

FEED ROLLERS “101”

Wood Tech recognizes the importance of having the right roller for the job. That’s why we offer the industry’s largest selection of feed roller options. Whether it’s steel, bonded or replaceable urethane rollers: we’ve got the solutions you need!

The feed system is intregally related to a moulder’s or stock feeder’s performance and resulting surface quality. Wood that is fed smoothly and evenly will improve finished product. Wood cannot properly be fed with feed rollers that slip or jam.

Steel feed rollers are available in a variety of tooth configurations, depending on the application. Most steel rollers can be resharpened to extend their life and enhance their performance. We specialize in sharpening worn steel rollers. We also offer hardening and hard chroming services for even more improved service. Wood Tech can also custom fabricate special rollers to your specifications.

Urethane rollers are used where scant materials are used, or marring is an issue. Rollers can either be bonded to a hub, or replaced on a reuseable hub system.

Durometers of urethane tires represent the hardness of the material. 50 is soft and 90 is harder. Urethane is color coded for easier identification. Softer rollers provide better traction, but will wear out more quickly.

Here are some guidelines:

- Moulder (Thru-Feed) 80 (orange) or 85 (green) durometer
- Moulder (Push-Feed) 85 (green) or 90 (red) durometer
- Power Stock feeders (Rough stock) 70 (yellow) durometer
- Power Stock feeders (Smooth stock) 50 (dark green) durometer



HELPFUL HINTS:

1. Feed pressure of 30-50 PSI is recommended by most machine manufacturers. Use only the pressure needed. More is not always better!
2. Proper machine alignment requires less pressure to feed the wood through the machine.
3. Steel rollers, like cutting tools, need to be sharp in order to do their job properly.
4. Resharpened steel rollers must be ground to the same diameter to feed properly. This also alleviates wear-and-tear on the gear box drive. *Equate that to the damage to your drive train from running different size tires on your car!*
5. Use denatured alcohol or lacquer thinner to clean or soften tires for better grip.



Knurled and other tooth styles available

