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ZHEJIANG CHINA



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硬质合金旋转锉

CARBIDE ROTARY FILE

(钨钢磨头)

TUNGSTEN STEEL GRINDER



ISO9001:2008 质量管理体系国际认证企业

Enterprise with ISO 9001-2008 International Quality Management System Certification

本厂产品由中国人民财产保险股份有限公司责任保险

Our Products Insured by the Peoples Insurance Company of China

浙江省余姚市丰华硬质合金刀具厂

ZHEJIANG YUYAO FENGHUA CARBIDE ALLOY CUTTING TOOL FACTORY



企业介绍

丰华刀具 刀具精华

FENGHUA BLADES BLADES HIGHLIGHTS

余姚市丰华硬质合金刀具厂位于浙江省余姚工业重镇泗门。本厂已具有二十多年硬质合金旋转锉的生产历史。现有职工近200人，厂区占地面积近15000M²，拥有精良的专业制造设备五百多台和一百多台五轴五联动数控工具磨床，有年产2000万件的生产能力。本厂技术力量雄厚。产品规格齐全，质量符合GB/T9217-2005要求，可与国外产品媲美，产品畅销世界各地。是国内专业规模生产“金鹰牌”硬质合金旋转锉和享有很高知名度的企业。曾荣获省机电产品优秀品牌称号，多次荣获省A级重合同守信用企业。是国家安全生产标准化达标企业。

Yuyao Fenghua Carbide Alloy Cutting Tool Factory is located in Simen, a key industrial town of Yuyao, Zhejiang Province; with more than 20 years of carbide rotary file production history and a staff of nearly 200 people covering an area of nearly 20,000 m². The factory has 300+ professional sophisticated manufacturing devices, more than one hundred of five-axle five-linkage CNC tool grinders, and a production capacity of 15 million pieces per year. The factory boasts a powerful technical force, complete product specifications, quality in line with GB/T9217-2005 and products that can compare favorably with foreign competitors. Its products are good sellers around the world. It specifically produces Gold Eagle brand carbide rotary files and enjoys a rather high reputation. In addition, the factory has even won titles of Provincial Electromechanical Excellence and has repeatedly won Product Brand and Provincial Grade-A Contract-honoring & Promise-keeping & National safety production & standardization enterprise. The products are exported to many European countries such as Germany, America and Great Britain.

特点:

硬质合金旋转锉是钳工和模具工不可缺少的先进工具，其特点是取代带柄小砂轮并无粉尘污染，使用寿命相当于很多个带柄小砂轮，加工效率提高数倍以上，磨削加工硬度 HRC70 以下的各种金属和非金属材料，磨削面粗糙度可达 Ra1.6，掌握方便、使用简单、安全可靠，大大减轻繁重的体力劳动，减少生产成本。

Characteristic:

The carbide alloy rotary file is the fitter and mold labor's indispensable advanced tool, its characteristic is substitutes for the belt handle small grinding wheel and the non-dust pollution, the service life is equal to several hundred belt handle small grinding wheel, the processing efficiency enhances above 5 times, below abrasive machining degree of hardness HRC70 each metal and the nonmetallic material, grinding surface roughness may reach Ra1.6, convenience grasps, use to be simple, safe reliable, reduces the arduous manual labor greatly, reduce the cost of production.



用途:

硬质合金旋转锉用途极为广泛，应用于模具加工制造。机械零件的倒角、倒圆和沟槽加工，清理铸、锻、焊件的飞边，毛刺和焊缝；管道，叶轮流道的光整加工，金属和非金属材料（骨、玉、石）的工艺美术雕刻。

Use:

The carbide alloy rotary file use is extremely widespread, applies in the mold processing manufacture. Machine parts bevel edge, inverted round and trench processing, The clean-up casting, forging, weldment's edge, Burr and welded joint; pipeline, impeller passage's light entire processing, metal and nonmetallic material (bone, jade, stone) industrial art carving.



切削硬度HRC62的轴承钢图例
Cutting the hardness HRC62 bearing steel Legend

注意事项:

配套的驱动工具的夹具同心度要好，严禁和不同心的夹具配套使用，使用时柄部必须夹紧、夹正，运转时严禁有晃动现象，切削方向应从右向左平稳移动，不要用力过猛，防止弹动、撞击；柄长超过 80mm 的应减速操作，为防切屑飞散，请用防护眼镜。

Matters needing attention:

The supporting drive tool's fixture concentricity should be well, it is supporting use with the not concentric fixture, using stem must clamp and correct. The sloshing phenomenon is strictly prohibited while it is operating, the cutting direction should move smoothly from right to left, don't force excessive to prevent bounce and bump; If the handle length surpasses 80mm should decelerate the operation to prevent the chip flying, please use protective glasses.

使用:

硬质合金旋转锉主要和电动工具或风动工具配套使用（也可装在机床上）。配套驱动转速一般为6000-50000转/分。

Use:

The carbide alloy rotary file main supporting the use of electric tool or the pneumatic tool (may also install on machine tool). General support for the drive rotational speed is 6000-50000 turn/min.



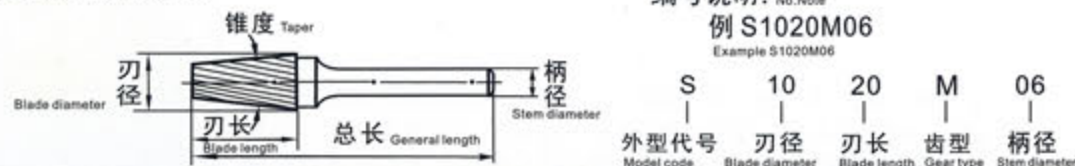
硬质合金旋转锉的订货编号 THE CARBIDE ALLOY ROTARY FILE ORDER NO.

图例说明: Legend Note

编号说明: No. Note

例 S1020M06

Example S1020M06



外型代号 刃径 刃长 齿型 柄径
Model code Blade diameter Blade length Gear type Stem diameter

外形及代号 Shape & Code	图例 Legend	订货编号 Order No.	尺寸 Size					齿型 Tooth	单价 (RMB) (元)
			刃径	刃长	柄径	总长	锥度		
圆柱形 Cylindrical 代号 A		A0313M03	3	13	3	50		M	18
		A0413M04	4	13	4	50		M	22
		A0616M06	6	16	6	56		M	29
		A0820M06	8	20	6	60		M	31
		A1020M06	10	20	6	60		M	35
		A1225M06	12	25	6	65		M	47
		A1425M06	14	25	6	65		M	57
		A1625M06	16	25	6	65		M	67
		A0804M06	8	4	6	50		M	18
		A1005M06	10	5	6	50		M	22
		A1205M06	12	5	6	50		M	27
		A1606M06	16	6	6	50		M	37
圆柱形球头 Cylindrical ball nose 代号 C		C0313M03	3	13	3	50		M	18
		C0413M04	4	13	4	50		M	22
		C0616M06	6	16	6	56		M	32
		C0820M06	8	20	6	60		M	34
		C1020M06	10	20	6	60		M	37
		C1225M06	12	25	6	65		M	51
		C1425M06	14	25	6	65		M	62
圆球形 Spherical 代号 D		D0303M03	3	2.7	3	50		M	18
		D0403M04	4	3.6	4	50		M	22
		D0605M06	6	5.4	6	55		M	26
		D0807M06	8	7.2	6	57		M	27
		D1009M06	10	9	6	54		M	28
		D1210M06	12	10.8	6	55		M	40
		D1412M06	14	12	6	52		M	45
		D1614M06	16	14.4	6	54		M	47
椭圆形 Oval 代号 E		E0610M06	6	10	6	60		M	36
		E0813M06	8	13	6	58		M	40
		E1016M06	10	16	6	61		M	45
		E1220M06	12	20	6	60		M	51
		E1422M06	14	22	6	62		M	62
		E1625M06	16	25	6	65		M	72
弧形圆头 Arc round nose 代号 F		F0313M03	3	13	3	50		M	18
		F0618M06	6	18	6	58		M	32
		F0818M06	8	18	6	58		M	36
		F1020M06	10	20	6	60		M	38
		F1225M06	12	25	6	65		M	45
		F1425M06	14	25	6	65		M	60
		F1625M06	16	25	6	65		M	72
弧形尖头 Arc pointed nose 代号 G		G0313M03	3	13	3	50		M	18
		G0618M06	6	18	6	58		M	37
		G0817M06	8	17	6	57		M	40
		G1020M06	10	20	6	60		M	45
		G1225M06	12	25	6	65		M	50
		G1425M06	14	25	6	65		M	65
		G1625M06	16	25	6	65		M	72
火炬形 Torch-shaped 代号 H		H0307M03	3	7	3	50		M	18
		H0618M06	6	18	6	58		M	37
		H0820M06	8	20	6	60		M	40
		H1025M06	10	25	6	65		M	45
		H1232M06	12	32	6	72		M	58
		H1430M06	14	30	6	70		M	72
		H1636M06	16	36	6	76		M	85
60°圆锥形 60°Conical 代号 J		J0605M06	6	5.2	6	55	60°	M	29
		J0807M06	8	7	6	55	60°	M	31
		J1008M06	10	8.7	6	53	60°	M	33
		J1210M06	12	10.4	6	55	60°	M	36
		J1613M06	16	13.8	6	56	60°	M	45

TEL: 0574-62153062

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外形及代号 Shape & Code	图例 Legend	订货编号 Order No.	尺寸 Size					齿型 Tooth	单价 (RMB) (元)
			刃径	刃长	柄径	总长	锥度		
90°圆锥形 90°Conical 代号 K		K0603M06	6	3	6	55	90°	M	29
		K0804M06	8	4	6	52	90°	M	31
		K1005M06	10	5	6	50	90°	M	33
		K1206M06	12	6	6	51	90°	M	36
		K1608M06	16	8	6	53	90°	M	45
圆锥圆顶 Taper with round top 代号 L		L0313M03	3	13	3	50	10°	M	18
		L0413M04	4	13	4	50	10°	M	22
		L0616M06	6	16	6	56	14°	M	29
		L0822M06	8	22	6	62	14°	M	34
		L1025M06	10	25	6	65	14°	M	40
		L1228M06	12	28	6	68	14°	M	43
		L1428M06	14	28	6	68	14°	M	60
		L1633M06	16	33	6	73	14°	M	75
锥形尖头 Conical pointed nose 代号 M		M0313M03	3	13	3	50	14°	M	18
		M0413M04	4	13	4	50	14°	M	22
		M0618M06	6	18	6	58	14°	M	36
		M0817M06	8	17	6	57	26°	M	38
		M1020M06	10	20	6	60	25°	M	44
		M1225M06	12	25	6	65	25°	M	50
		M1425M06	14	25	6	65	30°	M	56
		M1625M06	16	25	6	65	32°	M	75
倒锥形 Inverted conical 代号 N		N1213M06	12	13	6	53	20°	M	37
		N1616M06	16	16	6	56	20°	M	45
		N1005M06	10	5	6	50	20°	M	26
		N1205M06	12	5	6	50	26°	M	28
		N1606M06	16	6	6	50	26°	M	40
圆锥平头 Cone flat nose 代号 S		S0313M03	3	13	3	50	8°	M	18
		S0413M04	4	13	4	50	8°	M	22
		S0614M06	6	14	6	54	8°	M	28
		S0817M06	8	17	6	57	12°	M	31
		S1020M06	10	20	6	60	12°	M	36
		S1220M06	12	20	6	60	16°	M	40
		S1428M06	14	28	6	68	16°	M	45
		S0804M06	8	4	6	50	16°	M	25
		S1005M06	10	5	6	50	22°	M	26
		S1205M06	12	5	6	50	26°	M	28
		S1606M06	16	6	6	50	26°	M	40
圆弧盘形 Disc type with arc edge 代号 T		T0804M06	8	4	6	50		M	22
		T1005M06	10	5	6	50		M	25
		T1202M06	12	2	6	50		M	29
		T1205M06	12	5	6	50		M	29
		T1603M06	16	3	6	50		M	42
		T1604M06	16	4	6	50		M	42
		T1606M06	16	6	6	50		M	42
凹弧形 Concave arc shape 代号 U		U0610M06	6	10	6	50		M	36
		U0815M06	8	15	6	55		M	40
		U1020M06	10	20	6	60		M	45
		U1225M06	12	25	6	65		M	51
		U1625M06	16	25	6	65		M	72
圆柱形半圆头 Column form with half round nose 代号 W		W0614M06	6	14	6	54		M	33
		W0818M06	8	18	6	58		M	35
		W1018M06	10	18	6	58		M	38
		W1222M06	12	22	6	62		M	52
		W1422M06	14	22	6	62		M	63
		W1622M06	16	22	6	62		M	75
90度盘形 Disc type of 90 degree 代号 Y		Y1202M06	12	2	6	50	90°	M	30
		Y1602M06	16	2	6	50	90°	M	42
		Y1603M06	16	3	6	50	90°	M	42
		Y2505M06	25	5	6	45	90°	M	58
带端刃		带端刃的订货编号表示法: 在所需型号后加 "E" (加价2元/支) 如AE1020M06 NE1205M06. The representation of order No. of the carbide alloy rotary file with end edge blade: please add "E" behind the mode which you required (Add 2 Yuan for one file) Such as: AE1020M06 NE1205M06.							
带分屑槽		带分屑槽的订货编号表示法: 在所需型号后加 "X" (加价2元/支) 如AX1020M06 CX0820M06 LX1228M06等。 The representation of order No. of the carbide alloy rotary file with chip -groove: please add "X" behind the mode which you required (Add 2Yuan for one file) Such as: AX 1020M06, CX0820M06, LX1228M06, ect.							

丰华刃具
FENGHUA BLADES

刃具精华
BLADES HIGHLIGHTS

Fax: 0574-62158797

柄径Φ3系列旋转锉（钨钢滚磨刀）

Stem diameter Φ3 series of rotary file (tungsten steel roller blade)

(注：可加工英制) (Note: English machinable)

号	尺寸 Size			价格 RMB (元)	形状名称 Shape name	编号 No.	尺寸 Size			价格 RMB (元)
	D	L	L1				D	L	L1	
4	4	13	50	20	下半球型D _下 D below	D _下 6	6	3	41	20
5	5	13	50	25		D _下 8	8	4	42	25
6	6	13	50	30	上半球型D _上 D above	D _上 6	6	3	40	20
4	4	13	50	20		D _上 8	8	4	42	25
5	5	13	50	25	P型(不带分屑槽) without chip-groove	P1.5	12	1.5	39	27
6	6	13	50	30		P2	12	2	40	27
4	4	4	41	20		P3	12	3	41	27
5	5	5	42	25	A型 A type	A1.5	1.5	8	38	15
6	6	6	43	30		A2	2	10	38	15
4	4	7	45	20		A2.5	2.5	14	38	15
5	5	8	46	25		A3	3	16	38	15
6	6	10	48	30	C型 C type	C1.5	1.5	8	38	15
4	4	13	50	20		C2	2	10	38	15
5	5	13	50	25		C2.5	2.5	12	38	15
6	6	13	50	30		C3	3	16	38	15
4	4	13	50	20	D型(Φ3以下不带分屑槽) below Φ3 without chip-groove	D2	2	2	38	15
5	5	13	50	25		D2.5	2.5	2.3	38	15
6	6	13	50	30		D3	3	2.8	38	15
4	4	13	50	20	E型	E3	3	5.5	38	15
5	5	13	50	25	F型	F3	3	16	38	15
6	6	13	50	30	G型	G3	3	16	38	15
4	4	13	50	20	AG3型	AG3	3	16	38	15
5	5	13	50	25	H型	H3	3	6.3	38	15
6	6	13	50	30	L型	L3	3	16	38	15
4	4	6	44	20	M型	M3	3	16	38	15
5	5	7	45	25	N型	N3	3	4	38	15
6	6	7	45	30						

此页编号的产品刃部均带分屑槽，若不需要带分屑槽，请订货时说明。

旋转锉供货方法

- 一、旋转锉可成套、单支订货，并根据用户特殊要求，定制非标专用旋转锉和英制旋转锉。
- 二、硬质合金旋转锉可供15支/套，单价：524.00元/套。
15支/套规格型号：A0616M06 A1205M06 AX0820M06 AE1020M06 C0820M06 D1009M06 G0618M06 K1005M06 L0822M06 M0817M06 N1606M06 S0804M06 S1220M06 T1606M06 W1018M06
- 三、Φ3 硬质合金旋转锉：5支/套 单价：90元/套；
Φ4 硬质合金旋转锉：5支/套 单价：110元/套；
Φ3 旋转锉 5支/套型号为：A0313M03 C0313M03 D0303M03 L0313M03 M0313M03
Φ4 旋转锉 5支/套型号为：A0413M04 C0413M04 D0403M04 L0413M04 M0413M04
- 四、旋转锉刀柄按国标规定是40mm长，但可以加长。
加长在100mm以内加价2元/支，在150mm以内加价3元/支，在200以内加价4元/支。

The rotary file supplied method

- A. The rotary file can be order in set or single, and in accordance with specific requirements of users to make non-standard special rotary file and English machinable.
- B. The carbide alloy rotary file can supply 15 / set unit price: 524.00/set.
The specifications model of 15 / set: A0616M06 A1205M06 AX0820M06 AE1020M06 C0820M06 D1009M06 G0618M06 K1005M06 L0822M06 M0817M06 N1606M06 S0804M06 S1220M06 T1606M06 W1018M06
- C. The Φ3 carbide alloy rotary file: 5 / set unit price: 90 yuan / set;
The Φ4 carbide alloy rotary file: 5 / set unit price: 110 yuan / set;
The Φ3 rotary file model of 5 / set: A0313M03 C0313M03 D0303M03 L0313M03 M0313M03
The Φ4 rotary file model of 5 / set: A0413M04 C0413M04 D0403M04 L0413M04 M0413M04
- D. The rotary file knife stalk is according with GB specification that the length is 40 mm, but it can be lengthened.
Lengthened length within 100mm, add two Yuan each one, and within 150 mm, add 3 yuan each one, and within 200, add 4 Yuan each one.



产品源自五轴联动数控工具磨床
Products derived from 5-axis CNC tool grinder

齿型参考：



M
标准齿
Standard gear



C
粗齿
Thick gear



F
细齿
Thin gear

- 标准齿的订货编号表示方法，例 A1020M06
- 粗齿的订货编号表示方法，例 A1020C06
- 细齿的订货编号表示方法，例 A1020F06

可为用户定做专用非标刀具

Gear model reference:

- Stand gear Order No. express way, for example A1020M06
- Thin gear Order No. express way, for example A1020C6
- Thick gear Order No. express way, for example A1020F06

That can order specific non-standard knife tools for users