

Solid Wood Technologies<sup>SM</sup>

# tooling catalog

Revised February 2011

**stiles**  
Your success is our business.



# Solid Wood Technologies<sup>SM</sup> Tooling Catalog

## Expect more.

Stiles carefully researches worldwide trends and analyzes information to align solutions, technologies and strategies to support their customer's needs. Solid Wood Technologies (SWT) is a comprehensive product line for solid wood applications. SWT is a direct response to customers who require Total Production Solutions<sup>SM</sup> – exceptional machinery and a team of solid wood and manufacturing experts in integration, consulting, service and support. Expect more – solid solutions from Stiles.

### World-class machines. And so much more.

When you buy machinery, you're also investing in the company that sells you that machine. Stiles engineers help customers gain a competitive edge in planning, implementing and maintaining an efficient manufacturing workflow process. Offering advanced equipment and integration, experienced manufacturing consulting and superior service and support, Stiles provides the long-term value you can only get from the experts. It's all part of our commitment to your success.

# Solid Wood Technologies<sup>SM</sup>

## Tooling Catalog

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Your machinery investment is essential to the success of your business and the tooling you use on that machinery is no exception. High quality tooling allows your machine to operate at maximum efficiency, yielding high production and the best product delivered to your customers. Stiles is proud to offer superior tooling to extend the life of your machinery so it can produce the quality you and your customers expect. Don't compromise on your investment, use Stiles tooling.

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## Stiles Tooling Services

At Stiles, we recognize that your moulder is a very important investment in your business. We offer a variety of services that allow maximum return on your investment without sacrificing quality for price.

- Large inventory of high-quality knife steel in 25" bars, straight bore and Hydro-Bore cutterheads
- Bore concentricity of 20 microns
- Dynamically balanced to G1.8
- For greater accuracy and repeatability Hydro-Bore heads include:
  - Advanced O-ring construction
  - Full bore contact
  - 300-350 bar pressure
- Insert tooling
- Custom tooling

M2 <sup>+</sup> High Speed Steel (Per Inch)	Finish	Rough
Profile Ground up to 2 1/4"	\$18.00	\$12.00
Profile Ground 2 1/2 to 3"	\$20.00	\$13.00
X-Life, M3 & T1 High Speed Steel (Per Inch)	Finish	Rough
Profile Ground up to 2 1/4"	\$20.00	\$13.00
Profile Ground 2 1/2 to 3"	\$23.00	\$15.00
Straight Knives (Per Inch)	\$12.00	
Williams and Hussey (Per Inch)	Finish	
Profile Ground up to 2 1/4"	\$18.00	
Profile Ground 2 1/2 to 3"	\$20.00	
Inlay Carbide (Per Inch)		
Profile Ground up to 2"	\$35.00	
Profile Ground Greater than 2"	\$45.00	
Straight Knives (1 1/2")	\$25.00	
Euro Back Precision Carbide System	Finish	
Straight, 1 1/2" Width, Backer and Carbide	\$40.00	
Profile, 2" Width, Backer and Carbide	\$55.00	
Profile, 2" Width, Carbide Only	\$45.00	
Profile, 2 3/8" Width, Backer and Carbide	\$65.00	
Profile, 2 3/8" Width, Carbide Only	\$55.00	
Resharpener (Per Inch)		
Straight, High Speed Steel	\$2.50	
Profile, High Speed Steel	\$5.00	
Straight, Carbide	\$5.00	
Profile, Carbide	\$11.00	

Templates	
Custom Design	\$30.00
From Online Catalog	\$20.00
Replacement Template	\$15.00
Custom Pressure Shoe	From \$180.00

Ultra+ Steel (Per Inch)	Finish
Profile Ground up to 2 1/4"	\$23.00
Profile Ground 2 1/2"	\$24.00

## Template and Knife Grinding Services

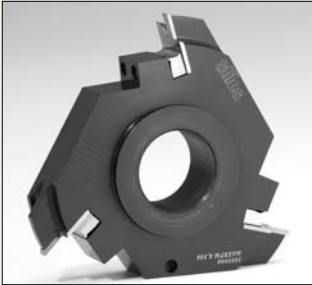
Precision knives begin with a precision template. Let Stiles take the guesswork out of producing a high-quality product.

- Send us a sample or drawing of your product, and we will provide a CAD drawing to produce the template and knives. Upon your approval of the drawing and layout, we will make the precision template and knives to the specifications using only high-quality materials.
- Knife steel grades are offered in M2, M3, T1, X-Life, Ultra+ inlay carbide, and Euro-back precision carbide. If you require something else, please contact us.

Stiles offers an online profile catalog featuring over 11,000 professionally drawn profiles. The intuitive search function allows you to quickly narrow your search and find what you are looking for.

Go to: [www.stilesmachinery.com/profiles](http://www.stilesmachinery.com/profiles) to view the online profile catalog.

## Custom Cutterheads



Delivering exactly what the customer needs, no matter how original the product, Stiles can provide you with the custom solution. Custom moulder tooling, including diamond and carbide, is available.

## Smooth Bore Cutterheads

Kentwood cutterheads are made from high-quality steel and precision engineering to offer you a superior product.

The balance quality of the Stiles tooling range of cutterheads is of a much higher standard than that specified in the appropriate tooling standards.

Standard specification ISO 1940-1: Quality level = G16 or 152gmm

Stiles quality level = G1.8

All cutterheads are ground to ensure the concentricity of the bore to the outside diameter and the squareness of the bore to each end face. This ensures there is no bending of the machine spindle on mounting of the cutterhead and hence no vibration problems due to cutterheads running out of true.

Each cutterhead has an end-of-life line turned into its side. This indicates when the knives have reached the end of their intended life and require replacement.

## Fitting Knives

1. Ensure all components are clean.
2. Check the serration angle in the cutterhead matches the serration angle of the knives.
3. Insert wedge and cutter into the knife slot.
4. Make sure all knives seat correctly when in position.
5. Using a torque wrench, tighten all screws to 23 - 25ft./lbs. torque, in the correct sequence, from the center to the outside of the cutterhead.
6. Balanced pairs of dummy knives must be used in opposite unused slots.

## Maximum Speeds

9,000 rpm (for cutterheads 150mm diameter and below)

8,000 rpm (for cutterheads above 150mm diameter)

Standard cutterheads are offered in:

- angles of 12, 20, and dual angle (12/20)
- 40mm, 1 13/16", and 1 1/2" bore
- cutting lengths of 60, 80, 100, 130, 150, 180, 230, 240 and 310mm

**Additional sizes, angles and bores are available upon request.**



## 40MM Bore Cutterheads

### 12 Degree 4-Pocket Heads

Part Number	Length (mm)	Length (In)	Bore	Diameter (mm)	Knives	Angle	Price
55-012-60122	60	2.36	40mm	122	4	12	\$146.00
55-012-80122	80	3	40mm	122	4	12	\$174.60
55-012-10122	100	4	40mm	122	4	12	\$205.00
55-012-13122	130	5	40mm	122	4	12	\$262.00
55-012-15122	150	6	40mm	122	4	12	\$299.39
55-012-18122	180	7	40mm	122	4	12	\$351.09
55-012-23122	230	9	40mm	122	4	12	\$436.29
55-012-24122	240	9.44	40mm	122	4	12	\$455.25

### 20 Degree 4-Pocket Heads

Part Number	Length (mm)	Length (In)	Bore	Diameter (mm)	Knives	Angle	Price
55-020-60122	60	2.36	40mm	122	4	20	\$146.00
55-020-80122	80	3	40mm	122	4	20	\$174.60
55-020-10122	100	4	40mm	122	4	20	\$205.00
55-020-13122	130	5	40mm	122	4	20	\$262.00
55-020-15122	150	6	40mm	122	4	20	\$299.39
55-020-18122	180	7	40mm	122	4	20	\$351.09
55-020-23122	230	9	40mm	122	4	20	\$436.29
55-020-24122	240	9.44	40mm	122	4	20	\$455.25

### Dual Angle 12/20 4-Pocket Heads

Part Number	Length (mm)	Length (In)	Bore	Diameter (mm)	Knives	Angle	Price
55-122-60122	60	2.36	40mm	122	4	12/20	\$138.70
55-122-80122	80	3	40mm	122	4	12/20	\$165.87
55-122-10122	100	4	40mm	122	4	12/20	\$194.75
55-122-13122	130	5	40mm	122	4	12/20	\$248.90
55-122-15122	150	6	40mm	122	4	12/20	\$284.42
55-122-18122	180	7	40mm	122	4	12/20	\$333.54
55-122-23122	230	9	40mm	122	4	12/20	\$414.48
55-122-24122	240	9.44	40mm	122	4	12/20	\$432.49

## 1 1/4" Bore Cutterheads

### Dual Angle 12/20 4-Pocket Heads

Part Number	Length (mm)	Length (In)	Bore	Diameter (mm)	Knives	Angle	Price
55-100-00050	50	2	1.25	100	4	12/20	\$117.00
55-100-00060	60	2.36	1.25	100	4	12/20	\$133.00
55-100-00080	80	3	1.25	100	4	12/20	\$147.00
55-100-00100	100	4	1.25	100	4	12/20	\$175.00
55-100-10015	150	6	1.25	100	4	12/20	\$250.00

### Spiral Cutterheads for Shaper

Part Number	Length (mm)	Length (In)	Bore	Diameter (mm)	Rows	Price
55-100-50100	50	2	1.25	100	6	\$117.00
55-100-10010	100	4	1.25	100	6	\$133.00
55-100-00150	150	6	1.25	100	6	\$147.00

# 1 1/2" Bore Cutterheads

## 12 Degree 4-Pocket Heads

Part Number	Length (mm)	Length (In)	Bore	Diameter (mm)	Knives	Angle	Price
55-012-06038	60	2.36	1 1/2"	122	4	12	\$146.00
55-012-08038	80	3	1 1/2"	122	4	12	\$174.60
55-012-10038	100	4	1 1/2"	122	4	12	\$205.00
55-012-13038	130	5	1 1/2"	122	4	12	\$262.00
55-012-15038	150	6	1 1/2"	122	4	12	\$299.39
55-012-18038	180	7	1 1/2"	122	4	12	\$351.09
55-012-23038	230	9	1 1/2"	122	4	12	\$436.29
55-012-24038	240	9.44	1 1/2"	122	4	12	\$455.25

## 12 Degree 2-Pocket Heads

Part Number	Length (mm)	Length (In)	Bore	Diameter (mm)	Knives	Angle	Price
55-212-06038	60	2.36	1 1/2"	122	2	12	\$146.00
55-212-08038	80	3	1 1/2"	122	2	12	\$174.60
55-212-10038	100	4	1 1/2"	122	2	12	\$205.00
55-212-13038	130	5	1 1/2"	122	2	12	\$262.00
55-212-15038	150	6	1 1/2"	122	2	12	\$299.39
55-212-18038	180	7	1 1/2"	122	2	12	\$320.00
55-212-23038	230	9	1 1/2"	122	2	12	\$403.57
55-212-24038	240	9.44	1 1/2"	122	2	12	\$421.10

## 20 Degree 4-Pocket Heads

Part Number	Length (mm)	Length (In)	Bore	Diameter (mm)	Knives	Angle	Price
55-020-06038	60	2.36	1 1/2"	122	4	20	\$146.00
55-020-08038	80	3	1 1/2"	122	4	20	\$174.60
55-020-10038	100	4	1 1/2"	122	4	20	\$205.00
55-020-13038	130	5	1 1/2"	122	4	20	\$262.00
55-020-15038	150	6	1 1/2"	122	4	20	\$299.39
55-020-18038	180	7	1 1/2"	122	4	20	\$351.09
55-020-23038	230	9	1 1/2"	122	4	20	\$436.29
55-020-24038	240	9.44	1 1/2"	122	4	20	\$455.25

## 20 Degree 2-Pocket Heads

Part Number	Length (mm)	Length (In)	Bore	Diameter (mm)	Knives	Angle	Price
55-202-06038	60	2.36	1 1/2"	122	2	20	\$146.00
55-202-08038	80	3	1 1/2"	122	2	20	\$174.60
55-202-10038	100	4	1 1/2"	122	2	20	\$205.00
55-202-13038	130	5	1 1/2"	122	2	20	\$262.00
55-202-15038	150	6	1 1/2"	122	2	20	\$299.39
55-202-18038	180	7	1 1/2"	122	2	20	\$320.00
55-202-23038	230	9	1 1/2"	122	2	20	\$403.57
55-202-24038	240	9.44	1 1/2"	122	2	20	\$421.10

## Dual Angle 12/20 4-Pocket Heads

Part Number	Length (mm)	Length (In)	Bore	Diameter (mm)	Knives	Angle	Price
55-122-06038	60	2.36	1 1/2"	122	4	12/20	\$131.79
55-122-08038	80	3	1 1/2"	122	4	12/20	\$160.05
55-122-10038	100	4	1 1/2"	122	4	12/20	\$189.54
55-122-13038	130	5	1 1/2"	122	4	12/20	\$240.16
55-122-15038	150	6	1 1/2"	122	4	12/20	\$278.60
55-122-18038	180	7	1 1/2"	122	4	12/20	\$326.71
55-122-23038	230	9	1 1/2"	122	4	12/20	\$424.17
55-122-24038	240	9.44	1 1/2"	122	4	12/20	\$440.00

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# 1 13/16" Bore Cutterheads

## 12 Degree 4-Pocket Heads

Part Number	Length (mm)	Length (In)	Bore	Diameter (mm)	Knives	Angle	Price
55-012-60137	60	2.36	1-13/16"	137	4	12	\$168.98
55-012-80137	80	3	1-13/16"	137	4	12	\$206.60
55-012-10137	100	4	1-13/16"	137	4	12	\$244.22
55-012-13137	130	5	1-13/16"	137	4	12	\$309.20
55-012-15137	150	6	1-13/16"	137	4	12	\$339.87
55-012-18137	180	7	1-13/16"	137	4	12	\$390.00
55-012-23137	230	9	1-13/16"	137	4	12	\$506.04
55-012-24137	240	9.44	1-13/16"	137	4	12	\$540.00
55-012-31137	310	12.2	1-13/16"	137	4	12	\$670.78

## 12 Degree 2-Pocket Heads

Part Number	Length (mm)	Length (In)	Bore	Diameter (mm)	Knives	Angle	Price
55-212-60137	60	2.36	1-13/16"	137	2	12	\$168.98
55-212-80137	80	3	1-13/16"	137	2	12	\$206.60
55-212-10137	100	4	1-13/16"	137	2	12	\$244.22
55-212-13137	130	5	1-13/16"	137	2	12	\$309.20
55-212-15137	150	6	1-13/16"	137	2	12	\$339.87
55-212-18137	180	7	1-13/16"	137	2	12	\$390.00
55-212-23137	230	9	1-13/16"	137	2	12	\$494.00
55-212-24137	240	9.44	1-13/16"	137	2	12	\$504.24
55-212-31137	310	12.2	1-13/16"	137	2	12	\$655.00

## 20 Degree 4-Pocket Heads

Part Number	Length (mm)	Length (In)	Bore	Diameter (mm)	Knives	Angle	Price
55-020-60137	60	2.36	1-13/16"	137	4	20	\$168.98
55-020-80137	80	3	1-13/16"	137	4	20	\$206.60
55-020-10137	100	4	1-13/16"	137	4	20	\$244.22
55-020-13137	130	5	1-13/16"	137	4	20	\$309.20
55-020-15137	150	6	1-13/16"	137	4	20	\$339.87
55-020-18137	180	7	1-13/16"	137	4	20	\$390.00
55-020-23137	230	9	1-13/16"	137	4	20	\$506.04
55-020-24137	240	9.44	1-13/16"	137	4	20	\$540.00
55-020-31137	310	12.2	1-13/16"	137	4	20	\$670.78

Part Number	Length (mm)	Length (In)	Bore	Diameter (mm)	Knives	Angle	Price
55-202-60137	60	2.36	1-13/16"	137	2	20	\$168.98
55-202-80137	80	3	1-13/16"	137	2	20	\$206.60
55-202-10137	100	4	1-13/16"	137	2	20	\$244.22
55-202-13137	130	5	1-13/16"	137	2	20	\$309.20
55-202-15137	150	6	1-13/16"	137	2	20	\$339.87
55-202-18137	180	7	1-13/16"	137	2	20	\$390.00
55-202-23137	230	9	1-13/16"	137	2	20	\$494.00
55-202-24137	240	9.44	1-13/16"	137	2	20	\$504.24
55-202-31137	310	12.2	1-13/16"	137	2	20	\$655.00

## Dual Angle 12/20 4-Pocket Heads

Part Number	Length (mm)	Length (In)	Bore	Diameter (mm)	Knives	Angle	Price
55-122-60137	60	2.36	1-13/16"	137	4	12/20	\$152.40
55-122-80137	80	3	1-13/16"	137	4	12/20	\$186.52
55-122-10137	100	4	1-13/16"	137	4	12/20	\$220.48
55-122-13137	130	5	1-13/16"	137	4	12/20	\$279.14
55-122-15137	150	6	1-13/16"	137	4	12/20	\$320.99
55-122-18137	180	7	1-13/16"	137	4	12/20	\$376.78
55-122-23137	230	9	1-13/16"	137	4	12/20	\$478.31
55-122-24137	240	9.44	1-13/16"	137	4	12/20	\$498.00
55-122-31137	310	12.2	1 13/16"	137	4	12/20	\$642.83



# Hydro-Bore Cutterheads

The Kentwood Hydro-Bore series includes the same high quality standards and features as the smooth-bore series but offers additional benefits for a higher speed and more accurate performance.

Our advanced O-ring construction offers many advantages compared to typical sealed systems:

- Construction allows a higher pressure (350 bar) to be used evenly down the length of the spindle, which in turn allows increased torque transmission between cutterhead and spindle.
- The increased torque means less chance of slippage; therefore, better surface finish and increased efficiency of the machine.
- The advanced O-ring construction has less likelihood of leakage occurring due to wear in a sealed system; therefore, less likelihood of incurring machine downtime or damage due to loss of pressure.

**Standard lengths, angles, bores, and knife slots are offered.  
Other sizes are available upon request.**

Using a torque wrench, tighten all screws to 23 - 25ft./lbs. torque, in the correct sequence, from the center to the outside of the cutterhead.

**The use of safety collars is required** to afford the protection of safe and positive drive if pressure in the block is not present.

Ensure that the cutterhead bore and spindle are clean and free from burrs or deep scratches. The efficiency of the friction drive is determined by the quality of contact between the cutterhead bore and the machine spindle. Failure to ensure clean conditions may cause a reduction in the power transmission properties of the cutterhead.

The cutterhead must never be pressurized unless mounted on the machine spindle or grinding arbor, as distortion of the inner sleeve may occur.

Operating pressure is 300 - 350 bar.

Check pressure daily, using grease pump before operating machine.

Release valves must be left open if the cutterhead is immersed in a cleaning tank or not used.

Maximum Speed: 8,000 rpm for cutterheads 150mm diameter and smaller  
6,000 rpm for 163mm diameter cutterheads

# Hydro-Bore Cutterheads



\*Advanced O-ring construction  
\*Full length bore contact

Part Number	Length (mm)	Length (In)	Bore	Diameter (mm)	Knives	Angle	Price
55-154-06012	60	2.36	1-13/16"	150	4	12	283.99
55-154-08012	80	3	1-13/16"	150	4	12	336.96
55-154-10012	100	4	1-13/16"	150	4	12	389.93
55-154-13012	130	5	1-13/16"	150	4	12	469.39
55-154-15012	150	6	1-13/16"	150	4	12	553.26
55-154-18012	180	7	1-13/16"	150	4	12	638.60
55-154-23012	230	9	1-13/16"	150	4	12	804.87
55-154-24012	240	9.44	1-13/16"	150	4	12	838.71
55-154-31012	310	12	1-13/16"	150	4	12	1,025.59
55-154-06020	60	2.36	1-13/16"	150	4	20	283.99
55-154-08020	80	3	1-13/16"	150	4	20	336.96
55-154-10020	100	4	1-13/16"	150	4	20	389.93
55-154-13020	130	5	1-13/16"	150	4	20	469.39
55-154-15020	150	6	1-13/16"	150	4	20	553.26
55-154-18020	180	7	1-13/16"	150	4	20	638.60
55-154-23020	230	9	1-13/16"	150	4	20	804.87
55-154-24020	240	9.44	1-13/16"	150	4	20	838.71
55-154-31020	310	12	1-13/16"	150	4	20	1,025.59
55-156-06012	60	2.36	1-13/16"	150	6	12	317.83
55-156-08012	80	3	1-13/16"	150	6	12	378.16
55-156-10012	100	4	1-13/16"	150	6	12	438.49
55-156-13012	130	5	1-13/16"	150	6	12	526.77
55-156-15012	150	6	1-13/16"	150	6	12	625.36
55-156-18012	180	7	1-13/16"	150	6	12	713.64
55-156-23012	230	9	1-13/16"	150	6	12	896.10
55-156-24012	240	9.44	1-13/16"	150	6	12	934.36
55-156-31012	310	12	1-13/16"	150	6	12	1,150.66
55-156-06020	60	2.36	1-13/16"	150	6	20	317.83
55-156-08020	80	3	1-13/16"	150	6	20	378.16
55-156-10020	100	4	1-13/16"	150	6	20	438.49
55-156-13020	130	5	1-13/16"	150	6	20	526.77
55-156-15020	150	6	1-13/16"	150	6	20	625.36
55-156-18020	180	7	1-13/16"	150	6	20	713.64
55-156-23020	230	9	1-13/16"	150	6	20	896.10
55-156-24020	240	9.44	1-13/16"	150	6	20	934.36
55-156-31020	310	12	1-13/16"	150	6	20	1,150.66
55-158-06012	60	2.36	1-13/16"	150	8	12	409.06
55-158-08012	80	3	1-13/16"	150	8	12	484.10
55-158-10012	100	4	1-13/16"	150	8	12	559.14
55-158-13012	130	5	1-13/16"	150	8	12	663.25
55-158-15012	150	6	1-13/16"	150	8	12	774.53
55-158-18012	180	7	1-13/16"	150	8	12	882.49
55-158-23012	230	9	1-13/16"	150	8	12	1,121.60
55-158-24012	240	9.44	1-13/16"	150	8	12	1,170.36
55-158-31012	310	12	1-13/16"	150	8	12	1,444.58

## Hydro-Bore Cutterheads *continued*

Part Number	Length (mm)	Length (In)	Bore	Diameter (mm)	Knives	Angle	Price
55-158-06020	60	2.36	1-13/16"	150	8	20	409.06
55-158-08020	80	3	1-13/16"	150	8	20	484.10
55-158-10020	100	4	1-13/16"	150	8	20	559.14
55-158-13020	130	5	1-13/16"	150	8	20	663.25
55-158-15020	150	6	1-13/16"	150	8	20	774.53
55-158-18020	180	7	1-13/16"	150	8	20	882.49
55-158-23020	230	9	1-13/16"	150	8	20	1,121.60
55-158-24020	240	9.44	1-13/16"	150	8	20	1,170.36
55-158-31020	310	12	1-13/16"	150	8	20	1,444.58
55-164-06012	60	2.36	50mm	150	4	12	283.99
55-164-08012	80	3	50mm	150	4	12	336.96
55-164-10012	100	4	50mm	150	4	12	389.93
55-164-13012	130	5	50mm	150	4	12	469.39
55-164-15012	150	6	50mm	150	4	12	553.26
55-164-18012	180	7	50mm	150	4	12	638.60
55-164-23012	230	9	50mm	150	4	12	804.87
55-164-24012	240	9.44	50mm	150	4	12	838.71
55-164-31012	310	12	50mm	150	4	12	1,025.59
55-164-06020	60	2.36	50mm	150	4	20	283.99
55-164-08020	80	3	50mm	150	4	20	336.96
55-164-10020	100	4	50mm	150	4	20	389.93
55-164-13020	130	5	50mm	150	4	20	469.39
55-164-15020	150	6	50mm	150	4	20	553.26
55-164-18020	180	7	50mm	150	4	20	638.60
55-164-23020	230	9	50mm	150	4	20	804.87
55-164-24020	240	9.44	50mm	150	4	20	838.71
55-164-31020	310	12	50mm	150	4	20	1,025.59
55-166-06012	60	2.36	50mm	150	6	12	317.83
55-166-08012	80	3	50mm	150	6	12	378.16
55-166-10012	100	4	50mm	150	6	12	438.49
55-166-13012	130	5	50mm	150	6	12	526.77
55-166-15012	150	6	50mm	150	6	12	625.36
55-166-18012	180	7	50mm	150	6	12	713.64
55-166-23012	230	9	50mm	150	6	12	896.10
55-166-24012	240	9.44	50mm	150	6	12	934.36
55-166-31012	310	12	50mm	150	6	12	1,150.66
55-166-06020	60	2.36	50mm	150	6	20	317.83
55-166-08020	80	3	50mm	150	6	20	378.16
55-166-10020	100	4	50mm	150	6	20	438.49
55-166-13020	130	5	50mm	150	6	20	526.77
55-166-15020	150	6	50mm	150	6	20	625.36
55-166-18020	180	7	50mm	150	6	20	713.64
55-166-23020	230	9	50mm	150	6	20	896.10
55-166-24020	240	9.44	50mm	150	6	20	934.36
55-166-31020	310	12	50mm	150	6	20	1,150.66

# Hydro-Bore Cutterheads *continued*

Part Number	Length (mm)	Length (In)	Bore	Diameter (mm)	Knives	Angle	Price
55-168-06012	60	2.36	50mm	163	8	12	414.94
55-168-08012	80	3	50mm	163	8	12	491.46
55-168-10012	100	4	50mm	163	8	12	569.44
55-168-13012	130	5	50mm	163	8	12	673.91
55-168-15012	150	6	50mm	163	8	12	787.21
55-168-18012	180	7	50mm	163	8	12	897.57
55-168-23012	230	9	50mm	163	8	12	1,141.83
55-168-31012	310	12	50mm	163	8	12	1,467.01
55-168-06020	60	2.36	50mm	163	8	20	414.94
55-168-08020	80	3	50mm	163	8	20	491.46
55-168-10020	100	4	50mm	163	8	20	569.44
55-168-13020	130	5	50mm	163	8	20	673.91
55-168-15020	150	6	50mm	163	8	20	787.21
55-168-18020	180	7	50mm	163	8	20	897.57
55-168-23020	230	9	50mm	163	8	20	1,141.83
55-168-31020	310	12	50mm	163	8	20	1,467.01
55-174-06012	60	2.36	2 1/8"	150	4	12	283.99
55-174-08012	80	3	2 1/8"	150	4	12	336.96
55-174-10012	100	4	2 1/8"	150	4	12	389.93
55-174-13012	130	5	2 1/8"	150	4	12	469.39
55-174-15012	150	6	2 1/8"	150	4	12	553.26
55-174-18012	180	7	2 1/8"	150	4	12	638.60
55-174-23012	230	9	2 1/8"	150	4	12	804.87
55-174-24012	240	9.44	2 1/8"	150	4	12	838.71
55-174-31012	310	12	2 1/8"	150	4	12	1,025.59
55-174-06020	60	2.36	2 1/8"	150	4	20	283.99
55-174-08020	80	3	2 1/8"	150	4	20	336.96
55-174-10020	100	4	2 1/8"	150	4	20	389.93
55-174-13020	130	5	2 1/8"	150	4	20	469.39
55-174-15020	150	6	2 1/8"	150	4	20	553.26
55-174-18020	180	7	2 1/8"	150	4	20	638.60
55-174-23020	230	9	2 1/8"	150	4	20	804.87
55-174-24020	240	9.44	2 1/8"	150	4	20	838.71
55-174-31020	310	12	2 1/8"	150	4	20	1,025.59
55-176-06012	60	2.36	2 1/8"	150	6	12	317.83
55-176-08012	80	3	2 1/8"	150	6	12	378.16
55-176-10012	100	4	2 1/8"	150	6	12	438.49
55-176-13012	130	5	2 1/8"	150	6	12	526.77
55-176-15012	150	6	2 1/8"	150	6	12	625.36
55-176-18012	180	7	2 1/8"	150	6	12	713.64
55-176-23012	230	9	2 1/8"	150	6	12	896.10
55-176-24012	240	9.44	2 1/8"	150	6	12	934.36
55-176-31012	310	12	2 1/8"	150	6	12	1,150.66

## Hydro-Bore Cutterheads *continued*

Part Number	Length (mm)	Length (In)	Bore	Diameter (mm)	Knives	Angle	Price
55-176-06020	60	2.36	2 1/8"	150	6	20	317.83
55-176-08020	80	3	2 1/8"	150	6	20	378.16
55-176-10020	100	4	2 1/8"	150	6	20	438.49
55-176-13020	130	5	2 1/8"	150	6	20	526.77
55-176-15020	150	6	2 1/8"	150	6	20	625.36
55-176-18020	180	7	2 1/8"	150	6	20	713.64
55-176-23020	230	9	2 1/8"	150	6	20	896.10
55-176-24020	240	9.44	2 1/8"	150	6	20	934.36
55-176-31020	310	12	2 1/8"	150	6	20	1,150.66
55-178-06012	60	2.36	2 1/8"	163	8	12	414.94
55-178-08012	80	3	2 1/8"	163	8	12	491.46
55-178-10012	100	4	2 1/8"	163	8	12	569.44
55-178-13012	130	5	2 1/8"	163	8	12	673.91
55-178-15012	150	6	2 1/8"	163	8	12	787.21
55-178-18012	180	7	2 1/8"	163	8	12	897.57
55-178-23012	230	9	2 1/8"	163	8	12	1,141.83
55-178-31012	310	12	2 1/8"	163	8	12	1,467.01
55-178-06020	60	2.36	2 1/8"	163	8	20	414.94
55-178-08020	80	3	2 1/8"	163	8	20	491.46
55-178-10020	100	4	2 1/8"	163	8	20	569.44
55-178-13020	130	5	2 1/8"	163	8	20	673.91
55-178-15020	150	6	2 1/8"	163	8	20	787.21
55-178-18020	180	7	2 1/8"	163	8	20	897.57
55-178-23020	230	9	2 1/8"	163	8	20	1,141.83
55-178-31020	310	12	2 1/8"	163	8	20	1,467.01

## Safety Collars

Part Number	Description	Price
55-256-00046	1 13/16" Standard	\$93.00
55-256-00050	50mm Standard	\$115.00
55-256-00054	2 1/8" Standard	\$115.00

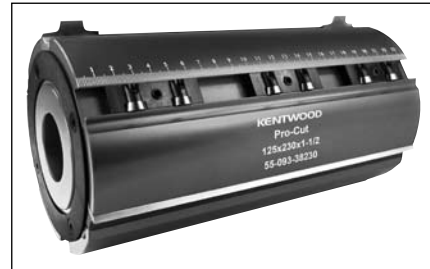
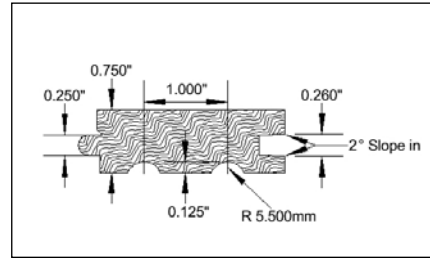
## Grease Fittings

Part Number	Description	Price
55-154-00931	Grease Fitting	\$8.10
55-154-00932	Replacement Seal	\$2.37
55-154-00933	Release Valve	\$9.48

## Pro-Cut Insert Planing/Profiling Cutterheads

The new Pro-Cut series of Kentwood cutterheads offer the ultimate in versatility while providing outstanding surface finish at an affordable price

Part Number	Length	Diameter	Bore	Price	Carbide Upcharge (Set)
55-093-38100	100mm	125mm	1 1/2"	\$413.10	\$65.36
55-093-38150	150mm	125mm	1 1/2"	\$586.43	\$93.36
55-093-38180	180mm	125mm	1 1/2"	\$639.95	\$110.14
55-093-38230	230mm	125mm	1 1/2"	\$818.65	\$138.16
55-093-40100	100mm	125mm	40mm	\$413.10	\$65.36
55-093-40150	150mm	125mm	40mm	\$586.43	\$93.36
55-093-40180	180mm	125mm	40mm	\$639.95	\$110.14
55-083-40230	230mm	125mm	40mm	\$818.65	\$138.16
55-093-46100	100mm	140mm	1 13/16"	\$438.75	\$65.36
55-093-46150	150mm	140mm	1 13/16"	\$609.97	\$93.36
55-093-46180	180mm	140mm	1 13/16"	\$706.28	\$110.14
55-093-46230	230mm	140mm	1 13/16"	\$890.35	\$138.16
55-093-46305	310mm	140mm	1 13/16"	\$1,313.98	\$166.48



Heads come standard with one set of 18% Tungsten (T1) HSS knives.

## Pro-Cut Carbide Profile Knives

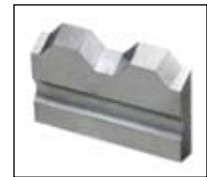
Part Number	Description	Price
56-093-10981	1/8" Radius	\$29.96
56-093-10975	3/16" Radius	\$29.96
56-093-10997	2mm Radius	\$29.96
56-093-10983	3mm Radius	\$29.96
56-093-10992	6mm Radius	\$29.96
56-093-10945	45 Degree Backout, 32mm wide	\$29.96
56-093-10947	Double Backout	\$29.96
56-093-10952	Double Bevel, 45 Degree	\$29.96
56-093-10998	Bead	\$29.96
56-093-10946	Blank	\$29.96
56-093-99999	Custom Profile (Includes Blank)	\$64.00
56-093-92000	Double Backout Holder	\$51.37
56-093-92001	Double Backout Knife	\$9.63



Radius



Double Bevel



Double Backout



Backout



Bead



Double Backout

Inserts are made from C3 grade carbide for long lasting performance.  
Custom inserts available per your drawings  
Max depth of profiles is 1/2"

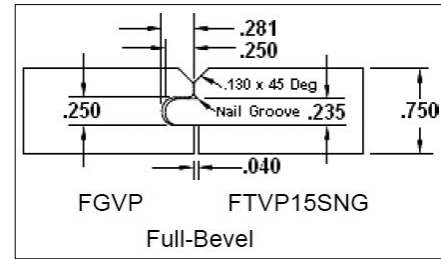
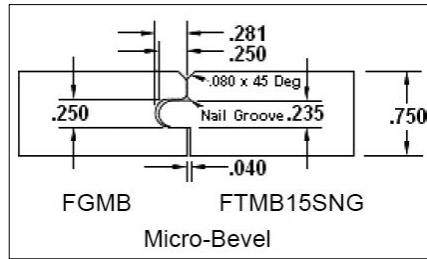
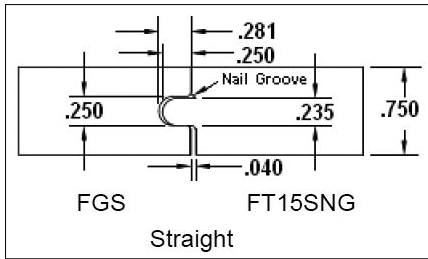
## Replacement S4S Knives

Part Number	Type	Length	Price
55-301-10100	HSS	100mm	\$9.79
55-302-10100	Carbide	100mm	\$32.68
55-301-10150	HSS	150mm	\$12.68
55-302-10150	Carbide	150mm	\$46.68
55-301-10180	HSS	180mm	\$15.40
55-302-10180	Carbide	180mm	\$55.07
55-301-10230	HSS	230mm	\$19.45
55-302-10230	Carbide	230mm	\$69.08
55-301-10310	HSS	310mm	\$29.00
55-302-10310	Carbide	310mm	\$83.24

- Light Weight High Strength Aluminum Design
- Easy Precision Knife Set-up
- Planing and Profiling Capabilities
- Outstanding Surface Finish

# Flooring/Paneling Cutterheads

Part Number	Description	Diameter	CEL	Wings	Bore	Price
55-300-16038	Groove Cutterhead	160mm	30mm	3	1 1/2"	\$385.00
55-301-16038	Tongue Cutterhead	160mm	30mm	3	1 1/2"	\$385.00
55-300-16040	Groove Cutterhead	160mm	30mm	3	40mm	\$385.00
55-301-16040	Tongue Cutterhead	160mm	30mm	3	40mm	\$385.00
55-300-16046	Groove Cutterhead	160mm	30mm	3	1 13/16"	\$385.00
55-301-16046	Tongue Cutterhead	160mm	30mm	3	1 13/16"	\$385.00

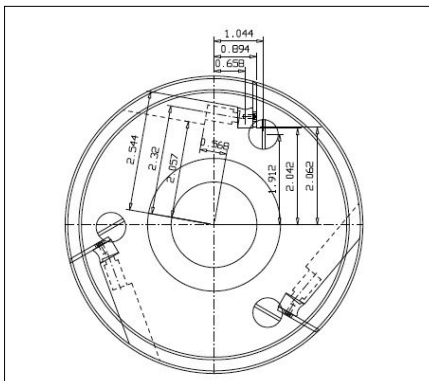


# Flooring/Paneling Carbide Inserts



Insert Part Number (with nail groove)	Insert Part Number (without nail groove)	Description	Price
	FGS	Groove Straight	\$26.32
	FGMB	Groove Straight- Micro Bevel	\$26.32
	FGVP	Groove Straight- V Panel	\$26.32
FT05SNG	FT05S	Tongue Straight- .005" Gap	\$26.32
FT15SNG	FT15S	Tongue Straight- .015" Gap	\$26.32
FTMB05NG	FTMB05	Tongue Straight- Micro Bevel .005" Gap	\$26.32
FTMB15NG	FTMB15	Tongue Straight- Micro Bevel .015" Gap	\$26.32
FTVP05NG	FTVP05	Tongue Straight- V Panel .005" Gap	\$26.32
FTVP15NG	FTVP15	Tongue Straight- V Panel .015" Gap	\$26.32

Minimum order qty of inserts is 6 for ea profile



## Multi-Profile Insert Cutterheads

The multi-profile insert cutterhead system allows the flexibility of using the same tool body to accommodate many different profiles. Steel backers and carbide inserts give you a precision profile with the convenience of an insert cutterhead. Steel backers are purchased just one time for each profile. Profiles can range from various tongue and groove to completely custom applications.

Part Number	Bore	Length	Wings	Price
55-555-40302	40mm	30mm	2	\$298.00
55-555-40402	40mm	40mm	2	\$419.20
55-555-40602	40mm	60mm	2	\$664.00
55-555-40802	40mm	80mm	2	\$853.65
55-555-40102	40mm	100mm	2	\$1,043.55
55-555-38302	1-1/2"	30mm	2	\$298.00
55-555-38402	1-1/2"	40mm	2	\$419.20
55-555-38602	1-1/2"	60mm	2	\$664.00
55-555-38802	1-1/2"	80mm	2	\$853.65
55-555-38102	1-1/2"	100mm	2	\$1,043.55
55-555-46302	1-13/16"	30mm	2	\$298.00
55-555-46402	1-13/16"	40mm	2	\$419.20
55-555-46602	1-13/16"	60mm	2	\$664.00
55-555-46802	1-13/16"	80mm	2	\$853.65
55-555-46102	1-13/16"	100mm	2	\$1,043.55
55-555-40303	40mm	30mm	3	\$373.50
55-555-40403	40mm	40mm	3	\$554.50
55-555-40603	40mm	60mm	3	\$877.65
55-555-40803	40mm	80mm	3	\$1,088.90
55-555-40103	40mm	100mm	3	\$1,302.00
55-555-38303	1-1/2"	30mm	3	\$373.50
55-555-38403	1-1/2"	40mm	3	\$554.50
55-555-38603	1-1/2"	60mm	3	\$877.65
55-555-38803	1-1/2"	80mm	3	\$1,088.90
55-555-38103	1-1/2"	100mm	3	\$1,302.00
55-555-46303	1-13/16"	30mm	3	\$373.50
55-555-46403	1-13/16"	40mm	3	\$554.50
55-555-46603	1-13/16"	60mm	3	\$877.65
55-555-46803	1-13/16"	80mm	3	\$1,088.90
55-555-46103	1-13/16"	100mm	3	\$1,302.00

Max Depth of profile: 20-25mm (Depending on application).  
Cutting Circle: 125mm minimum / 175mm maximum.

## Carbide Inserts

Part Number	Size	Price
56-555-03035	30x35, for 30mm heads	\$32.49
56-555-03040	30x40, for 30mm heads	\$36.10
56-555-03045	30x45, for 30mm heads	\$39.70
56-555-04035	40x35, for 40mm heads	\$39.35
56-555-04040	40x40, for 40mm heads	\$41.32
56-555-04045	40x45, for 40mm heads	\$42.77
56-555-06035	60x35, for 60mm heads	\$50.58
56-555-06040	60x40, for 60mm heads	\$54.24
56-555-06045	60x45, for 60mm heads	\$58.65
56-555-08035	80x35, for 80mm heads	\$68.26
56-555-08040	80x40, for 80mm heads	\$79.92
56-555-08045	80x45, for 80mm heads	\$89.71
56-555-10035	100x35, for 100mm heads	
56-555-10040	100x40, for 100mm heads	\$101.99
56-555-10045	100-45, for 100mm heads	\$111.78

Inserts take 7-10 Days to produce. Minimum order of inserts is 6.

## Backers

Part Number	Size	Price
56-555-00030	for 30mm heads	\$39.18
56-555-00040	for 40mm heads	\$43.59
56-555-00060	for 60mm heads	\$50.21
56-555-00080	for 80mm heads	\$54.63
56-555-00100	for 100mm heads	\$60.14





# Spiral Insert Heads



Part Number	Body	Length (mm)	Length (In)	Bore	Diameter (mm)	Wing	Price
55-126-38100	Aluminum	100	4	1 1/2"	125	6	\$545.00
55-127-38100	Steel	100	4	1 1/2"	125	6	\$545.00
55-126-38150	Aluminum	150	6	1 1/2"	125	6	\$682.00
55-127-38150	Steel	150	6	1 1/2"	125	6	\$682.00
55-126-38180	Aluminum	180	7	1 1/2"	125	6	\$805.00
55-127-38180	Steel	180	7	1 1/2"	125	6	\$805.00
55-126-38230	Aluminum	230	9	1 1/2"	125	6	\$1,005.00
55-127-38230	Steel	230	9	1 1/2"	125	6	\$1,070.00
55-126-00100	Aluminum	100	4	40mm	125	6	\$545.00
55-127-00100	Steel	100	4	40mm	125	6	\$545.00
55-126-00150	Aluminum	150	6	40mm	125	6	\$682.00
55-127-00150	Steel	150	6	40mm	125	6	\$682.00
55-126-00180	Aluminum	180	7	40mm	125	6	\$805.00
55-127-00180	Steel	180	7	40mm	125	6	\$805.00
55-126-00230	Aluminum	230	9	40mm	125	6	\$1,005.00
55-127-00230	Steel	230	9	40mm	125	6	\$1,070.00
55-156-00100	Aluminum	100	6	1 13/16"	140	6	\$583.00
55-157-00100	Steel	100	6	1 13/16"	140	6	\$583.00
55-156-00150	Aluminum	150	6	1 13/16"	140	6	\$710.00
55-157-00150	Steel	150	6	1 13/16"	140	6	\$710.00
55-156-00230	Aluminum	230	9	1 13/16"	140	6	\$1,030.00
55-156-00231	Steel	230	9	1 13/16"	140	6	\$1,110.00
55-156-00305	Aluminum	305	12	1 13/16"	140	6	\$1,350.00
55-157-00305	Steel	305	12	1 13/16"	140	6	\$1,470.00

Replacement inserts 15x15x2.5 square face 55-154-00151 \$3.00 ea  
 Replacement inserts 15x15x2.5 8 radius face 55-154-00152 \$2.74 ea

Please call for a quote on custom cutterheads.

## First Bottom

Part Number	Body	Length (mm)	Length (In)	Bore	Diameter (mm)	Price
55-125-00519	Steel	180	7	1 1/2"	125	\$800.00
55-125-00528	Steel	230	9	1 1/2"	125	\$1,050.00
55-125-00529	Steel	180	7	40mm	125	\$800.00
55-125-00028	Steel	230	9	40mm	125	\$1,050.00
55-125-00269	Steel	230	9	1 13/16"	125	\$1,050.00
55-125-00292	Steel	240	9.44	1 13/16"	125	\$1,100.00
55-125-00291	Steel	305	12	1 13/16"	125	\$1,493.00

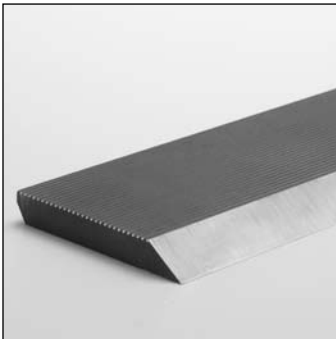
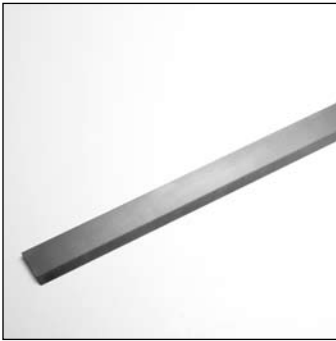
Replacement inserts 14x14x2 55-140-02460 \$1.82 ea

## Reference Engraver

Part Number	Bore	Price
55-125-00497	1 1/2"	\$280.31
55-305-00302	40mm	\$280.31
55-305-00304	1 13/16"	\$280.31

Replacement inserts 14x14x2 37 Degrees 55-140-03120 \$5.45 ea

# Knife Steel



## 25" Bars 5/16" Thick 60 Degree Corrugation

M2**		
56-025-20112	1 1/2"	\$55.00
56-025-20134	1 3/4"	\$61.00
56-025-20002	2"	\$68.00
56-025-20214	2 1/4"	\$74.58
56-025-20212	2 1/2"	\$81.89
56-025-20234	2 3/4"	\$112.42
56-025-20003	3"	\$122.29

X-Life		
56-025-40112	1 1/2"	\$89.19
56-025-40134	1 3/4"	\$96.48
56-025-40002	2"	\$108.65
56-025-40214	2 1/4"	\$121.98
56-025-40212	2 1/2"	\$133.87
56-025-40234	2 3/4"	\$156.00
56-025-40003	3"	\$175.54

Filler Stock		
56-025-20516	Bar, Filler Stock	\$45.00

Ultra+		
56-025-50112	1 1/2"	\$201.00
56-025-50134	1 3/4"	\$223.00
56-025-50002	2"	\$247.25
56-025-50214	2 1/4"	\$273.70
56-025-50212	2 1/2"	\$291.35

M3		
56-025-30112	1 1/2"	\$115.32
56-025-30134	1 3/4"	\$125.55
56-025-30002	2"	\$135.00
56-025-30214	2 1/4"	\$146.94
56-025-30238	2 3/8"	\$156.24
56-025-30212	2 1/2"	\$158.10
56-025-30234	2 3/4"	\$175.00
56-025-30003	3"	\$195.00

M2 1/4" Thick		
56-014-20114	1 1/4"	\$42.50
56-014-20112	1 1/2"	\$48.50
56-014-20134	1 3/4"	\$54.50
56-014-20002	2"	\$61.00
56-014-20214	2 1/4"	\$66.50
56-014-20212	2 1/2"	\$73.00

T1		
56-025-10112	1 1/2"	\$80.27
56-025-10134	1 3/4"	\$89.67
56-025-10002	2"	\$105.00
56-025-10214	2 1/4"	\$112.00
56-025-10212	2 1/2"	\$124.25
56-025-10234	2 3/4"	\$146.78
56-025-10003	3"	\$162.77

## High Speed Steel

Stiles offers only the best quality in knife steel. Made to precise tolerances with a consistent hardness and thickness to ensure accurate grinding and longer life.

- M2** • Most widely used HSS. Good wear characteristics, easy to grind and price makes M2 an overall best value. Used for short to medium runs.
- M3** • Offers increased wear resistance through higher contents of molybdenum, vanadium and carbon. Popular for longer production runs and for very hard woods.
- T1** • Tungsten content of 18% gives T1 a slightly harder makeup than other popular steels. Also a popular choice for longer production runs and finish quality.
- X-Life** • Stiles brand of HSS that has gone through a special heat treat process to provide "Extra Life". Extremely hard surface resists small chips from knots and other items that can cause lines or grooves down the length of the moulding. Nitride coated and used for long production runs. Easy to grind.
- Ultra+** • Special formulation to give the knife edge an unparalleled advantage in cutting life. Significant run life when compared to traditional M2, up to 5-10 times longer. This steel is the next best thing to carbide without the price and issues associated with grinding carbide.

## Pre-Cut and Balanced Filler Stock

Part Number	Length	Price (Per Set)
55-060-06025	60mm	\$9.50
55-060-08025	80mm	\$12.68
55-060-10025	100mm	\$15.85
55-060-13025	130mm	\$20.51
55-060-15025	150mm	\$23.77
55-060-18025	180mm	\$28.52
55-060-23025	230mm	\$36.45
55-060-31025	310mm	\$48.89

## Corrugated S4S Knives (Finish Ground)

Part Number	Length	Price
56-025-60000CR	150mm	\$145.00 pair
56-025-90000CR	230mm	\$200.00 pair

## Corrugated Carbide Inlay Knives

Part Number	25" Bars	Price
56-025-60112	1 1/2"	\$210.00
56-025-60134	1 3/4"	\$228.00
56-025-60002	2"	\$300.00
56-025-60238	2 3/8"	\$368.00

Cut fee- \$5.00 per cut

## Corrugated Insert S4S Knives for M409 Heads

Part Number	Length	Price
56-025-00155	155mm	\$65.00 each
56-025-00230	230mm	\$110.66 each
56-025-00060	60mm	\$42.35 each
56-025-00180	180mm	\$106.00 each

## Williams & Hussey Knives (Corrugated Back with Bevel Edge)

Part Number	25" Bars	Price	
56-030-20134	1 3/4"	\$65.00	1/4" Thick
56-030-20002	2"	\$73.00	1/4" Thick
56-030-20214	2 1/4"	\$81.00	1/4" Thick
56-030-20212	2 1/2"	\$87.90	1/4" Thick
56-030-20234	2 3/4"	\$145.38	5/16" Thick
56-030-30212	2 1/2"	\$293.55	Carbide Tipped

## Smooth Back Planer Knives

5/32" Thick x 2" Wide

D2-HCHC			M2	
Length	Part Number	Price	Part Number	Price
4.25"	56-400-30425	\$3.75	56-400-20425	\$5.00
4.5"	56-400-30450	\$3.97	56-400-20450	\$5.30
5"	56-400-30500	\$4.42	56-400-20500	\$5.89
6"	56-400-30600	\$5.30	56-400-20600	\$7.06
6.5"	56-400-30650	\$5.74	56-400-20650	\$7.65
7"	56-400-30700	\$6.18	56-400-20700	\$8.09
7.5"	56-400-30750	\$6.62	56-400-20750	\$8.83
8"	56-400-30800	\$7.27	56-400-20800	\$9.42
8.5"	56-400-30850	\$7.50	56-400-20850	\$10.00
9"	56-400-30900	\$7.95	56-400-20900	\$10.59
10"	56-400-31000	\$8.85	56-400-21000	\$11.77
10.5"	56-400-31050	\$9.27	56-400-21050	\$12.88
12"	56-400-31200	\$10.59	56-400-21200	\$14.13
13"	56-400-31300	\$11.48	56-400-21300	\$15.30
13.25"	56-400-31325	\$11.80	56-400-21325	\$15.60
14"	56-400-31400	\$12.36	56-400-21400	\$16.48
15"	56-400-31500	\$13.24	56-400-21500	\$17.66
16"	56-400-31600	\$14.13	56-400-21600	NA
20"	56-400-32000	\$17.66	56-400-22000	NA
25"	56-400-32500	\$22.07	56-400-22500	\$29.43
31"	56-400-33100	\$27.37	56-400-23100	\$36.49

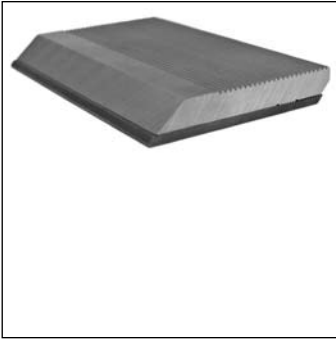
30 Degree Bevel  
Balanced in Pairs

## Centro-Lock™ Style Planer Knives

T1 HSS			Carbide	
Length	Part Number	Price	Part Number	Price
60mm	56-303-00060	\$4.85	56-304-00060	\$23.00
100mm	56-303-00100	\$8.00	56-304-00100	\$35.98
130mm	56-303-00130	\$8.50	56-304-00130	\$45.00
150mm	56-303-00150	\$9.75	56-304-00150	\$49.00
170mm	56-303-00170	\$11.10	56-304-00170	\$55.75
190mm	56-303-00190	\$12.50	56-304-00190	\$58.00
230mm	56-303-00230	\$15.00	56-304-00230	\$74.40
240mm	56-303-00240	\$15.75	56-304-00240	\$79.51
270mm	56-303-00270	\$17.60	56-304-00270	\$89.00
310mm	56-303-00310	\$23.00	56-304-00310	\$115.00

# Euro-Back Precision Carbide

## Standard Bevel 45°



Solid C3 micro-grain carbide knives, coupled with a corrugated backer, allows the flexibility and advantage of using carbide in conventional cutterheads. Best suited for cutting abrasive materials such as MDF, particleboard and plywood.

We only use the highest quality carbide available. A quality finish begins with quality, high-grade materials.

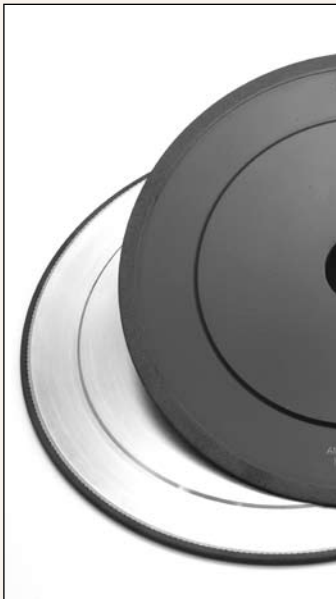
38mm Width				
Backer Set	Carbide Only		Set	Carbide Only
56-025-38060	56-026-38060	60MM	\$80.61	\$50.75
56-025-38080	56-026-38080	80MM	\$105.70	\$67.61
56-025-38100	56-026-38100	100MM	\$129.00	\$84.50
56-025-38130	56-026-38130	130MM	\$162.11	\$106.64
56-025-38150	56-026-38150	150MM	\$186.30	\$126.75
56-025-38180	56-026-38180	180MM	\$192.57	\$147.66
56-025-38230	56-026-38230	230MM	\$287.50	\$193.00
56-025-38310	56-026-38310	310MM	\$387.00	\$253.00

50mm Width				
Backer Set	Carbide Only		Set	Carbide Only
56-025-50060	56-026-50060	60MM	\$86.00	\$55.32
56-025-50080	56-026-50080	80MM	\$115.55	\$73.75
56-025-50100	56-026-50100	100MM	\$138.85	\$92.20
56-025-50130	56-026-50130	130MM	\$179.15	\$119.85
56-025-50150	56-026-50150	150MM	\$211.37	\$138.30
56-025-50180	56-026-50180	180MM	\$256.20	\$165.92
56-025-50230	56-026-50230	230MM	\$328.00	\$211.75
56-025-50310	56-026-50310	310MM	\$440.00	\$281.00

60mm Width				
Backer Set	Carbide Only		Set	Carbide Only
56-025-60060	56-026-60060	60MM	\$105.70	\$63.45
56-025-60080	56-026-60080	80MM	\$133.45	\$84.58
56-025-60100	56-026-60100	100MM	\$167.50	\$105.73
56-025-60130	56-026-60130	130MM	\$205.10	\$137.45
56-025-60150	56-026-60150	150MM	\$244.51	\$158.61
56-025-60180	56-026-60180	180MM	\$292.90	\$190.35
56-025-60230	56-026-60230	230MM	\$371.70	\$242.30
56-025-60310	56-026-60310	310MM	\$492.00	\$306.00

70mm Width				
Backer Set	Carbide Only		Set	Carbide Only
56-025-70060	56-026-70060	60MM	call	call
56-025-70080	56-026-70080	80MM	call	call
56-025-70100	56-026-70100	100MM	call	call
56-025-70130	56-026-70130	130MM	call	call
56-025-70150	56-026-70150	150MM	call	call
56-025-70180	56-026-70180	180MM	call	call
56-025-70230	56-026-70230	230mm	call	call
56-025-70310	56-026-70310	310MM	call	call

# Kentwood Grinding Wheels



Our grinding wheels have been carefully selected and tested in-house by our experienced personnel to ensure the best finish. 1/4" depth is standard on our super abrasive wheels.

If you require a wheel that is not listed here, please give us a call and we will get it.

Part Number	Bore	Size	Type	Grit	List
56-900-06025	60mm	2mm	CBN	120	\$220.00
56-901-06025	60mm	2mm	CBN	180	\$220.00
56-900-06013	60mm	2mm	Diamond	180	\$210.00
56-901-06013	60mm	2mm	CDX	120	\$215.00
56-900-06026	60mm	3mm	CBN	120	\$259.00
56-901-06026	60mm	3mm	CBN	180	\$259.00
56-900-60211	60mm	3mm	Diamond	180	\$215.00
56-900-06040	60mm	4mm	CBN	120	\$285.00
56-900-06041	60mm	4mm	Diamond	120	\$270.00
56-900-06042	60mm	4mm	CDX	80	\$265.00
56-900-06012	60mm	4.7mm	CBN	120	\$310.00
56-900-60210	60mm	4.7mm	Diamond	120	\$295.00
56-901-60210	60mm	4.7mm	CDX	80	\$285.00
56-900-06027	60mm	8mm Sq	CBN	180	\$395.00
56-900-60232	60mm	8mm Sq	Diamond	180	\$380.00

Part Number	Bore	Size	Type	Grit	List
56-900-00025	1.25"	2mm	CBN	120	\$220.00
56-901-00025	1.25"	2mm	CBN	180	\$220.00
56-900-00013	1.25"	2mm	Diamond	180	\$210.00
56-901-00013	1.25"	2mm	CDX	120	\$215.00
56-900-00026	1.25"	3mm	CBN	120	\$259.00
56-901-00026	1.25"	3mm	CBN	180	\$259.00
56-900-00211	1.25"	3mm	Diamond	180	\$215.00
56-900-00040	1.25"	4mm	CBN	120	\$285.00
56-900-00041	1.25"	4mm	Diamond	120	\$270.00
56-901-00041	1.25"	4mm	CDX	80	\$265.00
56-900-00012	1.25"	4.7mm	CBN	120	\$310.00
56-900-00210	1.25"	4.7mm	Diamond	120	\$295.00
56-901-00210	1.25"	4.7mm	CDX	80	\$285.00
56-900-00027	1.25"	8mm Sq	CBN	180	\$395.00
56-900-00232	1.25"	8mm Sq	Diamond	180	\$380.00

56-900-10002	Dressing Stick, Coarse	\$6.50
56-900-10001	Dressing Stick, Diamond Wheels	\$3.75
56-900-10000	Dressing Stick, CBN Wheels	\$4.50
56-900-76101	Sand-Flex	\$5.25

## Roughing Wheels

Part Number	Bore	Size	Type	Grit	List
56-900-06022	60mm	5mm	Ceramic	46/60	\$27.00
56-902-06022	60mm	5mm	Aluminum Oxide	54	\$17.00
56-901-06022	60mm	5mm	Ceramic	100	\$28.50

Part Number	Bore	Size	Type	Grit	List
56-900-00022	1.25"	5mm	Ceramic	46/60	\$27.00
56-902-00022	1.25"	5mm	Aluminum Oxide	54	\$17.00
56-901-00022	1.25"	5mm	Ceramic	100	\$28.50

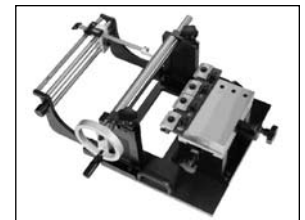
56-900-62100	Cup Wheel, Diamond for G602 Grinders	\$225.00
56-900-62101	Cup Wheel, CBN for G602 Grinders	\$260.00

## Tool Room Accessories and Services

Continuing with our commitment to your success, Stiles offers flexibility and convenience with our wide range of tool room accessories and services at affordable prices.

- Diamond and CBN grinding wheels
- Spindle repair
- Balancing
- Precision equipment to ensure exact setting and measurements

PART NUMBER	DESCRIPTION	PRICE
55-900-00001	HWM/SERIES HARDWOOD MOULDING PATTERNS CATALOG	\$18.50
55-900-00002	WMDF SERIES WOOD MOULDING PATTERNS CATALOG	\$18.50
55-900-00003	WM/SERIES SOFTWOOD MOULDING PATTERNS CATALOG	\$18.50
55-900-00004	WET STONE	\$9.00
55-900-00005	GAGE, ANGLE PROTRACTOR	\$15.90
55-900-00006	BLUEING	\$4.30
55-900-00007	SCRIBE, CARBIDE	\$4.45
55-900-00008	SQUARE, MACHINIST 4 INCH	\$16.85
55-900-00009	BASTARD FILES 6 INCH MILL-HALF-ROUND WITH HANDLES	\$20.05
55-900-00010	HACK SAW WITH METAL BLADE	\$8.25
55-900-00011	SCALE, BALANCING 2KG-5LB HARVARD TRIP 1400/1500	\$248.00
55-900-00012	SCALE, DIGITAL 2000G CAPACITY .1 GRAM RESOLUTION	\$334.00
55-900-00017	BLOCK, GRANITE 12X12	\$65.00
55-900-00020	STRAIGHT EDGE 12"	\$67.54
56-900-00010	FILTER, TRAY WHITE	\$10.00
97-009-00005	CALIPER, DIGITAL 6"	\$146.00
99-150-00004	LUBRICANT, TABLE WAXLIT USED WHERE WOOD SLIDES OVER METAL 5KG CAN LIQUID	\$41.00
55-308-01025	RADIUS MEASURING STAND	\$925.00
55-308-01045	RADIUS MEASURING STAND, 1 1/2" BORE	\$925.00
55-308-01046	RADIUS MEASURING STAND, 1 13/16" BORE	\$925.00
56-235-00006	TEMPLATE MATERIAL, STEEL, 330mmX85mmX1.5mm	\$33.30
56-235-00007	TEMPLATE MATERIAL, BLUE ACYRLIC SHEET 8.5"X12.5"	\$6.25
56-170-00138	GRINDING COOLANT, 1 GALLON	\$27.00
56-170-00139	GRINDING COOLANT, 5 GALLON BUCKET	\$120.00
56-170-00145	GRINDING COOLANT ADDITIVE, ANTI-BACTERIAL	\$65.85
55-140-02580	HIGH PRESSURE GREASE GUN WITH GUAGE	\$515.00
55-050-40110	INSERTION TOOL TO ASSIST WITH MOUNTING LARGE CUTTERHEADS	\$140.00
55-308-00052	12" HORIZONTAL MEASURING STAND	\$2,800.00



## Jointing Stones

Part Number	Size	Grit	Color	Description	Price
56-092-04003	230 x 60 x 15	600	GREEN	SC9 600-G9 RE DM ATLANTIC RESIN BOND	\$36.72
56-092-04004	230 x 60 x 15	600	BLUE-GREY	SC9 600-0-75 VUC8 ATLANTIC VITRIFIED BOND	\$40.00
56-092-04005	160 x 60 x 15	600	GREEN	SC9 600-G9 RE DM ATLANTIC RESIN BOND	\$27.10
56-092-04006	160 x 60 x 15	600	BLUE-GREY	SC9 600-0-75 VUC8 ATLANTIC VITRIFIED BOND	\$33.22
56-092-04007	12mm ROUND	320	BLUE-GREY	12mm x 1 1/2" LONG FOR STRAIGHT KNIVES	\$4.93

If you need something not listed, give us a call.

# Stiles Education



To achieve the desired results from any moulded product requires a combination of things. First you must have the right moulder that is adjusted to specifications. Next, properly ground and mounted tooling is paramount. Lastly, trained personnel to set-up your moulder and correctly use your tooling ensures quality and efficient production.

Stiles Education is the learning place that the industry's leading companies trust to train their people. Ours is the only internationally accredited woodworking educational program, certified by the International Association of Continuing Education and Training. Students who successfully complete Stiles Education courses receive a certificate of completion and continuing education credits (CEU).

For more information contact Diana Turner at 616.698.7500 ext. 1625 or [dturner@stilesmachinery.com](mailto:dturner@stilesmachinery.com)

## WD055 Moulder Knife Grinding Concepts

### Course description

This course will provide comprehensive instruction on proper setup and operation of knife grinding equipment. Identification and selection of proper tool grades for specific wood species and finish texture will be covered. Additional topics will include selection of grinding wheels and proper use of calipers and the Accu-Lok™ System to reference knife heads. Selection of steel grades for cutting knives along with management and organization of a productive tool room will be included.

### Major topics

- Machine safety
- Grinder nomenclature and component systems
- Grinder wheel selection and setup
- Selecting steel grade for knife tooling
- Using calipers and the Accu-lok™ System to reference knife heads

### What you will learn

- Proper grinding procedures
- Component identification
- Selecting the grade and dimension of steel based on desired finish
- Manual setup vs. the Accu-lok™ System to reference axial and radial points on the knife head
- Documentation and management of raw materials and tooling

## WD100 Moulder Operation

### Course description

This course provides comprehensive instruction on moulder setup, operation, tool referencing (Accu-lok System) and preventative maintenance. Instruction on identification and troubleshooting of defects will be emphasized in this session. Selection of the appropriate tooling and feed rates based on wood species and desired finish texture will also be discussed.

### Major topics

- Moulder nomenclature and component systems
- Proper operation procedures
- Selection of solid wood
- Cutterhead selection and setup
- Correct feed rates based on wood species and finish
- Preventative maintenance

### What you will learn

- How to accurately set up a moulder
- Proper operation procedures for consistency and quality
- How to minimize wasted wood by correctly referencing tooling
- How to identify defects and troubleshoot the cause

## Conversion Tables

inch	mm	inch	mm	mm	inch	mm	inch	mm	inch
0	0	1/2	0.5						
1/64	0.015625	0.3969	33/64	0.515625	13.0969				
1/32	0.03125	0.7938	17/32	0.5125	13.4938				
3/64	0.046875	1.1906	35/64	0.546875	13.8906				
1/16	0.0625	1.5875	9/16	0.5625	14.2875				
5/64	0.078125	1.9844	37/64	0.578125	14.6844				
3/32	0.09375	2.3812	19/32	0.59375	15.0812				
7/64	0.109375	2.7781	39/64	0.609375	15.4781				
1/8	0.125	3.1750	5/8	0.625	15.8750				
9/64	0.140625	3.5719	41/64	0.640625	16.2719				
5/32	0.15625	3.9688	21/32	0.65625	16.6688				
11/64	0.171875	4.3656	43/64	0.671875	17.0656				
3/16	0.1875	4.7625	11/16	0.6875	17.4625				
13/64	0.203125	5.1594	45/64	0.703125	17.8594				
7/32	0.21875	5.5562	23/32	0.71875	18.2562				
15/64	0.234375	5.9531	47/64	0.734375	18.6531				
1/4	0.25	6.3500	3/4	0.75	19.0500				
17/64	0.265625	6.7469	49/64	0.765625	19.4469				
9/32	0.28125	7.1438	25/32	0.78125	19.8438				
19/64	0.296875	7.5406	51/64	0.796875	20.2406				
5/16	0.3125	7.9375	13/16	0.8125	20.6375				
21/64	0.328125	8.3344	53/64	0.828125	21.0344				
11/32	0.34375	8.3712	27/32	0.84375	21.4312				
23/64	0.359375	9.1281	55/64	0.859375	21.8281				
3/8	0.375	9.5250	7/8	0.875	22.2250				
25/64	0.390625	9.9219	57/64	0.890625	22.6219				
13/32	0.40625	10.3188	29/32	0.90625	23.0188				
27/64	0.421875	10.7156	59/64	0.921875	23.4156				
7/16	0.4375	11.125	15/16	0.9375	23.8125				
29/64	0.453125	11.5094	61/64	0.953125	24.2094				
15/32	0.46875	11.9062	31/32	0.96875	24.6062				
31/64	0.484375	12.3031	63/64	0.984375	25.0031				

mm	inch	mm	inch	mm	inch
1	0.03937	36	1.41732	260	10.23622
2	0.07874	37	1.45669	270	10.62992
3	0.11811	38	1.49606	280	11.02362
4	0.15748	39	1.53543	290	11.41732
5	0.19685	40	1.57480	300	11.81102
6	0.23622	41	1.61417	310	12.20472
7	0.27559	42	1.65354	320	12.59842
8	0.31496	43	1.69291	330	12.99212
9	0.35433	44	1.73228	340	13.38582
10	0.39370	45	1.77165	350	13.77952
11	0.43307	46	1.81102	360	14.17322
12	0.47244	47	1.85039	370	14.56692
13	0.51181	48	1.88976	380	14.96062
14	0.55118	49	1.92913	390	15.35432
15	0.59055	50	1.96850	400	15.74803
16	0.62992	60	2.36220	410	16.14173
17	0.66929	70	2.75590	420	16.53543
18	0.70866	80	3.14960	430	16.92913
19	0.74803	90	3.54330	440	17.32280
20	0.78740	100	3.93700	450	17.71653
21	0.82677	110	4.33070	460	18.11023
22	0.86614	120	4.72440	470	18.50393
23	0.90551	130	5.11811	480	18.89763
24	0.94488	140	5.51181	490	19.29133
25	0.98425	150	5.90551	500	19.68503
26	1.02362	160	6.29921		
27	1.06299	170	6.69291		
28	1.10236	180	7.08661		
29	1.14173	190	7.48031		
30	1.18110	200	7.87401		
31	1.22047	210	8.26771		
32	1.25984	220	8.66141		
33	1.29921	230	9.05511		
34	1.33858	240	9.44881		
35	1.37795	250	9.84252		

1 mm = .03937 in.  
1 cm = .3937 in.  
1 m = 3.281 ft.  
  
1 in. = 25.4 mm  
1 ft = 304.8 mm  
1 yd. = 914.4 mm

## Knife Marks Per Inch

Wood	Knife Marks Per Inch
Ash	11 to 14
Basswood	8 to 12
Beech	12 to 14
Birch (plain)	12 to 14
Birch (curly)	13 to 16
Cedar	8 to 12
Cherry	12 to 14
Cottonwood	8 to 12
Cypress	8 to 12
Elm (hard)	10 to 13
Elm (soft)	8 to 12
Fir	8 to 12
Gum	9 to 13
Hemlock	8 to 12
Hickory	12 to 15
Mahogany (plain)	12 to 14
Mahogany (figured)	14 to 16
Maple	12 to 14
Oak	12 to 14
Pine (yellow)	9 to 13
Pine (white)	9 to 13
Poplar	9 to 13
Redwood	8 to 12
Spruce	8 to 12
Sycamore	11 to 14
Walnut	12 to 14

Knife finish ranges are generally recommended according to wood species.

## Finish and Feed Speed

R.P.M. x NO. KNIVES = KNIFE MARKS PER INCH  
FT. PER MIN. X 12

Finish quality is directly related to the feed speed of the machine. Using the recommended feed rate not only produces a quality finish, but it also minimizes the heat generated and increases the life of the tool. Please refer to this chart for the correct feed rate for the number of cutting knives in use. For speeds not listed, please contact the recommended feed rates.

RPM	KNIFE MARKS PER INCH	NUMBER OF CUTTING KNIVES									
		1	2	4	6	8	10	12	14	16	
3,600	10	30 ft	60 ft	120 ft	180 ft	240 ft	300 ft	360 ft	420 ft	480 ft	
	12	25	50	100	150	200	250	300	350	400	
	14	21	42	85	128	171	214	257	300	342	
	16	18	37	75	112	150	187	225	262	300	
	18	16	33	66	100	133	166	200	233	266	
4,800	10	40 ft	80 ft	160 ft	240 ft	320 ft	400 ft	480 ft	560 ft	640 ft	
	12	33	66	133	200	266	333	400	466	533	
	14	28	57	114	171	228	285	342	400	457	
	16	25	50	100	150	200	250	300	350	400	
	18	22	44	88	133	177	222	266	311	355	
6,000	10	50 ft	100 ft	200 ft	300 ft	400 ft	500 ft	600 ft	700 ft	800 ft	
	12	41	83	166	250	333	416	500	583	666	
	14	35	71	142	214	285	357	428	500	571	
	16	31	62	125	187	254	321	388	457	525	
	18	27	55	111	166	222	277	333	388	444	
7,200	10	60 ft	120 ft	240 ft	360 ft	480 ft	600 ft	720 ft	840 ft	960 ft	
	12	50	100	200	300	400	500	600	700	800	
	14	42	85	171	257	342	428	514	600	685	
	16	37	75	150	225	300	375	450	525	600	
	18	33	66	133	200	266	333	400	466	533	
8,000	10	66 ft	133 ft	266 ft	400 ft	533 ft	666 ft	800 ft	933 ft	1,066 ft	
	12	55	111	222	333	444	555	666	777	888	
	14	47	95	190	285	380	476	571	666	761	
	16	41	83	166	250	333	416	500	583	666	
	18	37	74	148	222	296	370	444	518	592	
10,000	10	83 ft	166 ft	333 ft	500 ft	666 ft	833 ft	1,000 ft	1,166 ft	1,333 ft	
	12	69	138	277	416	555	694	833	972	1,111	
	14	59	119	238	357	476	595	714	833	952	
	16	52	104	204	312	416	520	625	729	833	
	18	46	92	185	277	370	462	555	648	740	
20	41	83	166	250	333	416	500	583	666		

All finishes are single knife unless jointed.

## Cutting Angles

Wood	Kiln Dried 7% Moisture or Less Cutting Angle	Wet or Green More than 9% Cutting Angle
Ash	10°	15°
Basswood	10	20
Beech	10	15
Birch	10	15
Cedar	20	25
Cherry	10	15
Chestnut	5	10
Cottonwood	5	10
Cypress	5	10
Elm (hard)	0	5
Elm (soft)	5	10
Fir	15	15
Gum	20	25
Hemlock	15	20
Hickory	5	10
Mahogany	10	15
Maple	5	10
Oak	10	15
Pine (yellow)	20	25
Pine (white)	20	30
Pine (Ponderosa)	20	30
Poplar	20	35
Redwood	5	15
Spruce	20	25
Sycamore	5	10
Walnut	5	10







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