

DESIGN  
MANUFACTURE  
SUPPLY



DIAMOND TOOLING  
SETTING THE STANDARD  
WORLDWIDE

# INTRODUCTION



## THE COMPANY

D.K. Holdings Limited has been manufacturing diamond tools and associated products since 1959. We have developed a unique expertise in producing and supplying diamond tooling specifically for the composites industry.

## ISO 9001 QUALITY STANDARD

Our products are made to the highest quality standards. We are certified with the approved quality management system BS EN ISO 9001 : 2015 for manufacture and supply of our products.

## DIAMOND TOOLS

Electroplated, electroformed, metal bond and resin bond diamond tools are used on various materials because of very fast clean cutting, long life, versatility of design and relatively low cost.

## STRIP & REPLATE, RETIP SERVICE

DK is able to replate and retip at very competitive prices many products of our own manufacture and also of other manufacturer's tooling.

## STOCK & SPECIAL TOOLS

A large range of the most popular products is held in stock at our Staplehurst factory for immediate despatch. Special tools can be designed and manufactured to meet your specific requirements on a relatively short lead time.

Our Technical Department can test and advise on the correct tooling required for special materials.

## VISIT OUR FACTORY

We are happy to invite you to visit our UK factory located opposite Staplehurst Railway Station, which is on the main railway line just 60 minutes from London's Charing Cross Station.

ADDRESS:	Station Approach, Staplehurst, Kent TN12 0QN, UK
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WEB:	<a href="http://www.dk-holdings.co.uk">www.dk-holdings.co.uk</a>

## INFORMATION

The information in this product guide is given as a reference only and we reserve the right to alter, withdraw or amend, specifications and product availability without prior notice.

# PRODUCT INDEX

A - B - C		Page No	Electroflex Pads		14
ACCESSORIES		22	F - G - H		Page No
AS70 Angle Saw Machine	19		Fein Multimaster MM 700	21	
AS100 Angle Grinder	20		Fein Triangular Pads	14	
AS100 Angle Saw Machine	20		GRINDING		10 - 15
AS125 Angle Saw Machine	20		Groove Wheel	16	
Air Belt Polisher	21		GRP/GRE Pipe Tools	16	
Air Powered Machines	18 - 21		Gulleted Saw	1	
Bandsaw Blades	3		Hand Files (Electroflex)	12	
Blades	1 - 3		HAND MACHINES		18 - 21
Boring, Multi-Bore	6		Hand Pads	13	
Calibration Drums	16		Hi Di Routers	9	
Chamfer Rings	16		Holesaws	4	
Chamfer Wheel	16		Holesaw Arbors	4	
Continuous Rimmed Saw	1, 3		I - J - K		
Core Drills	5		Integral Spindle Saws	3	
Corrugated Toothed Saw	2		Jigsaw Blades	3	
Countersinks	7		Jig Trimming Guide, SE20	18	
CUTTING		1 - 3	L - M - N		
D			M14 Backed Discs	15	
Dia Dry Discs	10		M14 Drums	14	
Diagrit Water Chucks	5		Mandrels, D-Loc	15	
Dia Met Hand Pads	13		Metal Bond Core Drills	5	
Diamond Step Pro Drill	6		Multi-Bore Tools	6	
D-Loc Discs	15		Narrow Belts	14	
Dome Ended Routers	8		Needle Files	12	
Drill Countersinks	7		O - P		
DRILLING		4- 7	Oil Mist Lubricator	22	
E			Oscillating Blades	3	
Electroflex Belts	14		Parallel Routers	8	
Electroflex Discs	15		Pendulum Blade	3	
Electroflex Drums	14		Piercing Routers	9	
Electroflex Hand Files	12		Plastic Wedges	22	
Electroflex Hand Pads	13		Pneumatic Wet Polisher	19	
			Pyramid Saws	2	

# PRODUCT INDEX

	Page No
<b>Q</b>	
Q-6R Pneumatic Machine	19
QRS Backing Discs	15
<b>R - S</b>	
Rebating Attachment, SE20	18
Re-dress Service	23
<b>ROUTING</b>	<b>8 - 9</b>
Routing Machine	18 - 19
Saws	1 - 3
Side Spoke Saws	1
SE20 Machine	18
SE50 Machine	19
Serrated Edged Saw	2
Special Tools	16 - 17
Spindle Saws	2

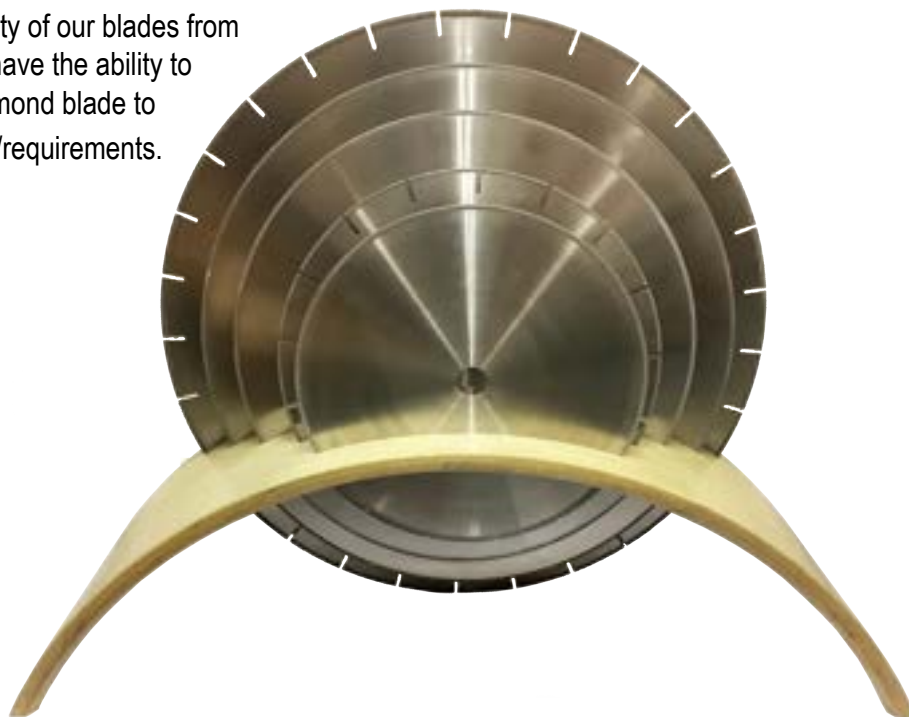
	Page No
<b>S (cont'd)</b>	
Spindle Arbors	2
Stop Wheel	16
Strip & Re-plate Service	23
Surface Planers	11, 17
<b>T</b>	
Technical Specifications	24 - 25
Titan Dry Grinding Discs	10
Trimming Machine	18
<b>U - V</b>	
Vortex Cutters	11
<b>W-X-Y-Z</b>	
Water Chucks	5
Wedges	22
Wind Turbine	17

## CUTTING

### DK DIAMOND SAWS FOR THE COMPOSITES INDUSTRY

As one of the world leaders in diamond blade technology we are pleased to offer a complete range of high quality diamond blades for the Composites Industry.

We offer the majority of our blades from stock but we also have the ability to manufacture a diamond blade to your specifications/requirements.



## CONTINUOUS RIM SAWS

For fast straight cutting of materials. Can be used in hand tools or on stationary machines at speeds between 1500 and 3000 surface metres per minute.

OPTIONS:            Diameters            25 - 700mm

### NOTE:

Can be supplied in a variety of diamond grades and widths. Normally saws over 40mm diameter are coated with 3mm down the sides and the larger saws have a deeper coating. Saws are made with bore sizes to suit customers' requirements which should be stated on order.



## SIDE SPOKE SAWS

This design allows the blade to cut curves without jamming or stalling the machine.

OPTIONS:            Diameters            25 - 700mm

### Note:

Can be supplied in a variety of diamond grades and widths. Also with 3 or 4 side spokes each side.

Normally supplied with 3 spokes each side. Larger sizes can be supplied with 4 spokes per side. Saws are made with bore sizes to suit customers' requirements which should be stated on order.

Saws coated in 36/44 grit are approximately 0.4mm wider than nominal width.



## GULLETED SAWS

The gullets allow clearance and cool cutting. Ideal for fast aggressive cutting of sheets, pipes and all materials over 20mm thick.

OPTIONS:            Diameters            100 - 700mm

### NOTE:

Can be supplied in a variety of diamond grades and widths.

Normally saws are coated a minimum 3mm down the sides and are made with bore sizes to suit customers' requirements which should be stated on order.

Saws coated in 36/44 grit are approximately 0.4mm wider than nominal width.

Silent centre saws are available on request. These saws lower the level of noise produced.



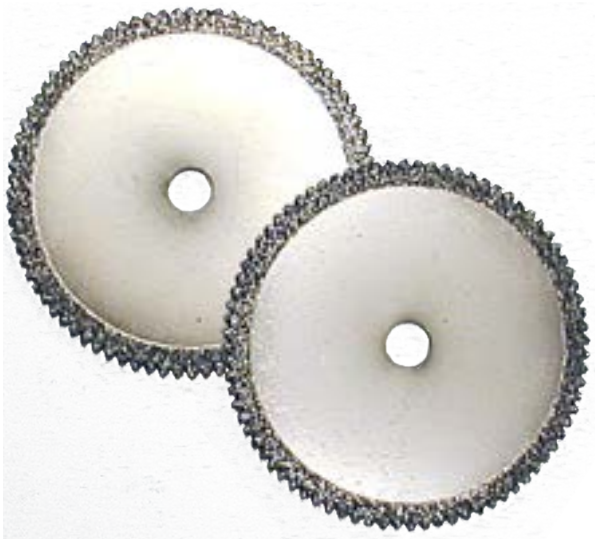
## OTHER RELATED PRODUCTS

HAND MACHINES - Pages 18-21

*Technical Specification: Page 24*



# CUTTING



## CORRUGATED TOOTHED SAW

Diamond coated 44/60 saw with serrated teeth for Kevlar®, Twaron® and Aramid fibres and also recommended for Carbon/Kevlar and Glass/Kevlar woven composite materials. The serrated teeth help to shear the fibre.

OPTIONS:                      Diameters                      50 - 200mm

## PYRAMID SAWS

For heavy duty hand trimming and sawing on GRP mouldings and other applications. Allows "side grinding " as well as cutting.

OPTIONS:                      Diameters                      100, 125 & 230mm  
   Grade                              36/44

### NOTE:

All saws are made with bore sizes to suit customers' requirements which should be stated when ordering.

Saws coated in 36/44 grit are approximately 0.4mm wider than nominal width.



## SPINDLE ARBORS

Spindle Arbors are used to adapt any small diameter saw onto a shank to be held in a spindle collet on a routing, air tool (such as our SE20 or SE50) or CNC machine.

This is useful when trimming FRP/GRP and carbon composite parts.

We can manufacture Spindle Arbors in to any size required and also offer standard, off-the-shelf solutions.

## OTHER RELATED PRODUCTS

HAND MACHINES - Pages 18 - 21

*Technical Specification: Page 24*

## INTEGRAL SPINDLE SAWS

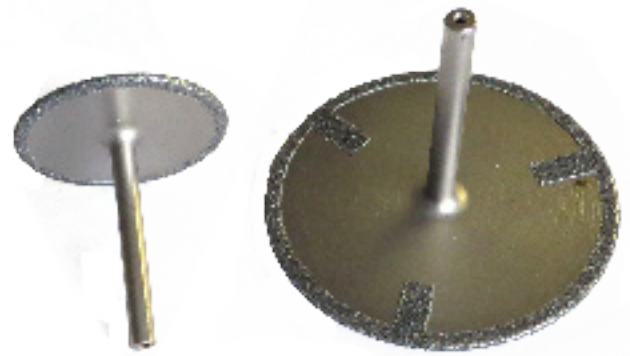
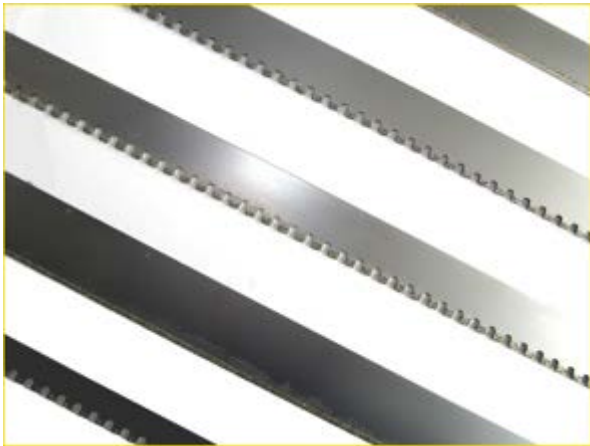
Used where it is necessary to cut close into a corner and where a boss or locking nut would get in the way. The blade and spindle are made in one piece and present an absolutely flush side to the work.

### OPTIONS:

Diameters	25 - 75mm
Configuration	Continuous Rim Side Spoke

### NOTE:

Can be supplied in a variety of diamond grades and widths.  
All saws are coated a nominal 2mm down the sides. Please state shank diameter and length when ordering.



## BANDSAW BLADES

Diamond coated bandsaws are made from high quality steel with the leading edge coated with diamond giving a continuous ribbon of aggressive cutting action. Both straight cut and curves can be easily achieved, bearing in mind the tighter the curve required, the narrower width of bandsaw needed.

Supplied ready welded to your exact required length or available in coils up to 39 metres long.

### OPTIONS:

Continuous Coated
Castellated Edge (for thicker materials)
Blade Widths 12, 16, 19, 25mm

### NOTE:

A Tension Gauge is also available.



## JIGSAW BLADES

Diamond coated for free cutting with clean finish. Available for a range of machines in medium 44/60 or coarse 36/44 diamond.

### OPTIONS:

Grades	36/44 coarse & 44/60 medium
--------	-----------------------------

### NOTE:

Longer jigsaw blades available on request.

# DRILLING

A wide selection of holesaws is available for both site and factory use when cutting holes in composites.



## SPECIAL HOLESAWS

Special Holesaws are available to required specifications and sizes and can be manufactured as follows:

- **Automatic Side Ejection** – Provides a very rapid method of dry cutting holes in GRP mouldings and laminates.

- **Piloted with Spring-Operated Core Ejection** – Designed for diameters under 25 mm. Offers ease of location with core ejection via a spring-loaded plunger. Supplied with either an HSS/Tungsten Carbide drill or plain pilot.

- **Spring Core Ejection without Pilot** – Designed for holesaws with diameters over 25 mm where internal space is limited.

**PLEASE NOTE:** This type does not accommodate a standard internal spring plunger ejector. A spring-loaded centre is incorporated for location purposes and ejects the core upon completion of the hole.

Grade 36/44 available – prices on request.

Prices include plain or HSS pilot drills.



## STANDARD HOLESAWS

(Various fittings available - Electroplated)

A range of holesaws coated in 36/44 diamond grit, that will rapidly cut through material leaving clean holes and giving long life.

OPTIONS:                      Diameters                      14 - 152mm

NOTE:

Holesaws furnished without arbors unless specified. Standard drilling depths; with pilot and ejector spring 15mm, without pilot and ejector spring 30mm, For customers requiring deeper drilling depth, quotations will be given on request.

## HOLESAWS ACCESSORIES

### ARBORS

#### Chuck Size

9.5mm                      Fits holesaw 14 - 30

13.0mm                      Fits holesaw 32 - 152

### PILOT DRILL

Tungsten Carbide Drill - Ø 6.5mm

### EJECTOR SPRING

Ejects slug out of holesaw

A1 ARBOR



A2 ARBOR



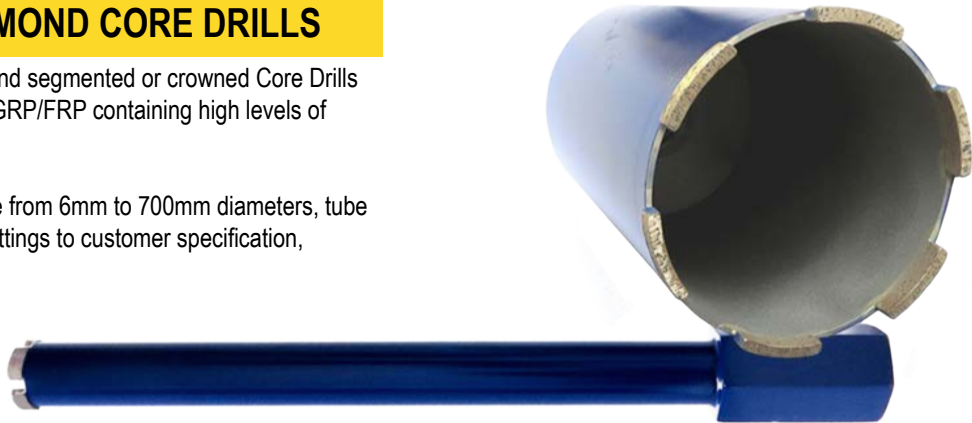
Technical Specification: Page 24



## METAL BOND DIAMOND CORE DRILLS

Heavy duty metal bond diamond segmented or crowned Core Drills for wet cutting clean holes in GRP/FRP containing high levels of Silicon.

**NOTE:** DK can manufacture from 6mm to 700mm diameters, tube lengths and shank fittings to customer specification, please contact us.



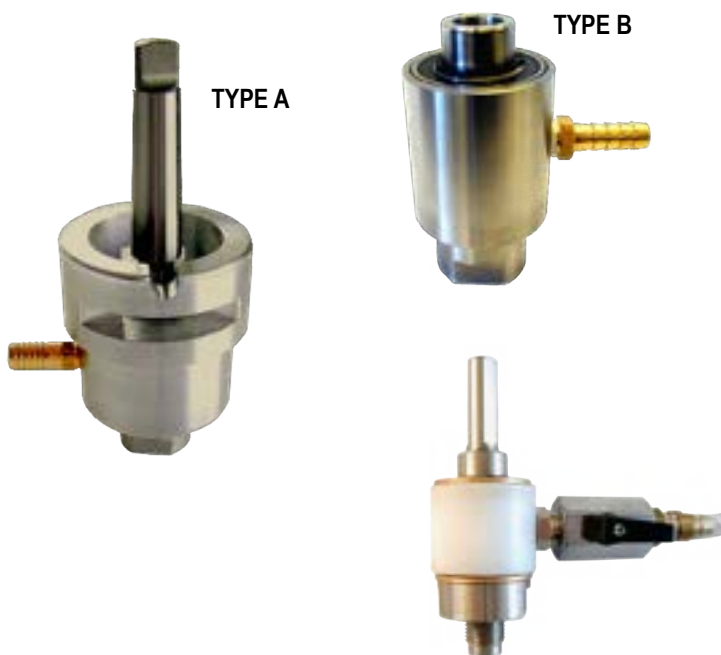
## DIAGRIT WATER CHUCKS

**TYPE A** - Heavy duty water chuck fits most popular pillar drills clamping directly onto the quill of the drilling machine enabling waterfeed through the centre of core drills.

**TYPE B** - Very popular Water Chuck fits most popular pillar drills enabling waterfeed through the centre of core drills.

**BABY WATER CHUCK** - A unique small water chuck is an easy answer to supplying water coolant to the working area when drilling holes with a hand held pistol drill. Available with all types of shank fittings. For use with standard holesaws.

**HEAVY DUTY WATER CHUCK** - Please call for details on our Heavy Duty Water Chucks as we can design to your specification.



TYPE A

TYPE B

BABY WATER CHUCK

HEAVY DUTY WATER CHUCK

### DIAGRIT WATER CHUCK - TYPE A

Continental 1/2" BSP fitting

**NOTE:** When ordering specify Morse taper size and quill diameter.

### DIAGRIT WATER CHUCK - TYPE B

Continental 1/2" BSP or Habit fitting

**NOTE:** When ordering please specify Morse taper size.

### BABY WATER CHUCK

Chuck complete with tap and pipe

**NOTE:** When ordering please specify required shank.

### DIAGRIT HEAVY DUTY WATER CHUCK

1 1/4" UNC Fitting

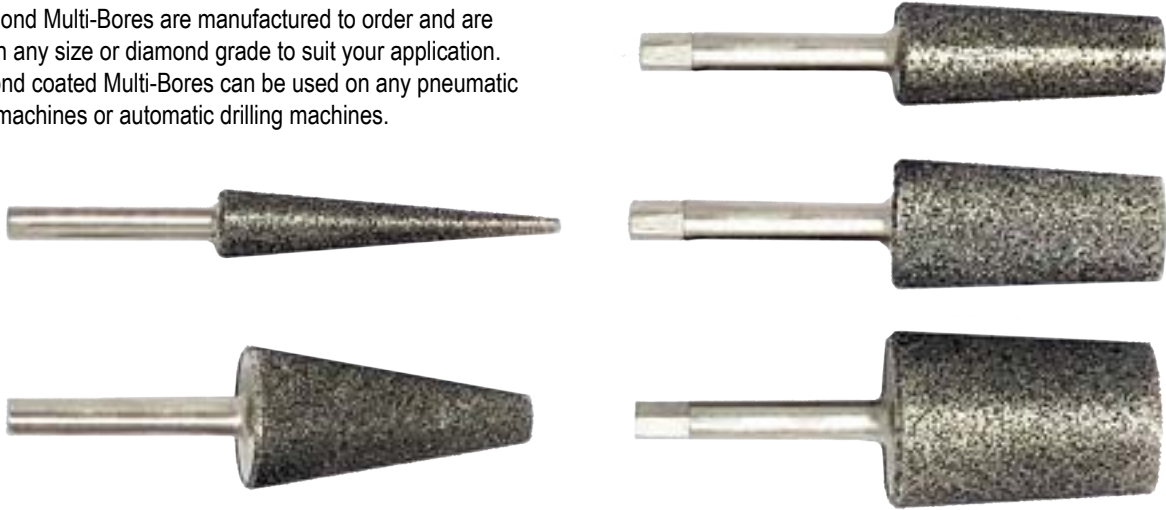
Technical Specification: Page 24

# DRILLING

## DIAMOND MULTI-BORE TOOLS

The DK manufactured Diamond Multi Bore is a diamond coated cone tool used for the opening up of existing holes in composite materials, giving a clean hole with a smooth finish in any GRP or FRP materials.

DK's Diamond Multi-Bores are manufactured to order and are available in any size or diamond grade to suit your application. The diamond coated Multi-Bores can be used on any pneumatic handheld machines or automatic drilling machines.



## DIAMOND STEP PRO DRILL

The innovative Diamond Step Pro Drill offers many advantages over conventional drilling and cutting methods and can be used for various industrial applications in the Aviation, Marine and Motorsport industries.

The cone shape design allows various hole sizes to be drilled with just one tool, offering cost saving in the process. Additionally, the tool is available in different grit sizes to achieve various finishes as required.

The company's R&D department based this new innovative design on its tools already used for sheet metal and developed it in partnership with one of their customers.



## TWIST DRILLS

### OPTIONS:

Diameters 4 - 9.5mm

### NOTE:

Other sizes and grades are available on request.  
We also manufacture solid drills, details on request.



## COUNTERBORES

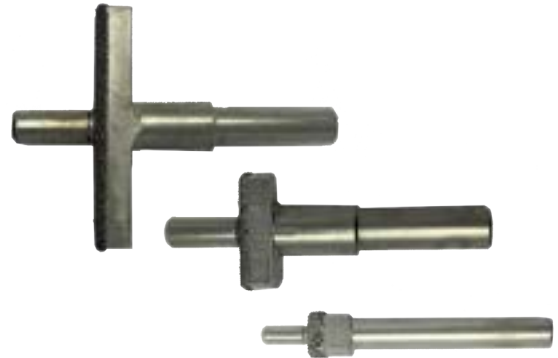
### OPTIONS:

Pilot 6, 8, 10, 16  
Diameter 10 - 70mm

### NOTE:

When ordering please state; Diameter, Pilot, Shank Diameter.

For holes up to 6mm diameter, these tools can be used in Series 50 or 20. Over 6mm diameter portable or fixed drilling machines can be used or static routing machines. Counterbores are not adjustable and must be ordered to cover both bore and recess, and can be manufactured to counterbore any size hole between 10mm and 50mm diameters.



## DIAMOND COUNTERSINKS

### OPTIONS:

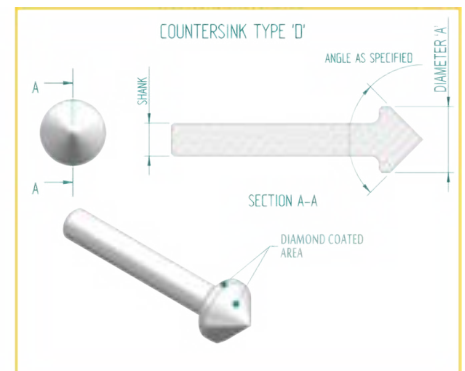
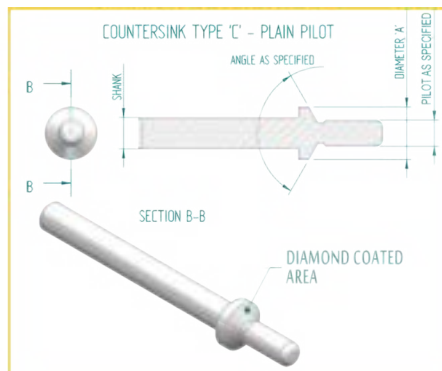
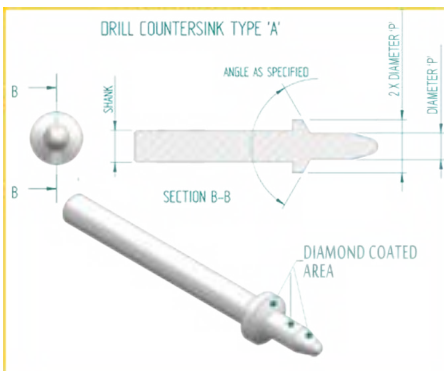
Diameters Type "A" 4 - 12mm  
Type "C" 4 - 12mm  
Type "D" 6.5 - 25mm

Grades 36/44 & 44/60

### NOTE:

When ordering please state shank diameter.  
Other sizes and grades are available on request.  
Can be manufactured to your specification.

### COUNTERSINKS - TYPE C



# ROUTING

We offer a range of diamond routers to encompass the majority of applications in the GRP/FRP Composites Industry. The high quality routers are available in various sizes and diamond grades. We can also manufacture these routers to your specific requirements.

## DOME ENDED ROUTERS

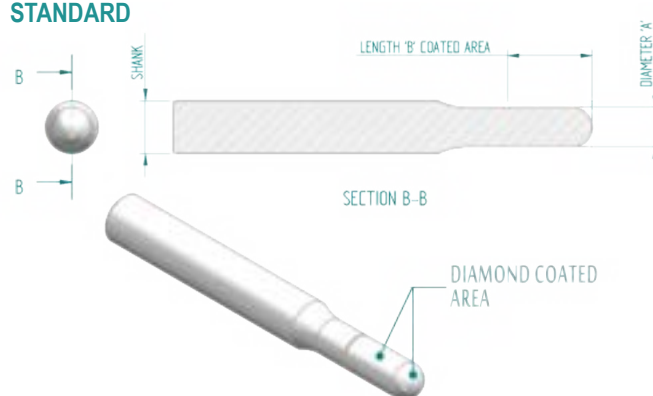
Designed for drilling, routing, rebating and trimming Glass Reinforced Plastic or similar materials. Developed to perform many different functions from trimming the unwanted section off fibreglass mouldings to routing deep rebates in laminates.

### OPTIONS:

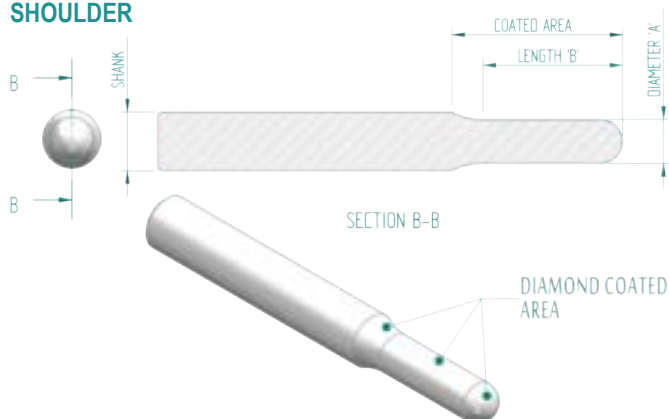
Type	Standard Coated to Shoulder
Diameters	From 4mm upwards to customer requirements
Shank Diameter	6mm, 8mm or to customer specification



### STANDARD



### COATED TO SHOULDER



## PARALLEL ROUTERS

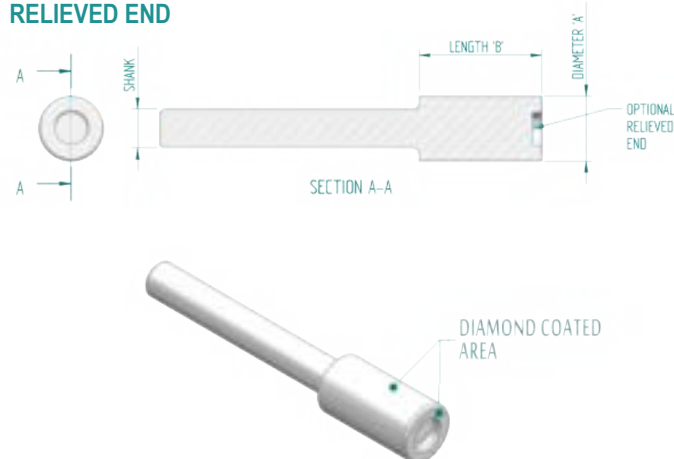
Designed for drilling, routing, rebating and trimming Glass Reinforced Plastic or similar materials. Developed to perform many different functions from trimming the unwanted section off fibreglass mouldings to routing deep rebates in laminates and other materials.

### OPTIONS:

Type	Flat End Relieved End
Diameters	4 - 25mm
Shank Diameter	6mm or to customer specification



### RELIEVED END



## OTHER RELATED PRODUCTS

SE 50 ROUTER MACHINE - Page 19

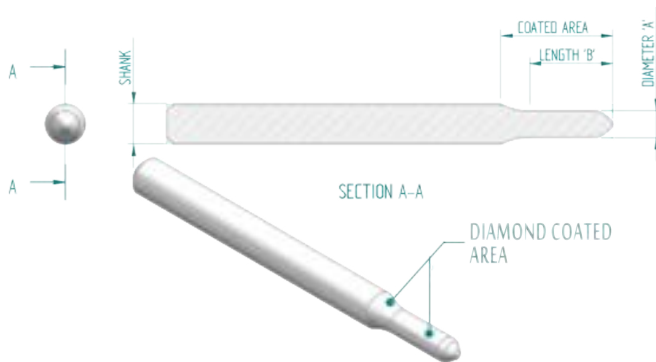
*Technical Specification: Page 24*

## PIERCING ROUTERS

Piercing routers or solid drills are usually used for drilling and routing Reinforced Plastic mouldings or laminate.

OPTIONS:

Diameter from 2mm upwards  
Shank Diameter 6mm

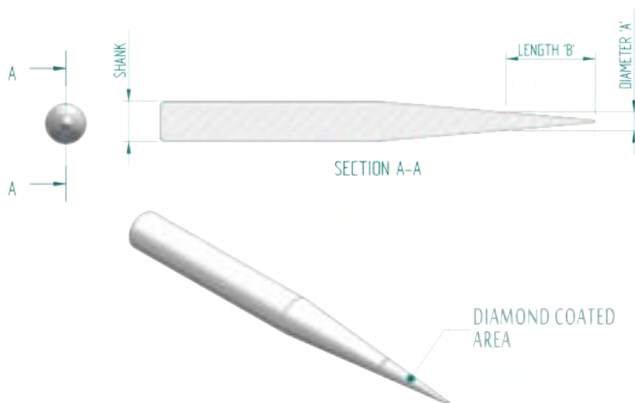


## HI-DI ROUTER

Our diamond coated routers have been developed over the years to perform many varied functions from trimming unwanted section off fibreglass mouldings to routing deep rebates in laminates of all kinds.

OPTIONS:

Diameter Top 3.5mm to point  
Shank Diameter 6mm

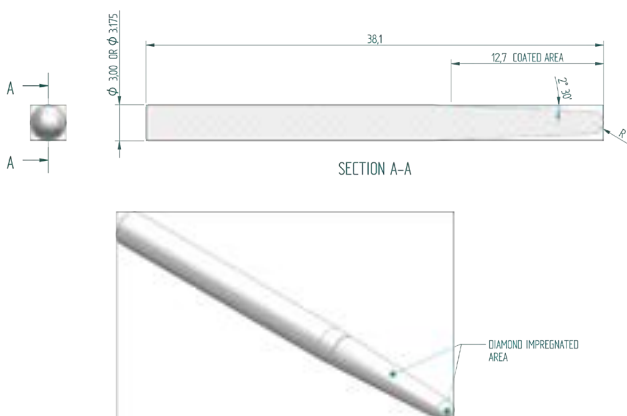


## GRASSO ROUTER

Small diameter router for intricate work on Composite and similar materials.

OPTIONS:

Diameter 3.5mm  
Shank Diameter 3mm



## OTHER RELATED PRODUCTS

SE 50 ROUTER MACHINE - Page 19

*Technical Specification: Page 24*



# GRINDING

We are able to supply grinding tools to cover the majority of grinding applications in the Composite industry.



## ELECTROPLATED DIA-DRY DISCS

Designed to provide a rapid continuous grinding of Reinforced Plastic and similar materials, with long life.

Made for dry use but can be used wet.

Recommended speed 8,000 to 12,000 rpm.

### OPTIONS:

Diameters	100, 180mm
Fitting	16mm, 22.2mm or M14
Grades	36/44, 44/60 & 60/85



## TITAN DRY GRINDING DISCS

Developed with vacuum brazed diamond for rapid stock removal.

### OPTIONS:

Diameters	115mm & 178mm
Bore	22.2mm
Grade	40

### NOTE:

Fits directly onto an angle grinder.

## OTHER RELATED PRODUCTS

AS100 ANGLE GRINDER MACHINE - Page 21

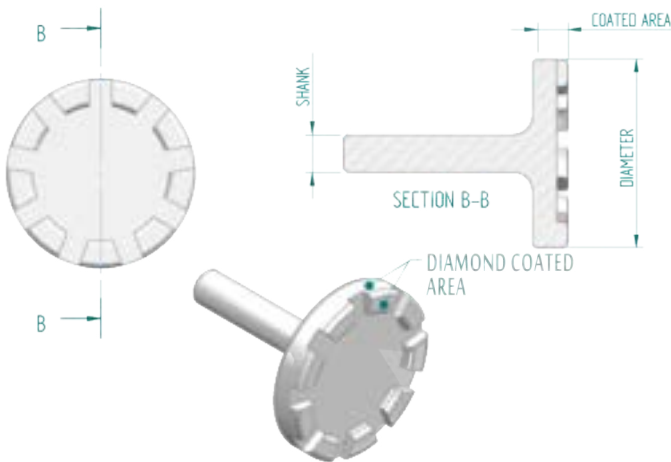
*Technical Specification: Page 24*

## SURFACE PLANERS

Designed to be used in a heavy duty routing machine for machining flat surfaces on Reinforced Plastic mouldings or blocks of laminate. The cutting edge is castellated to facilitate removal of swarf from the cutting face. Standard grade 44/60, for rapid stock removal 36/44 or 30/36 for abrasive materials.

### OPTIONS:

Diameters 40 - 75mm standard or to customer specification



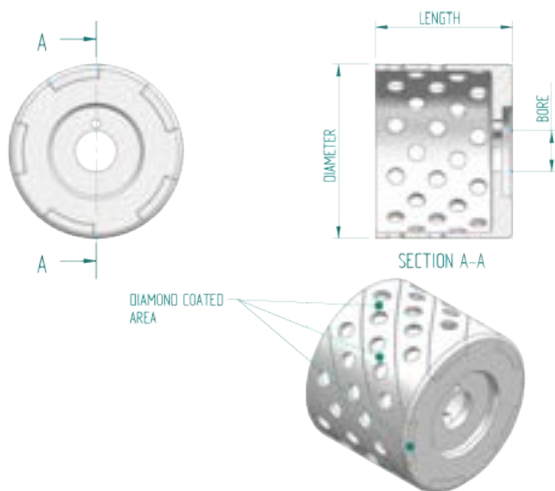
## VORTEX CUTTERS

The ideal tool for opening up, elongating and machining oval holes.

### OPTIONS:

Diameters 25 - 75mm standard or to customer specification.

Alternative sizes can be manufactured in both parallel or tapered types.



# GRINDING

## NEEDLE FILES

A full range of quality electroplated diamond coated needle files is available in the most popular shapes and grits 85/100, 120/150 and 200/240.

TYPE NO.	CODE	GRIT SIZE	DESCRIPTION
----------	------	-----------	-------------

### Tapered

TF1	ENF020	120/150	Taper Flat
TF3	ENF080	120/150	3 Square
TF5	ENF140	120/150	Square
TF6	ENF170	120/150	Round
TF9	ENF260	120/150	Half Round

### Parallel

PF10	ENF290	120/150	Hand
------	--------	---------	------

### Handle

	Taper Flat		Round
	3 Square		Half Round
	Square		Hand (Parallel)



## ELECTROFLEX HAND FILES

General purpose files supplied in sets of 4 different profiles.

### OPTIONS:

Size	155mm Overall length.
Metal Grades	Black M120, Red M200, Yellow M400 & White M800 grit



## CUSHIONED FLEXIBLE HAND PADS

Electroflex hand pads are Ideal for smoothing the edge of Reinforced Plastic moulding. Shaped foamed backing for comfortable grip. Colour coded foam backing for easy grade identification.

### OPTIONS:

Size	90 x 55 mm & 100 x 55 mm
Metal Grades	Black M120, Red M200, Yellow M400 & White M800 grit



## DIA-MET HAND PADS

A rigid hand pad with aggressive stock removal for hand grinding reinforced plastic and similar materials.

### OPTIONS:

Size	—	95 x 55mm
Grades	—	Green M60, Black M120, Red M200



# GRINDING



## NARROW DIAMOND BELTS

Designed for dry grinding and deburring reinforced plastic and similar materials.

### OPTIONS:

Size

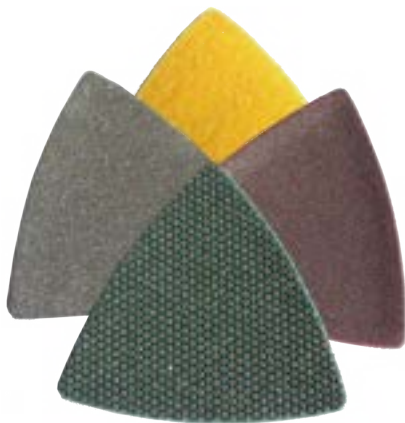
Length 305 x 13mm wide &

Length 610 x 13mm wide

Metal Grades

Black M120, Red M200,

Yellow M400 & White M800 grit



## ELECTROFLEX FEIN TRIANGLE PADS

Used for removing sharp edges, arrising and bevelling. These pads have a quick release backing (QRS) for rapid change. Available in various sizes with or without water holes.

### OPTIONS:

Metal Grades

Black M120, Red M200,

Yellow M400 & White M800 grit



## ELECTROFLEX DRUMS

M14 Drums with central waterfeed for wet polishing.

### OPTIONS:

Size

Ø50 x 42mm Wide

Ø75 x 50mm Wide

Metal Grades

Black M120, Red M200,

Yellow M400 & White M800 grit

Technical Specification: Page 24



## QRS BACKING DISCS (VELCRO™)

Quick release discs for grinding Reinforced Plastic and similar materials. Colour coded for easy grade identification.

Sizes Ø100mm & Ø125mm

Metal Grades Black M120, Red M200,  
Yellow M400 & White M800 grit



## QRS BACKUP PADS

Backing pads for Ø100mm QRS discs. Flat and Cushioned types available with M14 fitting.

Sizes Ø100mm & Ø125mm

## ELECTROFLEX BACKED DISCS

The M14 discs are used wet for rapid grinding.

Size Ø100mm

Metal Grades Black M120, Red M200,  
Yellow M400 & White M800 grit



## D-LOC DISCS

Quick release discs for grinding Composites. Colour coded for easy grade identification.

### OPTIONS:

Diameter 25, 50 & 75 mm

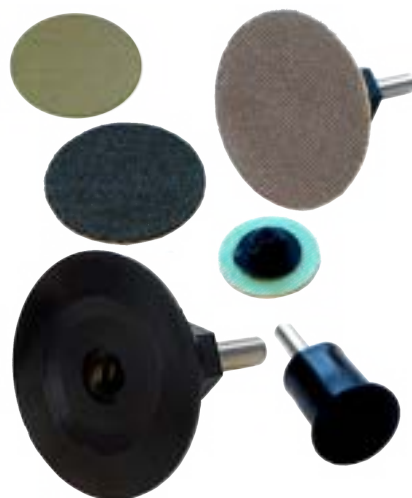
Metal Grades Black M120, Red M200,  
Yellow M400 & White M800 grit

## D-LOC MANDRELS

Quick release backup pads and shaft for D-Loc Discs.

### OPTIONS:

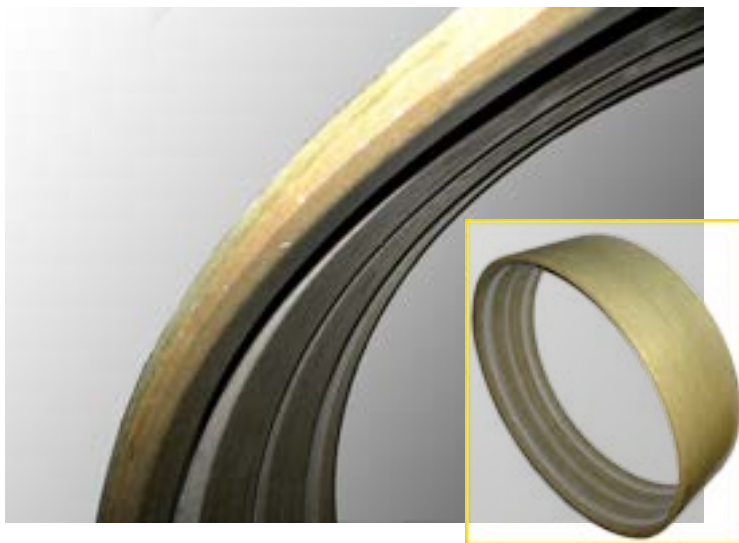
Diameter 25, 50 & 75 mm



# SPECIALS

## SPECIAL TOOLS

We are specialists in designing and manufacturing special tools for many applications. For example, we are renowned for a large range of calibration wheels, drills, saws, routers, holesaws etc. specifically for the GRP/FRP Pipe Industry and also for the Wind Turbine Industry.



## GRP/GRE PIPES

DK manufactures a range of standard tools as well as bespoke tooling for individual requirements. These tools can be used for both Continuous/Discontinuous Filament Wound Pipe and Centrifugal Cast Pipe.

We also hold a large stock for immediate despatch of Reka Coupling, Locking Bell and Spigot Joint tooling, Online and Offline Calibration Drums and Threading wheels.



## WIND TURBINE INDUSTRY

As one of the world's leading manufacturers of diamond tooling for the production of Wind Turbine parts DK Holdings can offer a range of holesaws up to 950mm in diameter, surface planers and large diameter saws of up to 700mm for blade root trimming. All of these tools are available in various diamond grades to suit your specific application.

We also offer a **Design - Manufacture - Supply** service for all of your special tools. Please contact our Technical Sales Engineers to discuss your requirements.

Additionally to the above, the team can also offer a strip, replate and retipping service for your used electroplated and metal bond tools. This could save you up to 40% on your tooling costs.



# HAND MACHINES

## AIR POWERED MACHINES

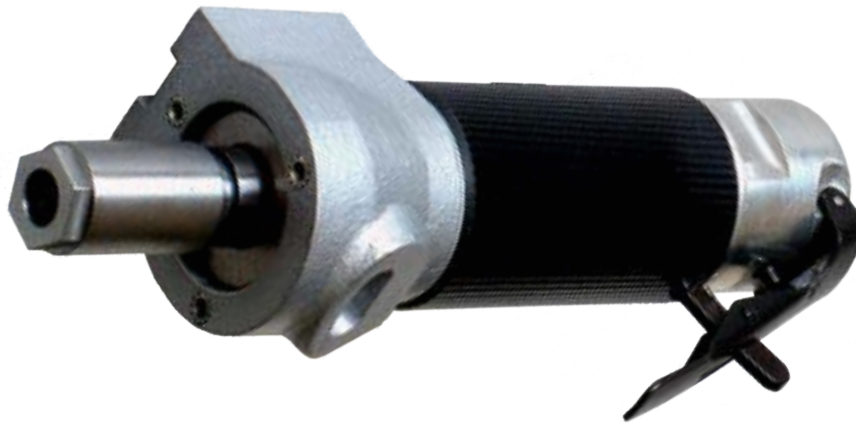
### SE20 TRIMMING MACHINE

This robust lightweight powerful hand machine has been developed for rebating and sawing materials up to 12mm thick. The design of the machine allows it to be easily adapted for jig following and can also be bench or pedestal mounted. The machine is supplied with a safety guard and includes a safety lever throttle.

NOTE:

For ROUTING — 6 or 8mm routers can be used and when used with a collet nut adaptor the machine will drive a 65mm diameter saw.

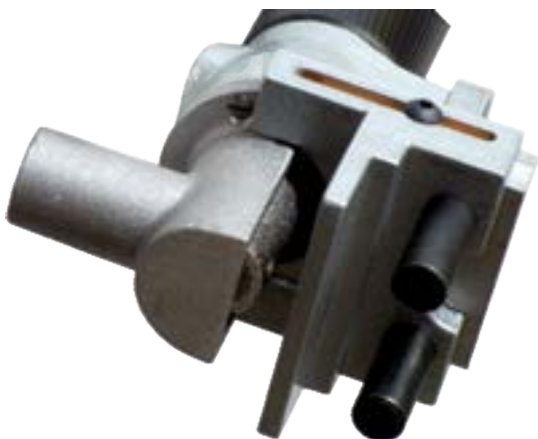
For TRIMMING — trimming can be carried out by using a 6mm router but the SE50 is more suited for this purpose.



### OPTIONAL ATTACHMENTS

#### REBATING ATTACHMENT AND GAUGE

When used with a standard 19 x 35mm rebating router the adjustable guide allows a large range of rebates to be machined quickly and economically.



#### JIG TRIMMING GUIDE AND GAUGE

When used with a 40mm diameter side spoke saw this unit allows for precision trimming to be carried out by following a jig with the roller guides and adjusting width of cut as required.



Technical Specification: Page 25



# HAND MACHINES

## SE50 ROUTING MACHINE

The high speed air powered machine has been designed principally to be used in conjunction with our diamond coated saws and routers for trimming Reinforced Plastic mouldings up to 3mm thick using saws up to 40mm diameter, either freehand or following a jig. The machine incorporates an auxiliary sleeve which can be easily removed for rapid change of tooling and will accept routers up to 6mm diameter. The machine is supplied with a plain nose cowl and includes a safety lever throttle.

### NOTE:

The SE50 has a side exhaust. The supplied plain nose cowl which can be used as a jig guide also protects both collet and router shank from abrasion.



## QUICK Q-6R PNEUMATIC WET POLISHER

Variable speed grinder with central water feed and rear exhaust. M14 fitting.



## AS70 ANGLE SAW

The AS70 is a very powerful lightweight machine fitted with an open saw guard and efficient dust extraction.

The narrow head on the AS70 enables machining to be carried out in tight corners up to 12mm thick. Spent air is exhausted through the handle preventing the material being contaminated by airborne particles. Supplied with safety lever throttle, hose, oil etc.

### NOTE:

Recommended Saws

Side Spoke Saw 44/60 grit, Ø70mm x 1.6mm x 16mm



*Technical Specification: Page 39*



# HAND MACHINES

## AS100 ANGLE SAW

The AS100 is a very powerful robust machine developing 1.5 HP. Fast cutting, with very effective dust extraction, of Reinforced Plastic up to 25mm thick using a 100mm diameter side spoke saw. Supplied with a combined saw guard and dust extraction cowl and safety lever throttle.

**NOTE:**

Recommended Saws

Side Spoke or Continuous Rim

44/60 grit, 100mm x 1.6mm x 15.875mm



## AS125 ANGLE SAW

The AS125 has the same power and specifications as the AS100. It has been designed to accept larger diameter saws for applications requiring a greater depth of cut. Will cut laminate up to 25mm thick or corrugated sheeting up to 40mm. Supplied as standard with safety lever throttle.

**NOTE:**

Recommended Saws

Side Spoke or Continuous Rim

44/60 grit, 125mm x 1.6mm x 15.875mm



## OPTIONAL ATTACHMENTS

### SOLE PLATE WITH ADJUSTABLE DEPTH GAUGE

A sole plate with adjustable depth gauge is available providing precise cutting depth of up to 35mm.

## AS100 ANGLE GRINDER

Very powerful, heavy duty machine developing 1.5HP. Used for rapid grinding of Reinforced Plastic with a 100mm diameter Dia-Dry disc. The machine is supplied with a combined guard and dust extraction cowl and with safety lever throttle.

**NOTE:**

Recommended Disc

Ø100mm Dia-Dry 36/44 & 44/60



*Technical Specification: Page 25*

# HAND MACHINES

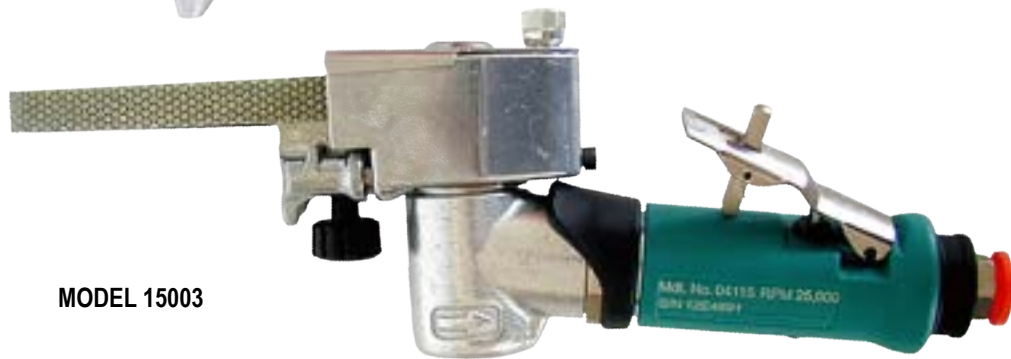
## AIR BELT POLISHERS

Diamond belt machine with Locklever for grinding, deburring and polishing difficult to reach areas. With 7° offset and rear exhaust.

MODEL 14000



MODEL 15003



## ELECTRIC MACHINE

### FEIN MULTIMASTER MM 700

The Fein Multimaster MM 700 is used for dry polishing.  
Speed variable 10,000 - 19,500

### FEIN BACKUP PADS

QRS backing pad (box of 2)



Technical Specification: Page 25

# ACCESSORIES



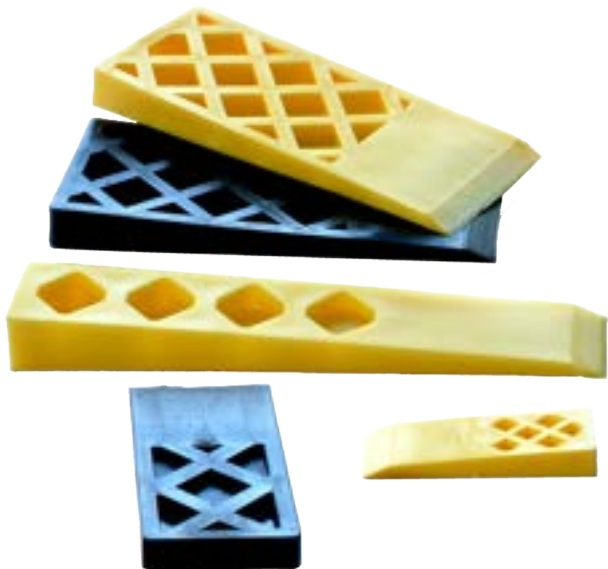
AIR PREPARATION MINI FILTER/  
REGULATOR AND LUBRICATOR

## OIL MIST LUBRICATOR

### FOR USE WITH AIR MACHINES

Air preparation mini filter/regulator and lubricator which filters air and water. The lubricator oil can be replenished without stopping the air line and oil delivery in a perfect mist, ensuring good lubrication to the working parts of the air power tool for maximum efficiency and long life. The semi-automatic drain filter bowl with high quality polycarbonate bowl is designed for long service life.

*BMP032	Mini	55 cu. ft./min
		1650 litre/min
*MMPL10	Hydrasil 10 Lubrication Oil ½L	



## PLASTIC WEDGES

Plastic wedges are used for separating Reinforced Plastic “lay ups” from the mould. These wedges are manufactured to provide an ideal and professional method for demoulding the finished lay up without causing damage to the “Gel Coat”.

### OPTIONS:

Sizes	175mm x 75mm, 130mm x 55mm 100mm x 38mm, 215mm x 38mm
Rigid	Yellow - used for flat moulds
Flexible	Black - used for curved moulds

## STRIP, RE-PLATE & RE-TIP SERVICE

We offer a strip and replate service for your used electroplated tools, this could save you up to 40% on your tooling costs.  
Please ask us for a quotation.

*BEFORE*

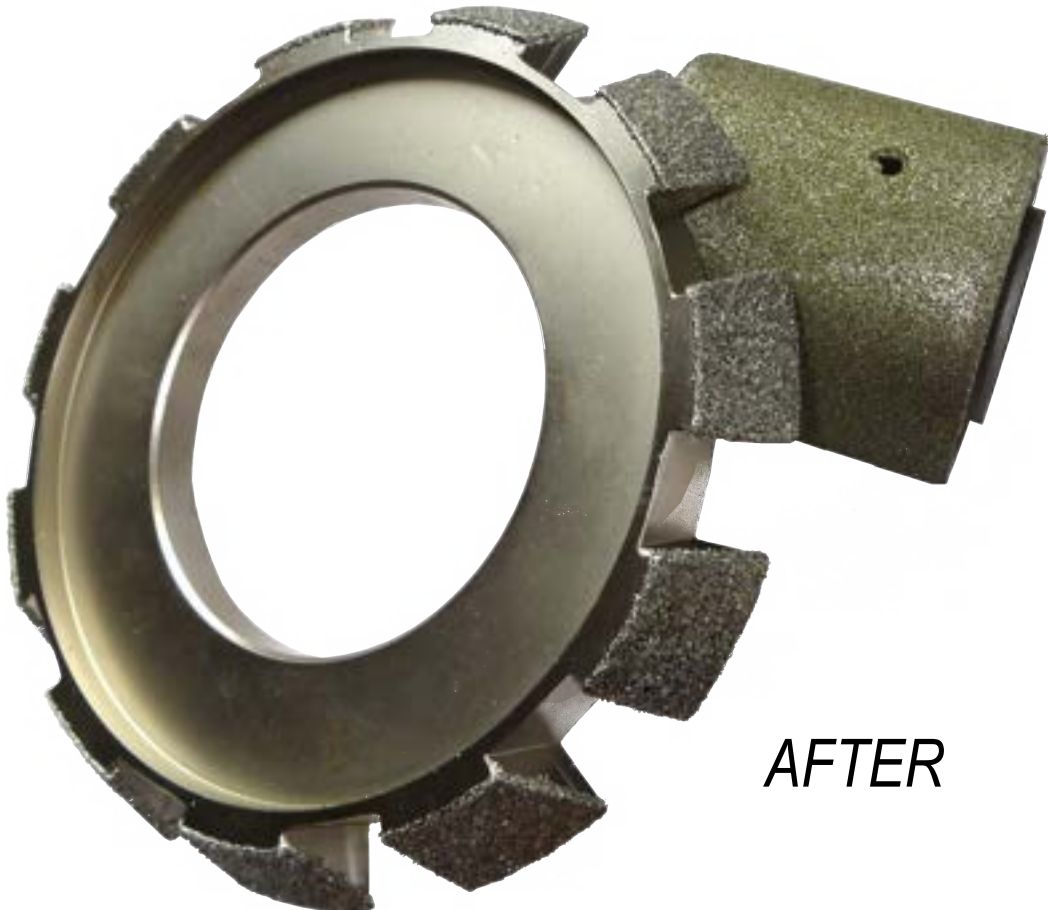


### STRIP & REPLATE SERVICE AVAILABLE FOR:

- Continuous Rim Blades
- Flute Wheels
- Profile Wheels
- Parallel Routers
- Various Electroplated CNC Tooling

### RE-TIP SERVICE AVAILABLE FOR :

- Multicut Core Drills
- Milling Wheels
- Routers (Metal Bond)
- Drums



*AFTER*

# TECHNICAL SPECIFICATION

## SAW BLADES - PAGES 2 - 3

SURFACE SPEED	
1,500 - 3,000 m/min	25 - 50 m/sec

## SPINDLE SAWS - PAGE 3

SURFACE SPEED	
1,500 - 3,000 m/min	25 - 50 m/sec

## OSCILLATING BLADES - PAGE 4

STROKES
11,000 - 18,500 / min

## BANDSAW BLADES - PAGE 4

TENSION	MOS
1,050 - 1,400 kg/cm <sup>2</sup>	1,400 m/min - 1,800 m/min

## JIGSAW BLADES - PAGE 4

STROKES
1,900 - 2,400 / min

## ELECTROPLATED HOLESAWS - PAGE 5

DIAMETER	RPM
14-20mm	2,500
22-38mm	2,000
40-60mm	1,500
65-85mm	1,000
90-150mm	500

## METAL BOND CORE DRILLS - PAGE 6

DIAMETER	RPM
12-20mm	3,300 - 2,000
23-39mm	1,740 - 1,030
40-60mm	1,000 - 670
62-89mm	650 - 450

## DIAMOND TWIST DRILLS - PAGE 7

DIAMETER	RPM
4mm	2,500
9.5mm	1,500

## DIAMOND COUNTERBORES - PAGE 7

DIAMETER	RPM
4mm	2,500
9.5mm	1,500

## DIAMOND COUNTERSINKS - PAGE 7

DIAMETER	RPM
4mm	2,500
9.5mm	1,500

## ELECTROPLATED ROUTERS - PAGES 8 - 9

DIAMETER	SURFACE SPEED	SPEED RANGE
6mm	8-16 m/sec	25,500 - 50,000 rpm
8mm	8-21 m/sec	20,000 - 50,000 rpm
10mm	8-16 m/sec	15,300 - 30,000 rpm
12mm	8-16 m/sec	12,700 - 25,000 rpm
16mm	8-16 m/sec	8,550 - 19,100 rpm
19mm	8-16 m/sec	8,050 - 16,100 rpm
25mm	8-16 m/sec	6,110 - 12,225 rpm

## DIA DRY DISCS - PAGE 10

DIAMETER	RPM
100mm	12,000
180mm	8,500

## TITAN DISCS - PAGE 10

DIAMETER	RPM
100mm	12,000
180mm	8,500

## SURFACE PLANERS - PAGE 11

DIAMETER	SURFACE SPEED	SPEED RANGE
30mm	25-31 m/sec	16,550 - 20,000 rpm
40mm	25-42 m/sec	12,000 - 20,000 rpm
50mm	25-52 m/sec	10,000 - 20,000 rpm
65mm	25-50 m/sec	7,350 - 14,700 rpm
75mm	20-50 m/sec	5,000 - 12,730 rpm

## VORTEX CUTTERS - PAGE 11

DIAMETER	SURFACE SPEED	SPEED RANGE
25mm	8-31 m/sec	6,000 - 23,700 rpm
50mm	16-31 m/sec	6,000 - 12,000 rpm
75mm	16-39 m/sec	4,000 - 10,000 rpm

## ELECTROFLEX DRUMS - PAGE 14

POLISHING	MOS
Wet	3,600 rpm

## FLEXIBLE DISCS & PADS - PAGES 15

Refer to machine manufacturers recommendations for speeds.
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# TECHNICAL SPECIFICATION

## SE20 TRIMMING MACHINE - PAGE 18

COLLET DIAMETER	MAX. HOSE DIAMETER	MAX. SAW DIAMETER	WEIGHT
mm 6 or 8	internal/dia. mm 10	mm 75	kg 0.91
FREE SPEED	AIR PRESSURE		AIR CONSUMPTION
rpm 20,000	PSI 100	BAR 6.9	litre/min 425

## SE50 ROUTING MACHINE - PAGE 19

COLLET DIAMETER	MAX. HOSE DIAMETER	MAX. SAW DIAMETER	WEIGHT
mm 6	internal/dia. mm 6	mm 50	kg 1.14
FREE SPEED	AIR PRESSURE		AIR CONSUMPTION
rpm 72,000	PSI 100	BAR 6.9	litre/min 340

## Q6-R PNEUMATIC WET POLISHER - PAGE 19

WEIGHT	FREE RUNNING SPEED	AIR PRESSURE
1.2 kg	0-3500 rpm	15 cfm @ 90 psi

## AS70 ANGLE SAW - PAGE 19

MIN. HOSE DIAMETER	MAX. SAW DIAMETER	WEIGHT
internal/dia. mm	mm	kg
10	70	0.9
FREE SPEED	AIR PRESSURE	AIR CONSUMPTION
rpm	PSI BAR	litre/min
12,000	100 6.9	536

## AS100 ANGLE SAW - PAGE 20

<b>MIN. HOSE DIAMETER</b>	<b>MAX. SAW DIAMETER</b>	<b>WEIGHT</b>
internal/dia. mm	mm	kg
10	100	1.68
<b>FREE SPEED</b>	<b>AIR PRESSURE</b>	<b>AIR CONSUMPTION</b>
rpm	<b>PSI   BAR</b>	litre/min
12,700	100   6.9	565

## AS125 ANGLE SAW - PAGE 20

<b>MIN. HOSE DIAMETER</b>	<b>MAX. SAW DIAMETER</b>	<b>WEIGHT</b>
internal/dia. mm	mm	kg
10	125	2.25
<b>FREE SPEED</b>	<b>AIR PRESSURE</b>	<b>AIR CONSUMPTION</b>
rpm	<b>PSI    BAR</b>	litre/min
12,700	100   6.9	565

## AS100 ANGLE GRINDER - PAGE 20

<b>MIN. HOSE DIAMETER</b>	<b>MAX. SAW DIAMETER</b>	<b>WEIGHT</b>
internal/dia. mm	mm	kg
10	100	1.68
<b>FREE SPEED</b>	<b>AIR PRESSURE</b>	<b>AIR CONSUMPTION</b>
rpm	<b>PSI   BAR</b>	litre/min
12,700	100   6.9	565

## AIR BELT POLISHERS - PAGE 21

WEIGHT	MODEL	AIR FLOW SCFM (LPM)	MOTOR hp	SPEED
0.82 kg	15003	20 (556)	.4	25,000 rpm max.
1.4 kg	14000	31 (878)	.5	20,000 rpm max.

## FEIN MULTIMASTER MM 700 - PAGE 21

WEIGHT	SPEED	VOLTAGE
1.9 kg	Variable 10,000 - 19,500	110

## OIL MIST LUBRICATOR - PAGE 22

Compact size up to 1650 litres/minute 55 cfm air flow 1/4" BSP fittings.

Operating pressure range 0.5-8.0kgf/cm<sup>2</sup> 0.5-7-114 PSI. Effective water and particle removal 5µm filter elements. Operating temperature range 10°-60° (14-140F).

Recommended oil type ISO-VG32 the 4-6 drops per minute is adjusted by screwdriver to prevent unintentional oil volume adjustment.

The Technical Specification information is for guidance only, assuming your machine/tools are in serviceable condition and have been maintained to the manufacturer's specification.

For further technical information, please contact us.

# BUSINESS TERMS

## BUSINESS HOURS

Monday — Friday : 8.00 am - 5.00 pm

## ORDERING IS EASY

Contact us on:



TELEPHONE - +44 (0)1580 891662



E-MAIL - [sales@dk-holdings.co.uk](mailto:sales@dk-holdings.co.uk)



Or alternatively post your order to:  
DK Holdings Limited  
Station Approach, Staplehurst  
Kent TN12 0QN  
UK

## MINIMUM ORDER VALUE

There is no minimum order value.

## DELIVERY

Phone or email your order through to our sales department before 12.00pm for same day despatch on certain stocked items when you hold an approved credit account. For non account holders we will despatch on receipt of payment. Cheques and credit card/debit payments accepted.

## DEDICATED SALES TEAM

Our fully trained sales staff are ready to take your calls from 8.00am to 5.00pm Monday to Friday (answering system outside these call times). They can offer advice and guidance to ensure that you get the right product for your application.

## SERVICE IS OUR STRENGTH

Our service does not end when a product has been sold. Qualified personnel provide operator training and after-sales technical support.



@DK\_Holdings



DK Holdings Limited

## PAYMENT TERMS

Paying is easy. Open an account, pay by credit/debit card, cheque or credit transfer.

To qualify for credit account status, a credit application must be completed in full. Satisfactory references are required for credit consideration.

## CARD PAYMENTS

We accept payment by Visa, MasterCard, Maestro and Visa Debit.

## BANK DETAILS

### International Bank Account Number (IBAN)

Bank: National Westminster Bank PLC  
Address: 3 High Street, Maidstone,  
Kent, ME14 1XU,  
United Kingdom.

Country: GB  
Currency: STERLING  
Sort Code: 60-60-08  
Account No: 02901749  
IBAN No: GB10NWBK60600802901749  
B.I.C. No: NWBKGB2L

# PURCHASE ORDER

Company Name & Address		Despatch Address <i>[if different to Company Address]</i>	
Name:	Authorized Signature:	Order No.	Date:

DESPATCHING INSTRUCTIONS		INVOICING INSTRUCTIONS	
9	Courier	9 Visa Debit 9 Visa	9 Mastercard 9 Maestro
9	1st Class Post	Account No.	
9	Parcel Post	Expiration date	Security No.
9	Air Freight	Name of cardholder	
9	Road Freight	9 COD 9 Prepayment	
9	Other	9 Invoice - established account, approved credit	

QTY	CODE	DESCRIPTION	UNIT PRICE

D.K. Holdings Limited collects personal information when you complete this form or place an order with us for our products. We will use this information to provide the products and services requested, maintain guarantee records and, if you have agreed, to send you occasional marketing information. For further information on how our data might be used, please see our Privacy Notice.

We would like to send you information about our products. Please tick one of the following.

Yes, I do agree ~  
No, I do not agree ~

Get in touch with us and find out more  
about our other Diamond Tooling Ranges.