

Consumables List

Stuga Machinery Consumables List

Contents

- Parts List
- Notes on Expected Life
- Comments

Parts List

Photo	Part Number	Product Description	Autoflow	ZX5	ZX5-E	ZX4	ZX3	Flowline	Microline	Ecoline	Saw	Other Information
	V0000001	8mm Coated Cutters						✓				Coated cutters are low performance and not suitable for machines with high-speed spindles
	V0000002	5mm Coated Cutters						✓				Coated cutters are low performance and not suitable for machines with high-speed spindles
	V0000012	10mm Coated Cutters						✓				Coated cutters are low performance and not suitable for machines with high-speed spindles

	V0000013	12.7mm Coated Cutters						✓				Coated cutters are low performance and not suitable for machines with high-speed spindles
	V0000039	4mm Coated Cutters						✓				Coated cutters are low performance and not suitable for machines with high-speed spindles
	V0000035	5mm Carbide Cutters (pointed end)	✓	✓	✓	✓	✓	✓	✓			
	V0000036	10mm Single Flute Carbide Cutters	✓	✓	✓	✓	✓	✓	✓	✓		
	V0000037	12.7mm Carbide Cutters	✓	✓	✓	✓	✓	✓	✓			
	V0000042	5mm Carbide Single Flute Cutters	✓	✓	✓	✓	✓	✓	✓	✓		
	V0000045	5mm Twin Flute Carbide Cutters	✓	✓	✓	✓	✓	✓	✓	✓		
	V0000046	10mm Twin Flute Carbide Cutters	✓	✓	✓	✓	✓	✓	✓	✓		
	V0000047	12.7mm Twin Flute Carbide Cutters	✓	✓	✓	✓	✓	✓	✓			
	V0000048	17mm Carbide Cutters	✓	✓	✓	✓	✓	✓	✓			
	V0000051	16mm Carbide Cutters-Quad	✓	✓	✓	✓	✓	✓	✓			
	T0000100	3mm Drill bits	✓	✓	✓	✓	✓	✓	✓			
	V0000004B	150mm ø V Notch Blades						✓		✓		
	V0000016B	200mm ø V Notch Blades	✓		✓	Z018 onwards	✓		✓	✓		
	V0000028B	300mm ø V Notch Blades				Z001 to Z016						
	V0000028B-ZX5	300mm ø ZX5 V Notch Blades		✓								
	V0000034B	400mm ø Main Saw Blade - 120 teeth		✓	✓	✓	✓	✓			✓	
	V0000043B	500mm ø Main Saw Blade - 160 teeth	✓	✓	✓	✓	✓	✓	✓		✓	Needs 500mm mechanical upgrade to suit on ZX3/4/5 Flowline & Saw

	V0000053B	500mm ø Main Saw Blade - 120 teeth	✓	✓	✓	✓	✓	✓	✓	✓	✓	Please note: less Teeth on this blade
	M0000253	Anti Slip Pads (pack 24)	✓	✓	✓	✓	✓	✓	✓	✓	✓	
	M0000454	Ring Gear Lube	✓	✓	✓	✓	✓	✓	✓	✓	✓	
	M0000493	Lubricant with siolube & ptfe-aerosol	✓	✓	✓	✓	✓	✓	✓	✓	✓	
	M0000494	Lubricant with siolube & ptfe cartridge	✓	✓	✓	✓	✓	✓	✓	✓	✓	
	M0000510	Duck Oil 5ltr	✓	✓	✓	✓	✓	✓	✓	✓	✓	
	M0001047	Grease Cartridge F03	✓									Cartridge for Auto- Lubrication System
	M0000151	Clear Poly bags	✓	✓	✓	✓	✓	✓	✓	✓	✓	
	M0000178	Extractor Filter Bag 8' x 20.5" dia.(Air Plants Extractor)	✓	✓	✓	✓	✓	✓	✓	✓	✓	Used on all new machines and refurbs since 2012
	M0000179	Extractor Filter Bag 8' x 19" Dia (original extractor)	✓			✓	✓	✓	✓	✓	✓	Original extractor has been obsolete since 2012, but still widely in use
	M0000189	Extractor Filter Bag 4' x 20.5" dia (Air Plants Extractor) ONLY IF HEIGHT REDUCED	✓	✓	✓	✓	✓	✓	✓	✓	✓	Used on all new machines and refurbs since 2012
	M0000190	Extractor Filter Bag 4' x 20" dia (original extractor) ONLY IF HEIGHT REDUCED	✓			✓	✓	✓	✓	✓	✓	Original extractor has been obsolete since 2012, but still widely in use
	M0000477	Labels for Baby Zebra Printer -White	✓	✓	✓	✓	✓	✓	✓	✓	✓	
	M0000481	Labels for Baby Zebra Printer -Blue	✓	✓	✓	✓	✓	✓	✓	✓	✓	
	M0000482	Labels for Baby Zebra Printer -Orange	✓	✓	✓	✓	✓	✓	✓	✓	✓	
	M0000483	Labels for Baby Zebra Printer -Green	✓	✓	✓	✓	✓	✓	✓	✓	✓	
	M0000484	Labels for Baby Zebra Printer -Red	✓	✓	✓	✓	✓	✓	✓	✓	✓	
	M0000485	Labels for Baby Zebra Printer -Yellow	✓	✓	✓	✓	✓	✓	✓	✓	✓	

	M0000492	Labels for Baby Zebra Printer -Grey	✓	✓	✓	✓	✓	✓	✓	✓	✓	
	D0005152	Chip Deflector Probes	✓			✓	✓	✓			✓	Only on Autoflows with Mk2 model saw backfences.
	D0010679	Autoflow Chip Deflector Probes (Mk1)	✓									
	D0015447B	Zx5 Chip Deflector Probes		✓	✓							
	D0001376	Universal gripper insert Mk9+				✓	✓	✓	✓	✓		
	E0000336	Proximity Sensor-8mm threaded	✓	✓	✓	✓	✓	✓	✓	✓	✓	
	E0000336L	Proximity Sensor-8mm threaded (longer 4mm range)		✓	✓							
	E0000079	Limit Switch - Roller Plunger				✓	✓	✓	✓	✓	✓	
	E0000161	Limit Switch -Side Rotary Roller Lever				✓	✓	✓	✓	✓		
	V0000006	Flowline Espag Drill - 10mm						✓				
	V0000007	Flowline Espag Drill - 12mm						✓				
	V0000023	R/H Flute Cutter (Router Aly)										
	V0000024	Chipbreaker Speed Cutter -8mm										
	V0000025	Chipbreaker -10mm										
	V0000026	Chipbreaker -12.7mm										
	B0000025	Saw blade V-Belts (400mm blade) -THERMAL suffix is used for the 987mm version for some 500mm bladesystems		✓	✓	✓	✓	✓	✓		✓	Pulley size differences mean there are 2 possible belt sizes for 500mm blade
	B0001175	Saw blade V-Belts (500mm blade)		✓	✓	✓	✓	✓			✓	Pulley size differences mean there are 2 possible belt sizes for 500mm blade
	B0000071	V-notch spindle V-belts (5 rib)			✓							Used only on Router
	B0000115	Spindle V belts (5 rib)										Used only on Flowline Mk3 50Hz Blue motor
	B0001041	Vee Belt SPZX 0900	✓									Autoflow saw belt

Notes on Expected Life

Tooling life depends entirely on the type and amount of operations carried out at a particular manufacturer and can vary greatly.

Main Saw Blade (400 or 500mm)

- Change for a sharpened blade every 100 hours of production
- Have a blade change and sharpening regime
- Generally, a blade can be sharpened around 25 times before disposal - this will vary depending on the sharpening 3rd party supplier

V Notch Saw Blades (150, 200 or 300mm)

- Chipping can occur if a saw blade is too sharp - may need "back polishing" with emery cloth or stone
- Life expectancy - 6 months

Tooling

- Tool cut speed will affect tool life, along with profile factors such as pre-inserted plastic reinforcing, the chemistry of the profile and the number of webs the cutter has to cut through
- Drainage cutter life depends on the use - eg upstand removal - all profile systems are different
- Pre-reinforced profile has a huge, unpredictable effect on tooling life - see Use of Reinforcing on Stuga Machines
- Tool life is impossible to predict - signs that the tool is wearing will be a noticeable change in tone of the cutter or stalling while cutting "heavy" cuts such as trickle vents through multiple skins