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SALESTECH



Nesting tools
Catalogue

2016
2017



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AKE is a family-run, medium-sized company with international orientation. Our position offers decisive advantages to our customers. They meet the versatility and competence of a big company and take advantage of the promptness and flexibility of a small firm. Our specialisation, the proverbial precision, the innovative approach and a huge wealth of experience help our customers to gain the top.

Since 1960 AKE has been standing for highest quality in industry and crafts. AKE today - is one of the leading manufacturers of circular saw blades and cutting tools worldwide.

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Nesting cutter



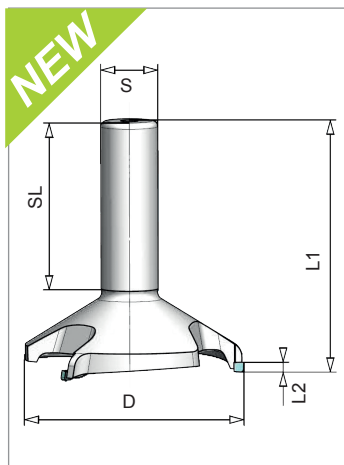
APPLICATION:	Special design for nesting
MATERIAL:	Solid wood and wood based panel material
MACHINE:	Stationary CNC machines, favoured for special nesting CNC machines
DESIGN:	Solid TC nesting cutter for high speed cutting; rpm up to 36.000, feed-speed over 15 m/min for use in collet chucks and shrink chucks; shank 12 mm for use in precision chucks

	D mm	L2 mm	UC mm	DC mm	S mm	L1 mm	Z	Order No.
NEW	9,5 (3/8")	22,0	9,7	12,3	9,5 (3/8")	75	2	10200160
NEW	9,5 (3/8")	22,0	9,7	12,3	9,5 (3/8")	75	3	10199571
NEW	9,5 (3/8")	28,0	9,7	12,3	12 (0,393")	90	2	10200163
NEW	9,5 (3/8")	28,0	9,7	12,3	12 (0,393")	90	3	10200164
NEW	10 (0,375")	22,0	9,7	12,3	10 (0,375")	75	2	10200161
NEW	10 (0,375")	22,0	9,7	12,3	10 (0,375")	75	3	10200162
NEW	10 (0,375")	28,0	9,7	18,3	12 (0,393")	90	2	10200165
NEW	10 (0,375")	28,0	9,7	18,3	12 (0,393")	90	3	10200166
NEW	12 (0,393")	38,0	16,7	21,3	12 (0,393")	90	3	10200167
NEW	16 (0,472")	45,0	16,7	28,7	16 (0,472")	100	3	10200168

UC = up cut
DC = down cut

Surface planing cutter

DP tipped



APPLICATION:

Cutting work tops on stationary CNC machines

MATERIAL:

MDF and wood based panels

MACHINE:

Stationary CNC machines

DESIGN:

Standard: shank type cutter for high speed surface planing

Plus System: extra stable design for more feed speed and best surface for use with HSK Plus or SK 30 Plus chuck System.

DP-Tips with small edge radius for a long life time

Standard - cutter with shank

	D mm	L2 mm	S mm	SL mm	L1 mm	Z	Order No.
NEW	80	3	20	50	88	3	10199042
NEW	100	3	20	50	88	4	10199043
NEW	130	3	25	50	95	5	10199045

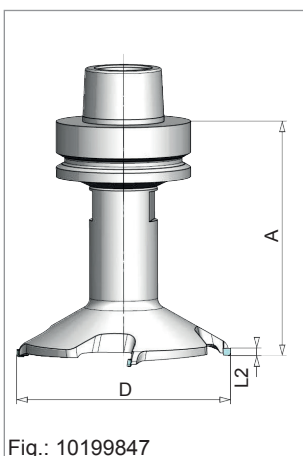


Fig.: 10199847

PLUS System - cutter for PLUS-System

	D mm	L2 mm	A mm	b	Z	Order No.
NEW	100	3	110	HSK 25 R	4	10199844
NEW	130	3	110	HSK 25 R	5	10199846

Cutter with chuck - complete HSK 63F System

	D mm	L2 mm	A mm	b	Z	Order No.
NEW	100	3	110	HSK 25 R	4	10199847
NEW	130	3	110	HSK 25 R	5	10199848

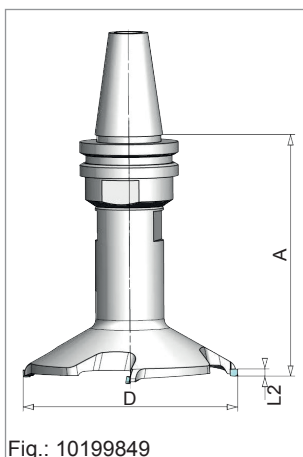


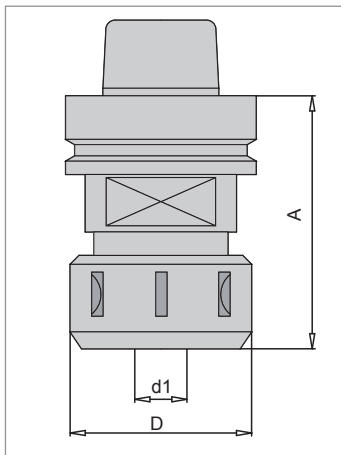
Fig.: 10199849

Cutter with chuck - complete SK 30 System

	D mm	L2 mm	A mm	b	Z	Order No.
NEW	100	3	113	HSK 25 R	4	10199849
NEW	130	3	113	HSK 25 R	5	10199850

HSK 63F Collet chuck standard

HSK in acc. with DIN 69893, for collets up to 25mm,
slim design



82000

APPLICATION:

Standard: Clamping shank tools with cylindric shank
Mini: Applied for plastic or aluminium processing to avoid interfering contours;
 Suitable for right-hand and left-hand rotation

MACHINE:

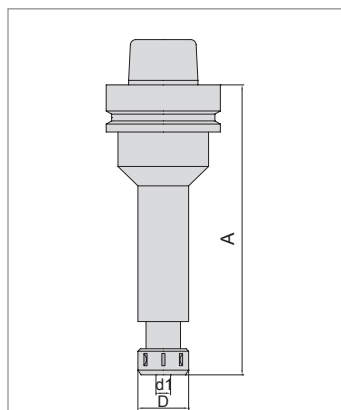
CNC routers and BAZ machining centers

DESIGN:

With a slot for data chip.
 Clamping nut ball bearing mounted

n (max) = 24.000 rpm

Standard	A mm	D/thread mm	d1 mm	for collet chucks no.	DT	Order No.
HSK 63 F	76	60/M48	3-25,4	462 E (up to 25 mm)	◇	10032786
HSK 63 F	115	60/M48	3-25,4	462 E (up to 25 mm)	◇	10035785



1010164023, 10164024, 10164025

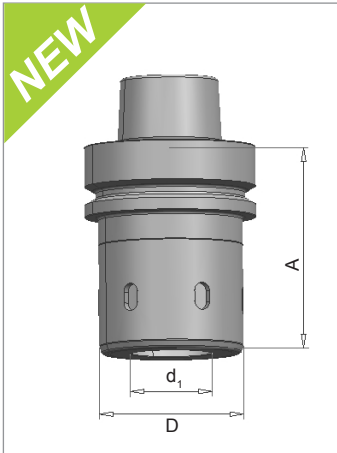
Mini	A mm	D/thread mm	d1 mm	for collet chucks no.	DT	Order No.
HSK 63 F	100	22/M19x1	1-12	426 E (up to 12mm)	◇	10164023
HSK 63 F	130	22/M19x1	1-12	426 E (up to 12mm)	◇	10164024
HSK 63 F	160	22/M19x1	1-12	426 E (up to 12mm)	◇	10164025

Spare part

Denomination	Dimension mm	Key size	Order No.
Hook wrench	58/62	M 48 x 2,0	10006111
Hook wrench	ER 16 mini	M 19 x 1,0	10174977

Delivery without hook wrench and collet.
 Please observe the minimum clamping length on the tool shaft.

HP Collet chuck



APPLICATION:

The new Collet chuck HP is a high precision tool holder. It meets the increased demands on accuracy and balancing quality when applied with high performance carbide and diamond router cutters. The chuck features higher precision and higher clamping forces compared to conventional collet chucks. Due to the slim design interfering contours are reduced – with an outer diameter of only 53 mm. Suitable for right-hand and left-hand rotation. Internal thread and clamping nut with anti-twist protection. The clamping nut will not open on abrupt motor stops.

MACHINE:

CNC routers and BAZ machining centers

DESIGN:

Hardened steel body, Polished surface
n (max) = 24.000 rpm

	Shank mm	A mm	D mm	d1 mm	for collet chucks no.	DT	Order No.
NEW	HSK 63 F	76	53	3 - 25,4 mm	462 E (up to 25 mm)	◇	10185756
NEW	SK 30	50	50	3 - 20 mm	470 E (ER 32)		10200307*

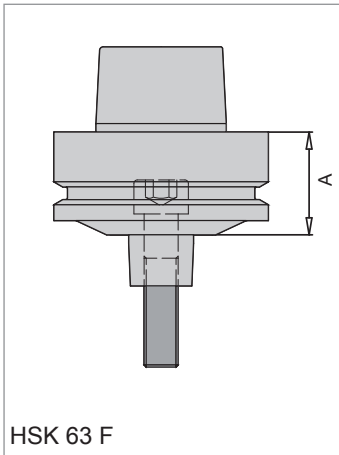
Spare part

	Denomination	D/thread mm	for collet chucks no.	DT	Order No.
NEW	Tightening nut	M 46 x 1,5	462 E (up to 25 mm)	◇	10185759
NEW	Hook wrench	M 46 52/55		◇	10180589

Delivery without hook wrench and collet.
Please observe the minimum clamping length on the tool shaft.

*included Pull Stud for Biesse (10006134)

HSK Plus tool holder for highest load



82000

APPLICATION: For holding HSK Plus cutters

MACHINE: CNC routers and BAZ machining centers

DESIGN: Screwed to the cutting tool a very high run-out accuracy of 0.003 - 0.01 mm is achieved.

n (max) = 40.000 rpm

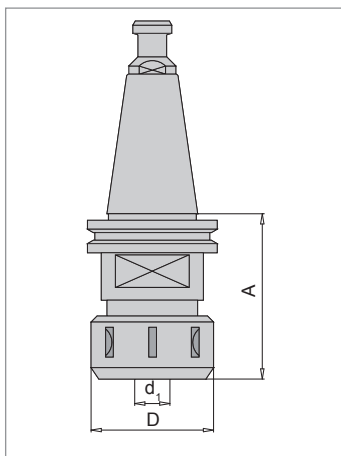
Shank mm	A mm	DT	Order No.
HSK 63 F	30,2	◇	10033898
HSK 63 F	50,2	◇	10033900
HSK 63 F	80,2	◇	10033902

Your advantages with HSK Plus tool holder.

- For up to 40,000 rpm
- Only minimal imbalance
- For best cutting quality

SK Collet chuck

SK in acc. with DIN 69871



APPLICATION:

Clamping shank tools with cylindrical shaft.
Suitable for right-hand and left-hand rotation

MACHINE:

CNC machines and stationary machining centers

DESIGN:

Pull stud, depending on machine manufacturer.
Clamping nut ball bearing mounted

n (max) = 24.000 rpm

82000

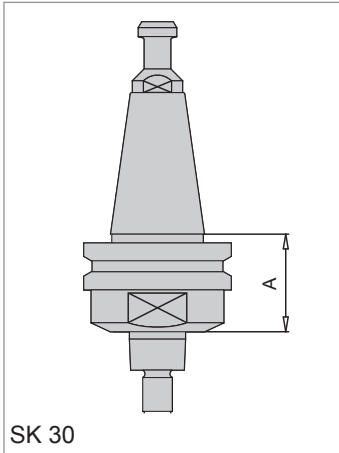
	Shank mm	A mm	D/Thread mm	d1 mm	for collet chucks no.	DT	Order No.
NEW	SK 30	50	50/M40	3-20	470 E (ER 32)		10200307*
	SK 30	56	63/M50	6-26	472 E (up to 25 mm)	◇	10014242
	SK 30	70	60/M48	3-25,4	462 E (up to 25 mm)	◇	10014643
	SK 40	81	60/M48	3-25,4	462 E (up to 25 mm)	◇	10014645
	SK 40	79	60/M48	3-25,4	462 E (up to 25 mm)	◇	10014517

Delivery without hook wrench and collet.
Pull stud DIN 69872 is supplied together with SK 40.
For SK 30 we need the machine details.

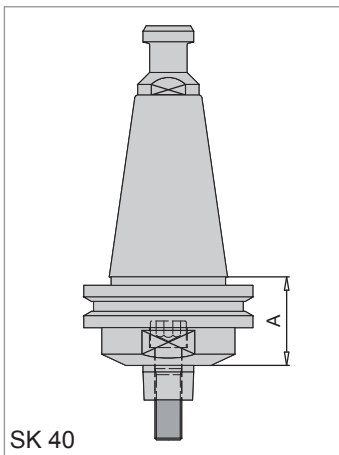
* included pull stud for Biesse (10006134)

Please observe the minimum clamping length on the shanks of the tools.

SK Plus tool holder for highest strain



82000



APPLICATION: For holding SK Plus cutters

MACHINE: CNC machines and stationary machining centers

DESIGN: Screwed to the cutting tool a very high run-out accuracy of 0.003 - 0.01 mm is achieved.

SK 30 n (max) 24.000 rpm
SK 40 n (max) 18.000 rpm

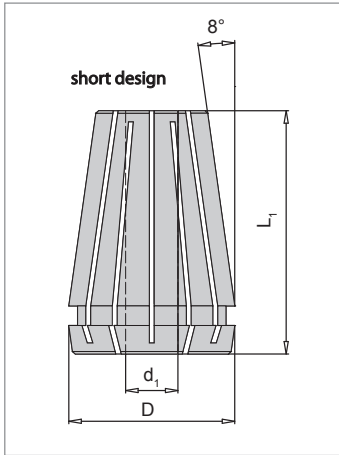
Cutter rh = rh rotation
Cutter lh = lh rotation

Shank mm	A mm	DT	Order No.
SK 30 lh	33,3	◇	10034362
SK 30 rh	33,3	◇	10034013
SK 40 rh	33,3	◇	10034015

Your advantages with SK Plus tool holder.

- Only minimal imbalance
- For best cutting quality

Precision collet



82000

APPLICATION:

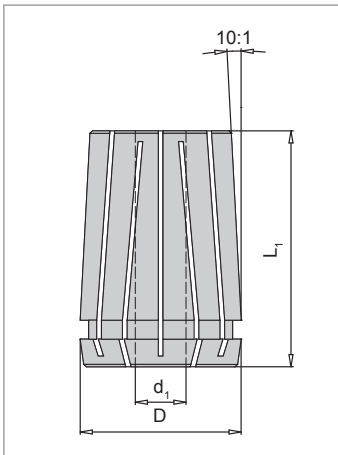
For collet chucks

DESIGN:

Clamping range:	Tolerance:	slotted:
ER 16 3 - 12 mm	0,5 mm	16-fold
ER 25 3 - 16 mm	0,5 mm / 1,0 mm	16-fold
ER 32 3 - 20 mm	1,0 mm	16-fold
ER 40 3 - 26 mm	1,0 mm	16-fold

	D mm	d1 mm	L1 mm	Clamping range mm	Clamping tolerance mm	Order No.
	17	3	27	up to 10 (426 E) ER 16	3	10174703
	17	4	27	up to 10 (426 E) ER 16	4	10174704
	17	5	27	up to 10 (426 E) ER 16	5	10174706
	17	6	27	up to 10 (426 E) ER 16	6	10174972
	17	7	27	up to 10 (426 E) ER 16	7	10174973
	17	8	27	up to 10 (426 E) ER 16	8	10174974
	17	9	27	up to 10 (426 E) ER 16	9	10174975
	17	10	27	up to 10 (426 E) ER 16	10	10174976
NEW	17	11	27	up to 10 (426 E) ER 16	11	10190727
NEW	17	12	27	up to 10 (426 E) ER 16	12	10190728
	26	3	34	up to 16 (430 E) ER 25	2,5 - 3	10174965
	26	4	34	up to 16 (430 E) ER 25	3,5 - 4	10174967
	26	5	34	up to 16 (430 E) ER 25	4,5 - 5	10174971
	26	6	34	up to 16 (430 E) ER 25	5,5-6	10017107
	26	8	34	up to 16 (430 E) ER 25	7,5-8	40002352
	26	10	34	up to 16 (430 E) ER 25	9,5-10	40002786
	26	12	34	up to 16 (430 E) ER 25	11,5-12	40002353
	26	14	34	up to 16 (430 E) ER 25	13,5-14	40003740
	26	16	34	up to 16 (430 E) ER 25	15,5-16	40002354
NEW	33	3	40	up to 20 (470 E) ER 32	2,5-3	40005814
NEW	33	4	40	up to 20 (470 E) ER 32	3,5-4	40008582
NEW	33	5	40	up to 20 (470 E) ER 32	4,5-5	40012691
	33	6	40	up to 20 (470 E) ER 32	5,5-6	10002467
	33	7	40	up to 20 (470 E) ER 32	6,5-7	10002468
	33	8	40	up to 20 (470 E) ER 32	7,5-8	10002469
	33	10	40	up to 20 (470 E) ER 32	9,5-10	10002470
	33	12	40	up to 20 (470 E) ER 32	11,5-12	10002471
	33	13	40	up to 20 (470 E) ER 32	12,5-13	10002472
	33	14	40	up to 20 (470 E) ER 32	13,5-14	10002473
	33	16	40	up to 20 (470 E) ER 32	15,5-16	10002474
	33	18	40	up to 20 (470 E) ER 32	17,5-18	10002475
	33	19	40	up to 20 (470 E) ER 32	18,5-19	40013253
	33	20	40	up to 20 (470 E) ER 32	19,5-20	10002476
NEW	41	3	46	up to 25 (472 E) ER 40	2,5-3	10176370
NEW	41	4	46	up to 25 (472 E) ER 40	3,5-4	10042169
NEW	41	5	46	up to 25 (472 E) ER 40	4,5-5	10142114
	41	6	46	up to 25 (472 E) ER 40	5,5-6	40002325
	41	7	46	up to 25 (472 E) ER 40	6,5-7	40013254
	41	8	46	up to 25 (472 E) ER 40	7,5-8	10002480
	41	10	46	up to 25 (472 E) ER 40	9,5-10	10002481
	41	12	46	up to 25 (472 E) ER 40	11,5-12	10002482
	41	13	46	up to 25 (472 E) ER 40	12,5-13	10002483
	41	16	46	up to 25 (472 E) ER 40	15,5-16	10002484
	41	18	46	up to 25 (472 E) ER 40	17,5-18	10002485
	41	19	46	up to 25 (472 E) ER 40	18,5-19	10002486
	41	20	46	up to 25 (472 E) ER 40	19,5-20	10002487
	41	25	46	up to 25 (472 E) ER 40	24,5-25	10002488
	41	26	46	up to 25 (472 E) ER 40	25,5-26	10002489

Precision collet



82000

APPLICATION:

For collet chucks

DESIGN:

Clamping range:

415 E 4,5 - 16 mm

462 E 3,0 - 25,4 mm

Tolerance:

0,5 mm

0,5 mm

slotted:

12-fold

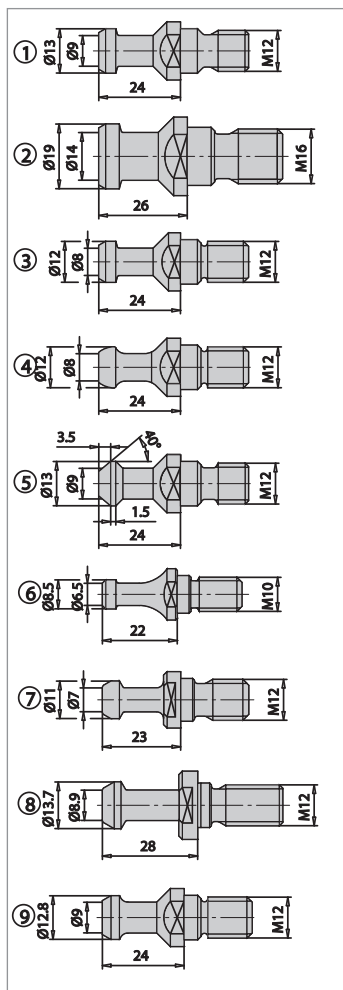
12-fold

D mm	d1 mm	L1 mm	Clamping range mm	Clamping tolerance mm	Order No.
22,65	5,0	40	up to 16 (415 E)	4,5-5,0	40011175
22,65	6,0	40	up to 16 (415 E)	5,5-6,0	40002318
22,65	6,5	40	up to 16 (415 E)	6,0-6,5	10002424
22,65	8,0	40	up to 16 (415 E)	7,5-8,0	40002320
22,65	9,5	40	up to 16 (415 E)	9,0-9,5	10017090
22,65	10,0	40	up to 16 (415 E)	9,5-10,0	10002425
22,65	12,0	40	up to 16 (415 E)	11,5-12,0	40002322
22,65	13,0	40	up to 16 (415 E)	12,5-13,0	10002426
22,65	14,0	40	up to 16 (415 E)	13,5-14,0	40005333
22,65	16,0	40	up to 16 (415 E)	15,5-16,0	10002427
32,9	3,0	52	up to 25 (462 E)	2,5-3,0	40003064
32,9	4,0	52	up to 25 (462 E)	3,5-4,0	40002435
32,9	5,0	52	up to 25 (462 E)	4,5-5,0	40002305
32,9	6,0	52	up to 25 (462 E)	5,5-6,0	10002432
32,9	6,5	52	up to 25 (462 E)	6,0-6,5	10002433
32,9	8,0	52	up to 25 (462 E)	7,5-8,0	40002306
32,9	9,5	52	up to 25 (462 E)	9,0-9,5	10002434
32,9	10,0	52	up to 25 (462 E)	9,5-10,0	10002435
32,9	12,0	52	up to 25 (462 E)	11,5-12,0	10002436
32,9	13,0	52	up to 25 (462 E)	12,5-13,0	10002437
32,9	14,0	52	up to 25 (462 E)	13,5-14,0	40002308
32,9	16,0	52	up to 25 (462 E)	15,5-16,0	10002438
32,9	18,0	52	up to 25 (462 E)	17,5-18,0	40002311
32,9	19,0	52	up to 25 (462 E)	18,5-19,0	10002439
32,9	20,0	52	up to 25 (462 E)	19,5-20,0	10013431
32,9	25,0	52	up to 25 (462 E)	24,5-25,0	40002313
32,9	25,4	52	up to 25 (462 E)	25,0-25,4	10002440

Spares / Accessories for collet chucks

39191

Pull stud



AB No.	Machine	Dimension mm	DT	Order No.
1	IMA, Maka, Reichenbacher, Weeke, Busellato, etc.	13/9 - M12		10006129
2	IMA, Maka, Reichenbacher, Stegherr, etc.	19/14 - M16		10006130
3	Biesse up to Bj. 09/1992	12/8 - M12	◇	10006133
4	Biesse up to Bj. 09/1992 Masterwood (HSD-Motors)	12/8 - M12	◇	10006134
5	Alberti, Masterwood (Colombo-Motors)	13/9 - M12	◇	10006136
6	Morbidelli, SCM	8,5/6,5 - M10	◇	10006131
7	Shoda	11/7 - M12	◇	10006132
8	Heian	13,7/8,9 - M12 JiS B 6339	◇	10006137
9	CMS	12,8/9 - M12	◇	10006135

Tightening nut and hook wrench for collet chuck

Denomination	Thread	D mm	DT	Order No.
Tightening nut, ball bearing mounted	M30x1,5	43	◇	10005969
Tightening nut, ball bearing mounted	M40x1,5	50		40012692
Tightening nut, ball bearing mounted	M48x2,0	60		10005970
Tightening nut, ball bearing mounted	M50x1,5	63		40004939
Tightening nut, ball bearing mounted	M19x1	22		10175069
Hook wrench	for M30x1,5	40/42	◇	10006109
Hook wrench	for M40x1,5	45/50		10006110
Hook wrench	for M48x2,0 for M50x1,5	58/62	◇	10006111
Hook wrench	M19x1	22	◇	10174977
NEW Hook wrench (for HP chucks)	M46	52/55	◇	10180589

Accessories

Masterclamp



APPLICATION:

Fast and safe mounting and clamping of tools in chucks, on cutter abors and with saw blade flanges.

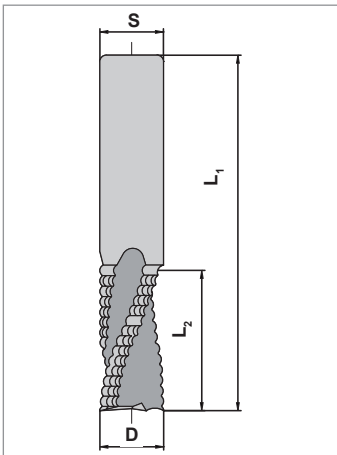


for chucks	Order No.
HSK 25	10163751
HSK 32 (C3)	10163752
HSK 40 (C4)	10163753
HSK 50 (SK 30)	10163754
HSK 63 (SK 40)	10163755
HSK 80	10163756
SK 50	10163757
HSK 100	10163758

Solid HW roughing cutter

APPLICATION:	For pre-cuts
DESIGN:	Solid HW roughing cutter with spiral knives and serrated knife design
MATERIAL:	Wood and wood-based panel material
MACHINE:	Stationary machines with and without tool changer
FEED:	MEC

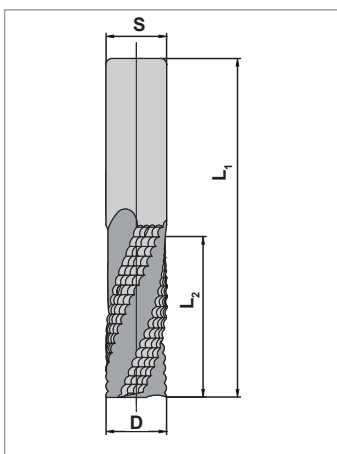
43070



Right-hand rotation / positive spiral - Z 2

D mm	L2 mm	L1 mm	Shank mm	Z	Order No.
6	20	60	6	2	10107183
8	25	80	8	2	10018734
10	30	75	10	2	10014613
12	42	90	12	2	10014614
14	35	80	14	2	10014615
16	35	90	16	2	10014616
16	55	110	16	2	10014617
18	55	115	18	2	10014618
20	55	115	20	2	10014619

Right-hand rotation / positive spiral - Z 3



D mm	L2 mm	L1 mm	Shank mm	Z	Order No.
12	42	90	12	3	10014620
14	35	90	14	3	10014621
14	55	110	14	3	10014622
16	35	90	16	3	10014623
16	55	110	16	3	10014624
18	55	115	18	3	10014625
18	55	135	25	3	10014630*
20	55	115	20	3	10014626
20	60	120	20	3	10014628
20	75	135	20	3	10014627
20	90	155	20	3	10014631
25	100	155	25	3	10014686*

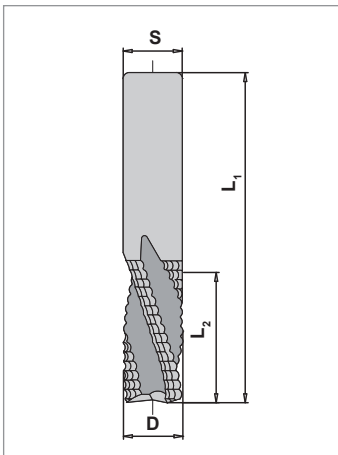
* with brazed shank

Further dimensions and special design, e.g. face-radius on request.

Solid HW roughing cutter

APPLICATION:	For pre-cuts
DESIGN:	Solid HW roughing cutter with spiral knives and serrated knife design
MATERIAL:	Wood and wood-based panel material
MACHINE:	Stationary machines with and without tool changer
FEED:	MEC

43070



Right-hand rotation / negative spiral - Z 2

D mm	L2 mm	L1 mm	Shank mm	Z	Order No.
10	30	75	10	2	10014632
16	55	110	16	2	10014633

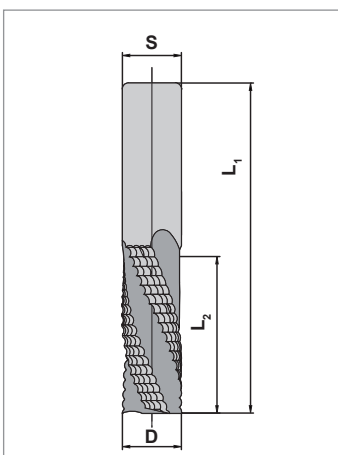
Right-hand rotation / negative spiral - Z 3

D mm	L2 mm	L1 mm	Shank mm	Z	Order No.
12	42	90	12	3	10014635
14	35	90	14	3	10014636
16	35	90	16	3	10014638
16	55	110	16	3	10014639
18	55	115	18	3	10014640
20	55	115	20	3	10014641

Left-hand rotation / negative spiral - Z 3

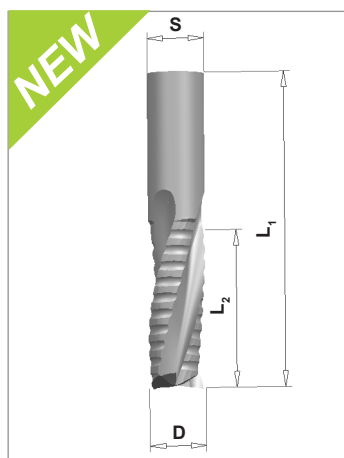
D mm	L2 mm	L1 mm	Shank mm	Z	Order No.
20	55	115	20	3	10017301

Further dimensions on request



Solid carbide roughing and smoothing - *smartline*

for door handle hole and lock barrel



43070

APPLICATION:	Cut-off and sizing cutter
DESIGN:	Solid carbide cutter with new roughing-smoothing tooth design and PLT coating. The new tooth design reduces the cutting pressure considerably if compared to the conventional smoothing cutter geometry. On the other hand there will be hardly any marks compared to the roughing cutter tooth design. Thanks to the PLT coating the service life is much longer and the friction at the same time minimized. The feed rate as well as overall performance can thus be clearly increased
MATERIAL:	Solid wood, wood-based material, plastic material
MACHINE:	Stationary machines with and without tool changer
FEED:	MEC

Short version

	D mm	L2 mm	L1 mm	Shank mm	Z	DT	Order No.
NEW	10	25	70	10 x 40	2	◇	10190153
NEW	12	25	70	12 x 40	2	◇	10190154
NEW	12	25	70	12 x 40	3		10190155
NEW	18	50	115	18 x 50	3	◇	10190156
NEW	20	50	115	20 x 50	3	◇	10190157

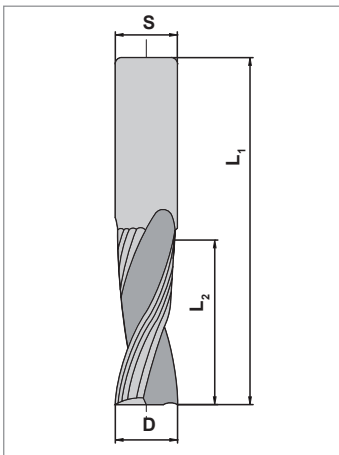
Long version

	D mm	L2 mm	L1 mm	Shank mm	Z	DT	Order No.
NEW	8	25	80	8 x 40	2	◇	10190163
NEW	12	42	90	12 x 40	3	◇	10190164
NEW	16	55	115	16 x 50	3		10190165
NEW	20	75	135	20 x 50	3		10190166

Solid HW finishing cutter

APPLICATION:	For high performance finishing cuts (smoothing)
DESIGN:	Solid HW finishing cutter with spiral knives
MATERIAL:	Wood and wood-based panel material
MACHINE:	CNC machines
FEED:	MEC

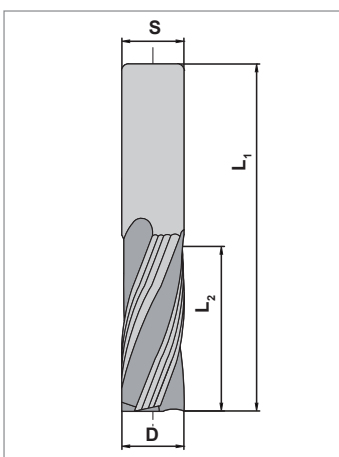
43070



Right-hand rotation / positive spiral - Z 2

D mm	L2 mm	L1 mm	Shank mm	Z	Order No.
5	18	50	5	2	10015649
6	20	60	6	2	10014978
8	25	80	8	2	10014579
8	32	80	8	2	10014580
10	30	75	10	2	10014581
12	42	90	12	2	10014582
14	35	80	14	2	10014583
14	50	100	14	2	10014584
16	35	90	16	2	10014585
16	55	110	16	2	10014586
18	55	115	18	2	10014587
20	55	115	20	2	10014588

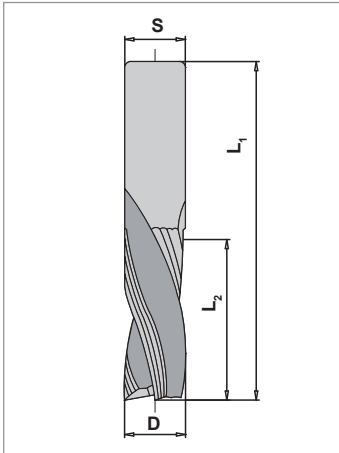
Right-Hand rotation / positive spiral - Z 3



D mm	L2 mm	L1 mm	Shank mm	Z	Order No.
12	42	90	12	3	10014589
14	35	90	14	3	10014590
14	55	110	14	3	10014591
16	35	90	16	3	10014592
16	55	110	16	3	10014593
18	55	115	18	3	10014594
20	55	115	20	3	10014595
20	60	120	20	3	10014597
20	75	135	20	3	10014596
20	90	155	20	3	10014598

Other dimensions, e.g. with face radius available on request.

Solid HW finishing cutter



43070

Right-hand rotation/ negative spiral - Z 2 [20258]

D mm	L2 mm	L1 mm	Shank mm	Z	Order No.
8	25	80	8	2	10014599
10	30	75	10	2	10014600
12	42	90	12	2	10014601
16	55	110	16	2	10014602
20	50	100	20	2	10014604

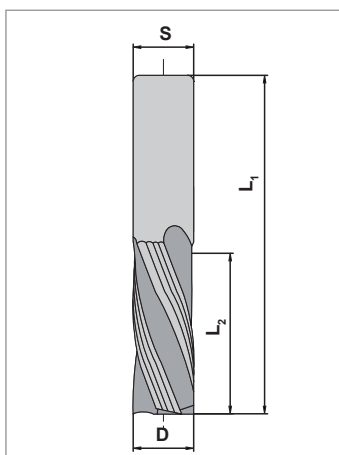
Right-hand rotation / negative spiral - Z 3

D mm	L2 mm	L1 mm	Shank mm	Z	Order No.
12	42	90	12	3	10014605
14	35	80	14	3	10014606
14	55	100	14	3	10014607
16	35	90	16	3	10014608
16	55	110	16	3	10014609
18	35	80	18	3	10014610
18	55	115	18	3	10014611
20	55	115	20	3	10014612

Left-Hand rotation / Negative spiral - Z 3

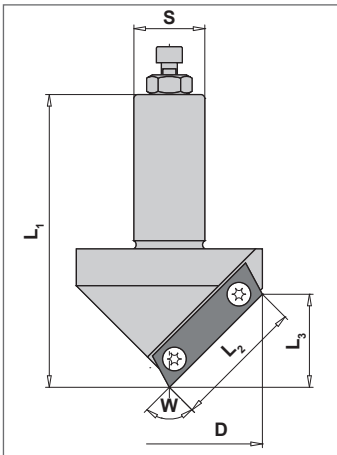
D mm	L2 mm	L1 mm	Shank mm	Z	Order No.
20	55	115	20	3	10014866

Further dimensions on request

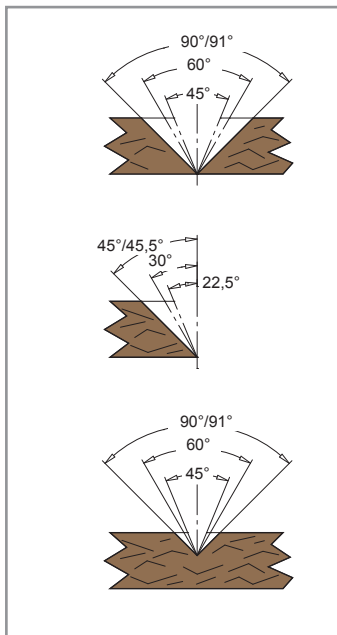


D mm	L2 mm	L3 mm	Shank mm	Angle	Order No.
14	12,5	7	8	90°	10004160
14	12,5	7	12	90°	10004162
14	16,5	12	8	60°	10004159
14	16,5	12	12	60°	10004161

TOK bevel / folding cutter Z1



43010



APPLICATION:	For V-grooves, decorative grooving, suitable for folding
DESIGN:	HW TOK, rh rotation, HW01 = for MDF HW02 = for solid wood and wood-based material
MACHINE:	Stationary machines with and without tool changer
FEED:	MEC

D mm	L2 mm	L1 mm	L3 mm	Shank mm	Angle	Order No.
43	46,4	115	43	25x55	45°	10110998
43	46,4	115	43	20x55	45°	10110997
41,5	41,5	118	35	25x55	60°	10003024
50	36,4	93	25	20x55	90°	40013307
50	36,4	93	25	25x55	90°	40013308
50	36,4	93	25	20x55	91°	10020657
50	36,4	93	25	25x55	91°	10003025

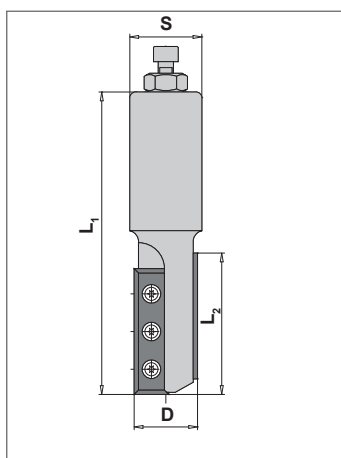
For folding cuts in chip boards use angle 91°, because of fibres possibly sticking out.

Spare parts:

Denomination	Dimensions mm	Order No.
TOK	60x12x1,5, HW02, for 45°	10113001
TOK	50x12x1,5, HW02, for 60°	10006982
TOK	50x12x1,5, HW01, for 60°	40015875
TOK	40x12x1,5 HW02, for 90°+91°	10006981
TOK	40x12x1,5 HW01, for 90°+91°	10006980
Torx screw	M 4x4 extra-large head, T15	10006040

TOK shank cutter Z 2

with HW boring tip



43010

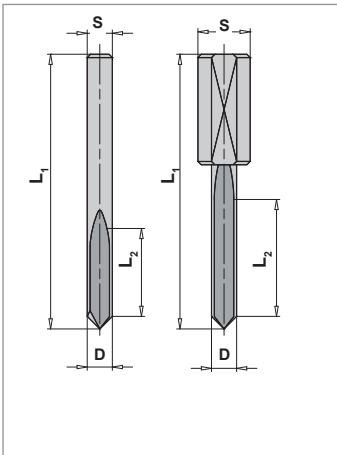
APPLICATION:	Grooving, jointing, sizing.
DESIGN:	Staggered HW TOK, screw-fixed on the back.
MATERIAL:	Wood, wood-based material, panel material and plastic material
MACHINE:	Stationary machines with and without tool changer
FEED:	MEC

D mm	L2 mm	L1 mm	Shank mm	rhs/lhs	Order No.
18	35	105	25x55	rhs	10029936
18	55	125	20x55	rhs	40013292
18	55	125	20x55	lhs	40013291
18	55	125	25x55	rhs	10002708
18	55	125	25x55	lhs	10002707
20	55	125	20x55	rhs	40013293
20	55	125	25x55	rhs	10002711
20	55	125	25x55	lhs	10025187
22	55	125	25x55	rhs	10002713

Spare parts:

Denomination	Dimensions mm	Order No.
TOK	30x12x1,5 Z4	10009523
TOK	50x12x1,7 Z4, 3hole design	10009526
Torx screw	M 4x5,9, extra-large head T15, for =16/18	10006039

Solid carbide drill pins



59900

APPLICATION:

For blind holes in abrasive materials and dry solid wood. Applied in adapters with cylindrical shank (see page 269) or with fixed 10 mm shank, with clamping surface and adjusting screw. Suitable for RH and LH rotation.

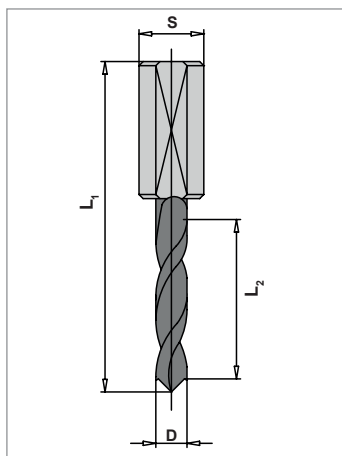
DESIGN:

Solid carbide, Inverted V tips, chip groove axially parallel,

*continuously cylindrical design

	D mm	L2 mm	L1 mm	Shank mm	Order No.
	2,5	15	70,0	10x33	40015741
*	3,0	15	45,0	3	10002045
*	3,0	23	48,0	3	10040539
	3,0	15	57,5	10x33	40015742
	3,0	23	70,0	10x33	40015743

Solid carbide Extreme dowel drill with centre point, 10 mm cylindrical shank



APPLICATION:

Applied in chucks, reducing sleeves etc., on dowel drilling machines and CNC machines. Used for drilling blind holes in solid wood, wood-based material etc. including coated material.

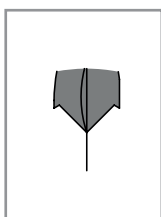
Very good hole edge quality and long tool life even in difficult wooden materials.

DESIGN:

Solid carbide spiral design with centre point, formed by means of an acute angle, including two negatively ground, reinforced spurs. Enlarged chip grooves. Cylindrical shank with clamping surface and depth adjustment screw.

HW micro grain

51010

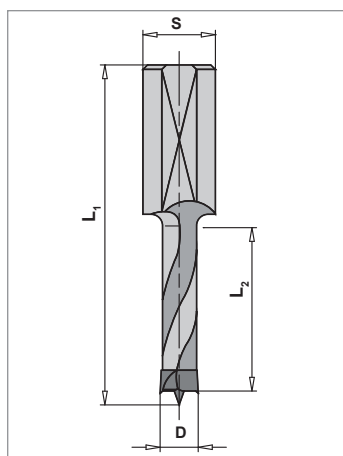


Rigid centre point due to acute angle and reinforced spur result in a longer tool service life.

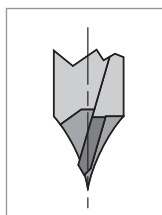
	D mm	L2 mm	L1 mm	Shank mm	rhs/lhs	Order No.
NEW	3	18	57,5	10x25	rhs	10022593
NEW	3	18	57,5	10x25	lhs	10022594
NEW	3	18	70,0	10x38	rhs	10159604
NEW	3	18	70,0	10x38	lhs	10159597
NEW	4	20	57,5	10x25	lhs	10175553
NEW	4	20	57,5	10x25	rhs	10178313
NEW	4	27	70,0	10x30	lhs	10188241
NEW	4	27	70,0	10x30	rhs	10188240
NEW	5	22	57,5	10x27	lhs	10175745
NEW	5	22	57,5	10x27	rhs	10175744
NEW	5	30	70,0	10x28	lhs	10168276
NEW	5	30	70,0	10x28	rhs	10168272
NEW	6	22	57,5	10x25	lhs	10022599
NEW	6	22	57,5	10x25	rhs	10022597
NEW	6	30	70,0	10x29	lhs	10022606
NEW	6	30	70,0	10x29	rhs	10022604
NEW	8	22	57,5	10x25	lhs	10178314
NEW	8	22	57,5	10x25	rhs	10178315
NEW	8	35	70,0	10x22	lhs	10134198
NEW	8	35	70,0	10x22	rhs	10134199
NEW	10	35	70,0	10x20	lhs	10107588
NEW	10	35	70,0	10x20	rhs	10107586

HW dowel drill with centre point

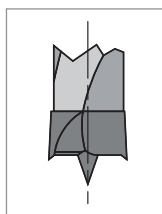
without back guidance, 10 mm cylindrical shank



51010



Negatively ground spurs for improved edge quality of the bore hole and longer tool service life.



Enlarged back clearance angle for reduced strain and improved chip ejection.

APPLICATION:

Applied in chucks, reducing sleeves etc., on dowel drilling machines. Used for drilling blind holes in solid wood, wood-based material etc., including coated material.

DESIGN:

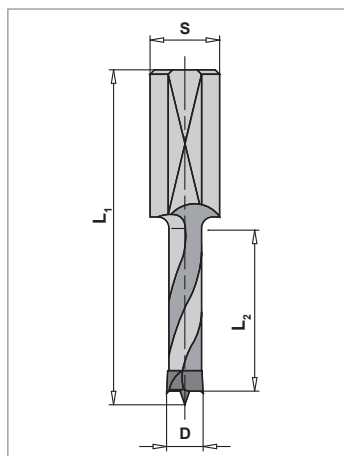
Carbide cutting head with centre point, two knives and negatively ground spurs. Enlarged back clearance angle. Spiral part plastic coated. Cylindrical shank with clamping surface and depth adjustment screw.

D mm	L2 mm	L1 mm	Shank mm	rhs/lhs	Order No.
4,0	35	70,0	10x30	lhs	10022478
4,0	35	70,0	10x30	rhs	10022477
4,5	35	70,0	10x30	lhs	10174590
4,5	35	70,0	10x30	rhs	10174592
5,0	27	57,5	10x27	lhs	10022438
5,0	27	57,5	10x27	rhs	10022437
5,0	35	70,0	10x30	lhs	10022480
5,0	35	70,0	10x30	rhs	10022479
5,0	42	77,0	10x30	lhs	10022515
5,0	42	77,0	10x30	rhs	10022512
5,1	27	57,5	10x27	rhs	10022439
5,1	27	57,5	10x27	lhs	10022440
5,2	27	57,5	10x27	lhs	10022442
5,2	27	57,5	10x27	rhs	10022441
5,5	35	70,0	10x30	lhs	40012741
5,5	35	70,0	10x30	rhs	40012740
6,0	27	57,5	10x27	lhs	10022444
6,0	27	57,5	10x27	rhs	10022443
6,0	35	70,0	10x30	lhs	10022482
6,0	35	70,0	10x30	rhs	10022481
6,0	44	77,0	10x33	lhs	10022521
6,0	44	77,0	10x33	rhs	10022518
6,5	35	70,0	10x30	lhs	10174609
6,5	35	70,0	10x30	rhs	10174607
7,0	27	57,5	10x27	lhs	10022448
7,0	27	57,5	10x27	rhs	10022447
7,0	35	70,0	10x30	lhs	10022486
7,0	35	70,0	10x30	rhs	10022485

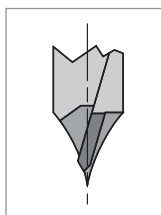
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HW dowel drill with centre point without back guidance, 10 mm cylindrical shank

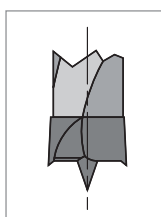
Continued from the previous page



51010



Negatively ground spurs for improved edge quality of the bore hole and longer tool service life.



Enlarged back clearance angle for reduced strain and improved chip ejection.

APPLICATION:

Applied in chucks, reducing sleeves etc., on dowel drilling machines. Used for drilling blind holes in solid wood, wood-based material etc., including coated material.

DESIGN:

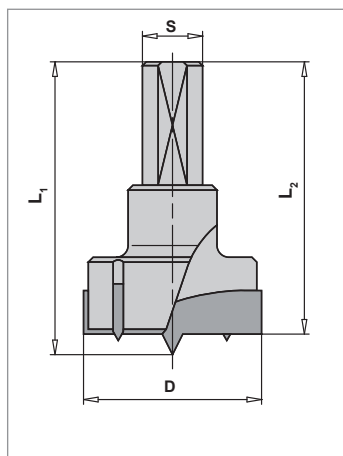
Carbide cutting head with centre point, two knives and negatively ground spurs. Enlarged back clearance angle. Spiral part plastic coated. Cylindrical shank with clamping surface and depth adjustment screw.

D mm	L2 mm	L1 mm	Shank mm	rhs/lhs	Order No.
8,0	27	57,5	10x27	lhs	10022450
8,0	27	57,5	10x27	rhs	10022449
8,0	35	70,0	10x30	lhs	10022491
8,0	35	70,0	10x30	rhs	10022487
8,0	44	77,0	10x30	lhs	10022529
8,0	44	77,0	10x30	rhs	10022525
8,2	35	70,0	10x30	lhs	10024203
8,2	35	70,0	10x30	rhs	10024202
9,0	27	57,5	10x27	lhs	10022455
9,0	27	57,5	10x27	rhs	10022453
9,0	35	70,0	10x30	lhs	10022497
9,0	35	70,0	10x30	rhs	10022494
10,0	27	57,5	10x27	lhs	10022469
10,0	27	57,5	10x27	rhs	10022468
10,0	35	70,0	10x30	lhs	10022501
10,0	35	70,0	10x30	rhs	10022500
10,0	44	77,0	10x30	lhs	10022536
10,0	44	77,0	10x30	rhs	10022532
11,0	35	70,0	10x30	lhs	10022503
11,0	35	70,0	10x30	rhs	10022502
12,0	35	70,0	10x30	rhs	10022504
12,0	35	70,0	10x30	lhs	10022505
12,0	44	77,0	10x30	lhs	10022543
12,0	44	77,0	10x30	rhs	10022542
12,7	35	70,0	10x30	lhs	10022507
12,7	35	70,0	10x30	rhs	10022506

Spare parts

Denomination	Dimensions mm	Order No.
Adjustment screw	M 5 x 10	10174969

HW boring bit Z2 + V2



52010

APPLICATION:

For drilling dimensionally stable and splinter-free blind holes in hard wood, wood-based material etc. (drilling holes for metal fittings etc.).

DESIGN:

Two wipers, two inserted spurs and centre point. Cylindrical shank with clamping surface and adjustment screw.

D mm	L2 mm	L1 mm	Shank mm	rhs/lhs	Order No.
15	55,5	57,5	10x26	lhs	10005449
15	55,5	57,5	10x26	rhs	10005450
15	68,0	70,0	10x26	lhs	10005451
15	68,0	70,0	10x26	rhs	10005452
18	55,5	57,5	10x26	lhs	10005455
18	55,5	57,5	10x26	rhs	10005456
18	68,0	70,0	10x26	lhs	10005457
18	68,0	70,0	10x26	rhs	10005458
20	55,5	57,5	10x26	lhs	10005459
20	55,5	57,5	10x26	rhs	10005460
20	68,0	70,0	10x26	lhs	10005461
20	68,0	70,0	10x26	rhs	10005462
22	55,5	57,5	10x26	rhs	10005464
25	55,5	57,5	10x26	rhs	10005466
25	68,0	70,0	10x26	lhs	10005467
25	68,0	70,0	10x26	rhs	10005468
30	68,0	70,0	10x26	lhs	10005477
30	68,0	70,0	10x26	rhs	10005478
35	55,5	57,5	10x26	lhs	10005481
35	55,5	57,5	10x26	rhs	10005482
35	68,0	70,0	10x26	lhs	10005483
35	68,0	70,0	10x26	rhs	10005484




Notes

be *better*



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