

# Insert Tooling and Inserts



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# Diamond Edge Band Tooling



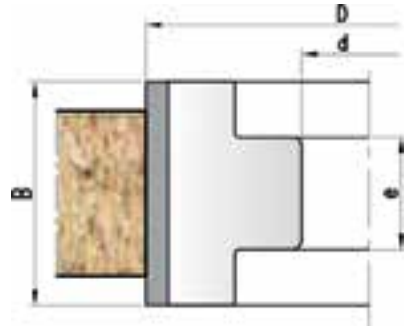
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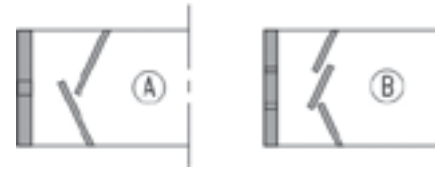
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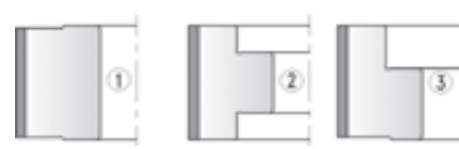
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Cutters Arrangement



Body Design



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## Diamond pre-mill cutters

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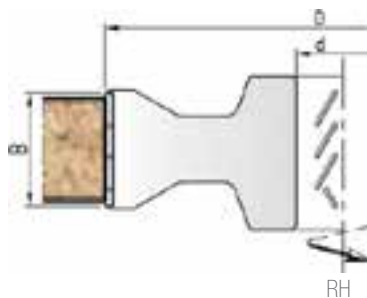
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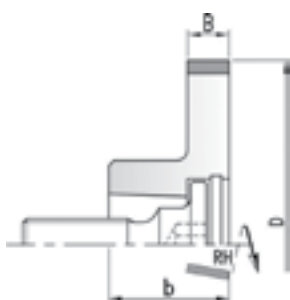
Part No. LH	Part No. RH	D	B/e	d	DKN	Z		Machine
822-0500	822-0524	80	48/25	20	6.5x3.5	2	B+2	Biesse
822-0501	822-0501	80	65/53	30	8x3	3+3	A+2	Biesse
822-0502	822-0502	125	42/47	30	8x3	3+3	A+1	Biesse
822-0503	822-0503	125	63/47	30	8x3	3+3	A+2	Biesse
822-0504	822-0504	60	52/28	16		3+3	A+2	Bi-Matic
822-0505	822-0529	100	50/25	20	6x3	2	B+2	Cehisa
822-0506	822-0530	80	65/25	20	6.5x3.5	2+2	B+2	Griggio
822-0507	822-0531	80	65/67	30	8x3	3+3	B+1	SCM-Stefani
822-0508	822-0532	100	64/40.6	30	8x3	3+3	B+3	SCM-Stefani
822-0509	822-0533	100	34/36	30	8x3	3+3	B+1	IMA/Brandt
822-0510	822-0534	100	45/40.6	30	8x3	3+3	B+3	IMA/Brandt
822-0511	822-0535	125	34/34	30	8x3	3+3	B+1	IMA
822-0512	822-0536	125	43/42	30	8x3	3+3	B+1	IMA
822-0513	822-0537	125	63/42	30	8x3	3+3	B+3	IMA
822-0514	822-0538	70	54/31	30	8x3	2+2	B+2	HolzHer
822-0515	822-0539	70	64/39	30	8x3	2+2	B+2	HolzHer
822-0516	822-0540	100	48/25	30	8x3	2+2	B+2	HolzHer
822-0517	822-0541	100	63/25	30	8x3	3+3	B+2	HolzHer
822-0518	822-0518	125	34/36	30	8x3	3+3	A+1	Homag
822-0519	822-0519	125	63/40	30	8x3	3+3	A+2	Homag
822-0520	822-0544	180	43/58.5	35	10x3.3	4+4	B+1	Homag
822-0521	822-0545	180	63/58.5	35	10x.3	4+4	B+1	Homag
822-0522	822-0546	85	60/50	30	8x3	3+3	B+3	Ott
822-0523	822-0547	85	45/47	30	8x3	3+3	B+1	Ott

# Diamond Edge Band Tooling



## Diamond pre-mill cutters

Part No.	D	B/b	d	DKN	Z	
822-0548	100	34/36	50	8x3	3+3	B+1
822-0549	125	34/34	50	8x3	3+3	B+1



## Spare Parts

Part No.	Description
1C0-0001	Screw - M10x1.25

## Edge banding diamond cutter

Part No. L.H.	Part No. R.H.	D	B/b	d	Z	n. max	Machine
827-0500	827-0504	70	8/23	HSK 25R	4	12000	Homag - IMA
827-0501	827-0505	70	8/23	HSK 25R	6	12000	Homag - IMA
827-0502	827-0506	70	15/23	HSK 25R	4	12000	Homag - IMA
827-0503	827-0507	70	15/23	HSK 25R	6	12000	Homag - IMA



## Spare Parts

Part No.	Description
1C0-0001	Screw - M10x1.25

## Edge rounding diamond cutter

Part No. L.H.	Part No. R.H.	D	R	B	d	Z	n. max	Machine
828-0500	828-0502	85	2/3	28	HSK 25R	4	24000	Homag - IMA
828-0501	828-0503	85	2/3	28	HSK 25R	6	24000	Homag - IMA

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# Diamond Edge Band Tooling

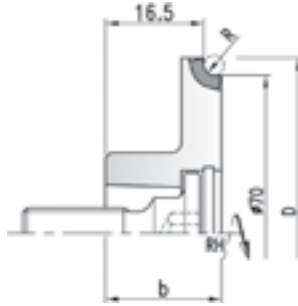


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## Spare Parts

Part No.	Description
1C0-0001	Screw - M10x1.25

## Edge rounding diamond cutter

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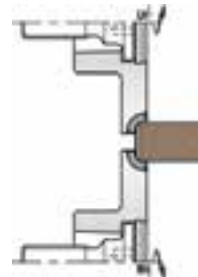
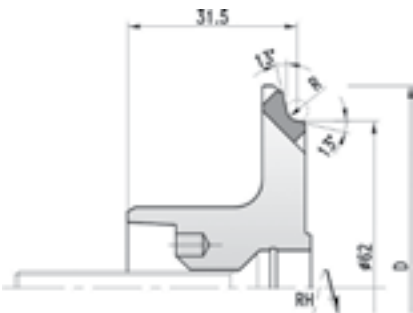
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Part No. L.H.	Part No. R.H.	D	R	B	d	Z	n. max	Machine
828-0504	828-0513	79	1	23	HSK 25R	4	24000	Homag - IMA
828-0505	828-0514	79	2	23	HSK 25R	4	24000	Homag - IMA
828-0506	828-0515	79	2	23	HSK 25R	6	24000	Homag - IMA
828-0507	828-0516	79	3	23	HSK 25R	4	24000	Homag - IMA
828-0508	828-0517	79	3	23	HSK 25R	6	24000	Homag - IMA
828-0509	828-0518	85	4	24	HSK 25R	4	24000	Homag - IMA
828-0510	828-0519	85	4	24	HSK 25R	6	24000	Homag - IMA
828-0511	828-0520	85	5	24	HSK 25R	4	24000	Homag - IMA
828-0512	828-0521	85	5	24	HSK 25R	6	24000	Homag - IMA



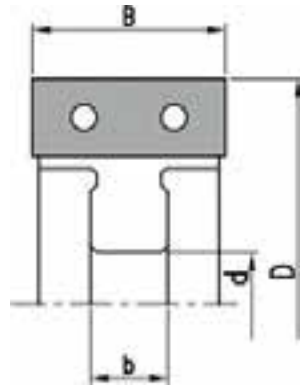
## Spare Parts

Part No.	Description
1C0-0003	M6x45

## Edge rounding diamond cutter

Part No. L.H.	Part No. R.H.	D	R	d	Z	n. max	Machine
829-0500	829-0509	75	1	HSK 32	4	18000	Homag - IMA
829-0501	829-0510	75	2	HSK 32	4	18000	Homag - IMA
829-0502	829-0511	75	2	HSK 32	6	18000	Homag - IMA
829-0503	829-0512	75	3	HSK 32	4	18000	Homag - IMA
829-0504	829-0513	75	3	HSK 32	6	18000	Homag - IMA
829-0505	829-0514	75	4	HSK 32	4	18000	Homag - IMA
829-0506	829-0515	75	4	HSK 32	6	18000	Homag - IMA
829-0507	829-0516	75	5	HSK 32	4	18000	Homag - IMA
829-0508	829-0517	75	5	HSK 32	6	18000	Homag - IMA

# Edge Band Tooling



Cutter head for edge banding machines

Part No.	D	B/b	d	DKN	Z	n. max	Machine
822-0600	70	12/10	16	5x2.3	4	18000	Brandt - Homag - IDM - Stefani
822-0601	70	12/10	16	5x2.3	6	18000	Brandt - Homag - IDM - Stefani
822-0602	80	40/25	30	8x3.3	4	18000	Holz-Her
822-0603	70	20/10	20	6x3.5	4	18000	Holz-Her - Homag - IMA
822-0605	50	12/10	16	5x2.3	2	18000	Homag - Homburg
822-0604	50	15/10	16	5x2.3	2	18000	IMA - Raimann
822-0606	70	30/12	16	6x3.5	4	18000	Olimpic
822-0607	70	20/10	16	5x2.3	4	18000	Ott
822-0608	70	20/11	16	6x3.5	6	18000	SCM-Stefani
822-0609	70	15/10	16	6x3.5	4	18000	SCM-Stefan
822-0610	72	20/11	16	6x3.5	4	18000	SCM-Stefan
822-0611	75	20/11	16	6x3.5	4	18000	SCM-Stefan
822-0612	75	30/11	16	6x3.5	4	18000	SCM-Stefan
822-0613	80	20/11	16	5x2.3	4	18000	SCM-Stefan
822-0614	80	30/11	16	5x2.3	4	18000	SCM-Stefan

## Spare Parts

Part No.	Description	Part No.	Description	Part No.	Description
210-5401 (TJ156)	Knife-12x12x1.5 (box of 10)	1C1-0000	Clamping wedge - 12	1C0-0005	Screw - M6x12
200-5403 (TJ114)	Knife-15x12x1.5 (box of 10)	1C1-0001	Clamping wedge - 15	1C4-0000	Adjusting Gauge - 1.0
200-5404 (TJ117)	Knife-20x12x1.5 (box of 10)	1C1-0002	Clamping wedge - 20		
202-5402 (TJ119)	Knife-30x12x1.5 (box of 10)	1C1-0003	Clamping wedge - 30		
202-5403 (TJ123)	Knife-40x12x1.5 (box of 10)	1C1-0004	Clamping wedge - 40		

# Edge Band Tooling

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## Spare Parts

Part No.	Description
200-5404 (TJ117)	Knife-20x12x1.5 (box of 10)
200-5402 (TJ119)	Knife-30x12x1.5 (box of 10)
1C1-0002	Clamping Wedge - 20
1C1-0003	Clamping Wedge - 30
1C0-0005	Screw - M6x12
1C4-0000	Adjusting Gauge - 1.0

## Cutter head for edge banding machines

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Part No. L.H.	Part No. R.H.	D	B/b	d	DKN	Z	n. max	Machine
822-0615	822-0620	70	20/12.5	20	6x3.5	4	18000	Brandt - Homag - IMA IDM - SCM - Stefani
822-0616	822-0621	70	20/12.5	20	6x3.5	6	18000	Brandt - Homag - IMA IDM - SCM - Stefani
822-0617	822-0622	72	30/12	16	6x3.5	4	18000	SCM-Stefani
822-0618	822-0623	70	20/11.5	20	6x3.5	6	18000	FRAVOL
822-0619	822-0624	80	30/25.5	20	6x3.5	6	18000	FRAVOL

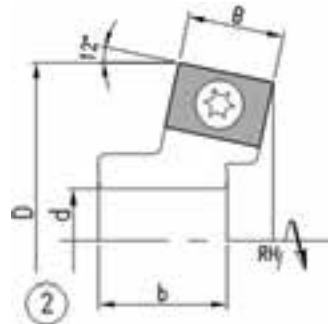
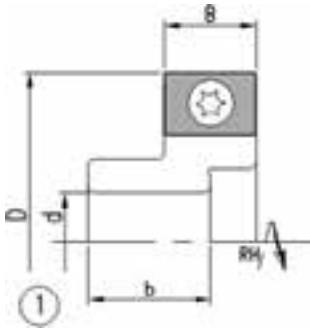
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## Spare Parts

Part No.	Description
1C3-0000	Knife - 14.6x9x1.5
1C0-0004	Screw - M3.5x7.5

## Cutter head for edge banding machines

Part No. L.H.	Part No. R.H.	D	B/b	d	DKN	Z	n. max	Machine
822-0625	822-0626	48	14.6/20	16	5x2.3	2	18000	SCM-1
825-0601	825-0600	52.8	14.6/20	16	5x2.3	2	18000	SCM-2



# Edge Band Tooling

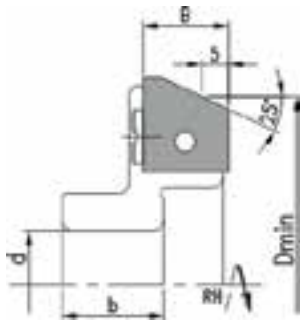


## Spare Parts

Part No.	Description
200-5404 (TJ117)	Knife-20x12x1.5 (box of 10)
200-5402 (TJ119)	Knife-30x12x1.5 (box of 10)
1C1-0002	Clamping Wedge - 20
1C1-0003	Clamping Wedge - 30
1C0-0005	Screw - M6x12
1C4-0000	Adjusting Gauge - 1.0

## Cutter head for edge banding machines

Part No. L.H.	Part No. R.H.	D	B/b	d	DKN	Z	n. max	Machine
822-0627	822-0630	70	20/22	20	6x2.8	6	18000	Biesse
822-0628	822-0631	80	20/22	20	6x2.8	6	18000	Biesse
822-0629	822-0632	80	30/22	20	6x2.8	6	18000	Biesse



## Spare Parts

Part No.	Description
1C2-0000	Knife - 16x17.5x2
1C1-0006	Clamping Wedge - 16
1C0-0005	Screw - M6x12

## Cutter head for edge banding machines

Part No. L.H.	Part No. R.H.	D	B/b	d	DKN	Z	n. max	Machine
825-0700	825-0701	70	16/19	16	5x2.3	6	18000	Biesse



# Edge Band Tooling

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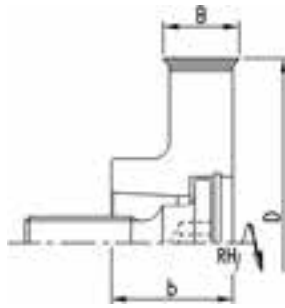
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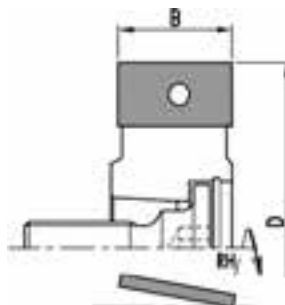


## Spare Parts

Part No.	Description
211-5804 (TJ487)	Knife-14.3x14.3x2.5 (box of 10)
1C0-0002	Screw - M5x13
1C0-0001	Screw - M10x1.25

## Cutter head for edge banding machines

Part No. L.H.	Part No. R.H.	D	B/b	d	Z	n. max	Machine
827-0600	827-0601	70	14.3/23	HSK 25R	4	18000	Homag - IMA



## Spare Parts

Part No.	Description
200-5408 (TJ475)	Knife-24.7x12.3x1.5 (box of 10)
1C1-0011	Clamping Wedge
1C0-0006	Screw - M8x12
1C0-0001	Screw - M10x1.25
1C4-0000	Adjusting Gauge - 1.0

## Cutter head for edge banding machines

Part No. L.H.	Part No. R.H.	D	B/b	d	Z	n. max	Machine
827-0602	827-0603	70	24	HSK 25R	4	18000	Homag - IMA

# Edge Band Tooling



## Spare Parts

Part No.	Description
230-5409	Knife - R2 - 16.17.5x2 (box of 10)
230-5410	Knife - R3 - 16.17.5x2 (box of 10)
230-5411	Knife - R4 - 16.17.5x2 (box of 10)
230-5412	Knife -R5 - 16.17.5x2 (box of 10)
1C1-0005	Clamping Wedge
1C0-0005	Screw - M6x12

## Cutter head for edge banding machines

Part No.	D	D1	B/b	d	DNK	R	Z	n. max	Machine
826-0600	73	61	16/11	16	5x2.3	2	3	18000	Homag - Gabbiani - Ott
826-0601	73	61	16/11	16	5x2.3	3	3	18000	Homag - Gabbiani - Ott
826-0602	73	61	16/11	16	5x2.3	4	3	18000	Homag - Gabbiani - Ott
826-0603	73	61	16/11	16	5x2.3	5	3	18000	Homag - Gabbiani - Ott
826-0604	73	61	16/11	20	6x3.5	2	3	18000	HolzHer
826-0605	73	61	16/11	20	6x3.5	3	3	18000	HolzHer
826-0606	73	61	16/11	20	6x3.5	4	3	18000	HolzHer
826-0607	73	61	16/11	20	6x3.5	5	3	18000	HolzHer
826-0608	73.3	61.3	16/10	16	5x2.3	2	3	18000	IDM
826-0609	73.3	61.3	16/10	16	5x2.3	3	3	18000	IDM
826-0610	73.3	61.3	16/10	16	5x2.3	4	3	18000	IDM
826-0611	73.3	61.3	16/10	16	5x2.3	5	3	18000	IDM
826-0612	70	70	16/11	20	6x3.5	2	4	18000	IMA - Wilmsmeyer
826-0613	70	70	16/11	20	6x3.5	3	4	18000	IMA - Wilmsmeyer
826-0614	70	70	16/11	20	6x3.5	4	4	18000	IMA - Wilmsmeyer
826-0615	70	70	16/11	20	6x3.5	5	4	18000	IMA - Wilmsmeyer

# Edge Band Tooling

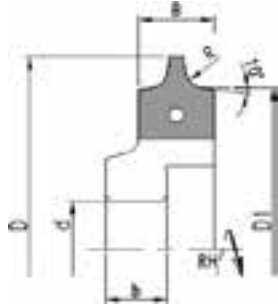
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## Spare Parts

Part No.	Description
230-5409	Knife - R2 - 16.17.5x2 (box of 10)
230-5410	Knife - R3 - 16.17.5x2 (box of 10)
230-5411	Knife - R4 - 16.17.5x2 (box of 10)
230-5412	Knife - R5 - 16.17.5x2 (box of 10)
1C1-0005	Clamping Wedge
1C0-0005	Screw - M6x12

## Cutter head for edge banding machines

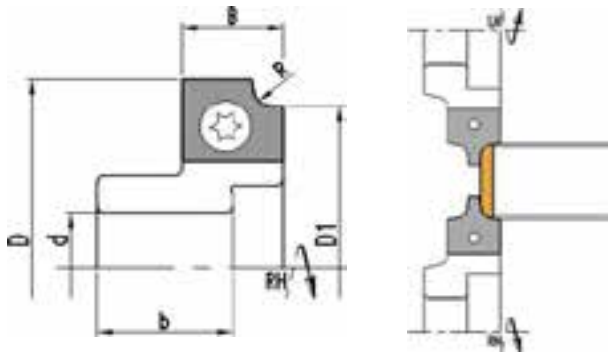
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Part No. L.H.	Part No. R.H.	D	D1	B/b	d	DKN	R	Z	n. max	Machine
826-0616	826-0620	82	70	16/13	20	6x3.5	2	4	18000	IMA
826-0617	826-0621	82	70	16/13	20	6x3.5	3	4	18000	IMA
826-0618	826-0622	82	70	16/13	20	6x3.5	4	4	18000	IMA
826-0619	826-0623	82	70	16/13	20	6x3.5	5	4	18000	IMA

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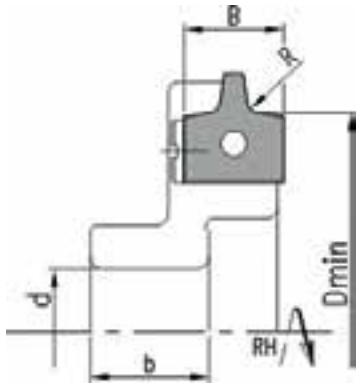
## Spare Parts

Part No. LH	Part No. RH	Description
1C2-0015	1C2-0020	Knife - R1 - 15x12x1.5
1C2-0016	1C2-0021	Knife - R1.5 - 15x12x1.5
1C2-0017	1C2-0022	Knife - R2 - 15x12x1.5
1C2-0018	1C2-0023	Knife - R2.5 - 15x12x1.5
1C2-0019	1C2-0024	Knife - R3 - 15x12x1.5
1C0-0004	1C0-0004	Screw - M3

## Cutter head for edge banding machines

Part No. L.H.	Part No. R.H.	D	D1	B/b	d	DKN	R	Z	n. max	Machine
826-0624	826-0629	55.5	47.5	15/20	16	5x2.3	1	2	18000	SCM
826-0625	826-0630	55.5	47.5	15/20	16	5x2.3	1.5	2	18000	SCM
826-0626	826-0631	55.5	47.5	15/20	16	5x2.3	2	2	18000	SCM
826-0627	826-0632	55.5	47.5	15/20	16	5x2.3	2.5	2	18000	SCM
826-0628	826-0633	55.5	47.5	15/20	16	5x2.3	3	2	18000	SCM

# Edge Band Tooling



## Spare Parts

Part No.	Description
230-5409	Knife - R2 - 16.17.5x2 (box of 10)
230-5410	Knife - R3 - 16.17.5x2 (box of 10)
230-5411	Knife - R4 - 16.17.5x2 (box of 10)
230-5412	Knife - R5 - 16.17.5x2 (box of 10)
1C1-0005	Clamping Wedge
1C0-0005	Screw - M6x12

## Cutter head for edge banding machines

Part No. L.H.	Part No. R.H.	D	B/b	d	DKN	R	Z	n. max	Machine
826-0634	826-0638	70	16/19	16	5x2.3	2	6	18000	Biesse
826-0635	826-0639	70	16/19	16	5x2.3	3	6	18000	Biesse
826-0636	826-0640	70	16/19	16	5x2.3	4	6	18000	Biesse
826-0637	826-0641	70	16/19	16	5x2.3	5	6	18000	Biesse



## Spare Parts

Part No. LH	Part No. RH	Description
1C2-0001	1C2-0002	Knife - R1.5/R2/R3 - 25x18.5x2
1C1-0007	1C1-0008	Clamping Wedge - 25x18.5x2
1C0-0005	1C0-0005	Screw - M6x12

## Cutter head for edge banding machines

Part No. L.H.	Part No. R.H.	D	B	d	DKN	R	Z	n. max	Machine
826-0642	826-0643	75	25	20	6x3.5	1.5/2/3	4	18000	Biesse

# Edge Band Tooling

A



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## Cutter head for edge banding machines

Part No. L.H.	Part No. R.H.	D	b	d	Z	R	n. max	Machine
828-0700	828-0704	79	23	HSK 25R	4	2	18000	Homag
828-0701	828-0705	79	23	HSK 25R	4	3	18000	Homag
828-0702	828-0706	85	24	HSK 25R	4	4	17700	Homag
828-0703	828-0707	85	24	HSK 25R	4	5	17700	Homag

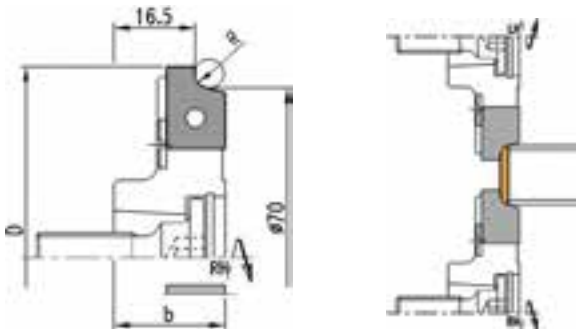
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## Spare Parts

Part No. LH	Part No. RH	Description
1C2-0004	1C2-0003	Knife - R2 - 12x17x2
1C2-0006	1C2-0005	Knife - R3 - 12x17x2
1C2-0008	1C2-0007	Knife - R4 - 12x20x2
1C2-0010	1C2-0009	Knife - R5 - 12x20x2
1C1-0010	1C1-0009	Clamping Wedge
1C0-0005	1C0-0005	Screw - M6x12
1C0-0001	1C0-0001	Screw - M10x1.25

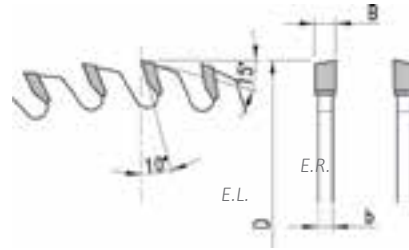
## Spare Parts

Part No. LH	Part No. RH	Description
1C2-0012	1C2-0011	Knife - R2 - 12x17x2
1C2-0014	1C2-0013	Knife - R3 - 12x17x2
1C1-0013	1C1-0012	Clamping Wedge
1C0-0005	1C0-0005	Screw - M6x12
1C0-0001	1C0-0001	Screw - M10x1.25

## Cutter head for edge banding machines

Part No. L.H.	Part No. R.H.	D	b	d	Z	R	n. max	Machine
828-0708	828-0710	79	23	HSK 25R	4	2	18000	IMA
828-0709	828-0711	79	23	HSK 25R	4	3	18000	IMA

# Edge Band Tooling



Circular saw blades for edge banders

472-A000	472-A100	80	3.2	2.2	30	12	Bi-Matic
472-A001	472-A101	85	3.2	2.2	30	12	Bi-Matic
472-A002	472-A102	100	2.6	1.6	32	20	Homag, Brandt
472-A003	472-A103	100	3.0	2.2	32	30	Cehisa
472-A004	472-A104	100	3.2	2.2	30	20	Tecnomat
472-A005	472-A105	100	3.2	2.2	22	20	Griggio, Homag, Wilmsmeyer
472-A006	472-A106	110	3.0	2.2	30	20	Homburg
472-A007	472-A107	110	3.0	2.2	32	20	SCM, Olimpic
472-A200	472-A200	110	3.6	2.4	22	20W	Holz-Her
472-A009	472-A109	110	3.6	2.4	32	20	IDM
472-A010	472-A110	110	3.2	2.2	32	30	Homag, Brand, Cehisa
472-A011	472-A111	125	3.2	2.2	22	36	Camal
472-A012	472-A112	130	3.6	2.8	30	24	Biesse
472-A013	472-A113	140	3.2	2.2	16	36	OTT
472-A014	472-A114	140	3.2	2.2	30	36	OTT
472-A015	472-A115	160	3.2	2.2	22	48	IMA
472-A201	472-A201	160	3.2	2.2	22	48W	IMA

# NEXT G Series – Save You Time and Money

A

Next G Series cutter heads clearly provide greater flexibility and ease-of-use features compared to old style diamond or carbide insert tools. You will see the savings add up with Next G..

B

## Easy tool changes reduces your tool body inventory

C

Changing profiles with NEXT G is so easy it makes sense to use one common body for different profiles. Knives are automatically and accurately positioned “hands free” and the large rear mount screw permits fast release and tightening. This means that you can reduce your inventory of dedicated tools. Your back up tooling can be just another set of diamond or carbide knives instead of a complete diamond cutterhead. Next G body style standardizes tooling set-up in the tool room and at the machine. Machine settings do not have to be adjusted after a knife change thanks to NEXT G’s constant diameter and profile positioning features.

D

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## Reduced tooling requirements and sharpening costs

G

A big advantage of the Next G Series is that if one tooth is accidentally chipped or damaged, only that knife needs to be serviced. Replace the damaged knife and you are up and running again. Then send us the damaged knife for service. With old style diamond tools the complete tool must be sent for service.

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It costs less to sharpen Next G diamond knives than a comparable old style diamond cutter head. The Next G self-positioning system provides constant diameter and profile positioning after service. That means that no fence or spindle adjustments on the machine are required after installing new or re-sharpened inserts in the Next G tool body. Shipping expenses are also reduced since only a small package of knives is being transported instead of a heavy box with a complete tool.

J

K

## Easily change from carbide to diamond

The dual system allows a new profile to be prototyped and tested with lower cost, lower risk, carbide cutting edges. Once the new profile is a proved, continuous production can then be started using the same tool body with diamond inserts. Optimize cutting edge for different applications. Reduce inventory of tools on hand. Introduce a new profile or produce a short run using quick delivery of carbide knives. Full utilization of a standard tool body compliments today’s LEAN manufacturing system.

## Cost Savings Add Up

Typical savings our customers see using NEXT G instead of old style diamond tools. Savings are calculated using a lifetime period 125 production days, based on a production of 10h/day at a feed rate of 10m/min diamond edges.

Duration	Savings
After 5 lifetimes .....	27%
After 10 lifetimes .....	30%





# NEXT G Series - Product Specifications



The Next G Series are the first tools capable of automatically positioning diamond or carbide profiled inserts while keeping accurate and constant axial and diameter positions.

## Accurate self-positioning system

Each profiled insert is positioned with a three contact point locating system on the tool body. This system eliminates the inherent positioning error of standard profiled inserts that are secured by just screws against one surface of the tool body, or by wedge gibs. The spring loaded system positions the insert knives within a repeatability of 0.0003" (3/10 of 1 thousandth of an inch). This system eliminates the time of trial and error checking of the knife position. It delivers more consistent production results due to the repeated exact positioning of the profile on all knives in the tool. Product quality is increased, scrap rejects are decreased.

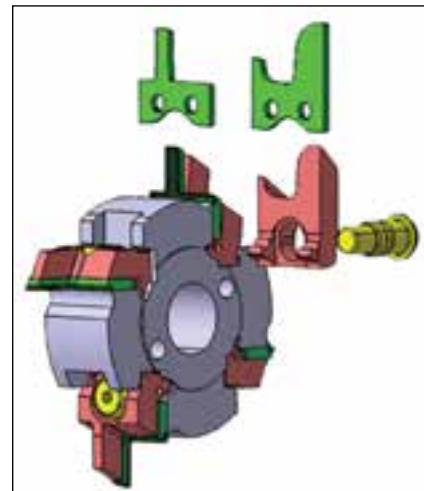


## Rear clamping system with single screw fastening

Secure clamping pressure is from the large diameter single screw located at the rear of the knife assembly. Positive interlocking of the knife and the clamping back plate with the solid tool body provides extremely high security even if the screw is loose.

## Diamond or carbide inserts in the same tool body

Choose to mount either Diamond or Carbide inserts in the same tool body to optimize the cutting edge for different material applications (hardwood, softwood, MDF, particle board, solid acrylics, cement board). This dual system also allows a new profile to be prototyped and tested with lower cost carbide cutting edges. Once the new design is approved, continuous production can then be started using the same tool body with diamond inserts.



## Change profiles as needed

Use one Next G series tool body for different profiles. One common body style standardizes tooling set ups in the tool room and out at the machine. Users can reduce their inventory of dedicated tools that may only be used occasionally. Faster delivery of new profiles and full utilization of a standard tool body can compliment today's LEAN manufacturing systems.



# NEXT G Series - Product Specifications

A

## NEXT G Specifications

Specifications for NEXT G Series only.  
For NEXT G PLUS use Pdiam.

B

When ordering please specify  
clockwise, or counter-clockwise  
cutting direction.

D

E

## Standard NEXT G Bodies

F

Body Ø	Number of Seats					
	2	3	4	6	8	10
75mm						
90mm						
100mm						
110mm						
120mm						
135mm						
145mm						
160mm						
180mm						
196mm						

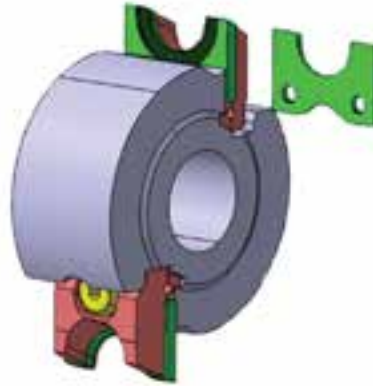
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We provide engineering/design services at no additional charge. Contact your NAP-GLADU representative for more information.

## NEXT G Back Clamps

Qty.	30mm	40mm	50mm
2			
3			
4			
6			
8			
12+			

## NEXT G Carbide Knives

Qty.	30mm	40mm	50mm
6			
12			
18			
24			
36			

## Standard Next G Specifications Table

Body Ø	Small Cutting Ø	RPM Range		Max Weight (kg) based on Body Thickness		
		Nmin	Nmax	30mm	40mm	50mm
75mm	3.125" or 80mm	9000	12000			
90mm	3.75" or 95mm	8000	12000			
100mm	4.125" or 105mm	7200	10000			
110mm	4.5" or 115mm	6500	9500			
120mm	5" or 125mm	6000	9000			
135mm	5.5" or 140mm	5500	8000			
145mm	6" or 150mm	5000	7500			
160mm	6.5" or 165mm	4500	7000			
180mm	7.25" or 185mm	4000	6500			
196mm	8" or 200mm	3600	6000			





# Operator Guides to NEXT G Insert Tools

## How to remove a knife

Unscrew the rear Back-Clamp 3 or 4 full turns. No need to hold the knife while doing this.



With one hand, hold the side edges of the knife then push it down to unlock it. You will feel the spring loaded system.



Move the knife against the Back-Clamp surface and slide it outward in order to remove the knife from the system.



Carefully place the knife in a secure area to prevent damage to the diamond edge.



## How to change a Profile Back-Clamp

After removing the knife, you can completely remove the screw. While removing the screw, hold the Back-clamp with the other hand to prevent it falling out.



You can remove the Back-Clamp by sliding it out of the side of the head. Carefully clean the head's seat with an air gun to remove any wood dust. Wear eye protection when using compressed air.



Insert a clean Back-Clamp by sliding it into the side of the head. Make sure that the Sf value of the Back-Clamp is lower than the Sfmax value of the Head and that the hook angle of the Back-Clamp matches the hook angle of the head.



Insert the screw and tighten completely without any knife installed. Then unscrew 3 turns to open the back-clamp.



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# Operator Guides to NEXT G Insert Tools

## A How to insert a knife into the head

B With one hand, hold the side edges of the knife and slide it along the Back-Clamp surface till you feel the spring load system.



C Push the knife to compress the springs and move it forward against the head's seat surface in order to lock it. Make sure that the knife surface is completely seated on the head surface.



D Screw the rear Back-Clamp. Do not hold the knife, it is self-positioned.



E Firmly hand tighten the screw to a min. torque of 16 N.m (11.5 lb. ft.). You can easily reach this torque requirement with the provided screwdriver.



## How to run the Next G cutter

Check that the machine RPM is within the RPM range printed on the tool's body.



Install the tool on the machine. You don't have to worry about the radial adjustment as your knives are sharpened to a constant small diameter.



With the same tool body you can change from a carbide insert to a diamond insert using the same back clamp. To change to a new profile you must also change to a new back clamp.



Each Back-Clamp can be used in any Next G Body of the same width (30, 40 or 50mm . . .) and with a matching hook angle. Check the hook angle etched on the back clamp and the body.



## How to prepare a damaged or worn diamond insert for service

Remove the diamond insert from the head and replace it with another diamond insert.



DO NOT mix diamond and carbide inserts on the same head.

Send us your worn diamond inserts for servicing. We will reprofile your inserts to the original constant diameter and re-balance them to their initial weight.



Check to see if the center round hole of the diamond insert is filled with a copper plug. If a copper plug is present that insert cannot be serviced. (Some wider inserts may have more than 1 center hole).



When receiving your re-profiled inserts, carefully stock it with the other inserts of the same number. You can mix new and re-profiled diamond inserts on the same head.





# NEXT G Series – FAQs

## Design

### What hook angles are available?

5, 10, 15, 20 as standard.  
0 & 25 as custom w/\$300 surcharge.

### What shear angles are available?

0, 5, 10, 15 as standard

### Is alternate shear available?

Yes, on tool bodies with an even number of wings  
(2,4, 6, 8)

### Are custom body sizes available?

Yes, custom body sizes are available at an upcharge.  
See the price list for details. Next G bodies can be  
customized between 75mm and 300mm diameter.

### What is the minimum cutting circle for each body diameter?

Minimum cutting circle is between 4mm to 8mm  
greater than body diameter. Otherwise specify a  
custom body diameter.

### What are the maximum bore sizes for each body diameter?

Maximum bore size is in relation to body diameter,  
number of teeth and hook angle. Ask for the chart of  
“Max bore diameter (mm) vs the number of teeth”.

### Can Next G be mounted on a tool holder for CNC use?

Yes, using an ETP Hydro Grip tool holder available  
from your local NAPGLADU representative.

### Is Next G available with an aluminum body to save weight?

No. Aluminum bodies are NOT available.

## Profile

### How do we calculate the price of diamond knives?

Measure the wood profile length as for standard  
diamond tools and refer to the Next G Series price  
list for the applicable price. Design dept. will confirm  
correct profile length at time of tool drawing.

### What is the maximum profile depth that can be cut with the Next G Series?

25.8mm as far as the wood surface area removed by the  
knives while respecting the max Sf value of the head.

### What is the Sf value?

The Sf value is the surface area of material removed  
by the profile of cut. Each tool body has a Sf max  
value calculated and laser printed. You can buy any  
profile to fit your head as long as the material surface  
area removed is lower than the Sf max. of the head.

### Why is the Sf value important?

To preserve user's security and tool integrity, Next G  
head has a min. RPM, max. RPM and max. Sf values.

### How do I determine Sf value?

Sf value is determined at the time of tool design. To  
correctly determine the Sf value, we use a CAD system.

### Can different profiles with similar dimensions be used with the same back clamp? (similar to the Perfect Match System)

Yes. As long as the knife projection of all profiles is  
less than 3.48mm (0.137") from the back clamp.  
There is a surcharge of 30% over the Back-Clamp  
price list to get this option. Note that the number of  
face sharpenings will then be reduced.

### How do we machine material thickness greater than 50mm? (example: exterior doors at 1-3/4")

Material greater than 50mm thickness may be able  
to be machined with a 2 piece assembly. The design  
department will develop the concept and price  
on request.

### Can we machine raise panels with the Next G Series?

Next G Series is mainly dedicated to outside profile,  
mouldings and stile & rail applications. It can be used  
for Raised Panels but the max. profile depth is limited  
to 38.1mm with 45° custom angled body. For raised  
panel profiles, ask for our Next G Plus Series for  
Raised Panel Head.

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# NEXT G Series – FAQs

A

## Operation

### Why are there min. & max. RPM speeds for each tool?

The RPM range is there for user safety. Also, the Sf max. value is determined based on min. and max. RPM limits. If you need to operate the tool out of this range, ask for a custom head spec.

B

C

### What happens if a tool runs below the min. RPM?

The clamping system will not reach the optimal holding value. As with any tool, excessive chip load could result in tool or equipment damage, or personal injury.

D

E

### Is there a maximum feed rate for Next G?

Yes. The Sf max. value is also based on a max. chip load of 0.036". You can calculate max. chip load and then max. feed rate for each application. Ask if you need help with this.

F

G

### Can we use the same knives and back clamps on different diameter heads?

The heads must have the same specifications including Sf, hook and shear. In a different diameter head (if all specs are compatible) the profile will be distorted. If that is acceptable, then you can do this.

H

I

### Can we mix carbide and diamond knives on the same head?

NO. Carbide and diamond knives cannot be mixed on the same tool body. They have a different weight and it will unbalance the tool. Use only all carbide or all diamond knives at one time.

J

K

## Service

### What is the best way to clean the knife seat when changing knives?

Compressed air (with eye protection) to remove wood dust. Nylon brush or cloth with liquid cleaners for resin, then dry off. Do not scratch the knife seat area with hard tools.

### Is a carbide knife resharpened on the face or the profile?

It is resharpened on the face of the cutting area only. The clamping area must not be reground as resharpened knives have to fit the Next G head after servicing.

### How many times can a carbide knife be reprofiled?

Two or three face sharpenings are possible. Always send all knives in a set for servicing. Use knives in the same sets as serviced.

### How many times can a diamond knife be reprofiled?

2 times, if the chipping is minimal. The damage must not exceed 0.7m. If it's between 0.4mm and 0.7mm, it can be reprofiled but you lose 1 service. If damage is less than 0.4mm, we can resharpened and still have another service possibility.

### How is the constant diameter and profile position maintained with diamond knives after sharpening?

Material is removed from the bottom of the alignment holes equal the removal from the profile. The knives position to the hole bottom.

### How is a resharpened diamond knife balanced to match the other knives?

After reprofiling, a diamond Next G knife is rebalanced to match the nominal weight of the knife number. We can increase the weight by adding a copper plug in the knife and reduce the weight by removing carbide on the bottom edge on the knife.

### Are carbide & diamond knives the same thickness?

Yes, carbide and diamond knives are both 2mm thick at the clamping area. Diamond knives are 3mm thick at the edge.

### Can new and resharpened knives be used together?

New and resharpened diamond knives can be used together because they are reprofiled with matching diameters and rebalanced to original weight. New and resharpened carbide knives cannot be mixed because they are sharpened on the face, so diameters will not match and the balance will be different. Use carbide knives in sets as returned from service.

### What parts need to be replaced in a preventive maintenance program?

Screws, clamps, springs, and knives must be replaced if you see any wear, damage or deformation. However, the body is designed to last years as it is manufactured with a special process to prevent wear.

### Can the springs on the back clamp be replaced?

You can replace the springs in back clamps if you accidentally damage it or the spring action is not working properly. Order the available "Spring replacement kit".

### Can carbide and diamond knives be sharpened at all NG service centers?

Service is performed only at the service centers that have received the proper instructions and training.

### What size is the Allen wrench for the rear screw?

M8

### What if a Next G had is crashed in a machine?

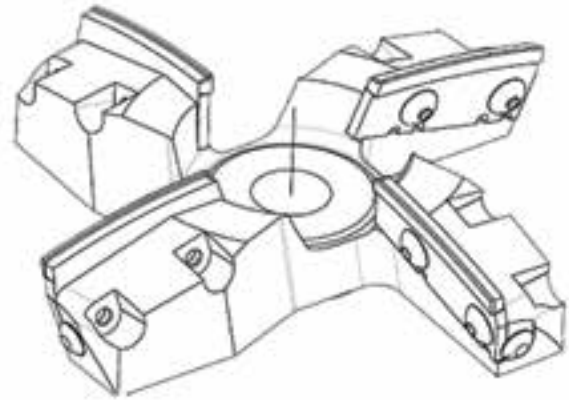
DO NOT use any longer. Return the tool to your NAPGLADU representative for evaluation, repair or replacement. User safety is our highest concern.

# NEXT G<sup>+</sup> Series

The original Next G Series provides great advantages such as the 1 screw automatic clamping system and a greater number of wings. The new Next G Plus series of tools presents the same advantages as the Next G Series with Back-Clamps. Limitations exist with the Next G Series (max. cutting depth or inside multi-profile router bit), but the Next G Plus Series does not have these limitations.

Both Series together can now cover a wide range of tools and wood profiles.

Here's a comparison table of both system's features.



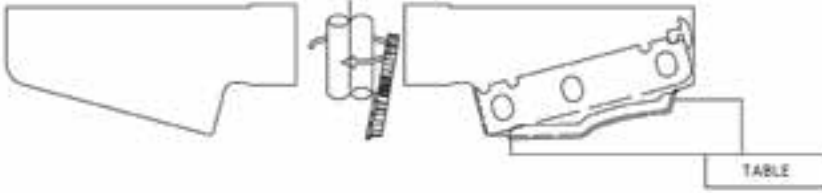
Feature	Next G Series	Next G Plus Series
Constant Knives position after Resharpener*	YES	YES
Carbide or Diamond Knives on the same body	YES	YES
Resharpenable*	2 times with constant weight	2 times with constant weight
Knives Thickness	2mm Knives	3mm Knives
Multi-Profiler	With Back-Clamps	No Back-Plate
	(max cutting depth = 28mm)	(max cutting projection = 8mm)
Knives' Width	30mm, 40mm & 50mm	20mm, 30mm, 40mm, 50mm & 60mm
Easy Clamping, Less parts	1 screw, 1 back-clamp	1, 2 or 3 screws
	automatic knives' position	screw on face, manually located
Number of wings	Up to 10 seats	Up to 4 seats
	(with 185mm body)	

\*Only Diamond Knives are resharpenable with Constant Edge Position. Carbide Knives can be resharpened on the face only.

# NEXT G+ Series Technical Drawings

A

**Raised Panel Cutter Head**  
(with 60mm & 40mm knives)



B

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**Double Raised Panel Cutter Head**  
(with 50mm & 20mm knives)

F

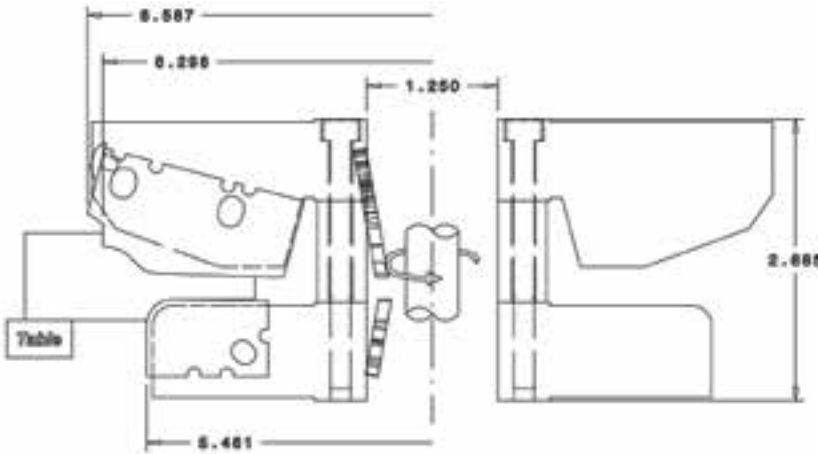
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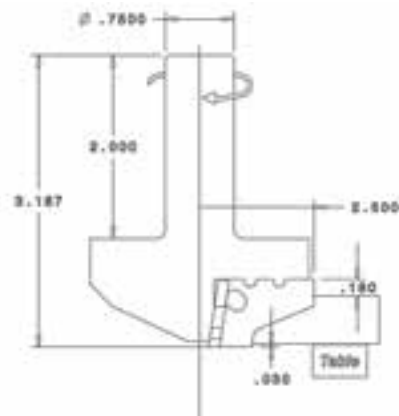
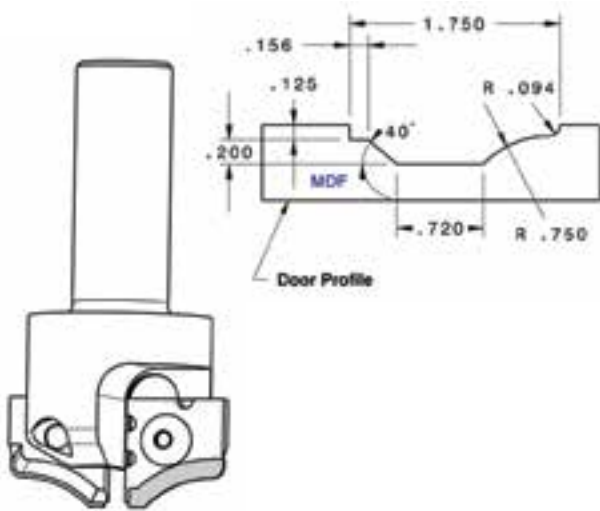
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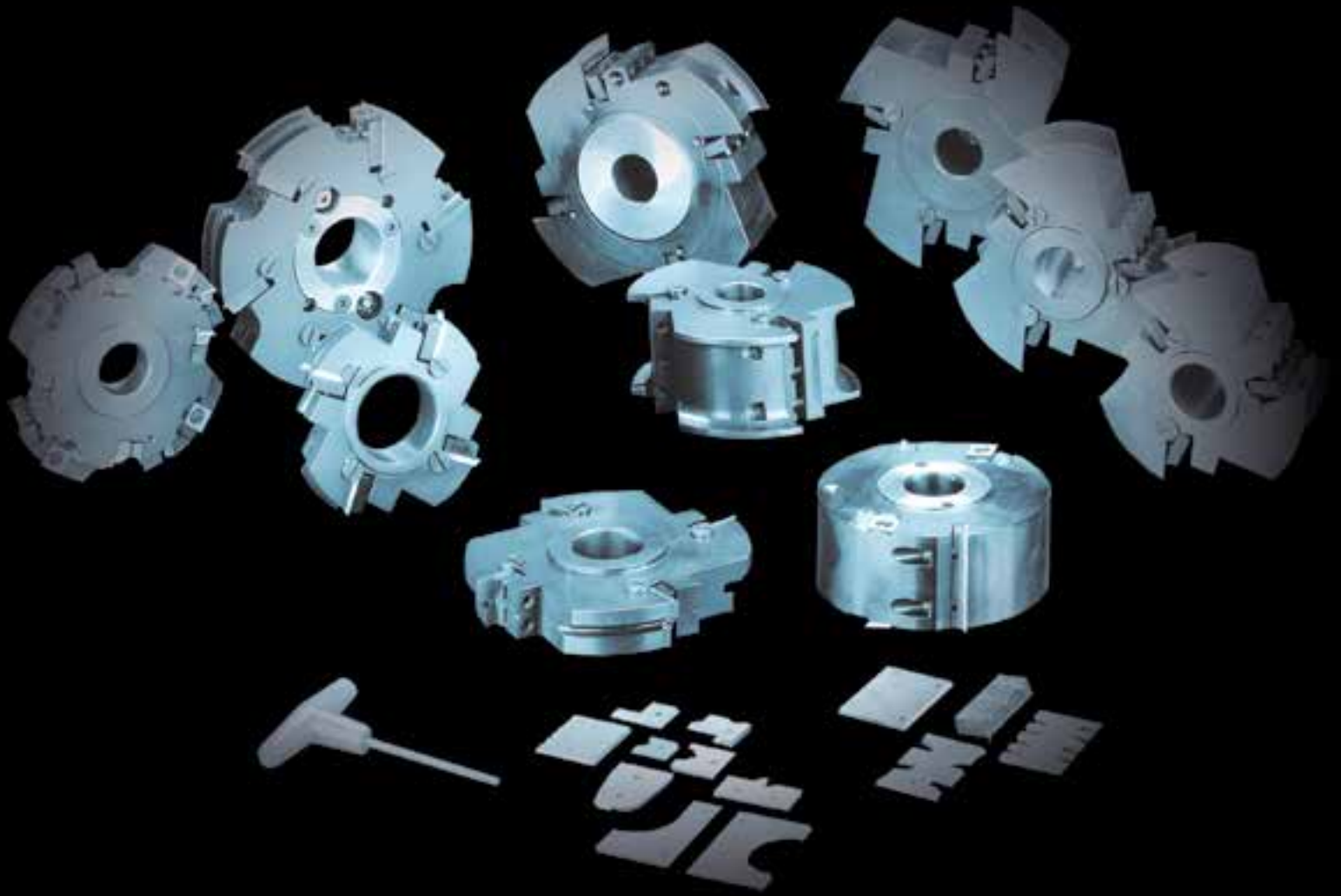
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**Inside Profile Router Bit**

**Outside Profile Router Bit**





# Dedicated and Universal Insert Heads

Delivering Productivity

# Dedicated Face-Mounted Insert Heads

A

B

C

D



We provide engineering/design services at no additional charge. Contact your NAPGLADU representative for more information.

E

## For Use on Decorative Patterns Only

Inserts are not included. Please see Standard and Profiled Carbide Insert section of this catalog for Inserts.

F

For information on surfacing heads that use turn-over knives, or profiling units using standard ICK knives please contact your NAPGLADU representative.

G



H

## Diameter Range: 5" - 5.999"

Cutting Width	3 Wing	4 Wing
35mm - 40mm		
50mm - 60mm		
80mm		

I

J

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## Diameter Range: 6" - 7.999"

Cutting Width	3 Wing	4 Wing
35mm - 40mm		
50mm - 60mm		
80mm		

## Diameter Range: 8" - 10"

Cutting Width	3 Wing	4 Wing
35mm - 40mm		
50mm - 60mm		
80mm		

## Insert Sizes and Profile Depth

Width	Height	Thick	Max. Depth
35	25.4	2.6	.433"
35	30.4	2.6	.562"
35	35.4	2.6	.590"
35	40.4	2.6	.787"
40	25.4	2.6	.433"
40	30.4	2.6	.562"
40	35.4	2.6	.590"
40	40.4	2.6	.787"
50	25.4	2.7	.433"
50	30.4	2.7	.562"
50	35.4	2.7	.590"
50	40.4	2.7	.787"
60	25.4	2.7	.433"
60	30.4	2.7	.562"
60	35.4	2.7	.590"
60	40.4	2.7	.787"
80	30.4	2.7	.562"
80	40.4	2.7	.787"

# Options – Dedicated Face-Mounted Insert Heads

## Optional Items

We offer a wide variety of optional features to provide the best possible cutting tool for your needs. Please contact your NAPGLADU representative for additional information on these options.

Options Include: Hubs, Trepan, Mounting Holes, Bores over 2.125 and Sleeve Bores.

Optional Item	Notes / Reference Information
Assembly	
Aluminum Body	
Bevel	
Alternate Bevel	
Shear	
Alternate Shear	
Special Balancing G2.5	
Bearing	
Bearing Case	
Solid Carbide Body for Router Bit	
Hydro Bore	
Chip Breaker	
Fit TurboSand	
Grease Fittings	
Kerf-O-Matic	
Key Ways	
Angled Seats	
Spacers	
S-System	
HSK-63 Shank	
Tapered Shank	
Screwed Shank	

No. Spurs per Piece	Tongue & Groove	Finger joints inserts
2 wings	3 wings	2 wings
3 wings	4 wings	3 wings
4 wings	6 wings	4 wings
6 wings	8 wings	6 wings
8 wings	10 wings	8 wings
10 wings	12 wings	10 wings
12 wings	14 wings	12 wings
14 wings	16 wings	14 wings









# Carbide Profiled Insert Router Bits

A

## Applications

- Designed for use on CNC router machines
- Can also be used on stationary overhead routers
- Use with mechanical feed operations
- To produce profiles that have a large depth of cut
- For cutting profiled grooves, veining, etc

B

C

D

## Technical Information

- Shank style cutter body design utilizes a double edge custom profiled carbide insert
- Cutter body provides profile zone support for various profiles utilizing a single body
- Comes with cutter body, screws and torx wrench
- Manufactured in right-hand rotation
- Maximum RPM = 24,000

E

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- Produce numerous profiles by simply changing the insert
- Extended tool life over brazed tooling due to insert accuracy and superior carbide grades
- Produces a constant cutting circle so setup and machine adjustments are reduced to a minimum
- Lower tooling costs due to decreased down time required for tooling changes

I

## Standard Insert Head Sizes

When ordering, first choose the shank diameter and number of wings desired from the table below. Note the cutting widths available. Please contact your NAPGLADU representative to place your order, or for assistance.

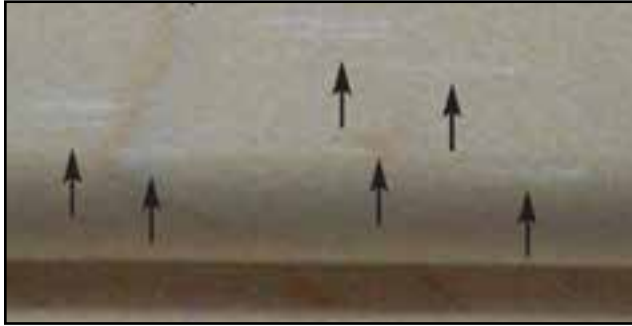
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Shank Diameter	No. Wings Available	Standard Cutting Widths Available (mm)
0.98"	2 wings	15, 20, 25, 30, 35, 40, 45, 50, 55, 60, 65, 70, 75
1.18"	2 wings	15, 20, 25, 30, 35, 40, 45, 50, 55, 60, 65, 70, 75
1.38"	2 wings	15, 20, 25, 30, 35, 40, 45, 50, 55, 60, 65, 70, 75
1.57"	2 wings	15, 20, 25, 30, 35, 40, 45, 50, 55, 60, 65, 70, 75
1.77"	2 wings	15, 20, 25, 30, 35, 40, 45, 50, 55, 60, 65, 70, 75
1.97"	2 wings	15, 20, 25, 30, 35, 40, 45, 50, 55, 60, 65, 70, 75
2.17"	2 wings	15, 20, 25, 30, 35, 40, 45, 50, 55, 60, 65, 70, 75
2.36"	2 wings	15, 20, 25, 30, 35, 40, 45, 50, 55, 60, 65, 70, 75
2.56"	2 wings	15, 20, 25, 30, 35, 40, 45, 50, 55, 60, 65, 70, 75
2.76"	2 wings	15, 20, 25, 30, 35, 40, 45, 50, 55, 60, 65, 70, 75
2.95"	2 or 3 wings	15, 20, 25, 30, 35, 40, 45, 50, 55, 60, 65, 70, 75
3.15"	2 or 3 wings	15, 20, 25, 30, 35, 40, 45, 50, 55, 60, 65, 70, 75
3.35"	2, 3, or 4 wings	15, 20, 25, 30, 35, 40, 45, 50, 55, 60, 65, 70, 75
3.54"	2, 3, or 4 wings	15, 20, 25, 30, 35, 40, 45, 50, 55, 60, 65, 70, 75
3.74"	2, 3, or 4 wings	15, 20, 25, 30, 35, 40, 45, 50, 55, 60, 65, 70, 75
3.94"	2, 3, or 4 wings	15, 20, 25, 30, 35, 40, 45, 50, 55, 60, 65, 70, 75

# Vanish Insert Head – Eliminate Chip Marks

## Vanish Head Prevents Chip Marks



The Vanish insert head is a great choice for high quality cabinet or moulding manufacturers who are trying to eliminate chip marks that typically occur on surfaces machined from the top spindle on the moulder.

Chip marks on the finished surface of the wood (see arrows in photo) are caused by chips that become temporarily trapped between the knife edge and the cutting surface.



The Vanish insert head is an effective way to prevent unsightly chip marks on high quality mouldings.

## Vanish Insert Head Sizes

When ordering, first choose the head diameter and number of wings desired from the table below. Note the cutting widths available. Please contact your NAPGLADU representative to place your order, or for assistance.

Head Diameter	No. Wings Available	Standard Cutting Widths Available (mm)
6"	2, 3, 4, 6	40, 50, 60, 70, 80, 90
7"	2, 3, 4, 6, 8	40, 50, 60, 70, 80, 90
8"	2, 3, 4, 6, 8, 10	40, 50, 60, 70, 80, 90
9"	2, 3, 4, 6, 8, 10, 12	40, 50, 60, 70, 80, 90
10"	2, 3, 4, 6, 8, 10, 12, 14	40, 50, 60, 70, 80, 90

NOTE: Vanish heads are manufactured from high-quality aluminum for light weight and reduced spindle load.

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# The Stabilizer – Sand Free, SF Series

## A The Stabilizer for Raised Panel Doors

B Use The Stabilizer to reduce scrap rates caused by chatter marks and/or mis-matched corners when machining raised panel doors.

C The Stabilizer provides a simple and effective way to prevent the panel from vibrating, which can cause chatter marks. It will also prevent the panel from deflecting under cutting pressures, which causes mis-matched corners.

E Contact your NAPGLADU representative to order.

F



Improve finish quality with The Stabilizer.

G

## Sand-Free Tooling, SF Series

H If you are trying to reduce the manual sanding performed in your shop, you should try our Sand Free tools. Our SF series tools reduce manual sanding by as much as 70%, quickly paying for themselves in time saved and increased productivity.

J SF Series tools work best on solid wood cabinets, panel processing, or similar operations. Use SF Series tools as a finishing pass that happens after your panel is pre-cut. You will notice improved consistency and quality in your finishing operations and reduce labor costs by automating your sanding operation.

K

Contact your NAPGLADU representative to order.



SF Series tools speed up sanding operations.

# Servicing Supplies and Replacement Parts

## Service Items and Cleaning Kit

Cleaning is the easiest way to prevent premature failure of insert tools. Dirt, chips, or other foreign objects can cause tools to wear out quicker and cause poor cutting performance. For best value we recommend purchasing No. NP271 Complete Cleaning Kit and replenishing kit items as they are depleted.

No. NP271 includes: 1 - NP276 1 qt. Wonder Wipe, 5 - NP286 Cotton Cloths, 1 - NP291 3/8" Diameter Nylon Brush, 1 - NP296 Brass Brush, 1 - NP311 Nylon Brush, and 1 - NP316 De Aqua Lube 18 oz.

If you don't see the service items you need in the catalog contact your NAPGLADU representative for a source.

Part No.	Description
NP271	Complete Cleaning Kit
NP276	1 qt. Wonder Wipe & MSDS
NP281	Spray Head For Wonder Wipe
NP286	Cotton Cloth
NP291	3/8" Diameter Brush
NP296	7-3/4" Brass Brush
NP311	7-3/4" Nylon Brush
NP316	De Aqua Lube 18 oz. Aerosol
NP552	High Pressure Grease Gun
NP553	High Pressure Hose
NP554	Hydraulic Connector
NP555	Grease Cartridge

## Insert Head Replacement Parts



INS-0011



INS-0013



INS-0016



INS-0018



INS-0026



INS-0012



INS-0015



INS-0017



INS-0019



146-1503



NP556

Part No.	Description	Application
INS-0011	8mm double-acting screw, RH/LH	Use with INS-0018
INS-0013	5mm double-acting screw, RH/LH	
INS-0016	6mm-1.00 16mm screw, Lg. Full Dog set	Wedge style
INS-0018	Gibbs style, round, 8mm-1.25 thd. LH	Use with INS-0011
INS-0026	Gibbs style, round, 6mm-1.0 thd. LH	Use with INS-0012
INS-0012	6mm double-acting screw, RH/LH	Use with INS-0026
INS-0015	8mm-1.25 20mm screw, Lg. Swivel Set	Wedge Style
INS-0017	5mm-8 16mm screw, Lg. Full Dog Set	
INS-0019	5mm-7 Flat Hd. / T15 Torx screw (previously slotted)	For use with spurs
NP556	4mm SW4 DIN 911 clamping screw wrench	Use with 93109
146-1503	5mm-7 Flat Hd. / T20 Torx screw (previously slotted)	For use with spurs

# Insert Head Cleaning Procedures

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For best results please follow the cleaning and assembly procedure below whenever tool changes are performed. Contact your sales representative if you have any questions about cleaning your removable insert cutting tools, call (800) 634-8665.

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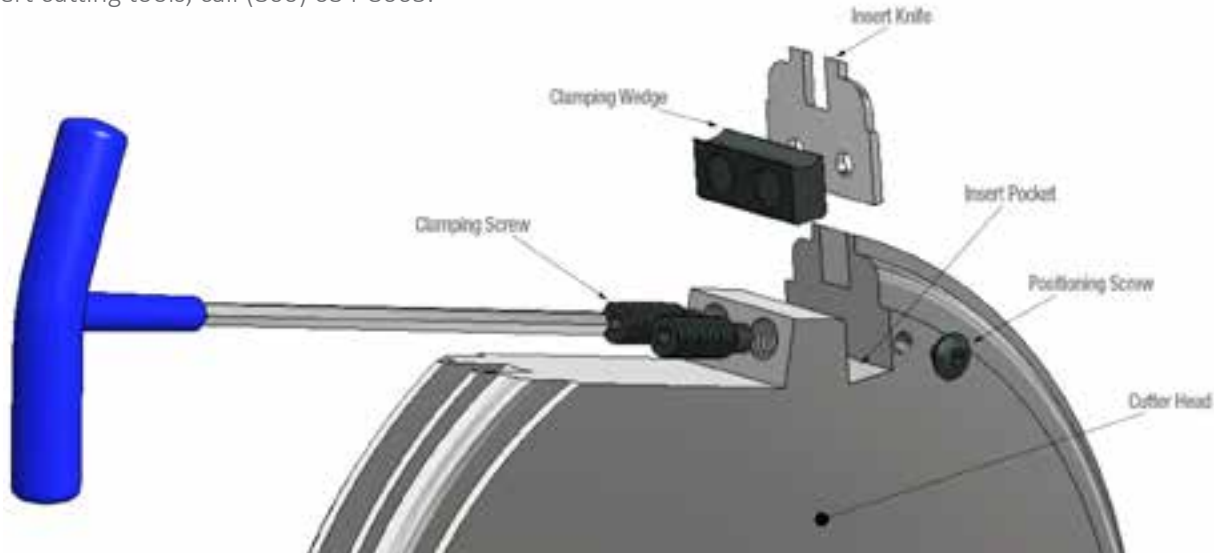
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## Disassembly

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1. Before disassembling the tool, use low pressure compressed air to remove any loose saw dust. Wipe the head clean with a shop rag to remove any remaining dust. Once the head is clean, unscrew the clamping screws, and remove the clamping wedge and insert knife. **Do not remove the positioning screw.** It is preset at the factory. Removal or adjustment of the positioning screw may alter the axial alignment of the insert.
2. Visually inspect the entire cutting tool, including the bore for any defects or burrs. Never use a cutter body that is cracked or has components that are damaged or excessively worn.

Pay particular attention to the clamping screws, wedge, insert knife, insert pocket, and the positioning screw. All components must be exceptionally clean and free of any burrs and debris. Even the smallest amount of debris on these surfaces can cause excessive runout.

3. Use a cleaning solvent such as our Wonder Wipe, kerosene, lacquer thinner or oven cleaner to remove any resin. Soak the affected areas for a few minutes prior to cleaning. Areas with excessive

For cleaning Hydro-Grip Heads use the Complete Cleaning Kit (Part No. NP271), which contains everything you need; including cleaner and brushes specifically designed for Hydro-Grip mounting systems.

build-up may need to be scrubbed with a brass brush. If your head includes a Hydro-Grip mounting system do not soak the unit in any solution, or damage to the O-ring may occur. **Never use caustic cleaning agents on cutter heads made of aluminum.**

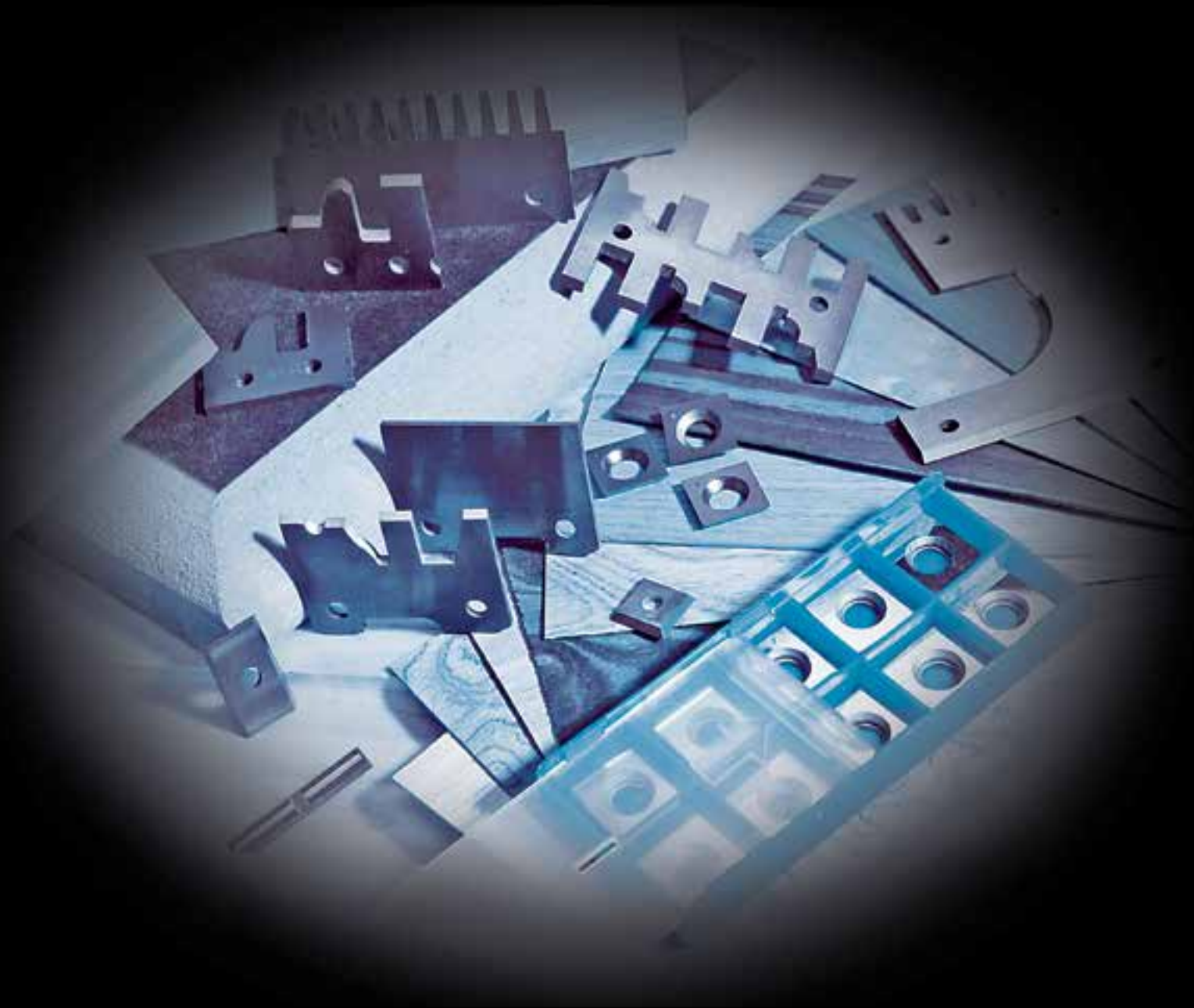
4. Once the parts are clean and have passed inspection, wipe all components with a dry type rust inhibitor. If you use a combination lubricant and rust inhibitor, such as Sandaro Top Cote or WD-40, be sure to wipe off excess lubricant with a clean cloth.

## Reassembly

1. Install the protruding pins of the clamping wedge into the holes of the insert knife, then place the assembly into the insert pocket. Ensure that the insert knife assembly sits flush with the bottom the insert pocket, and flush against the back of the pocket.

After installing all insert knives, fully tighten the clamping screws to the recommended torque. Torque values are printed on the parts list that came with your tool. Call your representative if you need any further assistance.





# Standard and Profiled Carbide Inserts

Delivering Productivity



# Important Ordering Information

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## Standard Turnover Knives (Pages xx)

1. Identify the insert you need by browsing through the section of the catalog that contains your style of inserts and locate the drawing that matches your insert. Call your NAPGLADU representative if you don't see what you need. We may still have it in stock, or can get it for you.
2. Position the insert over the drawing and verify that the holes and overall dimensions align. All drawings are drawn to scale (1:1) but we recommend you also measure your insert to ensure that the size matches our published specifications for width, height, and thickness (W x H x T) before ordering.
3. Once you have verified that the overall dimensions and hole location(s) are correct, you must identify the type of material that you are going to apply to the insert.

Example 50x12x1.5 Insert: This insert has two Grades.

- *TJ126 GP Grade (general purpose)*
- *TJ128 MM (man-made material)*

Most inserts in the woodworking industry are general purpose (GP). We suggested that you try this grade first unless you know you need a higher-performing insert. If you are machining man-made material such as MDF, particleboard, etc. then the MM material grade will perform better than the general purpose grade.

4. Once you have found the insert and grade you need, find the "Part No." for that item. This is the number you will use for placing an order or requesting a quote from your representative.
5. Note the "Quantity" information. Most Standard Turnover Inserts are sold in boxes of 10 however we do offer some that are sold individually or in different quantities. Contact your NAPGLADU representative to speak about volume pricing.

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## Profiled Inserts (Pages xx)

You must supply either a wood sample, mechanical drawing or an existing profiled insert that represents the exact profile the new inserts must be capable of producing.

If you are duplicating an existing pattern from an insert, you must be sure that the insert has not been used or sharpened so that the edge is true to the profile required.

1. Locate the drawing in the following pages that matches the inserts used in an existing head. All drawings used in this section are exact size or 1:1. You can locate the exact insert required by placing the existing insert directly on these drawings in order to select the correct one. Be sure to look at the side view of the drawings in order to determine if the insert has a beveled top and bottom, square top with a beveled bottom or square top and bottom.
2. Determine the carbide grade required for the given application and material/species that you are machining. Not all inserts are available in different carbide grades. If you require a specific grade that is not listed in this catalog, please contact your nearest NAPGLADU Sales Representative.
3. When making new profiles for existing cutter heads, you must supply the following information in order to correctly grind the clearances required for optimum performance.

- *Hook Angle of the cutter head*
- *Large or small diameter of the cutter head*
- *Manufacturer of the cutter head*

## Existing Inserts

If you are ordering an insert that NAPGLADU did not manufacture then we need the following in order to create an exact duplicate:

- *An unused "New" insert sample from your inventory that is exactly what you want duplicated.*
- *Send this insert in with your order or contact a NAPGLADU Sales Representative to make arrangements for a pickup.*

# Important Ordering Information

## New Inserts for Universal Heads

When ordering inserts with a “New” profile for a head NAP Gladu *did not manufacture* then we need the following:

- Head Diameter
- Hook Angle of the head
- Manufacturer of the cutter head
- Wood Sample or Drawing of the new profile
- A sample Backing Plate that is used in the head.

## New Inserts for Dedicated Heads

When ordering inserts with a “New” profile for a head NAP Gladu *did not manufacture* then we need the following:

- An existing insert with the original pattern
- Head Diameter
- Hook Angle of the head
- Manufacturer of the cutter head
- Wood Sample or Drawing of the new profile
- **WARNING!** Changes to the profile can only be small due to the steel body interference.

## Carbide Grades

Select the carbide grade that best suits the material you are cutting if available for the insert listed.

**General Purpose:** Used for man-made material and natural woods. Most common grade in the industry.

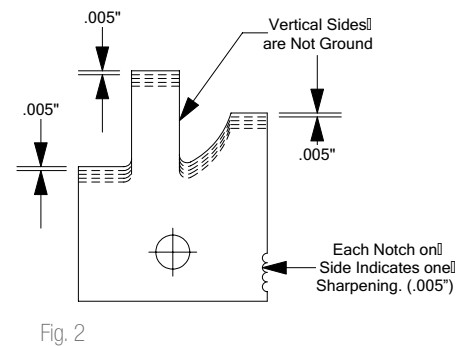
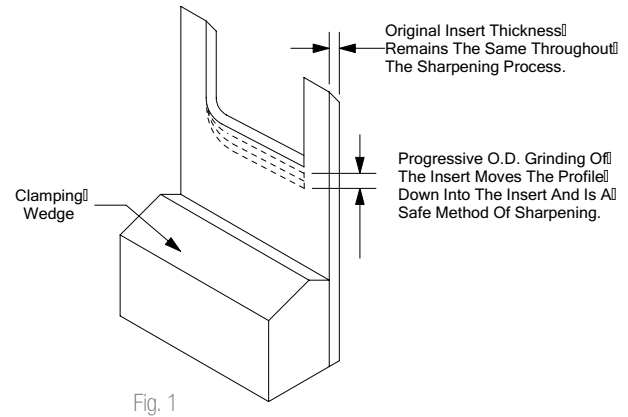
**Natural Wood:** All natural wood applications including both hard and softwoods

**HI Natural Wood:** High impact applications such as knots found in natural wood.

**Man-Made Material:** Composite materials such as MDF, particle board, plywood, etc.

## Insert Coatings

All inserts can be coated with various PVD & CVD coatings for specific applications – Contact your NAP GLADU representative for pricing.



## Sharpening Inserts

1. NAP Gladu will sharpen inserts by moving the profile further into the insert. (Fig. 1)
2. Mating inserts will be sharpened on the outside periphery only and all vertical sides will be left untouched. (Fig. 2)
3. All sharpened inserts will be identified by a notch located on the side of the insert. This notch indicates that the insert was sharpened. Each time an insert is sent in for sharpening, another notch is ground into the insert. Each notch indicates that .005" has been removed from the original profile configuration.

# Standard Turnover Carbide Knives

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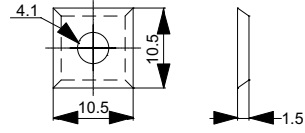
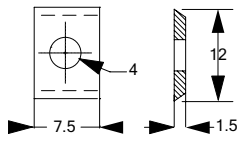
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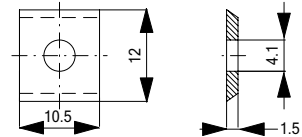
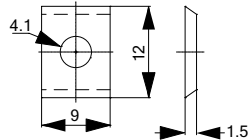
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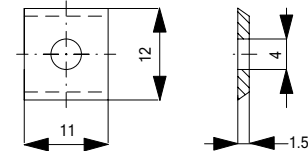
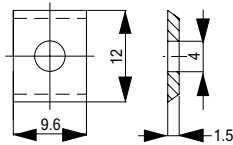
Part No.	W x H x T	Grade	Qty.
TJ111	7.5x12x1.5	GP	10
TJ518	7.5x12x1.5	MM-MDF	10

Part No.	W x H x T	Grade	Qty.
TJ528	10.5x10.5x1.5	GP	10



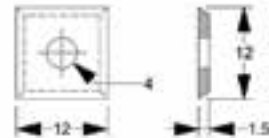
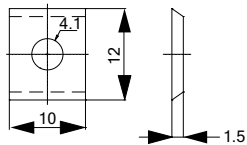
Part No.	W x H x T	Grade	Qty.
TJ112	9x12x1.5	GP	10

Part No.	W x H x T	Grade	Qty.
TJ473	10.5x12x1.5	GP	10



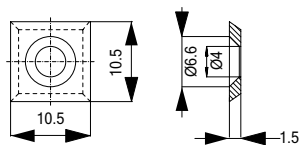
Part No.	W x H x T	Grade	Qty.
TJ472	9.6x12x1.5	GP	10

Part No.	W x H x T	Grade	Qty.
TJ522	11x12x1.5	GP	10



Part No.	W x H x T	Grade	Qty.
TJ113	10x12x1.5	GP	10

Part No.	W x H x T	Grade	Qty.
TJ156	12x12x1.5	GP	10
TJ157	12x12x1.5	MM-MDF	10
TJ484	12x12x1.5	MM-MDF	10

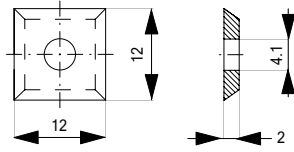


Part No.	W x H x T	Grade	Qty.
TJ489	10.5x10.5x1.5	GP	10

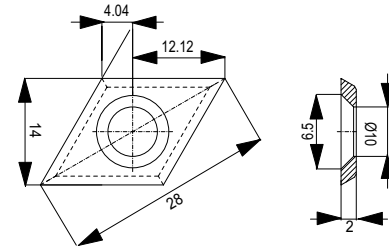
**NOTE:** Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

**CARBIDE GRADE:** GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

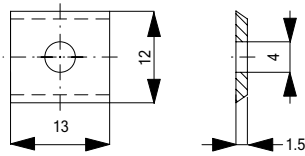
# Standard Turnover Carbide Knives



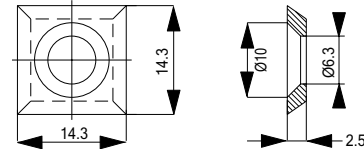
Part No.	W x H x T	Grade	Qty.
TJ527	12x12x2	MM-HDF	10



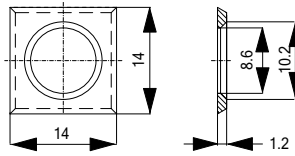
Part No.	W x H x T	Grade	Qty.
TJ499	14x14x2	GP	10



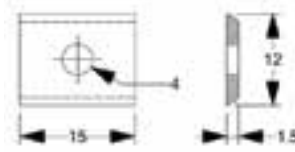
Part No.	W x H x T	Grade	Qty.
TJ471	13x12x1.5	GP	10
TJ539	13x12x1.5	MM-MDF	10



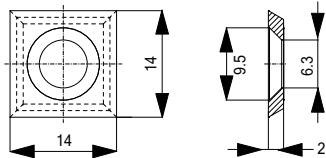
Part No.	W x H x T	Grade	Qty.
TJ487	14.3x14.3x2.5	NW	10



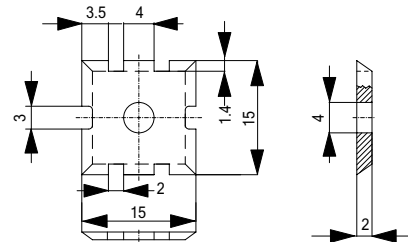
Part No.	W x H x T	Grade	Qty.
TJ490	14x14x1.2	GP	10



Part No.	W x H x T	Grade	Qty.
TJ114	15x12x1.5	GP	10
TJ519	15x12x1.5	MM-MDF	10



Part No.	W x H x T	Grade	Qty.
TJ486	14x14x2	MM-MDF	10
TJ488	14x14x2	NAW	10



Part No.	W x H x T	Grade	Qty.
TJ491	15x15x2	GP	10

NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Standard Turnover Carbide Knives

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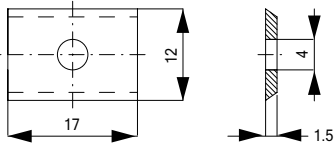
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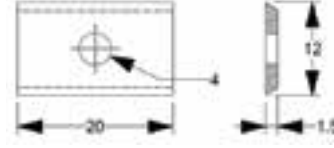
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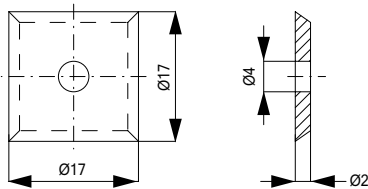
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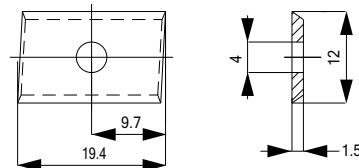
Part No.	W x H x T	Grade	Qty.
TJ474	17x12x1.5	GP	10



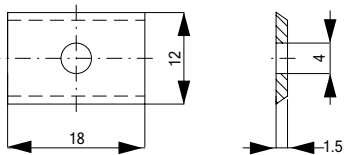
Part No.	W x H x T	Grade	Qty.
TJ116	20x12x1.5	NW	10
TJ117	20x12x1.5	GP	10
TJ118	20x12x1.5	MM-MDF	10
TJ470	20x12x1.5	MM-HDF	10



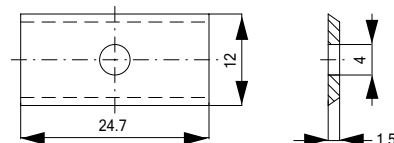
Part No.	W x H x T	Grade	Qty.
TJ485	17x17x2	GP	10



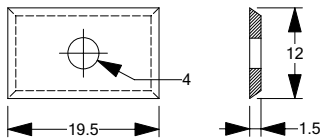
Part No.	W x H x T	Grade	Qty.
TJ540	19.4x12x1.5	GP	10



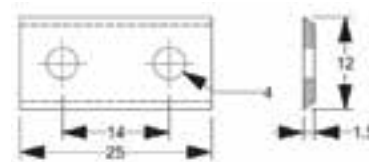
Part No.	W x H x T	Grade	Qty.
TJ523	18x12x1.5	GP	10



Part No.	W x H x T	Grade	Qty.
TJ475	24.7x12x1.5	GP	10



Part No.	W x H x T	Grade	Qty.
TJ115	19.5x12x1.5	GP	10

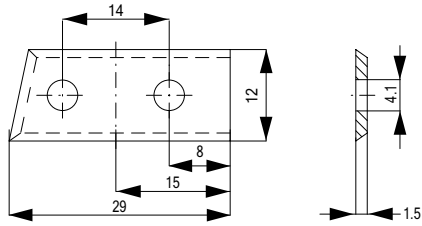


Part No.	W x H x T	Grade	Qty.
TJ122	25x12x1.5	GP	10

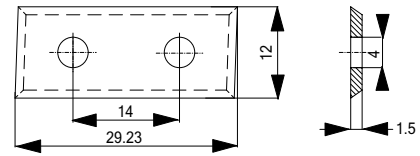
**NOTE:** Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

**CARBIDE GRADE:** GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

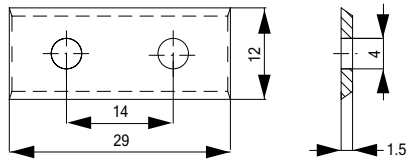
# Standard Turnover Carbide Knives



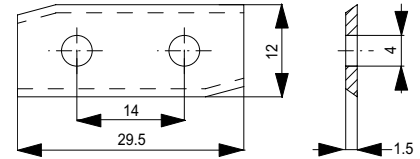
Part No.	W x H x T	Grade	Qty.
TJ538	29x12x1.5	MM-MDF	10



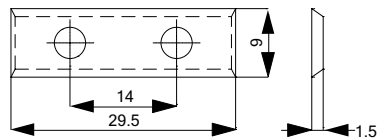
Part No.	W x H x T	Grade	Qty.
TJ501	29.23x12x1.5	MM-MDF	10



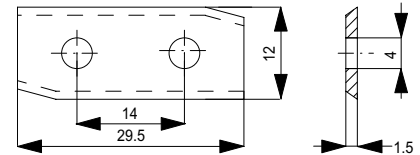
Part No.	W x H x T	Grade	Qty.
TJ529	29x12x1.5	GP	10



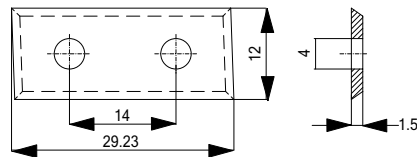
Part No.	W x H x T	Grade	Qty.
TJ481	29.5x12x1.5	MM-MDF	10



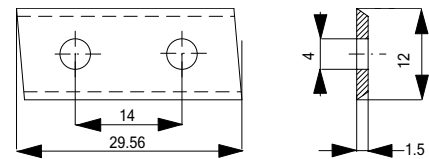
Part No.	W x H x T	Grade	Qty.
TJ498	29.5x9x1.5	GP	10



Part No.	W x H x T	Grade	Qty.
TJ482	29.5x12x1.5	MM-MDF	10



Part No.	W x H x T	Grade	Qty.
TJ500	29.23x12x1.5	MM-MDF	10



Part No.	W x H x T	Grade	Qty.
TJ524	29.56x12x1.5	MM-MDF	10

NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

- A
- B
- C
- D
- E
- F
- G
- H
- I
- J
- K

# Standard Turnover Carbide Knives

A

B

C

D

E

F

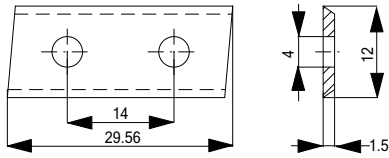
G

H

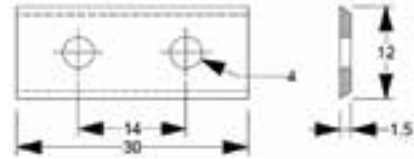
I

J

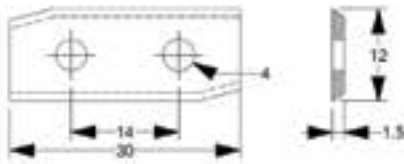
K



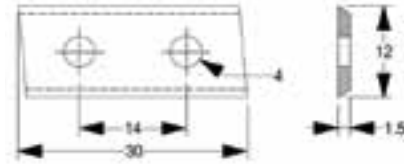
Part No.	W x H x T	Grade	Qty.
TJ525	29.56x12x1.5	MM-MDF	10



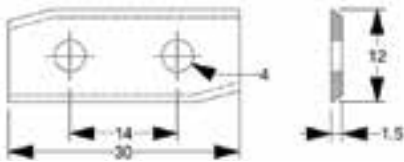
Part No.	W x H x T	Grade	Qty.
TJ119	30x12x1.5	GP	10
TJ121	30x12x1.5	MM-MDF	10
TJ476	30x12x1.5	MM-HDF	10



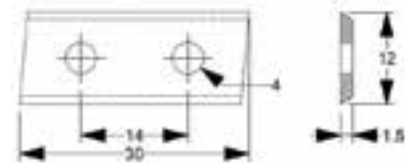
Part No.	W x H x T	Grade	Qty.
TJ144	30x12x1.5	GP	10



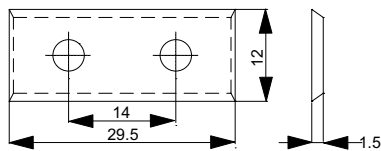
Part No.	W x H x T	Grade	Qty.
TJ149	30x12x1.5	GP	10



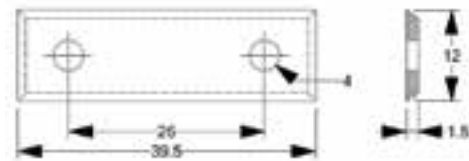
Part No.	W x H x T	Grade	Qty.
TJ147	30x12x1.5	GP	10



Part No.	W x H x T	Grade	Qty.
TJ153	30x12x1.5	GP	10



Part No.	W x H x T	Grade	Qty.
TJ384	29.5x12x1.5	GP	10
TJ493	29.5x12x1.5	MM-MDF	10
TJ492	29.5x12x1.5	MM-HDF	10



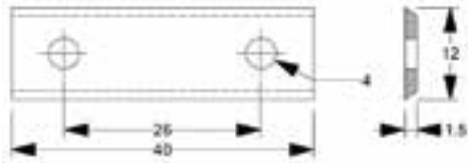
Part No.	W x H x T	Grade	Qty.
TJ124	39.5x12x1.5	GP	10

NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

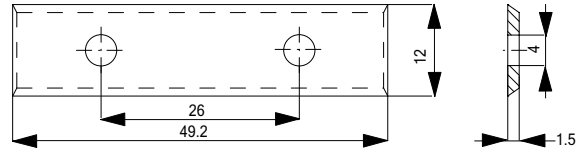
CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.



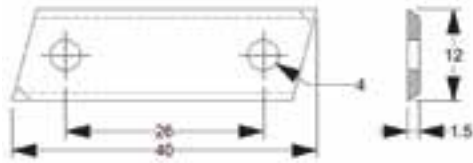
# Standard Turnover Carbide Knives



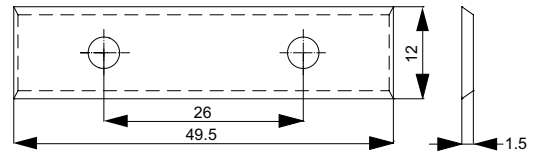
Part No.	W x H x T	Grade	Qty.
TJ123	40x12x1.5	GP	10
TJ478	40x12x1.5	MM-HDF	10



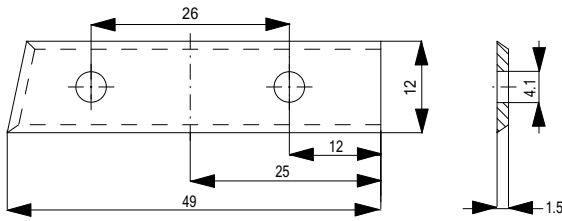
Part No.	W x H x T	Grade	Qty.
TJ496	49.2x12x1.5	MM-MDF	10



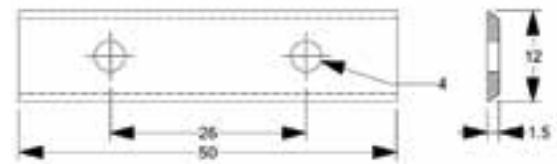
Part No.	W x H x T	Grade	Qty.
TJ125	40x12x1.5	GP	10



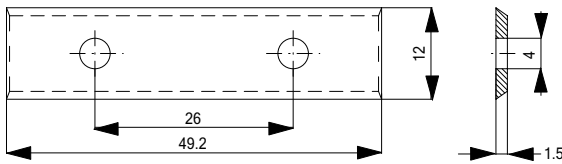
Part No.	W x H x T	Grade	Qty.
TJ497	49.5x12x1.5	GP	10



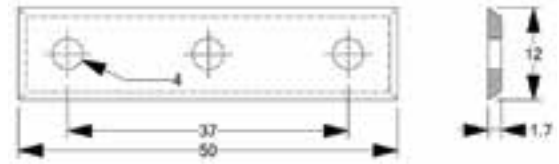
Part No.	W x H x T	Grade	Qty.
TJ532	49x12x1.5	MM-MDF	10



Part No.	W x H x T	Grade	Qty.
TJ126	50x12x1.5	GP	10
TJ128	50x12x1.5	MM-MDF	10
TJ477	50x12x1.5	MM-HDF	10



Part No.	W x H x T	Grade	Qty.
TJ495	49.2x12x1.5	MM-HDF	10



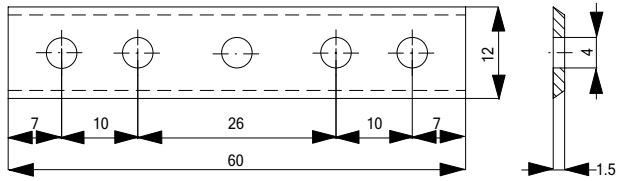
Part No.	W x H x T	Grade	Qty.
TJ129	50x12x1.7	GP	10
TJ514	50x12x1.7	MM-MDF	10

NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Standard Turnover Carbide Knives

A



B

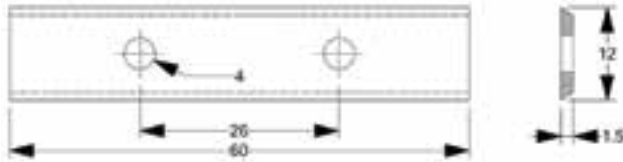
C

Part No.	W x H x T	Grade	Qty.
TJ512	60x12x1.5	GP	10

D

E

F



G

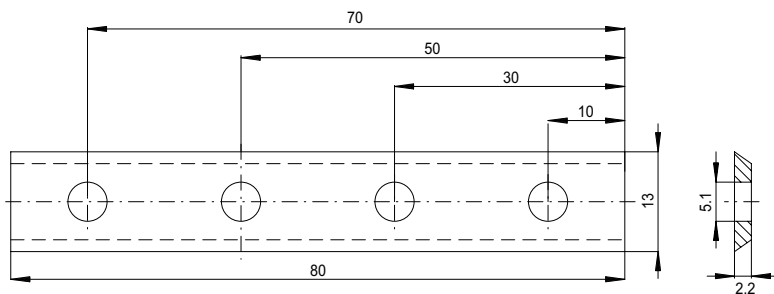
Part No.	W x H x T	Grade	Qty.
TJ132	60x12x1.5	GP	10
TJ479	60x12x1.5	MM-MDF	10

H

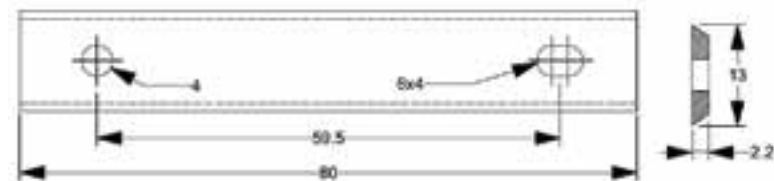
I

J

K



Part No.	W x H x T	Grade	Qty.
TJ537	80x13x2.2	MM-MDF	10



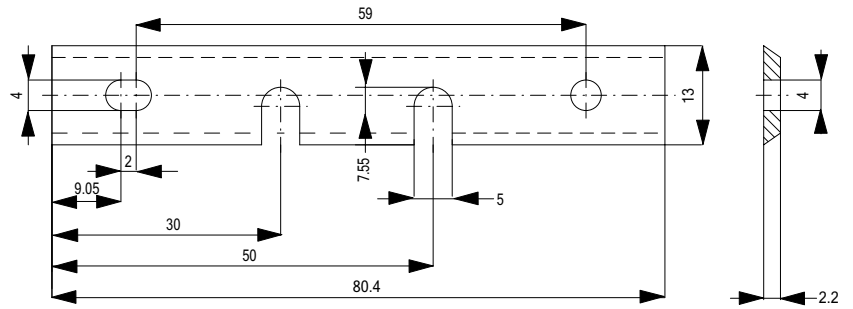
Part No.	W x H x T	Grade	Qty.
TJ135	80x13x2.2	GP	10

NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

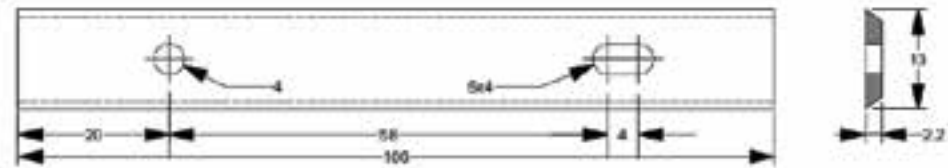
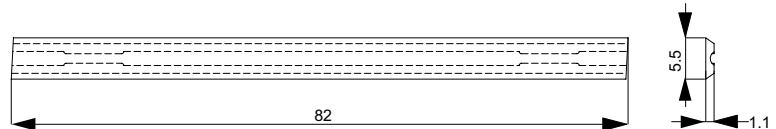
CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Standard Turnover Carbide Knives

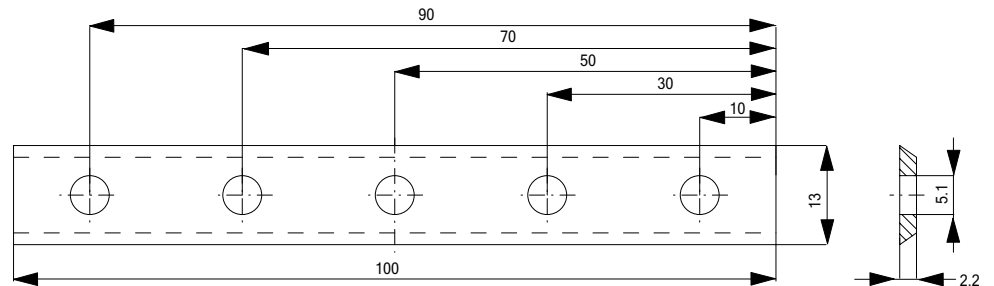
Part No.	W x H x T	Grade	Qty.
TJ483	80.4x13x2.2	GP	10



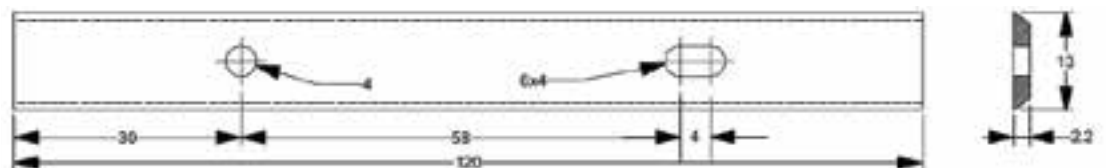
Part No.	W x H x T	Grade	Qty.
TJ517	82x5.5x1.1	NW	10



Part No.	W x H x T	Grade	Qty.
TJ138	100x13x2.2	GP	10



Part No.	W x H x T	Grade	Qty.
TJ530	100x13x2.2	MM-MDF	10
TJ541	100x13x2.2	GP	10



Part No.	W x H x T	Grade	Qty.
TJ141	120x13x2.2	GP	10

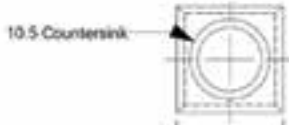
NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

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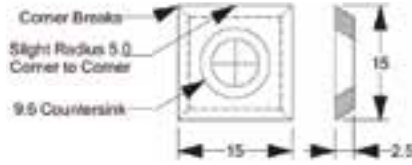
# Standard Carbide Knives for Spurs and Groovers

A

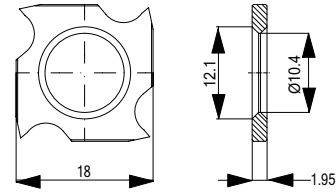


Part No.	W x H x T	Grade	Qty.
TJ159	14x14x1.2	GP	10

B

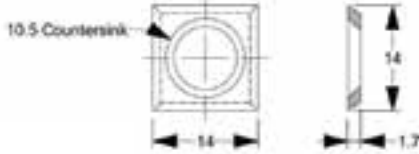


Part No.	W x H x T	Grade	Qty.
TJ175	15x15x2.5	GP	10



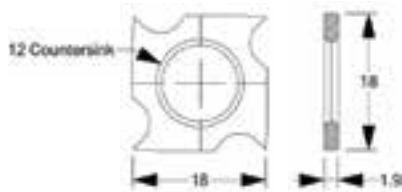
Part No.	W x H x T	Grade	Qty.
TJ509	18x18x1.95	NW	10

D

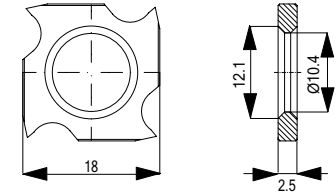


Part No.	W x H x T	Grade	Qty.
TJ162	14x14x1.7	GP	10

E



Part No.	W x H x T	Grade	Qty.
TJ174	18x18x1.95	GP	10

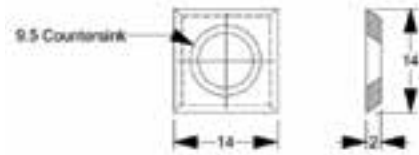


Part No.	W x H x T	Grade	Qty.
TJ507	18x18x2.5	NW	10

F

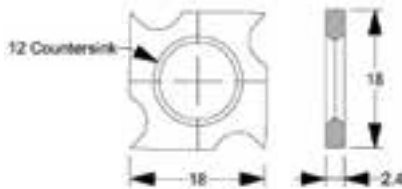
G

H

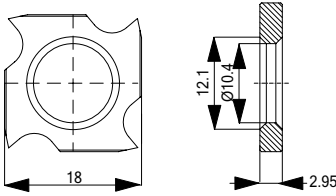


Part No.	W x H x T	Grade	Qty.
TJ168	14x14x2	GP	10

I



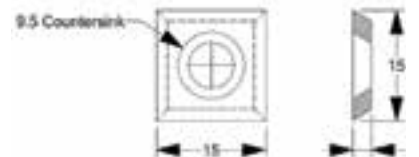
Part No.	W x H x T	Grade	Qty.
TJ177	18x18x2.45	GP	10



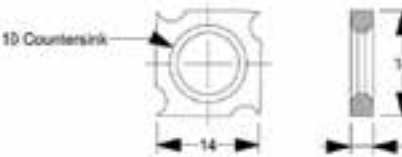
Part No.	W x H x T	Grade	Qty.
TJ508	18x18x2.95	NW	10

J

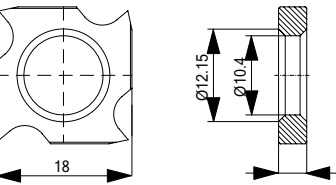
K



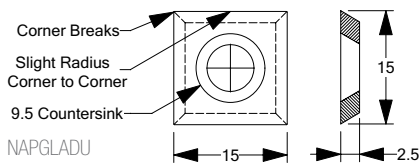
Part No.	W x H x T	Grade	Qty.
TJ165	14x14x2	NW	10



Part No.	W x H x T	Grade	Qty.
TJ171	14x14x3	GP	10



Part No.	W x H x T	Grade	Qty.
TJ510	18x18x3.7	NW	10

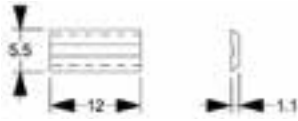


Part No.	W x H x T	Grade	Qty.
TJ173	15x15x2.5	GP	10
TJ520	15x15x2.5	NW	10
TJ533	15x15x2.5	MM	10
TJ180	15x15x2.5	VHI	10

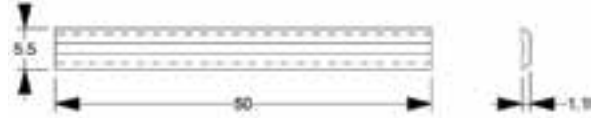
NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

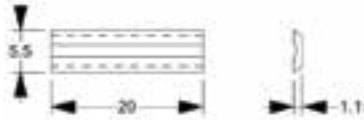
# Specialty Carbide Inserts for Router Bits



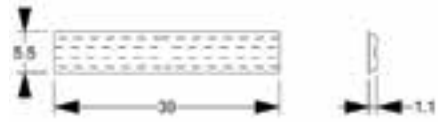
Part No.	W x H x T	Grade	Qty.
TJ179	12x5.5x1.1	GP	10



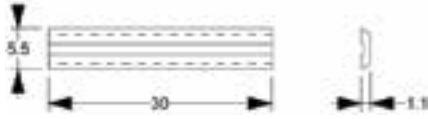
Part No.	W x H x T	Grade	Qty.
TJ192	50x5.5x1.1	GP	10



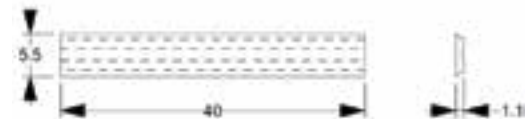
Part No.	W x H x T	Grade	Qty.
TJ183	20x5.5x1.1	GP	10



Part No.	W x H x T	Grade	Qty.
TJ198	30x5.5x1.1	GP	10



Part No.	W x H x T	Grade	Qty.
TJ186	30x5.5x1.1	GP	10
TJ188	30x5.5x1.1	MM	10



Part No.	W x H x T	Grade	Qty.
TJ211	40x5.5x1.1	GP	10



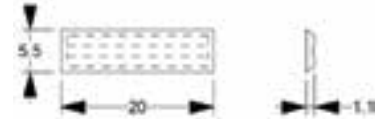
Part No.	W x H x T	Grade	Qty.
TJ189	40x5.5x1.1	GP	10



Part No.	W x H x T	Grade	Qty.
TJ214	50x5.5x1.1	GP	10



Part No.	W x H x T	Grade	Qty.
TJ195	20x5.5x1.1	GP	10



Part No.	W x H x T	Grade	Qty.
TJ217	20x5.5x1.1	GP	10

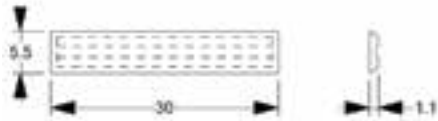
NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

- A
- B
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- D
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- F
- G
- H
- I
- J
- K

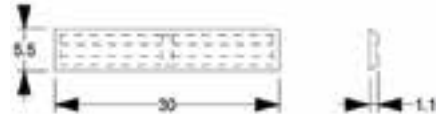
# Specialty Carbide Inserts for Router Bits

A



Part No.	W x H x T	Grade	Qty.
TJ219	30x5.5x1.1	GP	10

B

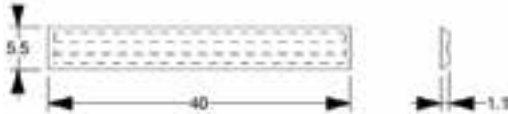


Part No.	W x H x T	Grade	Qty.
TJ235	30x5.5x1.1	GP	10

C

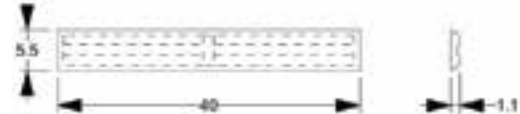
D

E



Part No.	W x H x T	Grade	Qty.
TJ223	40x5.5x1.1	GP	10

F



Part No.	W x H x T	Grade	Qty.
TJ238	40x5.5x1.1	GP	10

G

H

I

J

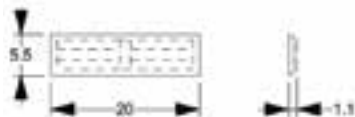


Part No.	W x H x T	Grade	Qty.
TJ226	50x5.5x1.1	GP	10

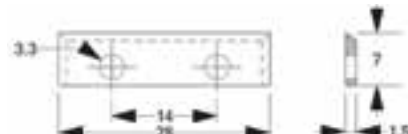


Part No.	W x H x T	Grade	Qty.
TJ241	50x5.5x1.1	GP	10

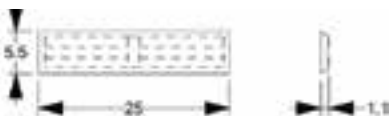
K



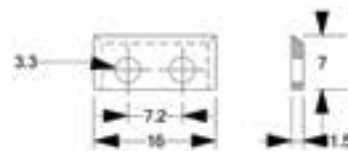
Part No.	W x H x T	Grade	Qty.
TJ229	20x5.5x1.1	GP	10



Part No.	W x H x T	Grade	Qty.
TJ381	28x7x1.5	GP	10



Part No.	W x H x T	Grade	Qty.
TJ232	25x5.5x1.1	GP	10

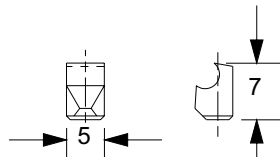


Part No.	W x H x T	Grade	Qty.
TJ389	16x7x1.5	GP	10

NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

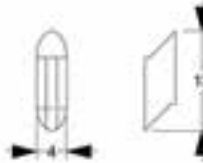
# Specialty Carbide Inserts for Router Bits



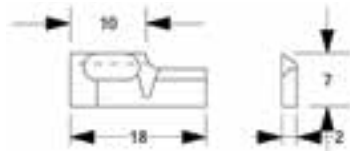
Part No.	W x H x T	Grade	Qty.
TJ374	5x7x5	GP	20



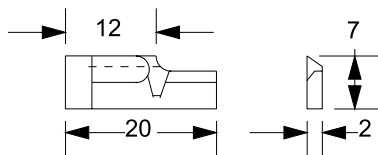
Part No.	W x H x T	Grade	Qty.
TJ379	5x6x5	GP	20



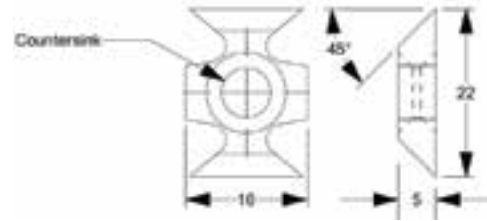
Part No.	W x H x T	Grade	Qty.
TJ372	4x13x4	GP	1



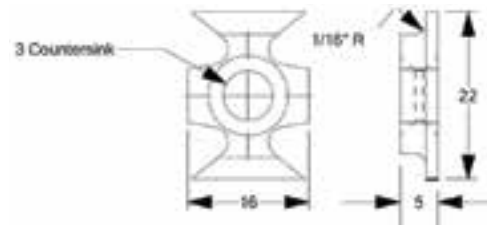
Part No.	W x H x T	Grade	Qty.
TJ383	18x7x2	GP	1



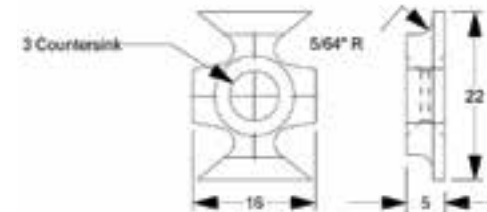
Part No.	W x H x T	Grade	Qty.
TJ377	20x7x2	GP	1



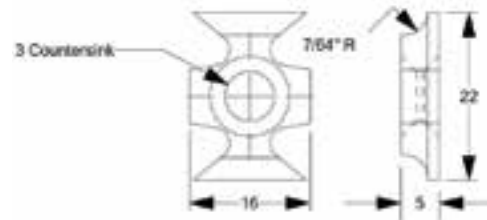
Part No.	W x H x T	Grade	Qty.
TJ353	16x22x5	GP	1



Part No.	W x H x T	Grade	Qty.
TJ356	16x22x5	GP	1



Part No.	W x H x T	Grade	Qty.
TJ359	16x22x5	GP	1



Part No.	W x H x T	Grade	Qty.
TJ362	16x22x5	GP	1

NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

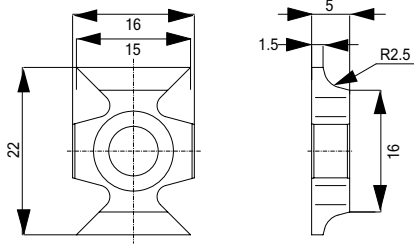
CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

- A
- B
- C
- D
- E
- F
- G
- H
- I
- J
- K



# Specialty Carbide Inserts for Router Bits

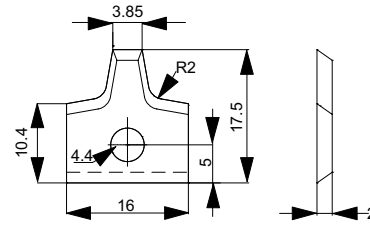
A



Part No.	W x H x T	Grade	Qty.
TJ504	16x22x5	NW	10

B

C

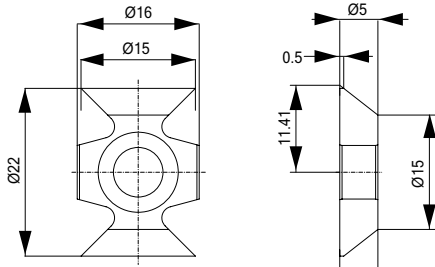


Part No.	W x H x T	Grade	Qty.
TJ502	16x17.5x2	GP	10

E

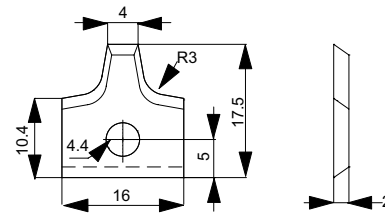
F

G



Part No.	W x H x T	Grade	Qty.
TJ505	16x22.03x5	NW	10

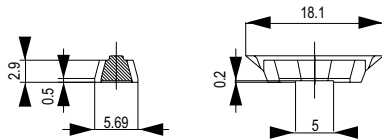
H



Part No.	W x H x T	Grade	Qty.
TJ503	16x17.5x2	GP	10

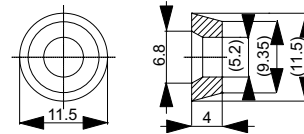
I

J



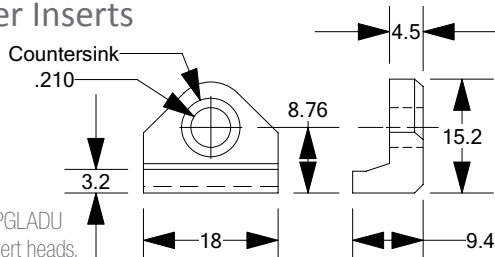
Part No.	W x H x T	Grade	Qty.
TJ515	18x5.69x3.5	NW	10

K



Part No.	W x H x T	Grade	Qty.
TJ506	11.5x11.5x4	MM-MDF	10

## Sidewinder Inserts



For use with NAPGLADU SIDEWINDER insert heads.

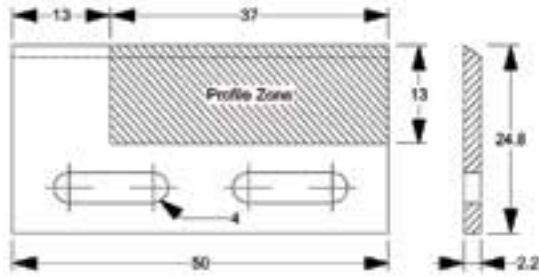
Part No.	Head Dia.	W x H x T	Grade	Qty.
TJ450R	102mm	16.8x15x9	NW	10
TJ456L	102mm	16.8x15x9	NW	10
TJ460R	127mm	16.8x15x9	NW	10
TJ466L	127mm	16.8x15x9	NW	10
TJ411R	139mm	16.8x15x9	NW	10
TJ416L	139mm	16.8x15x9	NW	10
TJ421R	152mm	16.8x15x9	NW	10
TJ426L	152mm	16.8x15x9	NW	10
TJ431R	165mm	16.8x15x9	NW	10
TJ436L	165mm	16.8x15x9	NW	10
TJ442R	197mm	16.8x15x9	NW	10
TJ446L	197mm	16.8x15x9	NW	10

Part No.	Head Dia.	W x H x T	Grade	Qty.
TJ550R	102mm	16.8x15x9	MM	10
TJ556L	102mm	16.8x15x9	MM	10
TJ560R	127mm	16.8x15x9	MM	10
TJ566L	127mm	16.8x15x9	MM	10
TJ511R	139mm	16.8x15x9	MM	10
TJ516L	139mm	16.8x15x9	MM	10
TJ521R	152mm	16.8x15x9	MM	10
TJ526L	152mm	16.8x15x9	MM	10
TJ531R	165mm	16.8x15x9	MM	10
TJ536L	165mm	16.8x15x9	MM	10
TJ542R	197mm	16.8x15x9	MM	10
TJ546L	197mm	16.8x15x9	MM	10

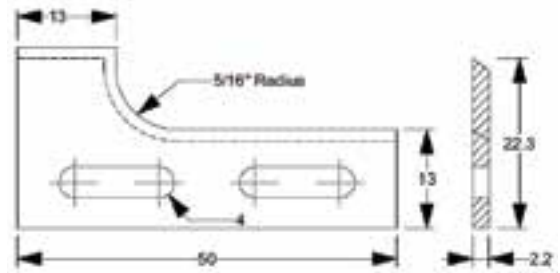
NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

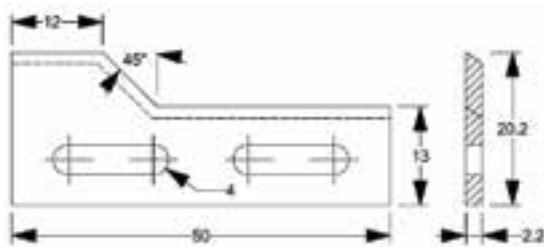
# Specialty Carbide Inserts for Router Bits



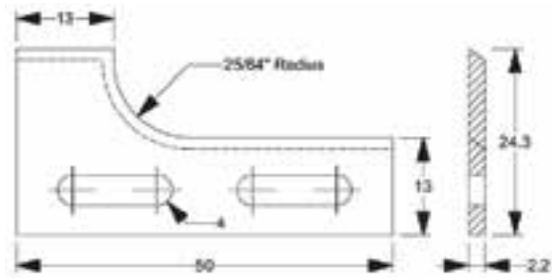
Part No.	W x H x T	Grade	Qty.
TJ441	50x24.8x2.2	GP	1



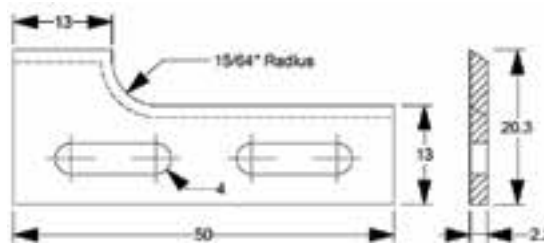
Part No.	W x H x T	Grade	Qty.
TJ457	50x22.3x2.2	GP	1
TJ461	50x22.3x2.2	GP	1



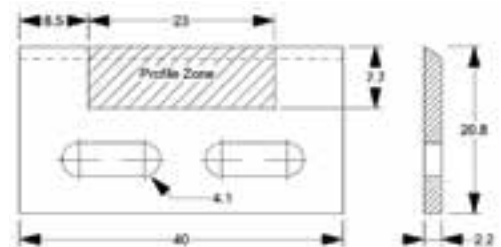
Part No.	W x H x T	Grade	Qty.
TJ444	50x20.2x2.2	GP	1
TJ447	50x20.2x2.2	GP	1



Part No.	W x H x T	Grade	Qty.
TJ464	50x24.8x2.2	GP	1
TJ467	50x24.8x2.2	GP	1



Part No.	W x H x T	Grade	Qty.
TJ451	50x20.3x2.2	GP	1
TJ454	50x20.3x2.2	GP	1



Part No.	W x H x T	Grade	Qty.
TJ311	40x20.8x2.2	GP	1

NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

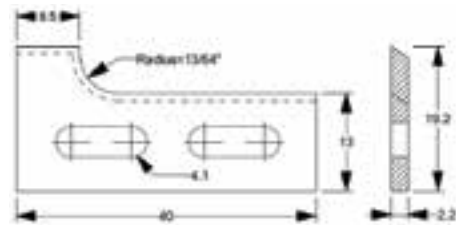
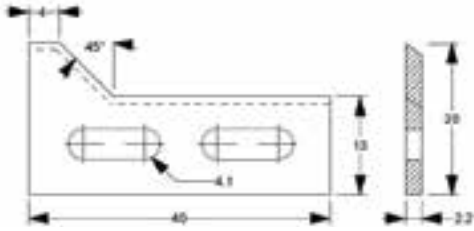
- A
- B
- C
- D
- E
- F
- G
- H
- I
- J
- K

# Specialty Carbide Inserts for Router Bits

A

B

C



D

Part No.	W x H x T	Grade	Qty.
TJ317	40x20x2.2	GP	1
TJ319	40x20x2.2	GP	1

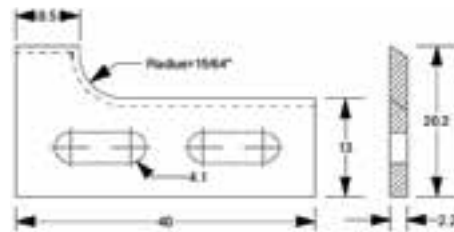
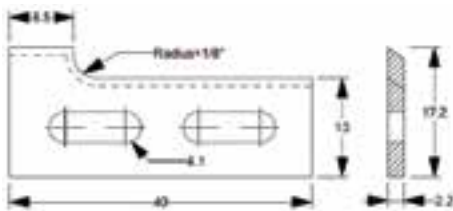
Part No.	W x H x T	Grade	Qty.
TJ335	40x19.2x2.2	GP	1
TJ338	40x19.2x2.2	GP	1

E

F

G

H



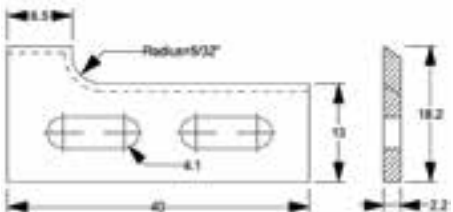
I

Part No.	W x H x T	Grade	Qty.
TJ323	40x17.2x2.2	GP	1
TJ326	40x17.2x2.2	GP	1

Part No.	W x H x T	Grade	Qty.
TJ341	40x20.2x2.2	GP	1
TJ344	40x20.2x2.2	GP	1

J

K



Part No.	W x H x T	Grade	Qty.
TJ329	40x18.2x2.2	GP	1
TJ332	40x18.2x2.2	GP	1

NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

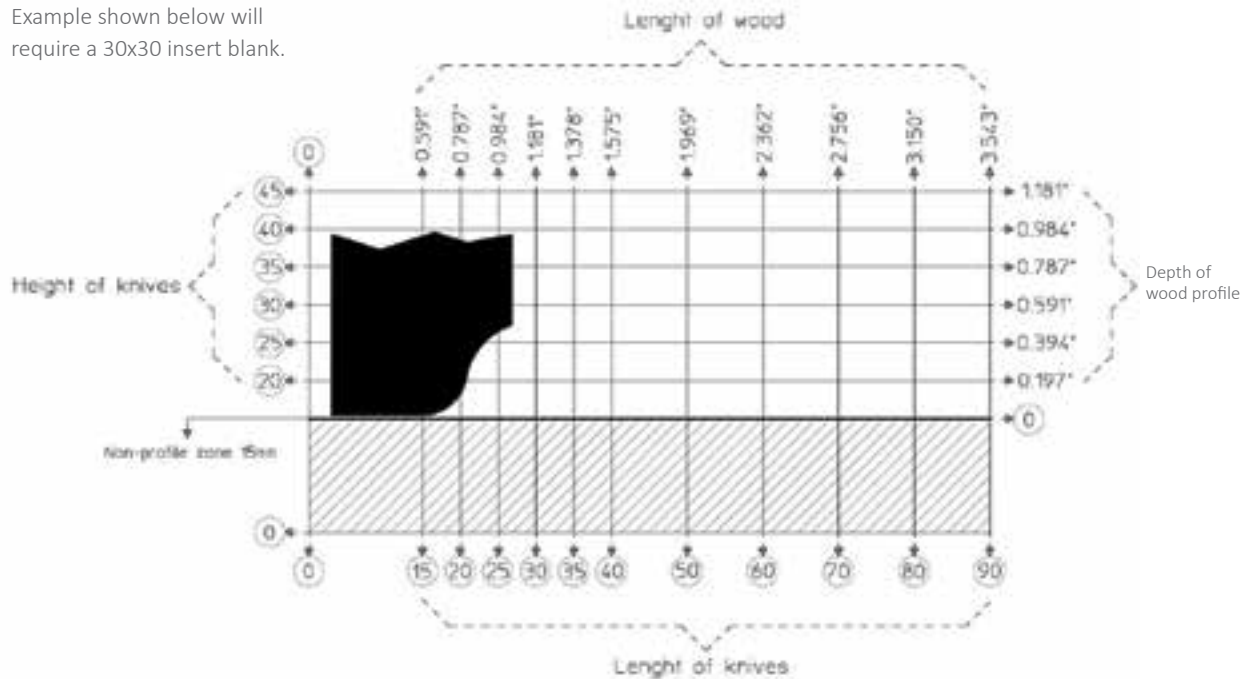
# Flat Bottom Carbide Insert Blanks

## New Insert Profile Sizing Grid

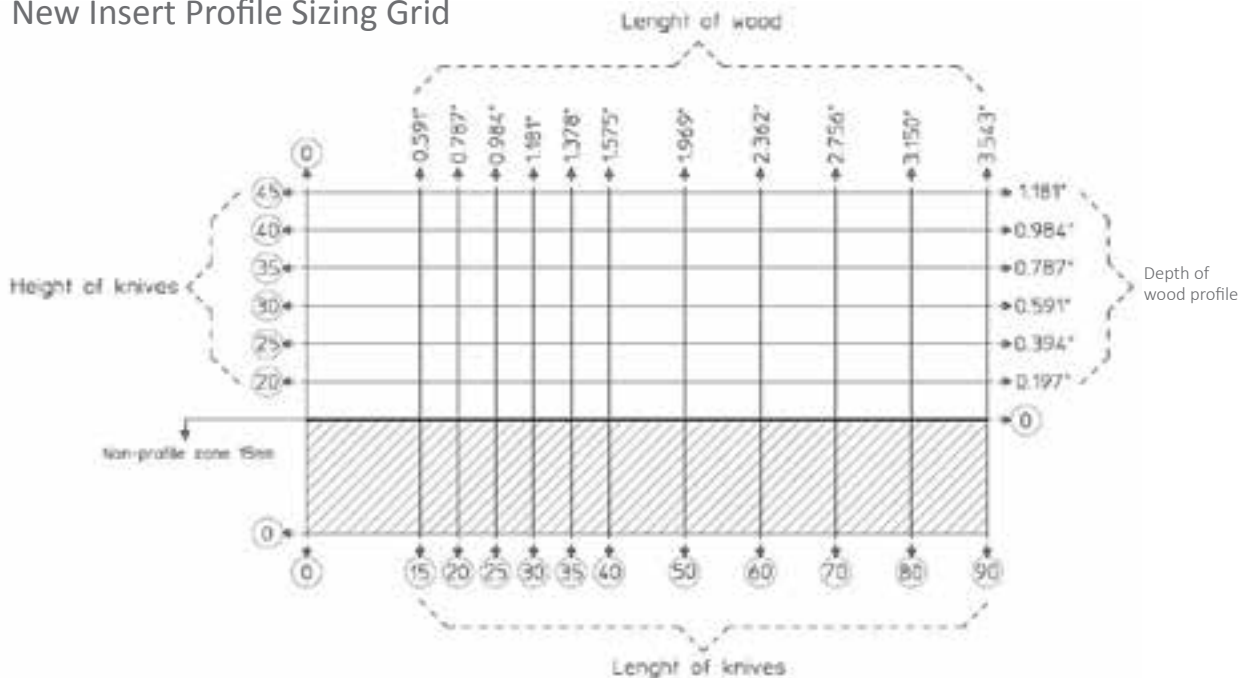
Use the Profile Sizing Grid (at bottom) to determine the proper size blank required for your profile. Refer to the example below.

Note in the example that the starting point 0, 0 is in the bottom left hand corner, but the profile (from a wood sample or drawing) must be placed above the non-profile zone in the starting position shown. Calculate the length and width of the required insert blank size. For assistance contact your NAPGLADU representative.

Example shown below will require a 30x30 insert blank.



## New Insert Profile Sizing Grid



- A
- B
- C
- D
- E
- F
- G
- H
- I
- J
- K

# Flat Bottom Carbide Insert Blanks

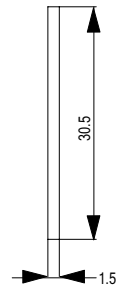
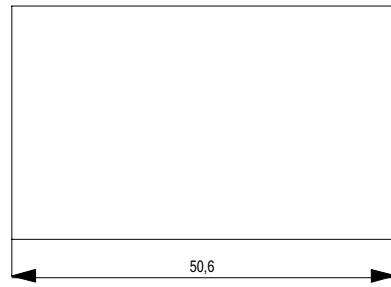
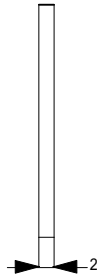
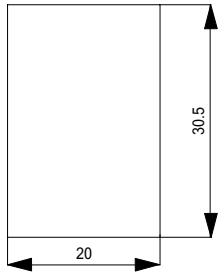
A

Non-turnable blanks – without mounting holes

B

C

D



E

Part No.	W x H x T	Grade	Qty.
4602	20x30.5x2	HNW	1

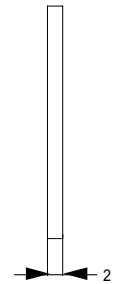
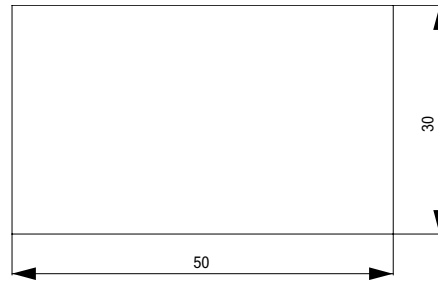
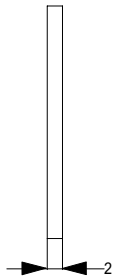
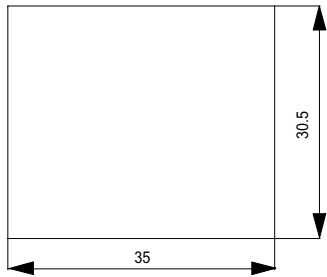
Part No.	W x H x T	Grade	Qty.
4794	50.6x30.5x1.5	GP	1

F

G

H

I

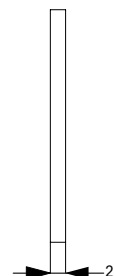
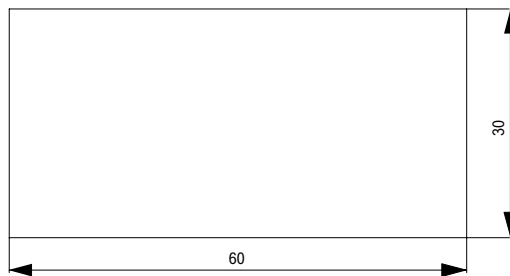
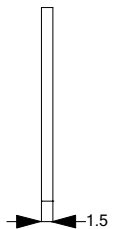


J

Part No.	W x H x T	Grade	Qty.
4790	35x30.5x2	HNW	1
4804	35x30.5x2	NW	1

Part No.	W x H x T	Grade	Qty.
4792	50x30x2	HNW	1

K



Part No.	W x H x T	Grade	Qty.
4600	50x25.4x1.5	GP	1

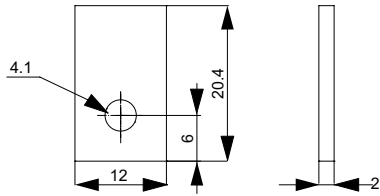
Part No.	W x H x T	Grade	Qty.
4788	60x30x2	MM-MDF	1

NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

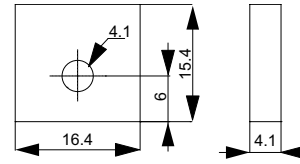
CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Flat Bottom Carbide Insert Blanks

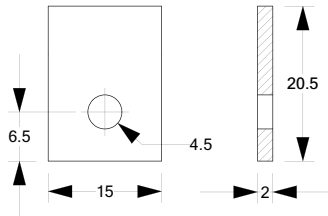
Non-turnable blanks – with 1 mounting hole



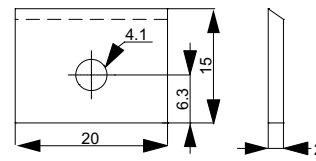
Part No.	W x H x T	Grade	Qty.
4606	12x20x2	GP	1



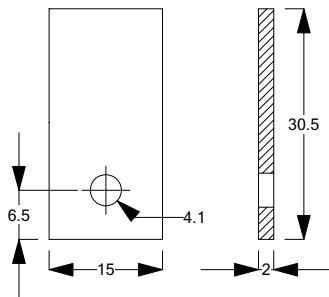
Part No.	W x H x T	Grade	Qty.
4604	16.4x15.4x4.1	MM-MDF	1



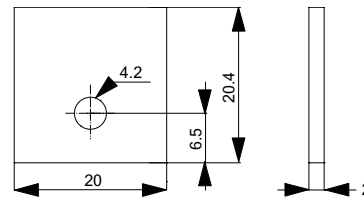
Part No.	W x H x T	Grade	Qty.
6001	15x20.5x2	GP	1
6000	15x20.5x2	NW	1



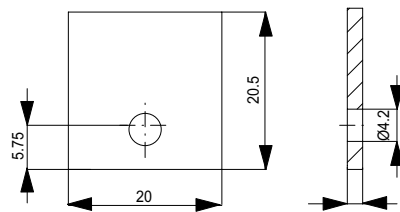
Part No.	W x H x T	Grade	Qty.
4718	20x15x2	GP	1



Part No.	W x H x T	Grade	Qty.
6006	15x30.5x2	GP	1



Part No.	W x H x T	Grade	Qty.
6027	20x20.4x2	GP	1



Part No.	W x H x T	Grade	Qty.
4808	20x20.5x2	GP	1

NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.



# Flat Bottom Carbide Insert Blanks

A

Non-turnable blanks – with 1 mounting hole

B

C

D

E

F

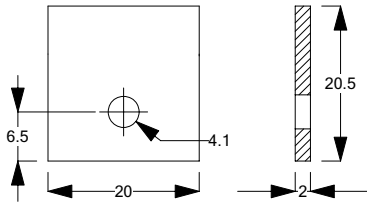
G

H

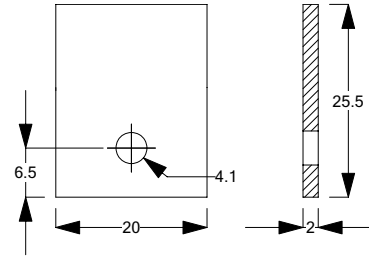
I

J

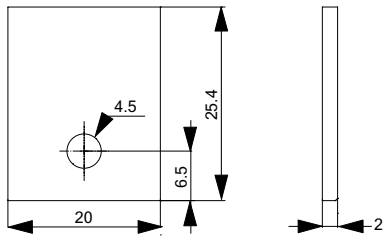
K



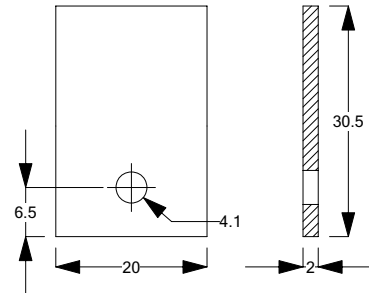
Part No.	W x H x T	Grade	Qty.
6025	20x20.5x2	NW	1



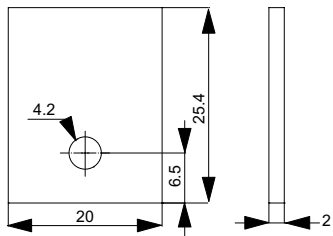
Part No.	W x H x T	Grade	Qty.
6030	20x25.5x2	NW	1



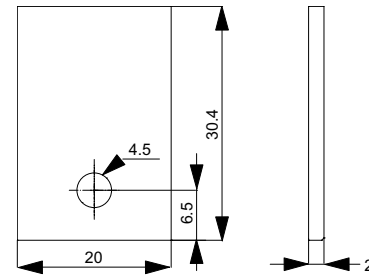
Part No.	W x H x T	Grade	Qty.
4610	20x25.4x2	HNW	1



Part No.	W x H x T	Grade	Qty.
6037	20x30.5x2	GP	1



Part No.	W x H x T	Grade	Qty.
4574	20x25.4x2	GP	1



Part No.	W x H x T	Grade	Qty.
4614	20x30.4x2	NW	1
4612	20x30.4x2	HNW	1

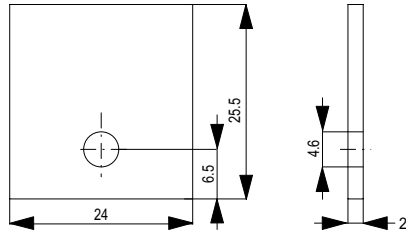
NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

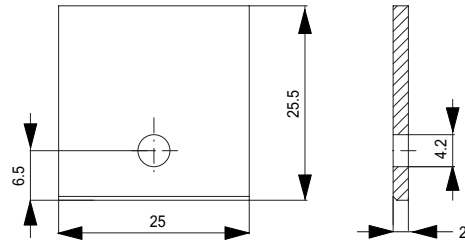


# Flat Bottom Carbide Insert Blanks

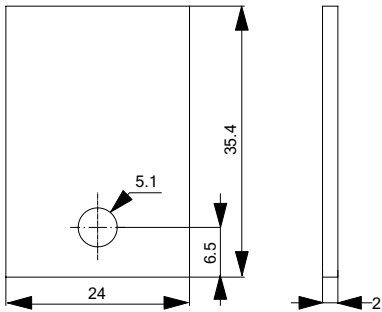
Non-turnable blanks – with 1 mounting hole



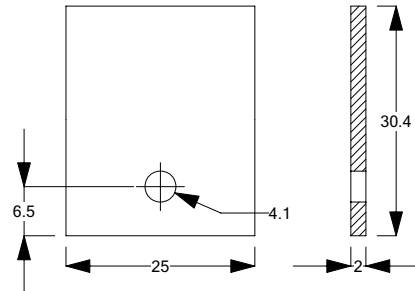
Part No.	W x H x T	Grade	Qty.
4810	24x25.5x2	HNW	1



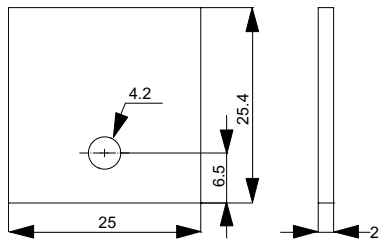
Part No.	W x H x T	Grade	Qty.
4806	25x25.5x2	GP	1



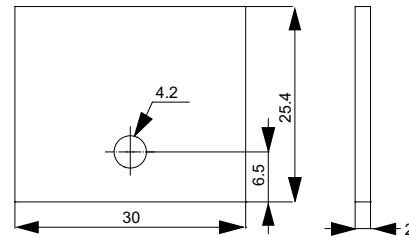
Part No.	W x H x T	Grade	Qty.
4608	24x35.4x2	GP	1



Part No.	W x H x T	Grade	Qty.
6057	25x30.4x2	NW	1



Part No.	W x H x T	Grade	Qty.
4576	25x25.4x2	GP	1
4590	25x25.4x2	MM-MDF	1



Part No.	W x H x T	Grade	Qty.
4766	30x25.4x2	GP	1

NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

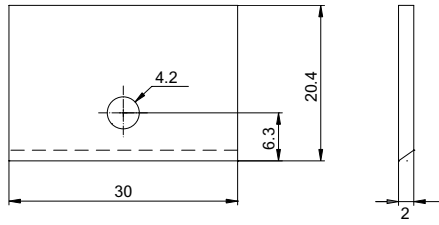
CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.



# Flat Bottom Carbide Insert Blanks

A

Non-turnable blanks – 1 mounting hole



Part No.	W x H x T	Grade	Qty.
5002	30x30.4x2	NW	1

B

C

D

E

F

G

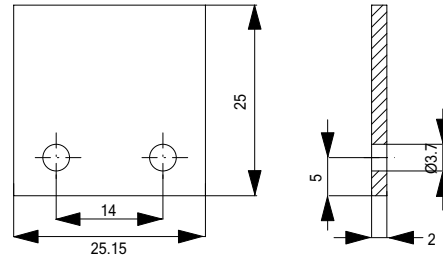
H

I

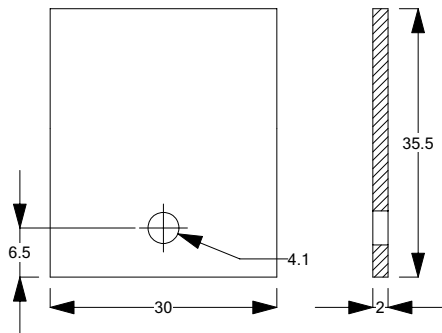
J

K

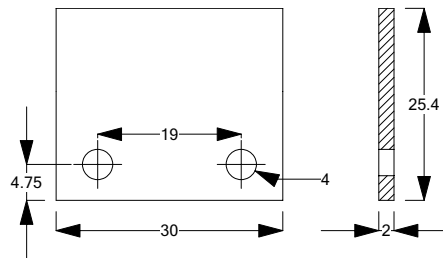
Non-turnable blanks – 2 mounting holes



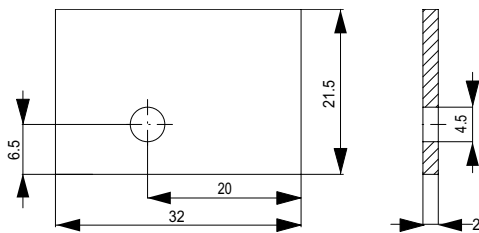
Part No.	W x H x T	Grade	Qty.
4812	25.15x25x2	GP	1



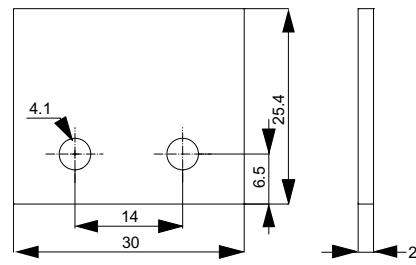
Part No.	W x H x T	Grade	Qty.
6085	30x35.5x2	NW	1



Part No.	W x H x T	Grade	Qty.
6078	30x25.4x2	NW	1



Part No.	W x H x T	Grade	Qty.
4760	32x21.5x2	GP	1



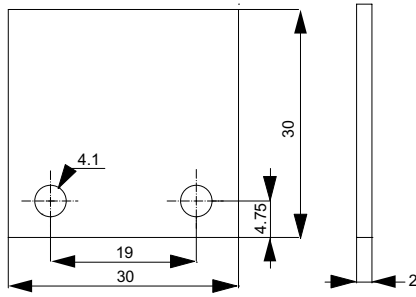
Part No.	W x H x T	Grade	Qty.
4770	30x25.4x2	GP	1

NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

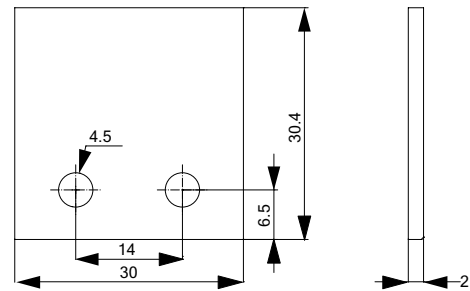
CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Flat Bottom Carbide Insert Blanks

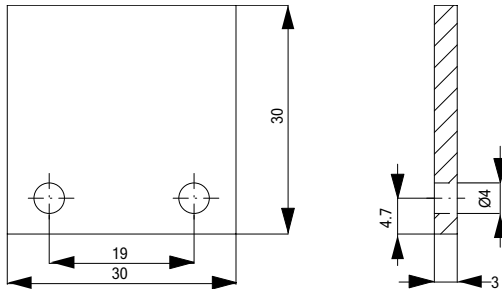
## Non-turnable blanks – 2 mounting holes



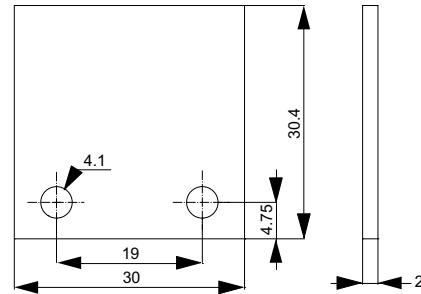
Part No.	W x H x T	Grade	Qty.
4816	30x30x2	GP	1



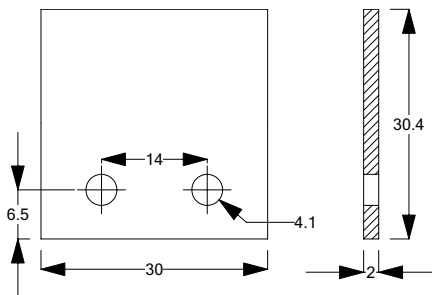
Part No.	W x H x T	Grade	Qty.
4676	30x30.4x2	NW	1



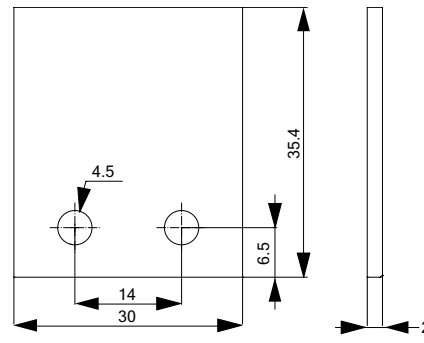
Part No.	W x H x T	Grade	Qty.
4820	30x30x3	GP	1



Part No.	W x H x T	Grade	Qty.
6079	30x30.4x2	GP	1



Part No.	W x H x T	Grade	Qty.
6082	30x30.4x2	GP	1



Part No.	W x H x T	Grade	Qty.
4628	30x35.4x2	GP	1

Part No.	W x H x T	Grade	Qty.
4670	30x35.4x2	HNW	1

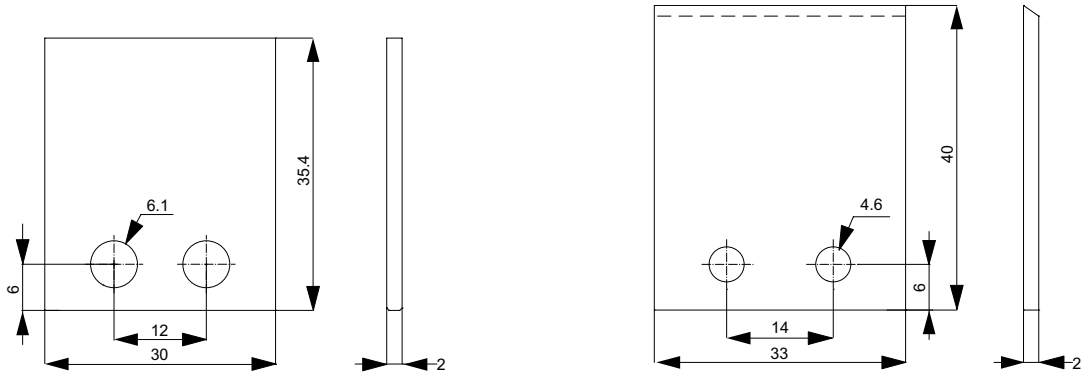
NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

- A
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- H
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- J
- K

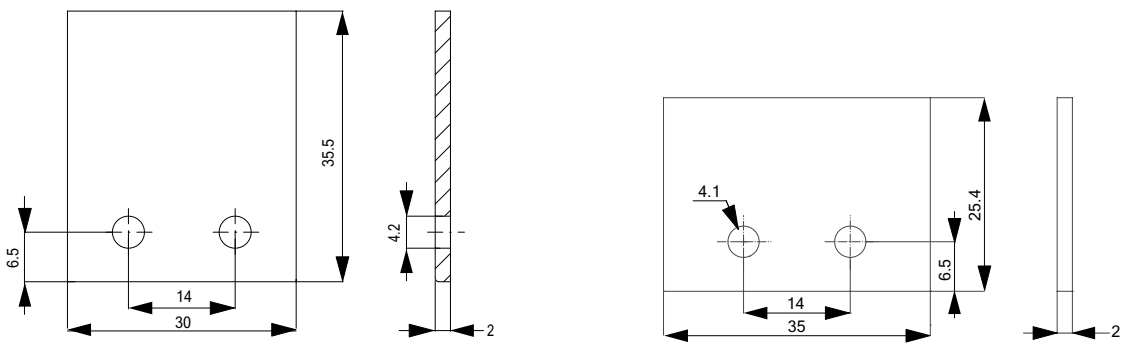
# Flat Bottom Carbide Insert Blanks

## A Non-turnable blanks – 2 mounting holes



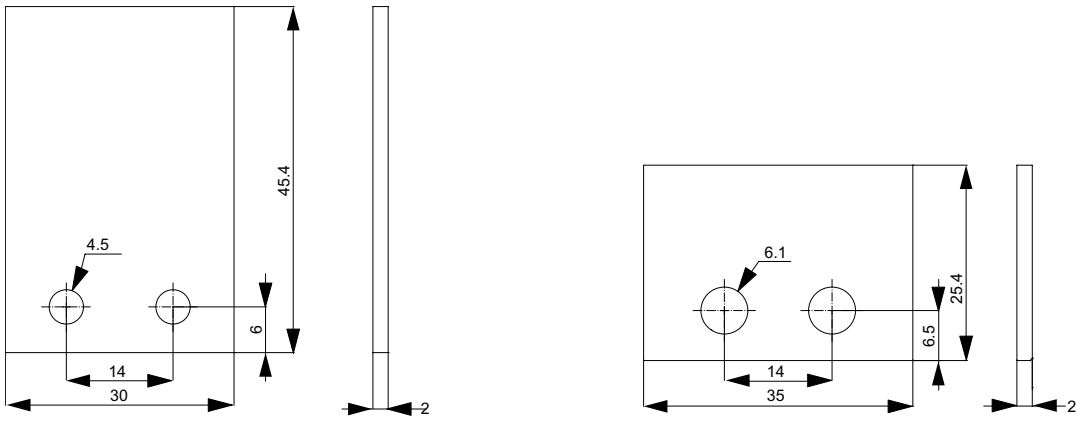
Part No.	W x H x T	Grade	Qty.
4666	30x35.4x2	GP	1

Part No.	W x H x T	Grade	Qty.
4656	33x40x2	GP	1



Part No.	W x H x T	Grade	Qty.
4624	30x35.5x2	MM-MDF	1

Part No.	W x H x T	Grade	Qty.
4654	35x25.4x2	GP	1



Part No.	W x H x T	Grade	Qty.
4658	30x45.4x2	GP	1

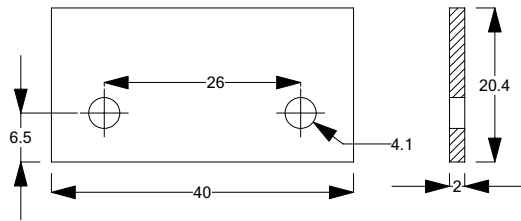
Part No.	W x H x T	Grade	Qty.
4592	35x25.4x2	GP	1

NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

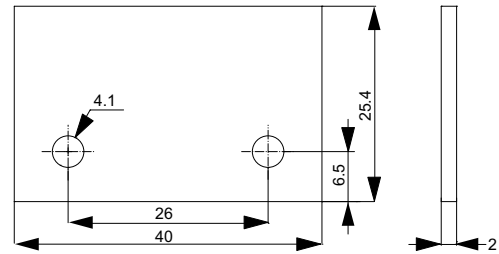
CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Flat Bottom Carbide Insert Blanks

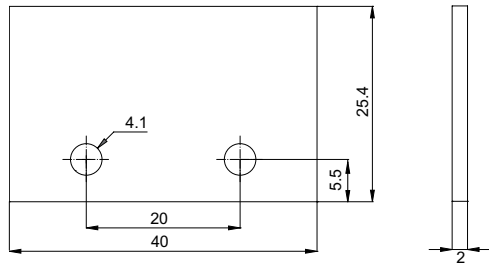
Non-turnable blanks – 2 mounting holes



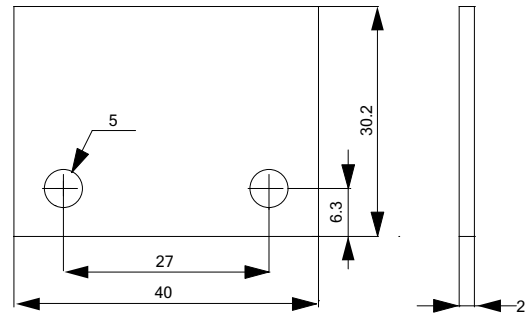
Part No.	W x H x T	Grade	Qty.
6110	40x20.4x2	GP	1



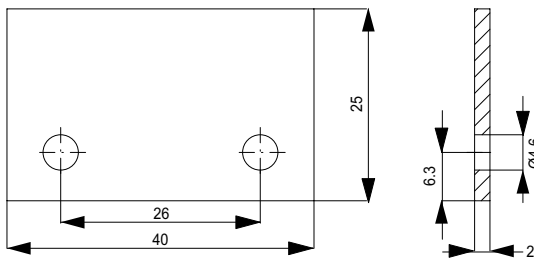
Part No.	W x H x T	Grade	Qty.
4582	40x25.4x2	GP	1



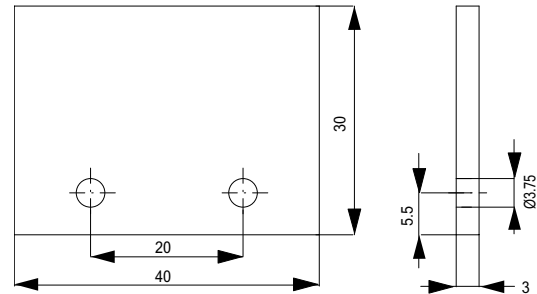
Part No.	W x H x T	Grade	Qty.
6114	40x25x2	GP	1



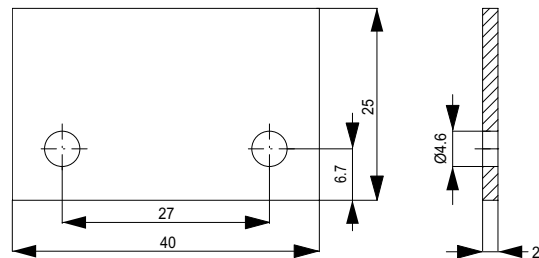
Part No.	W x H x T	Grade	Qty.
4626	40x30.2x2	GP	1
4786	40x30.2x2	MM-MDF	1
4674	40x30.2x2	NW	1
4668	40x30.2x2	HNW	1



Part No.	W x H x T	Grade	Qty.
4630	40x25x2	GP	1



Part No.	W x H x T	Grade	Qty.
4632	40x30x3	GP	1
4818	40x30x3	GP	1



Part No.	W x H x T	Grade	Qty.
4814	40x25x2	GP	1

NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.



# Flat Bottom Carbide Insert Blanks

## A Non-turnable blanks – 2 mounting holes

B

C

D

E

F

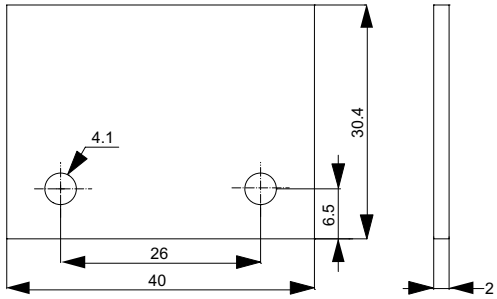
G

H

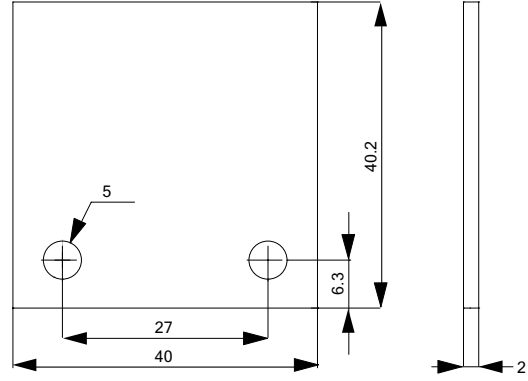
I

J

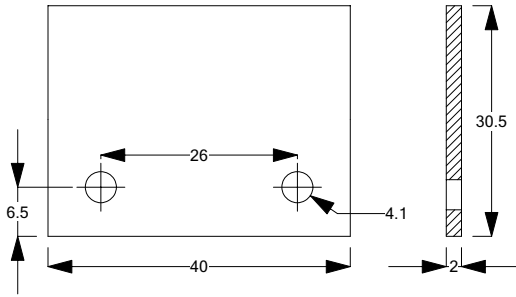
K



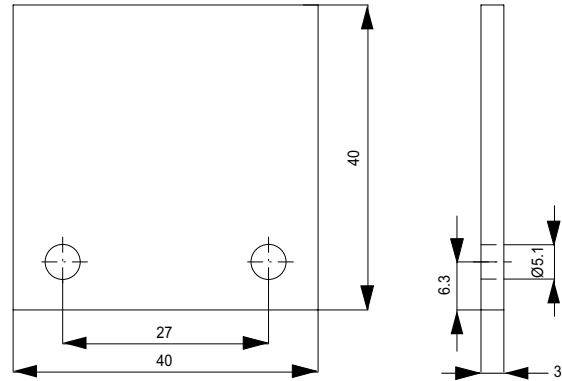
Part No.	W x H x T	Grade	Qty.
4778	40x30.4x2	MM-MDF	1



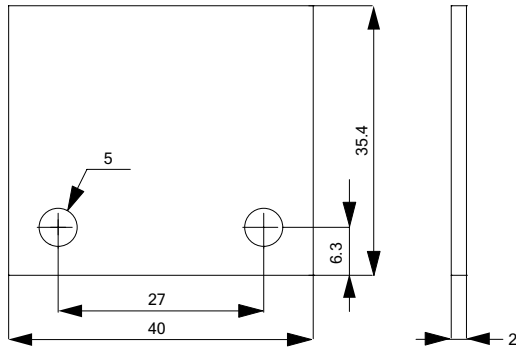
Part No.	W x H x T	Grade	Qty.
4636	40x40.2x2	GP	1



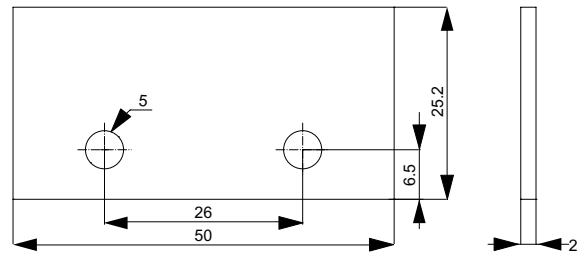
Part No.	W x H x T	Grade	Qty.
6115	40x30.5x2	GP	1



Part No.	W x H x T	Grade	Qty.
4638	40x40x3	GP	1



Part No.	W x H x T	Grade	Qty.
4634	40x35.4x2	GP	1



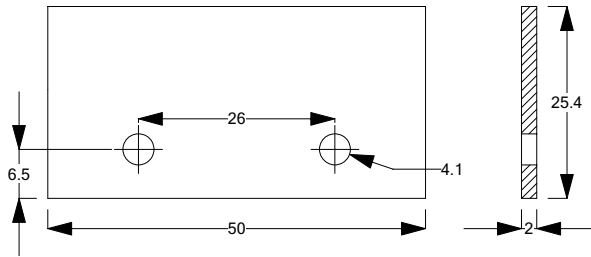
Part No.	W x H x T	Grade	Qty.
4562	50x25.2x2	GP	1
4672	50x25.2x2	GP	1

NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

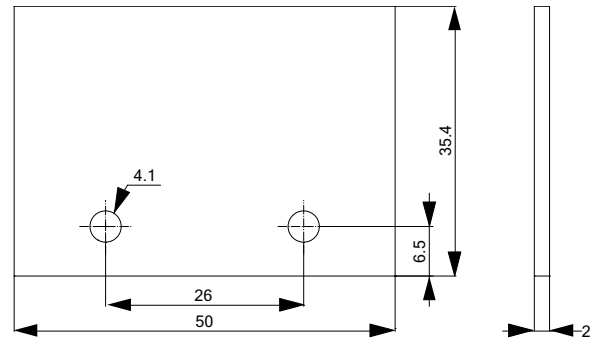
CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Flat Bottom Carbide Insert Blanks

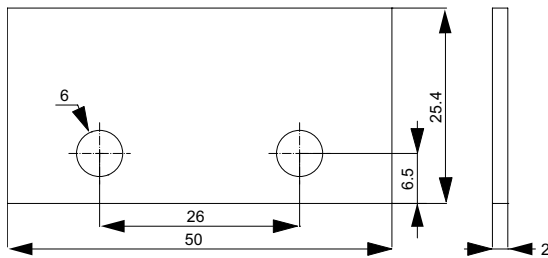
Non-turnable blanks – 2 mounting holes



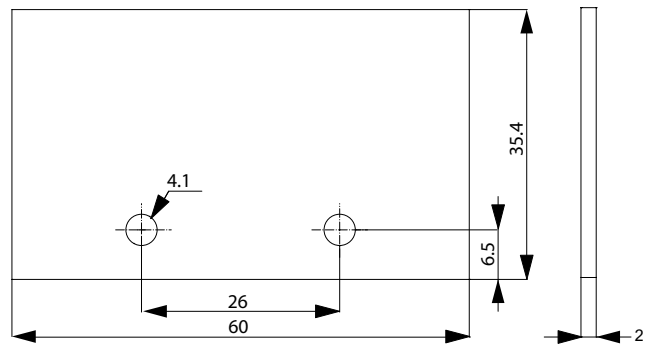
Part No.	W x H x T	Grade	Qty.
6661	50x25.4x2	NW	1



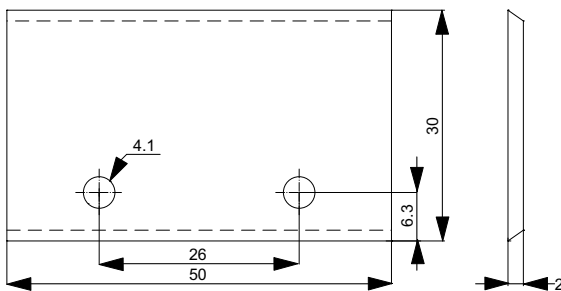
Part No.	W x H x T	Grade	Qty.
5997	50x35.4x2	GP	1



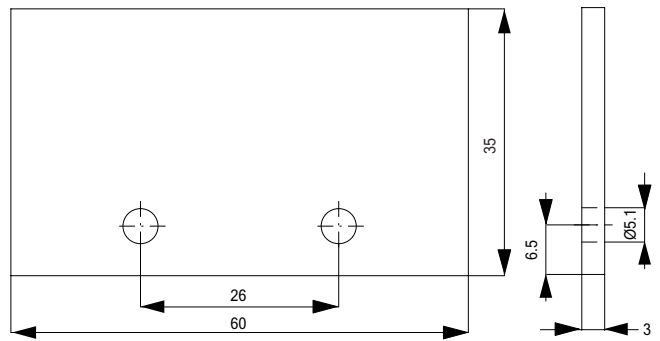
Part No.	W x H x T	Grade	Qty.
4594	50x25.4x2	GP	1



Part No.	W x H x T	Grade	Qty.
4652	60x35.4x2	GP	1



Part No.	W x H x T	Grade	Qty.
4580	50x30.4x2	GP	1



Part No.	W x H x T	Grade	Qty.
4642	60x35x3	GP	1

NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

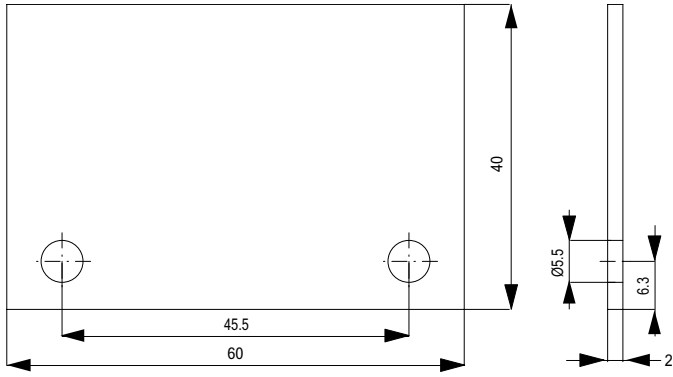
CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

- A
- B
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- D
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- F
- G
- H
- I
- J
- K

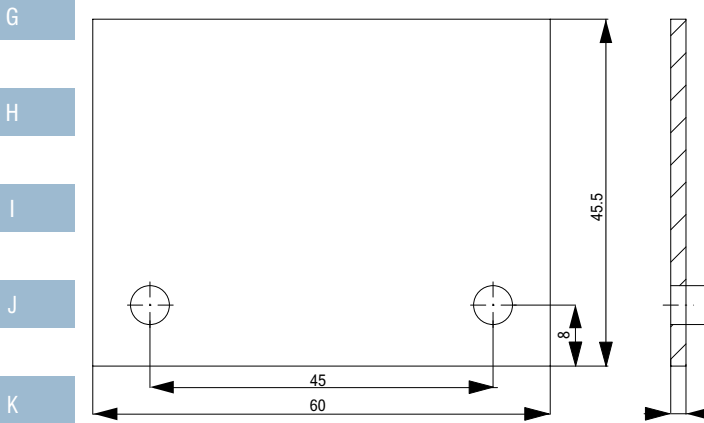


# Flat Bottom Carbide Insert Blanks

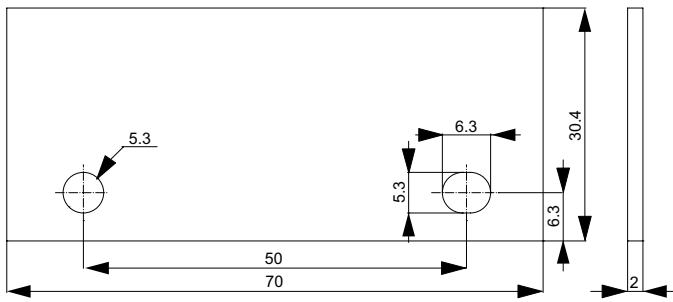
## A Non-turnable blanks – 2 mounting holes



Part No.	W x H x T	Grade	Qty.
4824	60x40x2	HNW	1



Part No.	W x H x T	Grade	Qty.
4644	60x45.5x2	GP	1



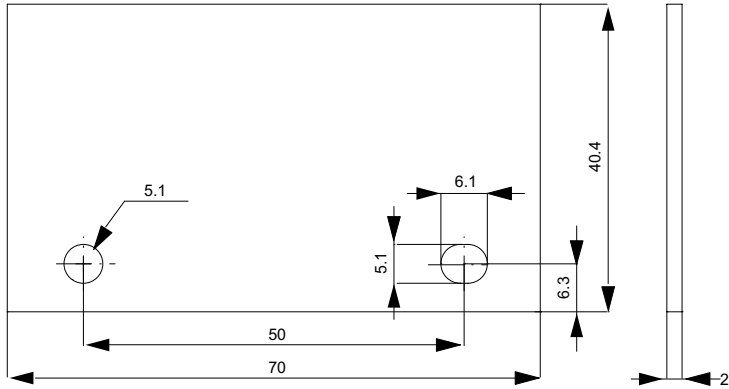
Part No.	W x H x T	Grade	Qty.
4662	70x30x2	GP	1

NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

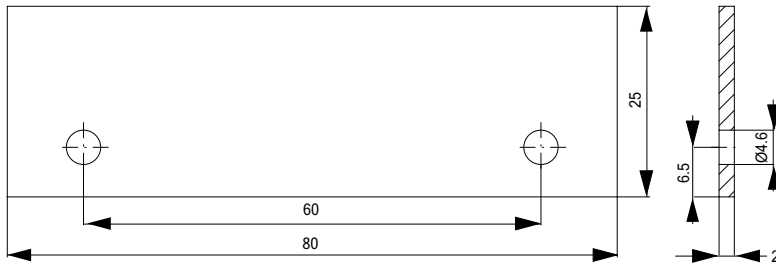
CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Flat Bottom Carbide Insert Blanks

Non-turnable blanks – 2 mounting holes



Part No.	W x H x T	Grade	Qty.
4660	70x40.4x2	GP	1



Part No.	W x H x T	Grade	Qty.
4646	80x25x2	GP	1
4822	80x25x2	HNW	1

**NOTE:** Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

**CARBIDE GRADE:** GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

A

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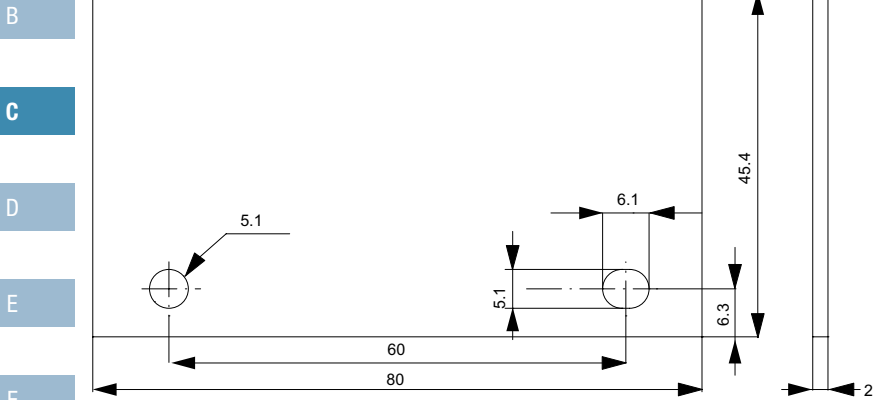
I

J

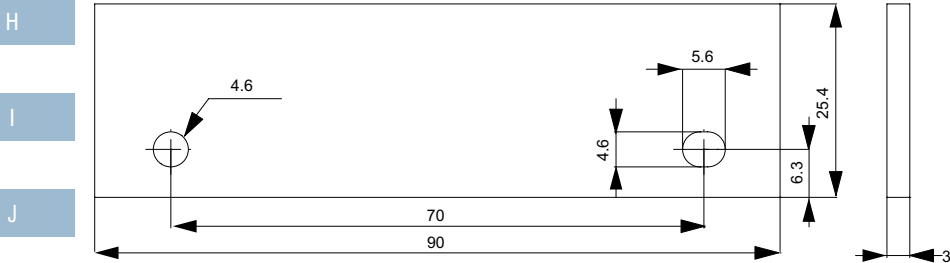
K

# Flat Bottom Carbide Insert Blanks

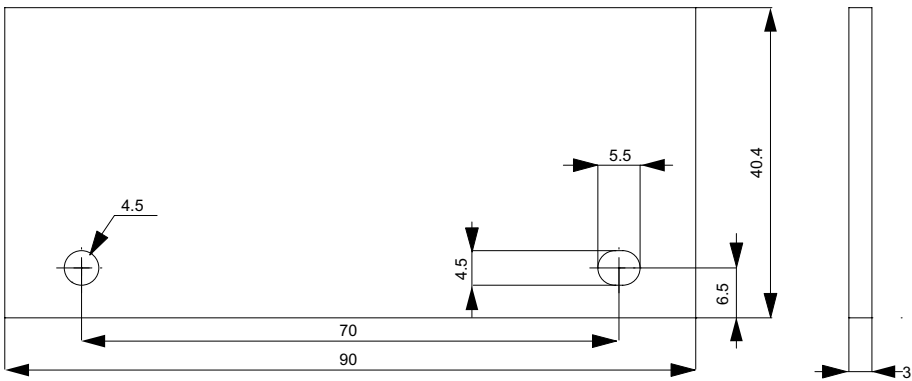
## A Non-turnable blanks – 2 mounting holes



Part No.	W x H x T	Grade	Qty.
4650	80x45.4x2	GP	1



Part No.	W x H x T	Grade	Qty.
4664	90x25.4x2	GP	1



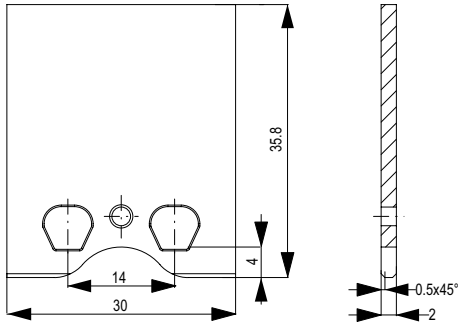
Part No.	W x H x T	Grade	Qty.
4648	90x40x3	GP	1

NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

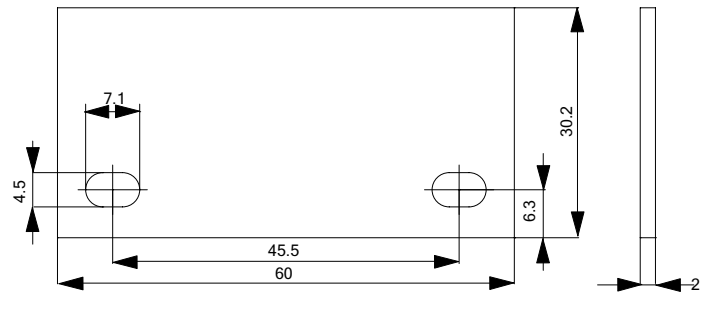
CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Flat Bottom Specialty Carbide Insert Blanks

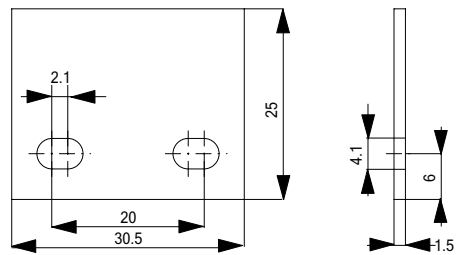
Non-turnable blanks – 2 mounting holes



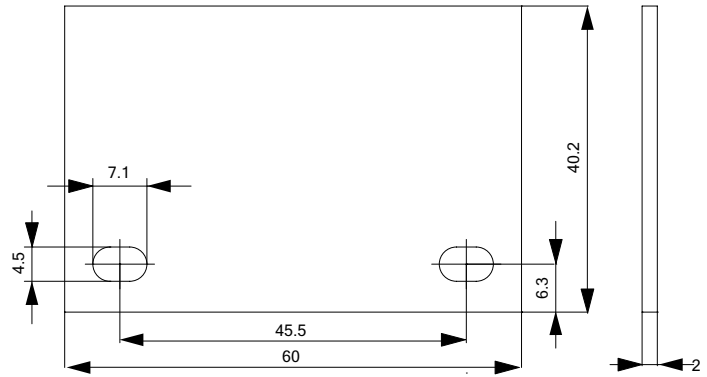
Part No.	W x H x T	Grade	Qty.
4756	30x35.8x2	GP	1



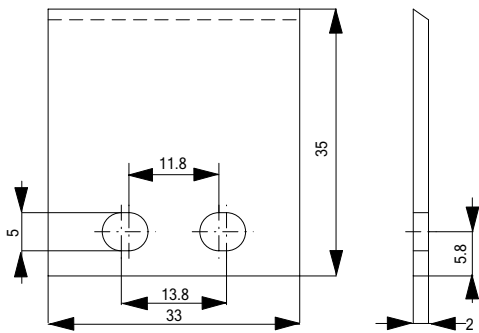
Part No.	W x H x T	Grade	Qty.
4694	60x30.2x2	GP	1



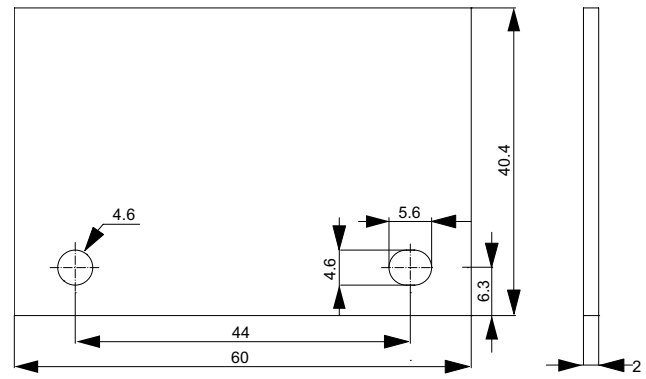
Part No.	W x H x T	Grade	Qty.
4832	30.5x25x1.5	GP	1



Part No.	W x H x T	Grade	Qty.
4696	60x40.2x2	GP	1



Part No.	W x H x T	Grade	Qty.
4834	33x35x2	GP	1



Part No.	W x H x T	Grade	Qty.
4702	60x40.4x2	HNW	1

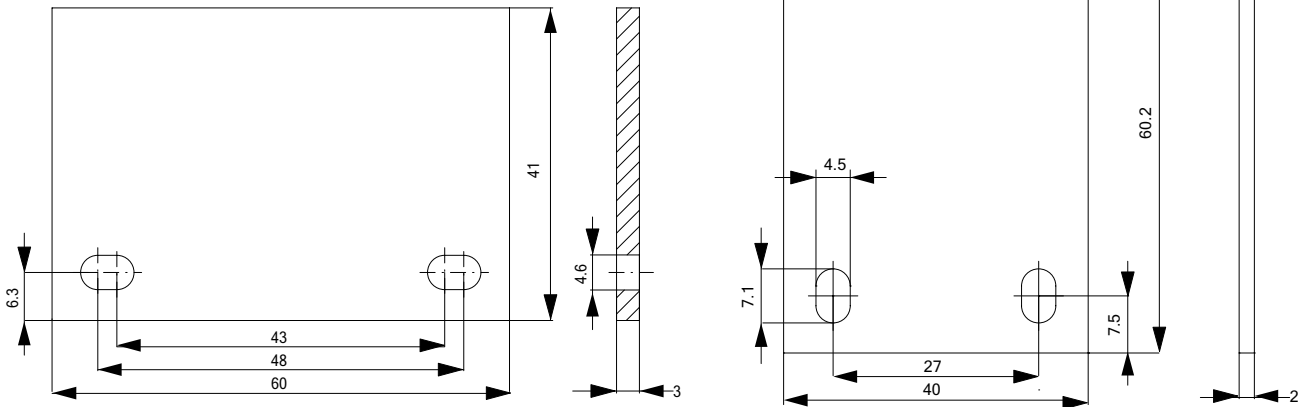
NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

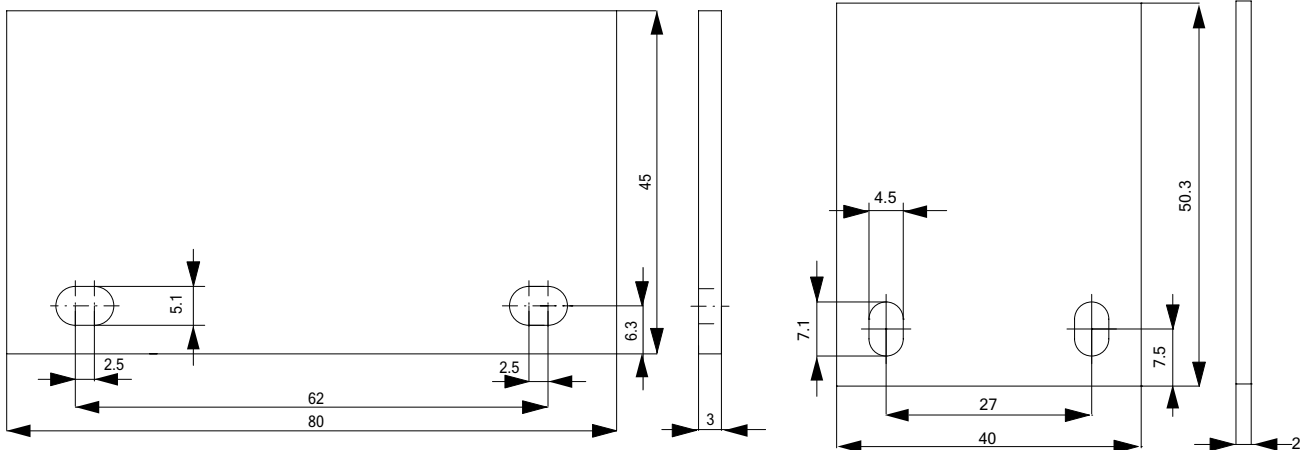
- A
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# Flat Bottom Specialty Carbide Insert Blanks

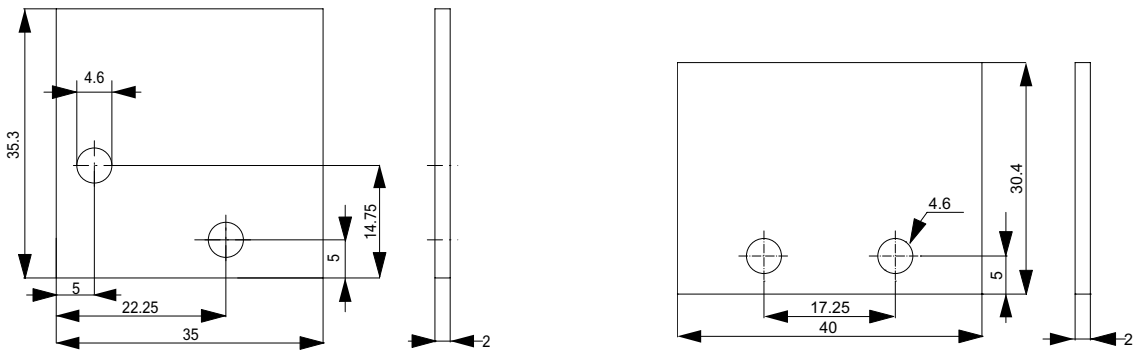
## A Non-turnable blanks – 2 mounting holes



Part No.	W x H x T	Grade	Qty.	Part No.	W x H x T	Grade	Qty.
4698	60x41x3	GP	1	4704	40x60.2x2	GP	1



Part No.	W x H x T	Grade	Qty.	Part No.	W x H x T	Grade	Qty.
4700	80x45x3	GP	1	4706	40x50.3x2	GP	1

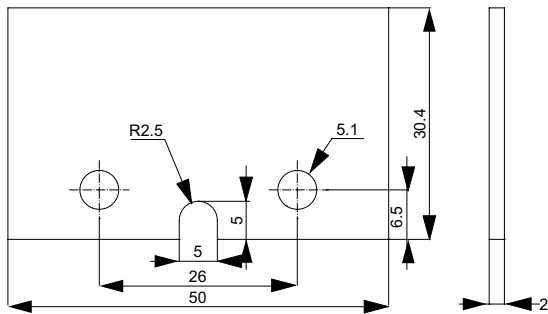


Part No.	W x H x T	Grade	Qty.	Part No.	W x H x T	Grade	Qty.
4708	35x35.3x2	GP	1	4710	40x30.4x2	GP	1

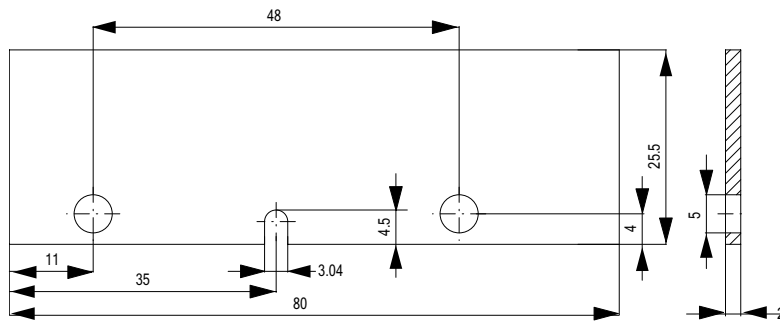
NOTE: Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1).  
 CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Flat Bottom Specialty Carbide Insert Blanks

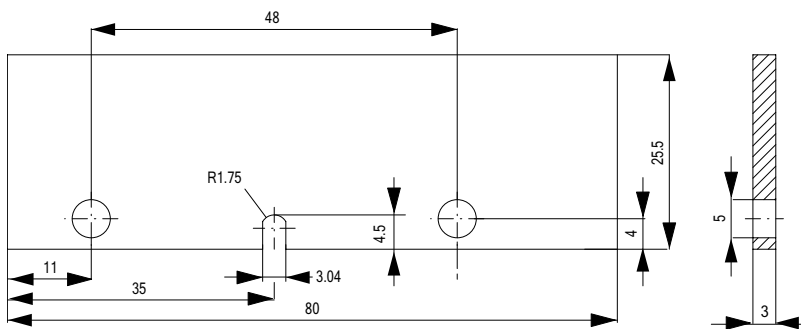
Non-turnable blanks – 2 mounting holes



Part No.	W x H x T	Grade	Qty.
4712	50x30.4x2	HNW	1
4714	50x30.4x2	HNW	1



Part No.	W x H x T	Grade	Qty.
4836	80x25.5x2	GP	1



Part No.	W x H x T	Grade	Qty.
4716	80x25.5x3	HNW	1

**NOTE:** Use the drawings and specifications to exactly match the inserts you require. All drawings are to scale (1:1) and are shown in face coming positions.

**CARBIDE GRADE:** GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Beveled Bottom Carbide Insert Blanks

## A Non-turnable blanks – 1 mounting holes

A

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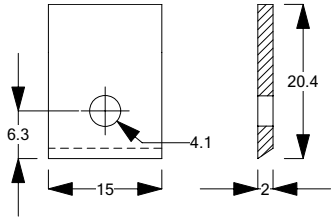
G

H

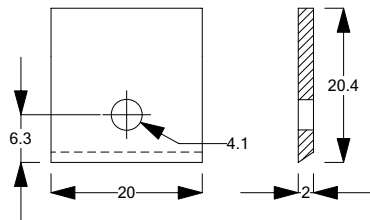
I

J

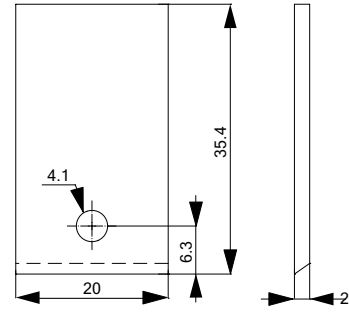
K



Part No.	W x H x T	Grade	Qty.
6190	15x20.4x2	GP	1



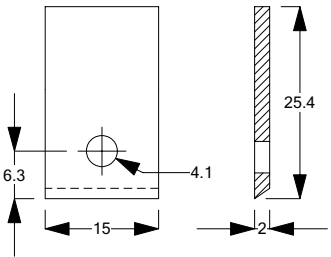
Part No.	W x H x T	Grade	Qty.
6205	20x20.4x2	GP	1



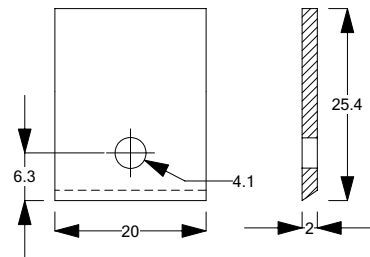
Part No.	W x H x T	Grade	Qty.
4728	20x35.4x2	NW	1



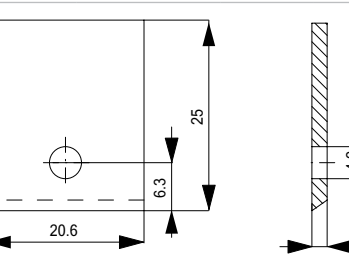
Part No.	W x H x T	Grade	Qty.
4720	20x35.4x2	GP	1



Part No.	W x H x T	Grade	Qty.
6191	15x25.4x2	GP	1



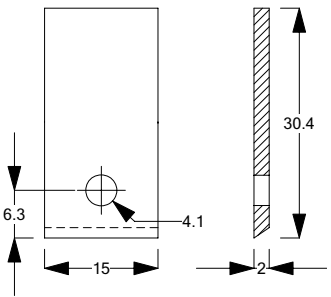
Part No.	W x H x T	Grade	Qty.
6210	20x25.4x2	GP	1



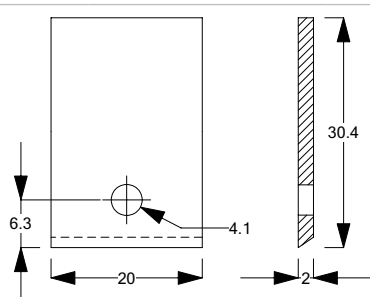
Part No.	W x H x T	Grade	Qty.
4724	18x18x2.5	HNW	1



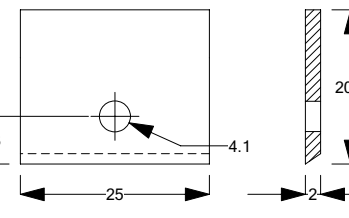
Part No.	W x H x T	Grade	Qty.
4762	20x25.4x2	HNW	1



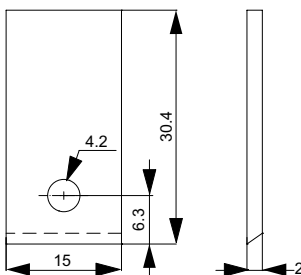
Part No.	W x H x T	Grade	Qty.
6193	15x30.4x2	GP	1



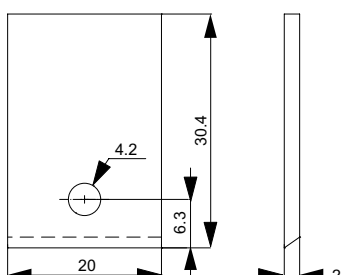
Part No.	W x H x T	Grade	Qty.
6215	20x30.4x2	GP	1



Part No.	W x H x T	Grade	Qty.
6235	25x20.4x2	GP	1



Part No.	W x H x T	Grade	Qty.
4776	15x30.4x2	HNW	1



Part No.	W x H x T	Grade	Qty.
4764	20x30.4x2	HNW	1

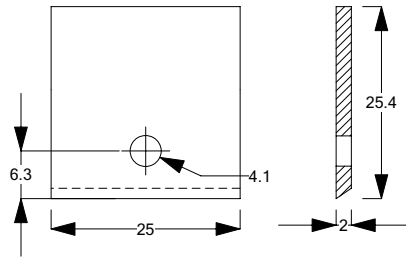
NOTE: Use the drawings and specifications to exactly match the inserts you require.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

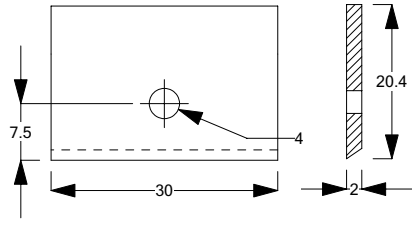


# Beveled Bottom Carbide Insert Blanks

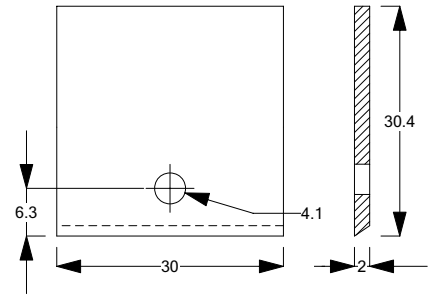
## Non-turnable blanks – 1 mounting holes



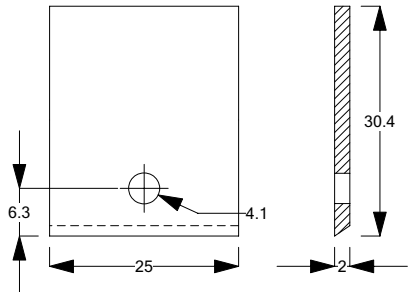
Part No.	W x H x T	Grade	Qty.
6240	25x25.4x2	GP	1
6241	25x25.4x2	HNW	1



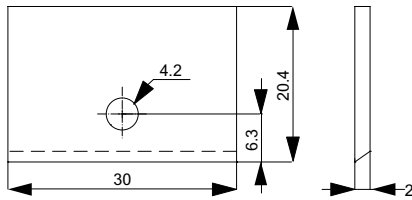
Part No.	W x H x T	Grade	Qty.
6270	30x20.4x2	GP	1



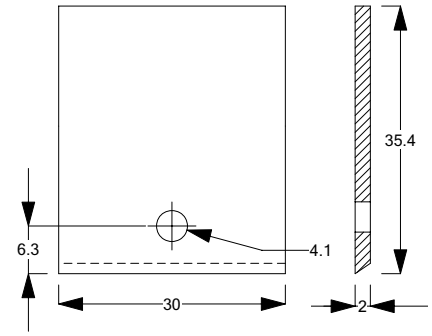
Part No.	W x H x T	Grade	Qty.
6280	30x30.4x2	GP	1
6281	30x30.4x2	HNW	1



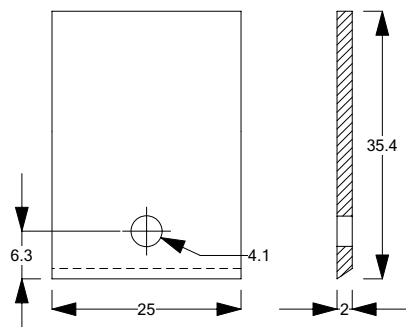
Part No.	W x H x T	Grade	Qty.
6245	25x30.4x2	GP	1



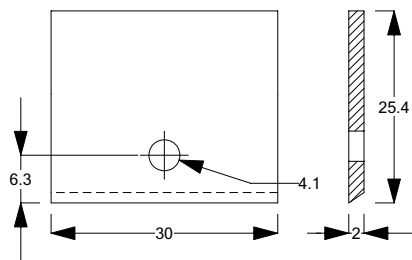
Part No.	W x H x T	Grade	Qty.
4726	30x20.4x2	HNW	1



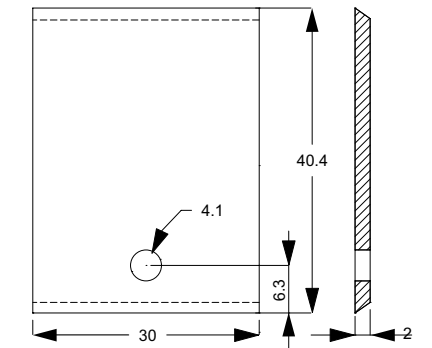
Part No.	W x H x T	Grade	Qty.
6285	30x35.4x2	GP	1
6286	30x35.4x2	NW	1
6287	30x35.4x2	HNW	1



Part No.	W x H x T	Grade	Qty.
6250	25x35.4x2	GP	1



Part No.	W x H x T	Grade	Qty.
6275	30x25.4x2	GP	1
4730	30x25.4x2	NW	1
4768	30x25.4x2	HNW	1



Part No.	W x H x T	Grade	Qty.
6469	30x40.4x2	GP	1

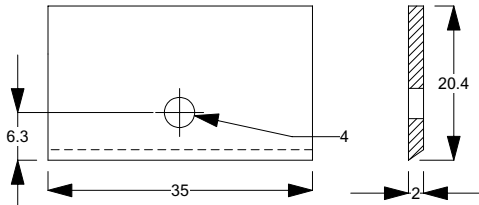
NOTE: Use the drawings and specifications to exactly match the inserts you require.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Beveled Bottom Carbide Insert Blanks

A

## Non-turnable blanks – 1 mounting holes

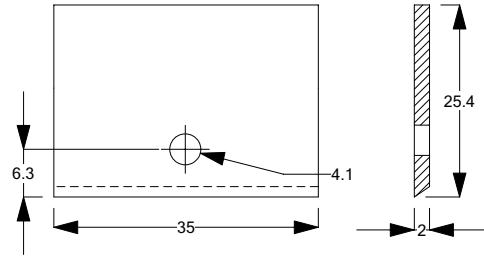


Part No.	W x H x T	Grade	Qty.
6300	35x20.4x2	GP	1

B

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D



Part No.	W x H x T	Grade	Qty.
6305	35x25.4x2	GP	1

E

F

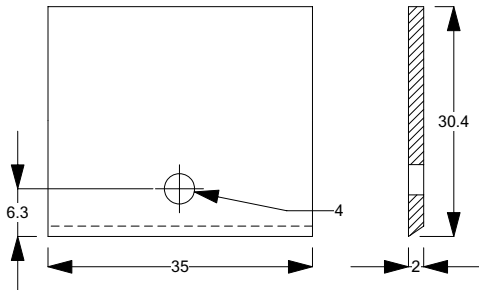
G

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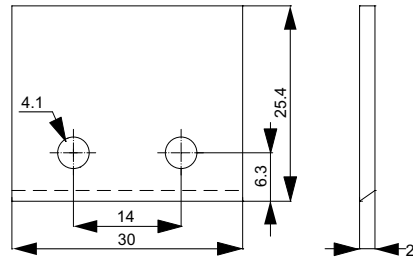
J

K

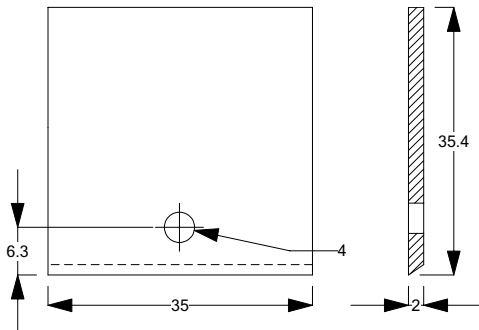


Part No.	W x H x T	Grade	Qty.
6310	35x30.4x2	GP	1

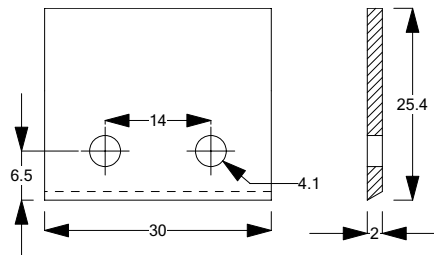
## Non-turnable blanks – 2 mounting holes



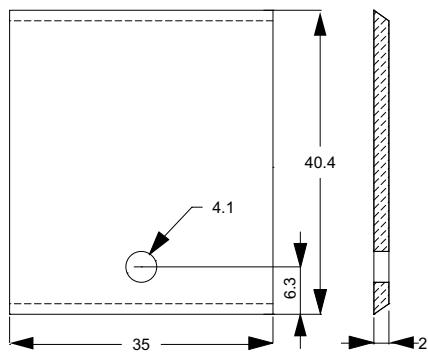
Part No.	W x H x T	Grade	Qty.
4586	30x25.4x2	GP	1



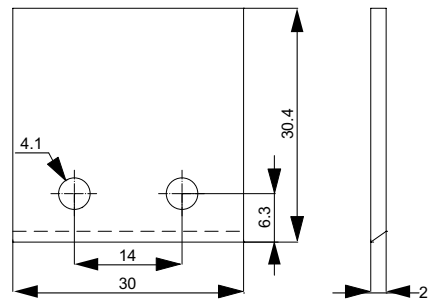
Part No.	W x H x T	Grade	Qty.
6315	35x35.4x2	GP	1



Part No.	W x H x T	Grade	Qty.
6330	30x25.4x2	HNW	1



Part No.	W x H x T	Grade	Qty.
6471	35x40.4x2	GP	1



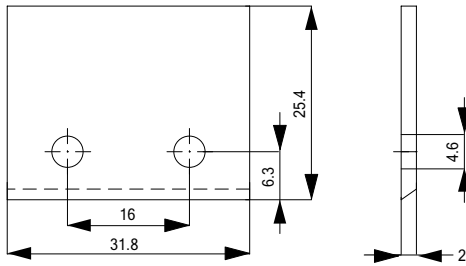
Part No.	W x H x T	Grade	Qty.
4588	30x30.4x2	GP	1

NOTE: Use the drawings and specifications to exactly match the inserts you require.

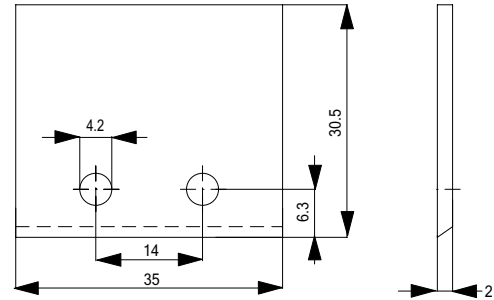
CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Beveled Bottom Carbide Insert Blanks

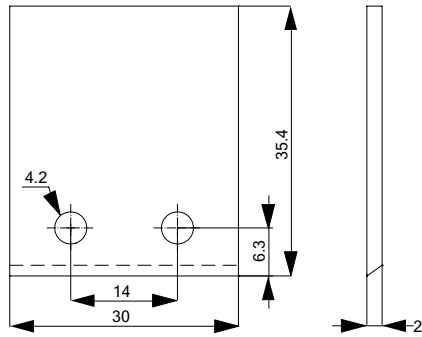
Non-turnable blanks – 2 mounting holes



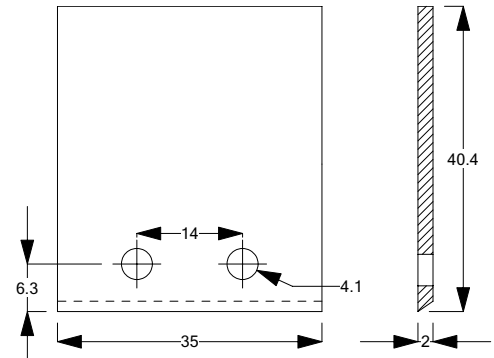
Part No.	W x H x T	Grade	Qty.
4744	31.8x25.4x2	GP	1



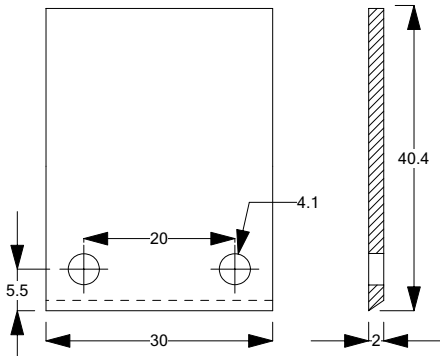
Part No.	W x H x T	Grade	Qty.
4844	35x30.5x2	GP	1



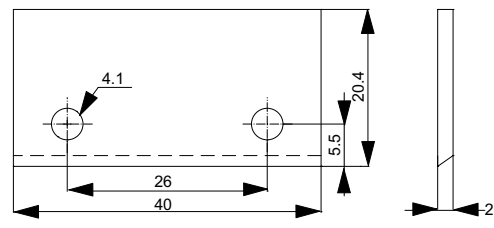
Part No.	W x H x T	Grade	Qty.
4742	30x35.4x2	GP	1



Part No.	W x H x T	Grade	Qty.
6470	35x40.4x2	GP	1

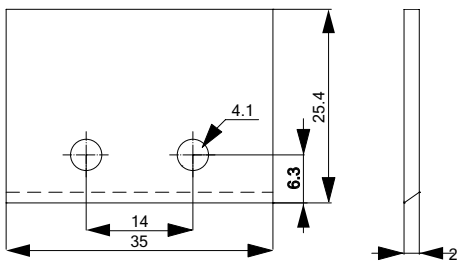


Part No.	W x H x T	Grade	Qty.
6468	30x40.4x2	GP	1

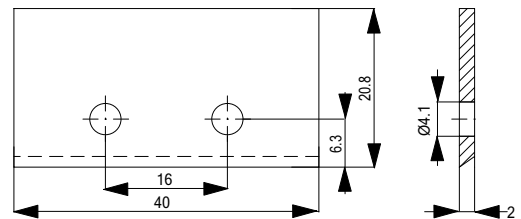


Part No.	W x H x T	Grade	Qty.
4584	40x20.4x2	GP	1

4772	40x20.4x2	NW	1
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Part No.	W x H x T	Grade	Qty.
4746	35x25.4x2	NAW	1



Part No.	W x H x T	Grade	Qty.
4846	40x20.8x2	GP	1

NOTE: Use the drawings and specifications to exactly match the inserts you require.



# Beveled Bottom Carbide Insert Blanks

## A Non-turnable blanks – 2 mounting holes

B

C

D

E

F

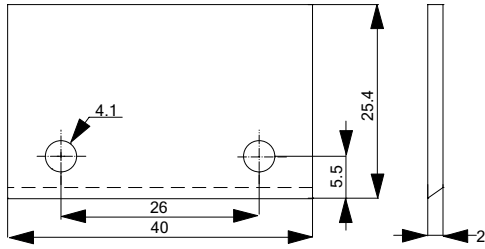
G

H

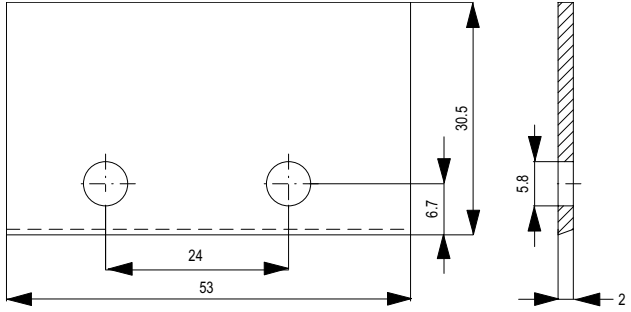
I

J

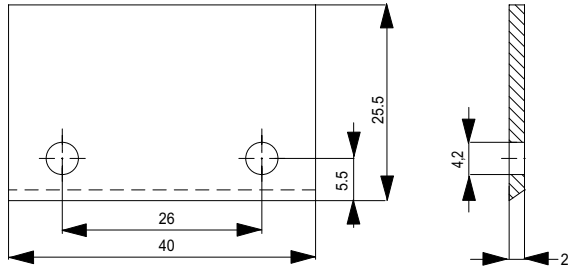
K



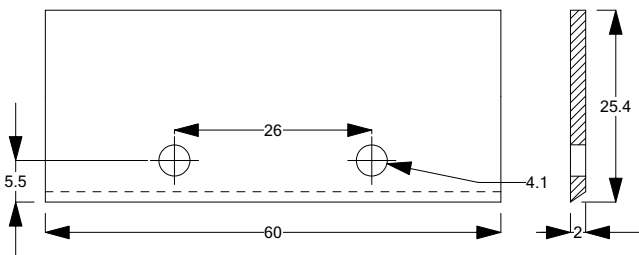
Part No.	W x H x T	Grade	Qty.
4748	40x25.4x2	GP	1



Part No.	W x H x T	Grade	Qty.
4852	53x30.5x2	GP	1

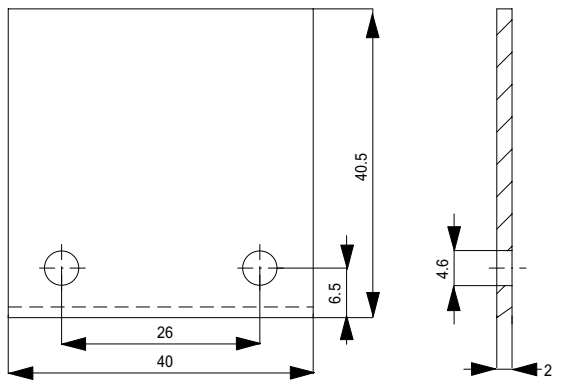


Part No.	W x H x T	Grade	Qty.
4842	40x25.5x2	MM-MDF	1

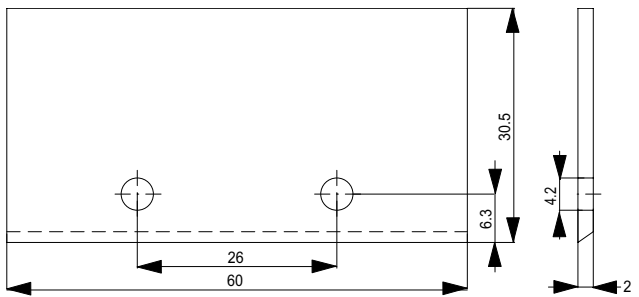


Part No.	W x H x T	Grade	Qty.
6357	60x25.4x2	GP	1

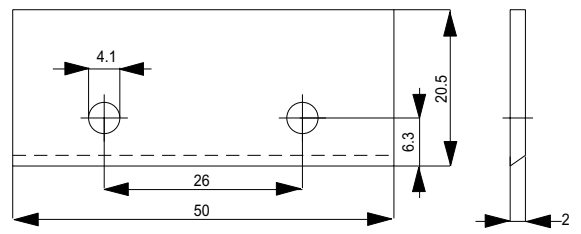
Part No.	W x H x T	Grade	Qty.
6358	60x25.4x2	HNW	1



Part No.	W x H x T	Grade	Qty.
4848	40x40.5x2	GP	1



Part No.	W x H x T	Grade	Qty.
4750	60x30.5x2	GP	1

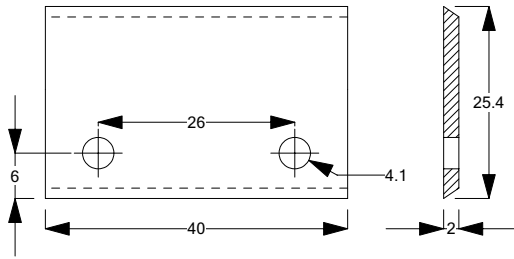


Part No.	W x H x T	Grade	Qty.
4850	50x20.5x2	GP	1

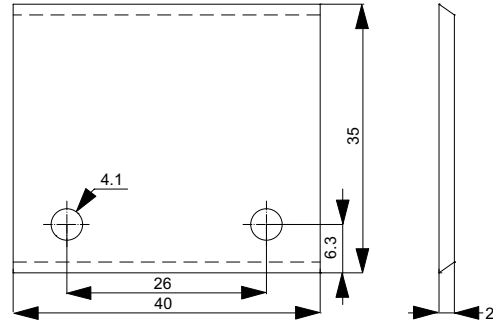
NOTE: Use the drawings and specifications to exactly match the inserts you require.  
 CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Beveled Top & Bottom Carbide Insert Blanks

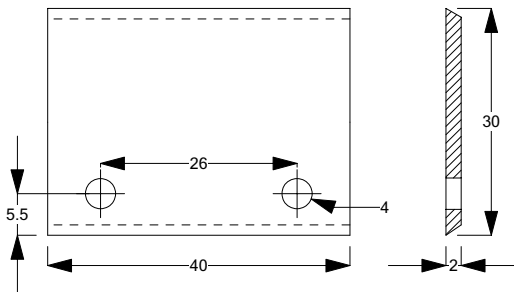
Non-turnable blanks – 2 mounting holes



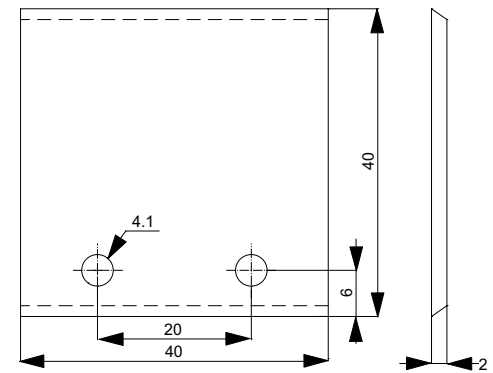
Part No.	W x H x T	Grade	Qty.
6335	40x25.4x2	GP	1



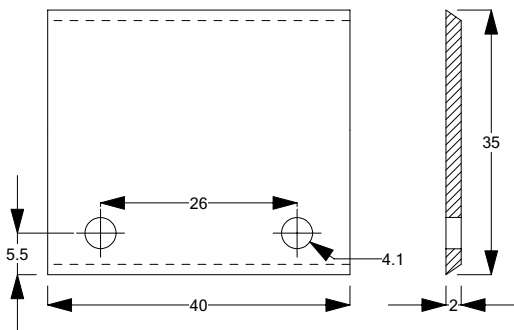
Part No.	W x H x T	Grade	Qty.
4564	40x35x2	GP	1



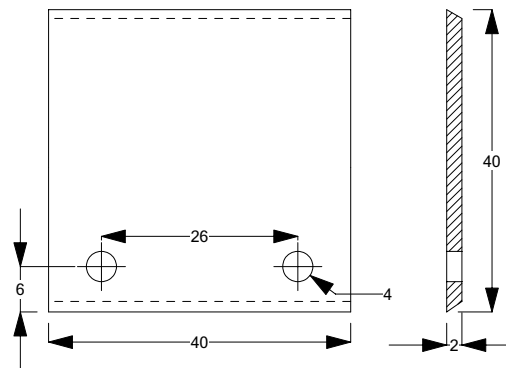
Part No.	W x H x T	Grade	Qty.
6337	40x30x2	GP	1



Part No.	W x H x T	Grade	Qty.
4774	40x40x2	GP	1



Part No.	W x H x T	Grade	Qty.
6340	40x35x2	GP	1
6341	40x35x2	HNW	1
4780	40x35x2	MM-MDF	1



Part No.	W x H x T	Grade	Qty.
5001	40x40x2	GP	1

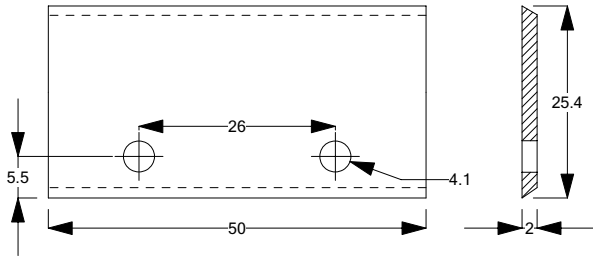
NOTE: Use the drawings and specifications to exactly match the inserts you require.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

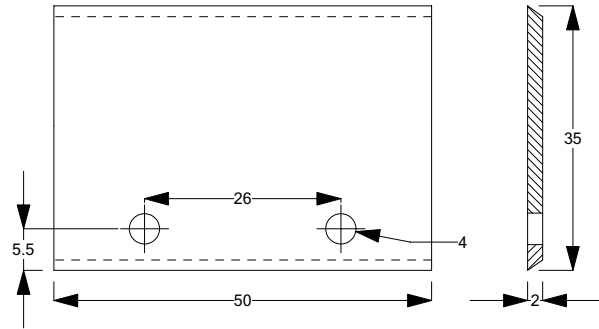
- A
- B
- C
- D
- E
- F
- G
- H
- I
- J
- K

# Beveled Top & Bottom Carbide Insert Blanks

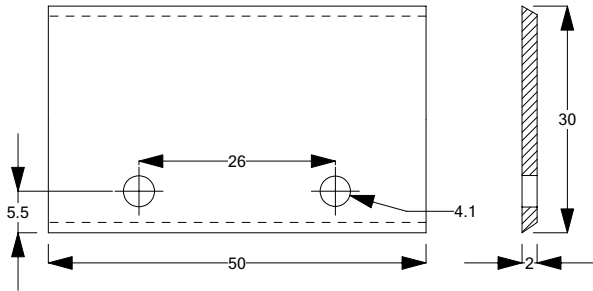
## A Non-turnable blanks – 2 mounting holes



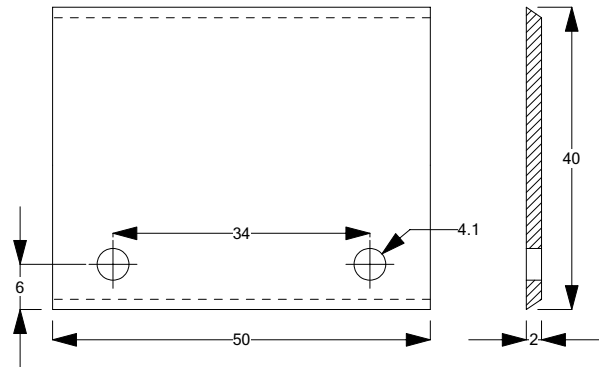
Part No.	W x H x T	Grade	Qty.
6345	50x25.4x2	GP	1



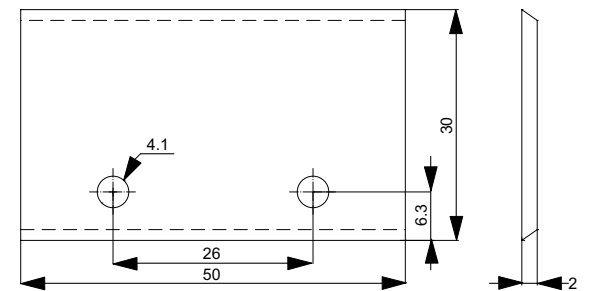
Part No.	W x H x T	Grade	Qty.
6354	50x35x2	GP	1



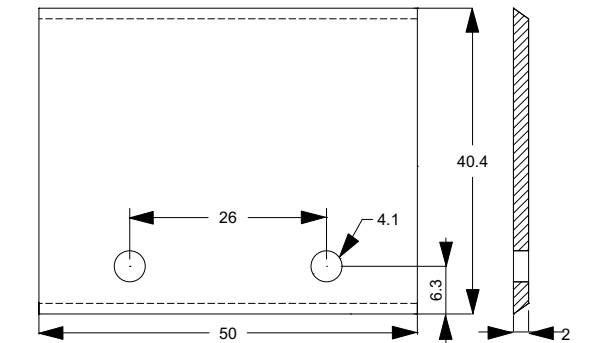
Part No.	W x H x T	Grade	Qty.
6350	50x30x2	GP	1
6351	40x35x2	HNW	1



Part No.	W x H x T	Grade	Qty.
5015Q	50x40x2	GP	1



Part No.	W x H x T	Grade	Qty.
4580	50x30x2	GP	1



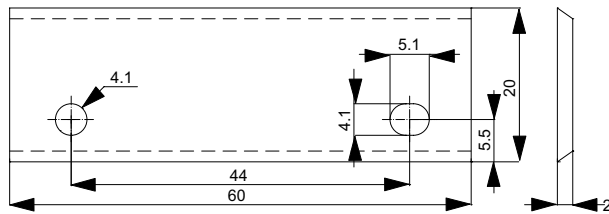
Part No.	W x H x T	Grade	Qty.
5016	50x40.4x2	GP	1

NOTE: Use the drawings and specifications to exactly match the inserts you require.

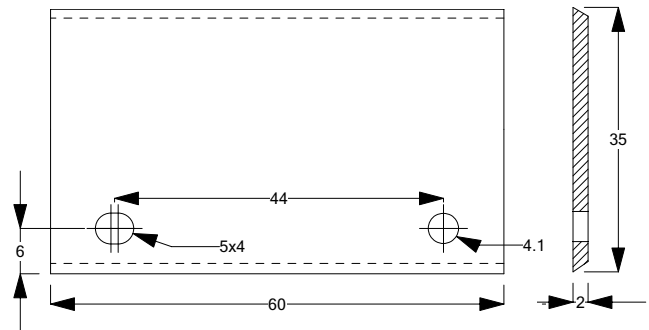
CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Beveled Top & Bottom Carbide Insert Blanks

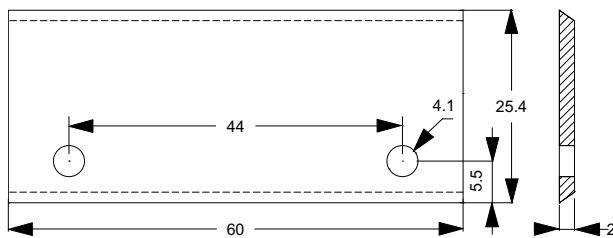
Non-turnable blanks – 2 mounting holes



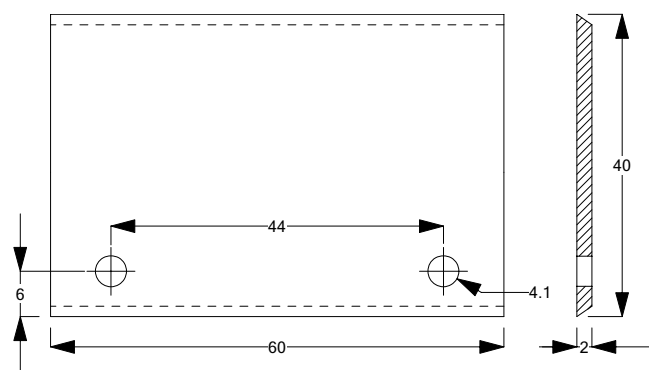
Part No.	W x H x T	Grade	Qty.
4596	60x20x2	GP	1



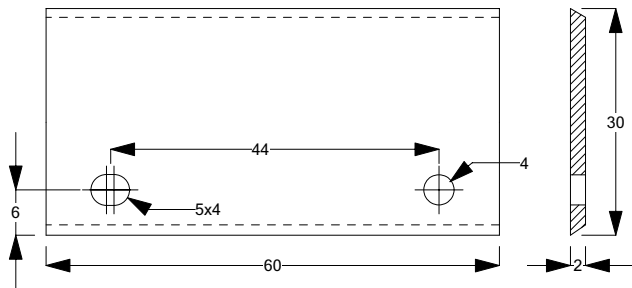
Part No.	W x H x T	Grade	Qty.
6363	60x35x2	GP	1



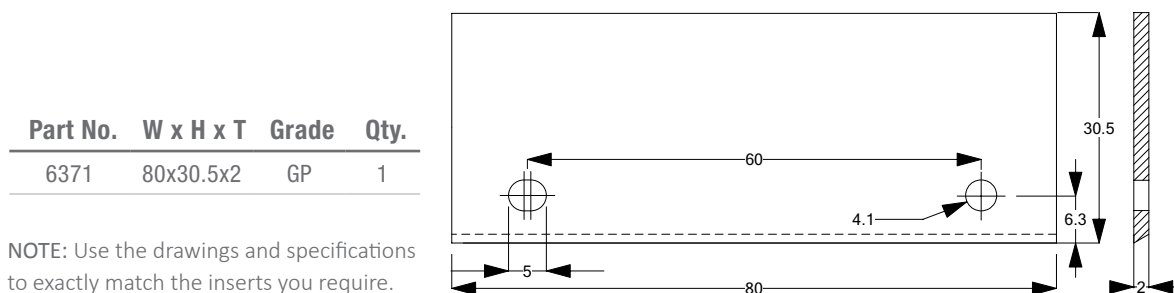
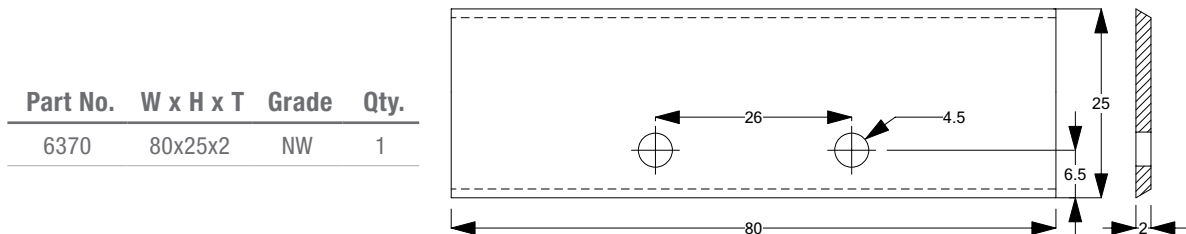
Part No.	W x H x T	Grade	Qty.
6359	60x25.4x2	GP	1



Part No.	W x H x T	Grade	Qty.
6360	60x40x2	GP	1
6361	60x40x2	HNW	1



Part No.	W x H x T	Grade	Qty.
6364	60x30x2	GP	1



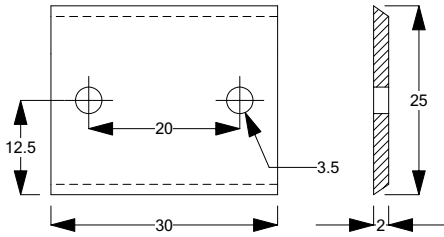
NOTE: Use the drawings and specifications to exactly match the inserts you require.



# Beveled Top & Bottom Carbide Insert Blanks

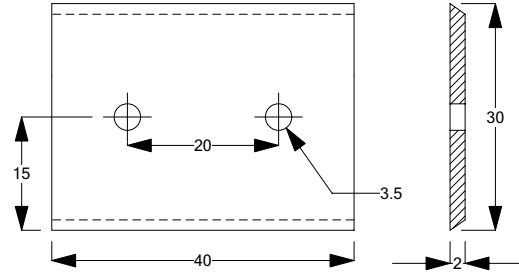
## Turnable blanks – 2 mounting holes

A



Part No.	W x H x T	Grade	Qty.
6465	30x25x2	GP	1

B



Part No.	W x H x T	Grade	Qty.
6485	40x30x2	GP	1

C

D

E

F

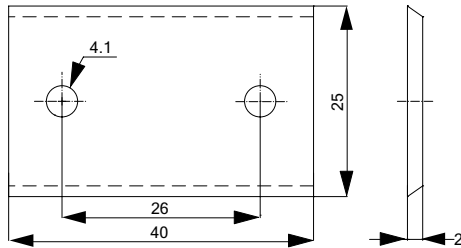
G

H

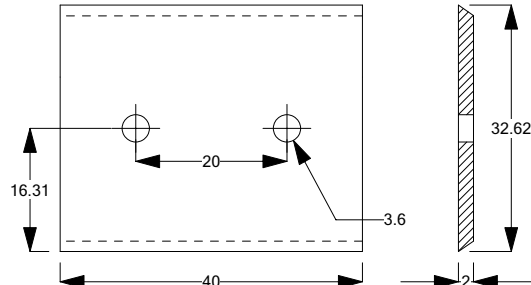
I

J

K

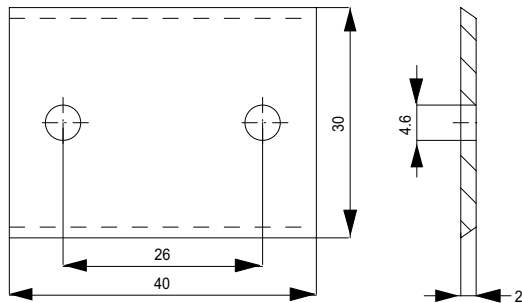


Part No.	W x H x T	Grade	Qty.
4754	40x25x2	GP	1

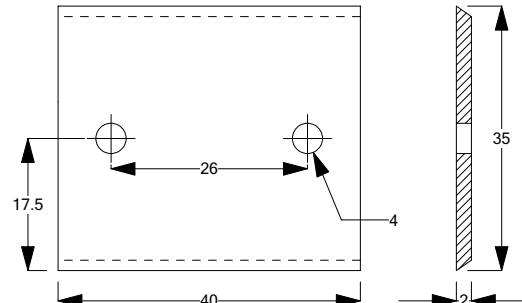


Part No.	W x H x T	Grade	Qty.
6490	50x30x2	GP	1

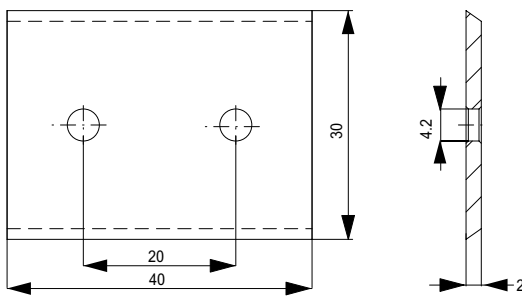
Part No.	W x H x T	Grade	Qty.
6491	40x35x2	NW	1



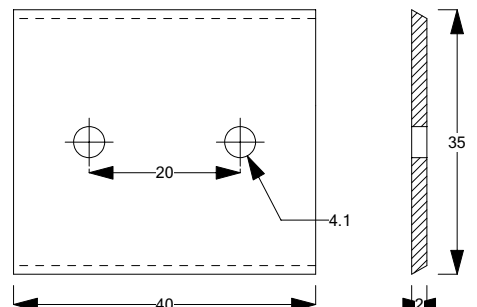
Part No.	W x H x T	Grade	Qty.
4860	40x30x2	GP	1



Part No.	W x H x T	Grade	Qty.
6495	40x35x2	GP	1



Part No.	W x H x T	Grade	Qty.
4858	40x30x2	GP	1



Part No.	W x H x T	Grade	Qty.
5012	40x35x2	GP	1

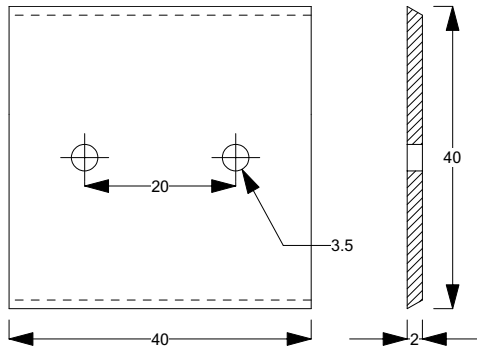
NOTE: Use the drawings and specifications to exactly match the inserts you require.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

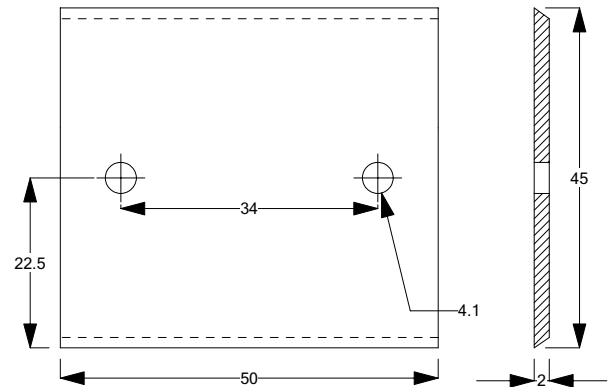


# Beveled Top & Bottom Carbide Insert Blanks

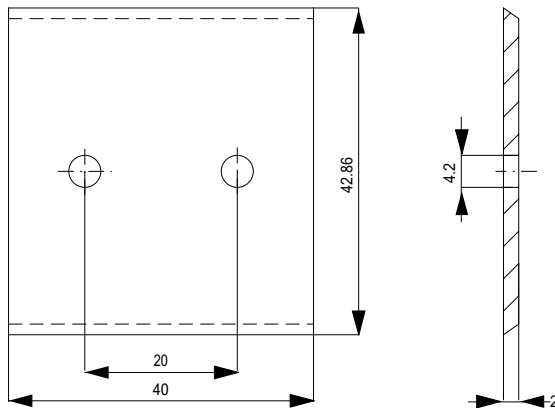
Turnable blanks – 2 mounting holes



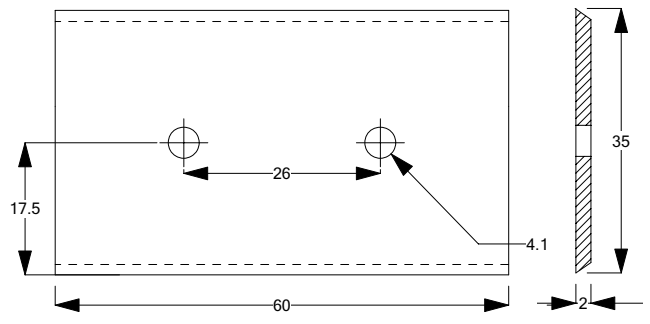
Part No.	W x H x T	Grade	Qty.
5011	40x40x2	GP	1



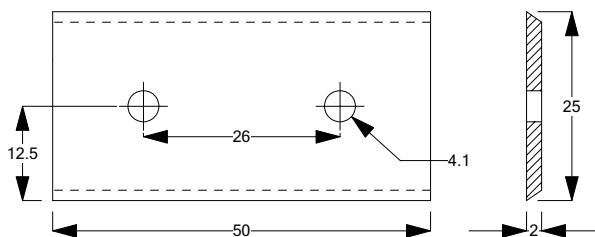
Part No.	W x H x T	Grade	Qty.
6520	50x45x2	GP	1



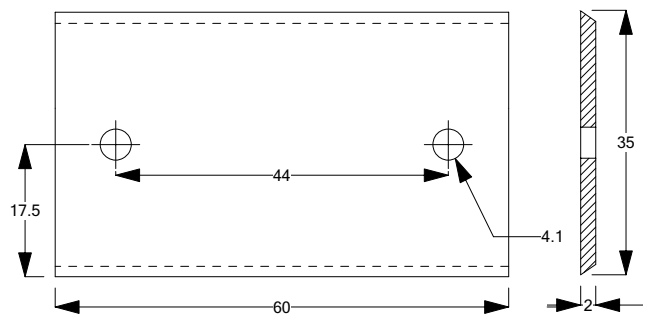
Part No.	W x H x T	Grade	Qty.
4856	40x42.86x2	GP	1



Part No.	W x H x T	Grade	Qty.
6540	60x35x2	GP	1



Part No.	W x H x T	Grade	Qty.
6515	50x25x2	GP	1



Part No.	W x H x T	Grade	Qty.
6545	60x35x2	GP	1

NOTE: Use the drawings and specifications to exactly match the inserts you require.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

- A
- B
- C
- D
- E
- F
- G
- H
- I
- J
- K

# Beveled Top & Bottom Carbide Insert Blanks

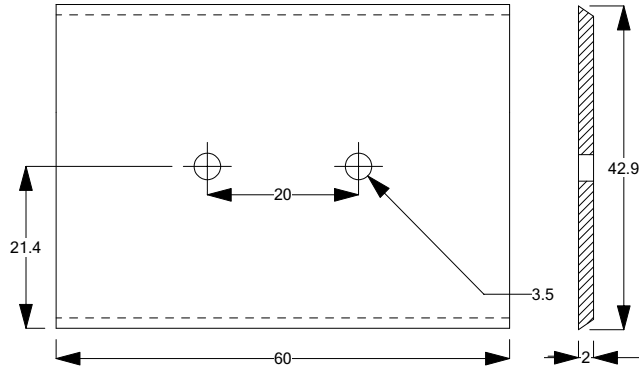
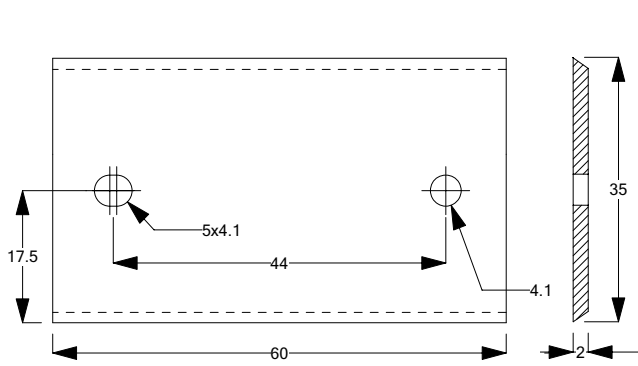
## A Turnable blanks – 2 mounting holes

B

C

D

E



F

Part No.	W x H x T	Grade	Qty.
6547	60x35x2	HNW	1
6549	60x35x2	NW	1

Part No.	W x H x T	Grade	Qty.
6550	60x42.9x2	GP	1

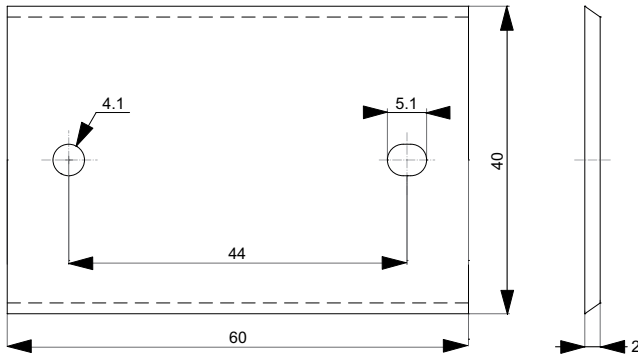
G

H

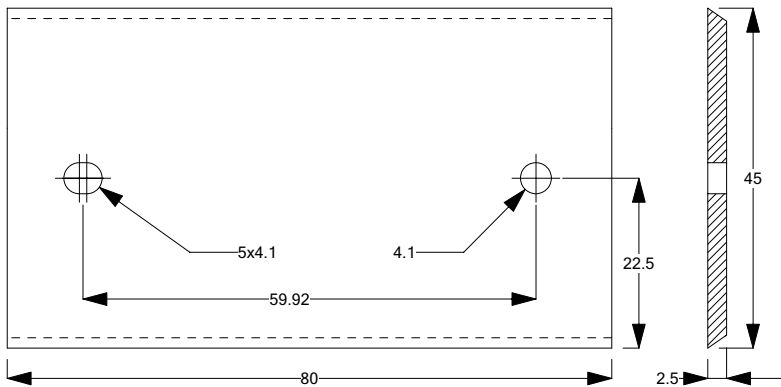
I

J

K



Part No.	W x H x T	Grade	Qty.
4560	60x40x2	GP	1

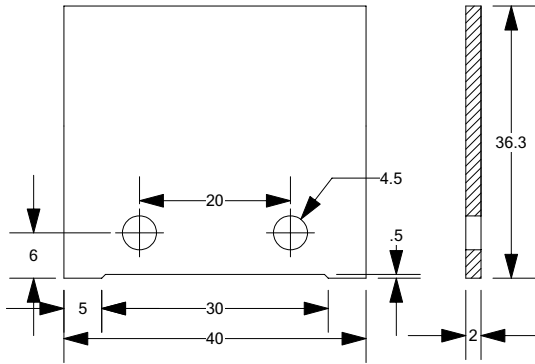


Part No.	W x H x T	Grade	Qty.
6375	80x45x2.5	GP	1

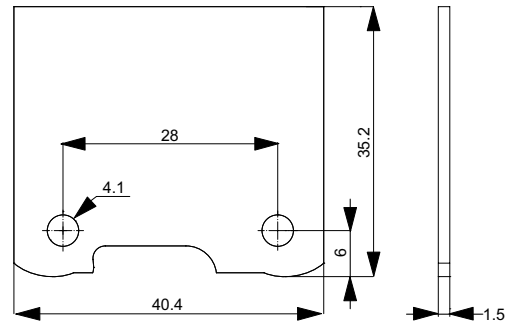
NOTE: Use the drawings and specifications to exactly match the inserts you require.  
 CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Special / Leuco<sup>®</sup> Carbide Insert Blanks

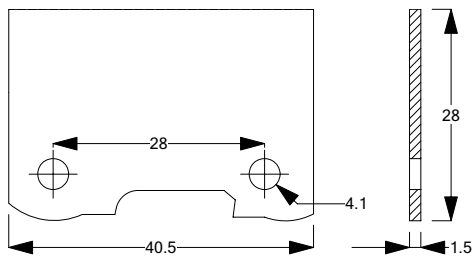
## Non-turnable blanks – 2 mounting holes



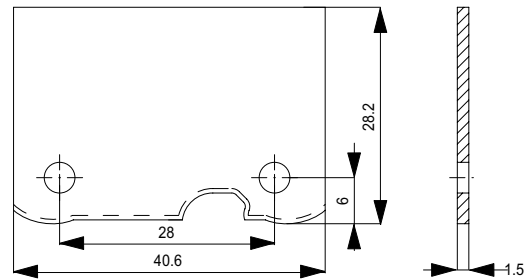
Part No.	W x H x T	Grade	Qty.
6650	40x36.3x2	GP	1



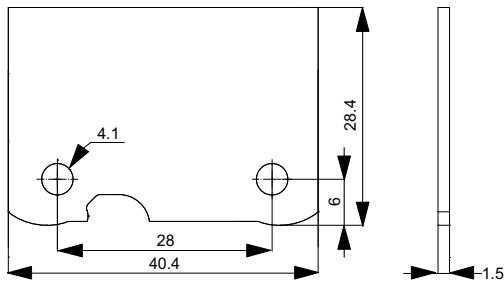
Part No.	W x H x T	Grade	Qty.
4572	40.4x35.2x1.5	GP	1



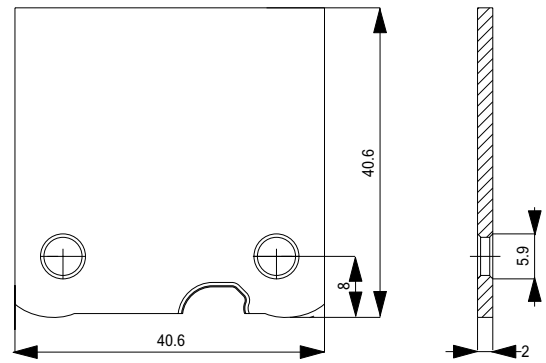
Part No.	W x H x T	Grade	Qty.
6175	40.5x28x1.5	GP	1



Part No.	W x H x T	Grade	Qty.
4784	40.6x28x1.5	GP	1



Part No.	W x H x T	Grade	Qty.
4758	40.6x28x1.5	NW	1



Part No.	W x H x T	Grade	Qty.
4866	40.6x40.6x2	NW	1

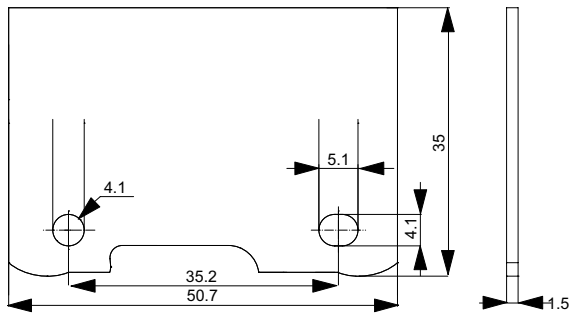
NOTE: Use the drawings and specifications to exactly match the inserts you require.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

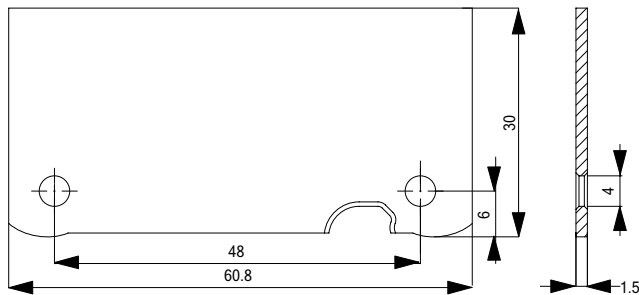
- A
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- D
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- J
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# Special / Leuco® Carbide Insert Blanks

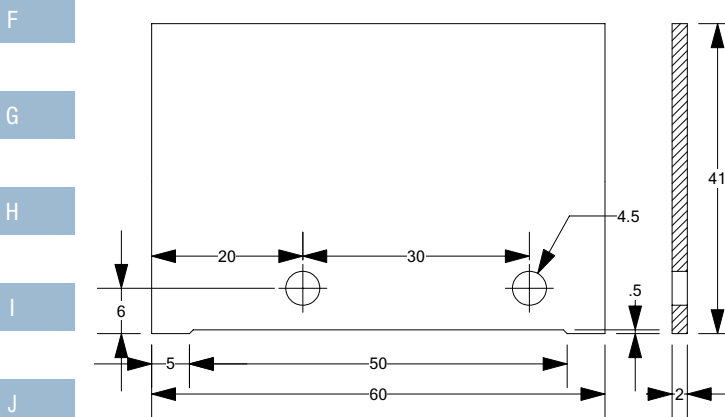
## A Non-turnable blanks – 2 mounting holes



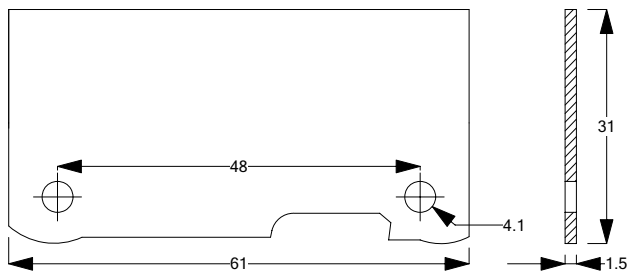
Part No.	W x H x T	Grade	Qty.
4570	50.7x35x1.5	GP	1



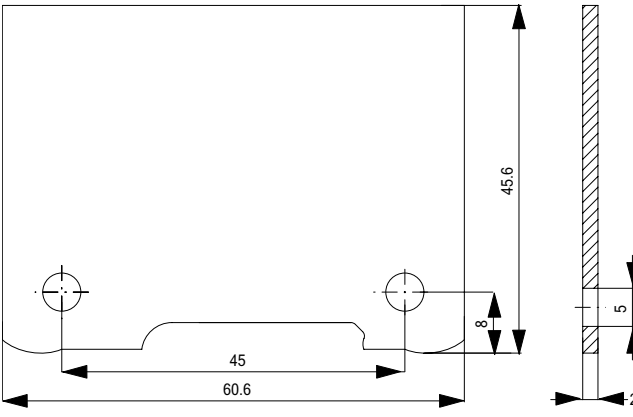
Part No.	W x H x T	Grade	Qty.
4864	60.8x30x1.5	NW	1



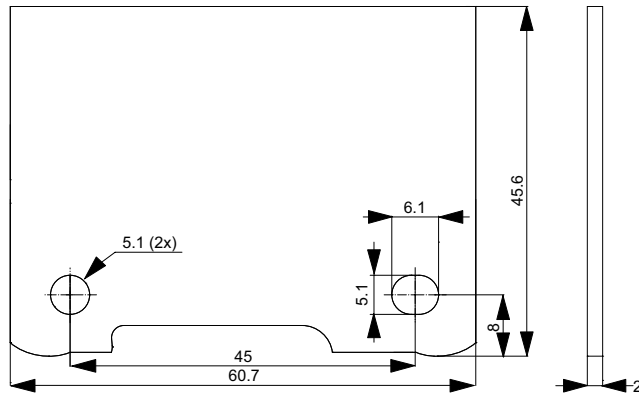
Part No.	W x H x T	Grade	Qty.
6660	60x41x2	GP	1



Part No.	W x H x T	Grade	Qty.
6180	61x31x2	GP	1

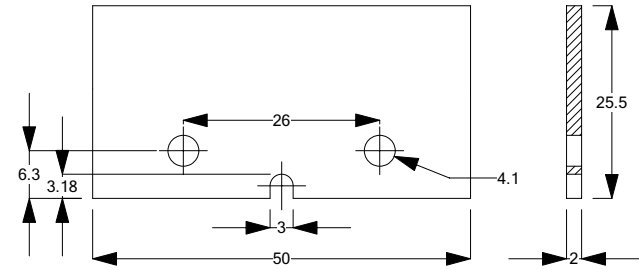


Part No.	W x H x T	Grade	Qty.
4862	60.6x45.6x2	GP	1



Part No.	W x H x T	Grade	Qty.
6186	60.7x45.6x2	NW	1

## Special carbide blank – 2 holes, 20-50mm

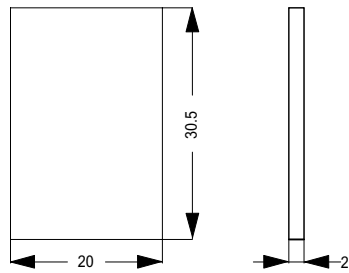


Part No.	W x H x T	Grade	Qty.
6347	50x25.5x2	GP	1

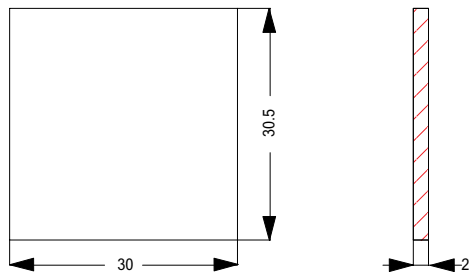
NOTE: Use the drawings and specifications to exactly match the inserts you require.  
 CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Jonalloy® Flat Bottom Insert Blanks

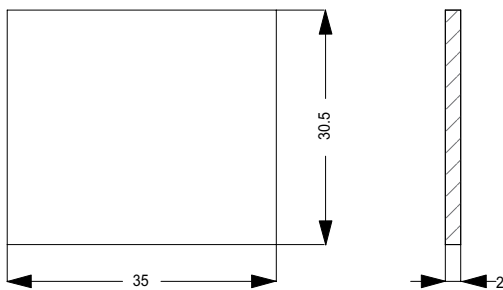
## Jonalloy® Non-turnable, No Holes



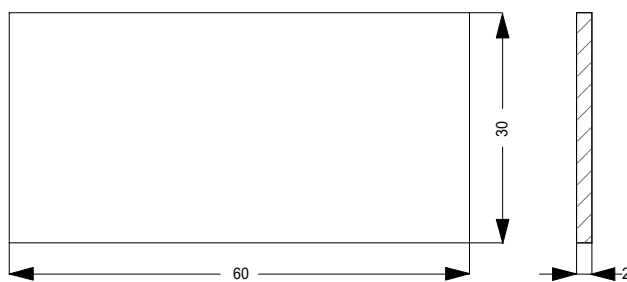
Part No.	W x H x T	Grade	Qty.
4798	20x30.5x2	NAW	1



Part No.	W x H x T	Grade	Qty.
4800	30x30.5x2	NAW	1

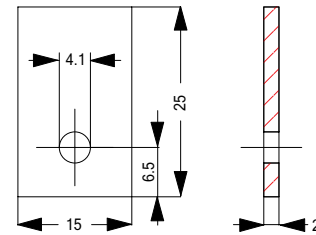


Part No.	W x H x T	Grade	Qty.
4802	35x30.5x2	NAW	1

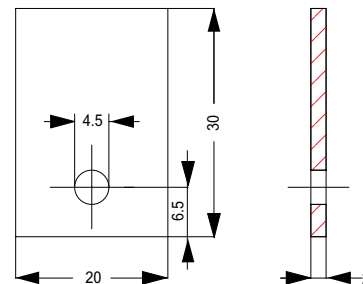


Part No.	W x H x T	Grade	Qty.
4796	60x30x2	NAW	1

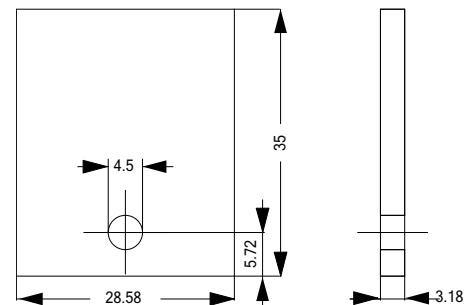
## Jonalloy® Non-turnable, 1 Hole



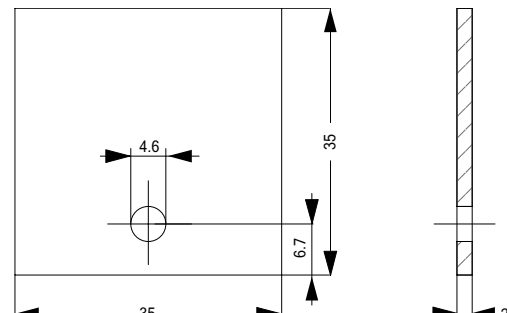
Part No.	W x H x T	Grade	Qty.
4616	15x25x2	NAW	1



Part No.	W x H x T	Grade	Qty.
4618	20x30x2	NAW	1



Part No.	W x H x T	Grade	Qty.
4622	28.58x35x3.18	NAW	1



Part No.	W x H x T	Grade	Qty.
4620	35x35x2	NAW	1

NOTE: Use the drawings and specifications to exactly match the inserts you require.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Jonalloy® Flat Bottom Insert Blanks

A

Jonalloy® Non-turnable, 2 Holes

B

C

D

E

F

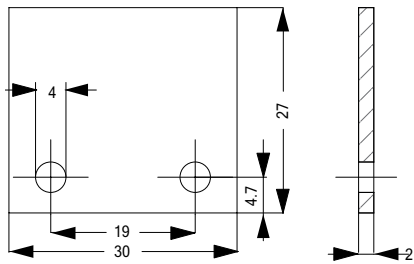
G

H

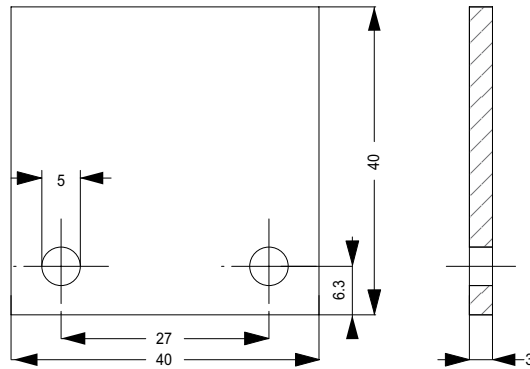
I

J

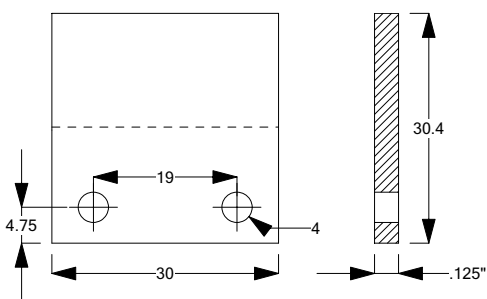
K



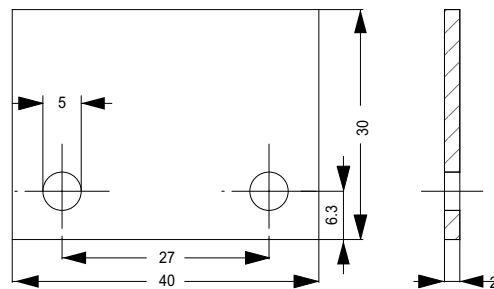
Part No.	W x H x T	Grade	Qty.
4830	30x27x2	NAW	1



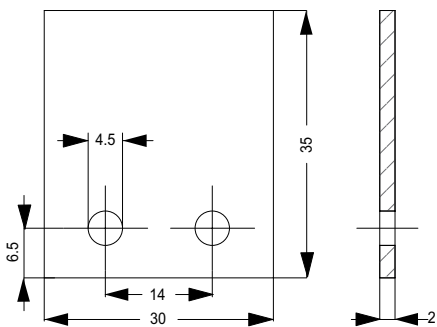
Part No.	W x H x T	Grade	Qty.
4688	40x40x3	NAW	1



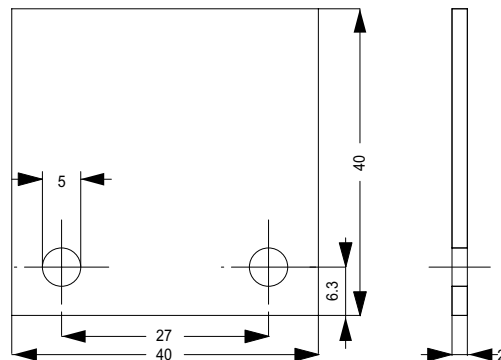
Part No.	W x H x T	Grade	Qty.
4079	30x30.4x.125"	NAW	1



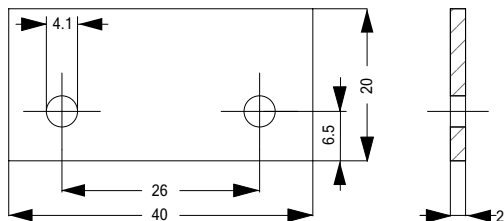
Part No.	W x H x T	Grade	Qty.
4678	40x30.2x2	NAW	1



Part No.	W x H x T	Grade	Qty.
4690	30x35x2	NAW	1



Part No.	W x H x T	Grade	Qty.
4682	40x40.2x2	NAW	1



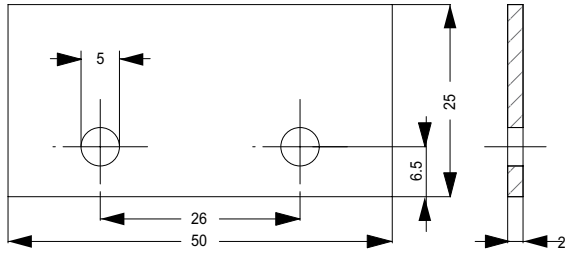
Part No.	W x H x T	Grade	Qty.
4828	40x20x2	NAW	1

NOTE: Use the drawings and specifications to exactly match the inserts you require.

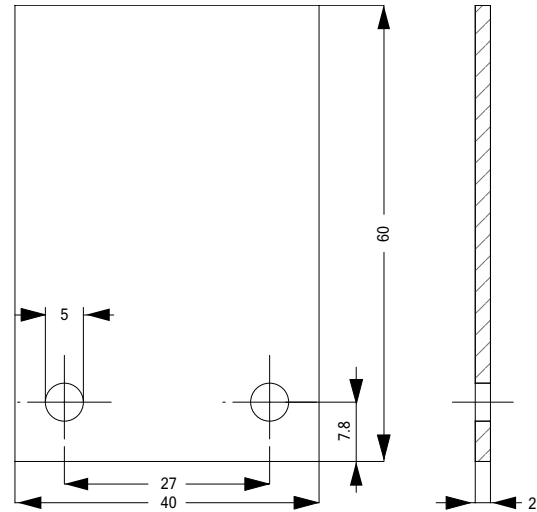
CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Jonalloy® Flat Bottom Insert Blanks

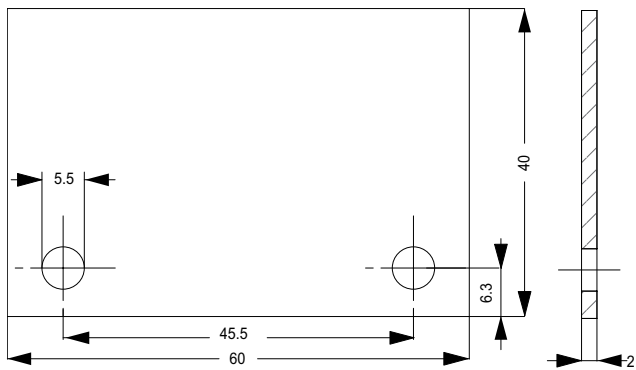
## Jonalloy® Non-turnable, 2 Holes



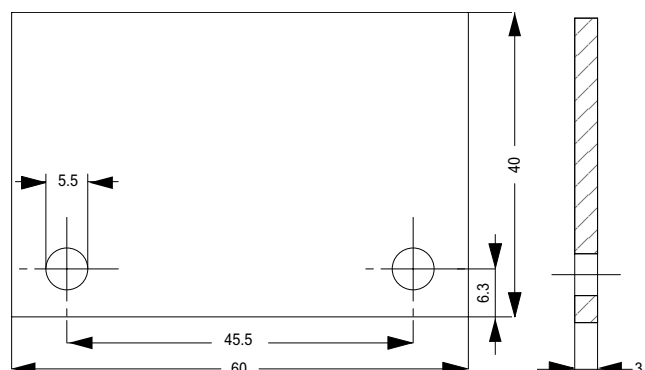
Part No.	W x H x T	Grade	Qty.
4680	50x25x2	NAW	1



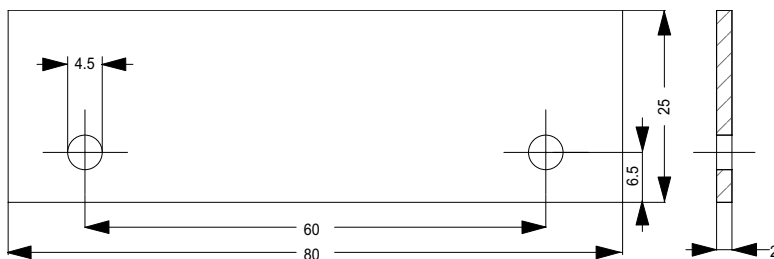
Part No.	W x H x T	Grade	Qty.
4684	40x60x2	NAW	1



Part No.	W x H x T	Grade	Qty.
4686	60x40x2	NAW	1



Part No.	W x H x T	Grade	Qty.
4826	60x40x3	NAW	1



Part No.	W x H x T	Grade	Qty.
4692	80x25x2	NAW	1

NOTE: Use the drawings and specifications to exactly match the inserts you require.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

- A
- B
- C
- D
- E
- F
- G
- H
- I
- J
- K

# Jonalloy® Beveled Bottom Insert Blanks

## Jonalloy® Non-turnable, 1 Hole

A

B

C

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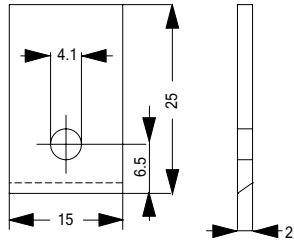
G

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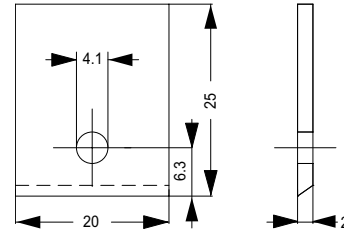
I

J

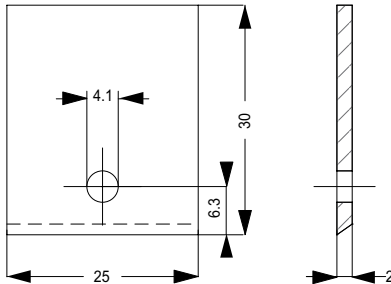
K



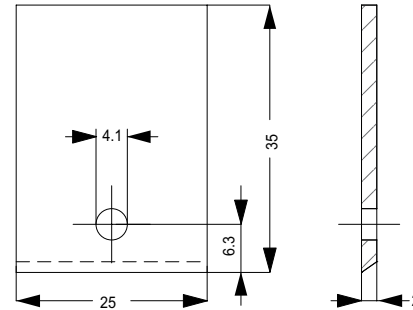
Part No.	W x H x T	Grade	Qty.
4732	15x25x2	NAW	1



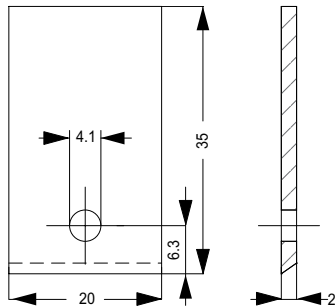
Part No.	W x H x T	Grade	Qty.
4734	20x25x2	NAW	1



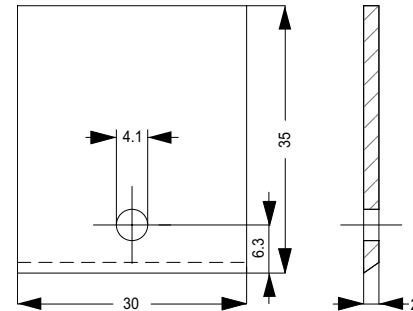
Part No.	W x H x T	Grade	Qty.
4740	25x30x2	NAW	1



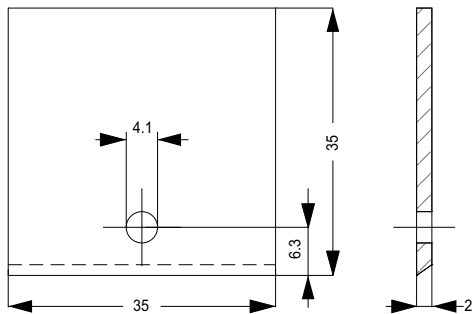
Part No.	W x H x T	Grade	Qty.
4838	25x35.4x2	NAW	1



Part No.	W x H x T	Grade	Qty.
4840	20x35x2	NAW	1



Part No.	W x H x T	Grade	Qty.
4736	30x35x2	NAW	1



Part No.	W x H x T	Grade	Qty.
4738	35x35x2	NAW	1

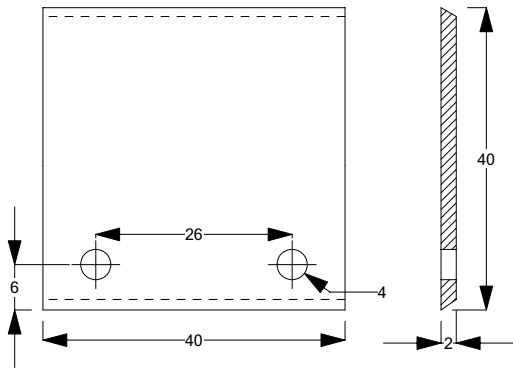
NOTE: Use the drawings and specifications to exactly match the inserts you require.

CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

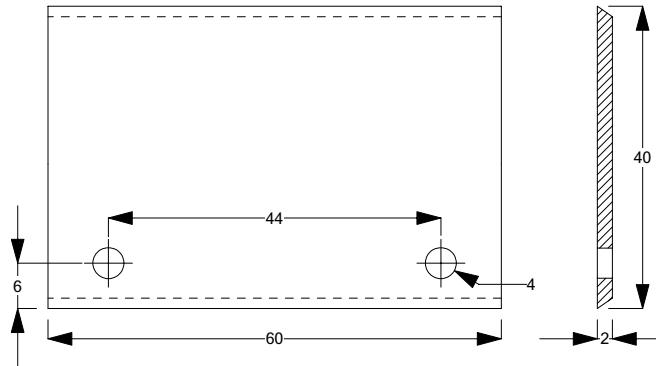


# Jonalloy® Beveled Bottom Insert Blanks

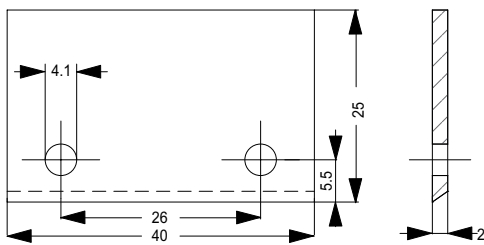
## Jonalloy® Non-turnable, 2 Holes



Part No.	W x H x T	Grade	Qty.
4001	40x40x2	NW	1

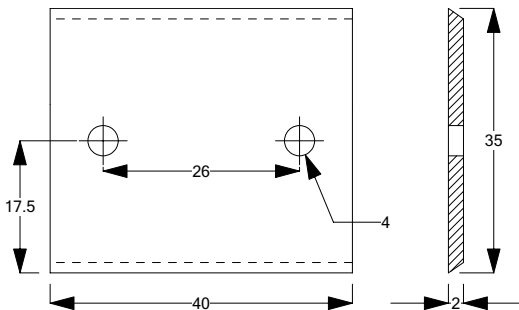


Part No.	W x H x T	Grade	Qty.
4360	60x40x2	NW	1



Part No.	W x H x T	Grade	Qty.
4854	40x25x2	NAW	1

## Jonalloy® Turnable, 2 Holes



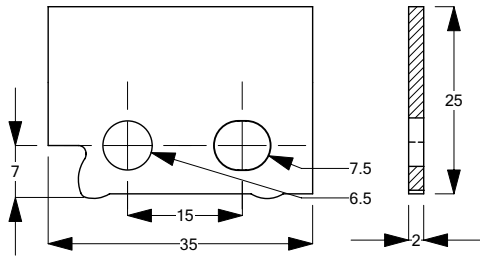
Part No.	W x H x T	Grade	Qty.
4495	40x35x2	NW	1

NOTE: Use the drawings and specifications to exactly match the inserts you require.

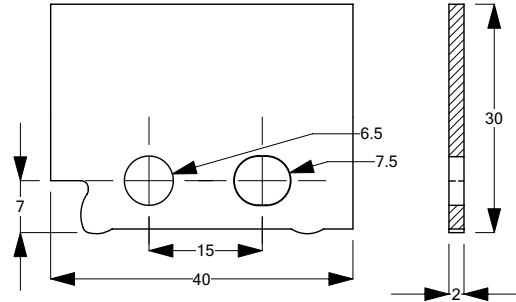
CARBIDE GRADE: GP - General Purpose, MM - Man-Made, NW - Natural Wood, NAW - Non-Abrasive Wood, HNW - HI Natural Wood, SW - Soft Wood. See catalog pages for available grades.

# Face Mount Inserts for Cutterheads

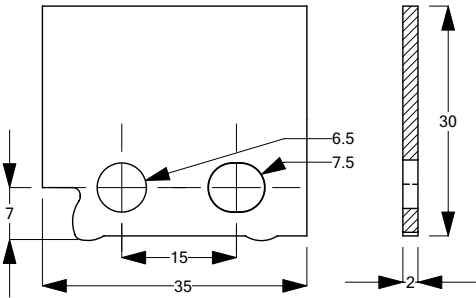
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- G
- H
- I
- J
- K



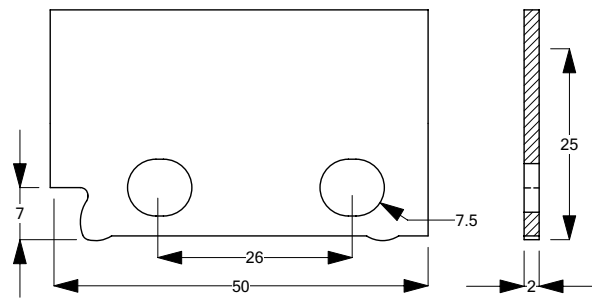
Part No.	W x H x T	Grade	Qty.
5320	35x25x2	GP	1



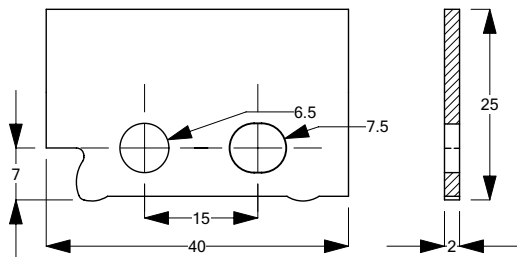
Part No.	W x H x T	Grade	Qty.
5329	40x30x2	GP	1



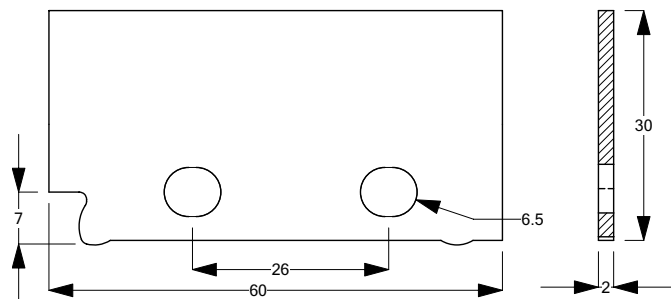
Part No.	W x H x T	Grade	Qty.
5321	35x30x2	GP	1



Part No.	W x H x T	Grade	Qty.
5337	50x25x2	GP	1

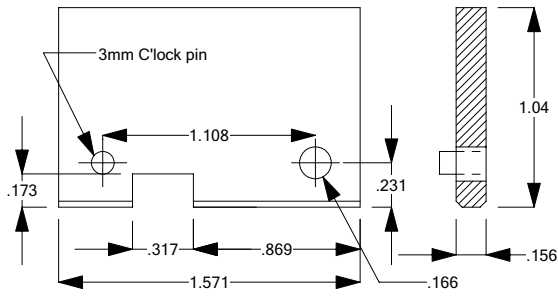


Part No.	W x H x T	Grade	Qty.
5328	40x25x2	GP	1

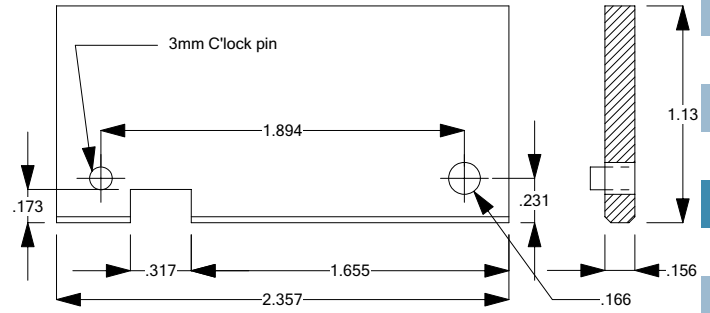


Part No.	W x H x T	Grade	Qty.
5344	60x30x2	GP	1

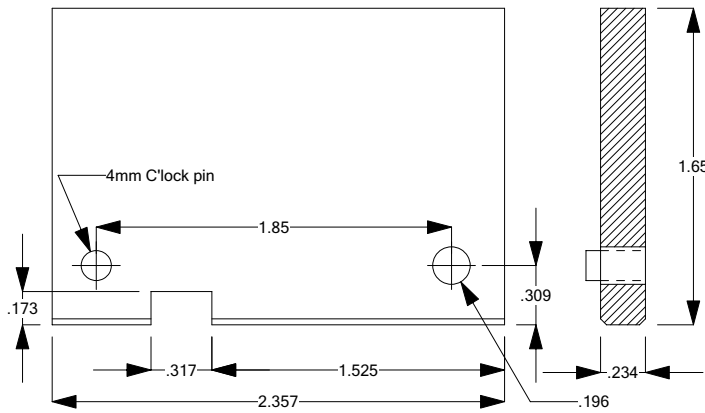
# Backing Plates for Leuco® Heads



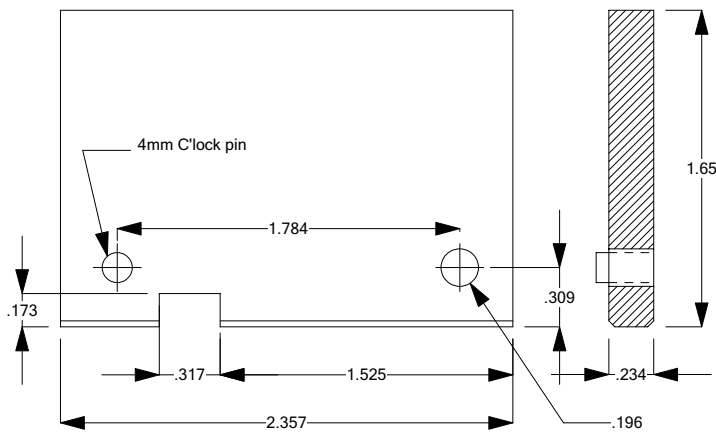
**Part No.** 6175BP  
**Dimensions W x H x T** 1.571x1.04x.156



**Part No.** 6180BP  
**Dimensions W x H x T** 2.357x1.13x.156



**Part No.** 66012BP  
**Dimensions W x H x T** 2.357x1.65x.234



**Part No.** 66020BP  
**Dimensions W x H x T** 2.357x1.65x.234

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# Serrated Backing Plates

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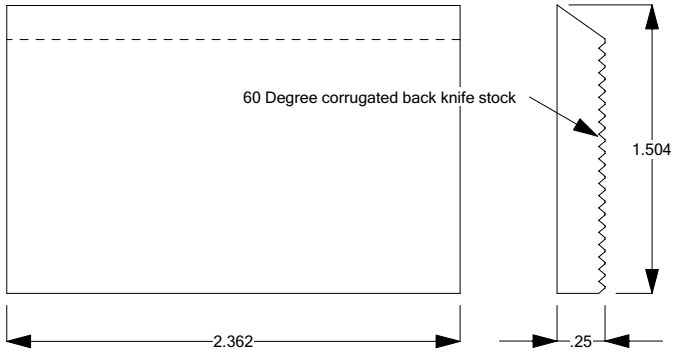
B

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Part No.	Dimensions W x H x T
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66027BP	2.362x1.504x.25
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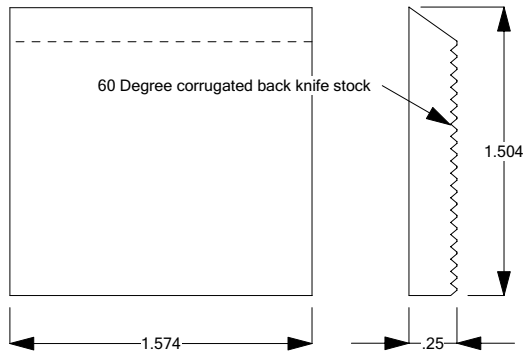
G

H

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J

K



Part No.	Dimensions W x H x T
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66028BP	1.574x1.504x.25
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