



**ALLIED**

**THE CUTTING EDGE**

CNC Starter Package - Furniture Manufacturing

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# Solid Carbide Finishing Spiral

## WROU Series

### Application

All wood and wood based products. Particularly suitable with plastic and synthetic material.

### Machine

Mechanical.

### Design

Single flute to provide good chip evacuation. Provides a very clean edge when machining plastics. Polished flutes prevents material bonding to the spiral.



Dia mm	CL mm	OAL mm	Shank mm	Pt.No.
2	5	50	6	WROU255061P
3	12	50	6	WROU3125061P
4	12	60	6	WROU4126061P
4	22	60	6	WROU4226061P
5	16	80	8	WROU5168081P
5	20	90	8	WROU5209081P
5	45	100	8	WROU54510081P
6	12	60	6	WROU6126061P
6	22	65	6	WROU6226561P
8	12	60	8	WROU8127081P
8	22	70	8	WROU8228081P
8	40	90	8	WROU8409081P
10	22	70	10	WROU102270101P
10	40	90	10	WROU104090101P
12	22	70	12	WROU122270121P
12	40	90	12	WROU124090121P

### Application Data

Dia mm	RPM Max	Feed M/Min
2	24,000	2
3-5	24,000	3-5
6-8	24,000	6-8
10-12	24,000	10-12

# Solid Carbide Finishing Spiral

## WRDF Series

### Application

All wood and wood based products.

### Machine

Mechanical.

### Design

Down shear to provide a perfect finish on the top of the material. Z = 2.

Dia mm	CL mm	OAL mm	Shank mm	Pt.No.
4	16	60	4	WRDF4136042
6	22	70	6	WRDF6227062
8	28	75	8	WRDF8287582
10	32	80	10	WRDF103280102
12	38	100	12	WRDF1238100122
16	35	100	16	WRDF1635100162
16	44	105	16	WRDF1644105162



### For Shaker Doors

Dia mm	CL mm	OAL mm	Shank mm	Z	Pt.No.
20	20	110	20	3	WRSD2020100203

### Application Data

Dia mm	RPM Max	Feed M/Min
4	24,000	4-6
6-8	24,000	6-10
10-12	24,000	10-16
16	24,000	14-22
20	24,000	16-30



# Solid Carbide Compression Spiral

## CLF+ Series

### Application

All wood and wood based products. Particularly suitable with MFC.

### Machine

Mechanical.

### Design

Up shear and down shear to provide a clean finish on the top and bottom of the material. Small up shear to allow for faster machining with reduced cutting pressure. Z = 2+2. Slick coating prevents resin build up and increases tool life.

Dia mm	CL mm	OAL mm	Shank mm	Pt.No.
Uncoated				
12	22	80	12	CLF+ 1222801222
12	28	90	12	CLF+ 1228901222
Slick coated				
12	22	80	12	CLF+ 1222801222T
12	28	80	12	CLF+ 1228901222T



### Application Data

Dia mm	RPM Max	Feed M/Min
Up to 18mm thickness		
12	24,000	16-26
Up to 25mm thickness		
12	24,000	14-22

# PCD Compression Router

## 10201 Series

### Application

All wood and wood based products. Particularly suitable with MDF.

### Machine

Mechanical.

### Design

PCD tipped increasing the tool life by 50x over carbide. Up shear and down shear to provide a clean finish on the top and bottom of the material. Only suitable for machining a maximum of 20mm material thickness. Z = 3+3.

Dia mm	CL mm	OAL mm	Shank mm	Pt.No.
12	24.5	72	12	10201821



### Application Data

Dia mm	RPM Max	Feed M/Min
12	24,000	18-26



# Hydro Extraction System

## ELF Series

### Application

All wood and wood based products.

### Machine

Mechanical.

### Design

Extracting 99% of swarf from the cut, increasing tool life and minimal secondary clean up operation. Hydraulic clamping provides quick and easy tool changes. New design allows for height adjustment.

Dia mm	Height mm	Attachment mm	Shank mm	Pt.No.
98	21	HSK-F63	12	THYDRO-12
98	21	HSK-F63	16	THYDRO-16



### Application Data

Dia mm	RPM Max	Feed M/Min
12	22,000	30
16	22,000	30

For optimal results, ensure Extraction System is 2-5mm above material.

# Disposable Tip Surfacing Router

## 22525 Series

### Application

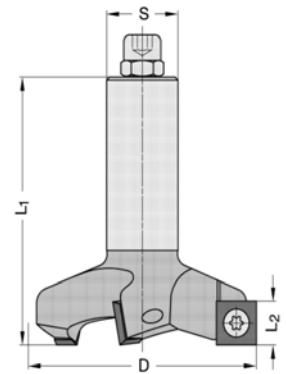
All wood and wood based products. Particularly suitable with MDF.

### Machine

Mechanical.

### Design

3 replaceable tips with shear to level slave boards on flat bed CNC machines. Replaceable tips are 4 sided, therefore a cost effective design.



Dia mm	L2 mm	L1 mm	Shank mm	Pt.No.
80	14	85	20	22525-5-80005-R

### Application Data

Dia mm	RPM Max	Feed M/Min
80	14,000	10-20





# AKE HP Collet Chuck

## HPC Series

### Application

All wood and wood based products.

### Machine

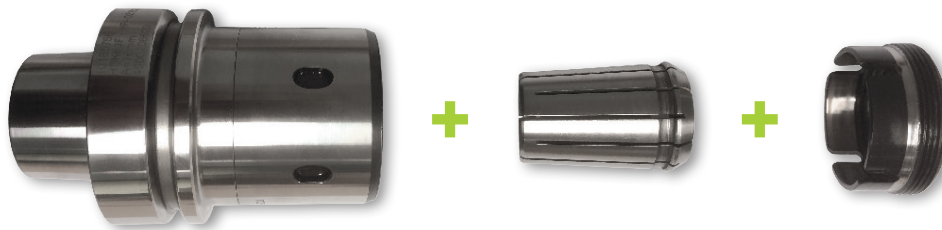
Mechanical.

### Design

Collet chuck for use in all CNC machines to hold round shanks from 3mm - 25mm. Suitable with 462e collets. Max RPM = 24,000.



Back End	Dia mm	Length mm	nm	Pt.No.
HSK-F63	21	HSK-F63	180	10185756



### Suitable collets

ID mm	Type	Pt.No.
3	462e	185.030.00
4	462e	185.040.00
5	462e	185.050.00
6	462e	185.060.00
6.35	462e	185.064.00
8	462e	185.080.00
10	462e	185.100.00
12	462e	185.120.00
12.7	462e	185.127.00
14	462e	185.140.00
16	462e	185.160.00
20	462e	185.200.00
25	462e	185.250.00

# Assembly Device

## AKE Series

### Application

All wood and wood based products.

### Machine

Mechanical.

### Design

Fast and safe mounting of round shanks in collet chucks, cutters on arbors and saw blades with flanges.



Back End	Pt.No.
HSK-F63	10163755

### Suitable Wrench

Type	Pt.No.
462e	10180589





# Lip & Spur Drills

## 311 Series

### Application

All wood and wood based products.

### Machine

Mechanical.

### Design

Drilling blind holes. 2 precision ground cutting edges with 2 precision negative spurs to prevent break out, 10mm shank with flat for adjusting screws. Suitable to drilling heads and collets. All 70mm OAL, 57mm also available.



Dia mm	CL mm	OAL mm	Shank mm	Z	Pt.No. Right Hand	Pt.No. Left Hand
4	35	70	10	2	311.040.11	311.040.12
4.5	35	70	10	2	311.045.11	311.045.12
4.76	35	70	10	2	311.047.11	311.047.12
5	35	70	10	2	311.050.11	311.050.12
5.1	35	70	10	2	311.051.11	311.051.12
5.2	35	70	10	2	311.052.11	311.052.12
5.55	35	70	10	2	311.055.11	311.055.12
6	35	70	10	2	311.060.11	311.060.12
6.35	35	70	10	2	311.064.11	311.064.12
6.5	35	70	10	2	311.065.11	311.065.12
7	35	70	10	2	311.070.11	311.070.12
8	35	70	10	2	311.080.11	311.080.12
8.2	35	70	10	2	311.082.11	311.082.12
9	35	70	10	2	311.090.11	311.090.12
9.5	35	70	10	2	311.095.11	311.095.12
10	35	70	10	2	311.100.11	311.100.12
11	35	70	10	2	311.110.11	311.110.12
11.1	35	70	10	2	311.111.11	311.111.12
12	35	70	10	2	311.120.11	311.120.12
12.7	35	70	10	2	311.127.11	311.127.12
13	35	70	10	2	311.130.11	311.130.12
14	35	70	10	2	311.140.11	311.140.12
15	35	70	10	2	311.150.11	311.150.12
16	35	70	10	2	311.160.11	311.160.12

# V-Point Drills

## 314 Series

### Application

All wood and wood based products.

### Machine

Mechanical.



### Design

Drilling through holes. 2 precision ground flutes to prevent break out on the hole exit. 10mm shank with flat for adjusting screws. Suitable to drilling heads and collets. All 70mm OAL, 57mm also available.

Dia mm	CL mm	OAL mm	Shank mm	Z	Pt.No. Right Hand	Pt.No. Left Hand
4	30	70	10	2	314.040.11	314.040.12
4.76	35	70	10	2	314.047.11	314.047.12
5	35	70	10	2	314.050.11	314.050.12
5.5	35	70	10	2	314.055.11	314.055.12
6	35	70	10	2	314.060.11	314.060.12
6.35	35	70	10	2	314.064.11	314.064.12
7	35	70	10	2	314.070.11	314.070.12
8	35	70	10	2	314.080.11	314.080.12
9	35	70	10	2	314.090.11	314.090.12
9.5	35	70	10	2	314.095.11	314.095.12
10	35	70	10	2	314.100.11	314.100.12
12	35	70	10	2	314.120.11	314.120.12
12.7	35	70	10	2	314.127.11	314.127.12



# Hinge Boring Drills

## 369 Series

### Application

All wood and wood based products.

### Machine

Mechanical.



### Design

Drilling blind holes. 2 precision ground cutting edges with 2 precision negative spurs to prevent break out, 10mm shank with flat for adjusting screws. Suitable to drilling heads and collets. All 70mm OAL, 57mm also available.

Dia mm	OAL mm	Shank mm	Z	Pt.No. Right Hand	Pt.No. Left Hand
14	70	10	2	369.140.11	369.140.12
15	70	10	2	369.150.11	369.150.12
16	70	10	2	369.160.11	369.160.12
18	70	10	2	369.180.11	369.180.12
20	70	10	2	369.200.11	369.200.12
22	70	10	2	369.220.11	369.220.12
25	70	10	2	369.250.11	369.250.12
26	70	10	2	369.260.11	369.260.12
30	70	10	2	369.300.11	369.300.12
35	70	10	2	369.350.11	369.350.12
40	70	10	2	369.400.11	369.400.12
45	70	10	2	369.450.11	369.450.12
50	70	10	2	369.500.11	369.500.12
55	70	10	2	369.550.11	369.550.12
60	70	10	2	369.600.11	369.600.12



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