

 **BIESSE**

*Selco by AKE -
Panel sizing programme*

Now even more efficient



www.ake.de

from **2017**



**saw blade
Type 0024**

APPLICATION:

Panel sizing. Single cut or in packs

MATERIAL:

Plastic laminated and foil-coated wood-based material, Duroplast

MACHINE:

Panel sizing machine horizontal with scoring aggregate

DESIGN:

Rigid saw body,
♪ Soundstar design: noise reduced

TOOTH:

Triple-chip/flat tooth (FT), HW

**Your advantages with
Universal circular saw blade**

- Sturdy saw blade
- Long service life
- High quality
- Noise reduction



**Circular scoring saw blade
Type 0026**

APPLICATION:

Scoring of laminated wood-based material, parallel feed Scoring of post forming components

MATERIAL:

Plastic laminated and foil-coated wood-based material

MACHINE:

Panel sizing unit horizontal with scoring aggregate, trimming saw with scoring aggregate

DESIGN:

Conical flat tooth for long tool service life and high feed rate. Conical alternate top bevel tooth for aggregates with low machine power. Alternate top bevel tooth for post forming cuts Alternate top bevel tooth with axial angle for post forming cuts

TOOTH:

Flat tooth conical (F con.), alternate top bevel tooth conical (W con.), HW alternate top bevel tooth (W), alternate top bevel tooth with axial angle (W m.A), HW

Black Belt Technologie®



**Circular scoring saw blade
Super Plus**

APPLICATION:

Scoring of laminated wood-based material, parallel feed Scoring of post forming components

MATERIAL:

Plastic laminated and foil coated wood-based material, veneered wood-based material

MACHINE:

Panel sizing machines horizontal with scoring aggregate

DESIGN:

Noise-reduced due to variable tooth pitch and different gullet depths. Conical alternate top bevel tooth (W) tips for aggregates with low motor power

TOOTH:

Conical alternate top bevel tooth, (W, con.); HW

**Your advantages with
Super Plus.**

- High productivity
- Short set-up time
- Reduction of costs
- High quality
- Noise reduction

Black Belt Technologie®



**saw blade
Super Plus**

APPLICATION:

Sizing cuts with high feed rate and long tool service life, single and in packs

MATERIAL:

Plastic laminated and foil coated wood-based material, Duroplast

MACHINE:

Panel sizing machine horizontal with scoring aggregate

DESIGN:

Noise reduced due to N-slots in the saw-body, division of cut (clustered teeth) for longer tool service life and improved cutting quality

TOOTH:

Triple chip, conical (T);
Flat /flat/ triple-chip (FFT), HW

**Your advantages with
Super Plus.**

- High productivity
- Short set-up time
- Reduction of costs
- High quality
- Noise reduction

Vario S



**saw blade
Solution**

APPLICATION:

Finish cut with long tool service life, preferably applied for single panels and panels in packs

MATERIAL:

Plastic laminated and foil-coated wood-based material, Duroplast

MACHINE:

Panel sizing machine horizontal with scoring aggregate

DESIGN:

Noise reduced due to N-shaped slots in the saw body, variable tooth pitch and different gullet depths

TOOTH:

Triple chip, conical (T);
flat /triple-chip (FT); HW

**Your advantages with
Solution.**

- Long tool service life
- Finish cut quality
- Economic efficiency
- Noise reduction



**saw blade
DIA**

APPLICATION:

Panel sizing, single and in packs

MATERIAL:

Wood-based material, laminated, Duroplast

MACHINE:

Panel sizing unit, horizontal, with scoring aggregate

DESIGN:

Rigid saw body

TOOTH:

Flat / triple-chip tooth (FT), DP




Diamond Technology -


Economic efficiency by AKE.

PANEL SIZING PROGRAMME FOR SELCO MACHINES


SELCO EB 70 / EB70L

Selco EB 70 / EB70L	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade	300	4,4	3,2	65	60	FT	2/9/110	0024.300.65
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	F con.	2/9/100 2/9/110	0026.200.65
Scoring saw blade 	200	4,4 - 5,2	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.67
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	W con.	2/9/100 2/9/110	0026.200.67
Postforming with Scoring saw blade	300	4,4 - 5,6	3,2	65	48	W con.	2/9/100 2/9/110	0026.300.69
Postforming	300	4,6	3,2	65	72	W	2/9/100 2/9/110	0026.300.65

SELCO EB 70 (KIT 80)


Selco EB 70 (kit 80)	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade	320	4,4	3,2	65	60	FT	2/9/110	0024.320.65
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	F con.	2/9/100 2/9/110	0026.200.65
Scoring saw blade 	200	4,4 - 5,2	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.67
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	W con.	2/9/100 2/9/110	0026.200.67
Postforming with Scoring saw blade	300	4,4 - 5,6	3,2	65	48	W con.	2/9/100 2/9/110	0026.300.69
Postforming	300	4,6	3,2	65	72	W	2/9/100 2/9/110	0026.300.65

SELCO EB 75


Selco EB 75	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade	320	4,4	3,2	65	60	FT	2/9/110	0024.320.65
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	F con.	2/9/100 2/9/110	0026.200.65
Scoring saw blade 	200	4,4 - 5,2	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.67
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	W con.	2/9/100 2/9/110	0026.200.67
Postforming with Scoring saw blade	300	4,4 - 5,6	3,2	65	48	W con.	2/9/100 2/9/110	0026.300.69
Postforming	300	4,6	3,2	65	72	W	2/9/100 2/9/110	0026.300.65

PANEL SIZING PROGRAMME FOR SELCO MACHINES


SELCO SEKTOR 430

Selco Sektor 430	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade	320	4,4	3,2	65	60	FT	2/9/110	0024.320.65
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	F con.	2/9/100 2/9/110	0026.200.65
Scoring saw blade 	200	4,4 - 5,2	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.67
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	W con.	2/9/100 2/9/110	0026.200.67
Postforming with Scoring saw blade	300	4,4 - 5,6	3,2	65	48	W con.	2/9/100 2/9/110	0026.300.69
Postforming	300	4,6	3,2	65	72	W	2/9/100 2/9/110	0026.300.65


SELCO SEKTOR 470

Selco Sektor 470	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade	355	4,4	3,2	65	72	FT	2/9/110	0024.355.65
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	F con.	2/9/100 2/9/110	0026.200.65
Scoring saw blade 	200	4,4 - 5,2	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.67
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	W con.	2/9/100 2/9/110	0026.200.67
Postforming with Scoring saw blade	300	4,4 - 5,6	3,2	65	48	W con.	2/9/100 2/9/110	0026.300.69
Postforming	300	4,6	3,2	65	72	W	2/9/100 2/9/110	0026.300.65

SELCO EB 80


Selco EB 80	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade	320	4,4	3,2	65	60	FT	2/9/110	0024.320.65
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	F con.	2/9/100 2/9/110	0026.200.65
Scoring saw blade 	200	4,4 - 5,2	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.67
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	W con.	2/9/100 2/9/110	0026.200.67
Postforming with Scoring saw blade	300	4,4 - 5,6	3,2	65	48	W con.	2/9/100 2/9/110	0026.300.69
Postforming	300	4,6	3,2	65	72	W	2/9/100 2/9/110	0026.300.65

SELCO EB 90


Selco EB 90	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade	355	4,4	3,2	80	72	FT	2/9/130 4/19/120	0024.355.82
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	F con.	2/9/100 2/9/110	0026.200.65
Scoring saw blade 	200	4,4 - 5,2	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.67
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	W con.	2/9/100 2/9/110	0026.200.67
Postforming with Scoring saw blade	300	4,4 - 5,6	3,2	65	48	W con.	2/9/100 2/9/110	0026.300.69
Postforming	300	4,55	3,2	65	72	W	2/9/100 2/9/110	0026.300.68

PANEL SIZING PROGRAMME FOR SELCO MACHINES


SELCO EB 95

Selco EB 95	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade	355	4,4	3,2	65	72	FT	2/9/110	0024.355.65
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	F con.	2/9/100 2/9/110	0026.200.65
Scoring saw blade 	200	4,4 - 5,2	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.67
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	W con.	2/9/100 2/9/110	0026.200.67
Postforming with Scoring saw blade	300	4,4 - 5,6	3,2	65	48	W con.	2/9/100 2/9/110	0026.300.69
Postforming	300	4,6	3,2	65	72	W	2/9/100 2/9/110	0026.300.65

SELCO EB 100


Selco EB 100	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade	360	4,4	3,2	65	72	FT	2/9/110	0024.360.65
Main saw blade	360	4,4	3,2	65	72	Solution	2/9/110	0428.360.65
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	F con.	2/9/100 2/9/110	0026.200.65
Scoring saw blade 	200	4,4 - 5,2	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.67
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	W con.	2/9/100 2/9/110	0026.200.67
Postforming with Scoring saw blade	300	4,4 - 5,6	3,2	65	48	W con.	2/9/100 2/9/110	0026.300.69
Postforming	300	4,6	3,2	65	72	W	2/9/100 2/9/110	0026.300.65

SELCO EB 108 / 110



Selco EB 108 / 110	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade	400	4,4	3,2	80	72	FT	2/9/130 4/19/120	0024.400.80
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	F con.	2/9/100 2/9/110	0026.200.65
Scoring saw blade 	200	4,4 - 5,2	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.67
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	W con.	2/9/100 2/9/110	0026.200.67
Postforming with Scoring saw blade	300	4,4 - 5,6	3,2	65	48	W con.	2/9/100 2/9/110	0026.300.69
Postforming	300	4,55	3,2	65	72	W	2/9/100 2/9/110	0026.300.68

PANEL SIZING PROGRAMME FOR SELCO MACHINES



SELCO WNA 600/162

Selco WNA 600/162	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade (PFS)	400	4,4	3,2	80	72	FT	2/9/130 4/19/120	0024.400.80
Main saw blade	510	4,8	3,5	80	72	FT	2/9/130 4/19/120	0024.510.80
Scoring saw blade	200	4,8 - 5,6	3,5	65	36	F con.	2/9/100 2/9/110	0026.200.66
Scoring saw blade 	200	4,8 - 5,6	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.68
Postforming	300	4,55	3,2	65	72	W	2/9/100 2/9/110	0026.300.68

SELCO EB 120 + WN 125

Selco EB 120 + WN 125	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade (PFS)	400	4,4	3,2	80	72	FT	2/9/130 4/19/120	0024.400.80
Main saw blade	430	4,4	3,2	80	72	FT	2/9/130 4/19/120	0024.430.80
Main saw blade 	430	4,4	3,2	80	72	FT	2/9/130 4/19/120	7024.430.005
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	F con.	2/9/100 2/9/110	0026.200.65
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	W con.	2/9/100 2/9/110	0026.200.67
Scoring saw blade 	200	4,4 - 5,2	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.67
Postforming with Scoring saw blade	300	4,4 - 5,6	3,2	65	48	W con.	2/9/100 2/9/110	0026.300.69
Postforming	300	4,55	3,2	65	72	W	2/9/100 2/9/110	0026.300.68

SELCO WN 200 + WN 600/132


Selco WN 200 + WN 600/132	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade (PFS)	400	4,4	3,2	80	72	FT	2/9/130 4/19/120	0024.400.80
Main saw blade	450	4,4	3,2	80	72	FT	2/9/130 4/19/120	0024.450.82
Main saw blade	450	4,8	3,5	80	72	FT	2/9/130 4/19/120	0024.450.83
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	F con.	2/9/100 2/9/110	0026.200.65
Scoring saw blade 	200	4,4 - 5,2	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.67
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	W con.	2/9/100 2/9/110	0026.200.67
Scoring saw blade	200	4,8 - 5,8	3,5	65	36	F con.	2/9/100 2/9/110	0026.200.66
Scoring saw blade 	200	4,8 - 5,6	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.68
Postforming	300	4,55	3,2	65	72	W	2/9/100 2/9/110	0026.300.68

PANEL SIZING PROGRAMME FOR SELCO MACHINES


SELCO WN 512

Selco WN 512	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade (PFS)	400	4,4	3,2	80	72	FT	2/9/130 4/19/120	0024.400.80
Main saw blade	480	4,8	3,5	80	72	FT	2/9/130 4/19/120	0024.480.80
Scoring saw blade	200	4,8 - 5,8	3,5	65	36	F con.	2/9/100 2/9/110	0026.200.66

SELCO WN 600/145


Selco WN 600/145	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade (PFS)	400	4,4	3,2	80	72	FT	2/9/130 4/19/120	0024.400.80
Main saw blade	480	4,8	3,5	80	72	FT	2/9/130 4/19/120	0024.480.80
Scoring saw blade 	200	4,8 - 5,6	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.68
Scoring saw blade	200	4,8 - 5,8	3,5	65	36	F con.	2/9/100 2/9/110	0026.200.66
Postforming	300	4,55	3,2	65	72	W	2/9/100 2/9/110	0026.300.68

SELCO WN 610


Selco WN 610	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade (PFS)	380	4,4	3,2	65	72	FT	2/9/110	0024.380.65
Main saw blade	380	4,4	3,2	65	72	FT	2/9/110	0024.380.65
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	F con.	2/9/100 2/9/110	0026.200.65
Scoring saw blade 	200	4,4 - 5,2	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.67
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	W con.	2/9/100 2/9/110	0026.200.67
Postforming with Scoring saw blade	300	4,4 - 5,6	3,2	65	48	W con.	2/9/100 2/9/110	0026.300.69
Postforming	350	4,6	3,2	65	72	W	2/9/110	0026.350.66

PANEL SIZING PROGRAMME FOR SELCO MACHINES


SELCO WN 630

Selco WN 630	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade (PFS)	400	4,4	3,2	65	72	FT	2/9/110	0024.400.65
Main saw blade	400	4,4	3,2	65	72	FT	2/9/110	0024.400.65
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	F con.	2/9/100 2/9/110	0026.200.65
Scoring saw blade 	200	4,4 - 5,2	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.67
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	W con.	2/9/100 2/9/110	0026.200.67
Postforming with Scoring saw blade	300	4,4 - 5,6	3,2	65	48	W con.	2/9/100 2/9/110	0026.300.69
Postforming	350	4,6	3,2	65	72	W	2/9/110	0026.350.66

SELCO WN 650


Selco WN 650	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade (PFS)	430	4,4	3,2	65	72	FT	2/9/110	0024.430.65
Main saw blade	430	4,4	3,2	65	72	FT	2/9/110	0024.430.65
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	F con.	2/9/100 2/9/110	0026.200.65
Scoring saw blade 	200	4,4 - 5,2	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.67
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	W con.	2/9/100 2/9/110	0026.200.67
Postforming with Scoring saw blade	300	4,4 - 5,6	3,2	65	48	W con.	2/9/100 2/9/110	0026.300.69
Postforming	350	4,6	3,2	65	72	W	2/9/110	0026.350.66

SELCO WN 710


Selco WN 710	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade (PFS)	430	4,8	3,5	70	72	FT	4/11/130	0024.430.70
Main saw blade	430	4,8	3,5	70	72	FT	4/11/130	0024.430.70
Scoring saw blade	200	4,8 - 5,8	3,5	65	36	F con.	2/9/100 2/9/110	0026.200.66
Scoring saw blade 	200	4,8 - 5,6	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.68
Postforming with Scoring saw blade	300	4,8 - 5,6	3,5	65	48	W con.	2/9/110	0026.300.67
Postforming	350	5	3,5	65	72	W	2/9/110	0026.350.65

PANEL SIZING PROGRAMME FOR SELCO MACHINES

SELCO WN 730

Selco WN 730	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade (PFS)	430	4,8	3,5	70	72	FT	4/11/130	0024.430.70
Main saw blade	470	4,8	3,5	70	72	FT	4/11/130	0024.470.70
Main saw blade (ABC with PFS)	430	4,8	3,5	75	72	FT	4/11/130 4/6,5/130	0024.430.76
Main saw blade (ABC)	470	4,8	3,5	75	72	FT	4/11/130 4/6,5/130	0024.470.76
Scoring saw blade	200	4,8 - 5,8	3,5	65	36	F con.	2/9/100 2/9/110	0026.200.66
Scoring saw blade 	200	4,8 - 5,6	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.68
Postforming with Scoring saw blade	300	4,8 - 5,6	3,5	65	48	W con.	2/9/110	0026.300.67
Postforming	350	5	3,5	65	72	W	2/9/110	0026.350.65

SELCO WN 750

Selco WN 750	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Main saw blade (PFS)	430	4,8	3,5	70	72	FT	4/11/130	0024.430.70
Main saw blade	520	4,8	3,5	70	72	FT	4/11/130	0024.520.70
Main saw blade (ABC with PFS)	430	4,8	3,5	75	72	FT	4/11/130 4/6,5/130	0024.430.76
Main saw blade (ABC with PFS)	520	4,8	3,5	75	72	FT	4/11/130 4/6,5/130	0024.520.75
Scoring saw blade	200	4,8 - 5,8	3,5	65	36	F con.	2/9/100 2/9/110	0026.200.66
Scoring saw blade 	200	4,8 - 5,6	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.68
Postforming with Scoring saw blade	300	4,8 - 5,6	3,5	65	48	W con.	2/9/110	0026.300.67
Postforming	350	5	3,5	65	72	W	2/9/110	0026.350.65

SELCO VSU

Selco VSU	D mm	B mm	b mm	d mm	Z	ZF	NL	Order No.
Postforming	300	4,95	3,5	65	72	W	2/9/100 2/9/110	on demand

ABC - automatic blade changer (FIRST)

CIRCULAR SAW BLADES ACCORDING TO DIAMETER

	D mm	B mm	b mm	d mm	Z	ZF	NL	Order-Nr.
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	F con.	2/9/100 2/9/110	0026.200.65
Scoring saw blade	200	4,8 - 5,8	3,5	65	36	F con.	2/9/100 2/9/110	0026.200.66
Scoring saw blade	200	4,4 - 5,6	3,2	65	36	W con.	2/9/100 2/9/110	0026.200.67
Scoring saw blade	200	4,4 - 5,2	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.67
Scoring saw blade	200	4,8 - 5,6	3,5	65	32	F con.	2/9/100 2/9/110	7026.200.68
Postforming	300	4,55	3,2	65	72	W	2/9/100 2/9/110	0026.300.68
Postforming	300	4,6	3,2	65	72	W	2/9/100 2/9/110	0026.300.65
Postforming with Scoring saw blade	300	4,4 - 5,6	3,2	65	48	W con.	2/9/100 2/9/110	0026.300.69
Postforming with Scoring saw blade	300	4,8 - 5,6	3,5	65	48	W con.	2/9/110	0026.300.67
Main saw blade	300	4,4	3,2	65	60	FT	2/9/110	0024.300.65
Main saw blade	320	4,4	3,2	65	60	FT	2/9/110	0024.320.65
Postforming	350	4,6	3,2	65	72	W	2/9/110	0026.350.66
Postforming	350	5	3,5	65	72	W	2/9/110	0026.350.65
Main saw blade	355	4,4	3,2	80	72	FT	2/9/130 4/19/120	0024.355.82
Main saw blade	355	4,4	3,2	65	72	FT	2/9/110	0024.355.65
Main saw blade	360	4,4	3,2	65	72	FT	2/9/110	0024.360.65
Main saw blade	360	4,4	3,2	65	72	Solution	2/9/110	0428.360.65
Main saw blade	380	4,4	3,2	65	72	FT	2/9/110	0024.380.65
Main saw blade	400	4,4	3,2	65	72	FT	2/9/110	0024.400.65
Main saw blade	400	4,4	3,2	80	72	FT	2/9/130 4/19/120	0024.400.80
Main saw blade	430	4,4	3,2	65	72	FT	2/9/110	0024.430.65
Main saw blade	430	4,4	3,2	80	72	FT	2/9/130 4/19/120	0024.430.80
Main saw blade	430	4,4	3,2	80	72	FT	2/9/130 4/19/120	7024.430.005
Main saw blade	430	4,8	3,5	70	72	FT	4/11/130	0024.430.70
Main saw blade	430	4,8	3,5	75	72	FT	4/11/130 4/6,5/130	0024.430.76
Main saw blade	450	4,4	3,2	80	72	FT	2/9/130 4/19/120	0024.450.82
Main saw blade	450	4,8	3,5	80	72	FT	2/9/130 4/19/120	0024.450.83
Main saw blade	470	4,8	3,5	70	72	FT	4/11/130	0024.470.70
Main saw blade	470	4,8	3,5	75	72	FT	4/11/130 4/6,5/130	0024.470.76
Main saw blade	480	4,8	3,5	80	72	FT	2/9/130 4/19/120	0024.480.80
Main saw blade	510	4,8	3,5	80	72	FT	2/9/130 4/19/120	0024.510.80
Main saw blade	520	4,8	3,5	70	72	FT	4/11/130	0024.520.70
Main saw blade	520	4,8	3,5	75	72	FT	4/11/130 4/6,5/130	0024.520.75



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AKE
Cutting & better

Safety Information for Tools

Please read prior to installation and operation

The tools conform to standard DIN-EN 847-1/2.

Tools should be stored in their original packing or in other appropriate packing. Tools should be stored in dry conditions and away from aggressive substances. There is always the danger of injury due to the sharpness of the tools. Tools must only be used as designated.

Cutting in feed direction is only permissible for mechanical feed.

The direction of rotation must be observed.

The maximum allowed operating speed must not be exceeded. The machine manufacturer's regulations must be adhered to. If in any doubt please contact AKE Knebel GmbH & Co. KG and/or the machine manufacturer.

Check tools carefully for any signs of damage or defects prior to installation.

Do not install the tool if there are any recognisable defects or damages, if already installed, stop operation immediately, remove tool and mark the tool clearly so that it cannot be installed prior to being checked by a competent person. Tools showing cracks or similar damages must not be welded or repaired in any form.

Only trained persons with the necessary safety training are allowed to install tools and commence operation of the machine.

Adhere to the operation manual of both the tools and the machine.

Ensure the machine cannot be started.

Tools should only be installed using the clamping mechanism as provided by the machine manufacturer, recommended starting torque should be observed, no other form of installation or tightening is allowed.

The European standard, DIN-EN 1870-1, chapter 3.2.3. is applicable for allocating the appropriate clamping flange diameter to the saw blade diameter.

Gloves must be worn, as should close-fitting clothes and ear protection when necessary.

Once the tool has been installed, please ensure that all safety protection devices and the splitting wedge are mounted correctly.

A test run by a trained person must be carried out.

Do not reach anywhere near the rotating tool. No uninvolved persons should be near this area.

Do not undertake any adjustments near the rotating tool. Make sure there is no imbalance. The cutting edge of the tool must not come into contact with any other cutting tools, fixing elements or any other parts of the machine. Bore hole reduction rings must be firmly fixed to the tool and must not project over the tool body. Reducing rings must be the correct size to ensure that the tool is fixed correctly.

Never leave the operating machine unattended.

All measures to prevent kick back must be taken, all corresponding devices must be applied.

The working material must be checked for any foreign matter.

The tool must be re-sharpened in due time. Indications for blunt tools are: extreme wear and tear on the cutting edges, broken edges, poor cutting quality and higher energy consumption by the machine.

Saw blades with cutting teeth of less than 1 mm must not be used.

Tools must only be re-sharpened by competent personnel and must only be repaired using original parts.

Competent persons are those with corresponding training and experience who have knowledge of the design, designation and safety requirements of the tool.

Tools must only be repaired in compliance with the manufacturer's instructions. The following must be observed: the tool design must not be altered, all safety regulations must be adhered to, the applicable tensioning tolerances must be observed.



Notes

 **BIESSE**

Panel sizing Technology by AKE.

„Think global - act local“

The long-established company of AKE

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 sawblades and cutting tools worldwide.

Whether individual tools or demanding standards are required: the solution is always AKE.



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