



普通线精修刀 finish trimming blades for normal production line

高速线精修刀 finish trimming blades for high speed production line

高速线扣型刀 Buckle profile blades for high speed production line

多片锯 Multi-disc saw

圆锯片 circular saw blades

普通线扣型刀 buckle profile for normal production line

镂铣刀 router bit for woodworking

液压涨紧套 Hydraulic pressure rise

平刀类 Face turning tools

成都工具研究所超硬工具部生产的金刚石（PCD）木工刀具，广泛应用于：人造密度板、强化木地板、实木及实木叠压板、竹地板、木塑地板及发热地板，以及电子线路板行业。主要品种有：金刚石（PCD）榫型刀、预铣刀、精修刀、倒角刀、锁扣成型刀、镂铣刀、线条刀、门框刀、修边刀以及各种规格的金金刚石（PCD）圆锯片。

Diamond (PCD) woodworking tools are widely used in: artificial density board, strengthen wood floor, solid wood and Laminated solid wood floor, bamboo floor, Wood plastic floor and heating floor, and the electronic circuit board industry. The main varieties are: Diamond (PCD) tenon cutter, pre-milling cutting tool, finishing

cutter, chamfer cutter, profile cutter for lock catch, router cutter, line cutter, door frame cutter, trimming cutter and various specifications of diamond (PCD) round saw blades.

专业的设计及加工系统，完善的检测及售后服务体系，使我们的刀具质量得到有效的保障，给您的产品带来质的飞跃！

Professional design for cutting tool, perfect processing and testing system, and complete customer service system provide ensure with the quality of our cutting tools and your products.

产品主要特点：

Advantage of products:

刀具加工精度高：精修刀圆跳动 $\leq 0.02\text{mm}$ ，榫型刀廓形精度 $\leq 0.02\text{mm}$ 。刀具整体优化设计并经过高精度动平衡校验，工作时切削轻快噪音小。

Cutting tool in high machining precision: finishing cutter circle run-out $\leq 0.02\text{mm}$, tenon profile accuracy $\leq 0.02\text{mm}$. Tool is overall optimize designed and is tested by high precision dynamic balance checking. They are easy cutting with low noise.

依据客户要求定制。经过大量的试验和用户长时间的使用分析，建立了自己的切削角度和切削参数最优化设计体系。可以针对不同刀具，不同被加工材料、不同机床，设计并选用最佳刀具配置方案、切削角度、切削参数。

Customization: Through large numbers of testing and analysis from customers, the optimize designed system is settled according to supportable cutting angle and cutting parameters. We provide cutting configuration scheme, cutting angle and cutting parameters according to different cutters, processing materials, different machine and drawing design.

刀具耐用度高，寿命更长。金刚石（PCD）刀具的原材料均采用国外著名公司的金刚石（PCD）原片。刀具加工采用国际最新金刚石（PCD）刀具加工工艺路线和高精度的专用加工设备。

High durability and long service life: the raw materials of PCD cutter are imported from famous foreign diamond (PCD) companies. Tooling processing use the latest international diamond (PCD) processing technology and high precision special processing equipment.

适用范围广。迄今为止，我们的产品不但在德国豪迈、威力等国外进口高档机床上使用,也广泛应用于豪凯、豪井、赫思迈、三星、福马等国内主流机床。从走板速度 30~60m/min 的普通 8 轴机床，到走板速度达到 80~120m/min 的 10、12 轴高速开槽线，都能为您生产出优质的产品。

Wide range of application: CTRI PCD cutting tool is good adaptability not only to foreign machine, namely HOMAG and WEINIG in Germany, but also to mainstream domestic machines, such as Hogae, Hao Jing, Mai Heth, Samsung, Foma, etc. CTRI PCD cutting tool will help you to produce quality products in different processing condition.

品种规格齐全

有强化木地板高速开槽线、实木及叠压实木地板、竹地板、木塑地板及发热地板等系列金刚石(PCD)锁扣成型刀具。规格从 ϕ 125mm~ ϕ 285mm, 齿数从 6Z~68Z。有单片锯、多片锯、单多片上下无缝锯、划线锯、刨花板、电子线路板专用裁切锯片。规格从 ϕ 125mm~ ϕ 350mm, 齿数从 24Z~108Z。

同时我们还能根据用户特殊要求定制各种金刚石（PCD）铣铣刀、线型刀、修边刀、门框刀。

Complete specifications:

There are a series of PCD locking profile cutting tools for high-speed slotted line, enhanced wood floor, solid wood, laminated solid wood floor, bamboo floor, wood-plastic floor and heating floor, etc. Specifications: ϕ 125mm~ ϕ 285mm, tooth numbers: 6Z~68Z.

There are single-chip saw, multiple-chip saw, single and multiple-chip seamless saw, marking saw, chipboard, and Printed Circuit Board special cutting tool. Specifications : ϕ 125mm~ ϕ 350mm, tooth numbers :24Z~108Z.

As well as we provide PCD router cutter, profile cutter, trimming cutter and door frame cutter according to the special requirements of users.

刀具使用说明：PCD cutting tool instructions

由于金刚石刀具硬度高，在安装刀具时，保证刀具刃口不要被异物撞伤。

PCD cutter is high hardness. Be sure cutting edge not injured when installation.

根据每一把刀的功能，在每一根轴安装相对应的刀具，同时保证旋向正确，锁紧紧固螺母，保证安全。对于加装液压涨紧轴套的刀具，应先用液压涨紧刀具，然后再锁紧紧固螺钉，以保证孔轴同心。

PCD cutter need to install on each axis according to cutter's function, ensuring spin direction right and locking fastening nut for safety. For the cutter, installed hydraulic tensioning sleeve, should start with hydraulic tensioning tool, and then lock fastening screws, in order to ensure hole and axis concentric.

对于不同的开槽加工线，应该在刀具设计对应的转速和进给速范围内加工，否则会影响加工质量和刀具寿命。

Different slot processing lines should process in the corresponding speed and feed speed range of the tool design, otherwise it will affect the quality of machining and tool life.

刀具在正常使用一定时间后，若加工出的地板边口质量不好，就预示着刀具刃口有磨损、不够锋利，需要返回原厂进行修磨。不同类型的刀具、以及刀具齿数多少、地板质量、产量差异，决定着刀具的使用寿命也是不一样。

If the quality of processing floor edge is not good after using for a period of time, it means cutter edge wear and blunt. It need to return to the original factory grinding. The cutter's life depends on different types of cutter, different tooth numbers of cutter, quality of the floor, and the difference yields of floor.

推荐加工参数 recommend processing data:

刀具直径: ϕ 180~220mm 刀具直径: ϕ 220~285mm

主轴转速: 3000~6000r/n 主轴转速: 6000~8000r/n

进给速度: 30~50m/min 进给速度: 50~150m/min

(每齿进给量根据刀具的齿数和不同类型刀具而不尽相同)

Diameter of cutting tool : ϕ 180~220mm Diameter of cutting tool : ϕ 220~285mm

Speed of main axis: 3000~6000r/n Speed of main axis: 6000~8000r/n

Speed of feed: 30~50m/min Speed of feed: 50~150m/min

(Each tooth feed rate is not the same according to the different number of teeth and different types of cutters.)