



# 金刚石刀具系统

## POLYCRYSTALLINE DIAMOND TOOLING SYSTEMS



如有特殊要求，可按需定制。  
Custom-tailor would be available against customers' requirements.

## 裁板锯 / Table Saw Blade



### 切割材料 / Cutting material:

人造板素板，三聚氰胺贴面，纸贴面及其他贴面的人造板 (MDF/PB)。

Non, Melamine Laminated, paper laminated or other material laminated MDF/PB

### 用途 / Usage:

推台锯  
Table saw

### 参数 / Parameter:

锯齿高度5.5mm  
H=5.5mm

### 特点 / Character:

高性能PCD刀头，优质合金工具钢本体，高效膨胀散热槽，优化的刃形结构。

High quality PCD tip, High quality steel body, good expansion slot, optimized teeth pattern.

序号 Ordinal	外径(ΦD) Diameter	刃厚(B) Kerf	本体厚(b) Body	内孔(Φd) Bore	定位孔(NLA)	齿数(P) Number of Teeth	齿型 Tooth Pattern
01	300	3.0	2.2	25.4	/	60	BT
02	300	3.0	2.2	25.4	/	72	BT
03	300	3.2	2.4	30.0	/	60	BT
04	300	3.2	2.4	30.0	/	72	BT

# 电子开料锯 / Panel Sizing Saw Blade



■ 切割材料 / Cutting material:

切人造板素板，三聚氰胺贴面，纸贴面及其他贴面的人造板(MDF/PB)  
Non, Melamine Laminated, paper laminated or other material laminated MDF/PB

■ 用途 / Usage:

电子开料锯  
Panel sizing

■ 参数 / Parameter:

锯齿高度6.0mm  
H=6.0mm

特点 / Character:

高性能PCD刀头，优质合金工具钢本体，高效膨胀散热槽，优化的刃形结构。  
High quality PCD tip, High quality steel body, good expansion slot, optimized teeth pattern.

序号 Ordinal	外径(φD) Diameter	刃厚(B) Kerf	本体厚(b) Body	内孔(φd) Bore	定位孔(NLA)	齿数(P) Number of Teeth	齿型 Tooth Pattern
01	350	3.5	2.6	25.4	/	72	BT
02	350	4.4	3.2	30.0	/	72	BT
03	400	4.8	3.5	30.0	/	72	BT
04	400	4.8	3.5	60.0	/	72	BT
05	400	4.8	3.5	75.0	/	72	BT
06	450	4.8	3.5	30.0	/	72	BT
07	450	4.8	3.5	60.0	/	72	BT
08	450	4.8	3.5	80.0	4/9/120	72	BT
09	510	4.8	3.5	30.0	2/13/95	84	BT

如有特殊要求，可按需定制。

Custom-tailor would be available against customers' requirements.



# 划线锯 / Scoring Saw Blade



■ **切割材料 / Cutting material:**

三聚氰胺贴面，纸贴面及其他贴面的人造板(MDF/PB)。  
Melamine Laminated, paper laminated or other material laminated MDF/PB

■ **用途 / Usage:**

电子开料锯和推台锯，顺铣。划线锯的切削宽度比主锯的宽度小0.2mm  
Panel sizing and Table saw. The cutting width of scoring saw is 0.2mm less than main saw.

■ **参数 / Parameter:**

锯齿高度5.5mm  
H=5.5mm

**特点 / Character:**

高性能PCD刀头，优质合金工具钢本体，高效膨胀散热槽，优化的刃形结构  
High quality PCD tip, High quality steel body, good expansion slot, optimized teeth pattern.

序号 Ordinal	外径(ΦD) Diameter	刃厚(B) Kerf	本体厚(b) Body	内孔(Φd) Bore	定位孔(NLA)	齿数(P) Number of Teeth	齿型 Tooth Pattern
01	100	2.8-3.6	2	20	/	12+12	DC
02	120	2.8-3.6	2	20	/	12+12	DC
03	120	2.8-3.6	2	22	/	12+12	DC

# 划线锯 / Scoring Saw Blade



■ 切割材料 / Cutting material:

三聚氰胺贴面，纸贴面及其他贴面的人造板(MDF/PB)。  
Melamine Laminated, paper laminated or other material laminated MDF/PB

■ 用途 / Usage:

电子开料锯和推台锯，顺铣。划线锯的切削宽度比主锯的宽度小0.2mm  
Panel sizing and Table saw. The cutting width of scoring saw is 0.2mm less than main saw.

■ 参数 / Parameter:

锯齿高度5.5mm  
H=5.5mm

特点 / Character:

高性能PCD刀头，优质合金工具钢本体，高效膨胀散热槽，优化的刃形结构  
High quality PCD tip, High quality steel body, good expansion slot, optimized teeth pattern.

序号 Ordinal	外径(ΦD) Diameter	刃厚(B) Kerf	本体厚(b) Body	内孔(Φd) Bore	定位孔(NLA)	齿数(P) Number of Teeth	齿型 Tooth Pattern
01	120	2.8-3.6	2.0	22.0	/	24	DC
02	160	2.8-3.6	2.0	55.0	/	32	DC
03	160	3.0-3.8	2.2	25.4	/	32	DC
04	180	3.0-3.8	2.2	25.4	/	36	DC
05	200	4.2-3.8	3.2	65.0	2/9/100+2/9/110	36	DC
06	200	4.6-5.4	3.5	20.0	/	36	DC
07	200	4.6-5.4	3.5	45.0	/	36	DC
08	200	4.6-5.4	3.5	65.0	2/9/100+2/9/110	36	DC

如有特殊要求，可按需定制。

Custom-tailor would be available against customers' requirements.

# 电子线路板开料锯 / PCB Sizing Saw Blade



■ 切割材料 / Cutting material:  
多层板、FR2、FR4、CEM1、CEM3

■ 用途 / Usage:  
开料  
Sizing

■ 参数 / Parameter:  
锯齿高度6.0mm  
H=6.0mm

**特点 / Character:**

高性能PCD刀头，优质合金工具钢本体，高效膨胀散热槽，优化的刃形结构  
High quality PCD tip, High quality steel body, good expansion slot, optimized teeth pattern.

序号 Ordinal	外径(ΦD) Diameter	刃厚(B) Kerf	本体厚(b) Body	内孔(Φd) Bore	定位孔(NLA)	齿数(P) Number of Teeth	齿型 Tooth Pattern
01	305	2.4	1.8	31.75	/	40	B
02	305	2.4	1.8	31.75	/	60	B/BC
03	305	2.4	1.8	31.75	/	80	BV
04	305	3.0	2.2	25.40	/	60	B/BC
05	305	3.0	2.2	25.40	/	80	BV
06	305	3.0	2.2	31.75	/	60	B/BC
07	305	3.0	2.2	31.75	/	80	BV
08	305	4.0	3.0	25.40	/	72	BV
09	325	4.0	3.0	30.00	/	72	BV
10	360	4.0	3.0	60.00	/	72	BV

# 电子线路板 V-cutter / PCB V-cutter



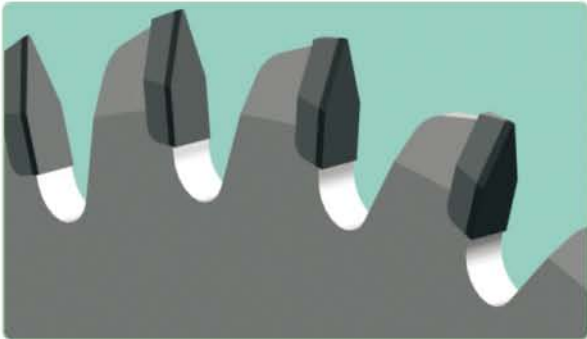
■ 切割材料 / Cutting material:  
CEM1、CEM3、FR4、FR5、及陶瓷基板

■ 用途 / Usage:  
V-cutter

■ 参数 / Parameter:  
锯齿高度6.5mm  
H=6.5mm

特点 / Character:

高性能PCD刀头，优质合金工具钢本体，高效膨胀散热槽，优化的刃形结构  
High quality PCD tip, High quality steel body, good expansion slot, optimized teeth pattern.



序号 Ordinal	外径(ΦD) Diameter	刃厚(B) Kerf	本体厚(b) Body	内孔(Φd) Bore	定位孔(NLA)	齿数(P) Number of Teeth	齿型 Tooth Pattern
01	100	2.0	2.0	25.4	/	20	V
02	100	2.0	2.0	40	/	24	V
03	120	2.0	2.0	25.4	4/6/44	20	V
04	120	2.0	2.0	25.4	4/6/44	30	V
05	120	2.0	2.0	25.4	4/7.5(10.5)/44	20	V
06	120	2.0	2.0	25.4	4/7.5(10.5)/44	30	V

如有特殊要求，可按需定制。  
Custom-tailor would be available against customers' requirements.

# 电子线路板磨边刀 / PCB Trimming Cutter



■ 切割材料 / Cutting material:

FR2、FR4、CEM1、CEM3

■ 用途 / Usage:

修边  
Trimming

■ 参数 / Parameter:

锯齿高度5.5mm  
H=5.5mm

特点 / Character:

高性能PCD刀头，优质合金工具钢本体，高效膨胀散热槽，优化的刃形结构  
High quality PCD tip, High quality steel body, good expansion slot, optimized teeth pattern.



POLYCRYSTALLINE DIAMOND TOOLING SYSTEMS

序号 Ordinal	外径(ΦD) Diameter	刃厚(B) Kerf	本体厚(b) Body	内孔(Φd) Bore	定位孔(NLA)	齿数(P) Number of Teeth	齿型 Tooth Pattern
01	83	5	6	25.4	2/6/44	3	TC
02	83	5	6	25.4	2/6/44	4	TC
03	83	5	6	25.4	2/6/44	6	TC
04	83	5	6	25.4	2/6/44	8	TC
05	103	5	6	25.4	2/6/44	4	TC
06	103	5	6	25.4	2/6/44	6	TC
07	103	5	6	25.4	2/6/44	8	TC

如有特殊要求，可按需定制。

Custom-tailor would be available against customers' requirements.



# 强化地板锯片 / Flooring Sizing Saw Blade



■ 切割材料 / Cutting material:

模压类或非模压类强化地板  
Used for sizing moulding or un-moulding laminated flooring.

■ 用途 / Usage:

推台锯或多片锯机，开料。  
Table saw and Multiple saw machine, Sizing.

■ 参数 / Parameter:

锯齿高度5.5mm  
H=5.5mm

特点 / Character:

高性能PCD刀头，优质合金工具钢本体，高效膨胀散热槽，优化的刃形结构  
High quality PCD tip, High quality steel body, good expansion slot, optimized teeth pattern.

序号 Ordinal	外径(ΦD) Diameter	刃厚(B) Kerf	本体厚(b) Body	内孔(Φd) Bore	定位孔(NLA)	齿数(P) Number of Teeth	齿型 Tooth Pattern
01	200	2.2	1.6/2.2	25.4	/	60	BT
02	200	2.2	1.6/2.2	30	/	60	BT
03	210	2.2	1.6/2.2	25.4	/	60	BT
04	210	2.2	1.6/2.2	30	/	60	BT
05	220	2.2	1.6/2.2	25.4	/	60	BT
06	220	2.2	1.6/2.2	30	/	60	BT
07	250	2.2	1.6/2.2	25.4	/	60	BT
08	250	2.2	1.6/2.2	30	/	60	BT
09	250	2.2	1.6/2.2	40	/	60	BT
10	250	2.2	1.6	115	8/7/131	60	BT
11	250	3.0	2.2	30	/	60	BT
12	250	3.2	2.4	30	/	60	BT
13	300	2.2	1.6/2.2	115	8/7/131	60	BT
14	300	2.2	1.6/2.2	30	/	60	BT
15	300	2.2	1.6/2.2	40	2/10/60	60	BT
16	300	2.2	1.6/2.2	80	/	60	BT
17	300	3.0	2.2	30	/	60	BT
18	300	3.0	2.2	40	/	60	BT
19	300	3.0	2.2	80	/	60	BT
20	300	3.2	2.4	30	/	60	BT
21	300	3.2	2.4	40	/	60	BT
22	300	3.2	2.4	80	/	60	BT

如有特殊要求，可按需定制。  
Custom-tailor would be available against customers' requirements.

## 强化地板锯片 / Flooring Sizing Saw Blade



■ 切割材料 / Cutting material:

模压类或非模压类强化地板

Used for sizing moulding or un-moulding laminated flooring.

■ 用途 / Usage:

推台锯或多片锯机，开料。

Table saw and Multiple saw machine, Sizing.

■ 参数 / Parameter:

锯齿高度5.5mm

H=5.5mm

■ 特点 / Character:

高性能PCD刀头，优质合金工具钢本体，高效膨胀散热槽，优化的刃形结构

High quality PCD tip, High quality steel body, good expansion slot, optimized teeth pattern.

序号 Ordinal	外径(ΦD) Diameter	刃厚(B) Kerf	本体厚(b) Body	内孔(Φd) Bore	定位孔(NLA)	齿数(P) Number of Teeth	齿型 Tooth Pattern
01	200	2.2	1.6	80	/	60	BT
02	200	2.8	2.2	80	/	60	BT
03	250	2.2	1.6/2.2	80	/	60	BT
04	250	2.8	2.2	80	/	60	BT

# 墙体材料锯片 / Ceramics Sizing Saw Blade



■ 切割材料 / Cutting material:  
纤维水泥板等建筑材料  
Cement Fiber and other building material

■ 用途 / Usage:  
开料  
Sizing

■ 参数 / Parameter:  
锯齿高度6.0mm  
H=6.0mm

特点 / Character:

高性能PCD刀头，优质合金工具钢本体，高效膨胀散热槽，优化的刃形结构。  
High quality PCD tip, High quality steel body, good expansion slot, optimized teeth pattern.

序号 Ordinal	外径(ΦD) Diameter	刃厚(B) Kerf	本体厚(b) Body	内孔(Φd) Bore	定位孔(NLA)	齿数(P) Number of Teeth	齿型 Tooth Pattern
01	80	1.8	1.2	20	/	8	B
02	100	1.8	1.2	20	/	8	B
03	100	1.8	1.2	20	/	12	B
04	125	1.8	1.2	20	/	8	B
05	125	1.8	1.2	20	/	12	B
06	180	2.0	1.4	25.4	/	8	B
07	180	2.0	1.4	25.4	/	12	B
08	305	3.0	2.3	25.4	4/9/76	40	B
09	305	3.0	2.2	25.4	/	60	B
10	305	8.0	6.0	25.4	/	10	B
11	405	3.2	2.4	25.4	/	60	B
12	480	4.85	3.8	30	/	60	BV

如有特殊要求，可按需定制。

Custom-tailor would be available against customers' requirements.

# 有机玻璃夹板锯片 / Plexiglass Saw Blade



■ 切割材料 / Cutting material:

有机玻璃夹板  
Plexiglas

■ 用途 / Usage:

修边  
Trimming

■ 参数 / Parameter:

锯齿高度5.5mm  
H=5.5mm

特点 / Character:

高性能PCD刀头，优质合金工具钢本体，高效膨胀散热槽，优化的刃形结构  
High quality PCD tip, High quality steel body, good expansion slot, optimized teeth pattern.

序号 Ordinal	外径(ΦD) Diameter	刃厚(B) Kerf	本体厚(b) Body	内孔(Φd) Bore	定位孔(NLA)	齿数(P) Number of Teeth	齿型 Tooth Pattern
01	85	3.6	3.0	30	/	16	LC/RC
02	120	3.6	3.0	20	/	16	LC/RC
03	120	3.6	3.0	20	/	16	LC/RC
04	150	3.6	3.0	30	/	30	LC/RC
05	180	3.6	3.0	30	/	30	LC/RC
06	180	3.6	3.0	30	/	32	LC/RC

## 硬树脂锯片 / Hard Resin Saw Blade

08	220	4.0	3.2	30.0	/	24	B
09	305	2.4	1.8	25.4	/	60	B
10	305	2.4	1.8	30.0	/	60	B
11	305	2.4	1.8	31.75	/	40	B
12	305	2.4	1.8	30.0	/	60	B
13	350	4.0	3.2	40.0	/	60	B
14	355	3.0	2.2	25.4	/	80	B
15	400	4.0	3.2	30.0	/	60	B

## 重竹锯片 / Strand Woven Bamboo Saw Blade

16	200	2.6	2.0	25.4	/	48	BA3
17	300	3.0	2.3	30.0	/	60	BT

如有特殊要求，可按需定制。

Custom-tailor would be available against customers' requirements.



## 预铣刀 / Pre-cutter



- 运用在Homag、Weinig等地板设备上；用于地板的预铣，去除大部分基材，减少成型铣刀的切屑阻力，提高刀具寿命；  
Mainly used on Homag, Weinig flooring system, for flooring pre-cutting, get rid of main base material, decrease resistance, make longer cutting life for profile cutter.
- 高性能PCD刀头，优质合金工具钢本体；尺寸精确，刀尖强度高、不易崩齿、锋利性好，有优良的物理性能，使用寿命长；  
High quality PCD tip, High quality steel body, high strength resistance, not easy to crack, sharp, good quality, long life.
- 转速/RPM: 6000~14000r/min

外径(φD) Diameter	孔径(φd) Bore	齿数(P) Number of Teeth
130/140/160	40	12
200	40/60	16
220/250	60	24/36

如有特殊要求，可按需定制。

Custom-tailor would be available against customers' requirements.

## 成型刀 / Profile cutter



- 运用在Homag、Weinig等地板设备上；用于地板榫头和榫槽的成型加工；  
Mainly used on Homag, Weinig flooring system, Groove and tongue profiling for flooring,
- 高性能PCD刀头，优质合金工具钢本体；尺寸精确，刀尖强度高、不易崩齿、锋利性好，有优良的物理性能，使用寿命长；  
High quality PCD tip, High quality steel body, high strength resistance, not easy to crack, sharp, good quality, long life.
- 转速/RPM: 6000~14000r/min

外径(φD) Diameter	孔径(φd) Bore	齿数(P) Number of Teeth
160/180	40/60	4/6
200	40/60	8/10
220/250/285	60	8/10/12/16

如有特殊要求，可按需定制。

Custom-tailor would be available against customers' requirements.

## 倒角刀 / Chamfer-cutter



- 运用在Homag、Weinig等地板设备上；用于地板面板和背板的倒角加工；  
Mainly used on Homag, Weinig flooring system, for Chamfer cutting
- 高性能PCD刀头，优质合金工具钢本体；尺寸精确，刀尖强度高、不易崩齿、锋利性好，有优良的物理性能，使用寿命长；  
High quality PCD tip, High quality steel body, high strength resistance, not easy to crack, sharp, good quality, long life.
- 转速/RPM: 6000~14000r/min

外径(ΦD) Diameter	孔径(Φd) Bore	齿数(P) Number of Teeth
100/160	40	8/12/16
220	60	24
250/285	60	24/36

如有特殊要求，可按需定制。

Custom-tailor would be available against customers' requirements.

## 精修刀 / Finish-cutter



- 运用在Homag、Weinig等地板设备上；用于地板配合面的精修加工；  
Mainly used on Homag, Weinig flooring system, for finish cutting
- 高性能PCD刀头，优质合金工具钢本体；尺寸精确，刀尖强度高、不易崩齿、锋利性好，有优良的物理性能，使用寿命长；  
High quality PCD tip, High quality steel body, high strength resistance, not easy to crack, sharp, good quality, long life.
- 转速/RPM: 6000~14000r/min

外径(ΦD) Diameter	孔径(Φd) Bore	齿数(P) Number of Teeth
160/180	40	12/18
220	40	24/36
250/285	60	36/48

如有特殊要求，可按需定制。

Custom-tailor would be available against customers' requirements.

## 家具刀 / Combination Cutter



- 运用在立轴铣或四面刨上，用于家具横框的开槽加工。  
Used on spindle milling machine, planing machine. Used for grooving of furniture frame rail.
- 高性能PCD刀头，优质合金工具钢本体；尺寸精确，刀尖强度高、不易崩齿、锋利性好，有优良的物理性能，使用寿命长；  
High quality PCD tip, High quality steel body, high strength resistance, not easy to crack, sharp, good quality, long life.

如有特殊要求，可按需定制。

Custom-tailor would be available against customers' requirements.

## 线条刀 / R Cutter



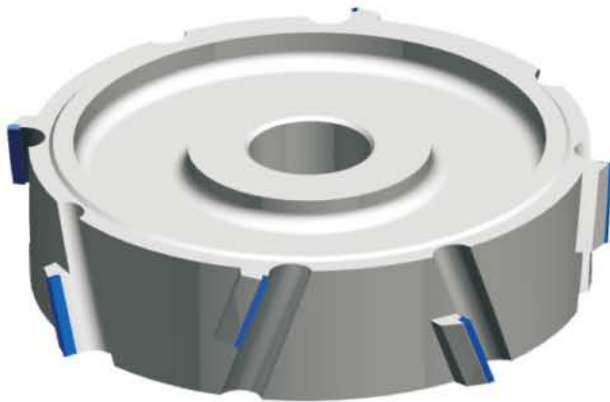
- 运用在立轴铣或四面刨上，用于踢脚线加工。  
Used on spindle milling machine, planing machine. Used for grooving of furniture frame rail.
- 高性能PCD刀头，优质合金工具钢本体；尺寸精确，刀尖强度高、不易崩齿、锋利性好，有优良的物理性能，使用寿命长；  
High quality PCD tip, High quality steel body, high strength resistance, not easy to crack, sharp, good quality, long life.

如有特殊要求，可按需定制。

Custom-tailor would be available against customers' requirements.



# 1+1修边刨刀 / Planning Cutter(1+1)



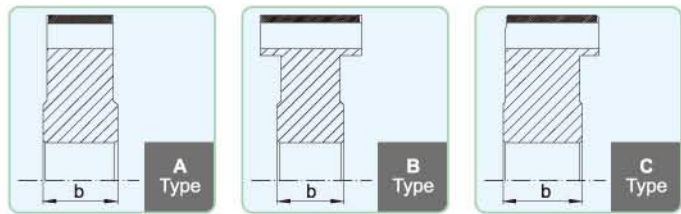
■ 切割材料 / Cutting material:

三聚氰胺贴面板, 纸质贴面板, 防火板和单板贴面板。  
Melamine and paper laminated, HPL coated and Particle Board.

■ 特点 / Character:

刃齿采用螺旋交错摆列, 外切削刃具有向内的横向前角, 有利于减小切削阻力, 并提高封边效果, 防止封边时上下两边出现暴边现象; 加大深度的螺旋排屑槽有利于切屑导向、排屑和吸尘。

Teeth pattern with spiral, cross design, side cutting teeth designed with inner face angle, which is good for decreasing cutting resistance, making end banding effect good, prevent cracking. Making the drain cistern longer is good for cutting leading, getting rid of dust and waste.



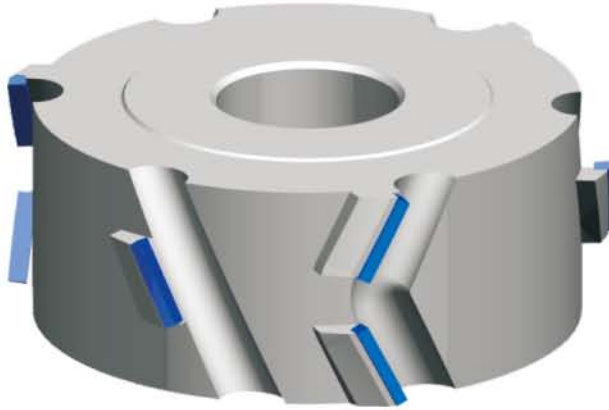
序号 Ordinal	刃径(φD) Diameter	刃宽(H) Kerf	台厚(b) Body	内径(φd) Bore	刃数(P) Number of Teeth	刃排(Z) Principle
01	80	25	25/40	20/30/35	6P	(1+1)×3
02	100	25	25/40	20/30/35	6P	(1+1)×3
03	125	25	25/40	20/30/35	6P	(1+1)×3
04	150	25	25/40	20/30/35	6P	(1+1)×3
05	150	25	25/40	20/30/35	8P	(1+1)×4

如有特殊要求, 可按需定制。

Custom-tailor would be available against customers' requirements.



## 2+1修边刨刀 / Planning Cutter(2+1)



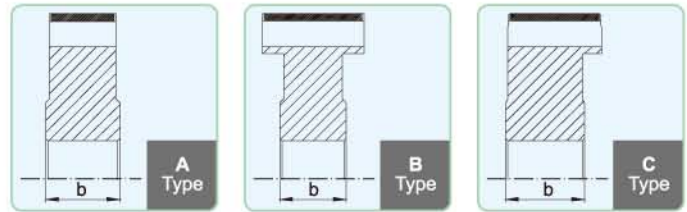
### ■ 切割材料 / Cutting material:

三聚氰胺贴面板, 纸质贴面板, 防火板和单板贴面板。  
Melamine and paper laminated, HPL coated and Particle Board.

### ■ 特点 / Character:

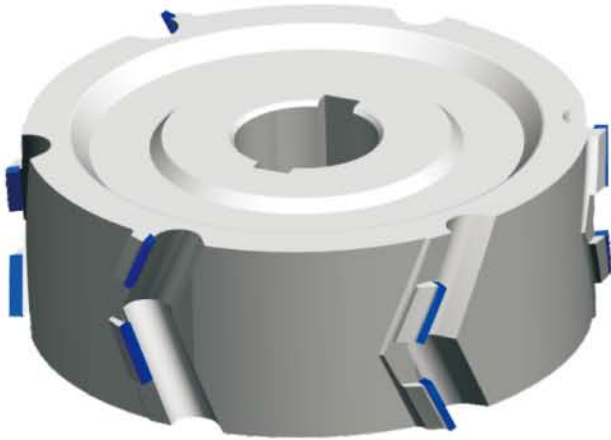
刃齿采用螺旋交错摆列, 外切削刃具有向内的横向前角, 有利于减小切削阻力, 并提高封边效果, 防止封边时上下两边出现暴边现象; 加大深度的螺旋排屑槽有利于切屑导向、排屑和吸尘。

Teeth pattern with spiral, cross design, side cutting teeth designed with inner face angle, which is good for decreasing cutting resistance, making end banding effect good, prevent cracking. Making the drain cistern longer is good for cutting leading, getting rid of dust and waste.



序号 Ordinal	刃径(ΦD) Diameter	刃宽(H) Kerf	台厚(b) Body	内径(Φd) Bore	刃数(P) Number of Teeth	刃排(Z) Principle
01	80	30	25/40	20/30/35	9P	(2+1)×3
02	100	30	25/40	20/30/35	9P	(2+1)×3
03	125	30	25/40	20/30/35	9P	(2+1)×3
04	125	30	25/40	20/30/35	12P	(2+1)×4
05	150	30	25/40	20/30/35	9P	(2+1)×3
06	150	30	25/40	20/30/35	12P	(2+1)×4

## 2+2修边刨刀 / Planning Cutter(2+2)



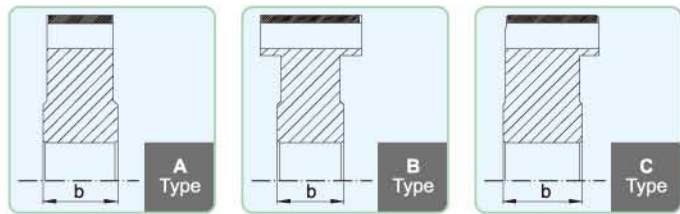
### ■ 切割材料 / Cutting material:

三聚氰胺贴面板, 纸质贴面板, 防火板和单板贴面板。  
Melamine and paper laminated, HPL coated and Particle Board.

### ■ 特点 / Character:

刃齿采用螺旋交错摆列, 外切削刃具有向内的横向前角, 有利于减小切削阻力, 并提高封边效果, 防止封边时上下两边出现暴边现象; 加大深度的螺旋排屑槽有利于切屑导向、排屑和吸尘。

Teeth pattern with spiral, cross design, side cutting teeth designed with inner face angle, which is good for decreasing cutting resistance, making end banding effect good, prevent cracking. Making the drain cistern longer is good for cutting leading, getting rid of dust and waste.

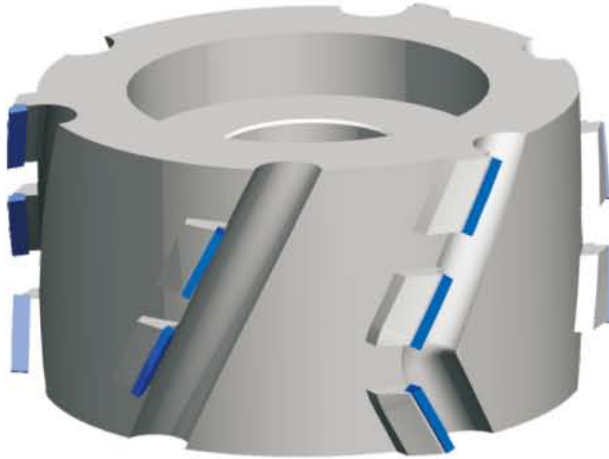


序号 Ordinal	刃径(φD) Diameter	刃宽(H) Kerf	台厚(b) Body	内径(φd) Bore	刃数(P) Number of Teeth	刃排(Z) Principle
01	80	34	25/40	20/30/35	12P	(2+2) × 3
02	80	43	25/40	20/30/35	12P	(2+2) × 3
03	100	34	25/40	20/30/35	12P	(2+2) × 3
04	100	43	25/40	20/30/35	12P	(2+2) × 3
05	125	34	25/40	20/30/35	12P	(2+2) × 3
06	125	43	25/40	20/30/35	12P	(2+2) × 3
07	125	34	25/40	20/30/35	16P	(2+2) × 4
08	125	43	25/40	20/30/35	16P	(2+2) × 4
09	150	34	25/40	20/30/35	12P	(2+2) × 3
10	150	43	25/40	20/30/35	12P	(2+2) × 3
11	150	34	25/40	20/30/35	16P	(2+2) × 4
12	150	43	25/40	20/30/35	16P	(2+2) × 4

如有特殊要求, 可按需定制。

Custom-tailor would be available against customers' requirements.

## 3+2修边刨刀 / Planning Cutter(3+2)



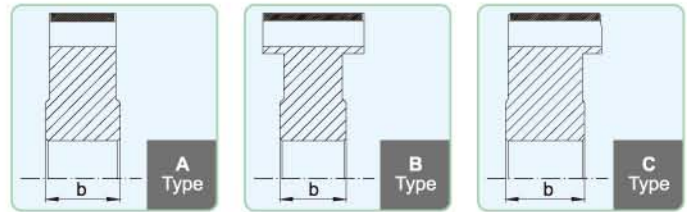
### 切割材料 / Cutting material:

三聚氰胺贴面板, 纸质贴面板, 防火板和单板贴面板。  
Melamine and paper laminated, HPL coated and Particle Board.

### 特点 / Character:

刃齿采用螺旋交错摆列, 外切削刃具有向内的横向前角, 有利于减小切削阻力, 并提高封边效果, 防止封边时上下两边出现暴边现象; 加大深度的螺旋排屑槽有利于切屑导向、排屑和吸尘。

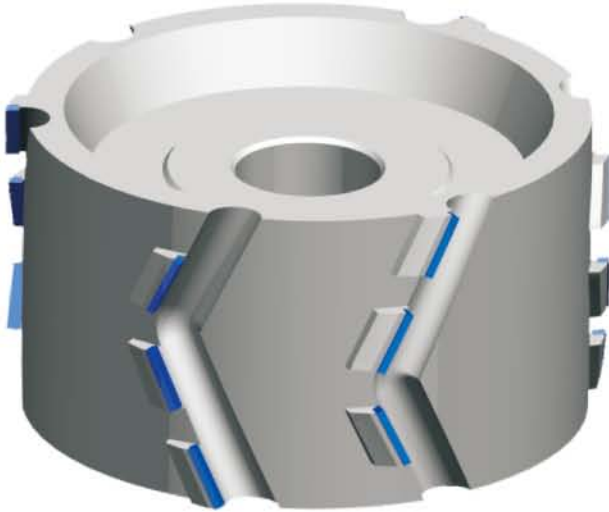
Teeth pattern with spiral, cross design, side cutting teeth designed with inner face angle, which is good for decreasing cutting resistance, making end banding effect good, prevent cracking. Making the drain cistern longer is good for cutting leading, getting rid of dust and waste.



序号 Ordinal	刃径(φD) Diameter	刃宽(H) Kerf	台厚(b) Body	内径(φd) Bore	刃数(P) Number of Teeth	刃排(Z) Principle
01	80	45	25/40	20/30/35	15P	(3+2)×3
02	100	45	25/40	20/30/35	15P	(3+2)×3
03	125	45	25/40	20/30/35	15P	(3+2)×3
04	125	45	25/40	20/30/35	20P	(3+2)×4
05	150	45	25/40	20/30/35	15P	(3+2)×3
06	150	45	25/40	20/30/35	20P	(3+2)×4



## 3+3修边刨刀 / Planning Cutter(3+3)



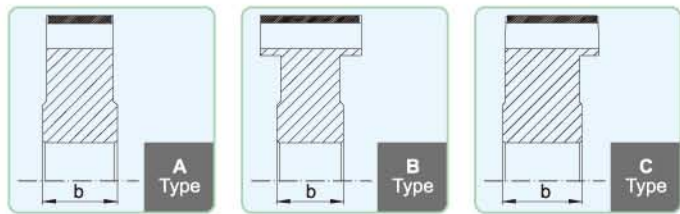
### ■ 切割材料 / Cutting material:

三聚氰胺贴面板, 纸质贴面板, 防火板和单板贴面板。  
Melamine and paper laminated, HPL coated and Particle Board.

### ■ 特点 / Character:

刃齿采用螺旋交错摆列, 外切削刃具有向内的横向前角, 有利于减小切削阻力, 并提高封边效果, 防止封边时上下两边出现暴边现象; 加大深度的螺旋排屑槽有利于切屑导向、排屑和吸尘。

Teeth pattern with spiral, cross design, side cutting teeth designed with inner face angle, which is good for decreasing cutting resistance, making end banding effect good, prevent cracking. Making the drain cistern longer is good for cutting leading, getting rid of dust and waste.



序号 Ordinal	刃径(φD) Diameter	刃宽(H) Kerf	台厚(b) Body	内径(φd) Bore	刃数(P) Number of Teeth	刃排(Z) Principle
01	80	48	25/40	20/30/35	18P	(3+3) × 3
02	80	52	25/40	20/30/35	18P	(3+3) × 3
03	100	48	25/40	20/30/35	18P	(3+3) × 3
04	100	52	25/40	20/30/35	18P	(3+3) × 3
05	125	48	25/40	20/30/35	18P	(3+3) × 3
06	125	52	25/40	20/30/35	18P	(3+3) × 3
07	125	63	25/40	20/30/35	18P	(3+3) × 3
08	125	48	25/40	20/30/35	24P	(3+3) × 4
09	125	52	25/40	20/30/35	24P	(3+3) × 4
10	125	63	25/40	20/30/35	24P	(3+3) × 4
11	150	48	25/40	20/30/35	18P	(3+3) × 3
12	150	52	25/40	20/30/35	18P	(3+3) × 3
13	150	48	25/40	20/30/35	24P	(3+3) × 4
14	150	52	25/40	20/30/35	24P	(3+3) × 4

如有特殊要求, 可按需定制。

Custom-tailor would be available against customers' requirements.



## 成型用镗铣刀 / Profile Router bit



■ 切割材料 / Cutting material:

刨花板和密度板(素板或贴面板)  
Particle board and MDF(raw and coated)

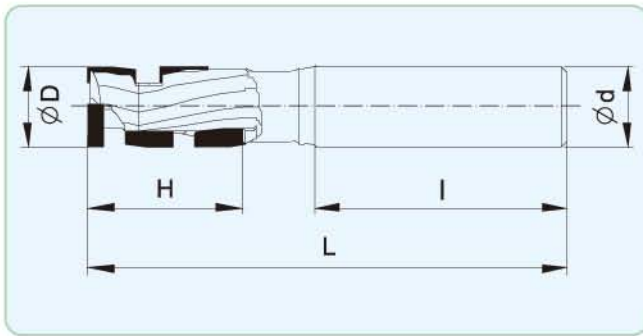
■ 用途 / Usage:

运用于CNC镗铣机和加工中心上仿型铣削。  
For profiling on CNC routers and machining centers.

■ 特点 / Character:

尺寸精确，使用寿命长。  
High strength resistance, long life.

# 1+1螺旋刃铣铣刀 / Router bit(1+1)



■ 切割材料 / Cutting material:

刨花板、密度板(素板或贴面板)  
Particle Board and MDF (raw or coated)

■ 用途 / Usage:

修边、开料、铣槽  
Trimming, Sizing, Grooving

■ 特点 / Character:

1+1共2排刃的金刚石铣铣刀，带硬质合金横刃，经济型柄铣刀。

螺旋型内凹式的刃排设计，可以有效的防止加工时材料被撕裂或者崩边，并有很好的切屑导向作用，有助于将切屑排入吸风口。

倾斜或螺旋切入工件，不可垂直切入工件。

PCD router bits with 2 principles and 1 cutting edge on all working point, together with carbide horizontal tooth, economic.

Teeth pattern with Spiral inner concave oblique design, which can prevent material get crack when working, good cutting leading, can help leading waste to exhaust inlet.

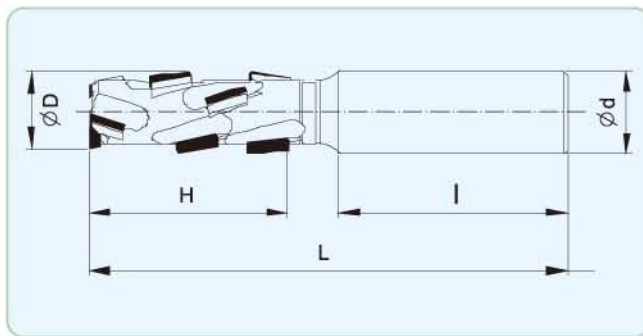
Please travel plunge-cut using Z and X axis.

序号 Ordinal	刃径(ΦD) Diameter	刃长(H) Length	柄径(Φd) Shank	总长(L) Total Length	刃数(P) Number of Teeth	刃排(Z) Principle	柄长(I) Length of Shank
01	12	25	12/12.7	85	3+1P	1+1	50
02	12	30	12/12.7	90	4+1P	1+1	50
03	12	35	12/12.7	95	5+1P	1+1	50
04	12.7	25	12.7	85	3+1P	1+1	50
05	12.7	30	12.7	90	4+1P	1+1	50
06	12.7	35	12.7	95	5+1P	1+1	50
07	16	25	16/20	85	3+1P	1+1	50
08	16	30	16/20	90	4+1P	1+1	50
09	16	35	16/20	90	5+1P	1+1	50
10	18	25	16/20	85	3+1P	1+1	50
11	18	30	16/20	90	4+1P	1+1	50
12	18	35	16/20	95	5+1P	1+1	50
13	18	40	16/20	100	5+1P	1+1	50
14	18	45	16/20	105	5+1P	1+1	50
15	20	25	20/25	85	3+1P	1+1	50
16	20	30	20/25	90	4+1P	1+1	50
17	20	35	20/25	95	5+1P	1+1	50
18	20	40	20/25	100	5+1P	1+1	50
19	20	45	20/25	105	5+1P	1+1	50
20	20	50	20/25	110	6+1P	1+1	50

如有特殊要求，可按需定制。

Custom-tailor would be available against customers' requirements.

## 2+2螺旋刃铣铣刀 / Router bit(2+2)



### ■ 切割材料 / Cutting material:

刨花板、密度板(素板或贴面板)  
Particle Board and MDF(raw or coated)

### ■ 用途 / Usage:

修边、开料、铣槽  
Trimming, Sizing, Grooving

### ■ 特点 / Character:

2+2共4排刃的金刚石铣铣刀，带硬质合金横刃，经济型柄铣刀。

螺旋型内凹式的刃排设计，可以有效的防止加工时材料被撕裂或者崩边，并有很好的切屑导向作用，有助于将切屑排入吸风口。

倾斜或螺旋切入工件，不可垂直切入工件。

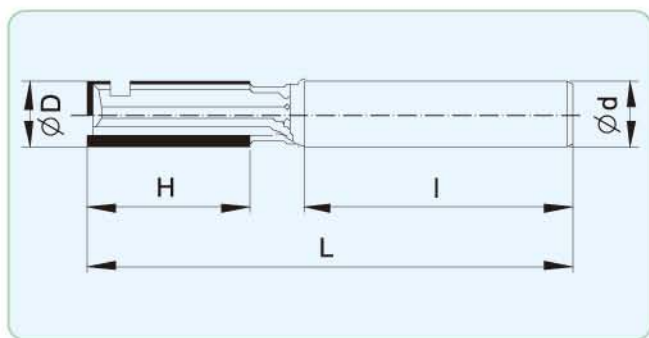
PCD router bits with 4 principles and 2 cutting edges on all working point, together with carbide horizontal tooth, economic.

Teeth pattern with Spiral inner concave oblique design, which can prevent material get crack when working, good cutting leading, can help leading waste to exhaust inlet. Please travel plunge-cut using Z and X axis.

序号 Ordinal	刃径(ΦD) Diameter	刃长(H) Length	柄径(Φd) Shank	总长(L) Total Length	刃数(P) Number of Teeth	刃排(Z) Principle	柄长(l) Length of Shank
01	18	25	20/25	90	6+1P	2+2	50
02	18	30	20/25	95	8+1P	2+2	50
03	18	35	20/25	100	10+1P	2+2	50
04	18	40	20/25	105	10+1P	2+2	50
05	20	25	20/25	90	6+1P	2+2	50
06	20	30	20/25	95	8+1P	2+2	50
07	20	35	20/25	100	10+1P	2+2	50
08	20	40	20/25	105	10+1P	2+2	50
09	20	45	20/25	110	10+1P	2+2	50
10	20	50	20/25	115	12+1P	2+2	50
11	22	25	25	90	6+1P	2+2	50
12	22	30	25	95	8+1P	2+2	50
13	22	35	25	100	10+1P	2+2	50
14	22	40	25	105	10+1P	2+2	50
15	22	45	25	110	10+1P	2+2	50
16	22	50	25	115	12+1P	2+2	50
17	25	25	25	90	6+1P	2+2	50
18	25	30	25	95	8+1P	2+2	50
19	25	35	25	100	10+1P	2+2	50
20	25	40	25	105	10+1P	2+2	50
21	25	45	25	110	10+1P	2+2	50
22	25	50	25	115	12+1P	2+2	50
23	25	55	25	120	12+1P	2+2	50



# 1+1直刃镟铣刀 / Router bit(1+1)



■ 切割材料 / Cutting material:

硬木, 密度板  
hard solid wood (without knots),MDF

■ 用途 / Usage:

修边、开料、铣槽  
Trimming, Sizing, Grooving

■ 特点 / Character:

1+1共2排刃的金刚石镟铣刀, 带硬质合金横刃, 经济型柄铣刀。

竖直的刃排设计, 可进行高质量表面的修边加工。

倾斜或螺旋切入工件, 不可垂直切入工件。

PCD router bits with 1+1= 2 lines PCD teeth, together with carbide horizontal tooth, economic.

Straight teeth pattern, it can be used for trimming with high requirement.

Please travel plunge-cut using Z and X axis.

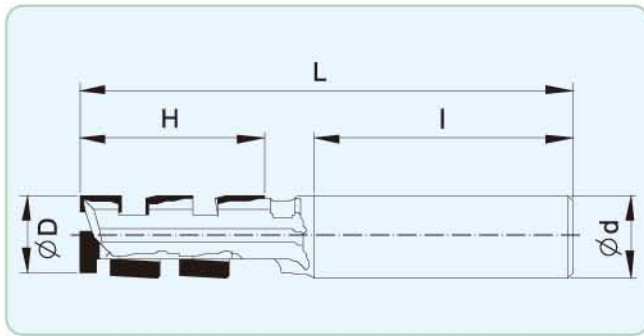
序号 Ordinal	刃径(ΦD) Diameter	刃长(H) Length	柄径(Φd) Shank	总长(L) Total Length	刃数(P) Number of Teeth	刃排(Z) Principle	柄长(l) Length of Shank
01	8	12	12/12.7	70	2+1P	1+1	50
02	10	22	12/12.7	80	2+1P	1+1	50
03	12	25	12/12.7	85	2+1P	1+1	50
04	12	30	12/12.7	90	2+1P	1+1	50
05	12	35	12/12.7	90	2+1P	1+1	50
06	12.7	25	12.7	85	2+1P	1+1	50
07	12.7	30	12.7	90	2+1P	1+1	50
08	12.7	35	12.7	90	2+1P	1+1	50
09	16	25	16/20	85	2+1P	1+1	50
10	16	30	16/20	90	2+1P	1+1	50
11	16	35	16/20	90	2+1P	1+1	50
12	18	25	16/20	85	2+1P	1+1	50
13	18	30	16/20	90	2+1P	1+1	50
14	18	35	16/20	90	2+1P	1+1	50
15	18	40	16/20	95	2+1P	1+1	50

如有特殊要求, 可按需定制。

Custom-tailor would be available against customers' requirements.



# 1+1斜刃铣铣刀 / Router bit(1+1)



■ 切割材料 / Cutting material:

硬木, 密度板  
hard solid wood (without knots),MDF

■ 用途 / Usage:

修边、开料、铣槽  
Trimming, Sizing, Grooving

■ 特点 / Character:

1+1共2排刃的金刚石铣铣刀, 带硬质合金横刃, 经济型柄铣刀。

内凹的斜刃排设计, 可以有效的防止加工时材料被撕裂或者崩边。

倾斜或螺旋切入工件, 不可垂直切入工件。

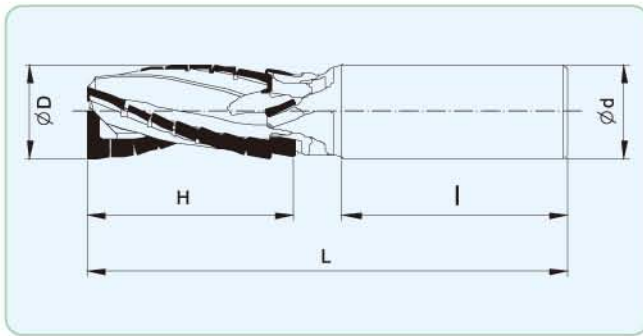
PCD router bits with 2 principles and 1 cutting edge on all working point, together with carbide horizontal tooth, economic.

Inner concave oblique teeth pattern, which can prevent material get crack when working.

Please travel plunge-cut using Z and X axis.

序号 Ordinal	刃径( $\varnothing D$ ) Diameter	刃长(H) Length	柄径( $\varnothing d$ ) Shank	总长(L) Total Length	刃数(P) Number of Teeth	刃排(Z) Principle	柄长(I) Length of Shank
01	12	25	12/12.7	85	3+1P	1+1	50
02	12	30	12/12.7	90	4+1P	1+1	50
03	12	35	12/12.7	95	5+1P	1+1	50
04	12.7	25	12.7	85	3+1P	1+1	50
05	12.7	30	12.7	90	4+1P	1+1	50
06	12.7	35	12.7	95	5+1P	1+1	50
07	16	25	16/20	85	3+1P	1+1	50
08	16	30	16/20	90	4+1P	1+1	50
09	16	35	16/20	90	5+1P	1+1	50
10	18	25	16/20	85	3+1P	1+1	50
11	18	30	16/20	90	4+1P	1+1	50
12	18	35	16/20	95	5+1P	1+1	50
13	18	40	16/20	100	5+1P	1+1	50
14	18	45	16/20	105	5+1P	1+1	50
15	20	25	20/25	85	3+1P	1+1	50
16	20	30	20/25	90	4+1P	1+1	50
17	20	35	20/25	95	5+1P	1+1	50
18	20	40	20/25	100	5+1P	1+1	50
19	20	45	20/25	105	5+1P	1+1	50
20	20	50	20/25	110	6+1P	1+1	50

## 3+3螺旋刃铣铣刀 / Router bit(3+3)



■ 切割材料 / Cutting material:

刨花板、密度板(素板或贴面板)  
Particle Board and MDF(raw or coated)

■ 用途 / Usage:

修边、开料、铣槽  
Trimming, Sizing, Grooving

■ 特点 / Character:

3+3共3排刃的金刚石铣铣刀，带硬质合金横刃，高寿命金刚石柄铣刀。

螺旋型内凹式的刃排设计，可以有效的防止加工时材料被撕裂或者崩边，并有很好的切屑导向作用，可进行高速度、高质量的加工，拥有更高的加工寿命和加工效率。

倾斜或螺旋切入工件，不可垂直切入工件。

PCD router bits with 3 principles and 3 cutting edges on all working point, together with carbide horizontal tooth, long life PCD router bits.

Teeth pattern with Spiral inner concave oblique design, which can prevent material get crack when working, good cutting leading, can work with high quality and high speed, have long life and efficiency.

Please travel plunge-cut using Z and X axis.

序号 Ordinal	刃径(ΦD) Diameter	刃长(H) Length	柄径(Φd) Shank	总长(L) Total Length	刃数(P) Number of Teeth	刃排(Z) Principle	柄长(I) Length of Shank
01	18	25	20/25	90	12+1P	3+3	50
02	18	30	20/25	95	14+1P	3+3	50
03	20	25	20/25	90	12+1P	3+3	50
04	20	30	20/25	95	14+1P	3+3	50
05	20	35	20/25	100	16+1P	3+3	50
06	20	40	20/25	105	18+1P	3+3	50
07	20	45	20/25	110	20+1P	3+3	50
08	22	25	20/25	90	12+1P	3+3	50
09	22	30	20/25	95	14+1P	3+3	50
10	22	35	20/25	100	16+1P	3+3	50
11	22	40	20/25	105	18+1P	3+3	50
12	22	45	20/25	110	20+1P	3+3	50
13	25	25	25	90	12+1P	3+3	50
14	25	30	25	95	14+1P	3+3	50
15	25	35	25	100	16+1P	3+3	50
16	25	40	25	105	18+1P	3+3	50
17	25	45	25	110	20+1P	3+3	50
18	25	50	25	115	22+1P	3+3	50

如有特殊要求，可按需定制。

Custom-tailor would be available against customers' requirements.

## 配件 / Accessory

### 液压轴套 / Hydraulic Grasp Sleeves



■ 用途 / Usage:

运用在Homag, fuma, yasuda等高速地板机器上；当地板的进料速度较快 (≥30m/min) 或者刀具的旋转外径过大时，刀具须跟液压轴套配合使用，以保证刀具的精度。

Used on Homag, Fuma, Yasuda and other high speed flooring machine.

PCD cutting tools should work together with Hydraulic Grasp Sleeves, when feeding speed is ( ≥ 30m/min ) quick or Outer diameter of tools is too big, so that the precision of tools can be sure.

### 地板模板 / Checkgage



■ 用途 / Usage:

用于检测成品地板的拼装是否合格。  
For Checking.

### 垫片 / Spacer



■ 用途 / Usage:

用于组合刀具的廓形调节。  
For Adjusting.

外径(ΦD) Diameter	内径(Φd) Bore	定位孔(NLA)	厚度(b) Thickness
60	30	3/7/45	0.1/0.2/0.5
70	40	2/7/58	0.1/0.2/0.5/1/2
75	22	2/7/58	0.1/0.2
90	60	3/10/75	0.1/0.2/0.5/1/2
100	25.4	4/9/60+4/7/85	0.1
厚垫片 Others			
90	60	3/9/75	依刀具定制 / Order
120	60	4/10/100	依刀具定制 / Order



## ● 维护和保养 / Maintenance

- 为确保刀具的安全工作，保证加工质量，需对刀具进行定期的检查和清洁；  
Check and clean the tools regularly, in order to make sure working condition is safe and the cutting quality is good.
- 清洁时可用气枪去除刀具上面附着的粉尘，对于刀具上面的树脂，可通过有防锈措施的浸泡清洗去除或由刀具提供商再研磨时进行专门清洗，严禁用机械方式去除树脂附着，以免造成刀具刃口的严重损伤；  
Use air gun to get rid of dust, for resin on the tools' surface, please use immersion cleaning together with anti-rust method or special clean method by supplier. Mechanical method is forbidden, it will hurt the kerf.
- 液压轴套也应进行定期清洁保养，如可用防锈油擦洗，但禁止浸泡式清洗；  
HYDRO-GRIP also needs to clean regularly.
- 清洗的频率视现场的加工环境而定；  
Clean frequency will be based on working condition.
- 再研磨前需对刀具进行彻底清洗；  
Diamond tools should be clean thoroughly before re-grinding.

- 当刀具刃口崩刃，切削质量不能达到所要求时，或刀具使用中机床功率出现明显提高现象时，需对刀具进行再研磨处理；  
Tip-broken, cutting quality can not reach requirement or machine power become higher, shows that the tools need to re-grind.
- 对非正常磨损会较大程度影响到刀具的总体使用寿命的刀齿必须做换齿处理，以达到刀具的最大有效利用率；  
The tip should be replaced when the broken tip effect the life of tools, in order to meet the biggest utilization rate.

## ● 检测 / Checking

- 在检测或调试安装刀具时，应尽量避免量具直接接触刃口，最好用非接触式测量仪（如光学仪器）进行检查，以免损坏刀刃影响刀具的寿命。  
When checking or adjusting tools, we should try our best not to touch the kerf. It is better to use un-touch equipment (such as light machine) to check, in order to prevent the kerf get hurt.

# 金刚石刀具修磨规范 Grinding Standard of Diamond tools

关于刀头修磨余量 / About Grinding Allowance			
刀具种类 / Kind	刀头余量 $\Delta$ / Allowance	对策 / Method	备注 / Remark
金刚石锯片 Diamond saw blade	$\Delta \geq 3.0\text{mm}$	修磨处理 / Grind	/
	$\Delta < 3.0\text{mm}$	建议报废处理 / Scrap	/
金刚石铣刀 Diamond cutter (含刨刀, Planner)	$\Delta \geq 2.0\text{mm}$	修磨处理 / Grind	/
	$\Delta < 2.0\text{mm}$	建议报废处理 / Scrap	/
金刚石镗铣刀 Diamond Router bits	$\Delta \geq 2.0\text{mm}$	修磨处理 / Grind	/
	$\Delta < 2.0\text{mm}$	建议报废处理 / Scrap	/





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