



# 2024 Catalog

Active Tooling, LLC. was founded in Zeeland, Michigan in 2011 by Gary Lubbers. Active Tooling offers hundreds of years of combined experience and expertise in the precision tooling industry. It continues to be a leader in custom manufactured tooling and distribution to the plastics, composites, wood, and non-ferrous metal industries.

At Active Tooling, we strive to combine the latest improvements in technology in order to supply and service a wide variety of your tooling needs. We house the latest CNC equipment that offers precision in manufacturing and sharpening all different types of carbide tooling. With the ability to service and manufacture carbide tooling in house, we can offer quick turn-around time. From your product sample or print, we can have your custom tool quoted, designed, and manufactured in less time than competitors. With our expertise, Active Tooling is available to assist you with recommended feeds and speeds and to assist you with any application that you may encounter. We currently offer personal delivery free of charge to most parts of Michigan, Ohio, Illinois, and Indiana. We also service worldwide to a wide range of customers and industries. Our line of industry-leading solid carbide spiral tooling is available in stock with many other router bits, saws, inserts, and tooling products. We also maintain an extensive dealer network to supply ever one of your tooling needs. Some of these companies include but are not limited to: Amana, Apex, Belin, Byrd Tooling, Ceratizit, CMT, G3 Fantacci, Freeborn, FS Cruing, FS Tool, Freud, Fullerton Tool, Guhdo, Hyde Tools, MK Morese, Morris Wood Tool, Onsrud Cutter, Popular Ruko Tool Techniks, Tenryu America, Terminus, Tigra, Timberline, Whiteside Machine, Wisconsin Knife Works, WL Fuller and more.

# Don't see what you are looking for?

## **Custom manufacturing**

Active's experienced staff can build a tool to optimize your equipment's performance. Starting with a CAD design based off of your drawing, print, or part itself, we can provide you with a quote on building your tool. Upon your approval, we use our state-of-the-art machine shop to give you quick turn around time on your tools

## **Service**

Active looks to help your bottom line. Our service staff has lost of experience trouble shooting tooling needs or optimizing efficiency. Call with questions or to set up a meeting for an advisor to help

## **Sharpening**

We service all tools for the woodworking and non-ferrous metal industries and more. Our CNC grinders can sharpen all tolerances to spec to ensure the longest life possible out of your tool.

## **Suppliers**

Through our vast supplier network, we have access to tools of all different types. Please call with your needs.

## Upcut Double Flute Solid Carbide

Part Number	CED	CEL	SHK DIA	OAL	Additional
AT250.125.350UPHH	1/4"	1 1/4"	1/4"	3 1/2"	High Helix
AT250.150.400UP	1/4"	1 1/2"	1/4"	4"	
AT375.113.300UP	3/8"	1 1/8"	3/8"	3"	
AT12212-CB	3/8"	1 1/4"	3/8"	3"	Chip Breaker
AT375.150.300UP	3/8"	1 1/2"	3/8"	3"	
AT375.163.350UPHH	3/8"	1 5/8"	3/8"	3 1/2"	High Helix
AT12224-LH	1/2"	1 1/4"	1/2"	3"	Left Hand
AT500.125.300UP	1/2"	1 1/4"	1/2"	3"	
AT500.150.300UP	1/2"	1 1/2"	1/2"	3"	
AT500.125.300SH	1/2"	1 1/4"	1/2"	3"	Slow Helix
AT500.200.400UP	1/2"	2"	1/2"	4"	
AT500.213.400UP	1/2"	2 1/8"	1/2"	4"	
AT625.200.400UP	5/8"	2"	5/8"	4"	
AT750.200.400UP	3/4"	2"	3/4"	4"	
AT750.350.600UP	3/4"	3 1/2"	3/4"	6"	

## Upcut Triple Flute Solid Carbide

Part Number	CED	CEL	SHK DIA	OAL	Additional
AT12150	1"	4 1/2"	1"	6"	

## Downcut Double Flute Solid Carbide

Part Number	CED	CEL	SHK DIA	OAL	Additional
AT250.100.300DN	1/4"	1"	1/4"	3"	
AT250.100.300DN-AAC	1/4"	1"	1/4"	3"	AAC
AT250.150.400DN	1/4"	1 1/2"	1/4"	4"	
AT250.225.400DN	1/4"	2 1/4"	1/4"	4"	
AT375.113.300DN	3/8"	1 1/8"	3/8"	3"	
AT406.125.300DN	0.406"	1 1/4"	1/2"	3"	
AT500.125.300DN	1/2"	1 1/4"	1/2"	3"	
AT500.125.300DN-AAC	1/2"	1 1/4"	1/2"	3"	AAC
AT500.150.350DN	1/2"	1 1/2"	1/2"	3 1/2"	
AT500.163.400DN	1/2"	1 5/8"	1/2"	4"	
AT500.200.400DN	1/2"	2"	1/2"	4"	
AT500.213.400DN CB	3/4"	2 1/8"	1/2"	4"	Chip Breaker
AT750.163.400DN	3/4"	1 5/8"	1/2"	4"	
AT750.200.400DN	3/4"	2"	3/4"	4"	
AT750.350.600DN	3/4"	3 1/2"	3/4"	6"	
AT750.350.600DN-LH	3/4"	4 1/2"	3/4"	6"	Left Hand

## Downcut Triple Flute Solid Carbide

Part Number	CED	CEL	SHK DIA	OAL	Additional
AT375.125.300.3DN	3/8"	1 1/4"	3/8"	3"	
AT500.125.300.3DN	1/2"	1 1/4"	1/2"	3"	
AT1311DN CB	1/2"	1 1/4"	1/2"	3"	Chip Breaker
AT500.125.350.3DN	1/2"	1 1/4"	1/2"	3 1/2"	

## Compression Single Flute Solid Carbide

Part Number	CED	CEL	SHK DIA	OAL	UCL	Additional
AT10132	1/2"	1"	1/2"	3"	3/8"	

## Compression Double Flute Solid Carbide

Part Number	CED	CEL	SHK DIA	OAL	UCL	Additional
AT250.845.250C	1/4"	7/8"	1/4"	2 1/2"	1/4"	
AT1026	1/4"	7/8"	1/4"	3"	3/16"	
AT1026M	1/4"	7/8"	1/4"	3"	1/16"	Mortise
AT250.150.400C	1/4"	1 1/2"	1/4"	4"	3/16"	
AT375.100.300CM	3/8"	1"	3/8"	3"	3/16"	Mortise
AT1019	3/8"	1 1/4"	3/8"	3"	1/4"	
AT1019-AAC	3/8"	1 1/4"	3/8"	3"	1/4"	AAC
AT1019-CB	3/8"	1 1/4"	3/8"	3"	1/4"	Chip Breaker
AT1019-M	3/8"	1 1/4"	3/8"	3"	3/16"	Mortise
AT375.125.300-CLU	3/8"	1 1/4"	3/8"	3"	1/2"	Long Up
AT10246-CB	3/8"	1 5/8"	3/8"	3 1/2"	1/2"	Chip Breaker
AT1018	1/2"	7/8"	1/2"	3"	0.44"	Mortise
AT500.125.300C	1/2"	1 1/4"	1/2"	3 1/2"	5/16"	
AT500.125.350C-AAC	1/2"	1 1/4"	1/2"	3 1/2"	5/16"	AAC
AT1043	1/2"	1 3/8"	1/2"	3"	1/4"	Mortise
AT1043-AAC	1/2"	1 3/8"	1/2"	3"	1/4"	Mortise, AAC
AT1043LH	1/2"	1 3/8"	1/2"	3"	1/4"	Left Hand
AT1043-CB	1/2"	1 3/8"	1/2"	3"	1/4"	Chip Breaker
AT500.138.300C	1/2"	1 3/8"	1/2"	3"	7/16"	
AT500.138.300C-AAC	1/2"	1 3/8"	1/2"	3"	7/16"	

## Compression Double Flute Solid Carbide

Part Number	CED	CEL	SHK DIA	OAL	UCL	Additional
AT1002	1/2"	1 1/2"	1/2"	4"	0.28"	Mortise
AT1002-AAC	1/2"	1 1/2"	1/2"	4"	0.28"	Mortise, AAC
AT1007	1/2"	1 5/8"	1/2"	4"	0.63"	
AT1007-AAC	1/2"	1 5/8"	1/2"	4"	0.63"	AAC
AT1007-CB	1/2"	1 5/8"	1/2"	4"	0.63"	Chip Breaker
AT1016	1/2"	1 3/4"	1/2"	4"	3/16"	
AT1016-LH	1/2"	1 3/4"	1/2"	4"	3/16"	Left Hand
AT10241	1/2"	2"	1/2"	4"	1/2"	
AT10241-LH	1/2"	2"	1/2"	4"	1/2"	Left Hand
AT1066	5/8"	2"	5/8"	4"	1/2"	
AT1015	3/4"	2"	3/4"	4"	7/16"	
AT1024	3/4"	2"	3/4"	4"	1"	Long Up
AT1024-LH	3/4"	2"	3/4"	4"	1"	Long Up, Left hand
AT1024L-AAC	3/4"	3"	3/4"	4"	1"	Long Up, Left hand, AAC
AT10279	3/4"	2"	3/4"	6"	5/8"	
AT750.350.600C	3/4"	3 1/2"	3/4"	6"	3/4"	
AT750.400.600C	3/4"	4"	3/4"	6"	9/16"	
AT1024L-AAC	3/4"	3"	3/4"	4"	1"	Long Up, Left hand, AAC
AT10279	3/4"	2"	3/4"	6"	5/8"	
AT750.350.600C	3/4"	3 1/2"	3/4"	6"	3/4"	
AT750.400.600C	3/4"	4"	3/4"	6"	9/16"	

## Compression Triple Flute Solid Carbide

Part Number	CED	CEL	SHK DIA	OAL	UCL	Additional
AT375.875.300CM	3/8"	7/8"	3/8"	3"	1/8"	Mortise
AT375.125.300.3CM	3/8"	1 1/4"	3/8"	3"	1/8"	Mortise
AT1003	3/8"	1.30"	3/8"	3"	1/2"	
AT1004	1/2"	1.30"	1/2"	3"	3/8"	
AT1004-AAC	1/2"	1.30"	1/2"	3"	3/8"	AAC
AT500.138.300.3CM	1/2"	1 3/8"	1/2"	3"	3/16"	Mortise



## Upcut Triple Flute Solid Carbide Rougher

Part Number	CED	CEL	SHK DIA	OAL	Additional
AT1142	1/4"	7/8"	1/4"	2 1/2"	
AT1100	3/8"	1.30"	3/8"	3"	
AT500.113.350.3UR	1/2"	1 1/8"	1/2"	3 1/2"	
AT1191SH	1/2"	1 1/8"	1/2"	3"	
AT1191	1/2"	2 5/8"	1/2"	4"	Slow Spiral
AT1118	1/2"	2"	1/2"	4"	
AT750.2503500TFR	3/4"	2 1/2"	3/4"	5"	
AT750.300.700UPRGH	3/4"	3"	3/4"	6"	
AT750.325.600TFR		3 1/4"	3/4"	7"	

## Upcut Triple Flute Solid Carbide Rougher

Part Number	CED	CEL	SHK DIA	OAL	Additional
AT500.113.350.3DR	1/2"	1 1/8"	1/2"	3 1/2"	
AT191-DN	1/2"	1 5/8"	1/2"	4"	Slow Spiral
AT750.250.400.3DR	3/4"	2 1/2"	3/4"	4"	

## Collet Measuring Guide

Collet Series	Length (L)	Diameter (D)
ER 11	18mm (0.708")	11.5mm (0.45")
ER 16	27.5mm (1.08")	17mm (0.67")
ER 20	31.5mm (1.08")	21mm (0.83")
ER 25	34mm (1.34")	26mm (1.02")
ER 32	40mm (1.57")	33mm (1.3")
ER 40	46mm (1.81")	41mm (1.61")
TG 75	47mm (1.85")	27mm (1.06")
TG 100	60mm (2.36")	35mm (1.38")
SYOZ 20	34mm (1.34")	20mm (0.78")
SYOZ 25	52mm (2.06")	35mm (1.38")

[Ask about our Heain piggyback motor collet nuts](#)

Abbreviations Meaning	
CED	Cutting Edge Diameter
CEL	Cutting Edge Length
SHK DIA	Shank Diameter
OAL	Overall Length
UCL	Up Cut Length
AAC	Active Advantage Tooling