	85	20.25
XXX100845V	Replaceable tire	5 1/2" OD x 3/4" wide	65	20.25
XXX100900	Keyed steel feed hub	For 2" wide replaceable tire		83.00
XXX100902	Keyed steel feed hub	For 3/4" wide replaceable tire		92.00
XXX100905	Steel cup feed hub	For 3/4" wide replaceable tire		96.00



Center Locking Washer for Stacking Cup Feed Rollers

- 250-233007** For use with steel cup rollers **\$16.00**
- 250-2330071** For use with urethane and knurled cup rollers **\$16.00**

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.

To purchase counter profile shoes, contact direct:
Advanced Moulding Technology
Phone: 1-318-544-2370
Fax: 1-318-544-8533
Email: amt@hughes.net

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.

Jointing Stones



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. These stones provide 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.

Resin Bond:

Provides a better finish quality.

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"

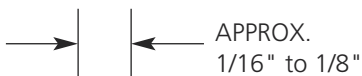
PLANING STONE SIZE:

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"

ARTICLE NUMBER	JOINTING STONE FOR	SIZE MM	BOND	COLOR	GRIT	PRICE U.S. \$
006-00187	HSS profiling	160 x 60 x 15	vitrified	blue-grey	600	16.75
006-00188	HSS profiling	160 x 60 x 15	resin	green	600	24.00
006-00377	HSS profiling	160 x 60 x 15	resin	brown	500	16.75
006-00189	HSS profiling	160 x 60 x 15	vitrified	blue-grey	400	16.75
006-00370	HSS profiling	230 x 60 x 15	vitrified	blue-grey	600	23.50
006-00095	HSS profiling	230 x 60 x 15	resin	green	600	31.00
006-02121	HSS profiling	230 x 60 x 15	resin	brown	500	23.50
XXX100727	HSS profiling	305 x 60 x 15	resin	green	600	46.00
251-362002	HSS planing	20 x 60 x 15	resin	brown	500	5.50
006-01654	HSS planing	20 x 60 x 15	vitrified	white	240	5.75
006-02116	HSS planing	12 x 38	vitrified	blue-grey	280	3.75
WAC501522	HSS planing	16 x 125	vitrified	dark grey	220	11.25
006-00186	HSS planing	20 x 100 x 10	vitrified	blue-grey	280	4.25
XXX100724	Carbide profiling	160 x 60 x 15	special	blue-grey	600	25.00
XXX100720	Carbide profiling	230 x 60 x 15	special	blue-grey	600	44.00
XXX100722	Carbide planing	20 x 60 x 15	special	dark grey	240	4.00
XXX100731	Carbide planing	12 x 38	special	dark grey	240	3.75



Finished jointing stone, end view

For the very best attainable finish when straight-knife jointing

ARTICLE NUMBER	JOINTING STONE FOR	SIZE	TYPE	PRICE U.S. \$
XXX100703	HSS planing	12 x 32	CBN	\$125.00
XXX100704	Carbide planing	12 x 32	Diamond	\$125.00

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	XXX100083	
5 Kg (1.6-gal.) can		\$45.00
20 Kg (6.5-gal.) can		\$170.00
160 Kg (52-gal.) drum		\$1255.00



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	XXX100074	
5-gallon can		\$88.00
55-gallon drum		\$885.00

Safety Locking Collars

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

WNW-101719	Safety locking collar for 1 13/16" spindles	\$76.00
WNW-101720	Safety locking collar for 2 1/8" spindles	\$76.00



Straight Edge

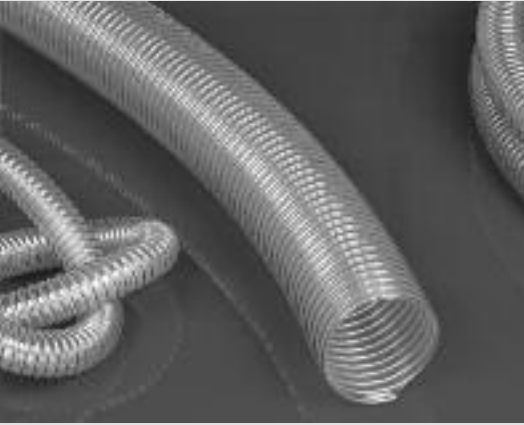
Precision machinist straight edge for use when positioning cutting tools and pressure shoes.

WNW-0287	10" length	\$42.00
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Polyurethane Flex Hose

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 three styles.

Standard quality and thickness, as delivered with new Weinig moulders and ripaws

Minimum 10' length, sold in 5' increments

ARTICLE NUMBER	HOSE DIAMETER (INSIDE DIAMETER)	PRICE PER FOOT U.S. \$
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 (INSIDE DIAMETER)	PRICE PER FOOT U.S. \$
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

Electrically Conductive Flex Hose (heavy-duty) Manufactured with a carbon additive, for elimination of static electricity buildup.

Minimum 10' length, sold in 5' increments

ARTICLE NUMBER	HOSE DIAMETER (INSIDE DIAMETER)	PRICE PER FOOT U.S. \$
003-044281SDH	120mm (4 33/32")	25.45
003-044561SDH	140mm (5 1/2")	30.10
003-044191SDH	160mm (6 9/32")	36.10
003-044331SDH	200mm (7 7/8")	51.80

Visit Our Website:
www.weinigusa.com

**2% discount on
online orders**

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	\$1.45 per crayon
91062211A	Optional Orange	\$1.45 per crayon
8290082286	Invisible Blue	\$1.80 per crayon

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

91062210	Old Style Red	\$1.25 per crayon
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Marking Crayons for Rough-cut and Wet Lumber

(Non-fluorescent, packed 12 pieces per box)

90763320A	Blue	\$0.75 per crayon
90763321A	Black	\$0.75 per crayon

Crayon Holder

91065555A	Standard	\$15.00
85489CH	Special for Invisible Blue crayon	\$15.75

Visit Our Website:
www.weinigusa.com

**2% discount on
 online orders**

Raimann Ripsaw Blades

NOW FROM WEINIG

3 Selections to Suit Your Needs



For additional information, see page 74 "Ripsaw Blade Selection Guidelines."

Premium Glue-line Quality Blades

Now with special coating

- Improved glue-line quality cut
- Increased stability
- Reduced buildup and heat
- Increased run-time

ARTICLE NUMBER	USAGE	BLADE KERF MM	# OF TEETH	FEED RATE FPM	PRICE U.S. \$
9119153	Standard blade supplied with all new KM saws	4.0	28	50-115	91.00
9119161	Standard blade supplied with all new KR saws	4.0	36	80-166	108.00
9119186	Alternative blade for KR saws with high-speed package	4.0	48	130-260	136.00
9119272	Optional thin kerf blade	2.8	28	50-115	131.00
9119274	Optional thin kerf blade	2.8	36	80-166	145.00
9119276	Optional thin kerf blade	2.8	48	130-260	163.00

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 U.S. \$
9119354	3.5	28	50-115	49.00
9119362	3.5	36	80-166	61.00
9119387	3.5	48	130-260	68.00

Special Application Blades

ARTICLE NUMBER	USAGE	BLADE KERF MM	# OF TEETH	FEED RATE FPM	PRICE U.S. \$
9119177	Alternative blade for KR saws with high-speed package	4.0	54	220-300	277.00
9119163	Special 330mm OD blade for 10/4 material	4.0	28	50-115	148.00
9119165	Special 360mm OD blade for 12/4 material	4.0	36	80-130	188.00

Quickfix Fixed Clamping Device

Clamping flange for a single saw blade

312196	For production of up to 6/4 lumber	\$518.00
312196 SD	For production of 8/4 lumber and larger	\$518.00



Quickfix Movable Clamping Device

Clamping flange for a single saw blade on the movable head

349014	Clamping flange only	\$1790.00
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Standard Locking (Non-Quickfix) Fixed Clamping Device

Clamping flange for a single saw blade

311636	Clamping flange only	\$720.00
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New and Improved Lubrication Accessories



Lubrication oil for feed chain

New formulation for better lubrication and less runoff

PUS750100

5-gallon pail \$106.00



Oil for arbor lubrication

New formulation for better lubrication, eliminates sticking and buildup problems

PUS909715

5-gallon pail \$89.00

Raimann Ripsaw Accessories

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	\$865.00
9121425	300 x 18.6 for LH (outside) position	\$865.00

Additional Trim Saws

91214352B	300 x 36T for RH (inside) Hogcut #9121435–Standard	\$153.00
91214351B	300 x 28T for RH (inside) Hogcut #9121435–Optional	\$131.00
9121435B	300 x 48T for RH (inside) Hogcut #9121435–Optional	\$173.00
91214252B	300 x 36T for LH (outside) Hogcut #9121425–Standard	\$153.00
91214251B	300 x 28T for LH (outside) Hogcut #9121425–Optional	\$131.00
9121425B	300 x 48T for LH (outside) Hogcut #9121425–Optional	\$173.00



Hogfix Fixed Clamping Device for Quickfix Arbor

Fixed clamping flange for Standard TCT Hogcut

349518	\$665.00
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Hogfix Fixed Clamping Device for Standard (Non-Quickfix) Arbor

Fixed clamping flange for Standard TCT Hogcut

349435	\$1520.00
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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 Saw Blades

Dimter Crosscut Saws

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, rough material

8601032	350mm OD	Z84	\$185.00
48032583S	400mm OD	Z120	\$256.00
48033731S	450mm OD	Z138	\$315.00
48033741S	500mm OD	Z144	\$362.00
48033761S	600mm OD	Z172	\$475.00
48032182S	700mm OD	Z200	\$695.00
48033850S	500mm OD	Z144	\$362.00
(Special for S35 and S50 saw with 35mm arbor)			



Special Finish-cut Blades

48032603S	450mm OD	Z138	\$430.00
48032593S	500mm OD	Z144	\$475.00
48033900S	500mm OD	Z144	\$475.00
(Special for S35 and S50 saw with 35mm arbor)			

ProfiPress Saw Blade

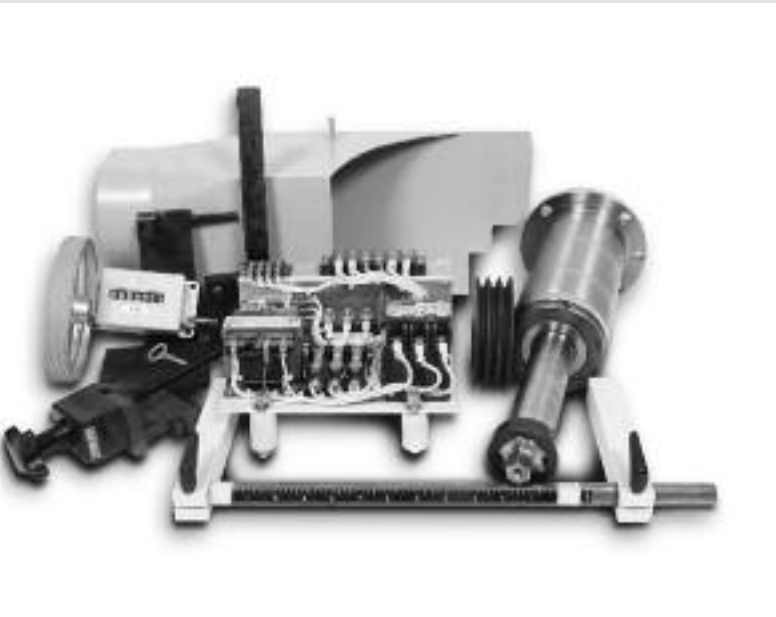
48033721S	400mm OD	Z48	\$150.00
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Spare Parts



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

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The HOLZ-HER Group Success Through Specialization

HOLZ-HER

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 Weinig credo – “Use the Best on the Best” – now 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, call

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Email: partsales@weinigusa.com



Bench Repair Service

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**

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.

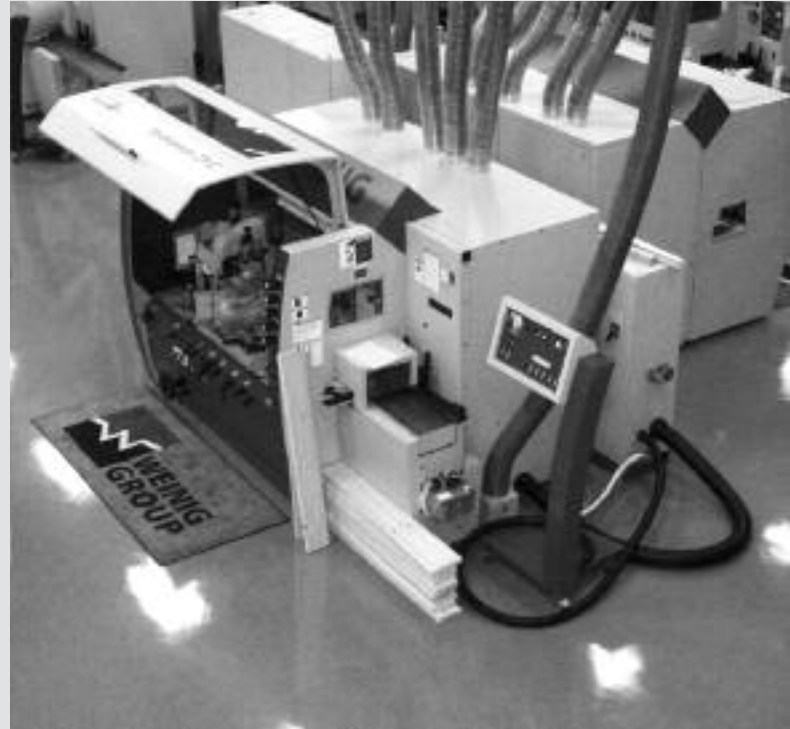
Train With the Best on the Best

Under one roof at our headquarters in Mooresville, N.C., we offer training on:

- Weinig moulders, planers, knife grinders
- Raimann ripping solutions, gang or optimizing rip-saws
- Grecon fingerjointers, complete rip-first or crosscut-first rough mills
- Dimter optimizing crosscut saws, vision scanning systems, edge-gluing presses
- Holz-Her edge banders, vertical panel saws, CNC machining center, beam saws, and sanders

For more details on enrollment, or for field training, contact:

Training Manager
1-877-548-0929, ext. 7863
training@weinigusa.com

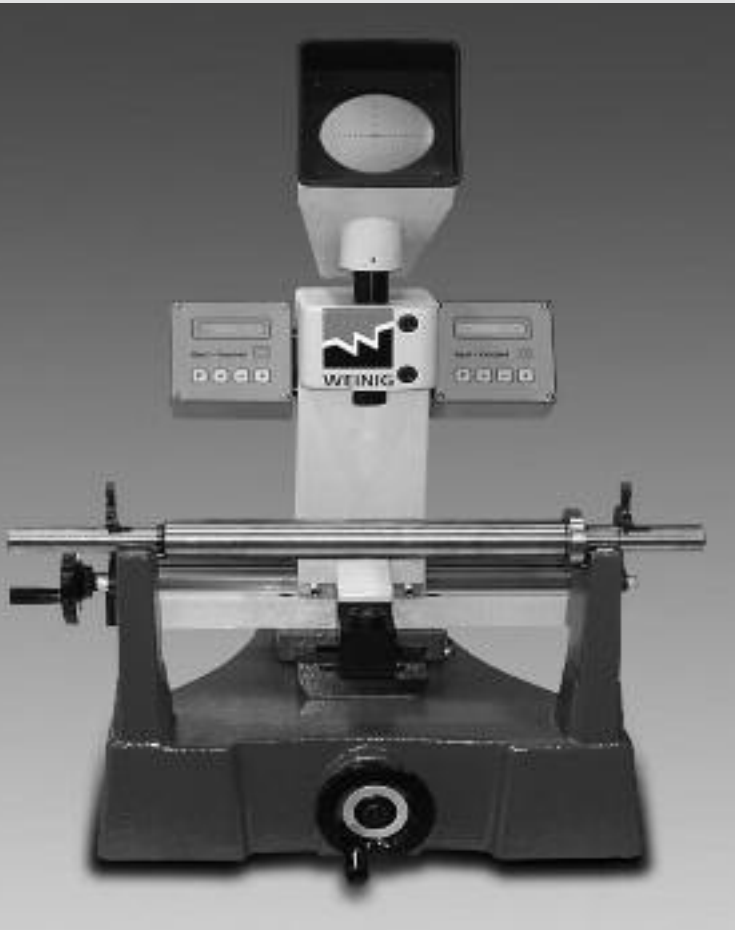


Need More Information?

You can view the training schedule and description on our website, www.weinigusa.com. Look at "Weinig Machine Training, View Schedule."

OptiControl Measuring Stand

The tool-room mediator



- Check
- Measure
- Correct

...all tooling to avoid downtime on your moulder.

For remarkably shorter moulder-setting times and reduction or elimination of set-up scrap.

The dimensional precision of your finished product is enhanced from the tool room.

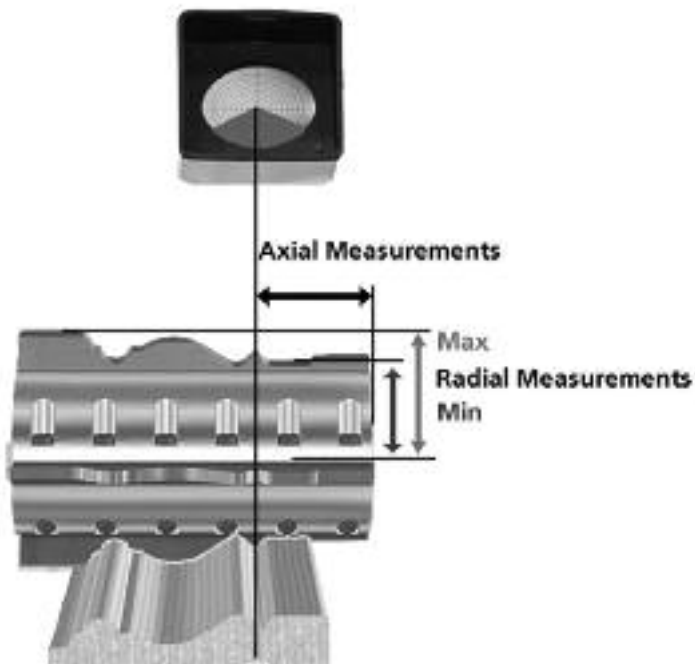
With the viewing scope magnifying the tooling 20 X, and the electronic read-outs on both axes, you can:

Measure

- Measure axial tooling points
- Measure radial tooling points
- Measure and adjust old corrugated knives to Weinig's Axial Constant position
- Measure and zero counters at any time to get a point-point incremental measurement

Compare

- Knife-to-knife positioning in the same cutterhead
- Replaceable insert knife tips with absolute viewing when changing knives
- The finished knife to the original profile information
- Saw-blade tips for accuracy after sharpening
- Finger-jointer tooling for concentricity of each cutter
- Milled-to-pattern tooling for accuracy from manufacturer



For more information, call

Phone: 877-548-0929, ext. 7314

Email: sales@weinigusa.com

Link your OptiControl Measuring Stand with a PC powered by PowerCom software

- Name and store each tool with all measurements given from the OptiControl Measuring Stand
- Enter all profile information from the tool room
- Transfer all tool and profile data to any moulder with PowerCom software



PowerCom Assist

- Now PowerCom software can assist your set-ups on conventional Weinig moulders.
- Swivel adjusting mounting arm lets the operator see the next profile to be run and all relative tooling information
- PowerCom can be linked to the OptiControl Measuring Stand in the tool room for direct data download, or used as a stand-alone assistant for storing profile and tooling information

For more information, call

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Email: sales@weinigusa.com



Powermat Moulder

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.
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, call

Phone: 877-548-0929

Email: service@weinigusa.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. They 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.
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, call

Phone: 877-548-0929

Email: service@weinigusa.com

Frequently Asked Tooling Questions

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 pounds 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 9,000 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.

Q: Why is the 4-knife PowerLock cutterhead closed on the non-clamping end of the tool?

A: This extra ring is part of the manufacturing process. It provides additional strength and stability due to the increase in metal stress created by centrifugal force. Please note that 4-knife cutterheads, although certified for operation up to 12,000 rpm, are designed for exclusive use on Powermat 2000 moulders.

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Important Information

Regarding Operation of Weinig PowerLock Cutterheads #538 And Powermat Moulders

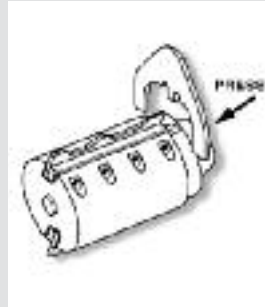


1. For safety reasons, the maximum adjustment of re-ground knives must not exceed four corrugations (1/4") from the bottom. There is a line on the cutterhead that indicates the maximum outward adjustment.
2. Knives and clamping wedges must have the same thickness, and MUST be balanced within 0.1 gram (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. Weinig Double-Back Carbide system is certified to run up to 12,000 rpm in Weinig PowerLock cutterheads. Different clamping wedges are required when used in Z4 heads.
4. Never exceed the maximum speed specified on the tool.
5. Cleanliness is extremely important between the PowerLock shank and receiver. Perform frequent visual inspections for burrs or damage on the tool taper, as tool breakage can occur if there is contamination. Use of PowerLock taper cleaning device #006-03226 (page 10) is recommended on EVERY cutterhead exchange.
6. Maximum tool weight when running at 10,000 and 12,000 rpm is 30 pounds. This tool is required to be an integrated one-piece tool (no adapters or tool-holders allowed), as technically specified by Weinig.
7. When using PowerLock adapters for conventional tools, the cutting tool dimensions and weights must not exceed the limits specified below. Note that minimum spindle adapter size is 1.5".

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

Remember never to exceed the maximum speed stamped on the tool.
8. Use of non-certified tooling is not recommended. Custom-tooling manufacturers must be able to furnish a tool-speed test AND balance certificate.

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 Z4 PowerLock Cutterheads

NOTE: Since these tool bodies are closed on the non-clamping end for strength and stability, loose knife placement and removal is slightly different from the Z2 version.

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 50). 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.

Balancing Instructions for Weinig Cutterheads

All Cutterheads



1. Knives must have the same thickness, and must be balanced within 0.1 gram (0.0035 oz) in pairs. When installed in the cutterhead, these knives must be installed into opposite pockets.
2. 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.
3. Confirm that all gib screws are the same length.
4. On type #503 and #504 cutterheads, balance gibs to within 0.1 gram (0.0035 oz) in pairs. Be sure to install into opposite pockets.

Specific to PowerLock Cutterheads



Without Pockets and Gibs Numbered

NOTE: Effective 8/1/06, all Powerlock tools are balanced by this method. These cutterheads are balanced in the factory with the tool body only.

1. Balance gibs to within 0.1 gram (0.0035 oz) in pairs. Be sure to install into opposite pockets. This is the same procedure as listed for type #503 and #504 cutterheads.

With Pockets and Gibs Numbered

These cutterheads are balanced in the factory as a complete assembly with tool body, gibs, and filler strips.

1. Gibs and pockets are numbered, and must ALWAYS stay in the same location. Do NOT balance gibs, since they have been balanced as an assembly.
2. If a gib is lost or misplaced, then the entire cutterhead unit must be rebalanced.

NOTE: PowerLock cutterheads no longer are being manufactured with the bolts installed in the end of the tool body, so you will receive tools that may or may not have these bolts. Either way, each is balanced and ready for production.

RPM	KNIFE MARKS PER INCH	FPM PER NUMBER OF KNIVES FINISH CUTTING					
		1	2	4	6	8	10
6000	10	50'	100'	200'	300'	400'	500'
	12	41'	83'	166'	250'	333'	416'
	14	35'	71'	142'	214'	285'	357'
	16	31'	62'	125'	187'	254'	312'
	18	27'	55'	111'	166'	222'	277'
	20	25'	50'	100'	150'	200'	250'
8000	10	66'	133'	266'	400'	533'	666'
	12	55'	111'	222'	333'	444'	555'
	14	47'	95'	190'	285'	300'	476'
	16	41'	83'	166'	250'	333'	416'
	18	37'	74'	148'	222'	296'	370'
	20	33'	66'	133'	200'	266'	333'
10,000	10	83'	167'	333'	500'	—	—
	12	69'	139'	278'	417'	—	—
	14	60'	119'	238'	357'	—	—
	16	52'	104'	208'	313'	—	—
	18	46'	93'	185'	278'	—	—
	20	42'	83'	167'	250'	—	—
12,000	10	100'	—	—	—	—	—
	12	82'	—	—	—	—	—
	14	70'	—	—	—	—	—
	16	62'	—	—	—	—	—
	18	54'	—	—	—	—	—
	20	50'	—	—	—	—	—

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



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Recommended Cutterhead Cutting Angle



The following chart should be used as a general guideline when purchasing moulder tooling.

- Cutterheads with a 20° cutting angle should be used for the majority of wood species machined in North America. This especially is recommended for use on 10,000 rpm and 12,000 rpm Powermats.
- Cutterheads with a 12° cutting angle should be used only for difficult species when tearout is a problem. However, remember that these cutterheads require 30% more horsepower and reduce knife life by a similar percentage.
- The following chart is to be used for materials with a moisture content between 6% and 9%. Higher moisture content generally requires a cutterhead of 20° or higher.

ALL MOULDERS 6,000-12,000 RPM 20° CUTTING ANGLE	6,000 RPM AND 8,000 RPM MOULDERS 12° CUTTING ANGLE	CALL WEINIG TOOLING DEPARTMENT FOR SPECIFICS
alder	cherry	cedar, western red
basswood	cypress	cottonwood
beech	exotic hardwoods	fir, douglas
fir	hickory	hemlock
MDF	maple, hard	synthetic materials
mahogany	maple, soft	all other species
oak, red	pecan	
oak, white		
pine		
pine, heart		
poplar		
spruce		
walnut		

These guidelines are the result of Weinig's many years of experience in machining wood. By following these guidelines, you will experience fewer horsepower-related moulder problems, and the material being machined will continue to have the exceptional Weinig-quality surface finish you expect and deserve.

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Following is a convenient check list 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

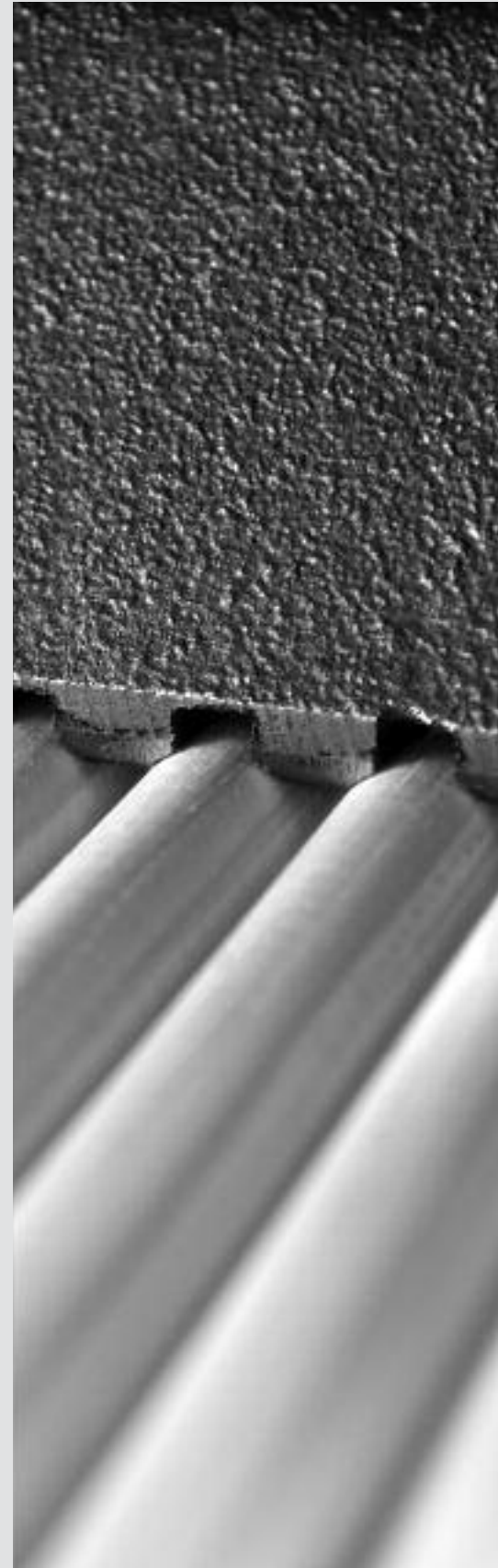
- Spindle diameter is worn, or spindle is bent
- Spindle bearings are worn (worn bearings may produce an inconsistent mark)
- Casting that the spindle barrel mounts into is worn
- Spindle slides are loose
- Spindle spacers are burred
- Wood chips between tool and spindle face or spacers
- Belt pulley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

Chatter

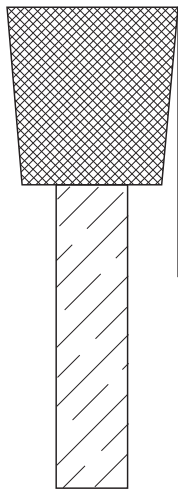
Chatter, an inconsistently patterned mark on the finished product, is caused by the product moving during the cut. The product must be held in a way that does not permit it to move (except in the direction of feed). Example: A counter-profile pressure shoe may be used to hold an uneven profile being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

Causes for chatter marks:

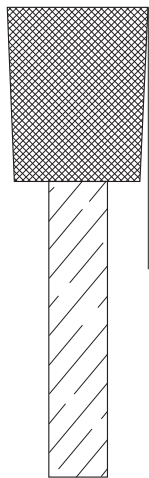
- Pressure shoe not aligned parallel to the bed
- Slides in pressure shoe are too tight or too loose
- Worn bed plates or fences
- Straight knives not ground parallel
- Undersized material



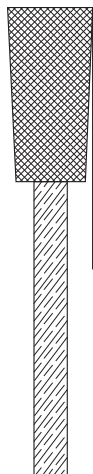
Ripsaw Blade Selection Guidelines



**Moulder
Blank
Blades**



**Glue-line
Blades**



**Thin Kerf
Blades**

MOULDER BLANK BLADES

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.

GLUE-LINE BLADES

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.

THIN KERF BLADES

- Offer savings on wood consumption.
- Reduced stability, so attaining a glue-line finish is difficult, but not impossible.
- Generally, blade characteristics are similar to those of glue line blades.

BENEFITS OFFERED BY NEW 'COATED' BLADES

Although these blades are slightly more expensive, the benefits far outweigh the additional cost.

- Increased run time
- Increased stability
- Increased lubricity
- Reduced buildup
- Reduced heat

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