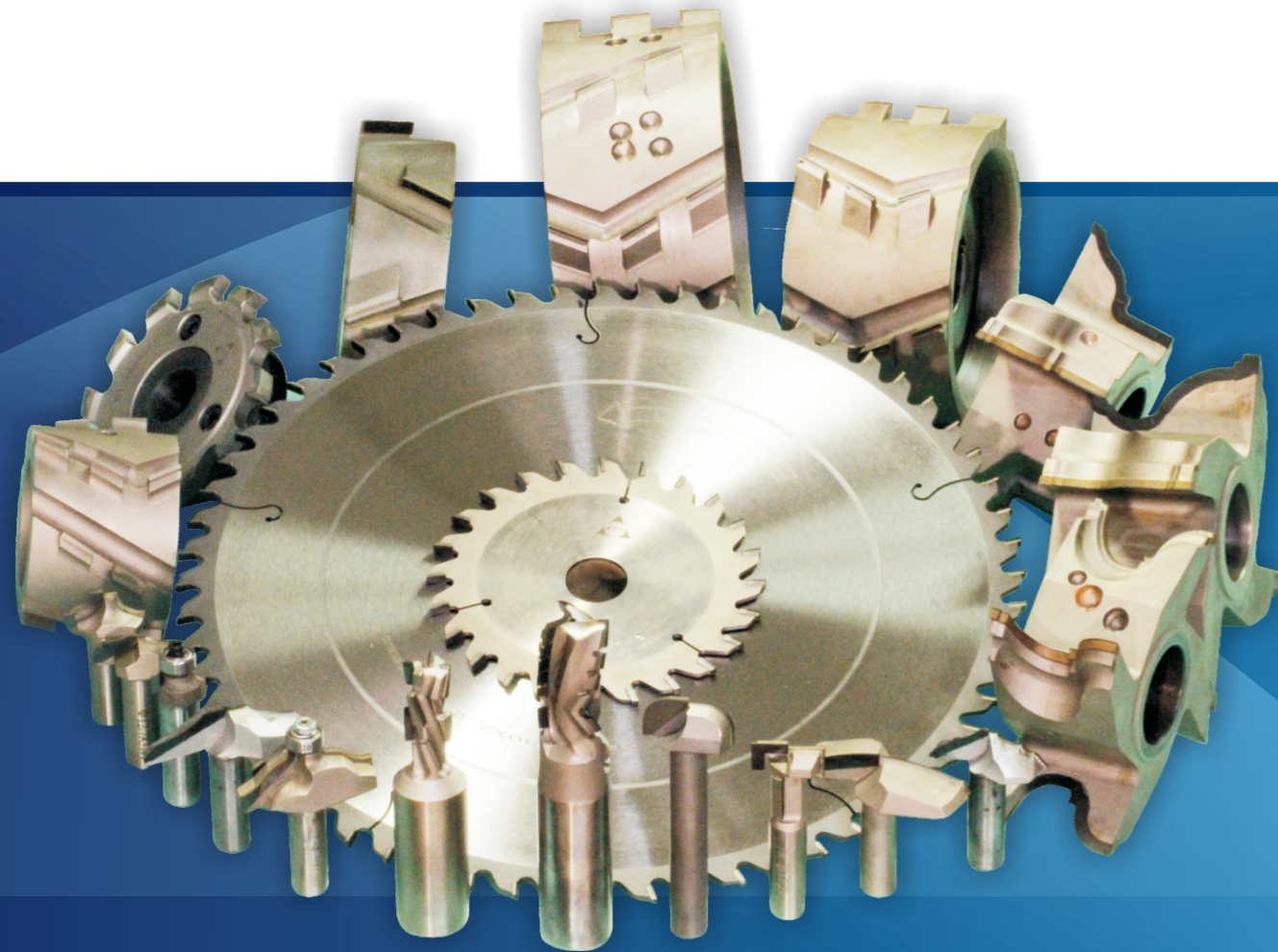


生产精品刀具 打造世界品牌  
Produce Excellent Cutting Tools Creat World Famous Brand



**PCD木工刀**  
PCD WOODWORKING TOOLS



**成都戴梦迪超硬工具有限责任公司**

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**成都戴梦迪超硬工具有限责任公司**  
**CHENGDU DIAMOND TOOLS CO., LTD.**





## COMPANY 公司简介 INTRODUCTION

成都戴梦迪超硬工具有限责任公司成立于2001年，是专业生产PCBN/PCD金属切削刀具、PCD木工刀具、PCD石材刀具、硬质合金螺线车、铣刀具，以及硬质合金成形刀具的民营企业。公司拥有英国COBORN、德国VOLLMER、日本FANUC、德国ZOLLER等数十台先进制造及高精度检测设备，技术力量雄厚，始终以“生产精品刀具，打造世界品牌”为宗旨，产品畅销全球五十多个国家。

公司生产的PCD金刚石木工刀具具有精度高（刀具齿跳动 $\leq 0.01\text{mm}$ ）、切削速度高（最高转速大于20000转/分）、刀具寿命长（是硬质合金木工刀寿命的几十倍）、工件表面质量好（通常可以去掉打磨工序）、多次修磨后使用如新的特点，尤其适用于家具、地板等木工行业的规模化生产。公司还为用户提供各种非标定制、来样定制、来图加工、售后修磨等全套PCD木工刀具的解决方案。

公司已通过ISO9001-2008质量管理体系认证、瑞士SGS认证、德国TUV认证。

Established in 2001 year, Chengdu Diamond Tools Co., Ltd is a leading and professional manufacturer of PCBN/PCD Metalworking Tool, PCD woodworking tool, PCD carving tool for stone, Thread turning and Milling tool, and Carbide forming insert. We own professional technical team, and equip with decades of advanced CNC machines – CORBON from UK, Japan FANUC, Germany VOLLMER, Germany inspection device ZOLLER. Our mission is “Produce Excellent Cutting Tools, Create World Famous Brand”. Our products are popular over fifty countries around the world.

Our PCD Woodworking Tools advantages:  
 High Precision (Tool teeth run out  $\leq 0.01\text{ mm}$ )  
 High productivity at higher speed (MAX RPM  $\geq 20000\text{ rev/min}$ )  
 Long Tool Life (dozens of times longer than carbide tools)  
 Excellent Surface Finish Quality (after machining, no need to polish)  
 Can be re-sharpened several times without affecting the original profile  
 Suitable for Furniture, Floorboard and other Woodworking industries in mass production  
 Our company could also provide customers with custom tooling solutions.

We are granted ISO 9001:2008, Swiss SGS certification, and comprehensive capabilities verified by Germany TÜV Rhineland.





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随着现代家具制造业的发展,使用更高效、高精度、高稳定性、低粗糙度的PCD家具刀具的场合越来越多,家具行业的裁板、修边、成型等PCD刀具将取缔部分硬质合金刀具成为今后的发展方向。

With the development of modern furniture manufacturing industry, the more-efficient, high-precision, high-stability, and low-roughness PCD (Polycrystalline Diamond) cutting tools are increasingly applied for machining furniture. PCD tools will replace tungsten carbide tools for sawing, sizing, trimming, and profiling, and it becomes the development trend in the furniture industry.



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## PCD锯片齿形图 PCD Tooth Shape

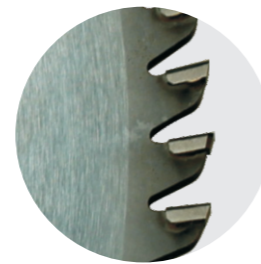
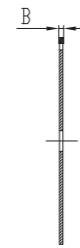
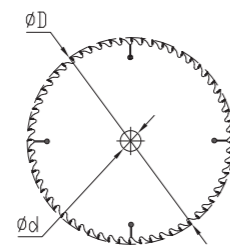
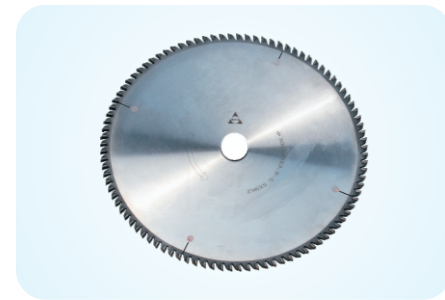
代号 code	FZ	TR	FZ/TR	WZ	KON	KON/WZ
齿形 tooth shape						



## 1.1 平梯齿PCD锯片 FZ/TR Tooth Shape PCD saw blades

适合推台锯及电子开料锯，对刨花板、中密度板、塑料贴面板、石膏板、水泥板等的单层和多层切断。

Ideal for table saws and CNC cutting saws for parting off single and multi-layer Chipboard, MDF, plastic plywood, gypsum board, cement board, artificial stone, etc.

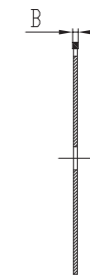
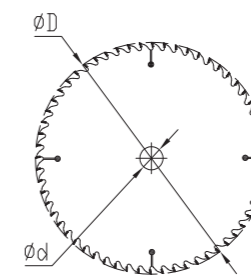
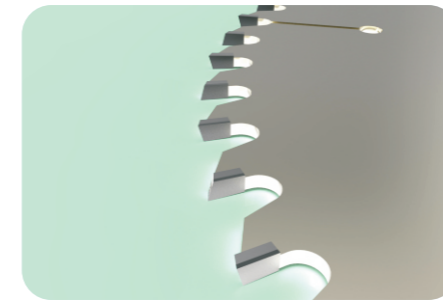


ID No.	$\phi D$	$\phi d$	$\phi d_{Max}$	B	齿数(Z)	齿形 tooth shape	备注 remark
12211001	200	30	60	4	24	FZ/TR	
12211002	220	30	80	3.2	36	FZ/TR	
12211003	220	30	80	3.2	36	FZ/TR	
12211004	250	30	115	3.5	48	FZ/TR	
12211005	250	30	115	3.5	60	FZ/TR	
12211006	250	30	115	3.5	80	FZ/TR	加工三聚氰胺板建议采用梯齿 (TR/TR) 锯片
12211007	300	30	115	3.2	60	FZ/TR	
12211008	300	30	115	3.2	72	FZ/TR	
12211009	300	30	115	3.2	84	FZ/TR	Suggest to use saw blade in Trapezoidal tooth (TR/TR) for Melamine boards
12211010	300	30	115	3.2	96	FZ/TR	
12211011	350	30	120	3.5	60	FZ/TR	
12211012	350	30	120	3.5	72	FZ/TR	
12211013	350	30	120	3.5	84	FZ/TR	
12211014	350	35	120	3.5	108	FZ/TR	
12211015	400	30	130	3.5	84	FZ/TR	
12211016	400	30	130	3.5	96	FZ/TR	
12211017	400	35	130	3.5	120	FZ/TR	

## 1.2 左右齿PCD锯片 WZ Tooth Shape PCD saw blades

适合推台锯、纵横切锯及其它锯机，对实木、刨花板、中密度板、三聚氰胺贴面板、塑料贴面板、防火板等的单层和多层切断。

Suitable for table saws, cross cutting saws, and other saws for parting off single and multi-layer Solid wood, Chipboard, MDF, Melamine plywood, Plastic veneer, Fire-proof board, etc.

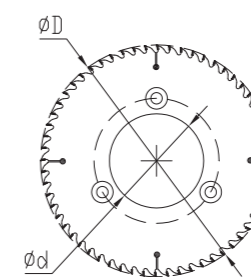
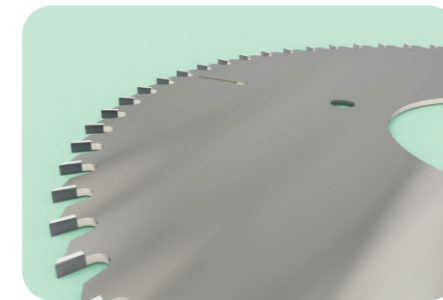


ID No.	$\phi D$	$\phi d$	$\phi d_{Max}$	B	齿数(Z)	齿形 tooth shape	备注 remark
12212001	200	30	60	3.2	36	WZ	
12212002	220	30	60	3.2	36	WZ	
12212003	220	30	60	3.2	64	WZ	
12212004	250	30	80	3.2	48	WZ	
12212005	250	30	80	3.2	60	WZ	
12212006	250	30	80	3.2	80	WZ	
12212007	300	30	80	3.2	60	WZ	
12212008	300	30	80	3.2	72	WZ	
12212009	300	30	80	3.2	96	WZ	
12212010	300	60	80	3.2	48	WZ	
12212011	350	30	100	3.5	60	WZ	
12212012	350	30	100	3.5	72	WZ	
12212013	350	30	100	3.5	84	WZ	
12212014	350	35	100	3.5	108	WZ	
12212015	400	30	100	3.5	84	WZ	
12212016	400	30	100	3.5	96	WZ	
12212017	400	35	100	3.5	120	WZ	
12212018	400	60	100	4.4	84	WZ	

## 1.3 带轴套的平齿PCD锯片 FZ Tooth Shape PCD saw blades with sleeve

适合于各种锯机，对刨花板、中密度板、塑料贴面板、石膏板等的修边。

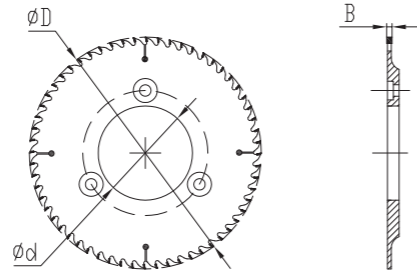
For trimming Chipboard, MDF, Plastic plywood, and Gypsum board on full range of saws.



ID No.	$\phi D$	$\phi d$	B	齿数(Z)	齿形 tooth shape	备注 remark
12213001	180	65	3.5	24	FZ	
12213002	180	65	3.5	36	FZ	
12213003	180	65	3.5	48	FZ	



## 增强机型带轴套的PCD划线锯片 Reinforced PCD scoring saws with sleeve

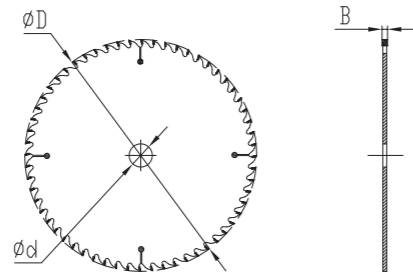


ID No.	ΦD	Φd	B	齿数(Z)	齿形 tooth shape	备注 remark
12213004	180	65	3.5	24	FZ	
12213005	180	65	3.5	36	FZ	
12213006	180	65	3.5	48	FZ	

## 1.4 PCD电子开料锯主锯片 PCD Main Saw blades

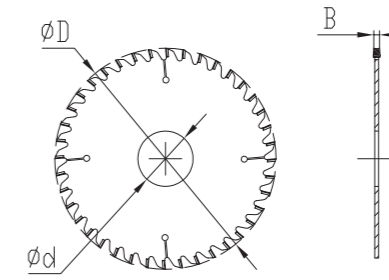
适合电子开料锯, 对刨花板、中密度板、三聚氰胺贴面板、防火板等的单层和多层切断。

Suitable for parting off single and multi-layer Chipboard, MDF, Melamine plywood, and Fire-proof board on CNC cutting saws



ID No.	ΦD	Φd	B	齿数(Z)	齿形 tooth shape	备注 remark
12214001	280	30	3.2	60	FZ/TR	
12214002	300	30	3.2	60	FZ/TR	
12214003	300	30	3.5	60	FZ/TR	
12214004	300	30	4.4	60	FZ/TR	
12214005	300	60	4.4	60	FZ/TR	
12214006	320	50	4.4	60	FZ/TR	其它规格可参照 1.1平梯齿锯片选择 Other specifications could refer to 1.1 FZ/TR Tooth type saw blades for choice
12214007	320	75	4.4	60	FZ/TR	
12214008	350	30	4.4	72	FZ/TR	
12214009	350	60	4.4	72	FZ/TR	
12214010	370	30	4.4	72	FZ/TR	
12214011	400	30	3.5	72	FZ/TR	
12214012	400	30	4.4	72	FZ/TR	
12214013	450	30	4.4	72	FZ/TR	
12214014	450	60	4.8	72	FZ/TR	
12214015	450	30	4.4	84	FZ/TR	
12214016	450	60	4.4	96	FZ/TR	

## 1.5 PCD电子开料锯划线锯片 (配左右梯齿) PCD scoring saw blades

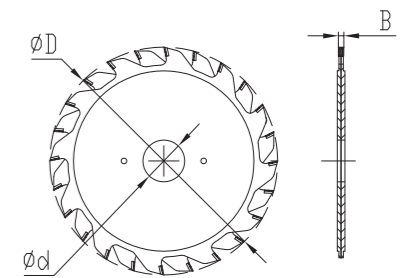


ID No.	ΦD	Φd	B	齿数(Z)	齿形 tooth shape	备注 remark
12215001	125	20	2.8/3.6	12+12	KON/WZ	主锯3.2
12215002	125	22	2.8/3.6	12+12	KON/WZ	..
12215003	125	20	4.3/5.3	24	KON/WZ	主锯4.4
12215004	125	45	4.3/5.3	24	KON/WZ	..
12215005	150	20	4.3/5.3	24	KON/WZ	..
12215006	150	45	4.3/5.3	24	KON/WZ	..
12215007	160	45	4.3/5.3	36	KON/WZ	..
12215008	180	20	4.3/5.3	36	KON/WZ	..
12215009	180	30	4.3/5.3	36	KON/WZ	..
12215010	180	45	4.3/5.3	40	KON/WZ	..
12215011	180	55	4.3/5.3	40	KON/WZ	..
12215012	200	20	4.3/5.3	36	KON/WZ	..
12215013	200	30	4.3/5.3	24	KON/WZ	..
12215014	200	30	4.3/5.3	36	KON/WZ	..
12215015	200	45	4.3/5.3	36	KON/WZ	..
12215016	200	65	4.3/5.3	40	KON/WZ	..
12215017	220	50	4.3/5.3	36	KON/WZ	..
12215018	220	50	4.3/5.3	40	KON/WZ	..

## 1.6 PCD可调节划线锯片(配左齿、右齿) Adjustable PCD scoring saw blades

适用于推台锯, 对刨花板、中密度板、三聚氰胺贴面板、防火板等的划线。

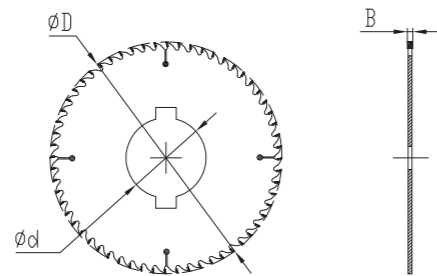
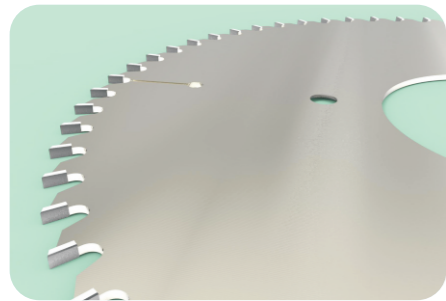
Suitable for scoring Chipboard, MDF, Melamine plywood, and Fire-proof board on stable saws



ID No.	ΦD	Φd	B	齿数(Z)	齿形 tooth shape	备注 remark
12216001	100	20	2.8	10+10	WZ	主锯3.2
12216002	100	22	2.8	10+10	WZ	主锯3.2
12216003	120	20	2.8	12+12	WZ	主锯3.2
12216004	120	22	2.8	12+12	WZ	主锯3.2
12216005	125	20	2.8	12+12	WZ	主锯3.2
12216006	125	22	2.8	12+12	WZ	主锯3.2



## 1.7 PCD多片锯 PCD Multi-blade saws

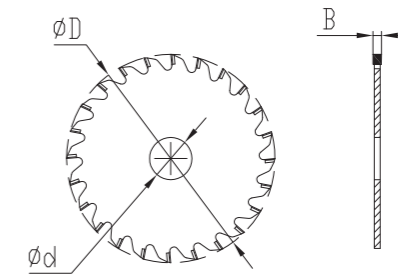


ID No.	ΦD	Φd	B	齿数(Z)	齿形 tooth shape	备注 remark
12217001	210	90	2.2	36	FZ/TR	
12217002	210	90	3.2	36	FZ/TR	
12217003	210	100	2.2	36	FZ/TR	
12217004	210	100	3.2	36	FZ/TR	
12217005	210	115	2.2	36	FZ/TR	
12217006	210	115	3.2	36	FZ/TR	
12217007	210	90	2.2	48	FZ/TR	
12217008	210	90	3.2	48	FZ/TR	
12217009	210	100	2.2	48	FZ/TR	
12217010	210	100	3.2	48	FZ/TR	
12217011	210	115	2.2	48	FZ/TR	
12217012	210	115	3.2	48	FZ/TR	
12217013	250	60	2.2	36	FZ/TR	
12217014	250	60	3.2	36	FZ/TR	
12217015	250	90	2.2	36	FZ/TR	
12217016	250	90	3.2	36	FZ/TR	
12217017	250	100	2.2	36	FZ/TR	
12217018	250	100	3.2	36	FZ/TR	
12217019	250	115	2.2	36	FZ/TR	
12217020	250	115	3.2	36	FZ/TR	
12217021	250	90	2.2	48	FZ/TR	
12217022	250	90	3.2	48	FZ/TR	
12217023	250	100	2.2	48	FZ/TR	
12217024	250	100	3.2	48	FZ/TR	
12217025	250	115	2.2	48	FZ/TR	
12217026	250	115	3.2	48	FZ/TR	

## 1.8 PCD开槽锯片(平齿) PCD grooving saw blades

适用于各种家具的高速开槽。

Suitable for all kinds of furniture of high-speed slotting



ID No.	ΦD	Φd	B	齿数(Z)	齿形 tooth shape	备注 remark
12218001	125	30	3.2	12	FZ	
12218002	125	30	4	12	FZ	
12218003	180	35	4	18	FZ	
12218004	180	35	4	24	FZ	
12218005	180	35	5	18	FZ	
12218006	180	35	5	24	FZ	
12218007	180	35	6	18	FZ	
12218008	180	35	6	24	FZ	
12218009	180	35	8	18	FZ	
12218010	180	35	8	24	FZ	
12218011	220	30	9	24	FZ	
12218012	220	30	9	30	FZ	
12218013	220	30	10	30	FZ	

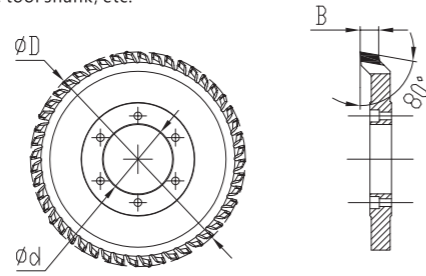
承接非标定制 OEM & ODM service are welcome





## 2.1 80°PCD端面粉碎刀(非均匀齿) 80°teeth PCD End Hogger

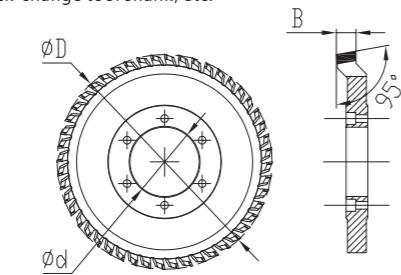
在双端铣及封边机等，加工刨花板、中密度板、塑料贴面板等的粉碎及修边。刀具较重，通常与液压套、法兰盘、快换刀柄等配合使用。  
Suitable for crushing and trimming Chipboard, MDF, Plastic Plywood on the two-sided milling machine and edge banding machine, etc. Tools are heavy, so it is usually applied with hydraulic sleeve, flange, quick-change tool shank, etc.



ID No.	ΦD	Φd	B	齿数(Z)	左旋刀代码 ID No.(left style)	备注 remark
12231001	250	80/60	10	20+7	12231002	
12231003	250	80/60	10	28+7	12231004	
12231005	250	80/60	10	34+7	12231006	
12231007	250	80/60	10	42+7	12231008	
12231009	250	80/60	10	54+9	12231010	
12231011	250	80/60	15	20+7	12231012	
12231013	250	80/60	15	28+7	12231014	
12231015	250	80/60	15	34+7	12231016	
12231017	250	80/60	15	42+7	12231018	
12231019	250	80/60	15	54+9	12231020	

## 2.2 95°PCD端面粉碎刀(非均匀齿) 95°teeth PCD End Hogger

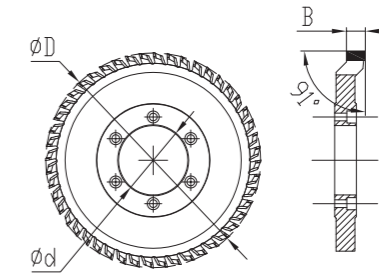
在双端铣及封边机等，加工刨花板、中密度板、塑料贴面板等的粉碎及铣台阶。刀具较重，通常与液压套、法兰盘、快换刀柄等配合使用。  
Suitable for crushing and milling step of Chipboard, MDF, Plastic Plywood on the two-sided milling machine and edge banding machine, etc. Tools are heavy, so it is usually applied with hydraulic sleeve, flange, quick-change tool shank, etc.



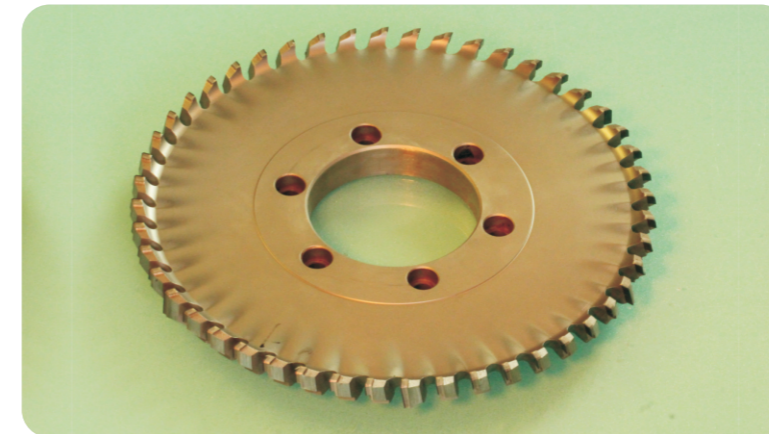
ID No.	ΦD	Φd	B	齿数(Z)	左旋刀代码 ID No.(left style)
12232001	250	80/60	6.5	22+11	12232002
12232003	250	80/60	6.5	28+13	12232004
12232005	250	80/60	6.5	34+17	12232006
12232007	250	80/60	6.5	42+21	12232008
12232009	250	80/60	10	22+11	12232010
12232011	250	80/60	10	28+13	12232012
12232013	250	80/60	10	34+17	12232014
12232015	250	80/60	10	42+21	12232016
12232017	250	80/60	15	22+11	12232018
12232019	250	80/60	15	28+13	12232020
12232021	250	80/60	15	34+17	12232022
12232023	250	80/60	15	42+21	12232024

## 2.3 91°折叠槽PCD粉碎刀 91°folding groove PCD End Hogger

在双端铣及封边机等，加工刨花板、中密度板、塑料贴面板等的粉碎及铣台阶。刀具较重，通常与液压套、法兰盘、快换刀柄等配合使用。  
Suitable for crushing and milling step of Chipboard, MDF, Plastic Plywood on the two-sided milling machine and edge banding machine, etc. Tools are heavy, so it is usually applied with hydraulic sleeve, flange, quick-change tool shank, etc.



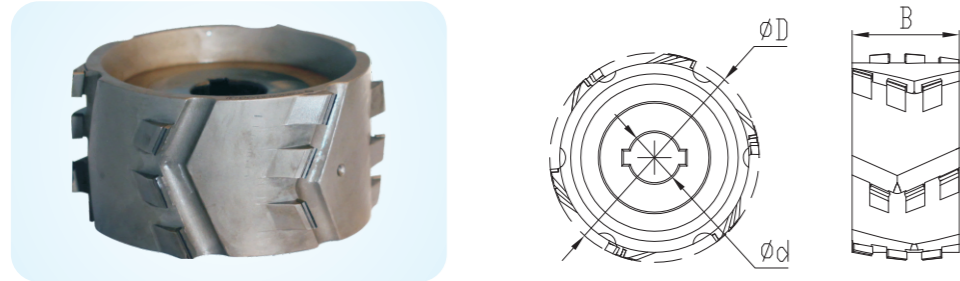
ID No.	ΦD	Φd	B	齿数(Z)
12234001	200	80	15	21 (14+7)
12234002	200	80	15	33 (22+11)
12234003	200	80	25	21 (14+7)
12234004	200	80	25	33 (22+11)
12234005	250	80	15	21 (14+7)
12234006	250	80	15	33 (22+11)
12234007	250	80	25	21 (14+7)
12234008	250	80	25	33 (22+11)



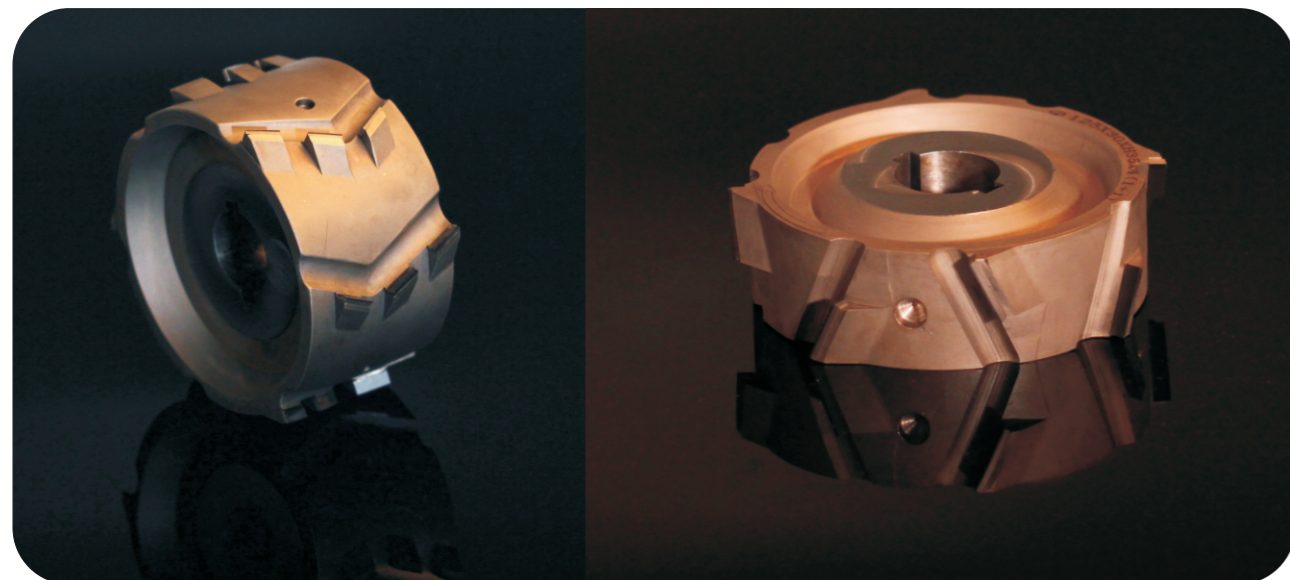


### 3.1 PCD人字形预铣刀 PCD Herring-bone Pre-milling Cutter

在双端铣及封边机等设备，加工三聚氰胺贴面板、刨花板、中密度板、塑料贴面板等的封边前的预成型。  
Suitable for pre-profiling of Melamine board, Chipboard, MDF, and Plastic plywood on two-sided milling machine and edge banding machine



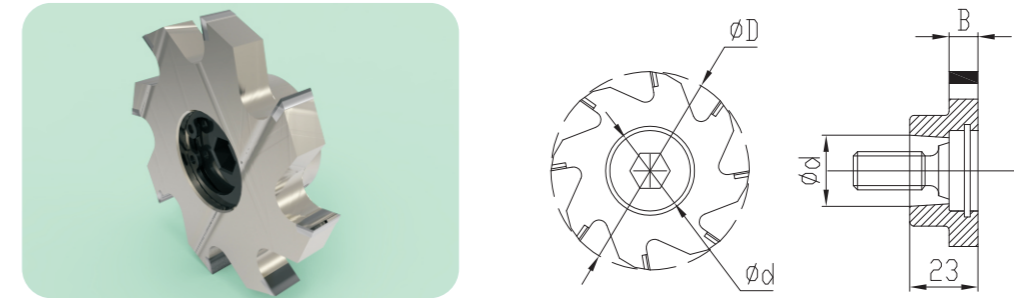
ID No.	$\phi D$	$\phi d$	B	齿数(Z)	左旋刀代码 ID No.(left style)	备注 remark
12241001	80	20	30	3+3	12241002	
12241003	80	20	35	3+3	12241004	
12241005	80	20	50	3* (3+2)	12241006	
12241007	100	30	35	3+3	12241008	
12241009	100	30	45	3* (3+1)	12241010	
12241011	100	30	48	3* (3+2)	12241012	
12241013	100	30	28	3* (1+1)	12241014	
12241015	100	30	34	3* (2+2)	12241016	
12241017	100	30	46	3* (2+2)	12241018	
12241019	100	30	63	3* (2+3)	12241020	
12241021	125	30	34	3* (2+2)	12241022	承接非标定制
12241023	125	30	43	3* (2+2)	12241024	OEM & ODM service
12241025	125	30	63	3* (3+3)	12241026	are welcome
12241027	125	28	30	3* (2+2)	12241028	
12241029	125	34	30	3* (2+2)	12241030	
12241031	125	46	30	3* (2+2)	12241032	
12241033	125	63	30	3* (2+2)	12241034	
12241035	150	30	34	3* (2+2)	12241036	
12241037	150	30	43	3* (2+2)	12241038	
12241039	180	30	63	3* (3+3)	12241040	
12241041	180	35	43	4* (3+1)	12241042	
12241043	180	35	63	4* (5+1)	12241044	
12241045	180	60	34	6* (2+2)	12241046	
12241047	180	60	34	12* (2+2)	12241048	
12241049	180	60	56	6* (3+3)	12241050	



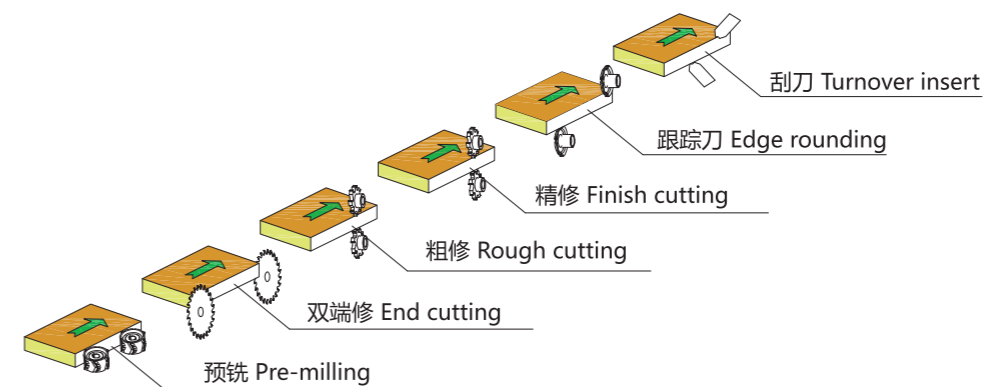
### 3.2 PCD粗修刀 PCD Rough Trimming Cutter

用于HOMAG、IMA封边机，对实木、板材的封边条的粗修和倒角。  
Applied in roughing trimming and chamfering Solid wood as well as Edge plate on HOMAG and IMA edge banding machine

#### 3.2.1 带螺钉的PCD粗修刀 PCD Rough Cutter with screw

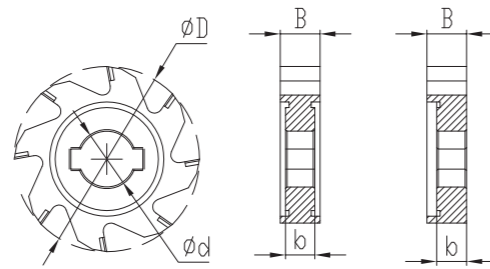
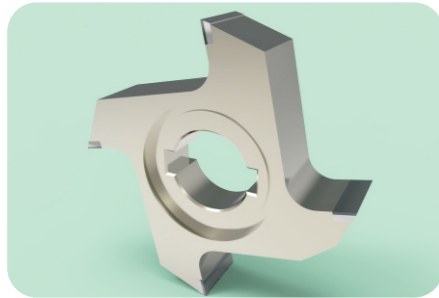


ID No.	$\phi D$	$\phi d$	B	齿数(Z)	备注 remark
12242001	50	HSK25R	5	4	
12242002	61	HSK25R	5	4	
12242003	70	HSK25R	7	4	
12242004	70	HSK25R	7	4	
12242005	70	HSK25R	8	4	
12242006	70	HSK25R	14	6	
12242007	70	HSK25R	15	4	
12242008	70	HSK25R	23	4	配HSK25柄 Mounting on HSK25 toolholder
12242009	70	HSK25R	25	4	
12242010	70	HSK25R	35	4	

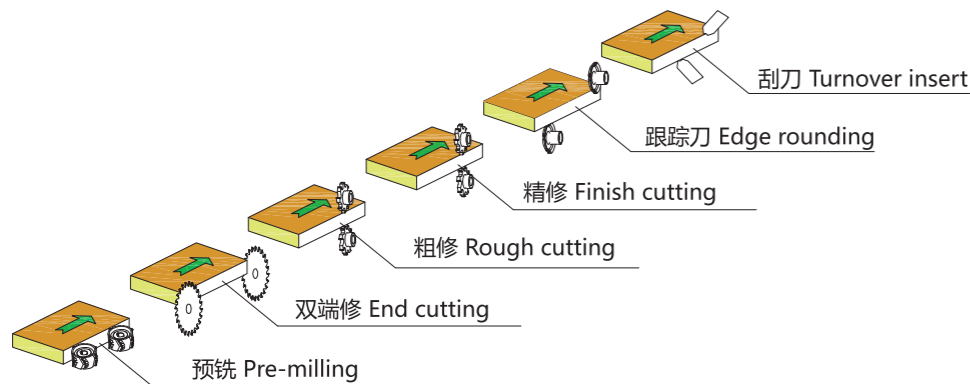




### 3.2.2 0°PCD粗修刀 0°PCD Rough Trimming Cutter

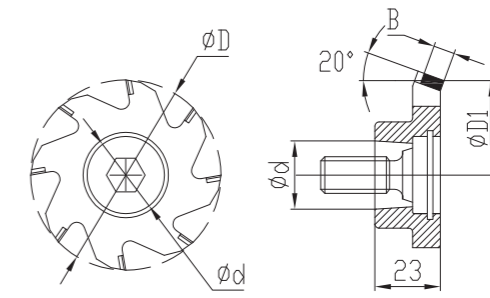
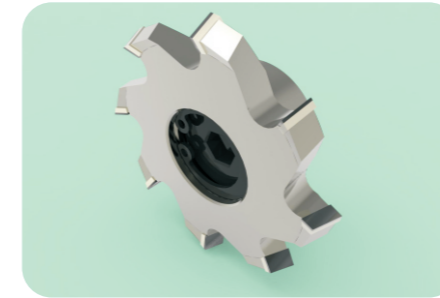


ID No.	ΦD	Φd	B	齿数(Z)	备注 remark
12242011	50	16	5	4	配HSK25柄 Mounting on HSK25 toolholder
12242012	50	16	12	4	
12242013	61	16	5	4	
12242014	61	16	12	4	
12242015	70	16	7	4	
12242016	70	20	7	4	
12242017	70	20	8	4	
12242018	70	20	14	6	
12242019	70	20	20	4	
12242020	70	20	20	6	
12242021	70	20	15	4	
12242022	70	20	23	4	
12242023	70	20	25	4	
12242024	70	20	35	4	

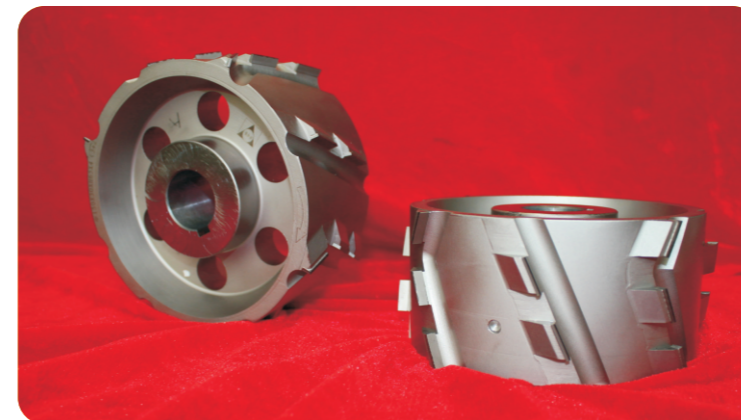
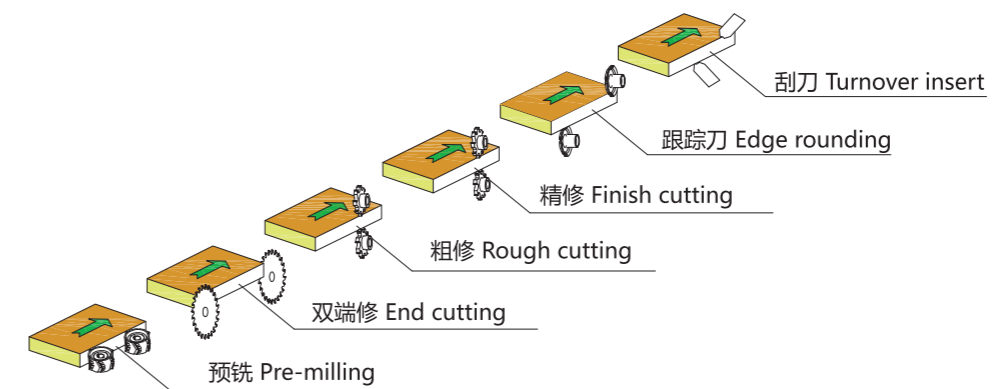


### 3.2.3 20°PCD粗修刀 20°PCD Rough Trimming Cutter

用于封边机，对实木、板材的封边条的精修和倒R。  
Applied in finish trimming and chamfering Solid wood as well as Edge plate on the edge banding machine



ID No.	ΦD	Φd	B	齿数(Z)	左旋刀代码 ID No. (left style)
12242025	62	16	5	4	12242026
12242027	62	16	5	4	12242028
12242029	72	20	6	4	12242030
12242031	72	20	8	4	12242032
12242033	72	配HSK25柄 Mounting on HSK25 toolholder	6	4	12242034
12242035	72	配HSK25柄 Mounting on HSK25 toolholder	6	4	12242036
12242037	72	配HSK25柄 Mounting on HSK25 toolholder	6	4	12242038
12242039	62	31.5	5	4	12242040
12242041	62	31.5	5	6	12242042
12242043	62	31.5	5	8	12242044

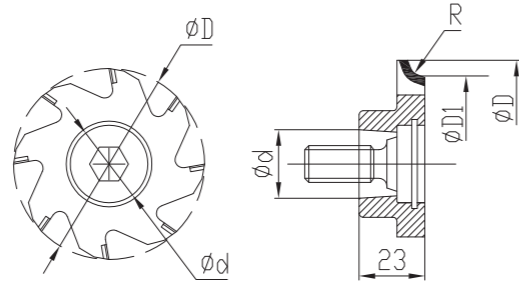




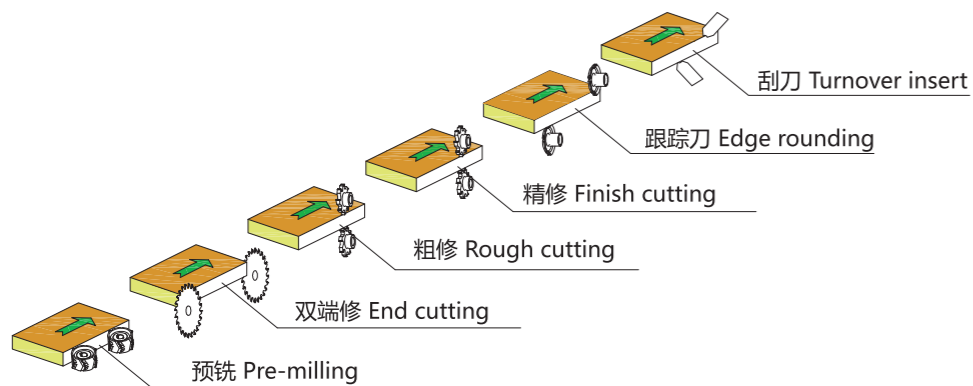
## 3.3 PCD精修刀 PCD Finish Trimming Cutter

### 3.3.1 精修及倒R成型PCD刀 PCD Finish Cutter and Chamfering Radius Cutter

用于封边机，对实木、板材的封边条的精修和倒R。  
Suitable for finishing and chamfering Solid wood as well as Edge plate on the Edge banding machine

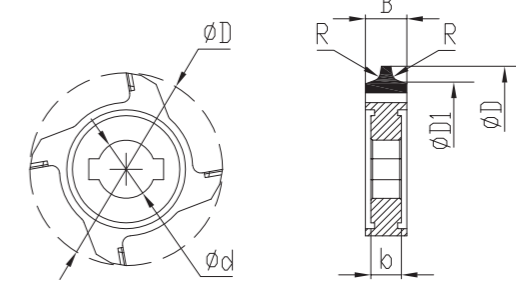
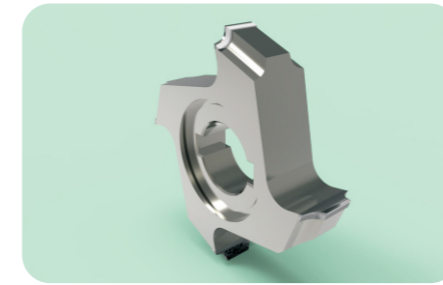


ID No.	$\Phi D$	$\Phi d$	R	左旋刀代码 ID No.(left style)
12243001	75	配HSK25柄 Mounting on HSK25 toolholder	1.0	12243002
12243003	75	..	1.5	12243004
12243005	75	..	2.0	12243006
12243007	75	..	2.0	12243008
12243009	75	..	2.5	12243010
12243011	75	..	2.5	12243012
12243013	75	..	3.0	12243014
12243015	75	..	3.0	12243016
12243017	75	..	3.5	12243018
12243019	75	..	3.5	12243020
12243021	75	..	4.0	12243022
12243023	75	..	4.0	12243024
12243025	75	..	4.5	12243026
12243027	75	..	4.5	12243028
12243029	75	..	5.0	12243030
12243031	75	..	5.5	12243032

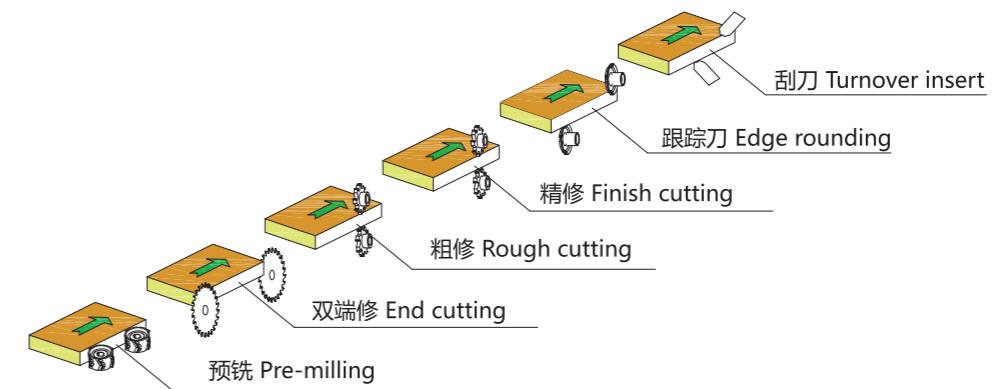


## 3.3.2 精修及倒R成型PCD刀 PCD Finishing and Chamfering Radius Cutter

用于封边机，对实木、板材的封边条的精修和倒R。  
Suitable for finishing and chamfering Solid wood as well as Edge plate on the Edge banding machine



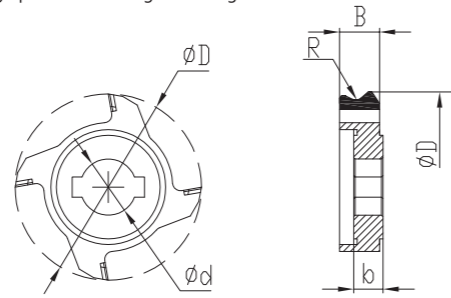
ID No.	$\Phi D$	$\Phi d$	B	$\Phi d$	R	齿数(Z)	左旋刀代码 ID No.(left style)
12243033	57	50	12	16	2.0	4	12243034
12243035	57	50	12	16	3.0	4	12243036
12243037	58	50	12	16	2.0	4	12243038
12243039	58	50	12	16	2.0	4	12243040
12243041	62	50	16	16	2.0	4	12243042
12243043	62	50	16	16	2.0	4	12243044
12243045	73	50	16	16	2.0	4	12243046
12243047	73	50	16	16	2.0	4	12243048
12243049	80	70	16	20	2.0	4	12243050
12243051	80	70	16	20	3.0	4	12243052
12243053	82	70	16	20	2.0	4	12243054
12243055	82	70	16	20	3.0	4	12243056



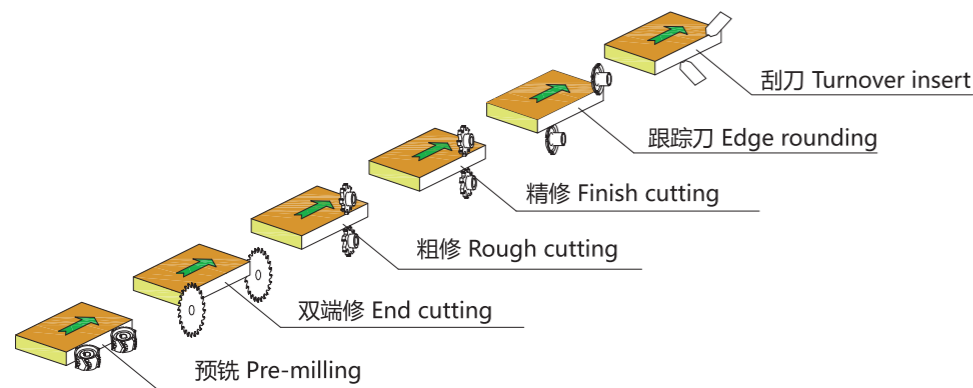


### 3.3.3 精修PCD刀 PCD Finishing Cutter

用于封边机，对实木、板材的封边条的精修和倒R。  
Suitable for finishing and chamfering Solid wood as well as Edge plate on the Edge banding machine



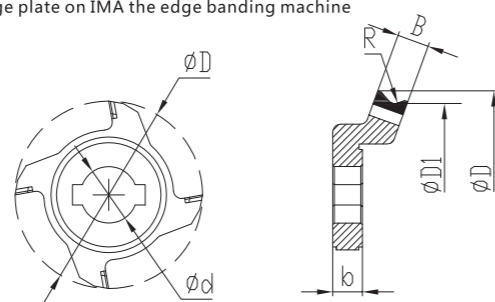
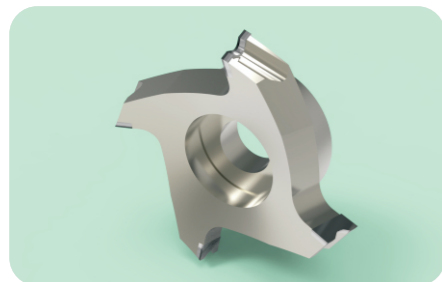
ID No.	$\Phi D$	B	$\Phi d$	R	齿数(Z)	左旋刀代码 ID No.(left style)
12243057	75	16	20	1.5	4	12243058
12243059	75	16	20	2.0	4	12243060
12243061	75	16	20	2.5	4	12243062
12243063	75	16	20	3.0	4	12243062



### 3.4 PCD跟踪刀 PCD Edge Rounding Cutter

#### 3.4.1 PCD倒R成型刀 PCD Chamfering Cutter

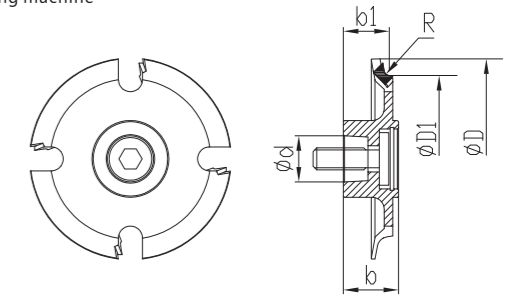
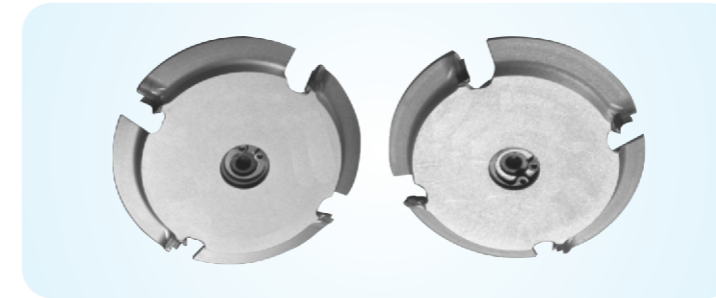
用于IMA封边机，对实木、板材的封边条的精修和倒R。  
Suitable for finishing and chamfering Solid wood as well as Edge plate on IMA the edge banding machine



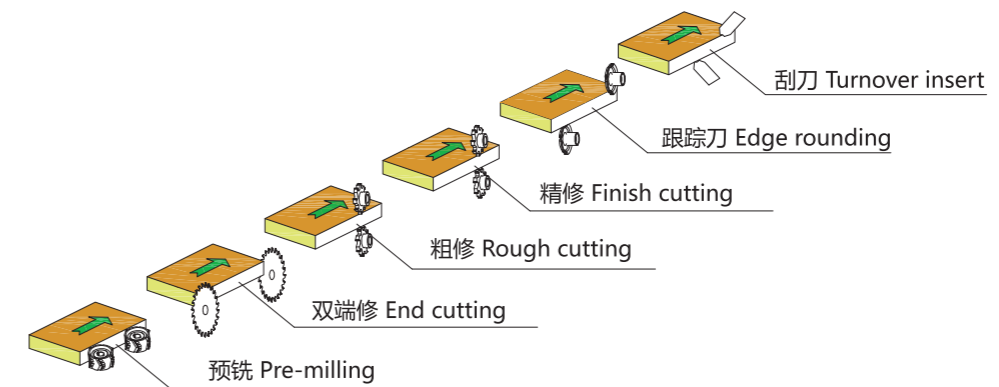
ID No.	$\Phi D$	$\Phi D1$	B	$\Phi d$	R	齿数(Z)	左旋刀代码 ID No.(left style)
12244001	77.6	70	13	20	2.0	4	12244002
12244003	77.6	70	13	20	3.0	4	12244004
12244005	77.6	70	13	20	4.0	4	12244006

### 3.4.2 PCD跟踪刀 PCD Edge Rounding Cutter

用于Homag封边机，对实木、板材的封边条的精修和倒R。  
Suitable for finishing and chamfering Solid wood as well as Edge plate on HOMAG edge banding machine



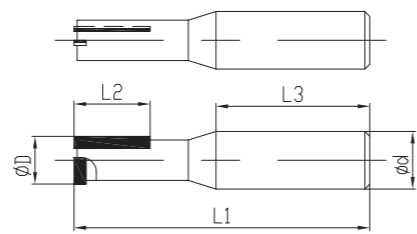
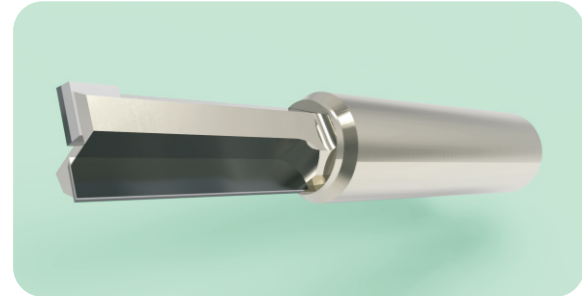
ID No.	$\Phi D$	$\Phi D1$	b1	$\Phi d$	R	齿数(Z)	备注 remark
12244007	74	62	31.5	HSK32	1.0	4	左右为一套 left+right=a set
12244009	74	62	31.5	HSK32	1.5	4	
12244011	74	62	31.5	HSK32	2.0	4	
12244013	74	62	31.5	HSK32	2.5	4	
12244015	74	62	31.5	HSK32	3.0	4	
12244017	74	62	31.5	HSK32	1.0	6	
12244019	74	62	31.5	HSK32	1.5	6	
12244021	74	62	31.5	HSK32	2.0	6	
12244023	74	62	31.5	HSK32	2.5	6	
12244025	74	62	31.5	HSK32	3.0	6	



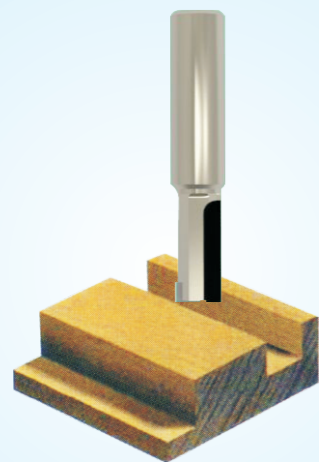


## 4.1 PCD直刃铣刀Z=1 PCD Straight Router Cutter Z=1

适用于CNC铣镗机上，对刨花板、中密度板、实木、贴面板等材料的开槽修边加工，扩孔或铣台阶。  
Suitable for grooving, trimming, reaming and milling step of Chipboard, MDF, Solid wood and Veneer on CNC router

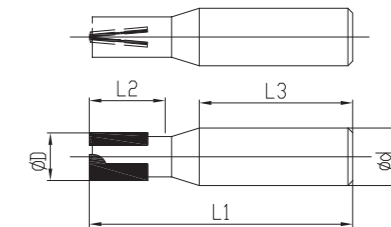
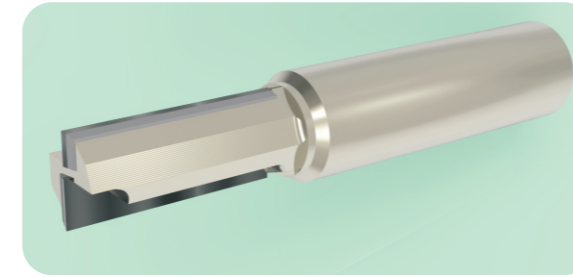


ID No.	ΦD	L2	Φd	L3	L1	齿数(Z)	最大转速 Max. RPM	左旋刀代码 ID No.(left style)
12251001	5	12	12/12.7	40	60	1	30000	12251002
12251003	6	12	12/12.7	40	60	1	30000	12251004
12251005	8	12	12	35	60	1	30000	12251006
12251007	8	12	12	40	60	2	30000	12251008
12251009	10	22	12	35	70	2	30000	12251010
12251011	12	25.4	12	35	70	2	24000	12251012
12251013	16	25.4	16	45	85	1	24000	12251014
12251015	16	35	16	45	95	1	24000	12251016
	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	



## 4.2 PCD直刃铣刀Z=2 PCD Straight Router Cutter Z=2

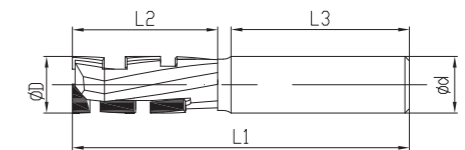
固定铣镗设备的直刃柄铣刀  
Straight router cutter for fixed routing machine



ID No.	ΦD	L2	Φd	L3	L1	齿数(Z)	左旋刀代码 ID No.(left style)
12252001	16	20	20	50	80	1+1	12252002
	[mm]	[mm]	[mm]	[mm]	[mm]		

## 4.3 PCD螺旋刃柄铣刀Z=1+1 PCD Spiral Router Cutter Z=1+1

该刀具具有1+1个螺旋容屑槽，适用于CNC铣镗机上，对刨花板、中密度板、实木、贴面板等材料的开槽修边加工（可以垂直进刀）。  
It has 1+1 spiral cutting edge, so it's ideal for grooving and sizing Chipboard, MDF, Solid wood and Veneer on CNC router (Vertical feed is available)

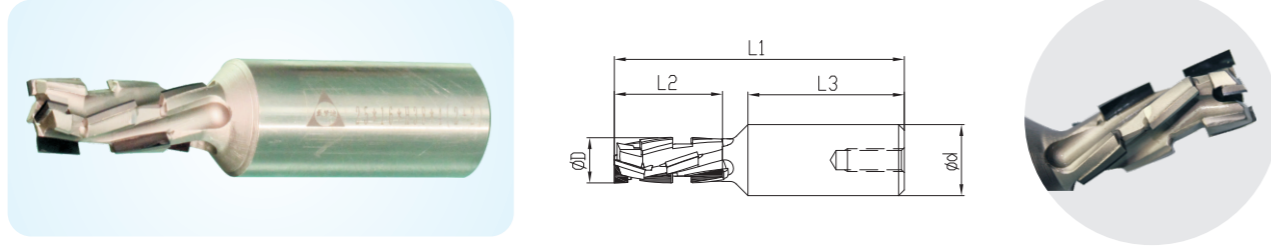


ID No.	ΦD	Φd	L2	L1	容屑槽 flute	齿数(Z)
12253001	12	16	24	90	1+1	4
12253002	14	16	28	90	1+1	4
12253003	14	20	28	90	1+1	4
12253004	16	16	28	90	1+1	4
12253005	16	20	28	90	1+1	4
12253006	18	16	38	100	1+1	6
12253007	18	16	48	110	1+1	6
12253008	18	20	48	110	1+1	6
12253009	20	16	28	90	1+1	6
12253010	20	16	38	100	1+1	6
12253011	20	20	48	110	1+1	6
12253012	20	25	20	90	1+1	6
12253013	20	25	28	100	1+1	6
12253014	20	25	38	110	1+1	6
12253015	20	25	48	120	1+1	6
12253016	20	25	58	130	1+1	6



## 4.4 PCD 螺旋刃柄铣刀 Z=2+2 PCD Spiral Router Cutter Z=2+2

该刀具具有2+2个螺旋容削槽，适用于CNC铣铣机上，对刨花板、中密度板、实木、贴面板等材料的开槽修边加工（可以垂直进刀）。  
It has 2+2 spiral cutting edge, so it's ideal for grooving and sizing Chipboard, MDF, Solid wood and Veneer on CNC router (Vertical feed is available)

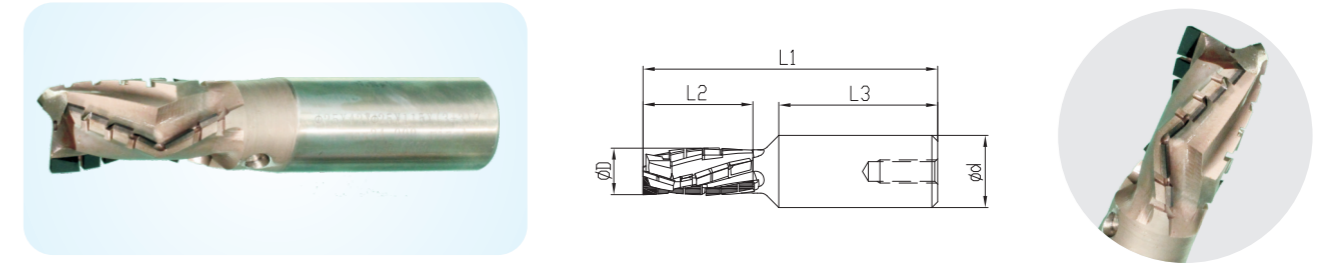


ID No.	ΦD	Φd	L2	L1	容屑槽 flute	备注 remark
12254001	20	20	28	90	2+2	承接非标定制 OEM & ODM service are welcome
12254002	20	20	38	100	2+2	
12254003	20	20	48	110	2+2	
12254004	20	25	28	90	2+2	
12254005	20	25	38	100	2+2	
12254006	20	25	48	110	2+2	
12254007	25	20	28	90	2+2	
12254008	25	20	38	100	2+2	
12254009	25	20	48	110	2+2	
12254010	25	25	28	90	2+2	
12254011	25	25	38	100	2+2	
12254012	25	25	48	110	2+2	



## 4.5 PCD 螺旋刃柄铣刀 Z=3+3 PCD Spiral Router Cutter Z=3+3

该刀具具有3+3个正、负的螺旋角容削槽，螺旋刃搭接在刀具尖端，适用于CNC铣铣机上，对刨花板、中密度板、实木、贴面板等材料的开槽、修边加工（可以垂直进刀）。  
It has 3+3 spiral cutting edge, so it's ideal for grooving and sizing Chipboard, MDF, Solid wood and Veneer on CNC router (Vertical feed is available)



ID No.	ΦD	Φd	L2	L1	容屑槽 flute	备注 remark
12255001	16	20	24	100	3+3	承接非标定制 OEM & ODM service are welcome
12255002	20	20	24	90	3+3	
12255003	20	20	30	95	3+3	
12255004	20	20	46	110	3+3	
12255005	25	20	24	90	3+3	
12255006	25	20	30	95	3+3	
12255007	25	20	46	110	3+3	
12255008	18	25	24	100	3+3	
12255009	18	25	30	110	3+3	
12255010	20	25	24	100	3+3	
12255011	20	25	30	105	3+3	
12255012	20	25	38	110	3+3	
12255013	20	25	46	120	3+3	
12255014	25	25	24	100	3+3	
12255015	25	25	30	105	3+3	
12255016	25	25	38	110	3+3	
12255017	25	25	46	120	3+3	



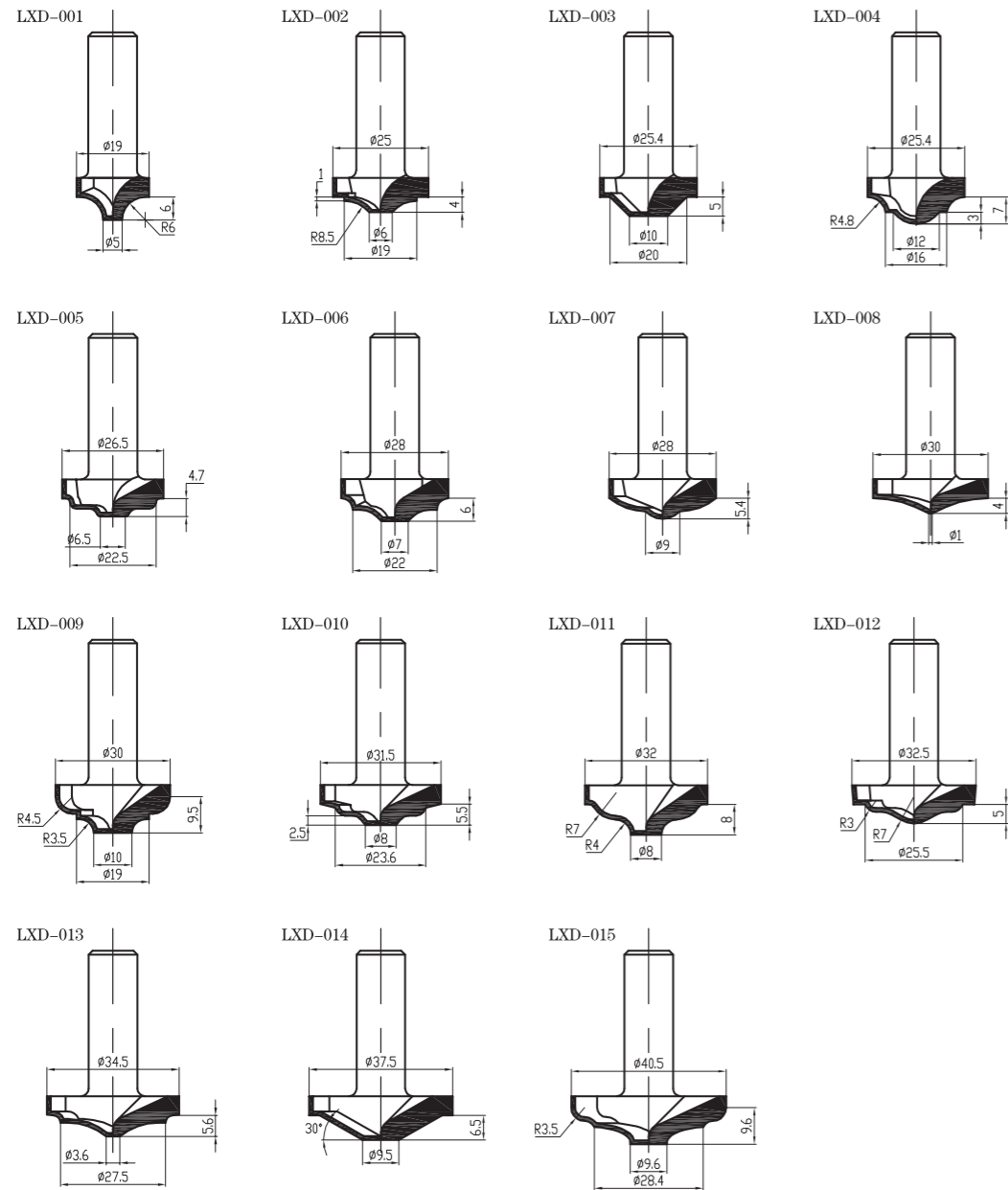


## 5.1 PCD成型铣铣刀 PCD Profiling Router Bit

橱柜门、衣柜门、实木门、及其他板材表面的成形铣削。用于CNC铣铣机上，适用与刨花板、中密度板、纤维板及实木的成形加工。  
Applied in profiling milling surface of cabinet door, wardrobe door, solid wood door and other boards, The Bit is suitable for profiling cutting of Chipboard, MDF, Fibre board and Solid wood on CNC router.



### PCD各种铣铣刀图样 PCD Router cutter specification

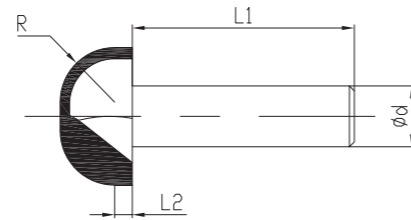
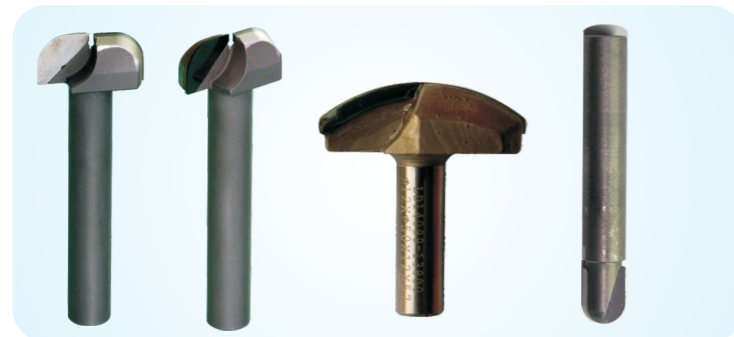


ID No.	ΦD	Φd	H	齿数(Z)	规格 specification
12261001	19	12.7/12	6	2	LXD-001
12261002	25	12.7/12	4	2	LXD-002
12261003	25.4	12.7/12	5	2	LXD-003
12261004	25.4	12.7/12	7	2	LXD-004
12261005	26.5	12.7/12	4.7	2	LXD-005
12261006	28	12.7/12	6	2	LXD-006
12261007	28	12.7/12	5.4	2	LXD-007
12261008	30	12.7/12	4	2	LXD-008
12261009	30	12.7/12	9.5	2	LXD-009
12261010	31.5	12.7/12	5.5	2	LXD-010
12261011	32	12.7/12	8	2	LXD-011
12261012	32.5	12.7/12	5	2	LXD-012
12261013	34.5	12.7/12	5.6	2	LXD-013
12261014	37.5	12.7/12	6.5	2	LXD-014
12261015	40.5	12.7/12	9.6	2	LXD-015
非标订制 Special Custom-made					LXD-□□□





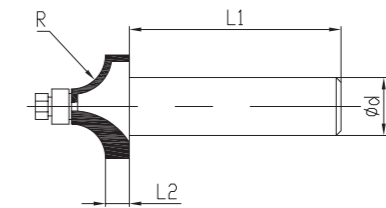
## 5.2 PCD圆底刀 PCD Core Box Router Bit



ID No.	R	L1	L2	Φd	齿数(Z)	备注 remark
12262001	3.17	38	3	12.7/12	2	承接非标定制 OEM & ODM service are welcome
12262002	6.35	38	3	12.7/12	2	
12262003	9.52	38	3	12.7/12	2	
12262004	12.7	38/75	3	12.7/12	2	

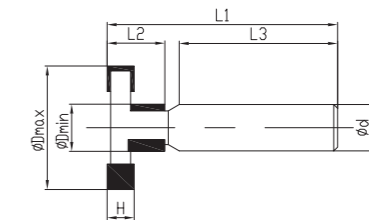


## 5.3 PCD圆弧刀 PCD Corner Round Router Bit



ID No.	R	L1	L2	Φd	齿数(Z)	备注 remark
12263001	4.76	38	3	12.7/12	2	承接非标定制 OEM & ODM service are welcome
12263002	6.35	38	3	12.7/12	2	
12263003	9.52	38	3	12.7/12	2	
12263004	12.7	38	3	12.7/12	2	

## 5.4 PCD T型槽铣刀 PCD T-slot Router Bit



ID No.	Dmax	Dmin	L2	L3	Φd	齿数(Z)
12264001	Φ24.7	Φ12.7	26	38	12.7/12	2+2
12264002	Φ35	Φ10	22	38	12.7/12	2+2

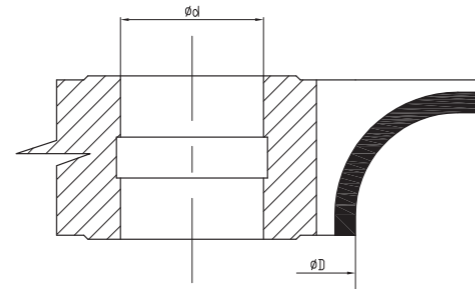
承接非标定制OEM & ODM service are welcome



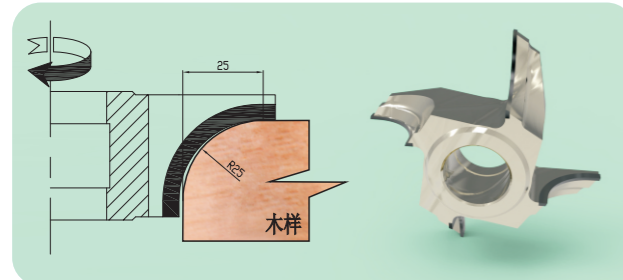
## 6.1 PCD 线刀(成型盘铣刀) PCD Profile Cutter

PCD线刀(成型盘铣刀), 适用于立轴铣或专用带轴数控铣, 以加工各种形状线材及轮廓而得名。例如桌子板刀、茶几板刀、板凳板刀、木桶刀等等, PCD线刀以其高速、高精度、优秀的表面质量、长刀具寿命而著称, 在越来越多的家具企业取代了传统的硬质合金刀具。

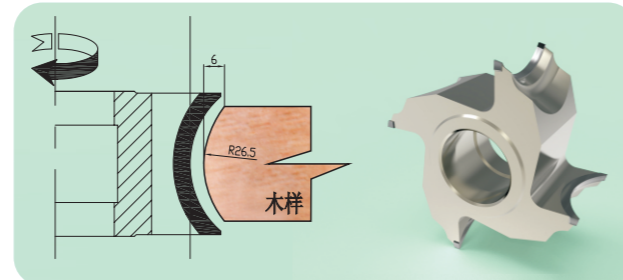
PCD Profile Cutter is suitable for various line shapes and profiling on the vertical axis milling or CNC milling machine with axis. It can be used as table plate knife, coffee table plate knife, knife bench plate, knife and etc. PCD profilecutter is well known as its high speed, high precision, superior surface quality and long tool life, and it replaces conventional carbide tools in more and more furniture manufacturers.



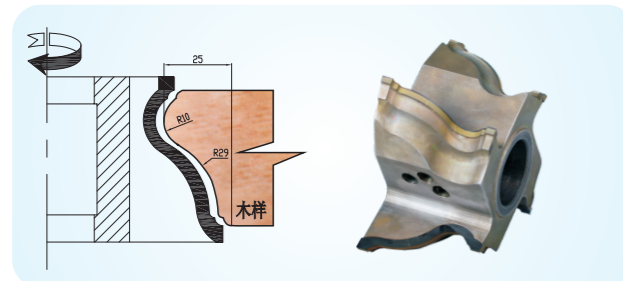
PXD-001



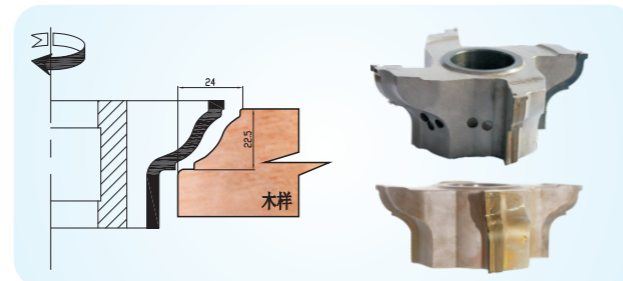
PXD-002



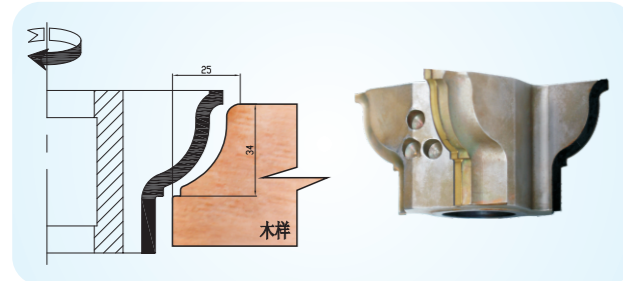
PXD-003



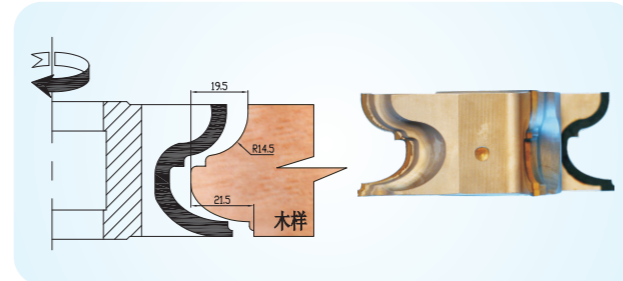
PXD-004



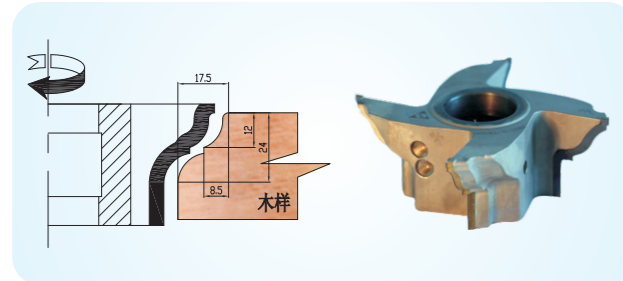
PXD-005



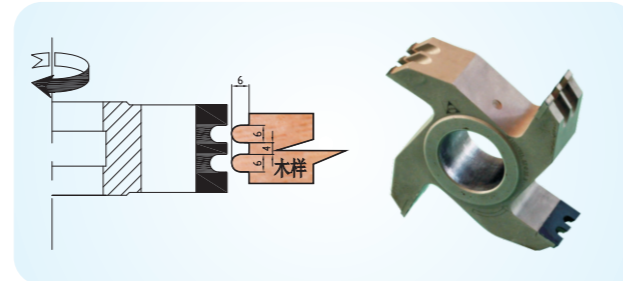
PXD-006



PXD-007



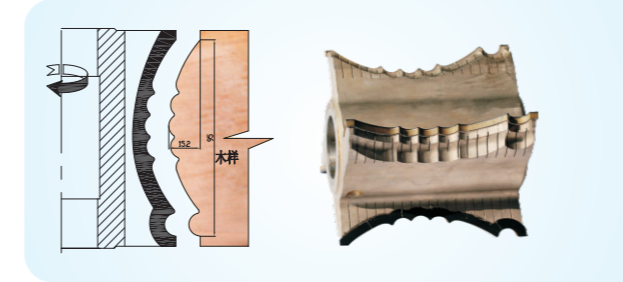
PXD-008



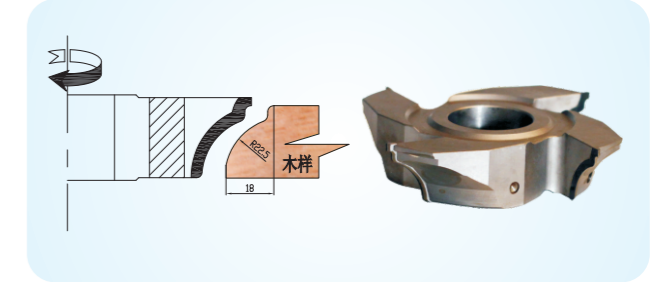
PXD-009



PXD-010



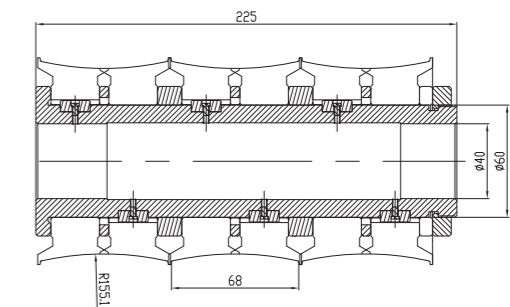
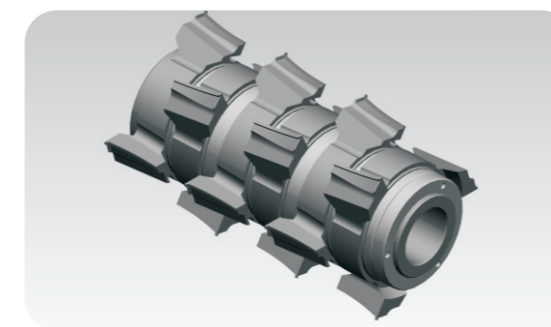
PXD-011



ID No.	$\phi d$	齿数(Z)	规格 specification
12271001	35/40	4	PXD-001
12271002	35/40	4	PXD-002
12271003	35/40	4	PXD-003
12271004	35/40	4	PXD-004
12271005	35/40	4	PXD-005
12271006	35/40	4	PXD-006
12271007	35/40	4	PXD-007
12271008	35/40	4	PXD-008
12271009	35/40	4	PXD-009
12271010	35/40	4	PXD-010
12271011	35/40	4	PXD-011
非标订制			PXD-□□□

## 6.2 PCD 组合线刀 PCD Combination Profiling cutter

PCD成型组合盘铣刀(线刀), 适用于立轴铣或专用带轴数控铣, 以加工各种较大形状线材及轮廓而得名。例如立柱刀、大型线条刀等等。PCD profile combination facing cutter (profiling cutter) is suitable for the vertical axis milling or CNC milling machine with axis, and it is well known as processing various large shape line wood. For example: Column cutter, large line cutter, etc.





## 7.1 PCD 铣刀切削参数 PCD Milling Cutter Cutting Parameter

### 7.1.1 切削速度 Cutting Speed

$$V = \pi ND / 1000$$

V: 切削速度 (米/分), V/60 (米/秒)

V: cutting speed (M/min), V/60 (M/s)

$\pi$ : 圆周率 (3.1416)

N: 转速 (转/分)

N: RPM (rev./min)

D: 刀具直径 (毫米)

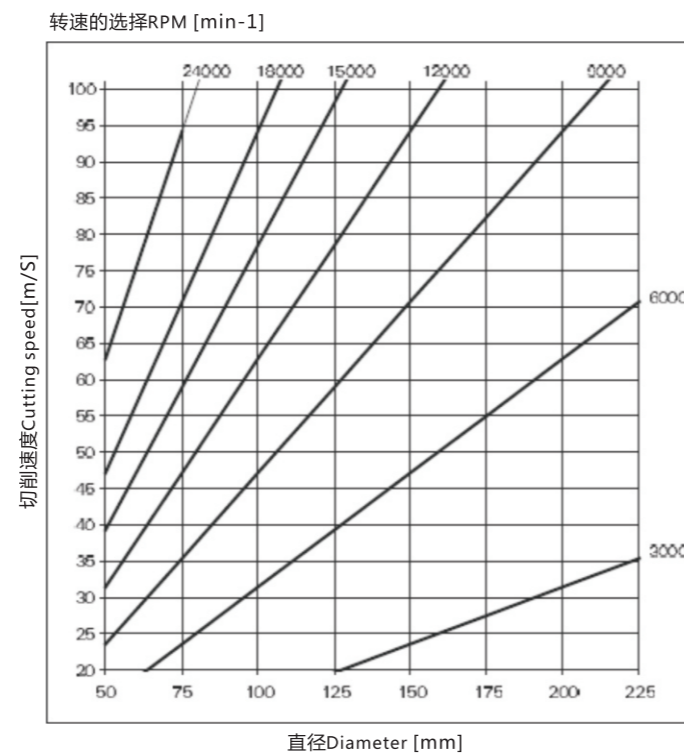
D: diameter of tool (mm)

1. 切削速度的选择原则:

工件表面质量要求越高, 切削速度 (转速) 选择越高。

The Selection principle of Cutting speed:

The higher surface Finish of work-piece required,  
The higher cutting speed have to choose.



### 7.1.2 走刀量 (mm/min) (mm/edge) Feed Rate (mm/rev)

$$F = f \times \text{齿数} \quad F = f / \text{No. of teeth}$$

机床走刀量 (毫米/转) (mm/rev) f Feed rate of lathe (mm/rev)

每齿进给速度 Tooth feed rate fz 推荐表 Recommended Table

铣削 Milling

工件材料 Workpiece Material	每齿进给速度 fz [mm] Tooth Feed rate Fz (mm)	工件表面质量 Work piece surface finish
实木顺纹 Solid wood along grain	0,60-0,80	降低Fz, 可提高工件表面质量 reduce Fz, can improve work piece surface quality.
实木横纹 Solid Wood across grain	0,30-0,40	
木质多层板 Wood Multi-layer board	0,40-0,50	
素板 Unpainted board	0,50,0,70	
层积板 Laminated board	0,20-0,40	
胶合镶木皮板 Wood veneer board	0,10-0,15	

### 7.1.3 切削深度 Cutting Depth

PCD木工刀具的切削深度一般选择一次切削成型。

For PCD woodworking tool, it usually chooses the cutting depth that enables shaping by one pass.



## 7.2 PCD木工刀的修磨 The Resharpener of PCD Woodworking tools

PCD家具刀是一种高速、高精度、高寿命加工刀具, 其使用寿命可达硬质合金家具刀的几-几十倍, 其刀具寿命是在加工工件表面粗糙度变差时, 此时PCD家具刀具需要修磨, PCD家具刀具的修磨只能送到制造厂家修磨。一般修磨余量为0.1-0.5mm。

PCD Furniture Tools is a high speed, high precision and Long life processing tool. The service life is several tens of times longer than Carbide Furniture tools. It should be resharpened when the work-piece surface roughness turns bad, so the user should send the tools back to the manufacturer. The regrinding allowance is usually between 0.1mm-0.5mm.

