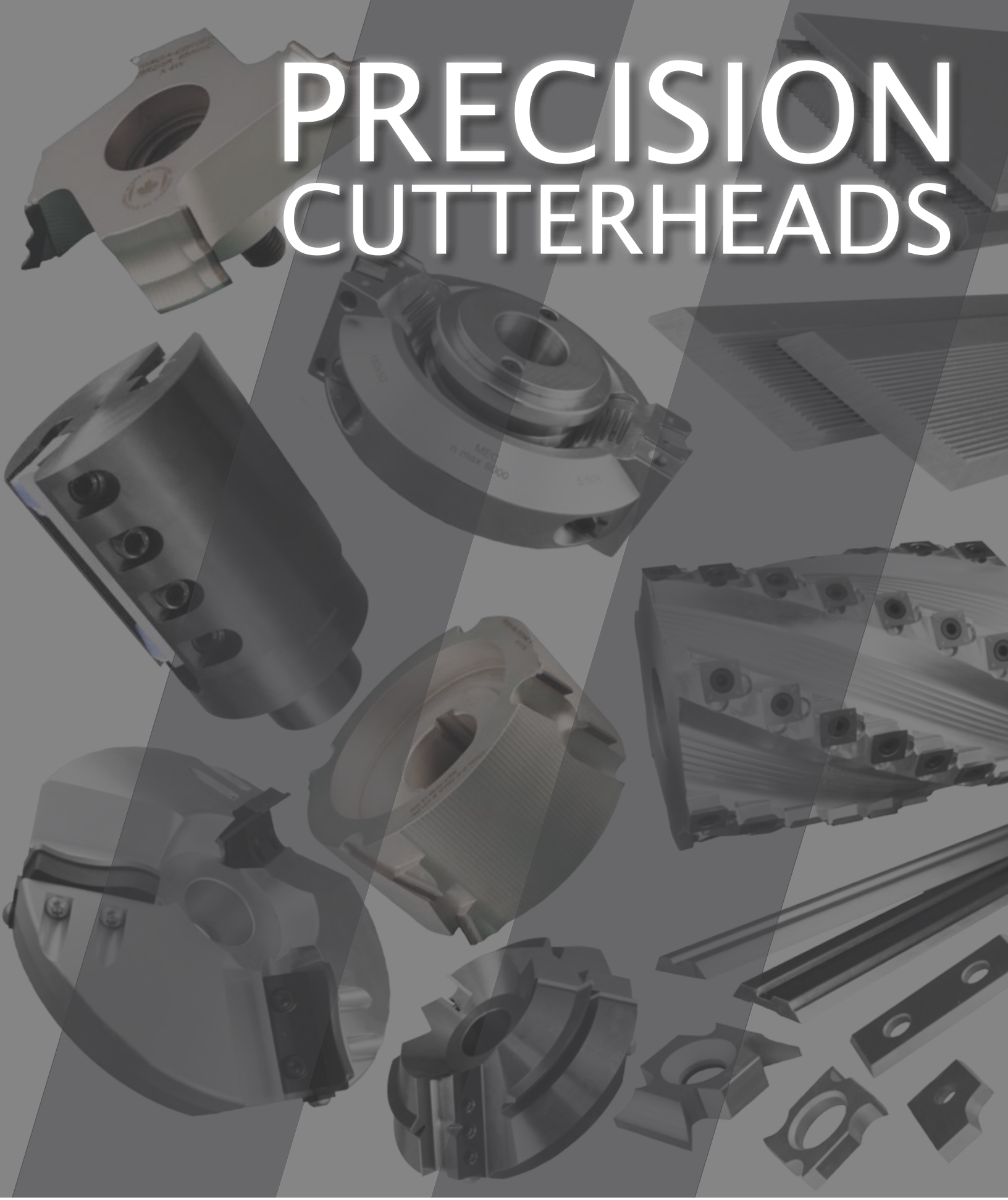
PRECISION CUTTERHEADS



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MADE IN NORTH AMERICA

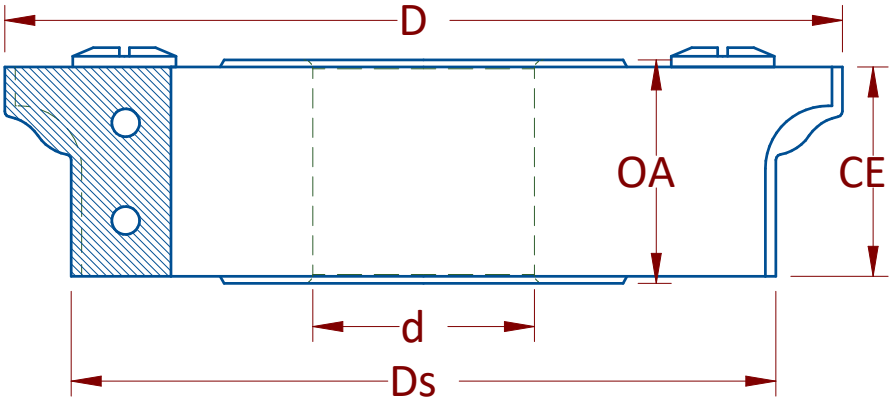
NSF ISO 9001

Technical Information

This catalog contains our standard product offering for cutterheads used on shapers, moulders, edgebanders, tenoners and other spindle type equipment. Most of our standard product offering can be re-bored upon your request. If what you are looking for is not shown we can produce custom tooling for any project you may require. Please provide the below information to your Royce Ayr representative and we will provide a price, drawing and lead time.

1) Type of machine tool is being used on
2) Type of feed system being used (mechanical or manual)
3) General RPM and feed rates that are required
4) Profile required to be cut
5) Material being cut
6) Rough dimension including arbor size and tool diameter

Explanation of Abbreviations



D	Diameter
Ds	Small Diameter
Z	Number of Teeth
d	Bore Size
W	Tool Width
CE	Cutting Edge Length

Lx	Max Length
Lm	Min Length
b	Profile Variable
a	Angle Dimension
r	Radius Dimension

Material Selection

	Best	Good	Acceptable
Hardwoods	Hw	Hw	Hw
Softwoods	Sw	Sw	Sw
Particle Board	Pb	Pb	Pb
Fiberboard	Fb	Fb	Fb
Plywood	Pl	Pl	Pl
Hard Plastic	Hp	Hp	Hp
Soft Plastic	Sp	Sp	Sp
Fibre Re-enforced Plastic Composites	Rp	Rp	Rp
Aluminium	Al	Al	Al
Material with Laminate	Lm	Lm	Lm

Climb vs Conventional Feed



Conventional cutting is the more common approach to machining. Higher feed rates can be attained with conventional cutting; this results in better tool life. It is also a safer method of machining.



Climb cutting is less common the advantages are improved finish quality and will often help if pitting or riving ahead is an issue. The disadvantage is lower feed rates must be used which results in poor tool life. It can also be dangerous as the material can be pulled into the tool and projected. NOT RECOMMENDED IN MANUAL FEED APPLICATIONS.

Calculations

$$\text{SFM} = \frac{3.14 \times \text{Diameter(in)} \times \text{RPM}}{12}$$

$$\text{Chipload (in)} = \frac{\text{FeedRate (FPM)} \times 12}{\#\ \text{Wings} \times \text{RPM}}$$

$$\text{Feed Speed (FPM)} = \frac{\text{RPM} \times \#\ \text{Wings}}{\text{Marks per inch} \times 12}$$

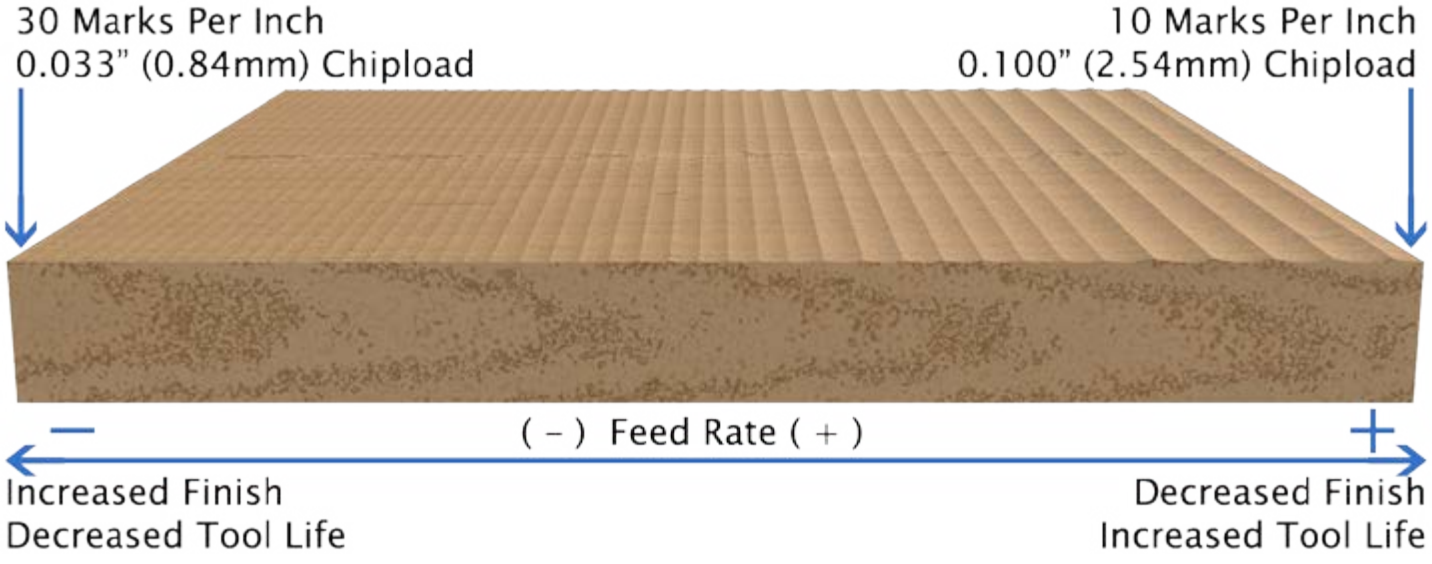
$$\text{Knife Marks (per in)} = \frac{\text{RPM} \times \#\ \text{Wings}}{\text{FeedRate (FPM)} \times 12}$$

Range of finishes

Recommended Knife Marks Per Inch	
Primary Industry	10-20
Secondary Industry	14-40

Recommended Chipload	
Primary Industry	.100" - .050"
Secondary Industry	.070" - .025"

Values are with grain, cross grain cutting typically done at 50% of the above values.



Feed Rate vs Desired Finish Values

Below table shows the correlation between number of wings, RPM, finish quality and feed rate.

			Number of Effective Cutting Edges											
			2		3		4		6		8		12	
RPM	Knife marks/"	Knife marks/cm	fpm	m/min	fpm	m/min	fpm	m/min	fpm	m/min	fpm	m/min	fpm	m/min
3600	10	3.94	60	18	90	27	120	37	180	55	240	73	360	110
3600	15	5.91	40	12	60	18	80	24	120	37	160	49	240	73
3600	20	7.87	30	9	45	14	60	18	90	27	120	37	180	55
3600	25	9.84	24	7	36	11	48	15	72	22	96	29	144	44
3600	30	11.81	20	6	30	9	40	12	60	18	80	24	120	37
4800	10	3.94	80	24	120	37	160	49	240	73	320	98	480	146
4800	15	5.91	53	16	80	24	107	33	160	49	213	65	320	98
4800	20	7.87	40	12	60	18	80	24	120	37	160	49	240	73
4800	25	9.84	32	10	48	15	64	20	96	29	128	39	192	59
4800	30	11.81	27	8	40	12	53	16	80	24	107	33	160	49
6000	10	3.94	100	30	150	46	200	61	300	91	400	122	600	183
6000	15	5.91	67	20	100	30	133	41	200	61	267	81	400	122
6000	20	7.87	50	15	75	23	100	30	150	46	200	61	300	91
6000	25	9.84	40	12	60	18	80	24	120	37	160	49	240	73
6000	30	11.81	33	10	50	15	67	20	100	30	133	41	200	61
8000	10	3.94	133	41	200	61	267	81	400	122	533	163	800	244
8000	15	5.91	89	27	133	41	178	54	267	81	356	108	533	163
8000	20	7.87	67	20	100	30	133	41	200	61	267	81	400	122
8000	25	9.84	53	16	80	24	107	33	160	49	213	65	320	98
8000	30	11.81	44	14	67	20	89	27	133	41	178	54	267	81
12000	10	3.94	200	61	300	91	400	122	600	183	800	244	1200	366
12000	15	5.91	133	41	200	61	267	81	400	122	533	163	800	244
12000	20	7.87	100	30	150	46	200	61	300	91	400	122	600	183
12000	25	9.84	80	24	120	37	160	49	240	73	320	98	480	146
12000	30	11.81	67	20	100	30	133	41	200	61	267	81	400	122

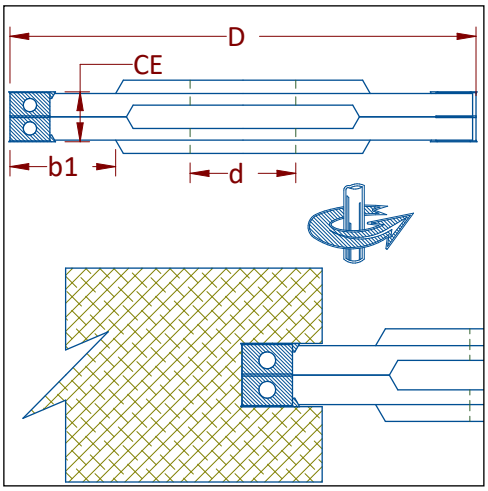
Feed Rate in Feet/Min and Meters/Min

Chipload to Knife Marks Conversion

Chipload		Knife Marks	
inches	mm	Per Inch	Per mm
0.100	2.54	10	0.394
0.067	1.69	15	0.591
0.050	1.27	20	0.787
0.040	1.02	25	0.984
0.033	0.85	30	1.181
0.029	0.64	35	1.378
0.025	0.73	40	1.575

502 – Adjustable Grooving TOK Tool Cutterhead





Hw Sw Fb Pb PI

See Material Guide p5

Insert groover for shapers. Inserts have 4 cutting edges that can be rotated when dull. Spurs allow a groove to be cut in wood. Tools can be adjusted with shims.

Shims sold separately

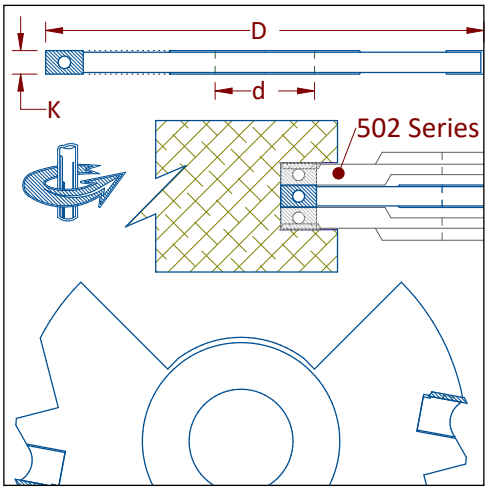
Replacement Parts

PART #	Description
592-1414	Spur Knife
580.CST-M4067.TX	Spur Screw
580SS.DH-M6016	Gib Screw

PART #	D	K	b1	d	Z	Knife
502-140.008	140mm	8-15mm	31mm	1-1/4”	2+2+2+2	590-0075
502-140.015	140mm	15-30mm	31mm	1-1/4”	2+2+2+2	590-0150
502-160.015	160mm	15-30mm	32mm	1-1/4”	2+2+2+2	590-0150
502-180.004	180mm	4-7.5mm	39mm	1-1/4”	2+2+2+2	591-1819
502-180.008	180mm	8-15mm	40mm	1-1/4”	2+2+2+2	590-0075
502-180.015	180mm	15-30mm	40mm	1-1/4”	2+2+2+2	590-0150
583SHM-I125.SET	1-1/4” ID shim set for above tools. consist of 3pc -.002”, 3pc -.005”, 2pc -.010”, 6pc -.020”, 4pc -.118”					

502E – Additional Tool for Adjustable Groover





Hw Sw Fb Pb PI

See Material Guide p5

Additional tool for 502 series adjustable groovers. Enables wider groove widths.

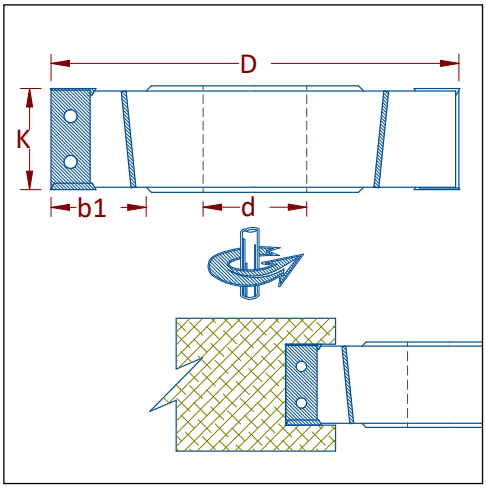
Replacement Parts

PART #	Description
580SS.DH-M6016	Gib Screw

PART #	D	K	d	Z	Knife
502E-140.008	140mm	8mm	1-1/4”	2	590-0075
502E-140.015	140mm	15mm	1-1/4”	2	590-0150
502E-180.008	180mm	8mm	1-1/4”	2	590-0075
502E-180.015	180mm	15mm	1-1/4”	2	590-0150

513 – Rebate TOK Cutterhead





Hw Sw Fb Pb Pl

See Material Guide p5

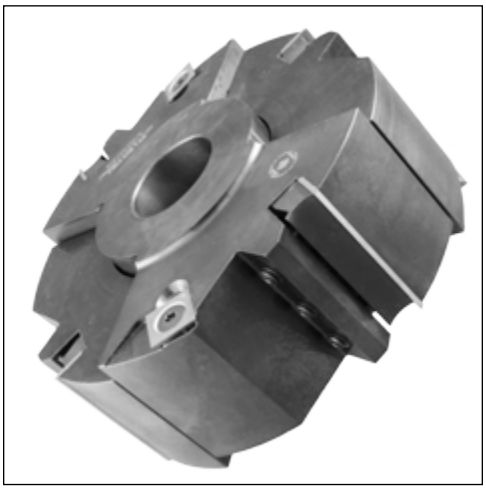
Insert turn over knife rebate tool. Knives can be rotated when dull. For machining rebates and grooves on various machines. Alternating face shear on straight knives lowers horsepower required to cut.

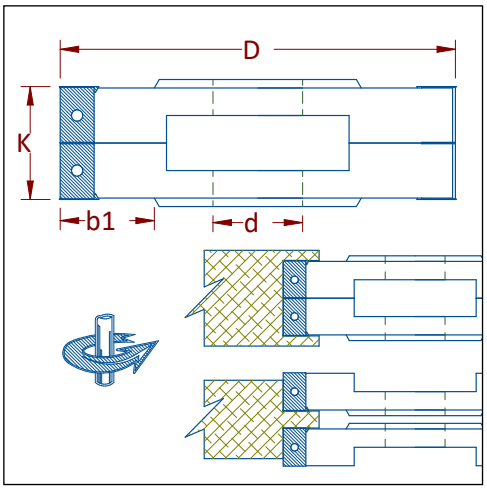
Replacement Parts

PART #	Description
592-1414	Spur Knife
580.CST-M4067.TX	Spur Screw
580SS.DH-M6016	Gib Screw

PART NO	D	K	b1	d	Z	Knife
513-100.40302	100mm	31mm	23mm	1-1/4"	2+4+2	590-0300
513-100.40502	100mm	51mm	23mm	1-1/4"	2+4+2	590-0500
513-125.4030	125mm	31mm	29mm	40mm	2+4+2	590-0300
513-125.4030-1.25	125mm	31mm	29mm	1-1/4"	2+4+2	590-0300
513-125.4030-30	125mm	31mm	29mm	30mm	2+4+2	590-0300
513-125.4050	125mm	51mm	29mm	40mm	2+4+2	590-0500
513-125.4050-1.25	125mm	51mm	29mm	1-1/4"	2+4+2	590-0500
513-125.4050-30	125mm	51mm	29mm	30mm	2+4+2	590-0500
513-125.4080	125mm	81mm	29mm	40mm	2+4+2	590-0800
513-150.4030	150mm	31mm	42mm	40mm	2+4+2	590-0300
513-150.40305	150mm	31mm	42mm	50mm	2+4+2	590-0300
513-150.4050	150mm	51mm	42mm	40mm	2+4+2	590-0500
513-150.4080	150mm	81mm	42mm	40mm	2+4+2	590-0800
513-180.4030.125	180mm	31mm	60mm	1-1/4"	2+4+2	590-0300

514 – Adjustable Grooving TOK Cutterhead





Hw Sw Fb Pb PI

See Material Guide p5

Insert groover for various machines. Inserts have 4 cutting edges that can be rotated when dull. Tools can be adjusted with shims.

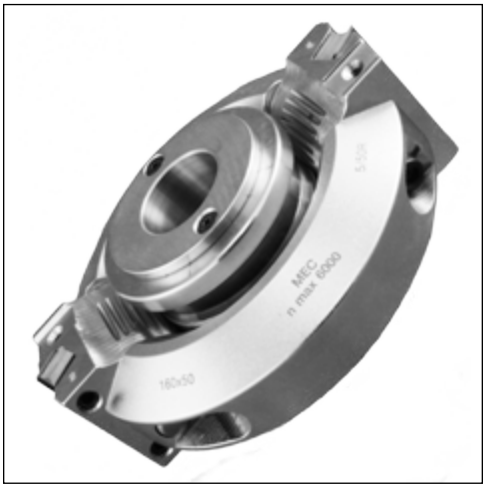
Shims & spacers sold separately

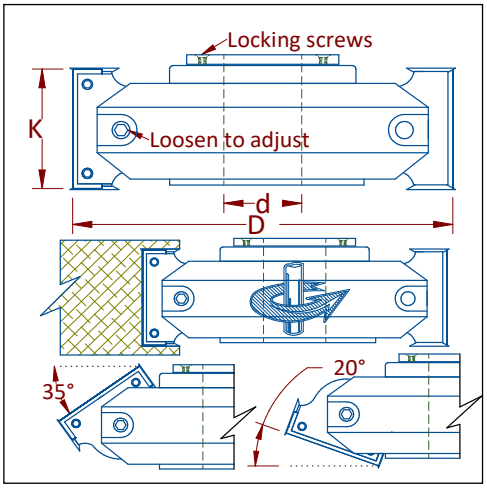
Replacement Parts

PART #	Description
592-1414	Spur Knife
580.CST-M4067.TX	Spur Screw
580SS.DH-M6016	Gib Screw

PART #	D	K	b1	d	Z	Knife
514-120.030	120mm	30.5-60mm	30mm	1-1/4"	2+2+2+2	590-0300
514-140.020	140mm	20.5-40mm	33mm	1-1/4"	2+2+2+2	590-0200
514-140.030	140mm	30.5-60mm	33mm	1-1/4"	2+2+2+2	590-0300
514-140.050	140mm	50.5-100mm	33mm	1-1/4"	2+2+2+2	590-0500
514-140.050.40	140mm	50.5-100mm	33mm	40mm	2+2+2+2	590-0500
514-180.020	180mm	20.5-40mm	43mm	1-1/4"	2+2+2+2	590-0200
514-180.030	180mm	30.5-60mm	43mm	1-1/4"	2+2+2+2	590-0300
514-180.050	180mm	50.5-100mm	43mm	1-1/4"	2+2+2+2	590-0500

517 – Adjustable Bevel Cutterhead





Hw Sw Fb Pb PI

See Material Guide p5

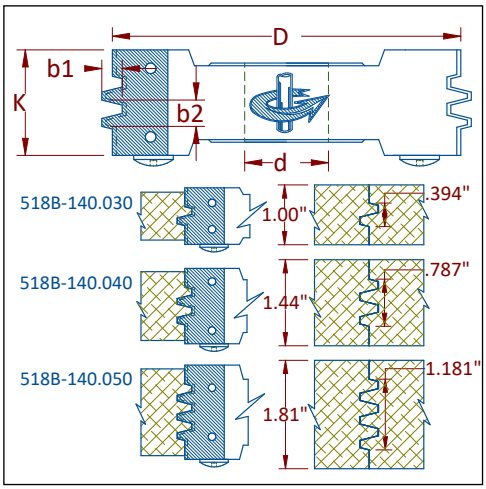
Adjustable bevel tool. Various angles can be achieved with single tool. Great for use on shapers. Simply loosen locking screws and turn dial, then tighten the locking screws to set at various angles.

Cannot re-bore

PART #	D	K	Z	d
517-155.050	160mm	50mm	2+2+2	1-1/4"
517-155.050-40	160mm	50mm	2+2+2	40mm

518B – Finger Joint Cutterhead





Hw Sw Fb Pb Pl

See Material Guide p5

Finger joint insert tool for use on shapers. Produces a stronger joint when gluing material together.

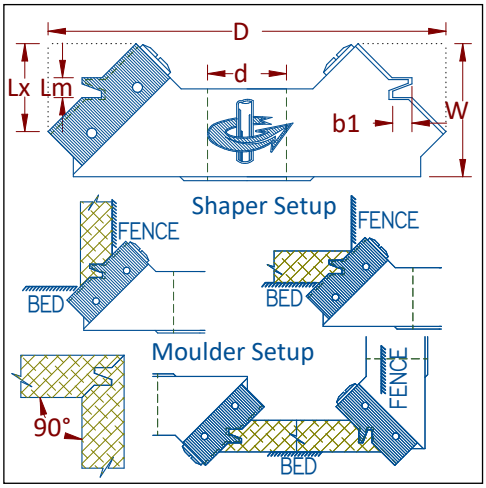
Replacement Parts

PART #	Description
580.HC-5016-L	Gib Screw
580-M5016.CAP	Stop Screw

PART #	D	K	Z	b1	b2	d	Knife #
518B-140.030	140mm	30mm	3	10mm	7.75mm	1-1/4"	158-518B-140.030
518B-140.040	140mm	40mm	3	10mm	7.75mm	1-1/4"	158-518B-140.040
518B-140.050	140mm	50mm	3	10mm	7.75mm	1-1/4"	158-518B-140.050

521 – Lock Mitre Shaper Cutterhead





Hw Sw Fb Pb Pl

See Material Guide p5

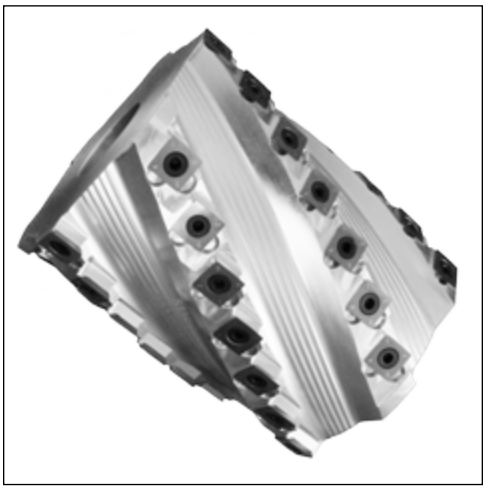
Lock mitre tool for use on shaper. Tool makes stronger 90° joints. Can be used for material of various thickness.

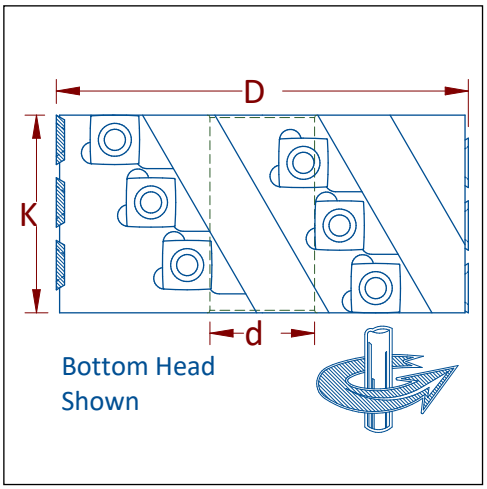
Replacement Parts

PART #	Description
580SS.DH-M8016	Gib Screw
581-27369-50	Gib
580.RH-M5010.T25	Stop Screws

PART #	D	Lx	Lm	b1	W	d	Knife #
521-160.030	160mm	15-30mm	.315"	.305"	2-1/8	1-1/4"	158-521-160.030

533F – Spiralex Cutterhead





Hw Sw Fb Pl Hp Sp

See Material Guide p5

Spiralex planing tools are great for general purpose planing on moulders, jointers, and shapers. Low horsepower required to cut. Radius knives help minimize lines. Top and bottom heads have different spiral directions that draw the chips towards the spindle base. Shallow gullets for reduced noise levels.

PART #	D	K	Z	d
533F-100.060-02B	100mm	60mm	2+2	1-1/4"
533F-100.060-03B	100mm	60mm	3+3	1-1/4"
533F-100.100-02B	100mm	100mm	2+2	1-1/4"
533F-100.100-03B	100mm	100mm	3+3	1-1/4"
533F-100.150-02B	100mm	150mm	2+2	1-1/4"
533F-100.240-02T	100mm	240mm	2+2	40mm
533F-125.060-03B	125mm	60mm	3+3	40mm
533F-125.060-03T	125mm	60mm	3+3	40mm
533F-125.100-03B	125mm	100mm	3+3	40mm
533F-125.100-03T	125mm	100mm	3+3	40mm
533F-125.150-03B	125mm	150mm	3+3	40mm
533F-125.150-03T	125mm	150mm	3+3	40mm
533F-125.230-03B	125mm	230mm	3+3	40mm
533F-125.240-03B	125mm	240mm	3+3	40mm
533F-125.240-03T	125mm	240mm	3+3	40mm
533F-140.060-03B	140mm	60mm	3+3	40mm
533F-140.100-03B	140mm	100mm	3+3	40mm
533F-140.100-03T	140mm	100mm	3+3	40mm
533F-140.150-03B	140mm	150mm	3+3	40mm
533F-140.240-03B	140mm	240mm	3+3	40mm
533F-140.240-03T	140mm	240mm	3+3	40mm

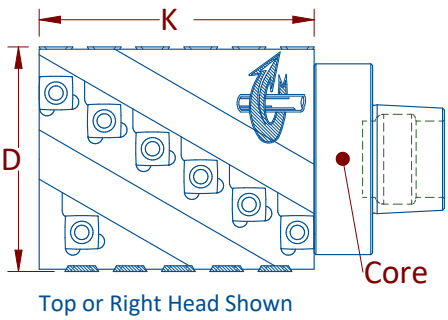
B = Indicates bottom or left spindle head
T = Indicates top or right spindle head

Replacement Parts

PART #	Description
592-0007	Replacement Knives
582-KEY-M3.0L	T20 Torx Wrench
580.SHD-M5014.A0BT20	Replacement Screws

533P – Spiralex Tool for High Speed Moulders





Top or Right Head Shown

Hw Sw Fb Pl Hp Sp

See Material Guide p5

Spiralex planing tools are great for general purpose planing on moulders. Low horse-power required to cut. Radius knives help minimize lines. Top and bottom heads for different spiral directions that draw the chips towards the spindle base. HSK80W adapter for high speed moulders. Integrated one piece tool for maximum rigidity and accuracy. Shallow gullets for reduced noise levels.

PART NO	D	K	Core	WINGS
533P.100.115-2B	100mm	115mm	HSK63F	2+2
533P.100.115-2T	100mm	115mm	HSK63F	2+2
533P.100.170-02B	100mm	170mm	HSK63F	2+2
533P.100.170-02T	100mm	170mm	HSK63F	2+2
533P.100.240-02B	100mm	240mm	HSK63F	2+2
533P.100.240-02T	100mm	240mm	HSK63F	2+2

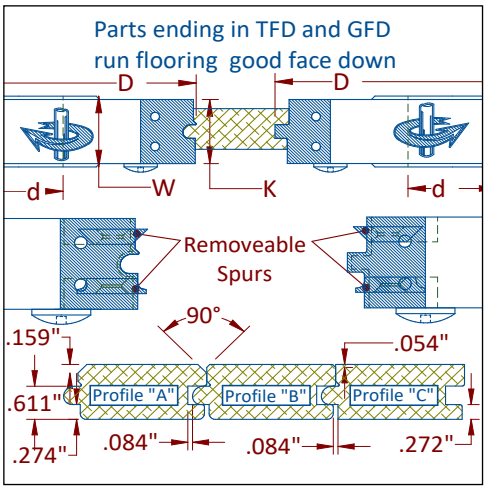
B = Bottom or Left Head
T = Top or Right Head

Replacement Parts

PART #	Description
592-0007	Replacement Knives
582-KEY-M3.0L	T20 Torx Wrench
580.SHD-M5014.A0BT20	Replacement Screws

538 – Hardwood Flooring Cutterheads





Hw Sw Fb Pb PI

See Material Guide p5

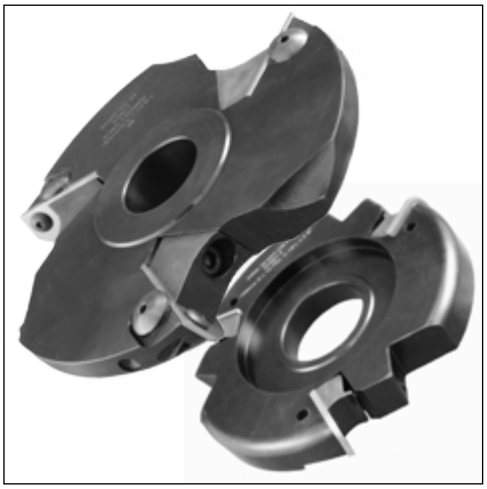
Standard low feed rate moulder tools for producing hardwood flooring. Profile conforms to NOFMA standard. Optional bevel and radius knives.

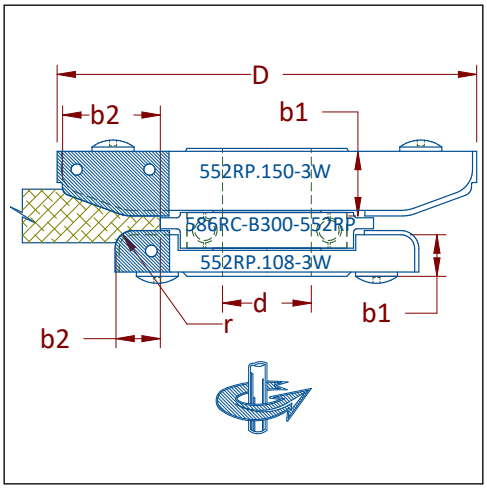
Replacement Parts

PART #	Description
599A-45	45° Chamfer Knives
599A-2.0R	2mm Radius Knives
580SS.DH-M6018	Gib Screws
580.M5016.CAP	Knife Stop Screws

PART #	D	K	W	Z	d	Knives
538-160.030-G	160mm	30mm	1.30”	3+3+3	40mm	158-538-160.030-G
538-160.030-T	160mm	30mm	1.30”	3+3+3	40mm	158-538-160.030-T
538-160.030-GFD	160mm	30mm	1.30”	3+3+3	40mm	158-538-160.030-GFD
538-160.030-TFD	160mm	30mm	1.30”	3+3+3	40mm	158-538-160.030-TFD
538-160.030-GFD-1.8	160mm	30mm	1.30”	3+3+3	1-13/16”	158-538-160.030-GFD
538-160.030-TFD-1.8	160mm	30mm	1.30”	3+3+3	1-13/16”	158-538-160.030-TFD

552RP – Raised Panel Cabinet Door Cutterhead



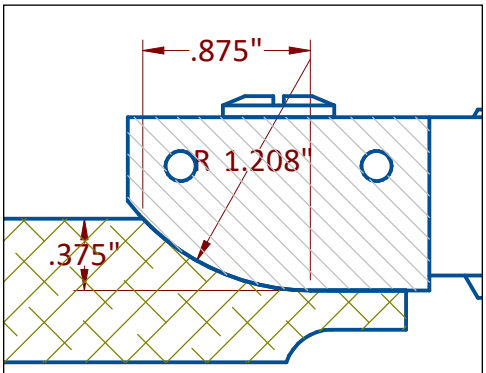


Hw Sw Fb Pb Pl

See Material Guide p5

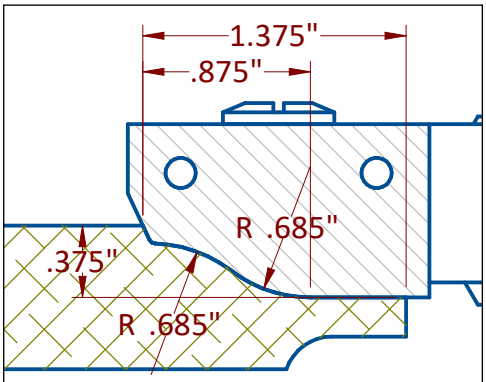
Raised panel assembly for use on shapers. Rub collar and relief tool sold separately. Tool comes standard with "A" knives installed. Additional profiles shown below. Custom profiles may fit in head but are limited due to profile of tool.

PART #	D	d	b1	b2	Z	Knife#
552RP.150-3W	150mm	1-1/4"	23mm	1-3/8"	3	See Table Below
552RP.108-3W	108mm	1-1/4"	15mm	3/8"	3	158-552RP.108-3W-A
586RC-B300-552RP	3"	1-1/4"	-	-	-	-



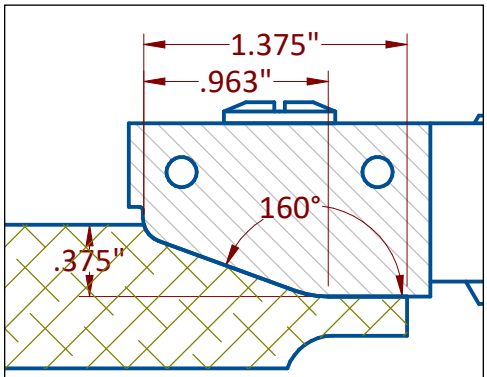
Actual Size Shown

Profile "A" Knives
158-552RP.150-3W-A



Actual Size Shown

Profile "B" Knives
158-552RP.150-3W-B



Actual Size Shown

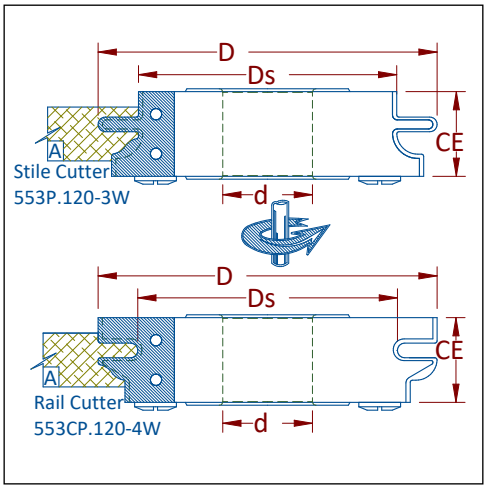
Profile "C" Knives
158-552RP.150-3W-C

Replacement Parts

PART #	Description
580SS.DH-M6016	552RP.108-3W Gib Screw
581-27369.015	552RP.108-3W Gib
580.HC-M6025	552RP.150-3W Gib Screw
581-552RP.020	552RP.150-3W Gib
580RH-M3505.9	552RP.150-3W Safety Screw
580-M5016.CAP	Stop Screws

553P & 553CP – Stile and Rail Cabinet Door



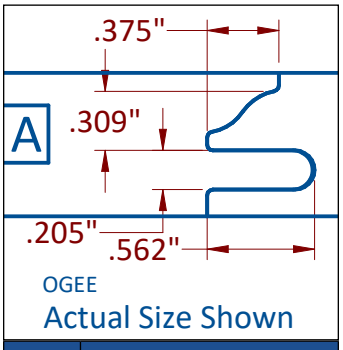


Hw Sw Fb Pb Pl

See Material Guide p5

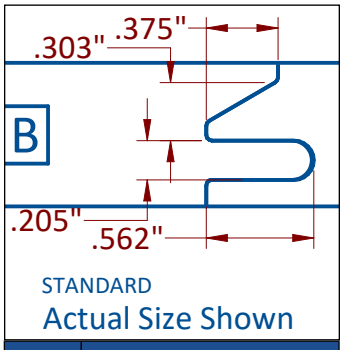
Stile and rail shaper tools for frame and panel cabinet doors. Profiles below can all run in same tool. Tool comes standard with "A" knives installed. Additional profiles shown below. Custom profiles may fit in head as well but are limited due to profile of steel body. Rub collar bearing available for stile tool (see page 47).

PART #	D	Ds	d	CE	Z
553P.120-3W	120mm	92mm	1-1/4"	30mm	3
553CP.120-4W	120mm	92mm	1-1/4"	30mm	4



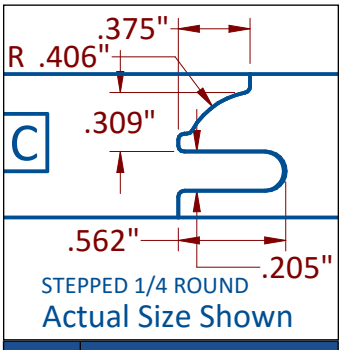
OGEE
Actual Size Shown

	Knife Part #
Stile	158-553P.120-3W-A
Rail	158-553CP.520-A



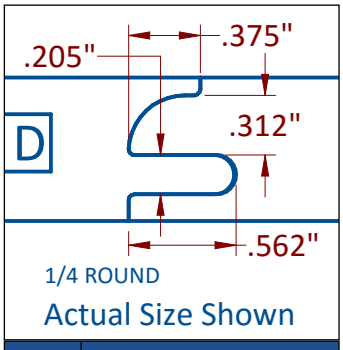
STANDARD
Actual Size Shown

	Knife Part #
Stile	158-553P.120-3W-B
Rail	158-553CP.520-B



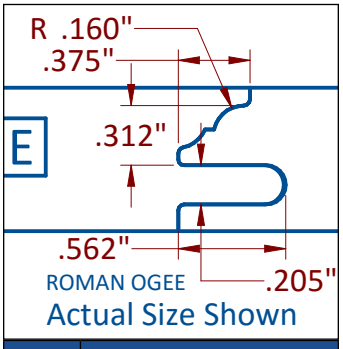
STEPPED 1/4 ROUND
Actual Size Shown

	Knife Part #
Stile	158-553P.120-3W-C
Rail	158-553CP.520-C



1/4 ROUND
Actual Size Shown

	Knife Part #
Stile	158-553P.120-3W-D
Rail	158-553CP.520-D



ROMAN OGEE
Actual Size Shown

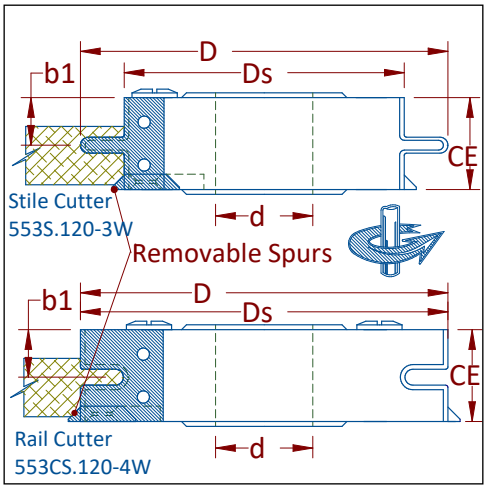
	Knife Part #
Stile	158-553P.120-3W-E
Rail	158-553CP.520-E

Replacement Parts

PART #	Description
580HC-M5016-L	Gib Screws
581-26800-30	Gibs
580.M5016.CAP	Knife Stop Screws

553S & 553CS – Stile and Rail Shaker Cutterhead



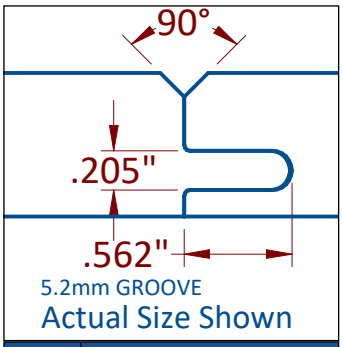


Hw Sw Fb Pb Pl

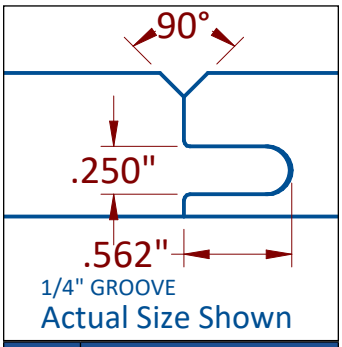
See Material Guide p5

Stile and rail tools for frame and panel "shaker" style cabinet doors. Tool comes standard with "A" knives installed. 45° spurs can be removed for no bevel. Rub collar bearing available for stile tool (see page 47).

PART #	D	Ds	d	CE	b1	Z
553S.120-3W	120mm	92mm	1-1/4"	30mm	15.5mm	3
553CS.120-4W	120mm	92mm	1-1/4"	30mm	15.5mm	4



	Knife Part #
Stile	158-553S.120-3W-A
Rail	158-553CS.120-4W-A

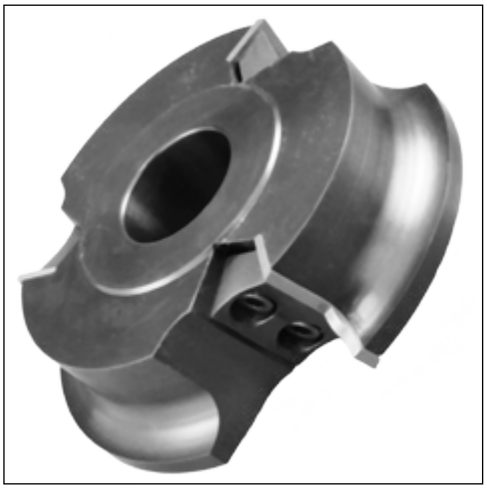


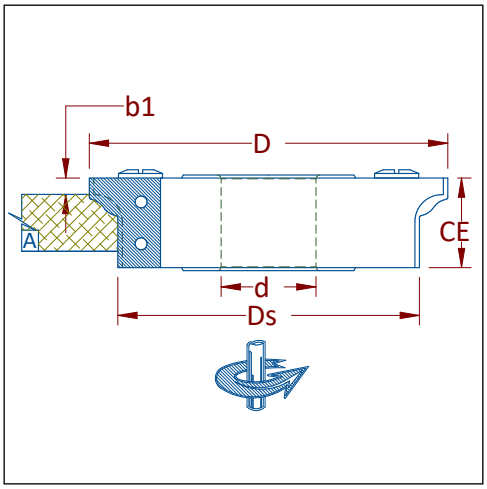
	Knife Part #
Stile	158-553S.120-3W-B
Rail	158-553CS.120-4W-B

Replacement Parts

PART #	Description
599A-45	45° Chamfer Knives
580SHD-M5012.ZU	Screw for Chamfer Knife
581-26800-30	Gib
580HC-M5016-L	Gib Screw
580-M5016.CAP	Stop Screw

553OP – Outside Edge Cabinet Door Cutterhead



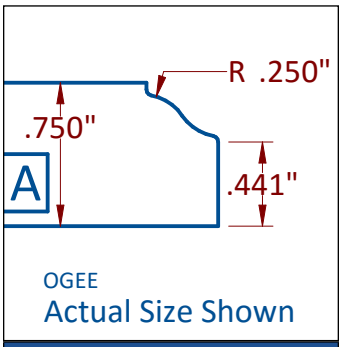


Hw Sw Fb Pb Pl

See Material Guide p5

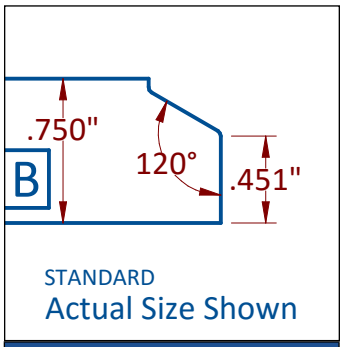
Outside edge detail tool for cabinet doors. Profiles below can all run in same tool. Tool comes standard with "A" knives installed. Additional profiles shown below. Custom profiles may fit in head as well but are limited due to profile of steel body.

PART #	D	Ds	d	CE	b1	Z
5530P.120-3W	120mm	92mm	1-1/4"	30mm	5.5mm	3



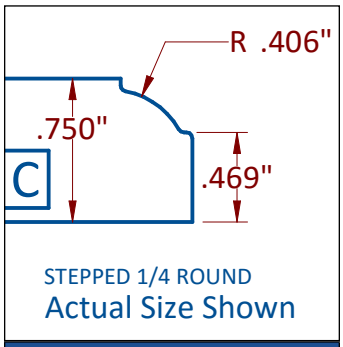
OGEE
Actual Size Shown

Knife Part #
158-5530P.120-3W-A



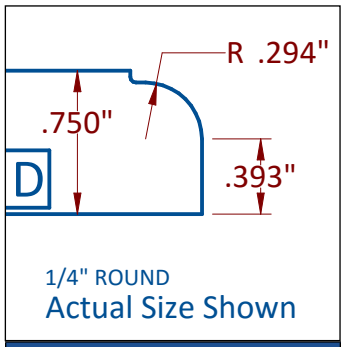
STANDARD
Actual Size Shown

Knife Part #
158-5530P.120-3W-B



STEPPED 1/4 ROUND
Actual Size Shown

Knife Part #
158-5530P.120-3W-C



1/4" ROUND
Actual Size Shown

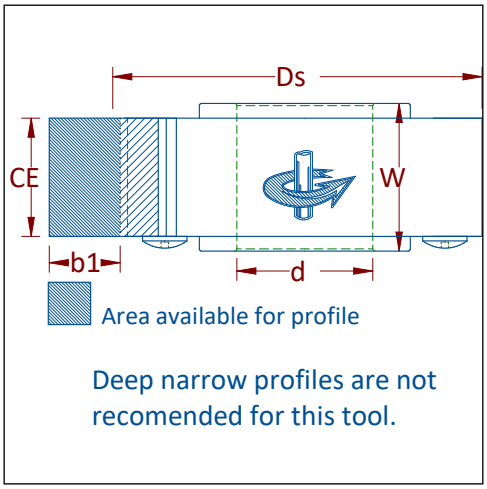
Knife Part #
158-5530P.120-3W-D

Replacement Parts

PART #	Description
580HC-M5016-L	Gib Screws
581-26800-30	Gibs
580.M5016.CAP	Knife Stop Screws

555 – Multi Profile Cutterheads





Hw Fb Sw Pb Pl

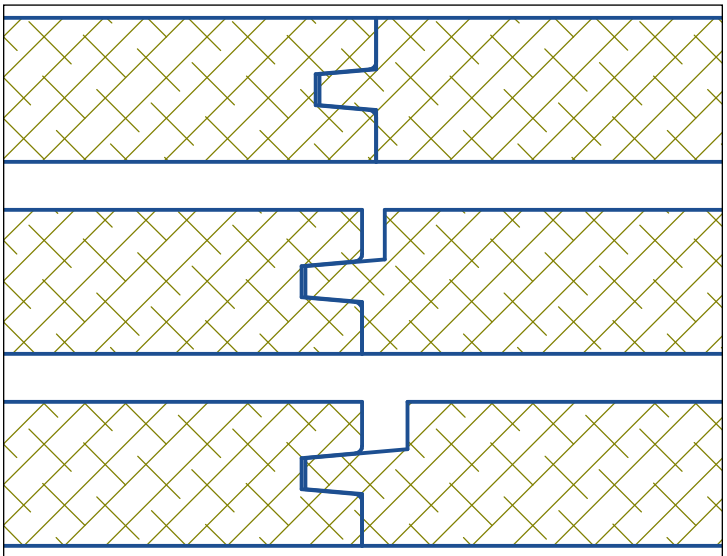
See Material Guide p5

Multi profile insert tool for use on shapers and moulders. Hard anodized steel backers and carbide knives can be profiled to suit an assortment of profiles. Narrow deep profiles and grooves are not recommended as knife may be prone to breakage. 12° hook suitable for hardwoods and MDF.

Knives and backers sold separately

PART #	Ds	CE	d	b1	W	Z
555-100.030-2W	100mm	30mm	1.250”	25mm	40mm	2
555-100.030-3W	100mm	30mm	1.250”	25mm	40mm	3
555-100.040-2W	100mm	40mm	1.250”	25mm	50mm	2
555-100.040-3W	100mm	40mm	1.250”	25mm	50mm	3
555-100.060-2W	100mm	60mm	1.250”	25mm	70mm	2
555-100.060-3W	100mm	60mm	1.250”	25mm	70mm	3
555-125.030-2W	125mm	30mm	40mm	25mm	40mm	2
555-125.030-3W	125mm	30mm	40mm	25mm	40mm	3
555-125.040-2W	125mm	40mm	40mm	25mm	50mm	2
555-125.040-3W	125mm	40mm	40mm	25mm	50mm	3
555-125.060-2W	125mm	60mm	40mm	25mm	70mm	2
555-125.060-3W	125mm	60mm	40mm	25mm	70mm	3
555-125.080-2W	125mm	80mm	40mm	25mm	90mm	2
555-125.100-2W	125mm	100mm	40mm	25mm	110mm	2

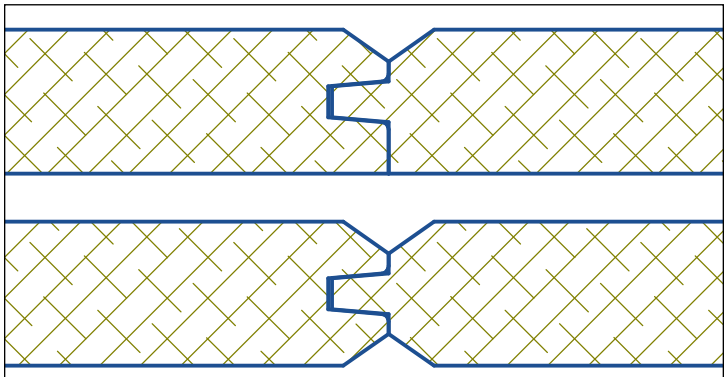
Standard Profiles for 30mm Heads



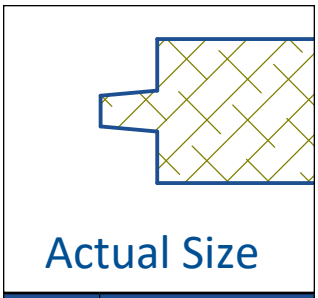
Actual Size

Replacement Parts

PART #	Description
580HC-M5016-L	Gib Screws
580.M5016.CAP	Knife Stop Screws
580.RH-M5010.T25	Backer Screws

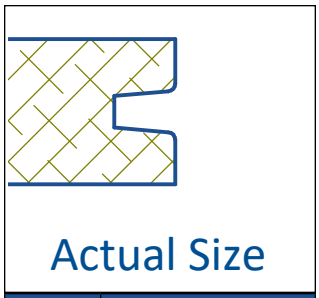


Actual Size



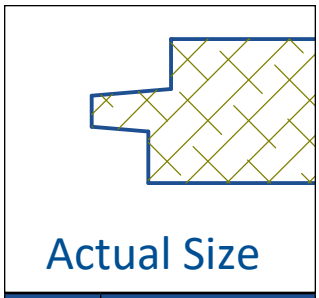
Actual Size

Part	Number
Backer	153-555VM.A1
Knife	158-SC-555VM.A1



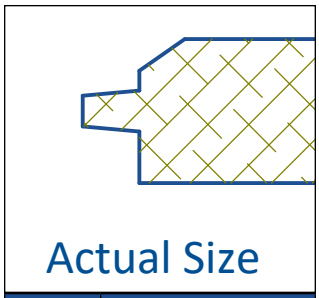
Actual Size

Part	Number
Backer	153-555VM.A2
Knife	158-SC-555VM.A2



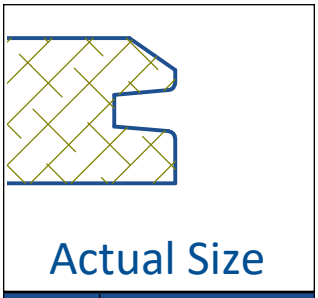
Actual Size

Part	Number
Backer	153-555VM.B1
Knife	158-SC-555VM.B2



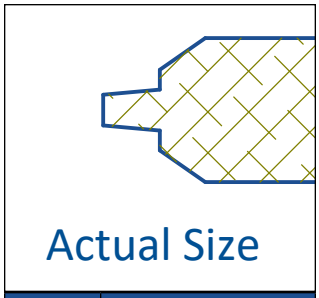
Actual Size

Part	Number
Backer	153-555VM.D1
Knife	158-SC-555VM.D1



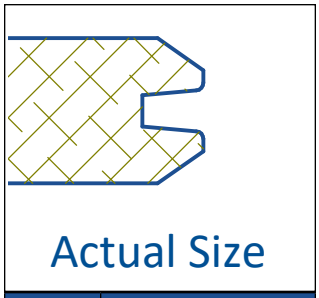
Actual Size

Part	Number
Backer	153-555VM.D2
Knife	158-SC-555VM.D2



Actual Size

Part	Number
Backer	153-555VM.E1
Knife	158-SC-555VM.E1



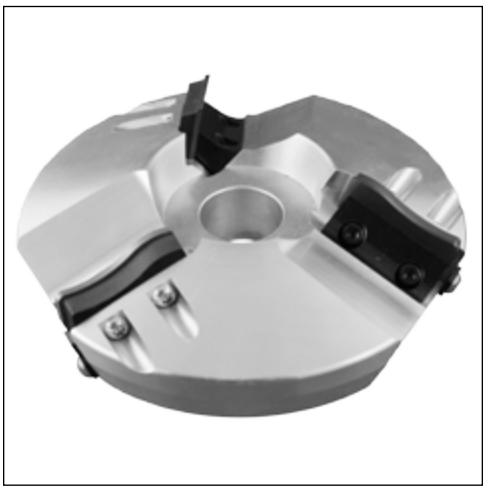
Actual Size

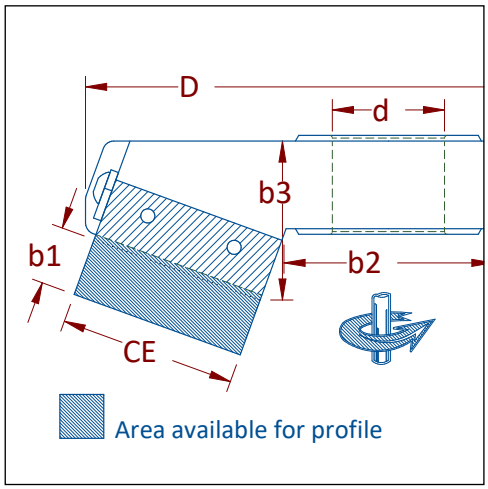
Part	Number
Backer	153-555VM.E2
Knife	158-SC-555VM.E2

NOTE: All knives are made to run in the below heads

555-100.030-2W
555-100.030-3W
555-125.030-2W
555-125.030-3W

555RP – Multi Profile Cabinet Panel Cutterhead





Hw Sw Fb Pb PI

See Material Guide p5

Multi profile insert tool for use on shapers for cabinet door raised panels. Tool is designed to be used for raised panel profiles. Hard anodized steel backers and carbide knives can be profiled to suit an assortment of profiles. Aluminum lightweight body. Backers and knives to be ordered with custom profiles thru your appropriate Royce Ayr sales representative.

Knives and backers sold separately

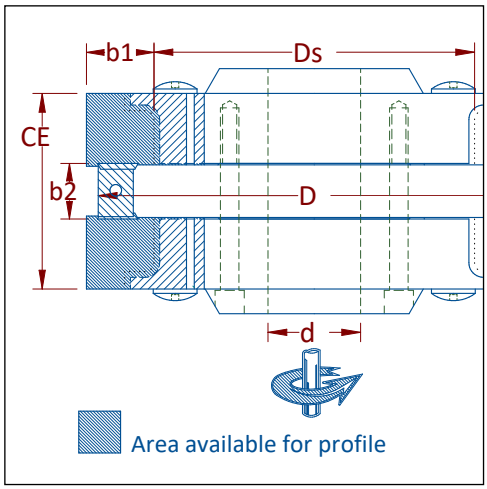
PART #	D	CE	d	b1	b2	b3	Z
555RP-170.050-3W	6-3/4"	50mm	1-1/4"	16.5mm	2.8"	1.8"	3

Replacement Parts

PART #	Description
580.HC-M5016	Gib Screws
581-26800-50	Gibs
580-SW105	Knife Stop Washer
580.RH-M5010.T25	Knife Stop Screws
580.M5010.T25	Backer Screws

555P – Rail Multi Profile Entry Door Tools





Hw Sw Fb Pb Pl

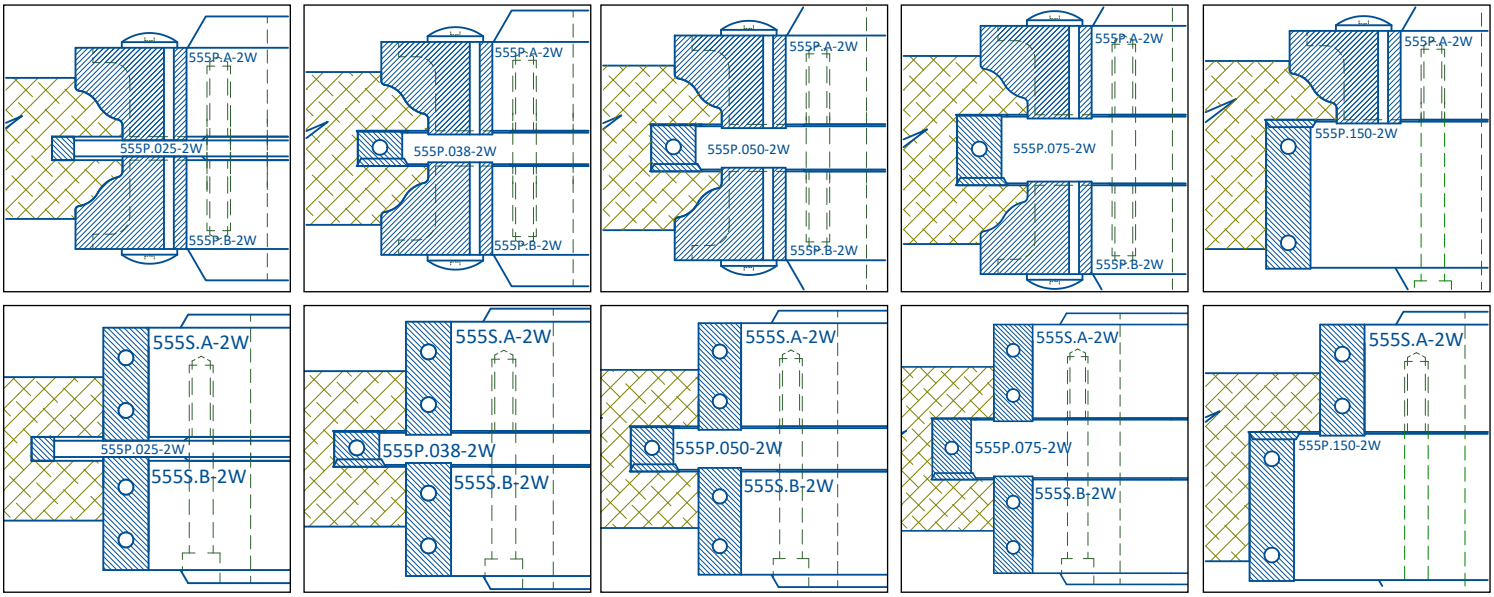
See Material Guide p5

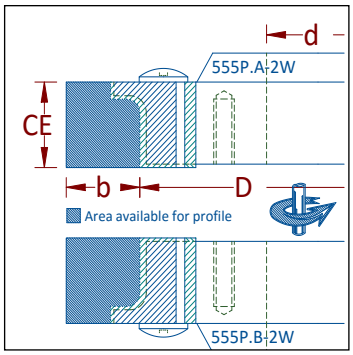
Semi-stock made to order option. Assembly can be run on shaper, moulder, or CNC router. Multi profile system allows assortment of profiles to be run on one set of tooling. Various components can be assembled for different configurations. Please contact your Royce Ayr sales representative to ensure proper parts and profiles are ordered.

Knives and backers sold separately

D	Ds	CE	d	b1	b2	Z
148mm (5.83”)	110mm (4.33”)	67mm (2.63”) to 54mm (2.13”)	1.250”	23mm (.905”)	6.35mm (1/4”), 9.5mm (3/8”) 12.7mm (1/2”), 19.05mm (3/4”)	2+2+2

Possible Configurations

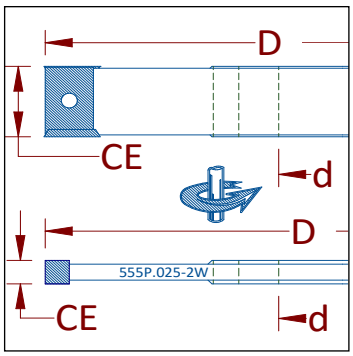




Rail Multi Profile Cutterheads

PART #	D	d	CE	b	Z
555P.A-2W	110mm	1.25”	25mm	23mm (.905”)	2
555P.B-2W	110mm	1.25”	25mm	23mm (.905”)	2

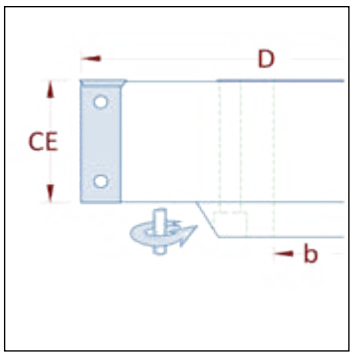
Tools can be re-bored up to 40mm



Rail Groover Cutterheads

PART #	D	d	CE	Z
555P.025-2W*	148.1mm (5.830”)	1.25”	6.35mm (.250”)	2
555P.038-2W	148.1mm (5.830”)	1.25”	9.5mm (.375”)	2+2+2
555P.050-2W	148.1mm (5.830”)	1.25”	12.7mm (.500”)	2+2+2
555P.075-2W	148.1mm (5.830”)	1.25”	19.05mm (.750”)	2+2+2

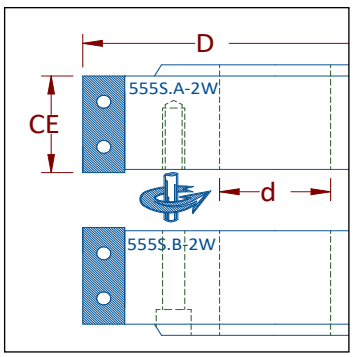
Tools can be re-bored up to 40mm
*Groover is PCD Diamond



Rail Glass Cutterhead

PART #	D	d	CE	Z
555P.150-2W	148.1mm (5.830”)	1.25”	40mm (1.57”)	2+2

Tools can be re-bored up to 40mm



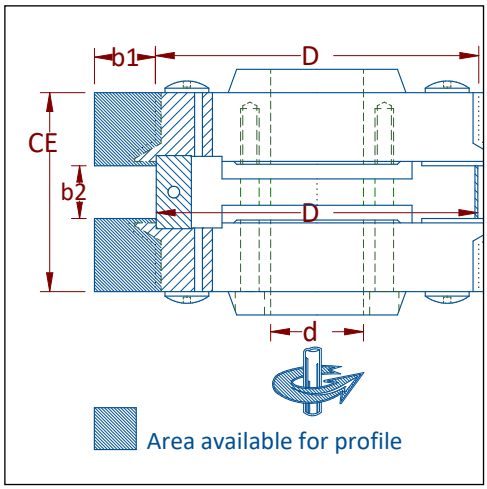
Shaker Rail Cutterheads

PART #	D	d	CE	Z
555S.A-2W	110mm (4.33”)	1.25”	25mm (0.98”)	2
555S.B-2W	110mm (4.33”)	1.25”	25mm (0.98”)	2

Tools can be re-bored up to 40mm

555CP – Stile Multi Profile Entry Door Tools





Hw Sw Fb Pb PI

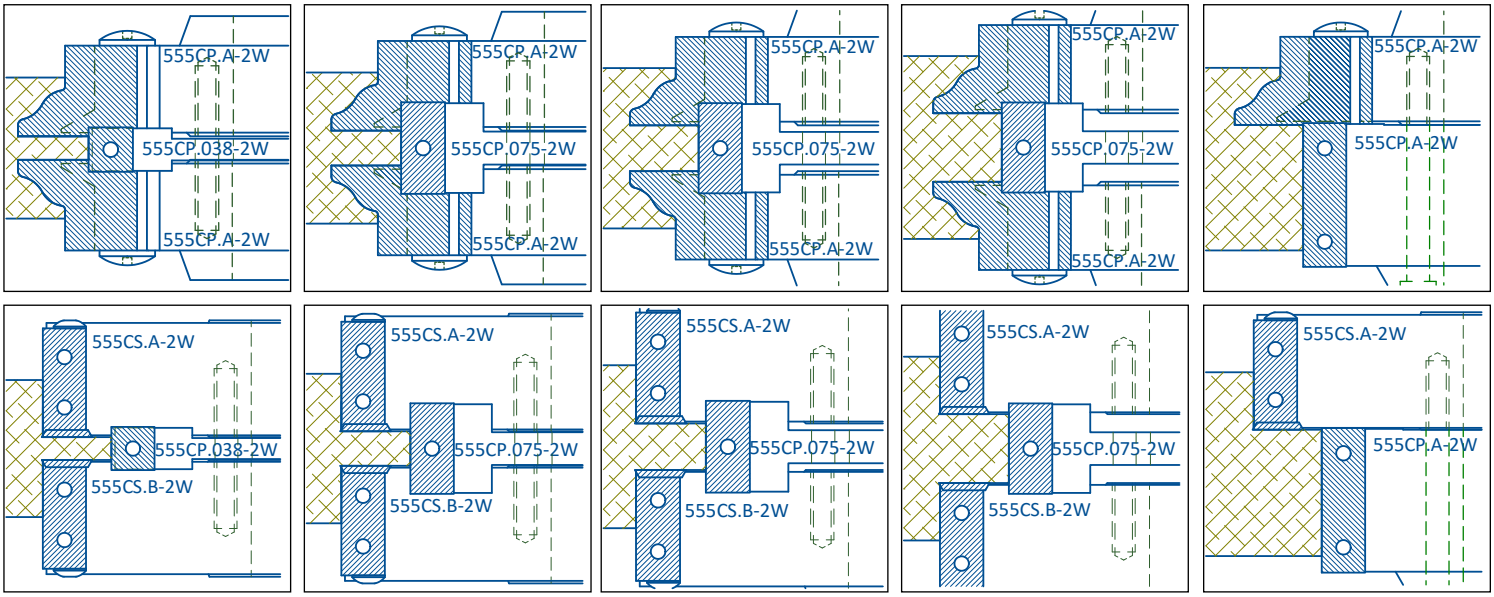
See Material Guide p5

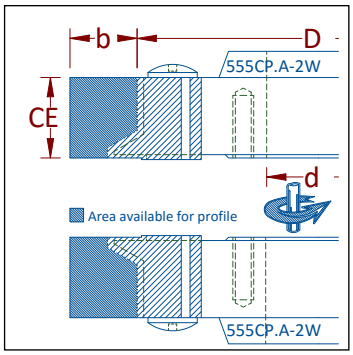
Semi-stock made to order option. Assembly can be run on shaper, moulder, or CNC router. Multi profile system allows assortment of profiles to be run on one set of tooling. Can be used for 1.5" - 2" thick doors. Various components can be assembled for different configurations. Please contact your Royce Ayr sales representative to ensure proper parts and profiles are ordered.

Knives and backers sold separately

D	Ds	CE	d	b1	b2	Z
110mm (4.33")	110mm (4.33")	67mm (2.63") to 54mm (2.13")	1.250"	23mm (.905")	6.35mm (1/4"), 9.5mm (3/8") 12.7mm (1/2"), 19.05mm (3/4")	2+2+2

Possible Configurations

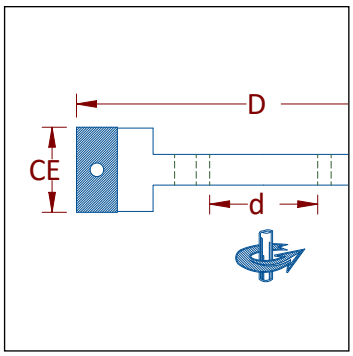




Stile Multi Profile Cutterheads

PART #	D	d	CE	b	Z
555CP.A-2W	110mm	1.25”	25mm	23mm (.905”)	2
555CP.B-2W	110mm	1.25”	25mm	23mm (.905”)	2

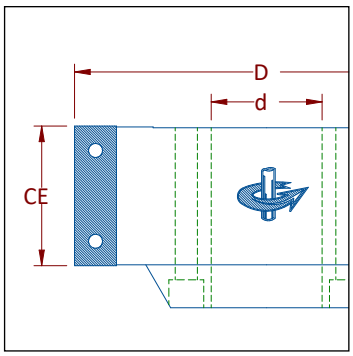
Tools can be re-bored up to 40mm



Stile Groover Cutterheads

PART #	D	d	CE	Z
555CP.038-2W	110mm (4.33”)	1.25”	12mm (0.47”)	2
555CP.075-2W	110mm (4.33”)	1.25”	20mm (0.79”)	2

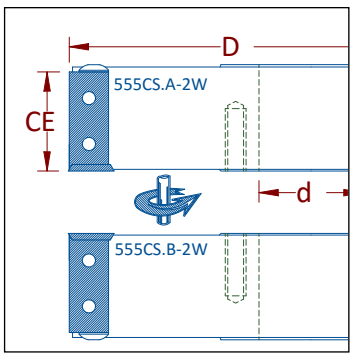
Tools can be re-bored up to 40mm



Stile Glass Cutterheads

PART #	D	d	CE	Z
555CP.150-2W	110mm (4.33”)	1.25”	40mm (1.57”)	2+2

Tools can be re-bored up to 40mm



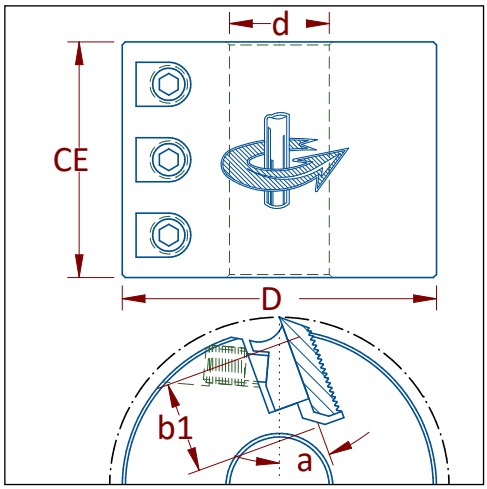
Shaker Cope Cutterheads

PART #	D	d	CE	Z
555CS.A-2W	147.6mm (5.81”)	1.25”	30mm (1.18”)	2+2
555CS.B-2W	147.6mm (5.81”)	1.25”	30mm (1.18”)	2+2

Tools can be re-bored up to 40mm

572 – Corrugated Heads for Shapers & Moulders





Sw Hw Fb Pb Pl

See Material Guide p5

Corrugated heads for shapers and moulders. Steel bodies with precision machined 60° corrugations to hold 579 series corrugated knives. Black oxide treatment for corrosion resistance. 20° hook heads for softwood and 12° hook for hardwood. Made in North America. Custom hydraulic arbor heads available upon request.

2 Wing Heads

PART #	D	CE	b1	a	d	Z
572-075025192	3"	1"	1"	20°	3/4"	2
572-075050192	3"	2"	1"	20°	3/4"	2
572-075075192	3"	3"	1"	20°	3/4"	2
572-090025252	3-1/2"	1"	7/8"	20°	1"	2
572-090050252	3-1/2"	2"	7/8"	20°	1"	2
572-090075252	3-1/2"	3"	7/8"	20°	1"	2
572-090100252	3-1/2"	4"	7/8"	20°	1"	2
572-100050322	100mm	50mm	1-1/8"	20°	1-1/4"	2
572-100075322	100mm	75mm	1-1/8"	20°	1-1/4"	2
572-100100322	100mm	100mm	1-1/8"	20°	1-1/4"	2
572-100120352.BENZ	100mm	120mm	1-1/8"	20°	35mm	2
572-100125322	100mm	125mm	1-1/8"	20°	1-1/4"	2
572-100170352.BENZ	100mm	170mm	1-1/8"	20°	35mm	2

BENZ = Lightweight aluminum and pin holed for BENZ V-Line aggregates

4 Wing Heads

PART #	D	CE	b1	a	d	Z
572-100050324	100mm	50mm	1-1/8"	20°	1-1/4"	4
572-100075324	100mm	75mm	1-1/8"	20°	1-1/4"	4
572-100100324	100mm	100mm	1-1/8"	20°	1-1/4"	4
572-100125324	100mm	125mm	1-1/8"	20°	1-1/4"	4
572-100150324	100mm	150mm	1-1/8"	20°	1-1/4"	4

573 – Corrugated Heads for Moulders

12° For Hardwood

PART #	D	CE	b1	a	d	Z
573-122040404-12	122mm	40mm	30mm	12°	40mm	4
573-122060402-12	122mm	60mm	30mm	12°	40mm	2
573-122060404-12	122mm	60mm	30mm	12°	40mm	4
573-122080402-12	122mm	80mm	30mm	12°	40mm	2
573-122100402-12	122mm	100mm	30mm	12°	40mm	2
573-122100404-12	122mm	100mm	30mm	12°	40mm	4
573-122130402-12	122mm	130mm	30mm	12°	40mm	2
573-122130404-12	122mm	130mm	30mm	12°	40mm	4
573-122150402-12	122mm	150mm	30mm	12°	40mm	2
573-122150404-12	122mm	150mm	30mm	12°	40mm	4
573-122180402-12	122mm	180mm	30mm	12°	40mm	2
573-122180404-12	122mm	180mm	30mm	12°	40mm	4
573-122230402-12	122mm	230mm	30mm	12°	40mm	2
573-122230404-12	122mm	230mm	30mm	12°	40mm	4
573-122240404-12	122mm	240mm	30mm	12°	40mm	4

20° For Softwood

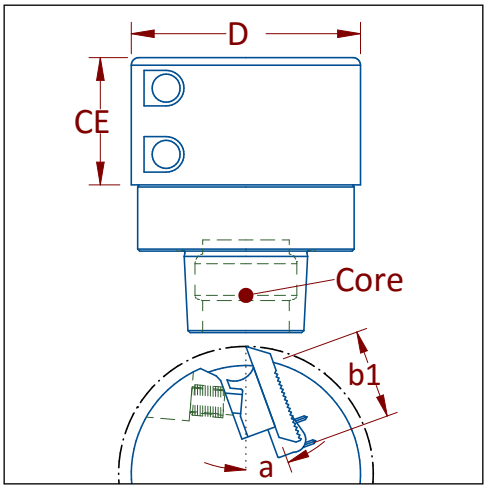
PART #	D	CE	b1	a	d	Z
573-122040404-20	122mm	40mm	30mm	20°	40mm	4
573-122050404-20	122mm	50mm	30mm	20°	40mm	4
573-122060402-20	122mm	60mm	30mm	20°	40mm	2
573-122060404-20	122mm	60mm	30mm	20°	40mm	4
573-122080402-20	122mm	80mm	30mm	20°	40mm	2
573-122080404-20	122mm	80mm	30mm	20°	40mm	4
573-122100402-20	122mm	100mm	30mm	20°	40mm	2
573-122100404-20	122mm	100mm	30mm	20°	40mm	4
573-122130404-20	122mm	130mm	30mm	20°	40mm	4
573-122150402-20	122mm	150mm	30mm	20°	40mm	2
573-122150404-20	122mm	150mm	30mm	20°	40mm	4
573-122170402-20	122mm	170mm	30mm	20°	40mm	2
573-122180402-20	122mm	180mm	30mm	20°	40mm	2
573-122180404-20	122mm	180mm	30mm	20°	40mm	4
573-122210404-20	122mm	210mm	30mm	20°	40mm	4
573-122230402-20	122mm	230mm	30mm	20°	40mm	2
573-122230404-20	122mm	230mm	30mm	20°	40mm	4
573-122240402-20	122mm	240mm	30mm	20°	40mm	2
573-122240404-20	122mm	240mm	30mm	20°	40mm	4

Dual Hook

PART #	D	CE	b1	a	d	Z
573D-122060404	122mm	60mm	30mm	20° + 12°	40mm	2+2
573D-122080404	122mm	80mm	30mm	20° + 12°	40mm	2+2
573D-122100404	122mm	100mm	30mm	20° + 12°	40mm	2+2
573D-122150404	122mm	150mm	30mm	20° + 12°	40mm	2+2
573D-122230404	122mm	230mm	30mm	20° + 12°	40mm	2+2

573P – Corrugated Heads for High Speed Moulders





Sw Hw Fb Pb Pl

See Material Guide p5

Corrugated heads for HSK80W moulders. Speed tested and balanced to run at 12,000rpm. Steel bodies with precision machined 60° corrugations to hold 579 series corrugated steel. Black oxide treatment for corrosion resistance. 20° hook heads for softwood and 12° hook for hardwood and MDF. Made in North America.

20° – 2 Wing

PART #	D	CE	b1	a	Core	Z	Spindle
573P-090050LB2-20	90mm	50mm	35mm	20°	HSK80W	2	Left or Bottom
573P-090050RT2-20	90mm	50mm	35mm	20°	HSK80W	2	Right or Top
573P-090060LB2-20	90mm	60mm	35mm	20°	HSK80W	2	Left or Bottom
573P-090060RT2-20	90mm	60mm	35mm	20°	HSK80W	2	Right or Top
573P-090080LB2-20	90mm	80mm	35mm	20°	HSK80W	2	Left or Bottom
573P-090080RT2-20	90mm	80mm	35mm	20°	HSK80W	2	Right or Top
573P-090100LB2-20	90mm	100mm	35mm	20°	HSK80W	2	Left or Bottom
573P-090100RT2-20	90mm	100mm	35mm	20°	HSK80W	2	Right or Top
573P-090130LB2-20	90mm	130mm	35mm	20°	HSK80W	2	Left or Bottom
573P-090130RT2-20	90mm	130mm	35mm	20°	HSK80W	2	Right or Top
573P-090150LB2-20	90mm	150mm	35mm	20°	HSK80W	2	Left or Bottom
573P-090150RT2-20	90mm	150mm	35mm	20°	HSK80W	2	Right or Top
573P-090180LB2-20	90mm	180mm	35mm	20°	HSK80W	2	Left or Bottom
573P-090180RT2-20	90mm	180mm	35mm	20°	HSK80W	2	Right or Top
573P-090210LB2-20	90mm	210mm	35mm	20°	HSK80W	2	Left or Bottom
573P-090210RT2-20	90mm	210mm	35mm	20°	HSK80W	2	Right or Top
573P-090240LB2-20	90mm	240mm	35mm	20°	HSK80W	2	Left or Bottom
573P-090240RT2-20	90mm	240mm	35mm	20°	HSK80W	2	Right or Top
573P-090260LB2-20	90mm	260mm	35mm	20°	HSK80W	2	Left or Bottom
573P-090260RT2-20	90mm	260mm	35mm	20°	HSK80W	2	Right or Top

20° – 4 Wing

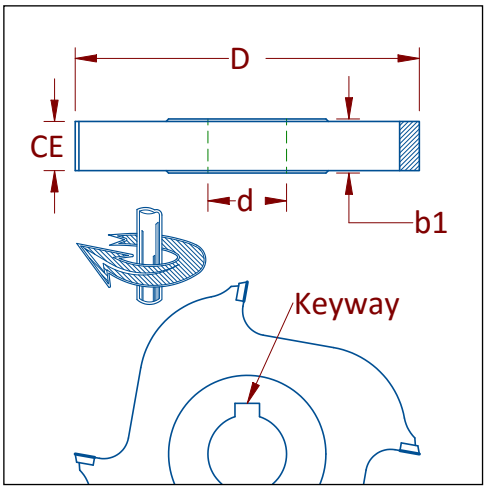
PART #	D	CE	b1	a	Core	Z	Spindle
573P-090050LB4-20	90mm	50mm	35mm	20°	HSK80W	4	Left or Bottom
573P-090050RT4-20	90mm	50mm	35mm	20°	HSK80W	4	Right or Top
573P-090060LB4-20	90mm	60mm	35mm	20°	HSK80W	4	Left or Bottom
573P-090060RT4-20	90mm	60mm	35mm	20°	HSK80W	4	Right or Top
573P-090070LB4-20	90mm	70mm	35mm	20°	HSK80W	4	Left or Bottom
573P-090070RT4-20	90mm	70mm	35mm	20°	HSK80W	4	Right or Top
573P-090080LB4-20	90mm	80mm	35mm	20°	HSK80W	4	Left or Bottom
573P-090080RT4-20	90mm	80mm	35mm	20°	HSK80W	4	Right or Top
573P-090100LB4-20	90mm	100mm	35mm	20°	HSK80W	4	Left or Bottom
573P-090100RT4-20	90mm	100mm	35mm	20°	HSK80W	4	Right or Top
573P-090150LB4-20	90mm	150mm	35mm	20°	HSK80W	4	Left or Bottom
573P-090150RT4-20	90mm	150mm	35mm	20°	HSK80W	4	Right or Top
573P-090170LB4-20	90mm	170mm	35mm	20°	HSK80W	4	Left or Bottom
573P-090170RT4-20	90mm	170mm	35mm	20°	HSK80W	4	Right or Top
573P-090210LB4-20	90mm	210mm	35mm	20°	HSK80W	4	Left or Bottom
573P-090210RT4-20	90mm	210mm	35mm	20°	HSK80W	4	Right or Top
573P-090240LB4-20	90mm	240mm	35mm	20°	HSK80W	4	Left or Bottom
573P-090240RT4-20	90mm	240mm	35mm	20°	HSK80W	4	Right or Top
573P-090260LB4-20	90mm	260mm	35mm	20°	HSK80W	4	Left or Bottom
573P-090260RT4-20	90mm	260mm	35mm	20°	HSK80W	4	Right or Top

12° – 2 Wing

PART #	D	CE	b1	a	Core	Z	Spindle
573P-090040LB2-12	90mm	40mm	35mm	12°	HSK80W	2	Left or Bottom
573P-090060LB2-12	90mm	60mm	35mm	12°	HSK80W	2	Left or Bottom
573P-090060RT2-12	90mm	60mm	35mm	12°	HSK80W	2	Right or Top
573P-090080LB2-12	90mm	80mm	35mm	12°	HSK80W	2	Left or Bottom
573P-090080RT2-12	90mm	80mm	35mm	12°	HSK80W	2	Right or Top
573P-090100LB2-12	90mm	100mm	35mm	12°	HSK80W	2	Left or Bottom
573P-090100RT2-12	90mm	100mm	35mm	12°	HSK80W	2	Right or Top
573P-090150LB2-12	90mm	150mm	35mm	12°	HSK80W	2	Left or Bottom
573P-090150RT2-12	90mm	150mm	35mm	12°	HSK80W	2	Right or Top
573P-090180LB2-12	90mm	180mm	35mm	12°	HSK80W	2	Left or Bottom
573P-090180RT2-12	90mm	180mm	35mm	12°	HSK80W	2	Right or Top

DIA-EBJ – Straight Edgebander Tools





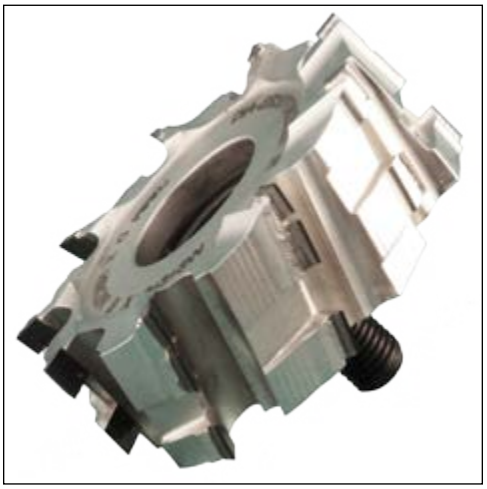
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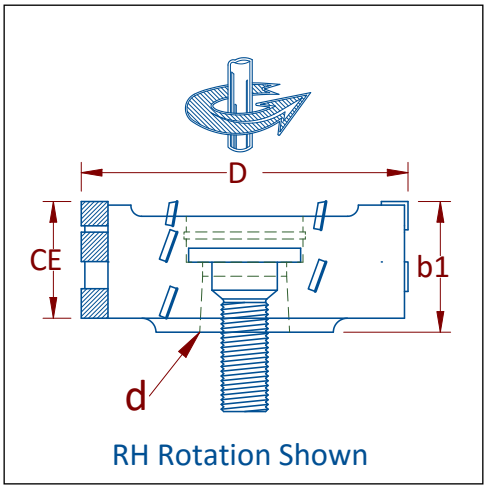
See Material Guide p5

PCD Diamond edgebander tooling for CNC edgebanders. Premium tool geometry and high quality PCD for maximum tool life.

PART #	D	CE	b1	Keyway	d	Z
DIA-EBJ-07041610	70mm	10mm	11mm	5mm	16mm	4

DIA-EBJ – Straight Edgebander Tools HSK25R





Pb Pl Fb Hw Hp Rp

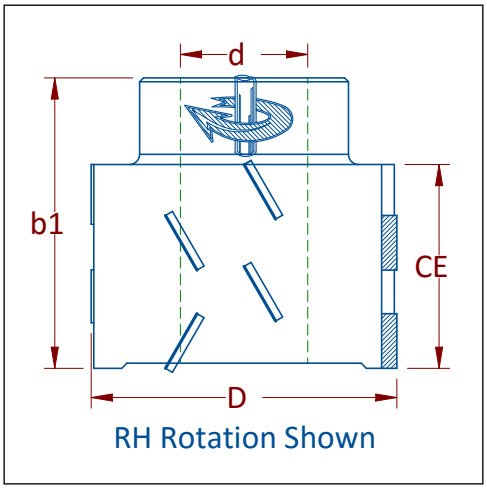
See Material Guide p5

PCD Diamond edgebander tooling for CNC edgebanders. Premium tool geometry and high quality PCD for maximum tool life.

PART # RH	PART # LH	D	CE	b1	d	Z
DIA-EBJ-07092525.R	DIA-EBJ-07092525.L	70mm	25mm	28mm	HSK25R	3+3+3

DIA-EBJ – Straight Edgebander Tools with Hub





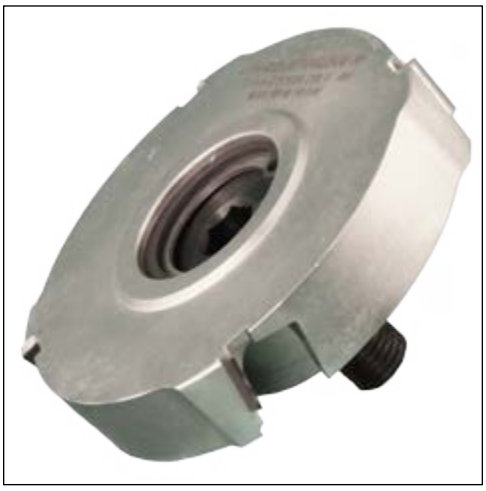
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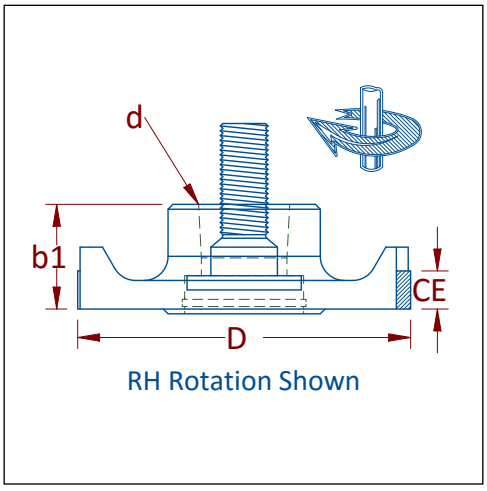
See Material Guide p5

PCD Diamond edgebander tooling for CNC edgebanders. Premium tool geometry and high quality PCD for maximum tool life.

PART # RH	PART # LH	D	CE	b1	Keyway	d	Z
DIA-EBJ06022540R	DIA-EBJ06022540L	60mm	40mm	57mm	8mm	HSK25R	2+2

DIA-EBJ – Edgebander Tools HSK25R Narrow





Pb PI Fb Hw Hp Rp

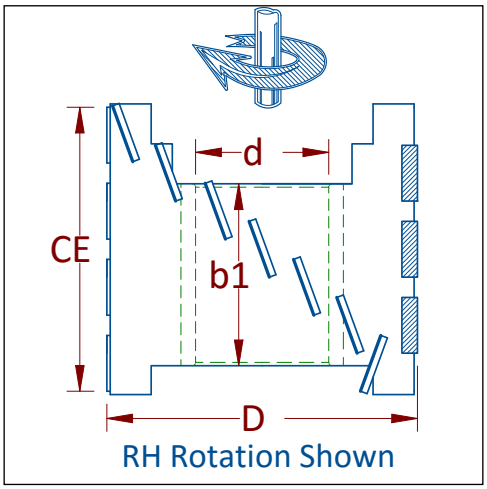
See Material Guide p5

PCD Diamond edgebander tooling for CNC edgebanders. Premium tool geometry and high quality PCD for maximum tool life.

PART # RH	PART # LH	D	CE	b1	d	Z
DIA-EBJ-07042508.R	DIA-EBJ-07042508.L	70mm	8mm	22mm	HSK25R	4
DIA-EBJ07062508R	DIA-EBJ07062508L	70mm	8mm	22mm	HSK25R	6

DIA-EBJ – Straight Edgebander Tools Stepped Hub





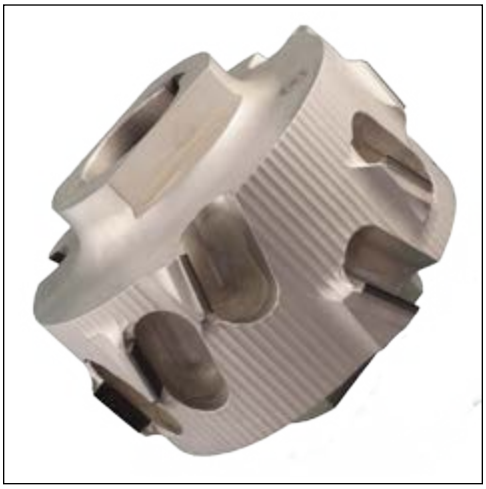
Pb Pl Fb Hw Hp Rp

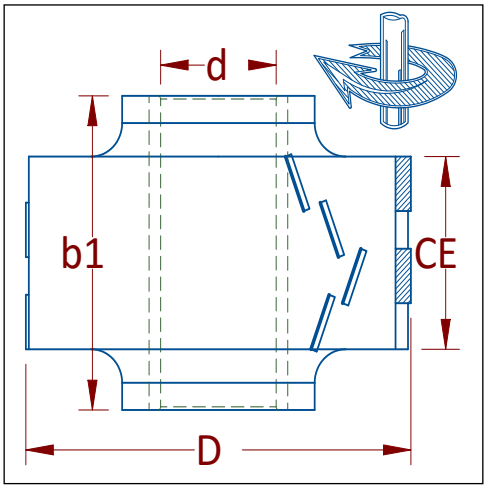
See Material Guide p5

PCD Diamond edgebander tooling for CNC edgebanders. Premium tool geometry and high quality PCD for maximum tool life.

PART # RH	PART # LH	D	CE	b1	Keyway	d	Z
DIA-EBJ07023064.R	*DIA-EBJ07023064.L*	70mm	65mm	41mm	8mm	30mm	2+2

DIA-EBJ – Straight Edgebander Tools Reversible





Pb Pl Fb Hw Hp Rp

See Material Guide p5

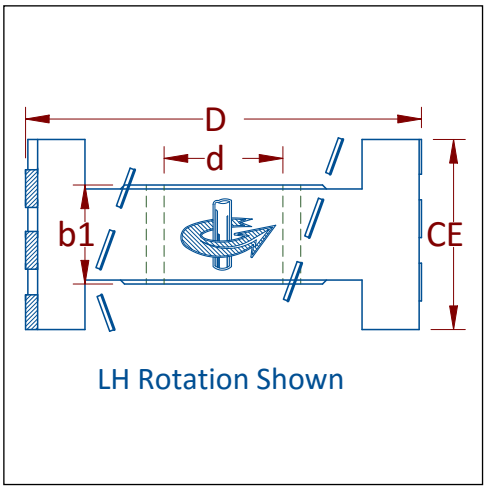
PCD Diamond edgebander tooling for CNC edgebanders. Premium tool geometry and high quality PCD for maximum tool life.

PART	D	CE	b1	Keyway	d	Z
DIA-EBJ10033045	100mm	46mm	75mm	8mm	30mm	3+3
DIA-EBJ10033065*	100mm	65mm	75mm	8mm	30mm	3+3

* 2 Pinholes 5.5mm on 80mm bolt circle for spanner wrench

DIA-EBJ – Straight Edgebander Tools Centered





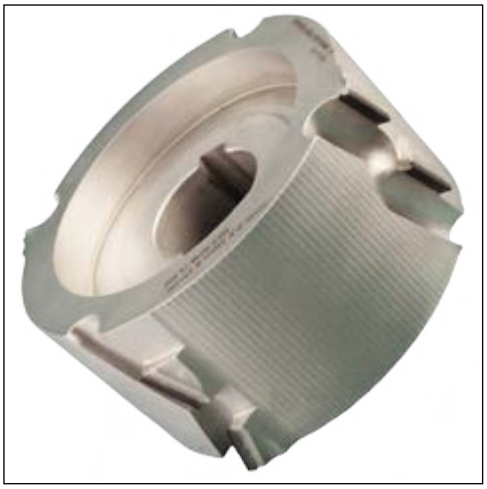
Pb Pl Fb Hw Hp Rp

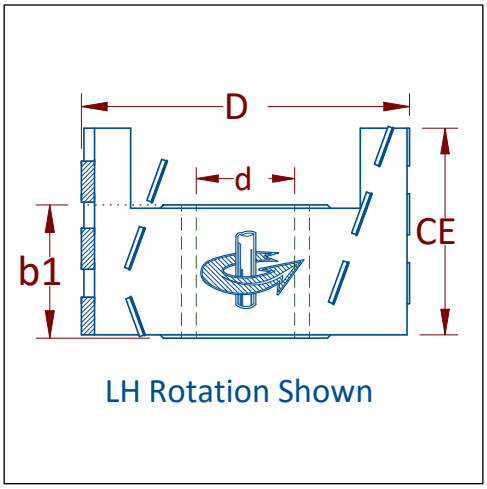
See Material Guide p5

PCD Diamond edgebander tooling for CNC edgebanders. Premium tool geometry and high quality PCD for maximum tool life.

PART # RH	PART # LH	D	CE	b1	Keyway	d	Z
DIA-EBJ10023048R	DIA-EBJ10023048L	100mm	48mm	25mm	8mm	30mm	2+2
DIA-EBJ12533034R	DIA-EBJ12533034L	125mm	34mm	37mm	8mm	30mm	3+3
DIA-EBJ12533043R	DIA-EBJ12533043R	125mm	45mm	41mm	8mm	30mm	3+3

DIA-EBJ – Straight Edgebander Tools Offset





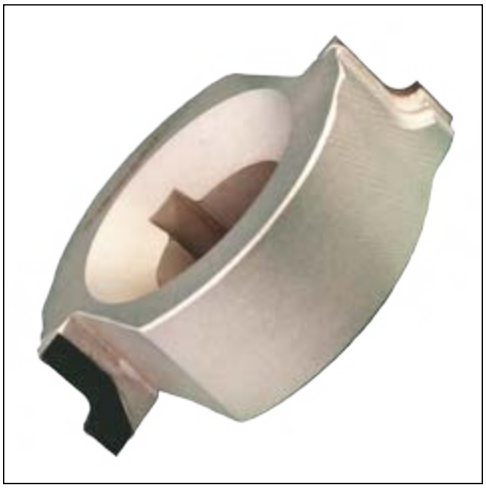
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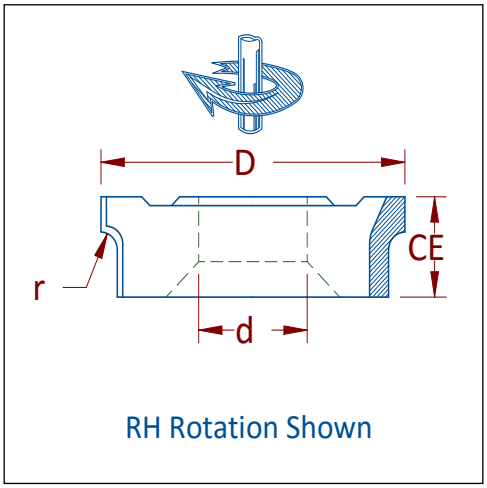
See Material Guide p5

PCD Diamond edgebander tooling for CNC edgebanders. Premium tool geometry and high quality PCD for maximum tool life.

PART # RH	PART # LH	D	CE	b1	Keyway	d	Z
DIA-EBJ10033048R	DIA-EBJ10033048L	100mm	48mm	41mm	8mm	30mm	3+3
DIA-EBJ10033063R	DIA-EBJ10033063L	100mm	64mm	41mm	8mm	30mm	3+3
DIA-EBJ12533063R	*DIA-EBJ12533063L*	125mm	63mm	41mm	8mm	30mm	3+3

DIA-EBR – Radius Edgebander Tools Mini





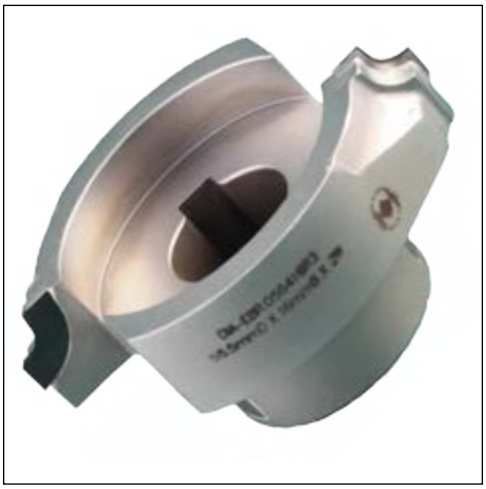
Pb Pl Fb Hw Hp Rp

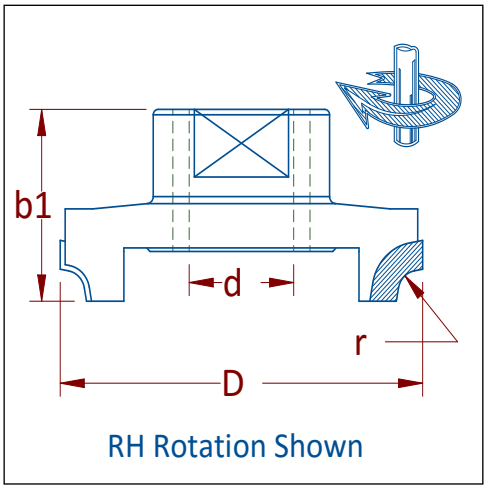
See Material Guide p5

PCD Diamond edgebander tooling for CNC edgebanders. Premium tool geometry and high quality PCD for maximum tool life.

PART # RH	PART # LH	D	CE	r	Keyway	d	Z
DIA-EBR056220R1.5R	DIA-EBR056220R1.5L	56mm	17mm	1.5mm	5mm	20mm	2
DIA-EBR056220R2.R	DIA-EBR056220R2.L	56mm	17mm	2.0mm	5mm	20mm	2
DIA-EBR056220R3.R	DIA-EBR056220R3.L	56mm	17mm	3.0mm	5mm	20mm	2

DIA-EBR – Radius Edgebander Tools Olympic





Pb Pl Fb Hw Hp Rp

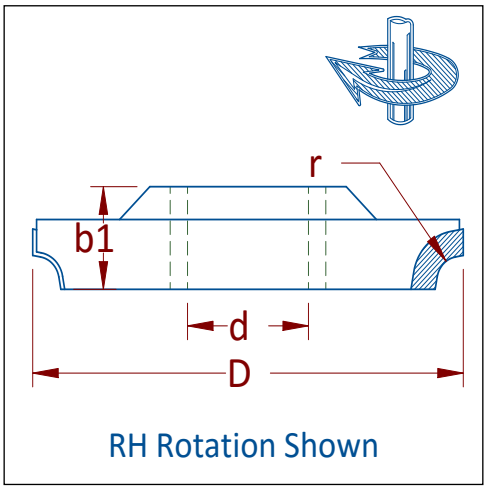
See Material Guide p5

PCD Diamond edgebander tooling for CNC edgebanders. Premium tool geometry and high quality PCD for maximum tool life.
2 flats for wrench to aid in tightening and loosening from machine.

PART # RH	PART # LH	D	r	b1	Keyway	d	Z
DIA-EBR-056416R02.R	*DIA-EBR-056416R02.L*	56mm	2mm	27mm	5mm	16mm	2
DIA-EBR-056416R03.R	DIA-EBR-056416R03.L	56mm	3mm	27mm	5mm	16mm	2

DIA-EBR – Radius Edgebander Tools





Pb Pl Fb Hw Hp Rp

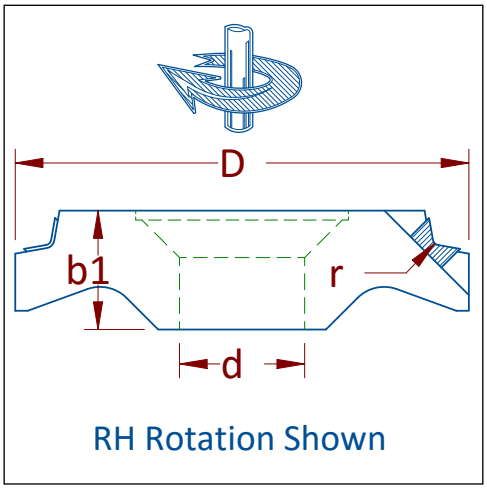
See Material Guide p5

PCD Diamond edgebander tooling for CNC edgebanders. Premium tool geometry and high quality PCD for maximum tool life.

PART # RH	PART # LH	D	r	b1	Keyway	d	Z
DIA-EBR-057216R2 RH	*DIA-EBR-057216R2 LH*	57mm	2.0mm	12.5mm	5mm	16mm	2
DIA-EBR-057216R3 RH	*DIA-EBR-057216R3 LH*	57mm	3.0mm	12.5mm	5mm	16mm	2

DIA-EBR – Radius Edgebander Tools Taper Bore





Pb Pl Fb Hw Hp Rp

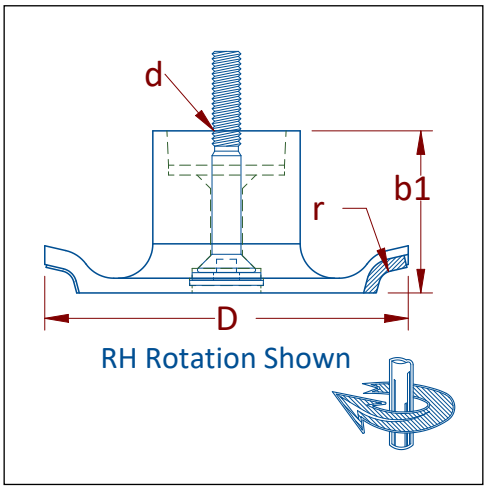
See Material Guide p5

PCD Diamond edgebander tooling for CNC edgebanders. Premium tool geometry and high quality PCD for maximum tool life.

PART # RH	PART # LH	D	r	b1	Keyway	d	Z
DIA-EBR073420R1.R	DIA-EBR073420R1.L	73mm	1.0mm	19mm	5mm	20mm	4

DIA-EBR – Radius Edgebander Tools HSK32





Pb Pl Fb Hw Hp Rp

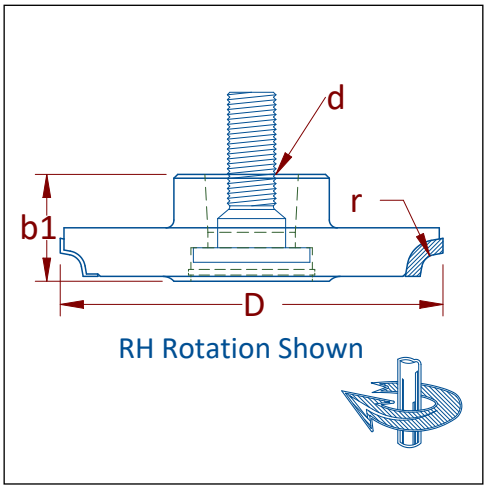
See Material Guide p5

PCD Diamond edgebander tooling for CNC edgebanders. Premium tool geometry and high quality PCD for maximum tool life.

PART # RH	PART # LH	D	r	b1	d	Z
DIA-EBR-074432R03.R	DIA-EBR-074432R03.L	74mm	3mm	33mm	HSK32	4

DIA-EBR – Radius Edgebander Tools HSK25





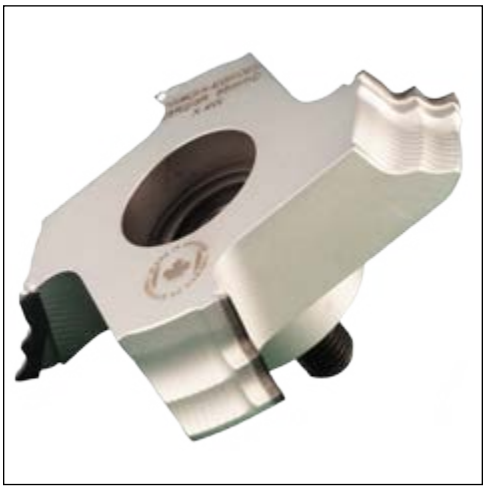
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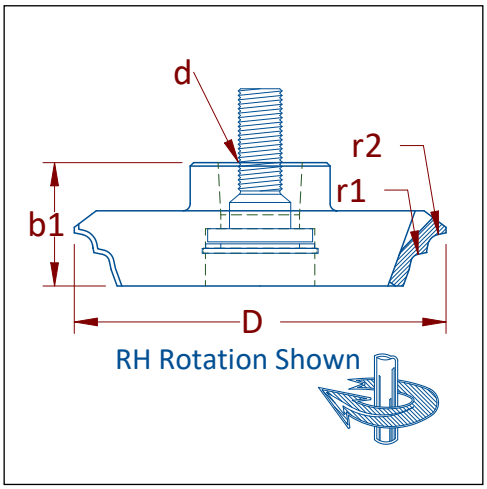
See Material Guide p5

PCD Diamond edgebander tooling for CNC edgebanders. Premium tool geometry and high quality PCD for maximum tool life.

PART # RH	PART # LH	D	r	b1	d	Z
DIA-EBR-07662515.R	DIA-EBR-07662515.L	76mm	1.5mm	23mm	HSK25	6
DIA-EBR084425R2R	*DIA-EBR084425R2L*	84mm	2.0mm	23mm	HSK25	4
DIA-EBR084425R3R	*DIA-EBR084425R3L*	84mm	3.0mm	23mm	HSK25	4
DIA-EBR-079425R2.R	DIA-EBR-079425R2.L	79mm	2.0mm	23mm	HSK25	4
DIA-EBR-079425R3.R	DIA-EBR-079425R3.L	79mm	3.0mm	23mm	HSK25	4
DIA-EBR079625R3.R	DIA-EBR079625R3.L	79mm	3.0mm	23mm	HSK25	6

DIA-EBR – Double Radius Edgebander Tools HSK25





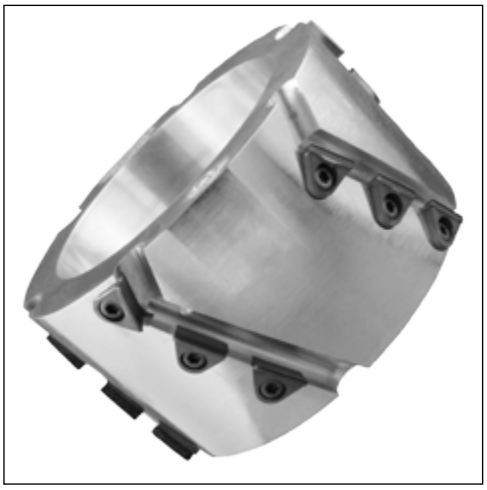
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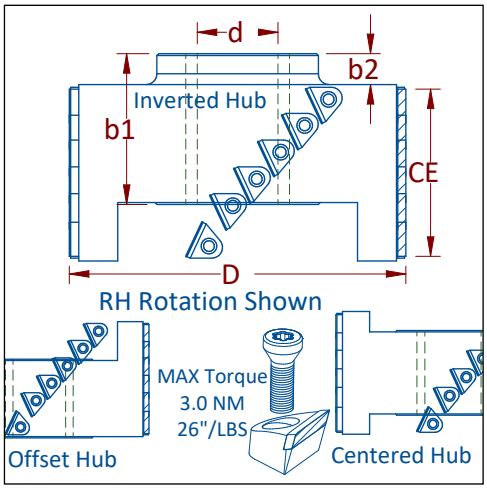
See Material Guide p5

PCD Diamond edgebander tooling for CNC edgebanders. Premium tool geometry and high quality PCD for maximum tool life.

PART # RH	PART # LH	D	r1	r2	b1	d	Z
DIA-EBR-085425R2/3.R	DIA-EBR-085425R2/3.L	85mm	2mm	3mm	28mm	HSK25	4

DIA-EBJ-IN – Insert Edgebander Tool





Pb Pl Fb Hw Hp Rp

See Material Guide p5

PCD Diamond edgebander tooling for CNC edgebanders. Premium tool geometry and high quality PCD for maximum tool life. Replacement inserts allow area that cuts laminate and wears quicker to be changed separately. Inserts can be sharpened 1-2 times. When sharpening inserts must be kept in sets to ensure diameters match.

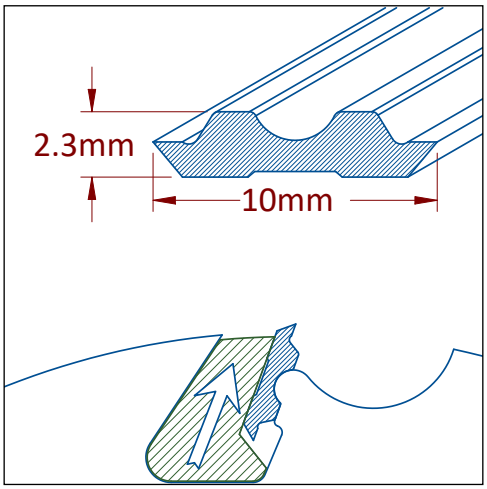
All tools have 8mm keyway

PART # RH	PART # LH	D	b1	b2	d	CE	Z	Hub	Insert
DIA-EBJ06022540.INR	*DIA-EBJ06022540.INL*	60mm	59mm	17mm	25mm	40mm	2	Inverted	DIA-EBJ080IN
DIA-EBJ10033045.INR	*DIA-EBJ10033045.INL*	100mm	40mm	-9.4mm	30mm	45mm	3	Offset	DIA-EBJ080IN
DIA-EBJ12533043.INR	*DIA-EBJ12533043.INL*	125mm	41mm	-3.2mm	30mm	42mm	3	Centered	DIA-EBJ125IN
DIA-EBJ12533062.INR	DIA-EBJ12533062.INL	125mm	56mm	11.5mm	30mm	62mm	3	Inverted	DIA-EBJ125IN

All tools have 8mm keyway

TERSA® Planer Knives





Sw Hw Fb Hp Sp

See Material Guide p5

High quality Swiss made TERSA knives. Knives can be cut to any specified length for each grade. Full length coils available to purchase and cut to length at your facility. Different grades shown below for various applications.

CHROME

Lowest knife prices. Offers best impact resistance when cutting green lumber or rough material. Best suited for primary softwoods.

HSS

Most popular grade. Great all around value. Harder and more wear resistant than chrome. HSS offers extended life on softwoods; and can be used on most hardwoods.

M42

Harder and more wear resistant than HSS and Chrome. M42 grade offers longer life in hardwoods and other man made materials.

CARBIDE

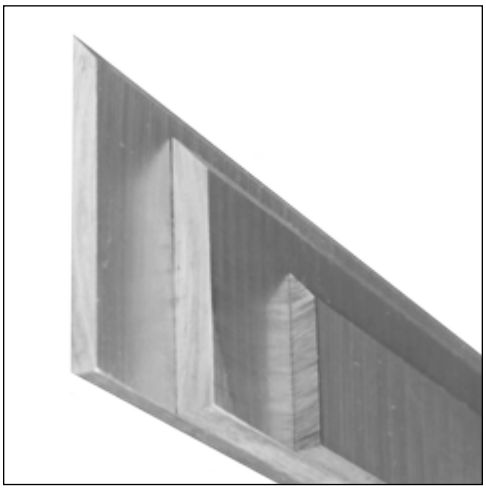
10 + times the life of M42 grade. Carbide offers extended life in machining dense hardwoods, glued material, MDF or other abrasive man made materials. Due to its high hardness, carbide is more brittle and is not recommended for primary or rough lumber.

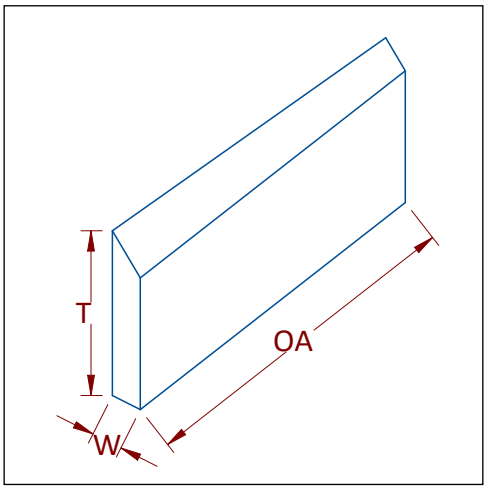
PART #	Grade	Length
TERSA-CR###	Chrome	10mm - 700mm
TERSA-HS###	HSS	10mm - 700mm
TERSA-M42###	M42	10mm - 700mm
TERSA-SC###	Carbide	50mm - 630mm

FULL COILS

PART #	Grade	Length
TERSA-COIL.CHR	Chrome	120 Meters
TERSA-COIL.HSS	HSS	120 Meters
TERSA-COIL.M42	M42	120 Meters

577 – HSS Planer Stock





Sw Hw Hp Sp

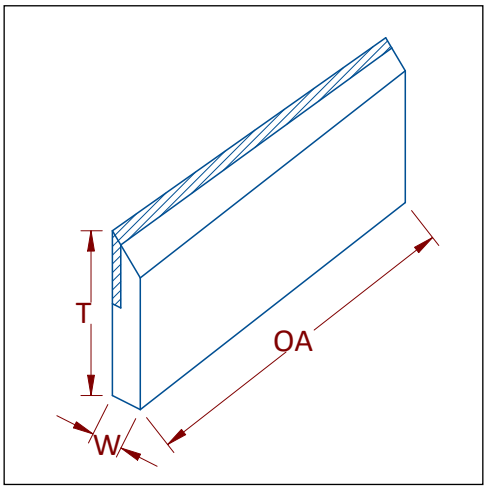
See Material Guide p5

Economical HSS planer stock for planers and jointers. 18% Tungsten HSS knives work great for softwoods and suitable for most hardwoods. Full length bar is available for order or knives can be cut to any specified length.

PART #	W	OA	T
577-18-1603 (BAR)	3mm	1000mm	16mm
577-18-1603 (PCS)	3mm	Per Request	16mm
577-18-1903 (BAR)	3mm	1000mm	19mm
577-18-1903 (PCS)	3mm	Per Request	19mm
577-18-2503 (BAR)	3mm	1000mm	25mm
577-18-2503 (PCS)	3mm	Per Request	25mm
577-18-2504 (BAR)	4mm	1000mm	25mm
577-18-2504 (PCS)	4mm	Per Request	25mm
577-18-3003 (BAR)	3mm	1000mm	30mm
577-18-3003 (PCS)	3mm	Per Request	30mm
577-18-3004 (BAR)	4mm	1000mm	30mm
577-18-3004 (PCS)	4mm	Per Request	30mm
577-18-3503 (BAR)	3mm	1000mm	35mm
577-18-3503 (PCS)	3mm	Per Request	35mm
577-18-3504 (BAR)	4mm	1000mm	35mm
577-18-3504 (PCS)	4mm	Per Request	35mm
577-18-4003 (BAR)	3mm	1000mm	40mm
577-18-4003 (PCS)	3mm	Per Request	40mm

578 – Carbide Inlay Planer Stock





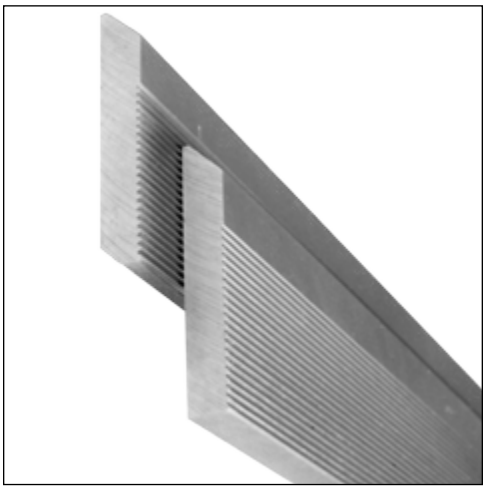
Sw Hw Fb Hp Sp

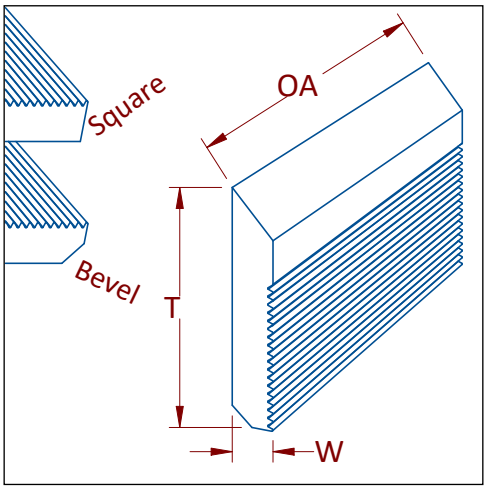
See Material Guide p5

Carbide inlayed planer stock for planers and jointers. Carbide inlay knives work great for hardwoods, glued material, MDF or other man made materials. Full length bar is available for order or knives can be cut to any specified length.

PART #	W	OA	T
578-01603M (BAR)	3mm	635mm	16mm
578-01603M (PCS)	3mm	Per Request	16mm
578-01903M (BAR)	3mm	635mm	19mm
578-01903M (PCS)	3mm	Per Request	19mm
578-02503M (BAR)	3mm	635mm	25mm
578-02503M (PCS)	3mm	Per Request	25mm
578-02504M (BAR)	4mm	635mm	25mm
578-02504M (PCS)	4mm	Per Request	25mm
578-03003M (BAR)	3mm	635mm	30mm
578-03003M (PCS)	3mm	Per Request	30mm
578-03004M (BAR)	4mm	635mm	30mm
578-03004M (PCS)	4mm	Per Request	30mm
578-03503M (BAR)	3mm	635mm	35mm
578-03503M (PCS)	3mm	Per Request	35mm
578-03504M (BAR)	4mm	635mm	35mm
578-03504M (PCS)	4mm	Per Request	35mm

579 –Corrugated Knife Stock





Sw Hw Hp Sp

See Material Guide p5

Premium quality corrugated steel for moulder heads. Full length bar is available for order or knives can be cut to any specified length. Profile can be applied to knife upon customers request. Multiple grades available for different applications. 60º corrugations fits majority of popular corrugated heads.

M2

Lowest knife prices. Offers best impact resistance when cutting green lumber or rough material. Best suited for primary softwoods. Most economical option for short runs. Not recommended for hardwoods.

18%

Super hard high speed steel with 18% tungsten. Well suited for hardwoods and can be used on softwoods also. Care must be taken not to apply too much heat to the material when grinding because excessive heating and cooling can cause cracking in the material.

HPS®

German steel made with a unique hardening process. Grinds extremely well and provides excellent life in both hardwoods and softwoods. Great all around grade.

M2 – Square Back

PART #	W	T	OA
579-PR-M2-6X40	6mm	40mm	635mm
579-PR-M2-6X50	6mm	50mm	635mm
579-PR-M2-6X65	6mm	65mm	635mm
579-PR-M2-8X35	8mm	35mm	635mm
579-PR-M2-8X40	8mm	40mm	635mm
579-PR-M2-8X45	8mm	45mm	635mm
579-PR-M2-8X50	8mm	50mm	635mm
579-PR-M2-8X65	8mm	65mm	635mm
579-PR-M2-8X70	8mm	70mm	635mm
579-PR-M2-8X75	8mm	75mm	635mm
579-PR-M2-8X80	8mm	80mm	635mm

M2 – Bevel Back

PART #	W	T	OA
579-M2-6X35	6mm	35mm	635mm
579-M2-6X40	6mm	40mm	635mm
579-M2-6X45	6mm	45mm	635mm
579-M2-6X50	6mm	50mm	635mm
579-M2-6X60	6mm	60mm	635mm
579-M2-6X65	6mm	65mm	635mm
579-M2-8X35	8mm	35mm	635mm
579-M2-8X40	8mm	40mm	635mm
579-M2-8X45	8mm	45mm	635mm
579-M2-8X50	8mm	50mm	635mm
579-M2-8X60	8mm	60mm	635mm
579-M2-8X65	8mm	65mm	635mm
579-M2-8X70	8mm	70mm	635mm
579-M2-8X75	8mm	75mm	635mm
579-M2-8X80	8mm	80mm	635mm

Continued on next page . . .

18% – Square Back

PART #	W	T	OA
579-PR-18-6X32	6mm	32mm	635mm
579-PR-18-6X40	6mm	40mm	635mm
579-PR-18-6X45	6mm	45mm	635mm
579-PR-18-6X50	6mm	50mm	635mm
579-PR-18-6X65	6mm	65mm	635mm
579-PR-18-8X32	8mm	32mm	635mm
579-PR-18-8X40	8mm	40mm	635mm
579-PR-18-8X45	8mm	45mm	635mm
579-PR-18-8X50	8mm	50mm	635mm
579-PR-18-8X60	8mm	60mm	635mm
579-PR-18-8X65	8mm	65mm	635mm
579-PR-18-8X70	8mm	70mm	635mm
579-PR-18-8X75	8mm	75mm	635mm

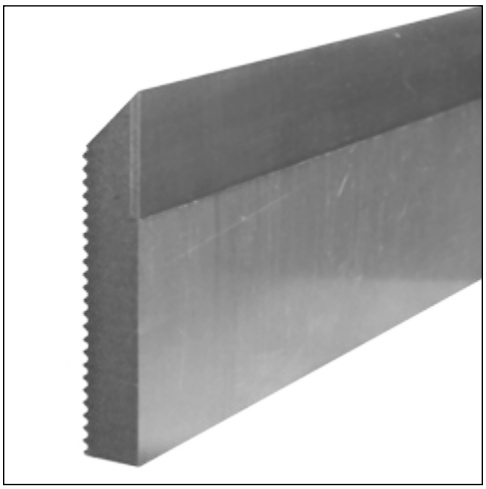
18% – Bevel Back

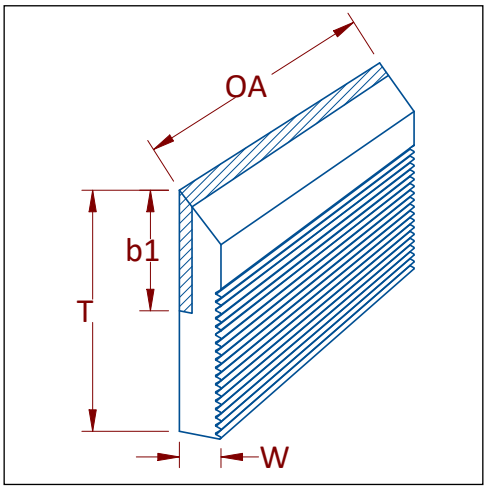
PART #	W	T	OA
579-18-6X40	6mm	40mm	635mm
579-18-6X45	6mm	45mm	635mm
579-18-6X50	6mm	50mm	635mm
579-18-6X65	6mm	65mm	635mm
579-18-8X32	8mm	32mm	635mm
579-18-8X35	8mm	35mm	635mm
579-18-8X40	8mm	40mm	635mm
579-18-8X45	8mm	45mm	635mm
579-18-8X50	8mm	50mm	635mm
579-18-8X60	8mm	60mm	635mm
579-18-8X65	8mm	65mm	635mm
579-18-8X70	8mm	70mm	635mm
579-18-8X80	8mm	75mm	635mm

HPS – Square Back

PART #	W	T	OA
579-HPS-6X40	1/4"	1-1/2"	25"
579-HPS-6X45	1/4"	1-3/4"	25"
579-HPS-6X50	1/4"	2"	25"
579-HPS-8X40	5/16"	1-1/2"	25"
579-HPS-8X45	5/16"	1-3/4"	25"
579-HPS-8X50	5/16"	2"	25"
579-HPS-8X55	5/16"	2-1/4"	25"
579-HPS-8X60	5/16"	2-1/2"	25"
579-HPS-8X70	5/16"	2-3/4"	25"
579-HPS-8X75	5/16"	3"	25"

579-CT – Carbide Inlay Corrugated Knife Stock





Hw Fb Hp Sp

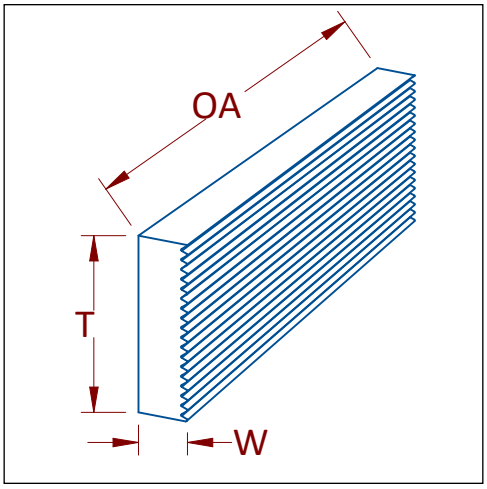
See Material Guide p5

Economical carbide inlay corrugated steel for moulder heads. Full length bar is available for order or knives can be cut to any specified length. Profile can be applied to knife upon customers request. Carbide inlay outlast conventional steel up to 10 times longer.

PART #	W	T	b1	OA
579-CT-6X45-20	6mm	45mm	20mm	635mm
579-CT-6X50-20	6mm	50mm	20mm	635mm
579-CT-6X50-25	6mm	50mm	25mm	635mm
579-CT-8X38-15	8mm	38mm	15mm	635mm
579-CT-8X45-15	8mm	45mm	15mm	635mm
579-CT-8X50-25	8mm	50mm	25mm	635mm

579-FILLER – Carbide Corrugated Filler Stock

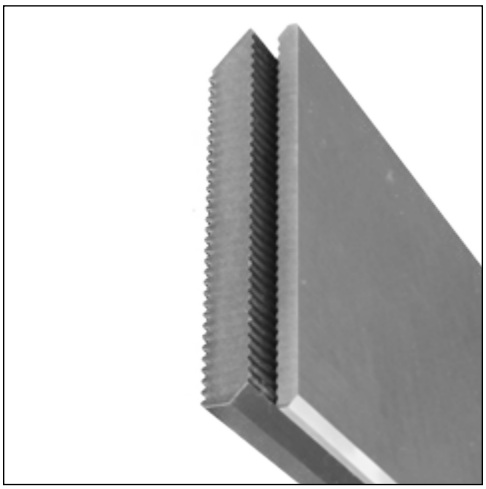


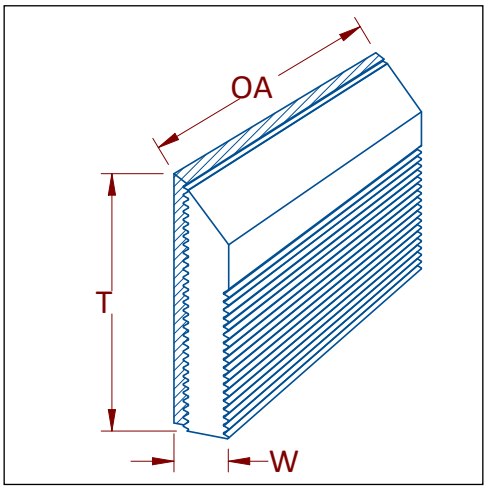


Used to fill empty sections of corrugated heads. Allows shorter profiled knives to run in longer heads. Can also be used to fill up unused pockets in 4 wing heads. Filler stock can be cut to any required length. Important to ensure filler stock is same thickness of knives.

PART #	W	T	OA
579-FILLER-1	1/4"	1"	25"
579-FILLER-3	5/16"	1"	25"

579BP – Bak-Pak Corrugated Steel





Hw Fb Hp Sp

See Material Guide p5

High quality German Bak-Pak carbide knives. Precision ground carbide provides 10+ times the life of conventional steel knives. Carbide insert can be sharpened multiple times and can be used on deeper profiles than carbide inlay. Full length bar is available for order or knives can be cut to any specified length. 60° corrugations fit conventional corrugated heads. Profile can be applied to knife upon customers request. Backer is made from premium tool steel.

Full Length Carbide & Backer

PART #	T	W	OA
579BP-38330	38mm	10mm	330mm
579BP-50330	50mm	10mm	330mm
579BP-60330	60mm	10mm	330mm

Cut to Length Carbide & Backer

PART #	T	W	OA
579BP-38###	38mm	10mm	Specify
579BP-50###	50mm	10mm	Specify
579BP-60###	60mm	10mm	Specify

Full Length Backer Only

PART #	T	W	OA
579BP-38330.B	38mm	10mm	330mm
579BP-50330.B	50mm	10mm	330mm
579BP-60330.B	60mm	10mm	330mm

Cut to Length Backer Only

PART #	T	W	OA
579BP-38###.B	38mm	10mm	Specify
579BP-50###.B	50mm	10mm	Specify
579BP-60###.B	60mm	10mm	Specify

Full Length Carbide Only

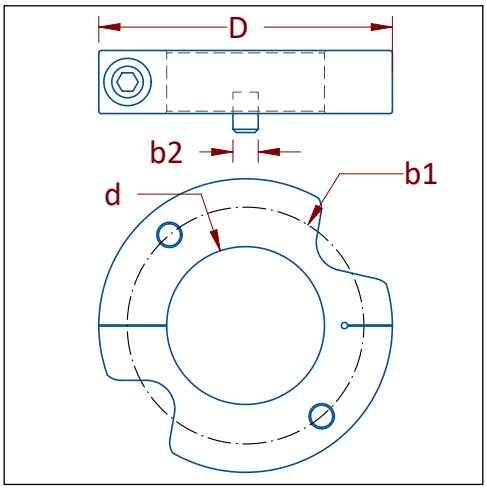
PART #	T	W	OA
579BP-38330.C	38mm	10mm	330mm
579BP-50330.C	50mm	10mm	330mm
579BP-60330.C	60mm	10mm	330mm

Cut to Length Carbide Only

PART #	T	W	OA
579BP-38###.C	38mm	10mm	Specify
579BP-50###.C	50mm	10mm	Specify
579BP-60###.C	60mm	10mm	Specify

583LR – Lock Collars





High quality locking collars for hydraulic arbor cutterheads. Provides added safety on moulder spindle in case the hydraulic sleeve loses pressure. Will prevent hydraulic arbor cutterhead from coming off spindle if pressure fails.

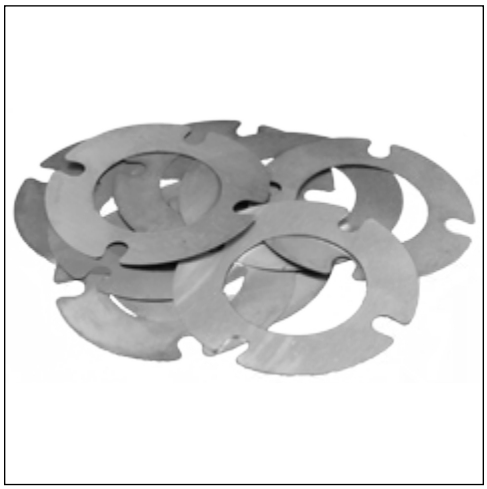
Imperial

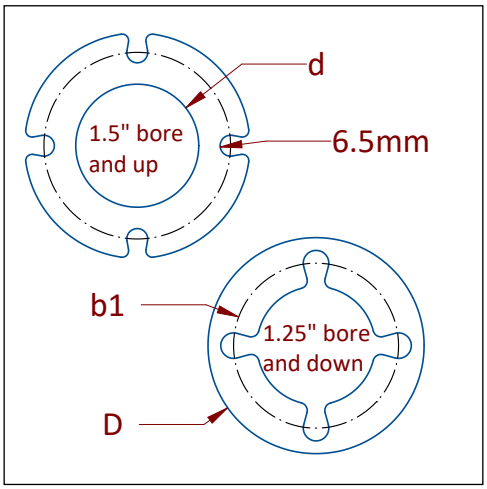
PART #	D	d	b1	b2
583LR-I150.050	83mm	1-1/2"	65mm	8mm
583LR-I181.060	93mm	1-13/16"	74mm	8mm
583LR-I181.065	93mm	1-13/16"	80mm	8mm
583LR-I212.065	98mm	2-1/8"	80mm	8mm

Metric

PART #	D	d	b1	b2
583LR-M040.050	83mm	40mm	65mm	8mm
583LR-M040.060	93mm	40mm	75mm	8mm
583LR-M050.060	93mm	50mm	80mm	8mm

583SHM – Shims





Precision shims for spacing cutterheads. Comes with standard bolt pattern common to custom tools manufactured at Royce Ayr.

Imperial

PART #	D	d	b1	Thick
583SHM-I100.002	55mm	1”	42mm	.002”
583SHM-I100.005	55mm	1”	42mm	.005”
583SHM-I100.010	55mm	1”	42mm	.010”
583SHM-I100.020	55mm	1”	42mm	.020”
583SHM-I100.3MM	55mm	1”	42mm	3mm
583SHM-I125.002	55mm	1-1/4”	42mm	.002”
583SHM-I125.005	55mm	1-1/4”	42mm	.005”
583SHM-I125.010	55mm	1-1/4”	42mm	.010”
583SHM-I125.020	55mm	1-1/4”	42mm	.020”
583SHM-I125.3MM	55mm	1-1/4”	42mm	3mm
583SHM-I150.002	70mm	1-1/2”	58mm	.002”
583SHM-I150.005	70mm	1-1/2”	58mm	.005”
583SHM-I150.010	70mm	1-1/2”	58mm	.010”
583SHM-I150.020	70mm	1-1/2”	58mm	.020”
583SHM-I150.3MM	70mm	1-1/2”	58mm	3mm
583SHM-I181.002	70mm	1-13/16”	58mm	.002”
583SHM-I181.005	70mm	1-13/16”	58mm	.005”
583SHM-I181.010	70mm	1-13/16”	58mm	.010”
583SHM-I181.020	70mm	1-13/16”	58mm	.020”
583SHM-I181.3MM	70mm	1-13/16”	58mm	3mm

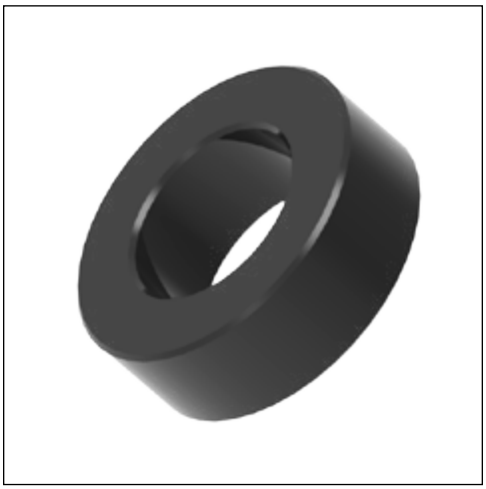
Metric

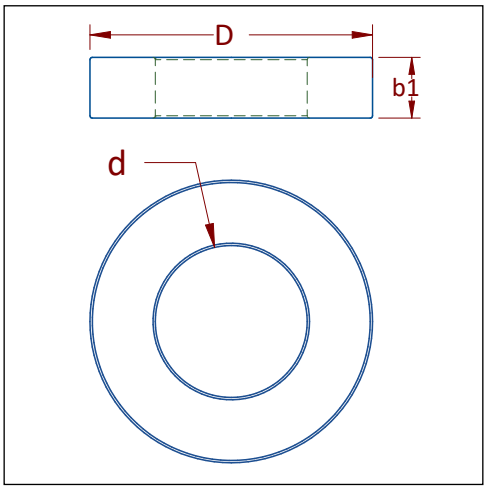
PART #	D	d	b1	Thick
583SHM-M30.002	55mm	30mm	42mm	.002”
583SHM-M30.005	55mm	30mm	42mm	.005”
583SHM-M30.010	55mm	30mm	42mm	.010”
583SHM-M30.020	55mm	30mm	42mm	.020”
583SHM-M30.3MM	55mm	30mm	42mm	3mm
583SHM-M40.002	70mm	40mm	58mm	.002”
583SHM-M40.005	70mm	40mm	58mm	.005”
583SHM-M40.010	70mm	40mm	58mm	.010”
583SHM-M40.020	70mm	40mm	58mm	.020”
583SHM-M40.3MM	70mm	40mm	58mm	3mm
583SHM-M50.002	83mm	50mm	64mm	.002”
583SHM-M50.005	83mm	50mm	64mm	.005”
583SHM-M50.010	83mm	50mm	64mm	.010”
583SHM-M50.020	83mm	50mm	64mm	.020”
583SHM-M50.3MM	83mm	50mm	64mm	3mm
583SHM-M60.002	93mm	60mm	74mm	.002”
583SHM-M60.005	93mm	60mm	74mm	.005”
583SHM-M60.010	93mm	60mm	74mm	.010”
583SHM-M60.020	93mm	60mm	74mm	.020”
583SHM-M60.3MM	93mm	60mm	74mm	3mm
583SHM-M65.002	70mm	65mm	58mm	.002”
583SHM-M65.005	70mm	65mm	58mm	.005”
583SHM-M65.010	70mm	65mm	58mm	.010”
583SHM-M65.020	70mm	65mm	58mm	.020”
583SHM-M65.3MM	70mm	65mm	58mm	3mm

Shim Sets

PART #	D	d	b1	Thick	Includes
583SHM-I125.SET3	55mm	1-1/4”	42mm	.002” to .633”	2pc - 0.002”, 3pc - 0.633”, 2pc - 0.010”, 6pc - 0.020”, 4pc - 0.118”
583SHM-M40.SET3	70mm	40mm	58mm	.002” to .633”	2pc - 0.002”, 3pc - 0.633”, 2pc - 0.010”, 6pc - 0.020”, 4pc - 0.118”

583SPR – Spacers





Precision spacers for spacing cutterheads on spindles.

Imperial

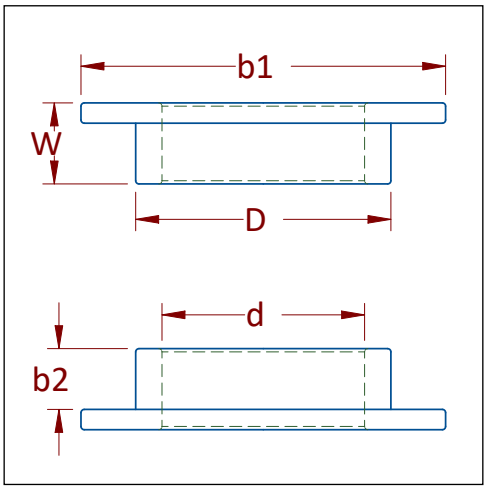
PART #	d	D	b1
583SPR.I100.025	1”	55mm	1/4”
583SPR.I100.050	1”	55mm	1/2”
583SPR.I100.100	1”	55mm	1”
583SPR.I125.025	1-1/4”	55mm	1/4”
583SPR.I125.050	1-1/4”	55mm	1/2”
583SPR.I125.100	1-1/4”	55mm	1”
583SPR.I181.025	1-13/16”	70mm	1/4”
583SPR.I181.050	1-13/16”	70mm	1/2”
583SPR.I181.100	1-13/16”	70mm	1”

Metric

PART #	d	D	b1
583SPR.M30.06MM	30mm	55mm	6mm
583SPR.M30.12MM	30mm	55mm	12mm
583SPR.M30.24MM	30mm	55mm	24mm
583SPR.M40.06MM	40mm	70mm	6mm
583SPR.M40.12MM	40mm	70mm	12mm
583SPR.M40.24MM	40mm	70mm	24mm

585 – T Bushing Sets

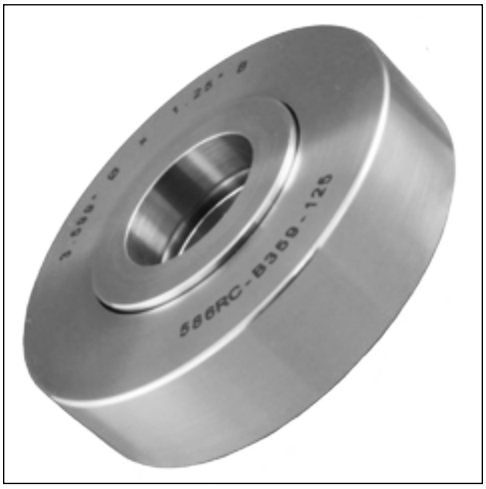


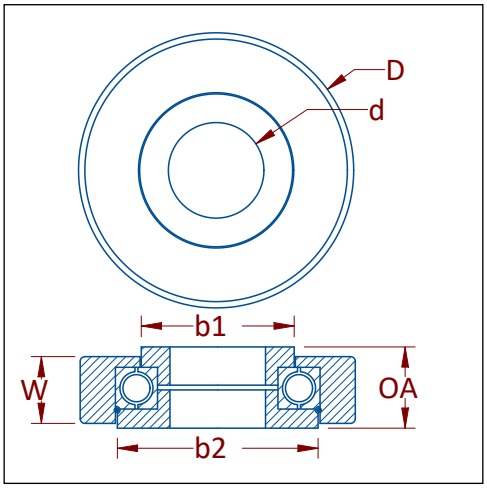


T bushing sets for moulders and shapers. Come in sets of 2 pieces. Good for adapting cutterheads to run on moulders, shapers and other machines.

PART #	D	d	W	b1	b2
585-T3219.50	1-1/4"	3/4"	1/2"	2"	3/8"
585-T3225.50	1-1/4"	1"	1/2"	2"	3/8"
585-T4032.50	40mm	1-1/4"	1/2"	2-1/4"	3/8"
585-T4632.63	1-13/16"	1-1/4"	5/8"	2-5/8"	7/16"
585-T4640.63	50mm	40mm	5/8"	65mm	7/16"

586RC – Rub Collar Bearings





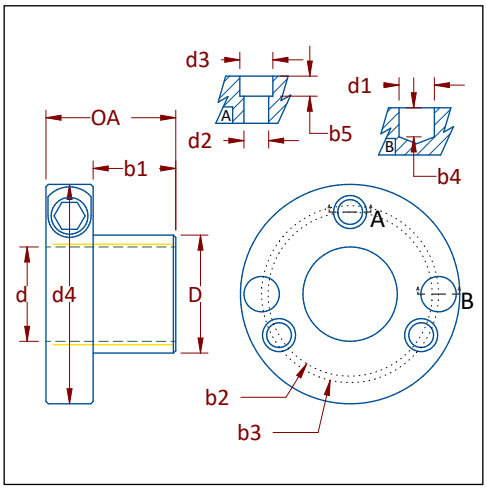
Rub collar bearings for shaper tools. Precision high quality bearings. Used to produce curved components by use of a template. Specific diameter bearings to run with stock cabinet door insert set.

PART #	D	d	W	b1	b2	OA
586RC-B300-125	3"	1-1/4"	7/8"	2"	2-5/8"	1-1/16"
586RC-B300.552RP*	3"	1-1/4"	2-9/16"	2-9/16"	5/32"	1/2"
586RC-B325-125	3-1/4"	1-1/4"	7/8"	2"	2-5/8"	1-1/16"
586RC-B359-125•	3.599"	1-1/4"	7/8"	2"	2-5/8"	1-1/16"
586RC-B393-125	100mm	1-1/4"	7/8"	2"	2-5/8"	1-1/16"
586RC-B400-125	4"	1-1/4"	7/8"	2"	2-5/8"	1-1/16"

* For use with 552RP.150-3W and 552RP.108-3W
• For use with 553P and 553S cabinet door tools

PRC-AI Hydraulic Sleeves "AI" Type





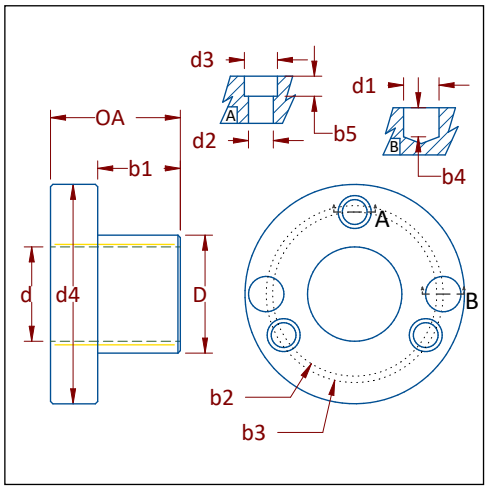
Hydraulic sleeve increases running accuracy and rigidity on tools that run on arbors. "AI" type sleeve for permanent assembly via bolts. Pressurization carried out by tightening 6mm allen key to 5 Nm. Sleeve pressurizes on internal arbor only.

HYDRO-GRIP

PART #	D	d	OA	b1	b2	b3	b4	b5	d1	d2	d3	d4
PRC-AI-1 1/2/50-55	50mm	1-1/2"	55mm	35mm	64mm	65mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-AI-1 1/4/40-55	40mm	1-1/4"	55mm	35mm	55mm	55mm	10mm	9.0mm	15mm	10.5mm	15mm	83mm
PRC-AI-1 13/16/60-55	60mm	1-13/16"	55mm	35mm	74mm	75mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-AI-1 13/16/65-55	65mm	1-13/16"	55mm	35mm	74mm	75mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-AI-2 1/8/65-55	65mm	2-1/8"	55mm	35mm	80mm	80mm	10mm	8.5mm	15mm	10.5mm	15mm	98mm
PRC-AI-40/50-55	50mm	40mm	55mm	35mm	64mm	65mm	10mm	5.5mm	15mm	6.0mm	10mm	83mm
PRC-AI-40/60-55	60mm	40mm	55mm	35mm	74mm	75mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-AI-50/60-55	60mm	50mm	55mm	35mm	74mm	75mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-AI-50/60-75	60mm	50mm	75mm	55mm	74mm	75mm	10mm	8.5mm	15mm	10.5mm	14mm	93mm
PRC-AI-50/65-75	65mm	50mm	75mm	55mm	80mm	80mm	10mm	8.5mm	15mm	10.5mm	15mm	98mm

PRC-A Hydraulic Sleeves "A" Type





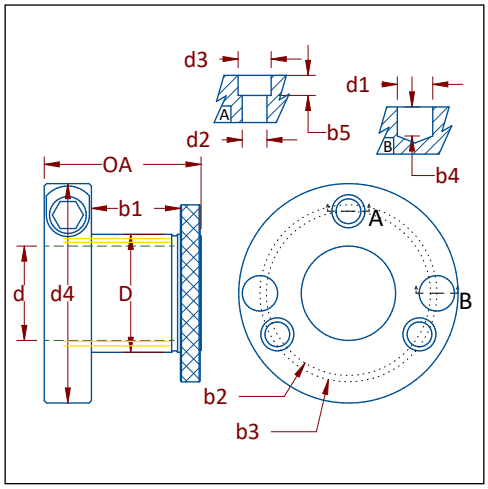
Hydraulic sleeve increases running accuracy and rigidity on tools that run on arbors. "A" type sleeve for permanent assembly via bolts. Pressurization carried out with high pressure grease pump. Sleeve pressurizes on internal arbor only.

HYDRO-GRIP

PART #	D	d	OA	b1	b2	b3	b4	b5	d1	d2	d3	d4
PRC-A-1 1/4/40-55	40mm	1-1/4"	55mm	35mm	55mm	55mm	10mm	9.0mm	15mm	10.5mm	15mm	75mm
PRC-A-1 13/16/65-55	60mm	1-13/16"	55mm	35mm	80mm	80mm	10mm	8.5mm	15mm	10.5mm	15mm	98mm
PRC-A-2 1/8/65/55	65mm	2-1/8"	55mm	35mm	80mm	80mm	10mm	9.0mm	15mm	10.5mm	15mm	98mm
PRC-A-40/60-55	60mm	40mm	55mm	35mm	74mm	75mm	10mm	8.5mm	15mm	10.5mm	14mm	93mm
PRC-A-50/60-75	60mm	50mm	75mm	55mm	74mm	75mm	10mm	8.5mm	15mm	10.5mm	14mm	93mm
PRC-A-60/70-55	70mm	60mm	55mm	35mm	85mm	86mm	10mm	9.0mm	15mm	10.5mm	15mm	98mm
PRC-A-60/70-75	70mm	60mm	75mm	55mm	85mm	86mm	10mm	9.0mm	15mm	10.5mm	15mm	98mm

PRC-BI Hydraulic Sleeves "BI" Type





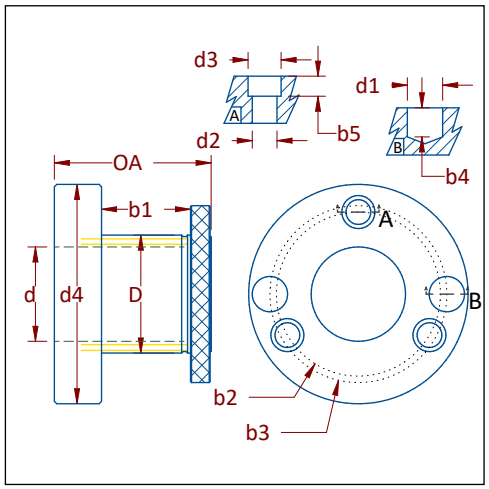
Hydraulic sleeve increases running accuracy and rigidity on tools that run on arbors. "BI" type sleeve for interchangeable tool assembly with threaded locking nut. Pressurization carried out by tightening 6mm allen key to 5 Nm. Sleeve pressurizes on internal arbor as well as tool.

HYDRO-GRIP

PART #	D	d	OA	b1	b2	b3	b4	b5	d1	d2	d3	d4
PRC-BI-1 13/16/60-115	60mm	1-13/16"	115mm	80mm	74mm	75mm	10mm	8.5mm	15mm	10.5mm	15mm	108mm
PRC-BI-2 1/8/65-185	65mm	2-1/8"	185mm	150mm	80mm	80mm	10mm	8.5mm	15mm	10.5mm	15mm	117mm
PRC-BI-40/50-75	50mm	50mm	75mm	40mm	64mm	65mm	10mm	8.5mm	15mm	10.5mm	15mm	100mm
PRC-BI-40/60-115	60mm	60mm	115mm	80mm	74mm	75mm	10mm	8.5mm	15mm	10.5mm	15mm	108mm
PRC-BI-40/60-95	60mm	60mm	95mm	60mm	74mm	75mm	10mm	8.5mm	15mm	10.5mm	15mm	108mm

PRC-B Hydraulic Sleeves "B" Type





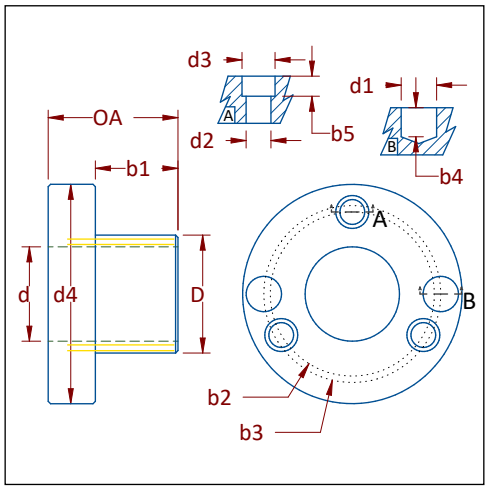
Hydraulic sleeve increases running accuracy and rigidity on tools that run on arbors. "B" type sleeve for interchangeable tool assembly with threaded locking nut. Pressurization carried out with high pressure grease pump. Sleeve pressurizes on internal arbor as well as tool.

HYDRO-GRIP

PART #	D	d	OA	b1	b2	b3	b4	b5	d1	d2	d3	d4
PRC-B-1 1/2/50-85	50mm	1-1/2"	85mm	50mm	64mm	64mm	10mm	9.0mm	15mm	10.5mm	15mm	83mm
PRC-B-1 1/4/40-135	40mm	1-1/4"	135mm	100mm	55mm	55mm	10mm	9.0mm	15mm	10.5mm	15mm	75mm
PRC-B-1 1/4/40-85	40mm	1-1/4"	85mm	50mm	55mm	55mm	10mm	9.0mm	15mm	10.5mm	15mm	75mm
PRC-B-1 13/16/60-115	60mm	1-13/16"	115mm	80mm	75mm	74mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-B-1 13/16/60-190	60mm	1-13/16"	190mm	155mm	75mm	74mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-B-1 13/16/60-75	60mm	1-13/16"	75mm	40mm	75mm	74mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-B-1 13/16/65-185	65mm	1-13/16"	185mm	150mm	80mm	80mm	10mm	9.0mm	15mm	10.5mm	15mm	98mm
PRC-B-1 13/16/65-85	65mm	1-13/16"	85mm	50mm	80mm	80mm	10mm	9.0mm	15mm	10.5mm	15mm	98mm
PRC-B-1 3/4/65-85	65mm	1-3/4"	85mm	50mm	80mm	80mm	10mm	9.0mm	15mm	10.5mm	15mm	98mm
PRC-B-2 1/8/65-135	65mm	2-1/8"	135mm	100mm	80mm	80mm	10mm	9.0mm	15mm	10.5mm	15mm	98mm
PRC-B-2 1/8/65-85	65mm	2-1/8"	85mm	50mm	80mm	80mm	10mm	9.0mm	15mm	10.5mm	15mm	98mm
PRC-B-40/50-75	50mm	40mm	75mm	40mm	65mm	64mm	10mm	5.5mm	15mm	6.00mm	10mm	98mm
PRC-B-40/50/140	50mm	40mm	140mm	105mm	65mm	64mm	10mm	5.5mm	15mm	6.00mm	10mm	83mm
PRC-B-40/60-115	60mm	40mm	115mm	80mm	75mm	74mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-B-40/60-140	60mm	40mm	140mm	105mm	75mm	74mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-B-40/60-215	60mm	40mm	215mm	180mm	75mm	74mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-B-40/60-75	60mm	40mm	75mm	40mm	75mm	74mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-B-50/60-115	60mm	50mm	115mm	80mm	75mm	74mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-B-50/60-190	60mm	50mm	190mm	155mm	75mm	74mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-B-50/60-230	60mm	50mm	230mm	195mm	75mm	74mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-B-50/60-240	60mm	50mm	240mm	205mm	75mm	74mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-B-50/60-75	60mm	50mm	75mm	40mm	75mm	74mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-B-60/70-190	70mm	60mm	190mm	190mm	86mm	85mm	10mm	9.0mm	15mm	10.5mm	15mm	105mm

PRC-C Hydraulic Sleeves “C” Type





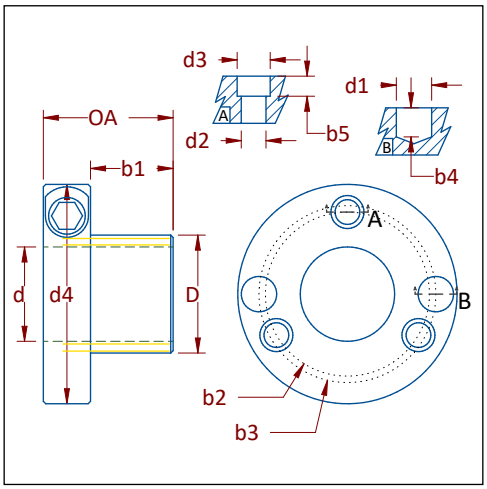
Hydraulic sleeve increases running accuracy and rigidity on tools that run on arbors. “C” type sleeve for interchangeable tool assembly with bolts through the collar. Pressurization carried out with high pressure grease pump. Sleeve pressurizes on internal arbor as well as tool.

HYDRO-GRIP

PART #	D	d	OA	b1	b2	b3	b4	b5	d1	d2	d3	d4
PRC-C-1 13/16/60-75	60mm	1-13/16”	75mm	55mm	74mm	75mm	10mm	10mm	15mm	10.5mm	15mm	93mm
PRC-C-1 13/16/65-135	65mm	1-13/16”	135mm	115mm	80mm	80mm	10mm	10mm	15mm	10.5mm	15mm	98mm
PRC-C-1 13/16/65-185	65mm	1-13/16”	185mm	165mm	80mm	80mm	10mm	10mm	15mm	10.5mm	15mm	98mm
PRC-C-1 13/16/65-85	65mm	1-13/16”	85mm	65mm	80mm	80mm	10mm	10mm	15mm	10.5mm	15mm	98mm
PRC-C-2 1/8/65-110	65mm	2-1/8”	110mm	90mm	80mm	80mm	10mm	10mm	15mm	10.5mm	15mm	98mm
PRC-C-40/60-115	60mm	40mm	115mm	95mm	74mm	75mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-C-40/60-140	60mm	40mm	140mm	120mm	74mm	75mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-C-40/60-165	60mm	40mm	165mm	145mm	74mm	75mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-C-40/60-75	60mm	40mm	75mm	55mm	74mm	75mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-C-40/60-95	60mm	40mm	95mm	75mm	74mm	75mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-C-45/60-190	60mm	45mm	190mm	170m	74mm	70mm	–	8.5mm	M5	10.5mm	15mm	93mm
PRC-C-45/60-75	60mm	45mm	75mm	55mm	74mm	70mm	–	8.5mm	M5	10.5mm	15mm	93mm
PRC-C-50/60-190	60mm	50mm	190mm	170mm	74mm	75mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-C-50/60-230	60mm	50mm	230mm	210mm	74mm	75mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-C-50/60-75	60mm	50mm	75mm	55mm	74mm	75mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-C-50/60-95	60mm	50mm	95mm	75mm	74mm	75mm	10mm	8.5mm	15mm	10.5mm	15mm	93mm
PRC-C-60/70-75	70mm	60mm	75mm	55mm	86mm	85mm	10mm	9.0mm	15mm	9.00mm	15mm	105mm

PRC-CI Hydraulic Sleeves "CI" Type





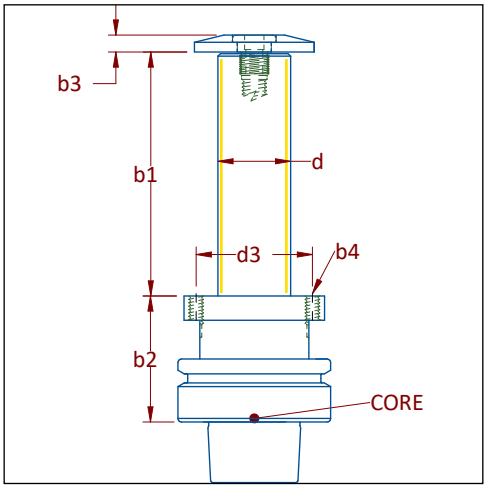
Hydraulic sleeve increases running accuracy and rigidity on tools that run on arbors. "CI" type sleeve for interchangeable tool assembly with bolts through the collar. Pressurization carried out by tightening 6mm allen key to 5 Nm. Sleeve pressurizes on internal arbor as well as tool.

HYDRO-GRIP

PART #	D	d	OA	b1	b2	b3	b4	b5	d1	d2	d3	d4
PRC-CI-1 1/2/50-75	50mm	1-1/2"	75mm	55mm	65mm	64mm	10mm	8.5mm	15mm	10.5mm	15mm	100mm
PRC-CI-40/50-75	50mm	40mm	75mm	55mm	65mm	64mm	10mm	8.5mm	15mm	10.5mm	15mm	100mm
PRC-CI-40/60-115	60mm	40mm	115mm	95mm	75mm	74mm	10mm	8.5mm	15mm	10.5mm	15mm	108mm
PRC-CI-40/60-75	60mm	40mm	75mm	55mm	75mm	74mm	10mm	8.5mm	15mm	10.5mm	15mm	102mm
PRC-CI-40/60-95	60mm	40mm	95mm	75mm	75mm	74mm	10mm	8.5mm	15mm	10.5mm	15mm	108mm
PRC-CI-50/60-75	60mm	50mm	75mm	55mm	75mm	74mm	10mm	8.5mm	15mm	10.5mm	15mm	102mm
PRC-CI-50/60-95	60mm	50mm	95mm	75mm	75mm	74mm	10mm	8.5mm	15mm	10.5mm	15mm	108mm

PRC-GE Hydraulic Sleeves "GE" Type





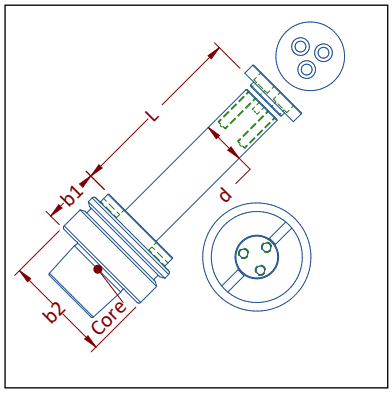
Hydraulic sleeve increases running accuracy and rigidity on tools that run on arbors. "GE" type sleeve can be run without cap; however, tool assembly must then be bolted to holder base. Pressurization carried out by tightening 6mm allen key to 5 Nm. Cap screw is M8 allen key.

HYDRO-GRIP

PART #	d	d3	b1	b2	b3	b4	CORE
PRC-ETP.HSK63F-10040	1"	40mm	40mm	52mm	7mm	2 x M6 & 2 x 6.5mm	HSK63F
PRC-ETP.HSK63F-10080	1"	40mm	80mm	52mm	7mm	2 x M6 & 2 x 6.5mm	HSK63F
PRC-ETP.HSK63F-12540	1-1/4"	48mm	40mm	52mm	7mm	2 x M6 & 2 x 6.5mm	HSK63F
PRC-ETP.HSK63F-12555	1-1/4"	48mm	55mm	52mm	7mm	2 x M6 & 2 x 6.5mm	HSK63F
PRC-ETP.HSK63F-30100	30mm	48mm	100mm	52mm	7mm	2 x M6 & 2 x 6.5mm	HSK63F

Precision HSK63F Arbors





Precision industrial arbors for CNC machines and shapers. Part includes cap. Cap is held in place with 3 screws. Balanced to run at high RPM for. Shafts are precision ground to h6 tolerances.

Imperial Sizes

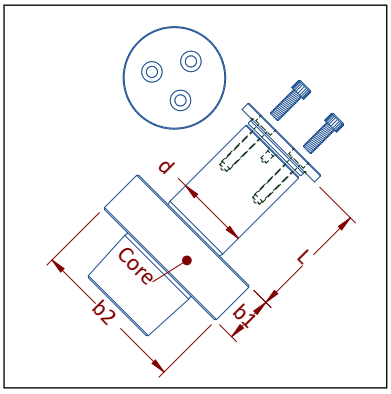
PART#	d	L	b1	b2	Core
PRC-HSK63F-100100	1"	100mm	33mm	63mm	HSK63F
PRC-HSK63F-100100-42	1"	100mm	42mm	63mm	HSK63F
PRC-HSK63F-100125	1"	125mm	33mm	63mm	HSK63F
PRC-HSK63F-100055-42	1"	55mm	42mm	63mm	HSK63F
PRC-HSK63F-100080	1"	80mm	33mm	63mm	HSK63F
PRC-HSK63F-100080-42	1"	80mm	42mm	63mm	HSK63F
PRC-HSK63F-125100	1-1/4"	100mm	33mm	63mm	HSK63F
PRC-HSK63F-125100-42	1-1/4"	100mm	42mm	63mm	HSK63F
PRC-HSK63F-125150	1-1/4"	150mm	33mm	63mm	HSK63F
PRC-HSK63F-12555	1-1/4"	55mm	33mm	63mm	HSK63F
PRC-HSK63F-12555-42	1-1/4"	55mm	42mm	63mm	HSK63F
PRC-HSK63F-12580	1-1/4"	80mm	33mm	63mm	HSK63F
PRC-HSK63F-12580-42	1-1/4"	80mm	42mm	63mm	HSK63F

Metric Sizes

PART#	d	L	b1	b2	Core
PRC-HSK63F-30103	30mm	103mm	33mm	63mm	HSK63F
PRC-HSK63F-30123	30mm	123mm	33mm	63mm	HSK63F
PRC-HSK63F-30123-42	30mm	123mm	42mm	63mm	HSK63F
PRC-HSK63F-30130-42	30mm	130mm	42mm	63mm	HSK63F
PRC-HSK63F-30203	30mm	203mm	33mm	63mm	HSK63F
PRC-HSK63F-30203-42	30mm	203mm	42mm	63mm	HSK63F
PRC-HSK63F-40080	40mm	80mm	33mm	63mm	HSK63F
PRC-HSK63F-40093-42	40mm	93mm	42mm	63mm	HSK63F
PRC-HSK63F-40103-42	40mm	103mm	42mm	63mm	HSK63F
PRC-HSK63F-40203-42	40mm	203mm	42mm	63mm	HSK63F

Precision HSK80W Arbors





Precision industrial arbors for CNC machines and shapers. Part includes cap. Cap is held in place with 3 screws. Balanced to run at high RPM for. Shafts are precision ground to h6 tolerances.

Imperial Sizes

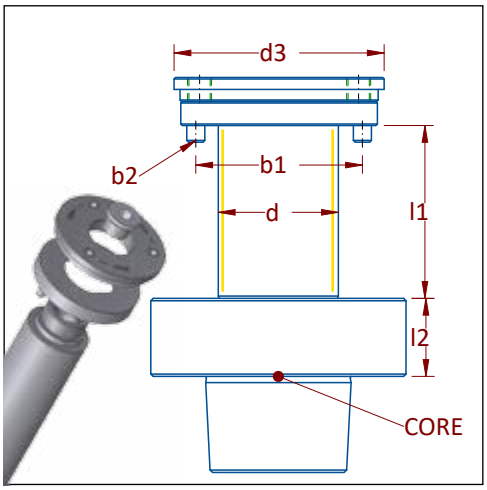
PART#	d	L	b1	b2	Core
PRC-HSK80W-125150	1-1/4"	153mm	26mm	85mm	HSK80W
PRC-HSK80W-12580	1-1/4"	83mm	26mm	85mm	HSK80W

Metric Sizes

PART#	d	L	b1	b2	Core
PRC-HSK80W-30060	30mm	63mm	26mm	85mm	HSK80W
PRC-HSK80W-30103	30mm	103mm	26mm	85mm	HSK80W
PRC-HSK80W-30203	30mm	203mm	26mm	85mm	HSK80W
PRC-HSK80W-30240	30mm	243mm	26mm	85mm	HSK80W
PRC-HSK80W-40040	40mm	43mm	26mm	85mm	HSK80W
PRC-HSK80W-40060	40mm	63mm	26mm	85mm	HSK80W
PRC-HSK80W-40080	40mm	83mm	26mm	85mm	HSK80W
PRC-HSK80W-40100	40mm	103mm	26mm	85mm	HSK80W
PRC-HSK80W-40130	40mm	133mm	26mm	85mm	HSK80W
PRC-HSK80W-40150	40mm	153mm	26mm	85mm	HSK80W
PRC-HSK80W-40170	40mm	173mm	26mm	85mm	HSK80W
PRC-HSK80W-40180	40mm	183mm	26mm	85mm	HSK80W
PRC-HSK80W-40240	40mm	243mm	26mm	85mm	HSK80W

PRC-GEW2 Hydraulic Sleeves “GEW2” Type





Hydraulic sleeve increases running accuracy and rigidity on tools that run on arbors. “GEW2” type sleeve for Power Lock system. Pressurization carried out by tightening center 6mm allen screw to 5 Nm. Special locking cap with 3 set screws for safety collar. Carrying handle for installation and removal of tool on machine.

HYDRO-GRIP

PART #	d	d3	l1	l2	b1	b2	CORE
PRC-ETP.GEW2-30100	30mm	70mm	100mm	26mm	55mm BC	2 - 6mm pins	HSK 80W
PRC-ETP.GEW2-3055	30mm	70mm	55mm	26mm	55mm BC	2 - 6mm pins	HSK 80W
PRC-ETP.GEW2-40135	40mm	70mm	135mm	26mm	55mm BC	2 - 6mm pins	HSK 80W
PRC-ETP.GEW2-40170	40mm	70mm	170mm	26mm	55mm BC	2 - 6mm pins	HSK 80W
PRC-ETP.GEW2-4055	40mm	70mm	55mm	26mm	55mm BC	2 - 6mm pins	HSK 80W

Spare Parts & Accesories



ETP Parts and accesories

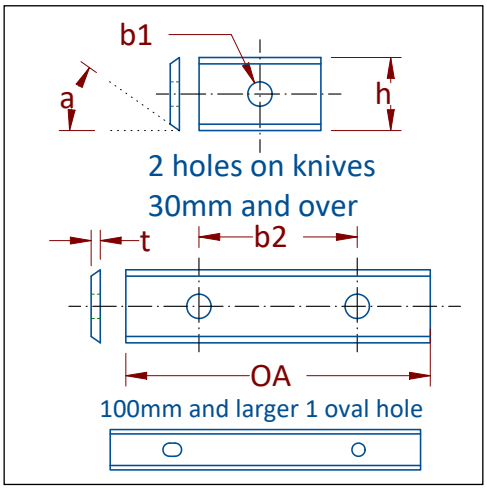
PART #	Description
TBO-F01	Replacement grease cartridge for ETP pressure gun
TBO-M08	Hydraulic grease for manual pressure gun
TBO-M08.NIPPLE	Filler nipple for ETP sleeves
TBO-M08.VALVE	Release valve for ETP sleeves
TBO-M10	Hydraulic grease for electric pressure gun
TBO-8NPTR	Release valve for Royce Ayr made integrated hydro sleeves
TBO-8NPTZ	Filler nipple for Royce Ayr made integrated hydro sleeves

Torque Wrenches

PART #	Description
582-20-200	1/4” Drive Click Torque Wrench 20-200 in/lbs
582-5-80	3/8” Drive Click Torque Wrench 5-80 ft/lbs

590 – Turn Over Insert Knives





Hw Sw Pl Hp Sp Fb

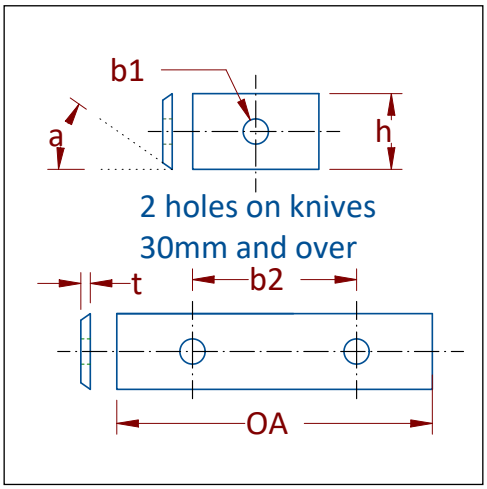
See Material Guide p5

Premium quality carbide insert knives for indexable insert cutter heads. General purpose grade is good for cutting a variety of materials. Two cutting edges allow the knife to be rotated one time. Sold in packs of ten knives.

PART #	OA	h	t	a	b1	b2
590-0075	7.5mm	12mm	1.5mm	35°	4mm	–
590-0086	8.6mm	12mm	1.5mm	35°	4mm	–
590-0090	9.0mm	12mm	1.5mm	35°	4mm	–
590-0095	9.5mm	12mm	1.5mm	35°	4mm	–
590-0096	9.6mm	12mm	1.5mm	35°	4mm	–
590-0105	10.5mm	12mm	1.5mm	35°	4mm	–
590-0110	11mm	12mm	1.5mm	35°	4mm	–
590-0130	13mm	12mm	1.5mm	35°	4mm	–
590-0150	15mm	12mm	1.5mm	35°	4mm	–
590-0155	15.7mm	12mm	1.5mm	35°	4mm	–
590-0160	16mm	12mm	1.5mm	35°	4mm	–
590-0170	17mm	12mm	1.5mm	35°	4mm	–
590-0180	18mm	12mm	1.5mm	35°	4mm	–
590-0200	20mm	12mm	1.5mm	35°	4mm	–
590-0240	24mm	12mm	1.5mm	35°	4mm	–
590-0290	29mm	12mm	1.5mm	35°	4mm	–
590-0300	30mm	12mm	1.5mm	35°	4mm	14mm
590-0350	35mm	12mm	1.5mm	35°	4mm	26mm
590-0400	40mm	12mm	1.5mm	35°	4mm	26mm
590-0450	45mm	15mm	1.5mm	35°	4mm	26mm
590-0500	50mm	12mm	1.5mm	35°	4mm	26mm
590-0600	60mm	12mm	1.5mm	35°	4mm	26mm
590-0800	80mm	13mm	2.2mm	35°	4mm	60mm
590-1000	100mm	13mm	2.2mm	35°	4mm	60mm
590-1200	120mm	13mm	2.2mm	35°	4mm	60mm
590-1300	130mm	13mm	2.2mm	35°	4mm	60mm
590-1400	140mm	13mm	2.2mm	35°	4mm	60mm
590-1600	160mm	13mm	2.2mm	35°	4mm	60mm

590S & 590SM – Submicron Turn Over Inserts





Fb Pb Pl Hp Hw Sw

See Material Guide p5

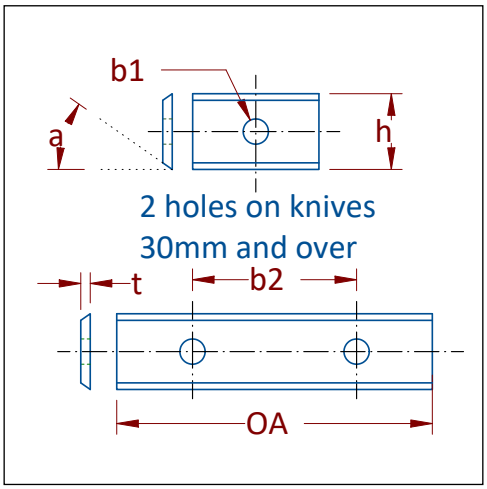
Premium quality carbide insert knives for indexable insert cutter heads. Ultra fine hard grade carbide for abrasive materials such as High Density Fiberboard, high pressure laminates and composites. Knives with "590SM" are slightly more wear resistant than 590S. Both knives are extremely resistant to wear. Two cutting edges allow knife to be rotated one time. Sold in packs of ten knives.

PART #	OA	h	t	a	b1	b2
590SM-0150	15mm	12mm	1.5mm	35°	4mm	–
590SM-0200	20mm	12mm	1.5mm	35°	4mm	–
590SM-0300	30mm	12mm	1.5mm	35°	4mm	14mm
590SM-0400	40mm	12mm	1.5mm	35°	4mm	26mm
590SM-0500	50mm	12mm	1.5mm	35°	4mm	26mm
590SM-0600	60mm	12mm	1.5mm	35°	4mm	26mm

PART #	OA	h	t	a	b1	b2
590S-0150	15mm	12mm	1.5mm	35°	4mm	–
590S-0200	20mm	12mm	1.5mm	35°	4mm	–
590S-0300	30mm	12mm	1.5mm	35°	4mm	14mm
590S-0400	40mm	12mm	1.5mm	35°	4mm	26mm
590S-0500	50mm	12mm	1.5mm	35°	4mm	26mm
590S-0600	60mm	12mm	1.5mm	35°	4mm	26mm

590W – Impact Resistant Turn Over Insert Knives





Sw Hw Pl Hp Fb Sp

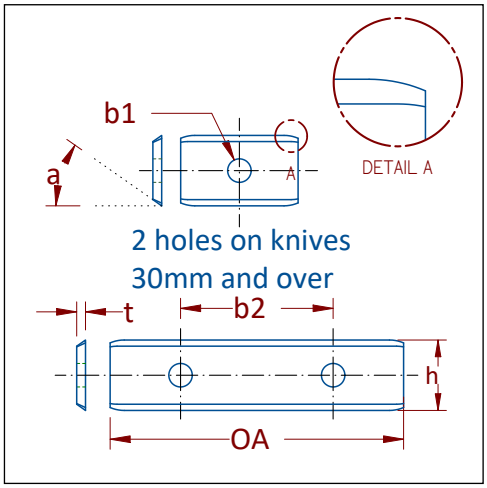
See Material Guide p5

Premium quality carbide insert knives for indexable insert cutter heads. More impact resistant grade for high feed rate machining of solid wood, or rough materials. Softer grade is more resilient to breaking or cracking in rough applications. Two cutting edges allow knife to be rotated one time. Sold in packs of ten knives.

PART #	OA	h	t	a	b1	b2
590W-0200	20mm	12mm	1.5mm	35°	4mm	–
590W-0300	30mm	12mm	1.5mm	35°	4mm	14mm
590W-0400	40mm	12mm	1.5mm	35°	4mm	26mm
590W-0500	50mm	12mm	1.5mm	35°	4mm	26mm
590W-0600	60mm	12mm	1.5mm	35°	4mm	26mm

590SP – Turn Over Insert Knives





Sw Hw Pl Hp Fb Sp

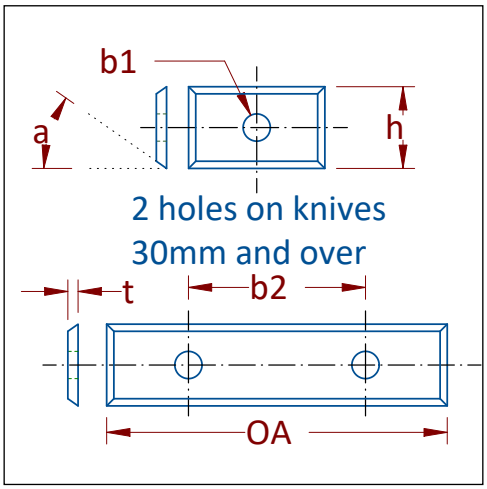
See Material Guide p5

Premium quality carbide insert knives for indexable insert cutter heads. Rounded edges to help with reducing lines on planer heads where knives overlap. General purpose grade is good for a variety of material. Two cutting edges allow knife to be rotated one time. Sold in packs of ten knives.

PART #	OA	h	t	a	b1	b2
590SP-0200	20mm	12mm	1.5mm	35°	4mm	–
590SP-0300	30mm	12mm	1.5mm	35°	4mm	14mm
590SP-0500	50mm	12mm	1.5mm	35°	4mm	26mm

590T – Thin Turn Over Insert Knives





Hw Sw Pl Hp Sp Fb

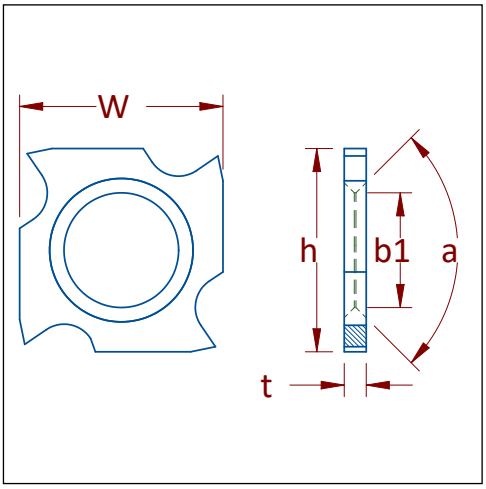
See Material Guide p5

Premium quality carbide insert knives for indexable insert cutter heads. General purpose grade is good for cutting a variety of materials. Knife has cutting edges on the ends. Knife can be rotated one time. Sold in packs of ten knives.

PART #	OA	h	t	a	b1	b2
590T-0150	15mm	9mm	1.5mm	35°	4mm	–
590T-0200	20mm	9mm	1.5mm	35°	4mm	–
590T-0300	30mm	9mm	1.5mm	35°	4mm	14mm
590T-0400	40mm	9mm	1.5mm	35°	4mm	26mm
590T-0500	50mm	9mm	1.5mm	35°	4mm	26mm

591 – 4 Edge Turn Over Insert Knives





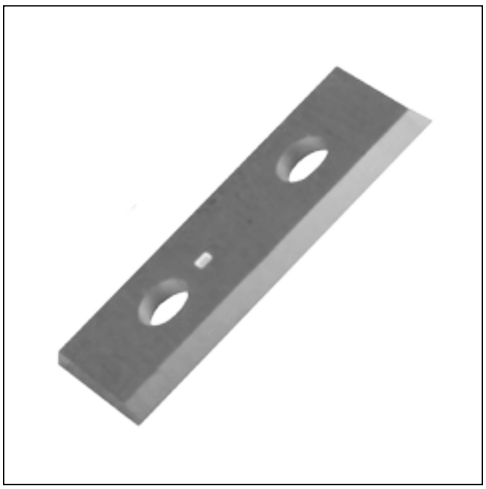
Hw Sw Pl Hp Sp Fb

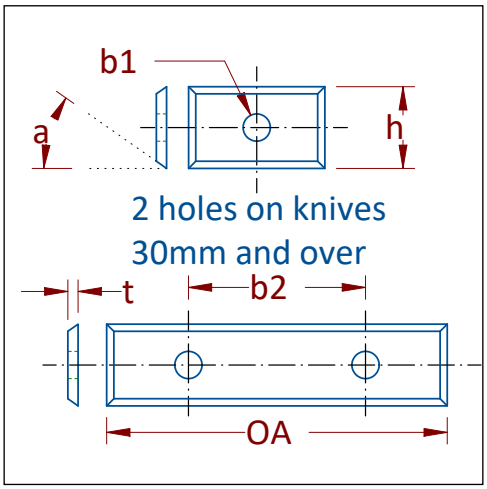
See Material Guide p5

Premium quality carbide insert knives for indexable insert cutter heads. General purpose grade is good for cutting a variety of material. Raker insert for use in indexable grooving tools. Knife can be rotated four times. Sold in packs of ten knives.

PART #	W	h	t	a	b1
591-1819	18mm	18mm	1.95mm	90°	10mm
591-1824	18mm	18mm	2.45mm	90°	10mm
591-1829	18mm	18mm	2.95mm	90°	10mm
591-1837	18mm	18mm	3.70mm	90°	10mm

591 – 4 Edge Turn Over Insert Knives





Hw Sw Pl Hp Sp Fb

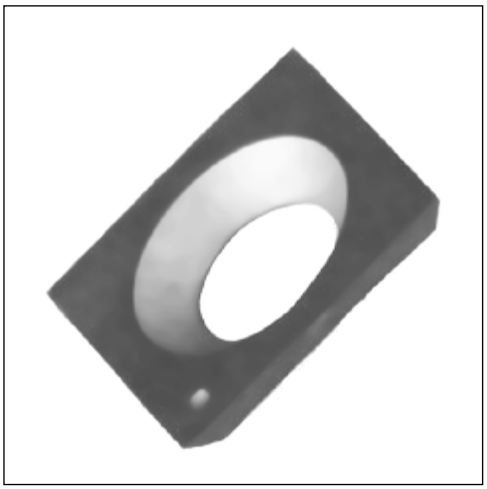
See Material Guide p5

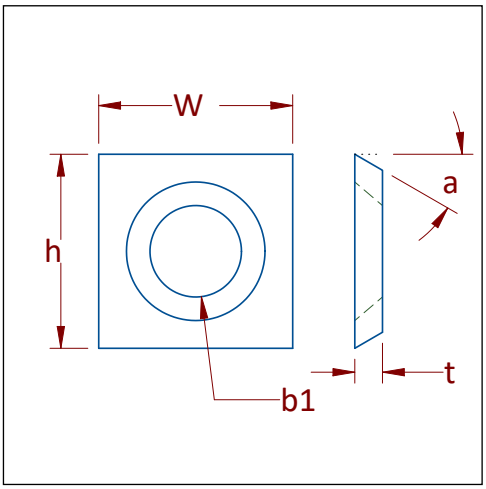
Premium quality carbide insert knives for indexable insert cutter heads. General purpose grade is good for cutting a variety of materials. Cutting edges on all four sides. Knife can be rotated one time. Sold in packs of ten knives.

PART #	OA	h	t	a	b1	b2
591-1111	11mm	11mm	1.5mm	35°	4mm	–
591-1212	12mm	12mm	1.5mm	35°	4mm	–
591-1212 45DEG	12mm	12mm	1.5mm	45°	4mm	–
591-1212 T10MG	12mm	12mm	1.5mm	35°	4mm	–
591-1515	15mm	15mm	2.0mm	35°	3mm	–
591-1717	17mm	17mm	2.0mm	35°	4mm	–
591-1919	19mm	19mm	2.0mm	35°	4mm	–
591-2008	19.5mm	8mm	1.5mm	35°	4mm	–
591-2009	19.5mm	9mm	1.5mm	35°	4mm	–
591-2012	19.5mm	12mm	1.5mm	35°	4mm	–
591-3009	29.5mm	9mm	1.5mm	35°	4mm	14mm
591SM-3009	29.5mm	9mm	1.5mm	35°	4mm	14mm
591-3012	29.5mm	12mm	1.5mm	35°	4mm	14mm
591SM-3012	29.5mm	12mm	1.5mm	35°	4mm	14mm
591-4012	39.5mm	12mm	1.5mm	35°	4mm	26mm
591-5008	49.5mm	8mm	1.5mm	35°	4mm	26mm
591-5009	49.5mm	9mm	1.5mm	35°	4mm	26mm
591-5012	49.5mm	12mm	1.5mm	35°	4mm	26mm

T10MG = Softer grade for rough applications
591SM = Submicron grade for abrasive applications

592 – 4 Edge Square Turn Over Insert Knives





Hw Sw Pl Hp Sp Fb

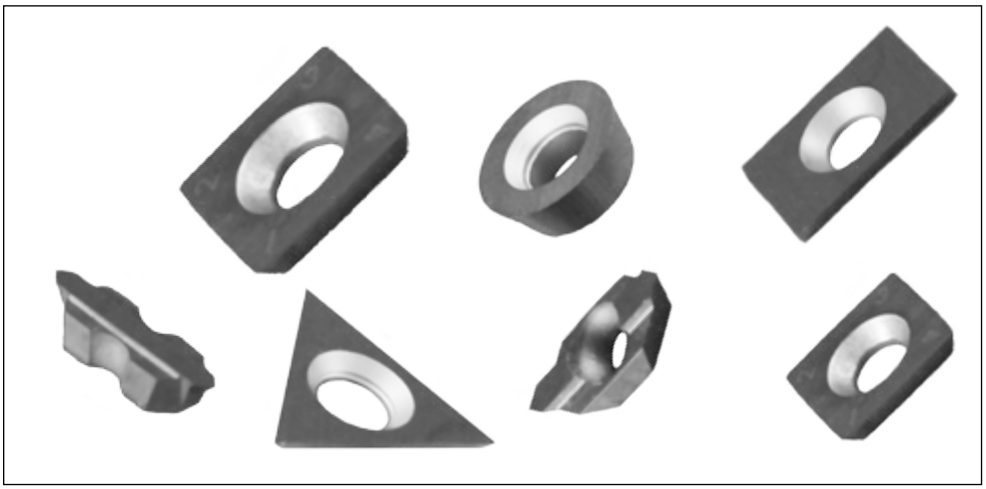
See Material Guide p5

Premium quality carbide insert knives for indexable insert cutter heads. General purpose grade is good for cutting a variety of materials. Square inserts for spiral planer heads or spur locations. Sold in packs of ten knives.

PART #	W	h	t	a	b1
592-1050	10.5mm	10.5mm	1.5mm	35°	3.95mm
592-1313	13.6mm	13.6mm	2.0mm	30°	6.5mm
592-1313.0	13.0mm	13.0mm	2.5mm	30°	6.0mm
592-1414	14.0mm	14.0mm	2.0mm	30°	6.0mm
592-1414.T10MG	14.0mm	14.0mm	2.0mm	30°	6.0mm
592-1414.L	14.0mm	14.0mm	1.2mm	30°	8.5mm
592-1414.N	14.0mm	14.0mm	1.7mm	30°	8.5mm
592-143143	14.3mm	14.3mm	2.5mm	35°	6.2mm
592-146146	14.6mm	14.6mm	2.5mm	30°	6.2mm
592-1515	15.0mm	15.0mm	2.5mm	30°	6.2mm

T10MG = Softer more impact resistant grade for softwood and rough hardwood

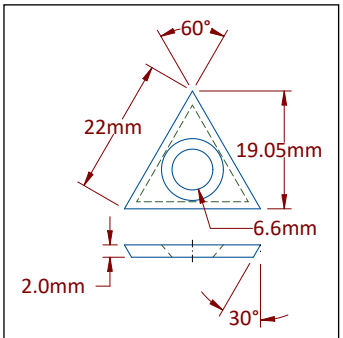
592 & 629 – Various Insert Knives



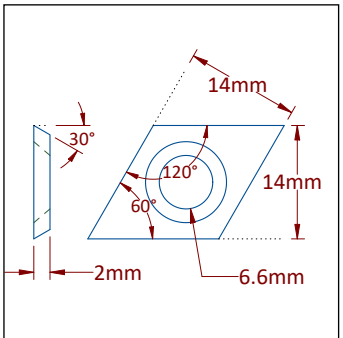
Hw Sw Pl Hp Sp Fb

See Material Guide p5

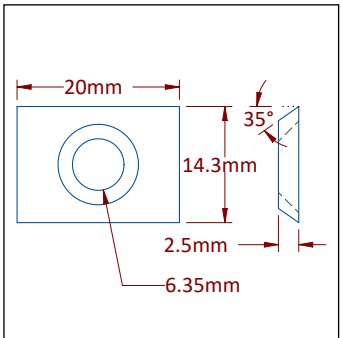
Premium quality carbide insert knives for indexable insert cutter heads. General purpose grade is good for cutting a variety of materials. Assortment of styles and shapes for various applications. Sold in packs of ten knives.



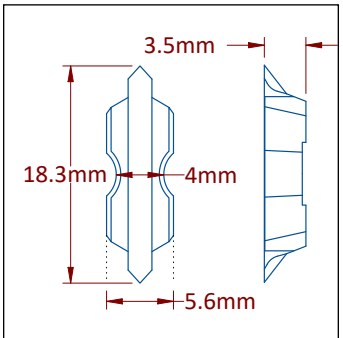
PART #
592-0001



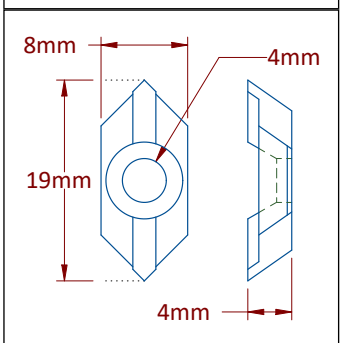
PART #
592-0002



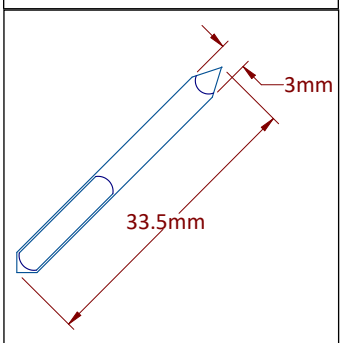
PART #
592-0003



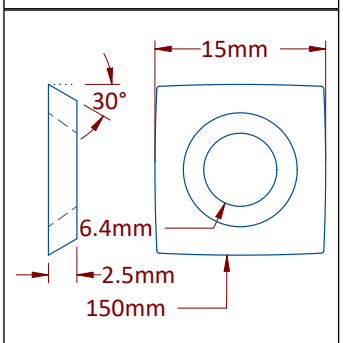
PART #
592-0004



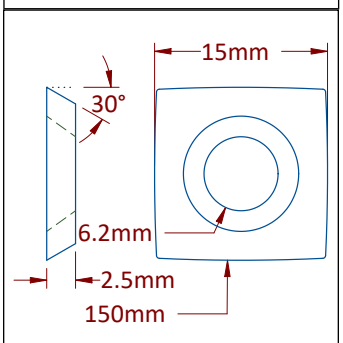
PART #
592-0005



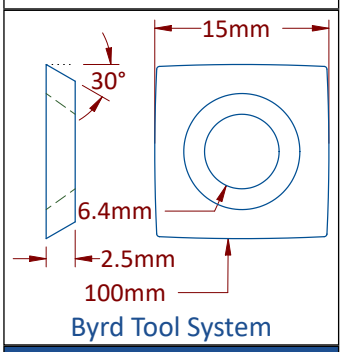
PART #
592-0006



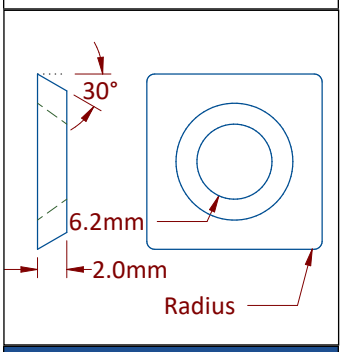
PART #
592-0007



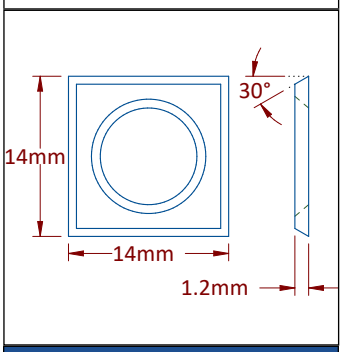
PART #
592-0007-R50



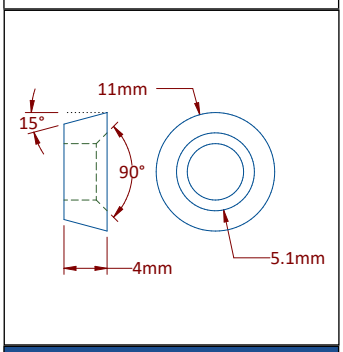
PART #
592-0007-BT



PART #
592-1414.R



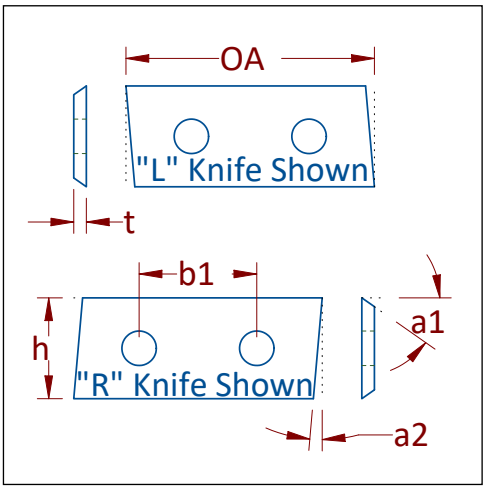
PART #
592-1414.H



PART #
629-CIRC.1104

593 – 2 Edge "V" Groove Knives





Hw Sw Pl Hp Sp Fb

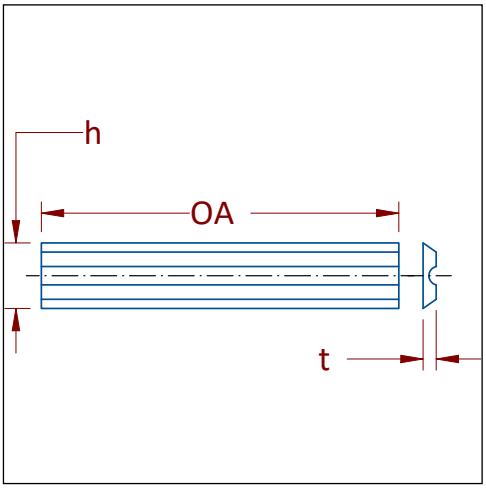
See Material Guide p5

Premium quality carbide insert knives for indexable insert cutter heads. General purpose grade is good for cutting a variety of materials. Bevel end insert knives for V-groove cutterheads. Knife can be rotated one time. Sold in packs of ten knives.

PART #	OA	h	t	b1	a2
593-V30L	29.5mm	12mm	1.5mm	35°	5°
593-V30R	29.5mm	12mm	1.5mm	35°	5°
593-V40L	39.5mm	12mm	1.5mm	35°	5°
593-V40R	39.5mm	12mm	1.5mm	35°	5°
593-V50L	49.5mm	12mm	1.5mm	35°	5°
593-V50R	49.5mm	12mm	1.5mm	35°	5°

594B – Mini Turnover Knives 2 Edge Back Groove





Hw Sw Pl Hp Sp Fb

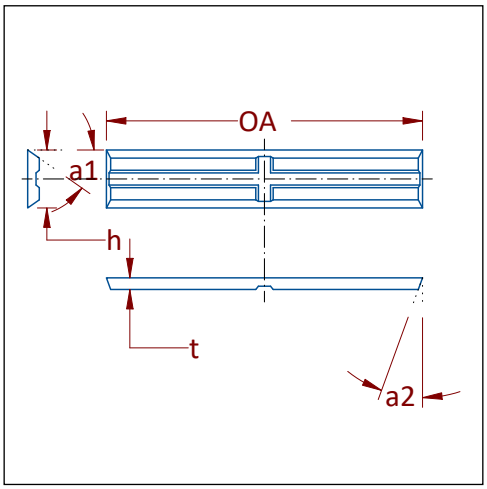
See Material Guide p5

Premium quality carbide insert knives for indexable insert cutter heads. General purpose grade is good for cutting a variety of materials. Thin insert knives for various insert heads. Knife can be rotated one time. Sold in packs of ten knives.

PART #	OA	h	t
594B-2055	20mm	5.5mm	1.1mm
594B-3055	30mm	5.5mm	1.1mm
594B-5055	50mm	5.5mm	1.1mm

594L – Mini Turnover Knives 4 Edge Back Groove





Hw Sw Pl Hp Sp Fb

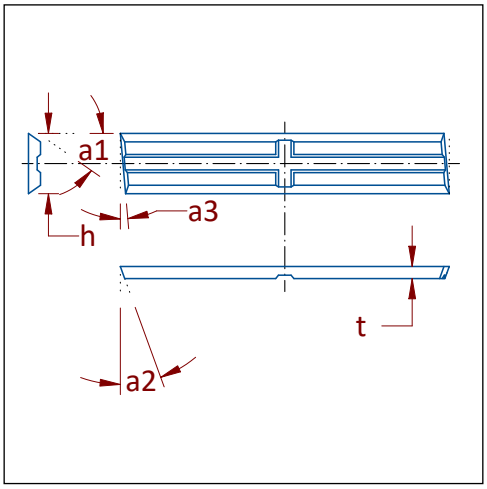
See Material Guide p5

Premium quality carbide insert knives for indexable insert cutter heads. General purpose grade is good for cutting a variety of materials. For use in insert TOK cutterheads and router bits. Knife can be rotated one time. Sold in packs of ten knives.

PART #	OA	h	t	a1	a2
594L-2041	20mm	4.1mm	1.1mm	35°	20°
594L-2055	20mm	5.5mm	1.1mm	35°	20°
594L-3055	30mm	5.5mm	1.1mm	35°	20°
594L-4055	40mm	5.5mm	1.1mm	35°	20°
594L-5055	50mm	5.5mm	1.1mm	35°	20°

595L – Mini Knives 4 Edge Back Groove Clearance





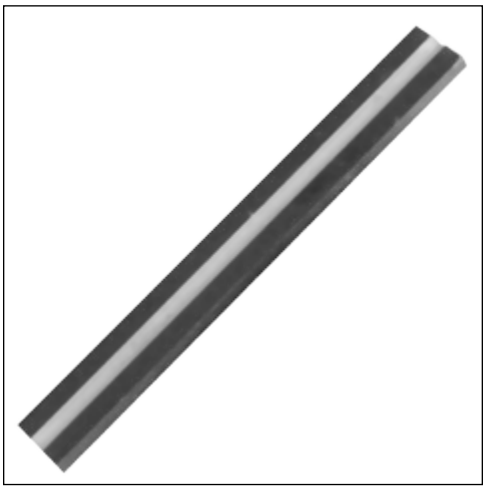
Hw Sw Pl Hp Sp Fb

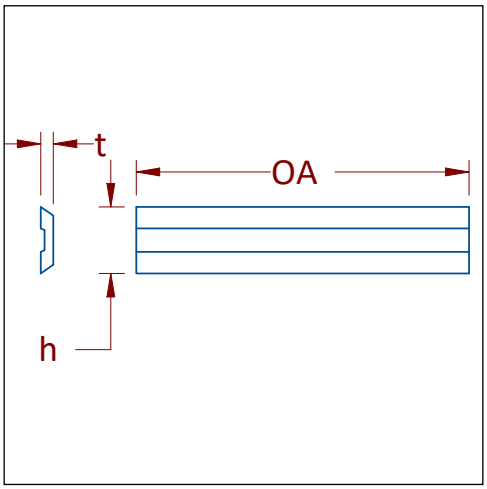
See Material Guide p5

Premium quality carbide insert knives for indexable insert cutter heads. General purpose grade is good for cutting a variety of materials. For use in 565 series router bits in Precision CNC catalog. Knife can be rotated one time. Sold in packs of ten knives.

PART #	OA	h	t	a1	a2	a3
595L-3055	30mm	5.5mm	1.1mm	35°	20°	5°

594F – Mini Turnover Knives 2 Edge Face Groove





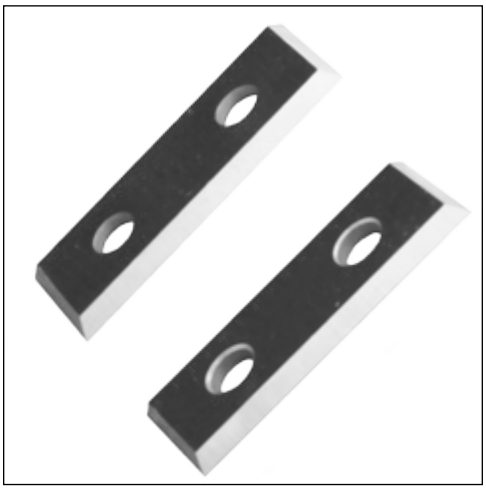
Hw Sw Pl Hp Sp Fb

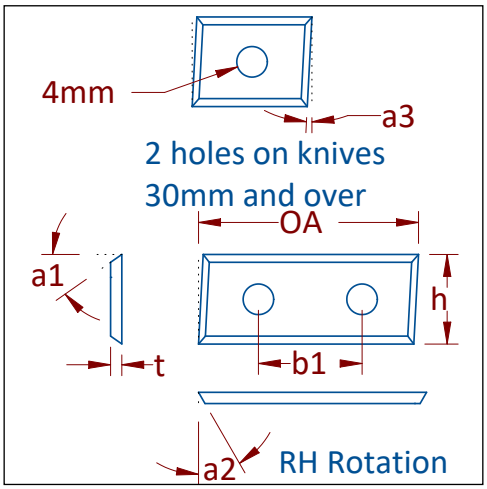
See Material Guide p5

Premium quality carbide insert knives for indexable insert cutter heads. General purpose grade is good for cutting a variety of materials. Thin insert knives for various insert heads. Knife can be rotated one time. Sold in packs of ten knives.

PART #	OA	h	t
594F-1080	9.7mm	8.0mm	1.5mm
594F-1255	12.0mm	5.5mm	1.1mm
594F-1280	11.7mm	8.0mm	1.5mm
594F-1555	15.0mm	5.5mm	1.1mm
594F-1580	14.7mm	8.0mm	1.5mm
594F-2055	20.0mm	5.5mm	1.1mm
594F-2080	19.7mm	8.0mm	1.5mm
594F-2580	24.5mm	8.0mm	1.5mm
594F-3055	30.0mm	5.5mm	1.1mm
594F-3080	30.0mm	8.0mm	1.5mm
594F-3555	35.0mm	5.5mm	1.1mm
594F-4055	40.0mm	5.5mm	1.1mm
594F-5055	50.0mm	5.5mm	1.1mm
594F-6080	60.0mm	8.0mm	1.5mm
594F-15080	150mm	8.0mm	1.5mm

595 – 4 Edge Bevel End Turnover Knives





Hw Sw Pl Hp Sp Fb

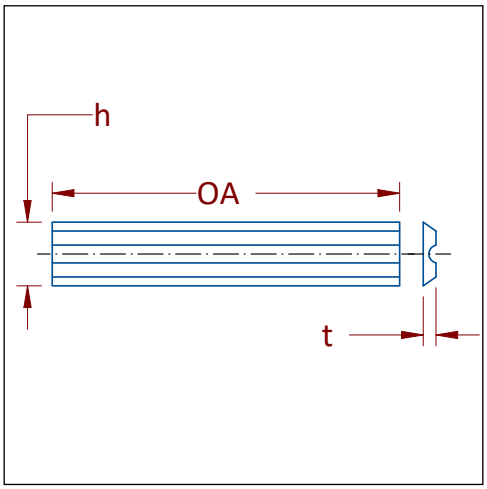
See Material Guide p5

Premium quality carbide insert knives for indexable insert cutter heads. General purpose grade is good for cutting a variety of materials. Bevel end insert knives for V-groove Cutterheads or end cutting router tools. Knife has cutting edge on ends. Knife can be rotated one time. Sold in packs of ten knives.

PART #	OA	h	t	a1	a2	a3	b1
595-1512L	14.5mm	12mm	1.5mm	35°	30°	3°	-
595-1512R	14.5mm	12mm	1.5mm	35°	30°	3°	-
595-2009L	19.5mm	9mm	1.5mm	35°	30°	3°	-
595-2009R	19.5mm	9mm	1.5mm	35°	30°	3°	-
595-2012L	19.5mm	12mm	1.5mm	35°	30°	3°	-
595-2012R	19.5mm	12mm	1.5mm	35°	30°	3°	-
595-2512L	24.5mm	12mm	1.5mm	35°	30°	3°	-
595-2512R	24.5mm	12mm	1.5mm	35°	30°	3°	-
595-3012L	29.5mm	12mm	1.5mm	35°	30°	3°	14mm
595-3012R	29.5mm	12mm	1.5mm	35°	30°	3°	14mm
595-3090L	29.5mm	9mm	1.5mm	35°	30°	3°	14mm
595-3090R	29.5mm	9mm	1.5mm	35°	30°	3°	14mm
595-4012L	39.5mm	12mm	1.5mm	35°	30°	3°	26mm
595-4012R	39.5mm	12mm	1.5mm	35°	30°	3°	26mm
595-4090L	39.5mm	9mm	1.5mm	35°	30°	3°	26mm
595-4090R	39.5mm	9mm	1.5mm	35°	30°	3°	26mm
595-5012L	49.5mm	12mm	1.5mm	35°	30°	3°	26mm
595-5012R	49.5mm	12mm	1.5mm	35°	30°	3°	26mm
595-5090L	49.5mm	9mm	1.5mm	35°	30°	3°	26mm
595-5090R	49.5mm	9mm	1.5mm	35°	30°	3°	26mm
595-6012R	59.5mm	12mm	1.5mm	35°	30°	3°	26mm

596 – Knives for Portable Planer





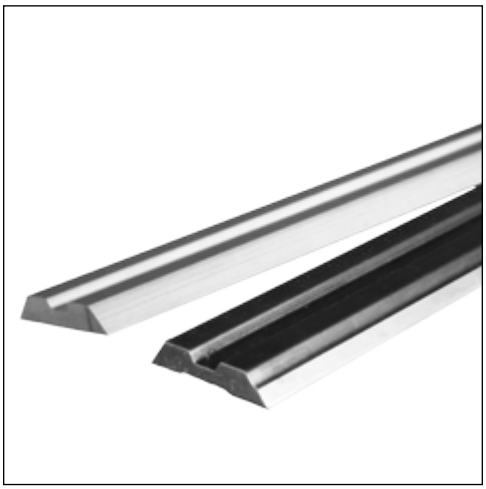
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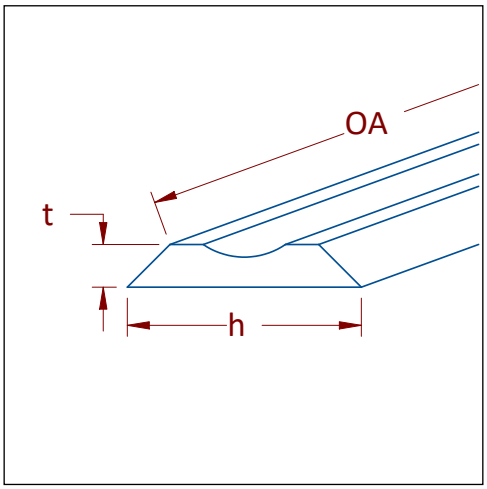
See Material Guide p5

Premium quality carbide insert knives for indexable insert cutter heads. General purpose grade for variety of materials. Knives used in portable electric planers. Sold in packs of ten knives.

PART #	OA	h	t	Planer Type
596-5655	56.0mm	5.5mm	1.1mm	Adler
596-7555	75.5mm	5.5mm	1.1mm	AEG, Bosch, Festo, Haffner, Kress, Mafell, Metabo, Scheer, Skil, Holz-Her
596-8059	80.5mm	5.9mm	1.2mm	ELU
596-8255	82.0mm	5.5mm	1.1mm	

598T – Terminus Knives





Hw Sw Pl Hp Sp Fb

See Material Guide p5

Solid carbide and HSS knives for Terminus planer system. Premium German made steel and carbide. HSS good for softwood and most hardwoods. Solid carbide provides 10 times the life of HSS in hardwoods and other man made materials such as MDF.

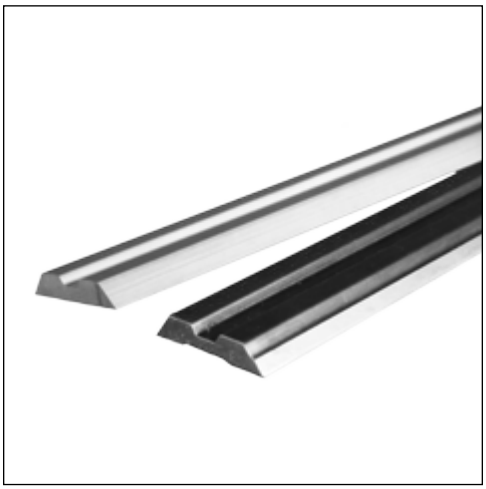
Solid Carbide

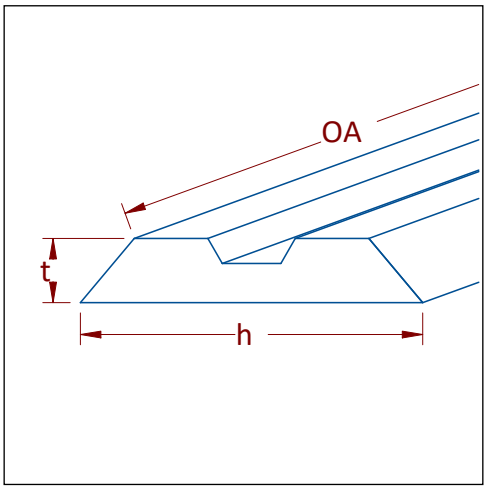
PART #	OA	h	t
598-TMC-130	130mm	14mm	2.55mm
598-TMC-150	150mm	14mm	2.55mm
598-TMC-160	160mm	14mm	2.55mm
598-TMC-180	180mm	14mm	2.55mm

High Speed Steel

PART #	OA	h	t
598-TMH-060	60mm	14mm	2.55mm
598-TMH-100	100mm	14mm	2.55mm
598-TMH-130	130mm	14mm	2.55mm
598-TMH-150	150mm	14mm	2.55mm
598-TMH-180	180mm	14mm	2.55mm
598-TMH-200	200mm	14mm	2.55mm
598-TMH-210	210mm	14mm	2.55mm
598-TMH-230	230mm	14mm	2.55mm
598-TMH-240	240mm	14mm	2.55mm
598-TMH-280	280mm	14mm	2.55mm
598-TMH-300	300mm	14mm	2.55mm
598-TMH-400	400mm	14mm	2.55mm

598WG – Centroloc Knives





Hw Sw Pl Hp Sp Fb

See Material Guide p5

Solid carbide and HSS knives for Centroloc planer system. Premium German made steel and carbide. HSS good for softwood and most hardwoods. Solid carbide provides 10+ times the life of HSS in hardwoods and other man made materials such as MDF.

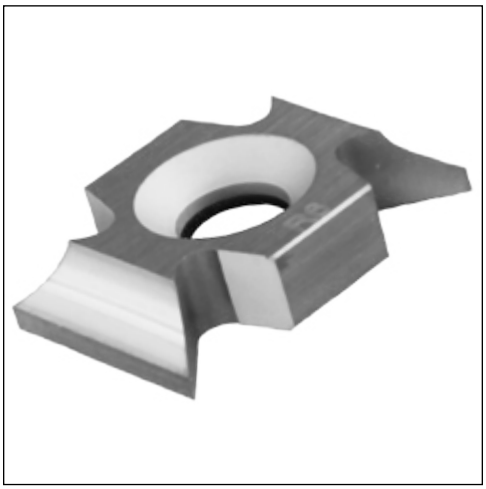
Solid Carbide

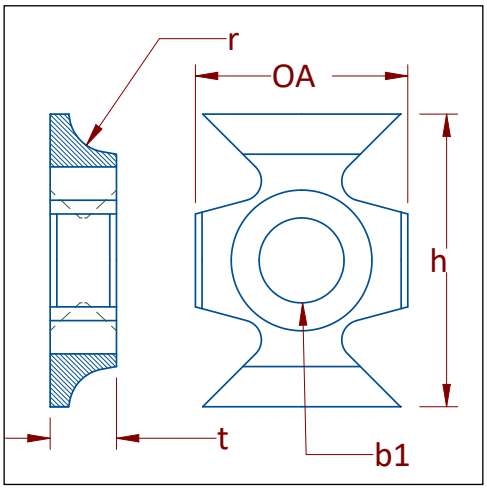
PART #	OA	h	t
598WG-020HM	20mm	16mm	3mm
598WG-060HM	60mm	16mm	3mm
598WG-080HM	80mm	16mm	3mm
598WG-100HM	100mm	16mm	3mm
598WG-130HM	130mm	16mm	3mm
598WG-150HM	150mm	16mm	3mm
598WG-170HM	170mm	16mm	3mm
598WG-180HM	180mm	16mm	3mm
598WG-190HM	190mm	16mm	3mm
598WG-210HM	210mm	16mm	3mm
598WG-230HM	230mm	16mm	3mm
598WG-235HM	235mm	16mm	3mm
598WG-240HM	240mm	16mm	3mm
598WG-260HM	260mm	16mm	3mm
598WG-270HM	270mm	16mm	3mm
598WG-300HM	300mm	16mm	3mm
598WG-310HM	310mm	16mm	3mm
598WG-460HM	460mm	16mm	3mm
598WG-650HM	650mm	16mm	3mm

High Speed Steel

PART #	OA	h	t
598WG-020HSS	20mm	16mm	3mm
598WG-060HSS	60mm	16mm	3mm
598WG-080HSS	80mm	16mm	3mm
598WG-085HSS	85mm	16mm	3mm
598WG-100HSS	100mm	16mm	3mm
598WG-130HSS	130mm	16mm	3mm
598WG-150HSS	150mm	16mm	3mm
598WG-170HSS	170mm	16mm	3mm
598WG-180HSS	180mm	16mm	3mm
598WG-190HSS	190mm	16mm	3mm
598WG-210HSS	210mm	16mm	3mm
598WG-230HSS	230mm	16mm	3mm
598WG-235HSS	235mm	16mm	3mm
598WG-240HSS	240mm	16mm	3mm
598WG-260HSS	260mm	16mm	3mm
598WG-270HSS	270mm	16mm	3mm
598WG-285HSS	285mm	16mm	3mm
598WG-300HSS	300mm	16mm	3mm
598WG-310HSS	310mm	16mm	3mm
598WG-460HSS	460mm	16mm	3mm
598WG-650HSS	650mm	16mm	3mm

599A – Radius & Bevel Insert Spurs





Hw Sw Pl Hp Sp Fb

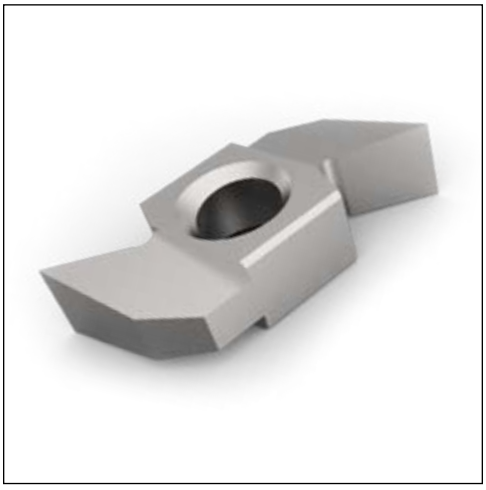
See Material Guide p5

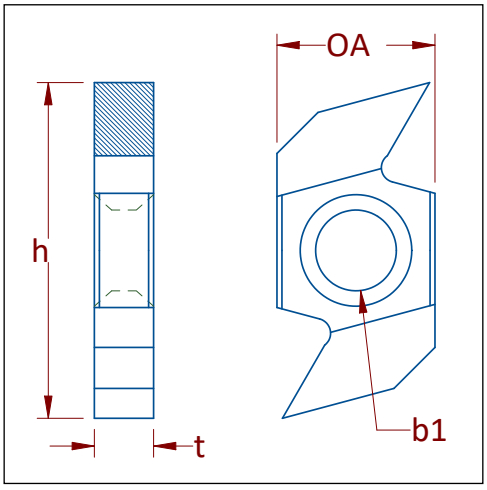
Turnover insert knives for indexable insert tools. General purpose grade for machining most materials. Knives have 4 cutting edges allowing them to be rotated. For applying radii and bevels.

PART #	OA	h	t	r	b1
599A-1.5R	16mm	22mm	5mm	1.5mm	3.2mm
599A-2.0R	16mm	22mm	5mm	2.0mm	3.2mm
599A-2.5R	16mm	22mm	5mm	2.5mm	3.2mm
599A-3.0R	16mm	22mm	5mm	3.0mm	3.2mm
599A-5.0R	16mm	22mm	5mm	5.0mm	3.2mm
599A-6.0R	16mm	22mm	5mm	6.0mm	3.2mm
599A-45*	16mm	22mm	5mm	45°	3.2mm

* 45° chamfer instead of radius

599C – Grooving Turnover Inserts





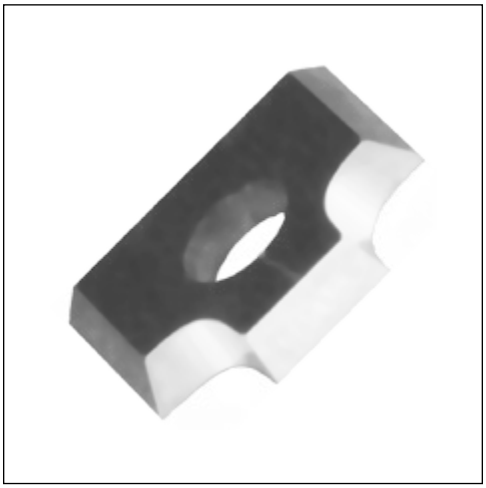
Hw Sw Pl Hp Sp Fb

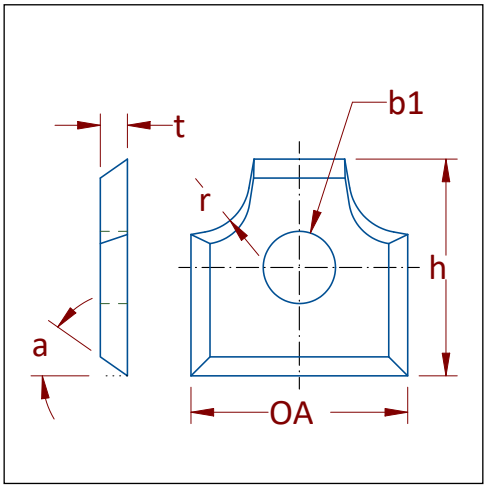
See Material Guide p5

Turnover insert knives for indexable insert tools. Knife is used on insert tools to produce grooves. General purpose grade for machining most materials. Knife can be rotated one time.

PART #	OA	h	t	b1
599C-030	16mm	34mm	3mm	8mm
599C-040	16mm	34mm	4mm	8mm
599C-060	16mm	34mm	6mm	8mm

600 – Edge Banding Inserts Holz-Her





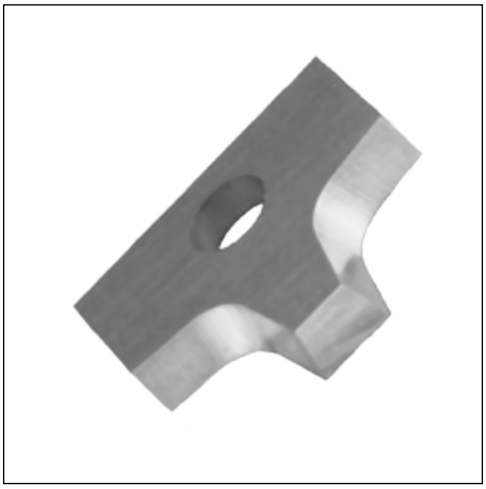
Hw Sw Pl Sp Fb

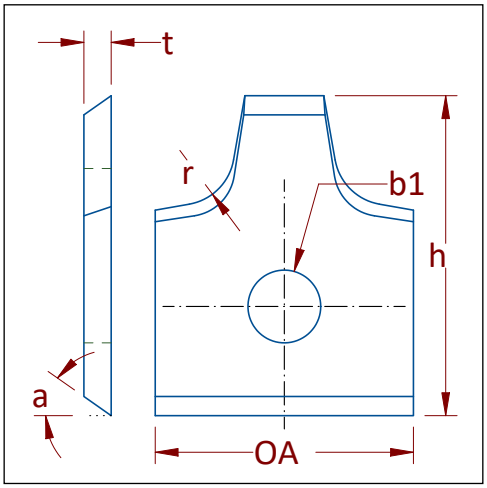
See Material Guide p5

Solid carbide edgebanding insert knives. For applying radius on banded material after edge has been glued. General purpose grade works well for all panel materials. Different radius sizes available.

PART #	OA	h	t	r	a	b1
600-002	16mm	34mm	3mm	8mm	35°	4mm
600-003	16mm	34mm	4mm	8mm	35°	4mm
600-004	16mm	34mm	6mm	8mm	35°	4mm

602 – Edge Banding Inserts Homag & Ima





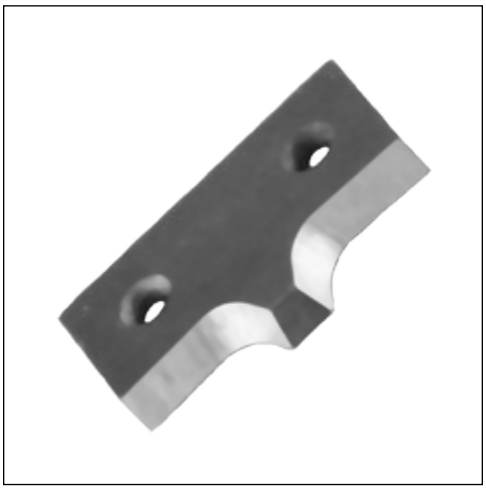
Hw Sw Pl Sp Fb

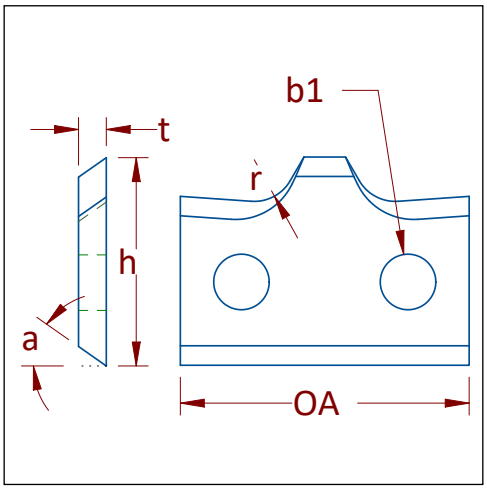
See Material Guide p5

Solid carbide edgebanding insert knives. For applying radius on banded material after edge has been glued. General purpose grade works well for all panel materials. Different radius sizes available.

PART #	OA	h	t	r	a	b1
602-002	16mm	17.5mm	2mm	2mm	35°	4mm
602-003	16mm	17.5mm	2mm	3mm	35°	4mm
602-003A	16mm	17.5mm	2mm	3mm	35°	3.5mm
602-004	16mm	17.5mm	2mm	4mm	35°	4mm
602-005	16mm	17.5mm	2mm	5mm	35°	4mm

604 – Edge Banding Inserts Homag





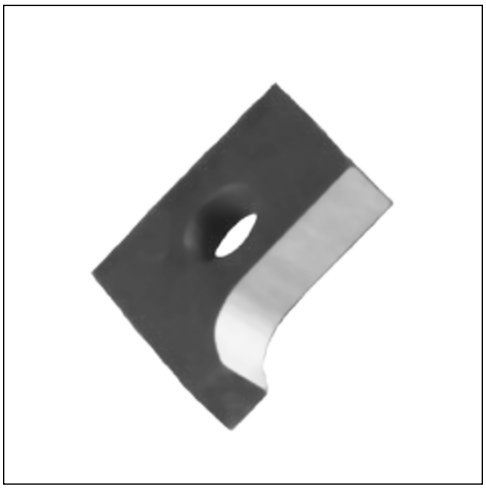
Hw Sw Pl Sp Fb

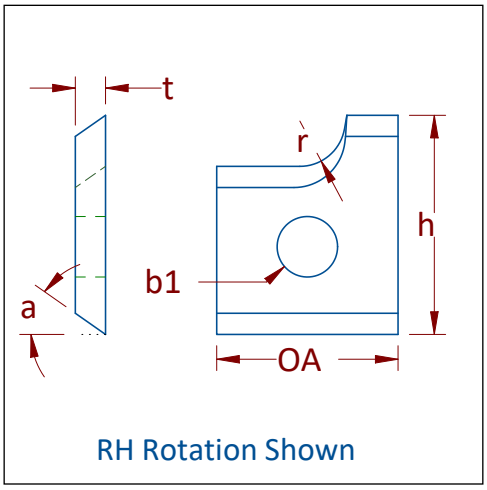
See Material Guide p5

Solid carbide edgebanding insert knives. For applying radius on banded material after edge has been glued. General purpose grade works well for all panel materials. Different radius sizes available.

PART #	OA	h	t	r	a	b1
604-002	20.8mm	15mm	2mm	2mm	35°	4mm
604-003	20.8mm	15mm	2mm	3mm	35°	4mm

608 – Edge Banding Inserts





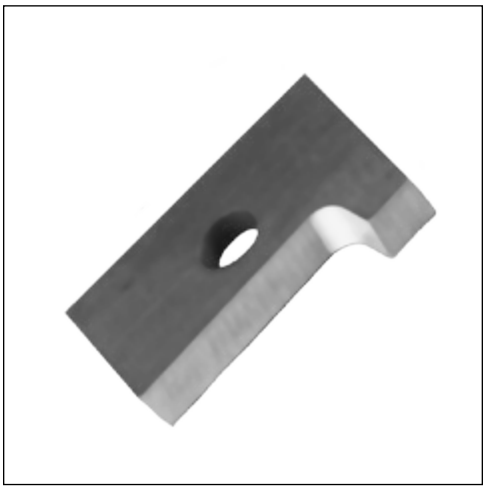
Hw Sw Pl Sp Fb

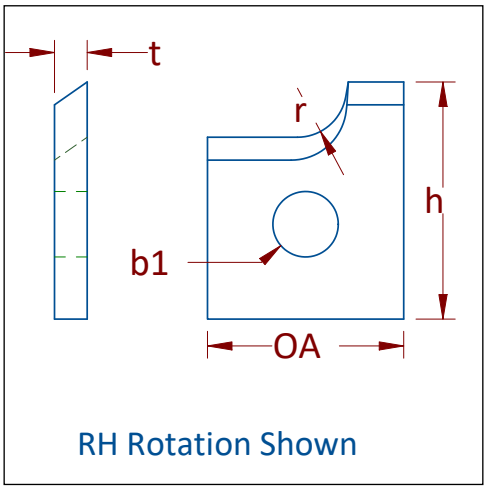
See Material Guide p5

Solid carbide edgebanding insert knives. For applying radius on banded material after edge has been glued. General purpose grade works well for all panel materials. Different radius sizes available.

PART # RH	PART # LH	OA	h	t	r	a	b1
608-002R	*608-002L*	12mm	14.5mm	2mm	2.0mm	35°	4mm
608-025R	*608-025L*	12mm	14.5mm	2mm	2.5mm	35°	4mm
608-003R	608-003L	12mm	14.5mm	2mm	3.0mm	35°	4mm

608 – Edge Banding Inserts





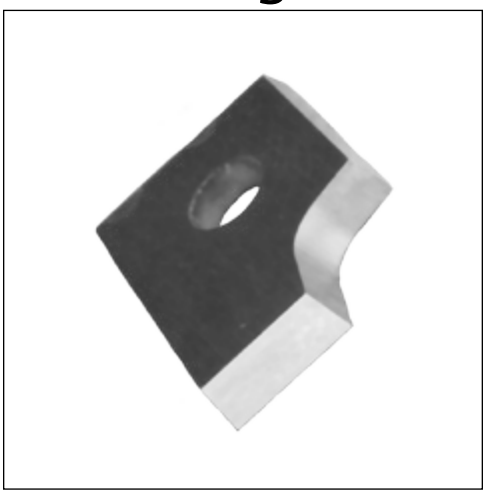
Hw Sw Pl Sp Fb

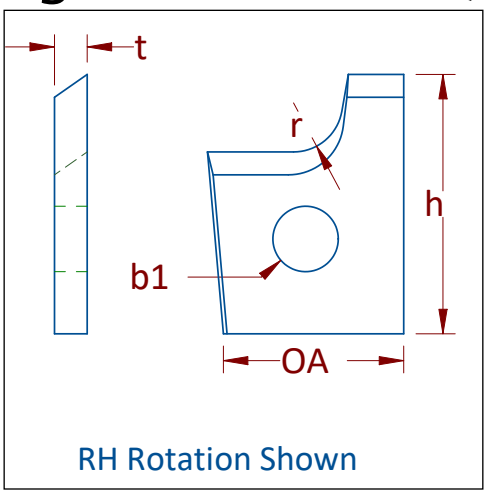
See Material Guide p5

Solid carbide edgebanding insert knives. For applying radius on banded material after edge has been glued. General purpose grade works well for all panel materials. Different radius sizes available.

PART # RH	PART # LH	OA	h	t	r	b1
608-019R	608-019L	19.6mm	15.2mm	2mm	2.0mm	4mm
608-021R	*608-021L*	19.6mm	15..2mm	2mm	3.0mm	4mm

610 – Edge Banding Inserts IMA Quadromat





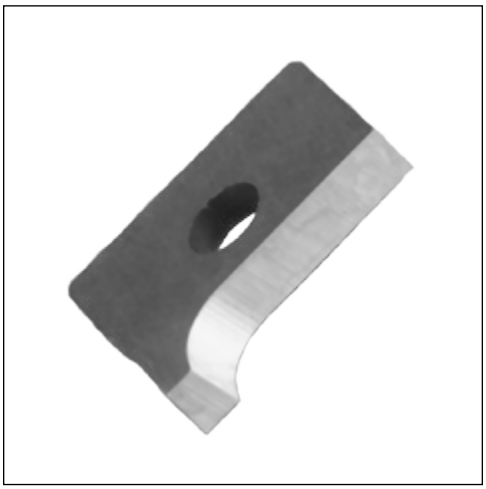
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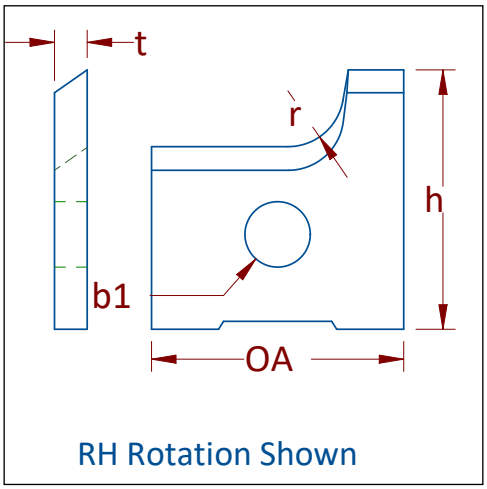
See Material Guide p5

Solid carbide edgebanding insert knives. For applying radius on banded material after edge has been glued. General purpose grade works well for all panel materials. Different radius sizes available.

PART # RH	PART # LH	OA	h	t	r	b1
610-002R	*610-002L*	12mm	18mm	2mm	2.0mm	4mm
610-003R	610-003L	12mm	18mm	2mm	3.0mm	4mm
610-028R	610-028L	12mm	18mm	3mm	3.0mm	4mm

612 – Edge Banding Inserts





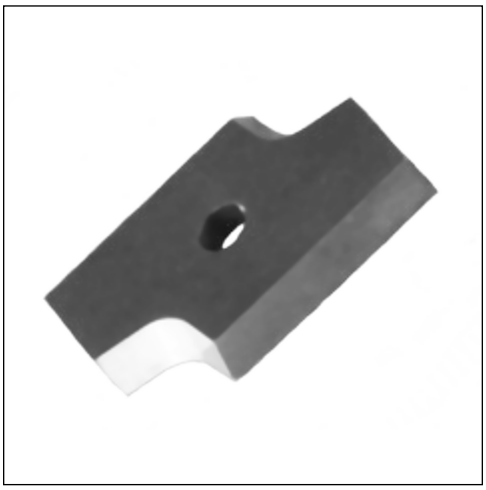
Hw Sw Pl Sp Fb

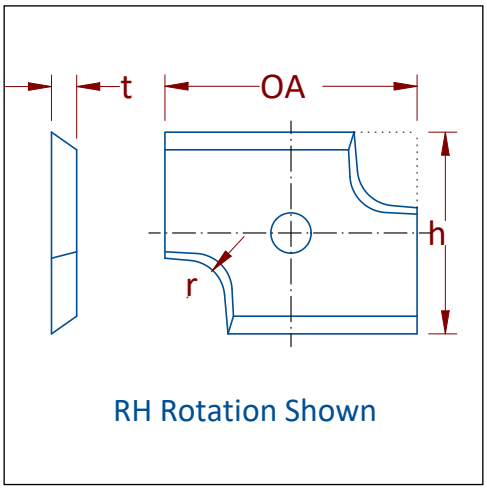
See Material Guide p5

Solid carbide edgebanding insert knives. For applying radius on banded material after edge has been glued. General purpose grade works well for all panel materials. Different radius sizes available.

PART # RH	PART # LH	OA	h	t	r	b1
612-002R	*612-002L*	15.0mm	14.5mm	2mm	2.0mm	4mm
612-025R	*612-025L*	15.0mm	14.5mm	2mm	2.5mm	4mm
612-003R	612-003L	15.0mm	14.5mm	2mm	3.0mm	4mm
612-005R	*612-005L*	16.1mm	14.0mm	2mm	3.0mm	5mm

614 – Edge Banding Inserts





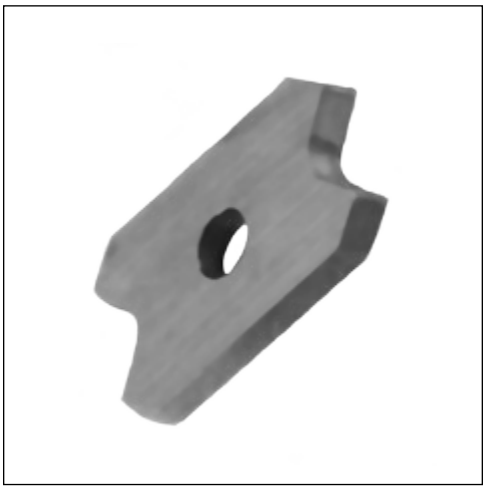
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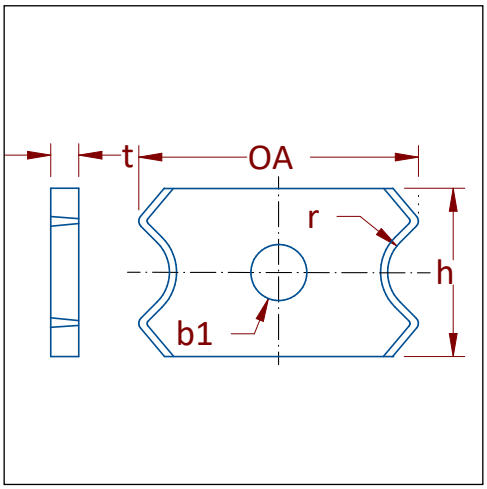
See Material Guide p5

Solid carbide edgebanding insert knives. For applying radius on banded material after edge has been glued. General purpose grade works well for all panel materials. Different radius sizes available.

PART # RH	PART # LH	OA	h	t	r	b1
614-002R	*614-002L*	30mm	14mm	2mm	2.0mm	4mm
614-003R	614-003L	20mm	16mm	2mm	3.0mm	3mm
614-030R	*614-030L*	30mm	14mm	2mm	3.0mm	4mm

616 – Edge Banding Inserts





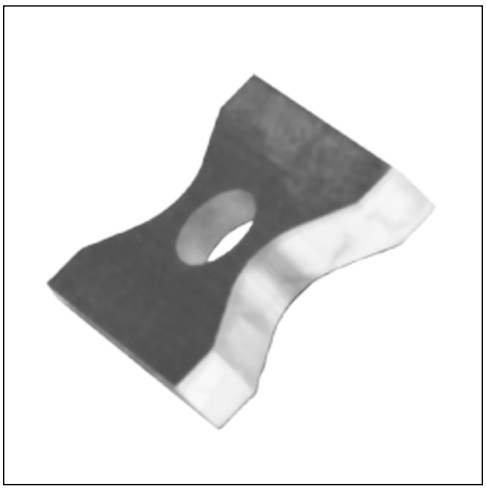
Hw Sw Pl Sp Fb

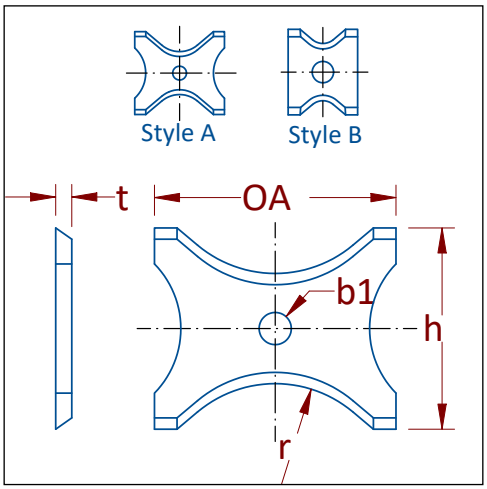
See Material Guide p5

Solid carbide edgebanding insert knives. For applying radius on banded material after edge has been glued. General purpose grade works well for all panel materials. Different radius sizes available.

PART #	OA	h	t	r	b1
616-001	20mm	12mm	2mm	1mm	4mm
616-002	20mm	12mm	2mm	2mm	4mm
616-003	20mm	12mm	2mm	3mm	4mm
616-004	20mm	12mm	2mm	4mm	4mm
616-005	20mm	12mm	2mm	5mm	4mm

618 – Edge Banding Inserts Leuco System





Hw Sw Pl Sp Fb

See Material Guide p5

Solid carbide edgebanding insert knives. For applying radius on banded material after edge has been glued. General purpose grade works well for all panel materials. Different radius sizes available.

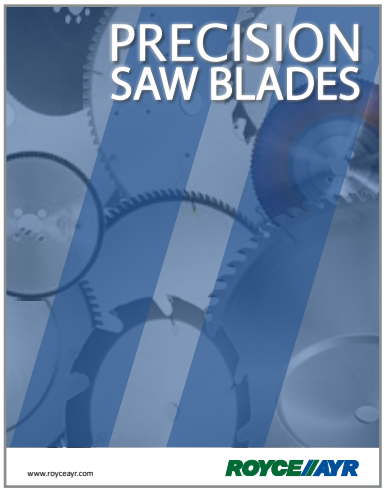
PART #	OA	h	t	r	b1	Style
618-002	13mm	16mm	2mm	2mm	4mm	B
618-003	13mm	16mm	2mm	3mm	4mm	B
618-004	13mm	16mm	2mm	4mm	4mm	B
618-005	20mm	21mm	2mm	5mm	4mm	A
618-006	20mm	21mm	2mm	6mm	4mm	A
618-007	20mm	21mm	2mm	7mm	4mm	A
618-008	20mm	21mm	2mm	8mm	4mm	A
618-009	26mm	24mm	2mm	9mm	4mm	A
618-011	26mm	24mm	2mm	11mm	4mm	A
618-012	26mm	24mm	2mm	12mm	4mm	A

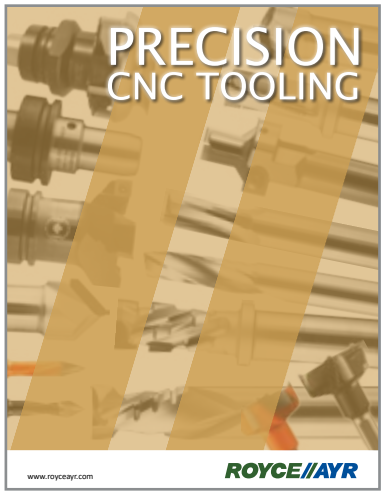
Precision Sharpening Services

Royce Ayr is capable of sharpening cutting tools back to original factory performance levels to keep them cutting as good as new. Same advanced machinery used to manufacture the tooling is used for servicing the tools.



Other Products Available





Custom Tooling

Did not find what you are looking for? We can produce a custom tool to meet your needs. Over 30% of our products are custom tooling. A sales representative would be more than happy to discuss your needs and utilize our experienced technical application specialists. The process is simple regardless if you need a brazed carbide, insertable carbide or polycrystalline diamond (PCD).

1) Contact your Royce Ayr represntative to discuss your need
2) A quotation will be sent as soon as possible for you to review
2) If the quotation is approved, provide any drawings or samples required for the order
3) A drawing will be sent within 2-5 business days depending on the complexity
4) Once the drawing is finalized and we have received your approval we will proceed with production



Royce Ayr Conditions of Sale

Limited Warranty

All items in the Royce Ayr catalogue, unless otherwise noted, are warranted for 90 days against defects in workmanship and materials. Normal wear or misuse of a tool is not covered by this warranty. Merchandise may be returned within the 90 day period to Royce Ayr for assessment and if a defect is found the tool will either be replaced, repaired or refunded at our discretion. In no way will Royce Ayr be responsible for any incidental or consequential damages resulting from use of our products. Stock items being returned free of defect must be within the 90 day period and may be subject to a 15% restocking fee.

Special Items

Special items that are not shown in the catalog are covered by the limited warranty. Items free of defect may be returned at our discretion. A 15% restocking fee will apply if the items can be returned.

Custom Tooling

Custom tools that are made to order are covered by the limited warranty. The customer is responsible to verify details shown on the drawing, such as but not limited to profile specifications, overall tool dimensions, arbor size, shank size, etc. These items are covered against defect in workmanship and material. Custom orders cannot be returned unless a defect in workmanship or materials existed at the time of delivery.

No Sale is Final

Please call us if you have a problem with an order or with the ordering experience. We want you to be satisfied with our products and services and will do our best to make sure that happens.

Deliveries

Partial orders will be shipped until the order is filled. Please specify if you would like an order to ship complete. Lead times and deliveries are provided as a best estimate and every effort will be made by Royce Ayr to meet these deadlines. Royce Ayr is not liable for any incurred expenses resulting from late delivery.

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USA 6391 Walmore Road,
Niagara Falls, NY, 14304

