石家庄华凯精密工具有限公司
SHIJIAZHUANG HUKAY PRECISION TOOLS CO.,LTD

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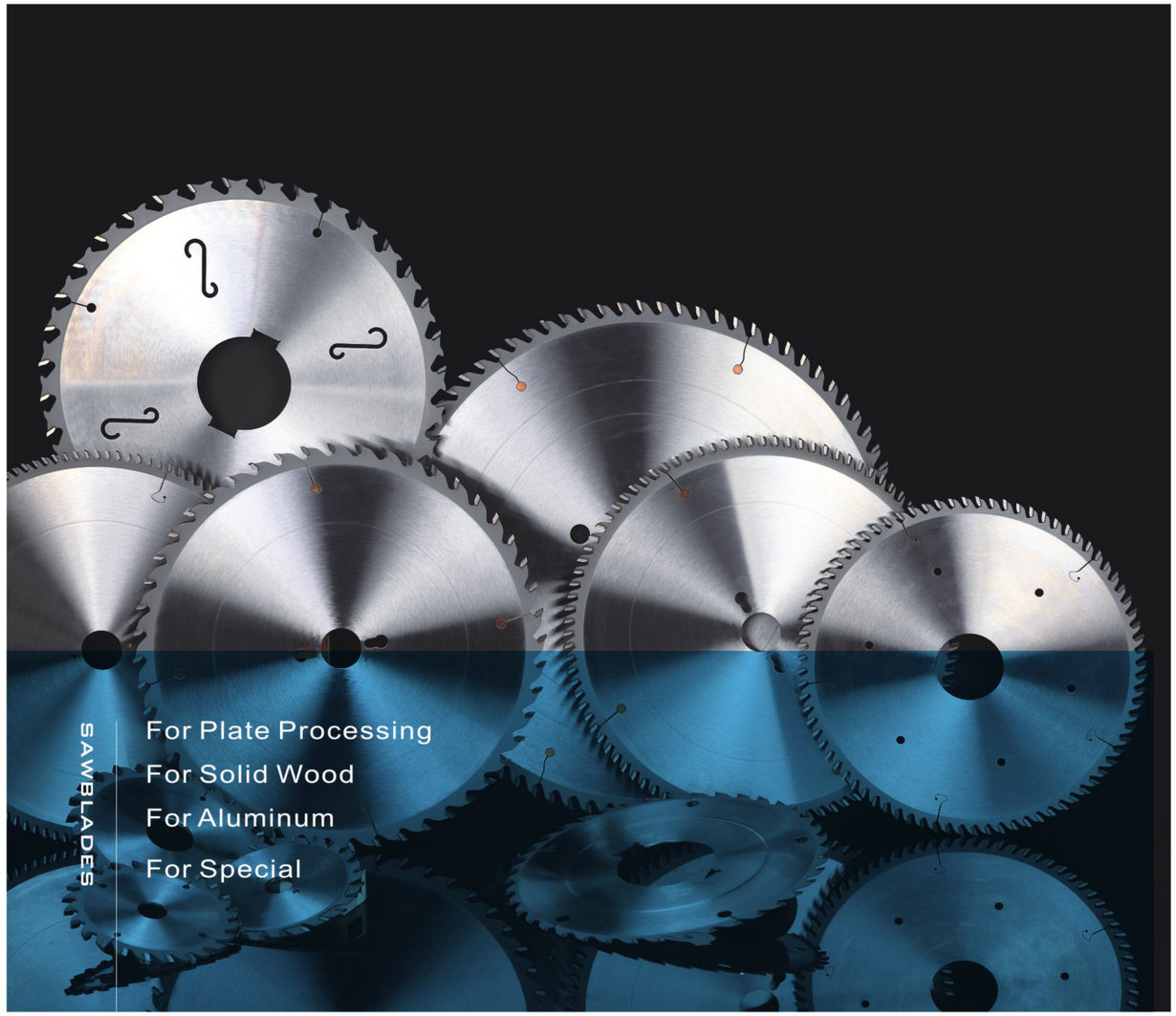
HUKAY®



华凯锯业 承锋而制

Scientific & Technological

SAWBLADES Scientific & Technological

石家庄华凯精密工具有限公司是一家专业生产高、中档硬质合金锯片、PCD锯片的工厂。致力于全球销售，公司按照不同国家和地区加工材质和使用习惯的不同，设计出最适合客户需求的锯片，产品出口俄罗斯、波兰、美国、加拿大、墨西哥、澳大利亚、印度、越南、马来西亚、泰国等20多个国家。

Shijiazhuang Hukay Precision Tools Co., Ltd is a professional manufacturer of high and medium grade T.C.T & PCD saw blades. Committed to global sales, our company designs the most suitable saw blades according to different countries、processing materials and usages. The products are exported to Russia, Poland, the United States, Canada, Mexico, Australia, India, Vietnam, Malaysia, Thailand, etc. more than 20 countries.

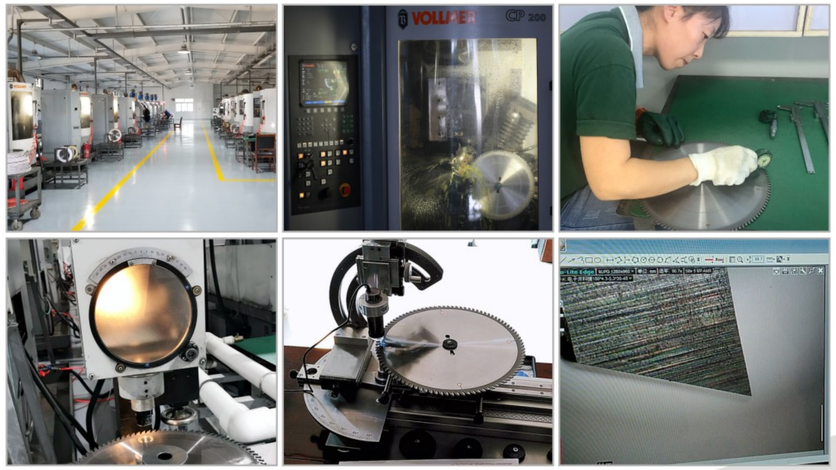
华凯锯业 承锋而制 Scientific & Technological

产品主要包括精密裁板锯锯片、 推台锯锯片、电子开料锯锯片、实木加工锯片、切铝合金锯片，主要应用于刨花板、密度板、 贴面板、 胶合板、实木、铝型材、铝棒等材料的锯切。

公司磨齿设备全部采用德国VOLLMER全自动磨齿机，精密的加工设备保证了产品加工的精度；根据客户的不同需求和锯片锯切材质的不同，原材料选择使用国际、国内顶尖品牌的合金、钢板，生产出适合客户需求的锯片。我公司从事刀具制造将近20年，有着丰富的刀具设计和制造经验，专业的技术人员，高素质的加工团队和先进严格的管理制度保证了产品质量的稳定性。

Our main products are precision panel saw blades,table saw blades, electronic panel sizing saw blades, solid wood saw blades and aluminum alloy cutting saw blades. They are mainly used in chipboard, particle board, MDF, laminates, melamine, plywood, solid wood, aluminum profiles, aluminum rods and other materials cutting.

All grinding equipments are Germany VOLLMER automatic gear grinding machines.The precision processing equipment guarantees the precision of the product processing. According to the different needs and cutting materials, the raw material of alloy and steel plates are selected from the international and domestic top brands, to produce the most suitable products for customers.Our company has been engaged in tool manufacturing for nearly 20 years and has extensive experience in tool design and manufacturing. Professional technicians, high-quality processing teams and advanced strict management systems have ensured the stability of product quality.



About HUKAY

10000m² 厂房面积，明亮整洁
10000m2 workshop area, bright and clean

锯片选择技巧

圆锯片最大转速随锯片外径大小及基体厚度不同而变化(如附表1)，如果高于表列中最大转速，将降低锯片使用特性，进而降低切割效果及锯片使用寿命。圆片高于工件凸出量(T)必须大于锯齿高(图1)，增加或减少锯齿凸出量会影响切割品质。

切割工件齿数(同时切割木料齿数-图2)必须在3齿或4齿间，若少于3齿切割，圆锯片将会产生震动导致切料不均匀。如果想切割较厚工件(S-图4)又希望维持锯片外径，可以使用较少齿数之锯片。在同等外径条件下，若想提高切割较薄工件切割面质量及使用寿命，可以选用齿数较多锯片。

The Max rpm of the saw blade should be changed according to the cutting diameter and the plate. Refer to the table 1 . If the rpm is higher than the data, it will influence the performance and shorten the cutting life of the blade. The T must be higher than the teeth top, refer to picture 1, too much or less will lower the quality of the blade.
The working teeth number must be 3 or 4. Refer to picture 2. If less than 3, it will cause the vibration and can' t get a smooth cutting face. If you want to cut thicker stock but use the same diameter blade, then choose the small number teeth blade. For the same diameter blade, if you want to cut thinner stock with longer cutting life, choose the larger number teeth blade.

圆锯片直径 Cutting Diameter	最大转速 Max. rpm
100mm	15000
125mm	12000
150mm	12000
175mm	10000
200mm	9000
225mm	8500
250mm	8000
280mm	6500
300mm	6000
320mm	5500
350mm	5000
380mm	4500
400mm	4500
450mm	4000
500mm	3500
550mm	3000

附表1

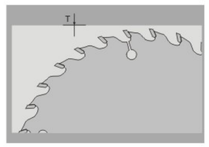


图1

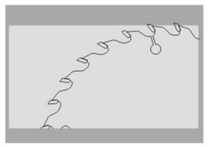


图2

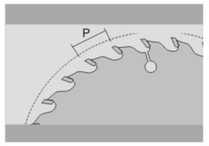


图3

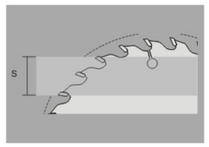


图4

Key
P= 齿距 pitch
S=切割材料厚度 the thickness of the work piece
Z=锯片齿数 teeth number
D=锯片外径 cutting diameter
注意/remark:
以上公式适用于横切锯片或切割其他合成材质
(MDF、胶合板、硬纸板与层压板)，不适用于纵切锯
The above formulation is used to for cross cut, or cutting MDF, plywood, chip boardor laminate, not for rip.

锯片规格选用(仅供参考)/How to choose the dimensions
1、P=SX1.4142/3
2、Z=DX3.14/P
3、Z=DX8/S

Formula A: Pitch = the work piece thickness x 1.4141 / 3 or 4 (how many teeth working together)
Formula B: teeth number = diameter x 3.14 / Pitch
Formula C: you can also work out the teeth number according to the blade diameter and the stock thickness

(a)	$P=\frac{S \times 1.4142}{3}$
(b)	$Z=\frac{D \times 3.14}{P}$
(c)	$Z=\frac{D \times 8}{S}$

附表2

锯间距P(二齿距离：附表2-见公式a)等於工件厚度乘以1.4142，再除以3(如果3齿切割)，或是除以4(4齿切割)公式b:圆锯片齿数等于锯片直径乘以3.14再除以锯齿间距(由前一公获得)。公式c可根据锯片外径和工件厚度获得锯片齿数。

Formula A: Pitch = the work piece thickness x 1.4141 / 3 or 4 (how many teeth working together)
Formula B: teeth number = diameter x 3.14 / Pitch
Formula C: you can also work out the teeth number according to the blade diameter and the stock thickness

How to choose the saw blades

锯片锯切速度查询表
The running speed table

Diameter D (mm)	Speed n (1/min) 1500	2000	2500	2850	3000	4000	4500	5000	5600	6000	8000	9000	10000	12000	18000
50	4	5	7	7,5	8	11	12	14	14,5	16	22	24	28	32	48
60	5	6	8	9	10	13	14	16	17,5	20	26	28	32	40	56
70	5,5	7	9	10,5	11	15	16,5	18	20,5	22	30	33	36	44	66
80	6,5	8,5	10,5	12	13	17	19	21	23,5	26	34	38	42	52	76
90	7	9,5	12	13,5	14	19	21	24	26,5	28	38	42	48	56	84
100	8	10,5	13	15	16	21	24	26	29	32	42	48	52	64	96
120	9,5	13	16	18	19	26	28	32	35	38	52	56	64	76	112
125	10	13,5	16,5	18,5	19,5	27	29	33	36,5	39	54	59	66	78	118
140	11	15	18	21	22	30	33	36	41	44	60	66	72	88	132
150	12	15,5	19,5	22,5	23,5	31,5	35,5	39	44	47	63	70,5	78,5	94,5	141,5
160	13	17	21	24	26	34	38	42	47	52	68	76	84	104	152
180	14	19	24	27	28	38	42,5	48	53	56	76	85	95	113	170
200	16	21	26	30	32	42	47	52	58,5	64	84	94	104	128	188
225	18	24	30	33,5	36	48	53	60	66	72	96	106	120	144	212
250	20	26	33	37	40	52	59	66	73,5	80	104	118	132	160	236
300	24	31,5	40	45	48	63	71	80	88	96	126	142	160	192	284
350	28	36,5	47	52	56	73	83	94	105	112	146	166	188	224	332
400	32	42	54	60	64	84	94	108	117	128	168	188	216	256	376
450	35,5	47	59	67,5	70,5	94,5	106	118	132	141,5	188	211	236	283	424
500	40	53	67	74,5	80	106	119	134	146,5	160	212	236	268	320	472

Mineral fibre plates
Non-ferrous metal
Wood material Plastic material
Natural wood (hard)
Natural wood (soft)
Safety limit
Cutting speed Vs (m/s)

锯切速度计算公式:
Vs=D*π*n/60*1000米/秒，
单位：D 外径 毫米 / n 转速 每分钟。
锯片允许的最大转速已标注在锯片上，在任何情况下，不得超过该转速！
该表已注明安全底限速度，此速度与实现最优生产效益的转速无等同关系。

The formulation of cutting speed
Vs=D*π*n/60*1000 m/s
D is cutting diameter, mm/n is rpm
The Max rpm is on the body. Do not run the blade over the rpm.
The safe limit rpm has no relationship with the optimal benefit.

安全底限/The safety limit
锯切速度（米/秒）/cutting speed (m/s)
转速（每分钟）/rpm (revolutions per minute)

根据加工材料的不同，上述图表表示了硬质合金圆锯片经济的锯切速度范围。当决定锯切复合材料的锯切速度时，基本上总是由组成材料中最耐磨的材料性质决定。
假定：
平均每齿速度Sz大约0.075毫米或更大，
平均锯切高度t大约0.15毫米或更低。

According to different material, it gives the reasonable rpm for different tct saw blade. When cutting the combined materials, the rpm is decided by the element in the material which has character of the most wear resistant.
For example
the average cutting speed of each tip Sz is or more than 0.075mm,the average height t is or less than 0.15mm.

硬质合金锯片修磨
Re-sharpening of the tct saw blade

合金锯片的修磨进给量建议：前角面与后角面进给比例为1：3。锯片需经正确修磨才能保证正常使用寿命。不正确的修磨，如只修磨前角面或只修磨后角面，将减少修磨次数，进而降低锯片使用寿命。另外修磨需保证覆盖整个磨损区域。由于设备精度的原因，我们不推荐手工修磨锯片，自动修磨设备能保证前角面与后角面修磨的精度及一致性。 前角面与后角面的同时修磨可保证合金锯齿的锋利状态及稳定的使用寿命，合金锯齿厚度小于1毫米时，为安全生产考虑，不建议再次修磨。

How to re-sharpen the saw blade: the feeding scale of front face and top is 1:3. The right re-sharpen can extend the cutting life of the saw blade. Wrong re-sharpen, such as just re-sharpen the hook angle, or just re-sharpen the back relief angle, will reduce the number of re-sharpen, so that will shorten the cutting life of the blade. The re-sharpen must cover all the worn area. Because of the precision of the equipment, we do not suggest to re-sharpen by hand. The CNC re-sharpen machine can guarantee the same precision on front face as well as on top. To re-sharpen the front face and the top at the same time can guarantee the sharp on the tips and consistent cutting life. When the thickness of the tip is thinner than 1mm, we suggest not to re-sharpen the tip again concerning of the safety.

校平与加应力
Flatten and adding stress

校平与应力加工对于发挥锯片的完全性能是必不可少的工序。因此在修磨前，需对锯片的平面度及应力进行检查并纠正。校平是为了降低锯片基体侧面跳动公差。 加应力可给与锯身力劲及弹性特征，特别是对于薄锯路锯片而言，应力加工是必不可少的工序。正确的整平与加应力工序应考虑法兰外径尺寸与锯机转速。

It is necessary step to have the flattening and tension during processing the blade. Before re-sharpen the blade, please check the flatness and inside stress of the body, and repair them. To flatten the body is to reduce the side section run out. To add the stress is to keep the flexibility of the body, special to the thin kerf blade. The right flattening and adding stress should consider the outside diameter of the flange as well as the rpm.

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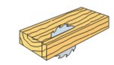
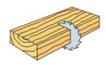


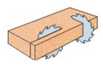
软木纵切
Softwood ripping



软木横切
Softwood crosscutting

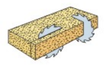
硬木纵切
hardwood ripping

硬木横切
Hardwood crosscutting

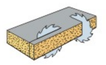


中密度纤维板
MDF

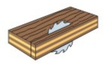
木质复合材料
wood composites



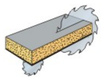
刨花板
Chip board



双面三聚氰胺
Double-sided melamine

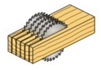


胶合板
Plywood

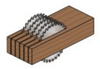


贴面板
Veneers

木皮贴面板
Veneer plywood



软木多片纵切锯
Softwood multi-ripping saw



硬木多片纵切锯
Hardwood multi-ripping saw

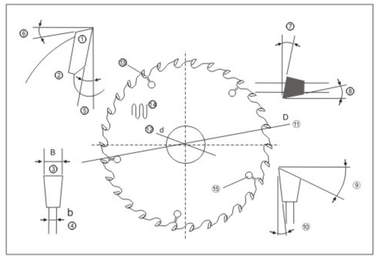
划槽
Grooving

划线
Scoring

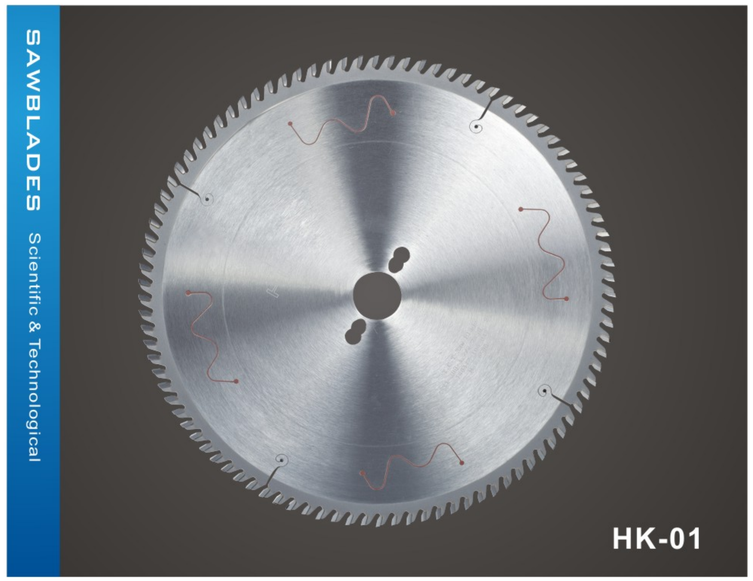
铝型材
Aluminum

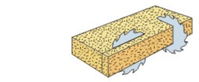
铝材
Aluminum

锯片各构成部分名称
The name of each section of the saw blades

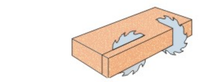


① 合金刀头 Tips
② 基体 Body
③ 刃厚B Tip thickness B
④ 基体厚b Plate b
⑤ 前角 Hook angle
⑥ 后角 Back relief angle
⑦ 横向前角 Face angle
⑧ 侧面后角 Sideward angle
⑨ 顶倾角 Top bevel angle
⑩ 侧面向心角 Sideward centripetal angle
⑪ 外径D External diameter D
⑫ 内径d Bore d
⑬ 消胀线（槽） Tension ring
⑭ 减振线 Expansion slot
⑮ 减振铜钉 Copper bin

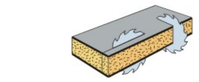




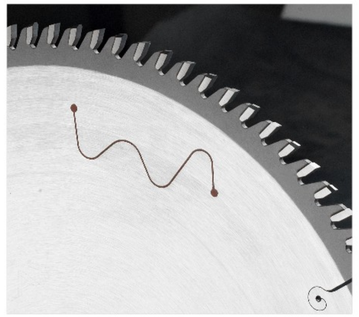
刨花板
Chip board



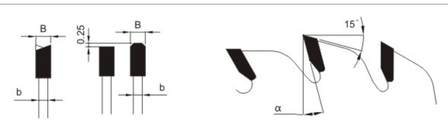
中密度纤维板
MDF



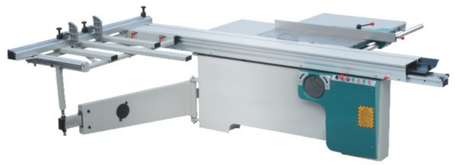
双面三聚氰胺
Double-sided melamine



锯片齿型
The tooth type



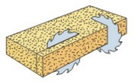
适用机器
Applicable machine



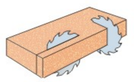
适用：精密切削
适合机械：推台锯机、往复锯机
切削材料：三聚氰胺或其它塑性材料贴面的刨花板、密度板、实木复合板材

Application: For fine cutting
Machines: For table saws, precision panel saw.
Cutting material: Melamine or other laminated chip board,MDF,composite materials.

产品序列号 Product	外径 Outer diameter	锯路 Kerf	基板厚度 Plate thickness	内径 Inner diameter	齿数 Number of teeth
ID	D (mm)	B (mm)	b (mm)	d (mm)	Z
001	250	3.2	2.2	25.4/30	80
002	300	3.2	2.2	25.4/30	72
003	300	3.2	2.2	25.4/30	80
004	300	3.2	2.2	25.4/30	96

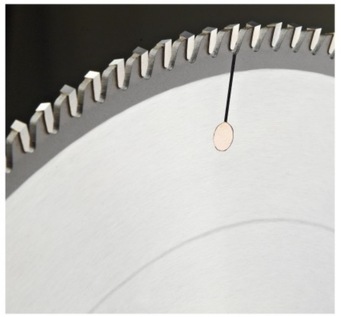


刨花板
Chip board

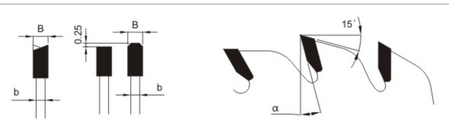


中密度纤维板
MDF

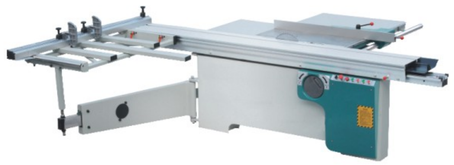
双面三聚氰胺
Double-sided melamine



锯片齿型
The tooth type



适用机器
Applicable machine

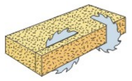


适用：精密切削
适合机械：推台锯机、往复锯机
切削材料：三聚氰胺或其它塑性材料贴面的刨花板、密度板、实木复合板材

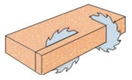
Application: For fine cutting
Machines: For table saws, precision panel saw.
Cutting material: Melamine or other laminated chip board,MDF,composite materials.

产品序列号 Product	外径 Outer diameter	锯路 Kerf	基板厚度 Plate thickness	内径 Inner diameter	齿数 Number of teeth
ID	D (mm)	B (mm)	b (mm)	d (mm)	Z
001	350	3.5	2.5	25.4/30	72
002	350	3.5	2.5	25.4/30	84
003	350	3.5	2.5	25.4/30	96
004	350	3.5	2.5	25.4/30	108

电子开料锯机用锯片 Electronic panel sizing saw blades

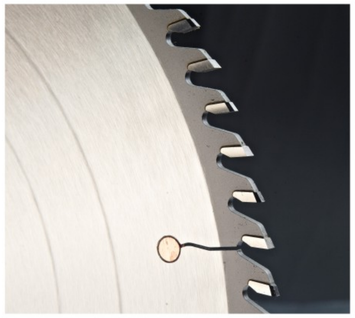


刨花板
Chip board

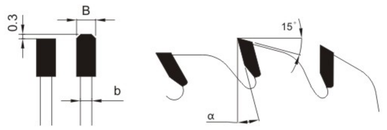


中密度纤维板
MDF

双面三聚氰胺
Double-sided melamine



锯片齿型
The tooth type



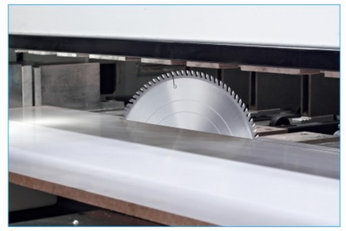
适用机器
Applicable machine

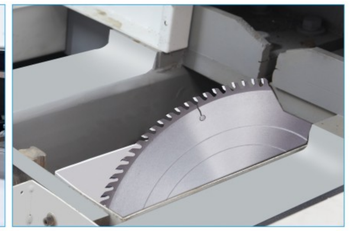
适用：精密切削
适合机械：电子开料锯
切削材料：三聚氰胺或其它塑性材料贴面的刨花板、密度板、实木复合板材。

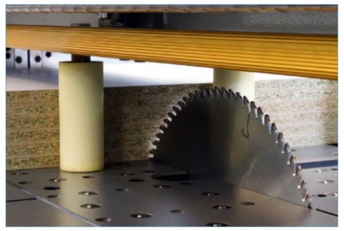
Application: For fine cutting
Machines: Electronic panel sizing machine.
Cutting material: Melamine or other laminated chip board,MDF,composite materials.

产品序列号 Product	外径 Outer diameter	锯路 Kerf	基板厚度 Plate thickness	内径 Inner diameter	齿数 Number of teeth
ID	D (mm)	B (mm)	b (mm)	d (mm)	Z
001	300	4.4	3.0	30/65	60
002	300	4.4	3.0	30/75/80	72
003	350	4.4	3.2	60/75	72
004	350	4.4	3.2	60/75	84
005	360	4.4	3.2	75	72
006	380	4.4	3.2	60/75	72
007	380	4.4	3.2	60/75	84
008	400	4.4	3.2	60/75	72
009	400	4.4	3.2	60/75	84
010	400	4.4	3.2	60/75	96
011	450	4.8	3.5	60/75/80	84
012	450	4.8	3.5	60/75/80	96
013	450	4.8	3.8	75/80	84
014	450	4.8	3.8	75/80	96

产品应用 Product application

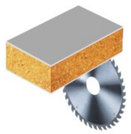






石家庄华凯精密工具有限公司
SHIJIAZHUANG HUKAY PRECISION TOOLS CO., LTD.

划线用单片锯片 Conical scoring saw blades



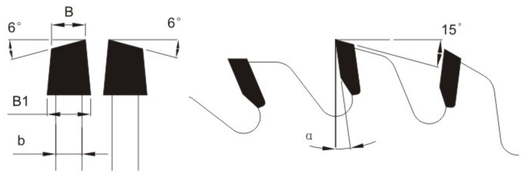
贴面板划槽

Bi-laminated board scoring

产品序列号 Product	外径 Outer diameter	锯路 Kerf	基板厚度 Plate thickness	内径 Inner diameter	齿数 Number of teeth
ID	D (mm)	B (mm)	b (mm)	d (mm)	Z
001	100	3.1–4.3	2.2	20/22	24
002	110	3.1–4.3	2.2	20/22	24
003	120	3.0–4.0	2.2	20/22	24
004	125	3.1–4.3	2.2	20/22	24
005	160	3.0–4.0	2.2	22	36
006	160	3.3–4.3	2.2	25.4/30	36
007	160	3.3–4.3	2.5	25.4/30	36
008	160	4.3–5.3	2.5	25.4/30/55	36
009	180	3.3–4.3	2.5	25.4/30	40
010	180	4.3–5.3	3.2	30/45/55	40
011	180	4.3–5.3	3.5	30/45/55	40
012	180	4.6–5.6	3.8	30/45	40
013	200	4.3–5.3	3.2	30/45/50/75	40
014	200	4.3–5.3	3.5	45/50/75	40
015	200	4.6–5.6	3.8	30/45	40

锯片齿型

The tooth type



适用：双贴面板材表层划槽

适合机械：推台锯机、往复锯机、电子开料锯

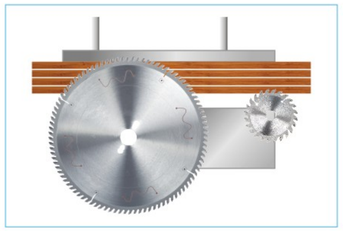
切削材料：三聚氰胺或其它塑性材料贴面的刨花板、密度板、实木复合板材。

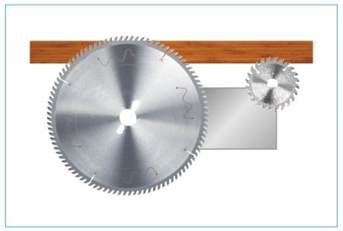
Application: To score the coating on bi-laminated panels.

Machines: For table saws, precision panel saw,electronic panel sizing saw blade.

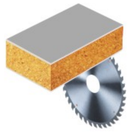
Cutting material: Melamine or other laminated chip board,MDF,composite materials.

产品应用 Product application

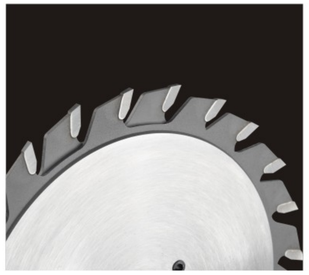




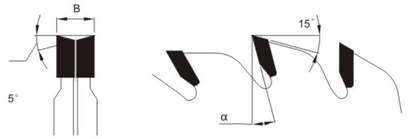
划线用双片组合锯片 Adjustable scoring saw blades



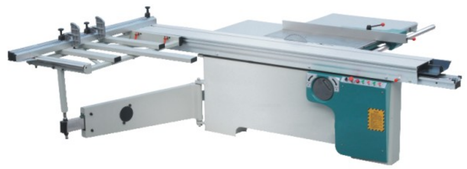
贴面板划槽
Bi-laminated board scoring



锯片齿型
The tooth type



适用机器
Applicable machine



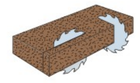
适用：双贴面板材表层划槽
适合机械：推台锯机、往复锯机
切削材料：三聚氰胺或其它塑性材料贴面的刨花板、密度板、实木复合板材。

Application: To score the coating on bi-laminated panels.
Machines: For table saws, precision panel saw.
Cutting material: Melamine or other laminated chip board,MDF,composite materials.

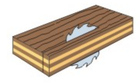
产品序列号 Product	外径 Outer diameter	锯路 Kerf	基板厚度 Plate thickness	内径 Inner diameter	齿数 Number of teeth
ID	D (mm)	B (mm)	b (mm)	d (mm)	Z
001	120	2.8–3.6	2.2	20/22	12+12
002	125	2.8–3.6	2.2	20/22	12+12

实木横截用锯片 Solid wood cross cutting saw blades

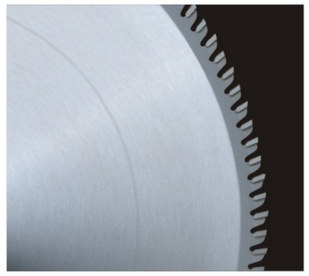
实木
Solid wood



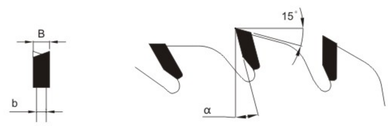
木质复合材料
wood composites



胶合板
Plywood



锯片齿型
The tooth type



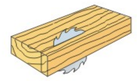
适用：精密切削
适合机械：推台锯
切削材料：实木横向加工、胶合板、实木复合料

Application: For fine cutting
Machines: Used on table saws
Cutting material: Cross cutting solid wood, plywood,composite materials.

产品序列号 Product	外径 Outer diameter	锯路 Kerf	基板厚度 Plate thickness	内径 Inner diameter	齿数 Number of teeth
ID	D (mm)	B (mm)	b (mm)	d (mm)	Z
001	255	3.0	2.2	25.4/30	40
002	255	3.2	2.2	25.4/30	60
003	255	3.2	2.2	25.4/30	80
004	255	3.2	2.2	25.4/30	100
005	255	3.2	2.2	25.4/30	120
006	300	3.2	2.2	25.4/30	72
007	300	3.2	2.2	25.4/30	80
008	300	3.2	2.2	25.4/30	96
009	300	3.2	2.2	25.4/30	100
010	300	3.2	2.2	25.4/30	120
011	350	3.2	2.2	25.4/30	108
012	350	3.2	2.2	30	120
013	400	4.0	3.2	30	96
014	400	4.0	3.2	30	120
015	450	4.4	3.5	30	100
016	500	4.4	3.5	30	100

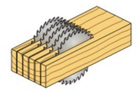
石家庄华凯精密工具有限公司
SHIJIAZHUANG HUKAY PRECISION TOOLS CO., LTD.

实木纵切用锯片 Solid wood ripping saw blades

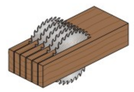


软木纵切
Softwood ripping

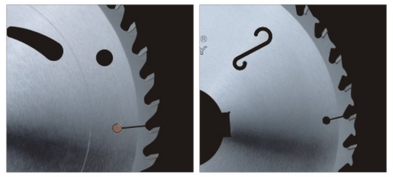
硬木纵切
hardwood ripping



软木多片纵切锯
Softwood
multi-ripping saw



硬木多片纵切锯
Hardwood
multi-ripping saw

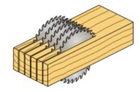


锯片齿型
The tooth type

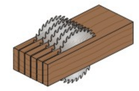
适用：精密切削	Application: For fine cutting
适合机械：推台锯	Machines: Used on table saws
切削材料：实木开料	Cutting material: For solid wood ripping

产品序列号 product	外径 Outer diameter	锯路 Kerf	基板厚度 Plate thickness	内径 Inner diameter	齿数 Number of teeth
ID	D (mm)	B (mm)	b (mm)	d (mm)	Z
001	230	3.2	2.2	25.4/30	40
002	255	3.2	2.2	25.4/30	40
003	255	3.2	2.2	25.4/30	60
004	305	3.2	2.2	30/50/70	28
005	305	3.2	2.2	30/50/70	36
006	300	3.2	2.2	25.4/30	48
007	300	3.2	2.2	25.4/30	60
008	350	3.2	2.2	30	32
009	350	3.2	2.2	30	54
010	350	3.2	2.2	30	60
011	400	3.5	2.5	30	60

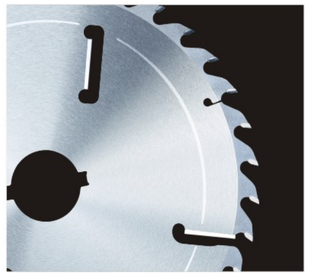
带刮刀多片锯 Multi blade with rakers



软木多片纵切锯
Softwood
multi-ripping saw



硬木多片纵切锯
Hardwood
multi-ripping saw



锯片齿型
The tooth type

适用机器
Applicable machine

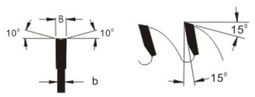
适用：实木纵切开料	Application: Solid wood longitudinal sizing
适合机械：常规多片锯、原木多片锯	Machines: Used on multi blade table saws.
切削材料：含水率低的软、硬木	Cutting material: To cut dried soft and hard wood.

产品序列号 Product	外径 Outer diameter	锯路 Kerf	基板厚度 Plate thickness	内径 Inner diameter	齿数 Number of teeth
ID	D (mm)	B (mm)	b (mm)	d (mm)	Z
001	255	2.2	1.6	50/60/70	24+2+2
002	255	2.4	1.8	50/60/70/80	24+2+2
003	255	2.6	2.0	50/60/70/80	24+2+2
004	305	2.4	1.8	50/60/70/80	28+2+2
005	305	2.6	2.0	50/60/70/80	28+2+2
006	305	2.8	2.2	50/60/70/80	28+2+2
007	320	2.8	2.2	30/50/80	32+2+2
008	320	3.2	2.5	30/50/80	32+2+2
009	355	3.2	2.5	30/60/70/80	36+2+2
010	355	3.4	2.7	30/60/70/80	36+2+2
011	355	3.6	2.8	30/60/70/80	36+2+2
012	380	3.2	2.5	30/50/60/70/80	36+2+2
013	405	3.2	2.5	50/60	32+2+4
014	405	3.4	2.7	50/60	36+2+4
015	455	3.8	3.0	30/50/70/80	36+2+4
016	455	4.0	3.2	30/50/70/80	36+2+4
017	500	4.8	3.5	30/50/70/80	40+2+4

开槽锯片 Grooving saw blades

划槽
Scroing

锯片齿型
The tooth type

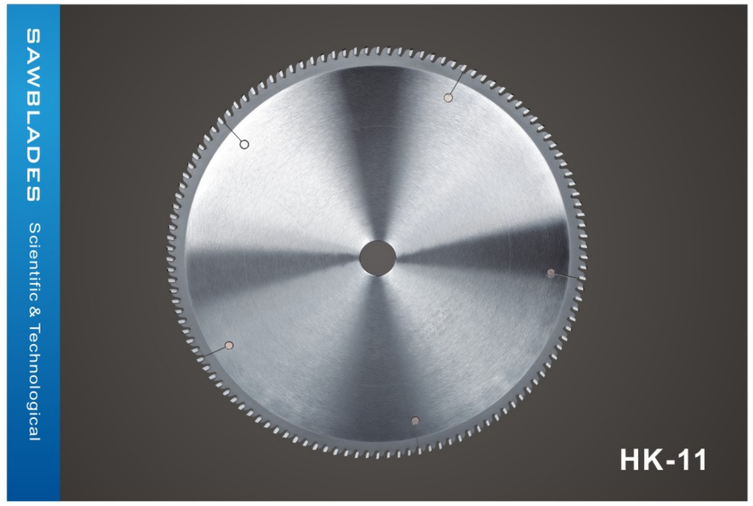


适用：开槽
适合机械：台锯机、双端铣、修边机、镂铣机
切削材料：三聚氢胺或其它塑性材料贴面的刨花板、实木、板材

Application: For grooving
Machines: Table saws, double-end milling, edge trimming machine, router machine.
Cutting material: Melamine board or other plastic material coated particle board, solid wood, wood-based panels, etc.

产品序列号 Product	外径 Outer diameter	锯路 Kerf	基板厚度 Plate thickness	内径 Inner diameter	齿数 Number of teeth
ID	D (mm)	B (mm)	b (mm)	d (mm)	Z
001	125	4.0	2.5	35	24
002	125	5.0	3.0	35	24
003	125	5.3	3.5	35	24
004	125	5.5	2.5	35	24
005	150	4.0	2.5	35	24
006	150	5.0	3.0	35	30
007	150	5.3	3.0	35	30
008	150	5.5	3.0	35	30
009	150	6.0	4.0	35	30
010	180	4.0	2.5	24.5/30/35	40
011	180	5.0	3.0	24.5/30/35	40
012	180	6.0	4.0	24.5/30/35	40
013	200	4.0	2.5	24.5/30	40
014	200	5.0	3.0	24.5/30	40
015	200	6.0	4.0	24.5/30	40
016	250	4.0	3.0	30	60
017	250	5.0	3.0	30	60

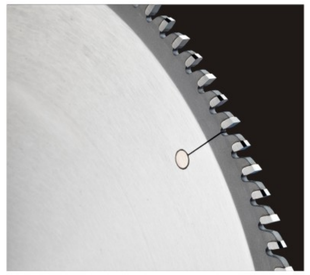
Φ350mm以下直径锯片 Smaller Φ350mm saw blades for aluminum



锯切铝棒
Aluminum bar

锯切门窗
Aluminum window and door

锯切硬质塑料
Rigid plastics



锯片齿型
The tooth type

适用机器
Applicable machine

适合切削材料：铝型材、实心铝材及塑形材的锯切
用途：横向截断、端角切割
设备：轻型铝材切割机、单双头锯、V型切割机等小型设备
锯片转速：2800转/分

Suitable for cutting materials: Aluminum profile, solid aluminum or plastic material sawing.
Application: Transverse, side angle cutting.
Equipment: Light aluminum cutting machine, double head saw, V-shaped cutting machine and other small equipment.
Saw blade speed: 2800 r/min

产品序列号 Product	外径 Outer diameter	锯路 Saw Kerf	基板厚度 Plate thickness	内径 Inner diameter	齿数 Number of teeth
ID	D (mm)	B (mm)	b (mm)	d (mm)	Z
001	255	2.8	2.2	25.4/30	100
002	255	2.8	2.2	25.4/30	120
003	305	3.0	2.4	25.4/30	100
004	305	3.0	2.4	25.4/30	120
005	350	3.2	2.5	25.4/30	100
006	350	3.2	2.5	25.4/30	120
007	355	3.2	2.5	25.4/30	120

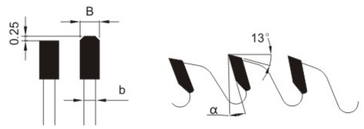
Φ350mm 以上直径锯片 Larger Φ350mm saw blades for aluminum

锯切铝棒
Aluminum bar

锯切门窗
Aluminum window and door

产品序列号 Product	外径 Outer diameter	锯路 Kerf	基板厚度 Plate thickness	内径 Inner diameter	齿数 Number of teeth	设备 Equipment
ID	D (mm)	B (mm)	b (mm)	d (mm)	Z	
001	400	3.4	2.7	25.4/30	100	
002	400	3.4	2.7	25.4/30	120	
004	420	4.0	3.2	25.4/30	108	
005	420	4.0	3.2	25.4/30	120	
006	450	4.2	3.5	30	100	双端斜切
007	450	4.0	3.2	30	96	锯重型数控双头
008	500	4.2	3.5	30	100	切割锯
009	500	4.4	3.7	30	120	等微量润滑设备
010	550	4.8	4.0	30	140	Double end miter saw,
011	600	4.8	4.0	30	140	heavy CNC saw,
012	610	4.8	4.1	30	140	double-headed cutting
013	650	6.0	5.0	30	96	trace lubrication equipment.
014	650	6.0	5.0	30	140	
015	700	6.0	5.0	30	72	
016	750	6.0	5.0	30	84	

锯片齿型
The tooth type

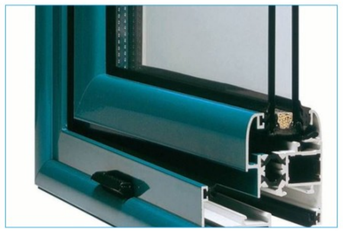


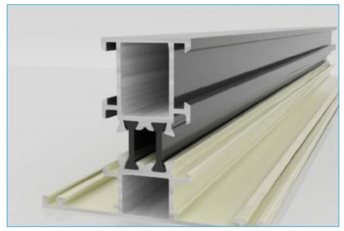
适用机器
Applicable machine

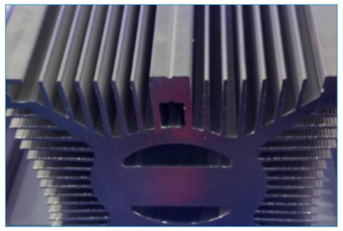
适合切削材料：铝型材、实心铝材及
塑形材的锯切
用途：横向截断、端角切割
设备：双端斜切锯、重型数控双头切割锯等微量润滑设备
锯片转速：2800转/分

Suitable for cutting materials: Aluminum profile, solid
aluminum or plastic material sawing.
Application: Transverse, side angle cutting.
Equipment: Double end miter saw,heavy CNC saw, double-headed
cutting trace lubrication equipment.
Saw blade speed: 2800 r/min

产品应用 Product application







铝用端铣刀 Aluminum end-milling blades

适用机器
Applicable machine

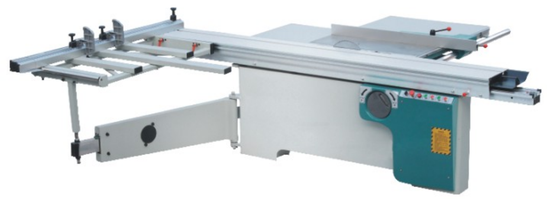
适合切削材料： 门窗铝型材及塑钢型材的锯切
用途：型材的端头切割、开槽、90度接角组合
设备：自动或半自动端面铣锯切机
锯片转速：2800转/分

Cutting material: Sawing of doors and windows aluminum profiles and plastic steel profiles.
Application: The end of the profile cutting, grooving, 90 degree angle combination.
Machines: Automatic or semi-automatic end-milling sawing machine.
Saw blade speed: 2800r/min

产品序列号 Product	外径 Outer diameter	厚度 thickness	内径 Inner diameter	齿数 Number of teeth
ID	D (mm)	B (mm)	b (mm)	d (mm)
001	160	6.0	32	24
002	160	6.5	32	24
003	160	8.0	32	24
004	200	4.0	32	40
005	200	5.0	32	40
006	200	5.5	32	40
007	200	6.0	32	40
008	250	6.5	32	40
009	250	7.0	32	40
010	250	7.5	32	40
011	250	8.0	32	40
012	250	8.5	32	40
013	250	10.0	32	40
014	250	5.0	32	24
015	250	6.0	32	24
016	250	8.0	32	24
017	250	10.0	32	24

PCD 双划线锯 PCD adjustable scoring saw blades

适用机器
Applicable machine

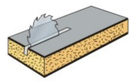


适用：双贴面板材表层划槽
适合机械：推台锯机、往复锯机
切削材料：三聚氰胺或其它塑性材料贴面的刨花板、密度板、实木复合板材

Application: To score the coating on bi-laminated panels.
Machines: For table saws, precision panel saw.
Cutting material: Melamine or other laminated chip board,MDF,composite materials.

产品序列号 Product	外径 Outer diameter	锯路 Kerf	基板厚度 Plate thickness	内径 Inner diameter	齿数 Number of teeth
ID	D (mm)	B (mm)	b (mm)	d (mm)	Z
001	100	2.8-3.6	2.2	20/22	12+12
002	120	3.0-4.0	2.2	20/22	12+12
003	120	3.1-4.1	2.2	20/22	12+12
004	125	3.3-4.3	2.2	20/22	12+12
005	125	4.3-5.3	2.2	20/22	12+12

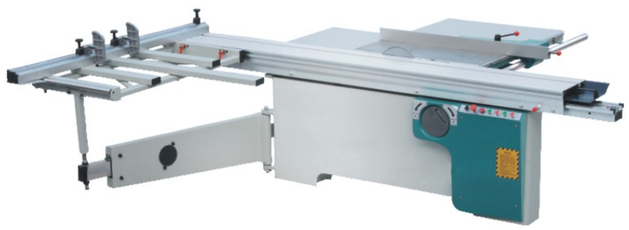
PCD 单划线锯 PCD conical scoring saw blades



贴面板划槽
Bi-laminated board scoring

产品序列号 Product	外径 Outer diameter	锯路 Kerf	基板厚度 Plate thickness	内径 Inner diameter	齿数 Number of teeth
ID	D (mm)	B (mm)	b (mm)	d (mm)	Z
001	100	3.1–4.3	2.2	20/22	24
002	110	3.1–4.3	2.2	20/22	24
003	120	3.0–4.0	2.2	20/22	24
004	125	3.1–4.3	2.2	20/22	24
005	160	3.0–4.0	2.2	22	36
006	160	3.3–4.3	2.2	25.4/30	36
007	160	3.3–4.3	2.5	25.4/30	36
008	160	4.3–5.3	2.5	25.4/30/55	36
009	180	3.3–4.3	2.5	25.4/30	40
010	180	4.3–5.3	3.2	30/45/55	40
011	180	4.3–5.3	3.5	30/45/55	40
012	180	4.6–5.6	3.8	30/45	40
013	200	4.3–5.3	3.2	30/45/50/75	40
014	200	4.3–5.3	3.5	45/50/75	40
015	200	4.6–5.6	3.8	30/45	40

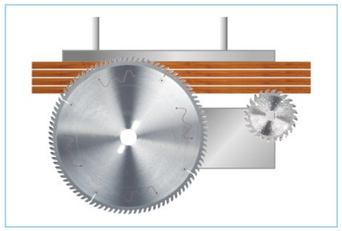
适用机器
Applicable machine

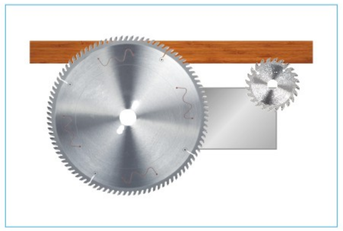


适用：双贴面板材表层划槽
适合机械：推台锯机、往复锯机、电子开料锯
切削材料：三聚氰胺或其它塑性材料贴面的刨花板、密度板、实木复合板材

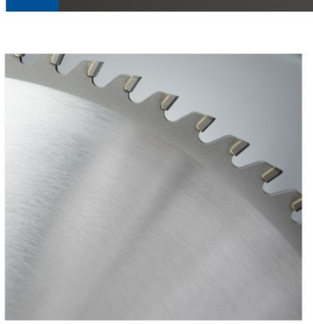
Application: To score the coating on bi–laminated panels.
Machines: For table saws, precision panel saw,electronic panel sizing saw blade.
Cutting material: Melamine or other laminated chip board,MDF,composite materials.

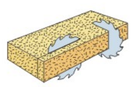
产品应用 Product application



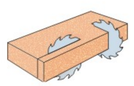


PCD 木工锯片 PCD woodworking saw blades

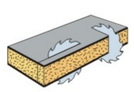




刨花板
Chip board



中密度纤维板
MDF



双面三聚氰胺
Double-sided melamine

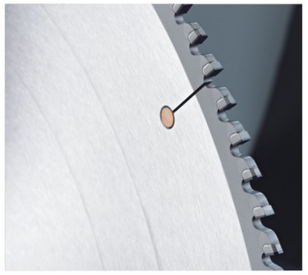
锯片齿型
The tooth type

适用：精密切削
适合机械：推台锯机、往复锯机
切削材料：三聚氰胺或其它塑性材料贴面的刨花板、密度板、实木复合板材

Application: For fine cutting
Machines: For table saws, precision panel saw.
Cutting material: Melamine or other laminated chip board,MDF,composite materials.

产品序列号 Product	外径 Outer diameter	锯路 Kerf	基板厚度 Plate thickness	内径 Inner diameter	齿数 Number of teeth
ID	D (mm)	B (mm)	b (mm)	d (mm)	Z
001	300	3.2	2.2	25.4/30	60
002	300	3.2	2.2	25.4/30	72
003	300	3.2	2.2	25.4/30	96
004	350	3.5	2.5	30	72
005	350	3.5	2.5	30	84
006	350	3.5	2.5	30	96
007	350	4.4	3.2	60/75	72
008	350	4.4	3.2	60/75	84
009	350	4.4	3.2	60/75	96
010	380	4.4	3.2	60/75	72
011	380	4.4	3.2	60/75	84
012	380	4.4	3.2	60/75	96
013	400	4.4	3.2	60/75	72
014	400	4.4	3.2	60/75	84
015	400	4.4	3.2	60/75	96

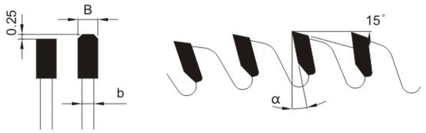
PCD 切铝锯片 PCD aluminum alloy cutting saw blades



锯切铝棒
Aluminum barl

锯切门窗
Aluminum window and door

锯片齿型
The tooth type



适用机器
Applicable machine

适合切削材料： 铝型材、实心铝材及塑形材的锯切
用途：横向截、端角切割
设备：双端斜切锯、重型数控双头切割锯等微量润滑设备
锯片转速：2800转/分

Suitable for cutting materials: Aluminum profile, solid aluminum or plastic material sawing.
Application: Transverse, side angle cutting.
Equipment: Double end miter saw,heavy CNC saw, double-headed cutting trace lubrication equipment.
Saw blade speed: 2800 r/min

产品序列号 product	外径 Outside diameter	锯路 Saw road	基板厚度 Substrate thickness	内径 Inner diameter	齿数 Number of teeth
ID	D (mm)	B (mm)	b (mm)	d (mm)	Z
001	450	4.4	3.7	30	120
002	500	4.4	3.7	30	120
003	500	4.2	3.5	30	100
004	550	4.8	4.0	30	140