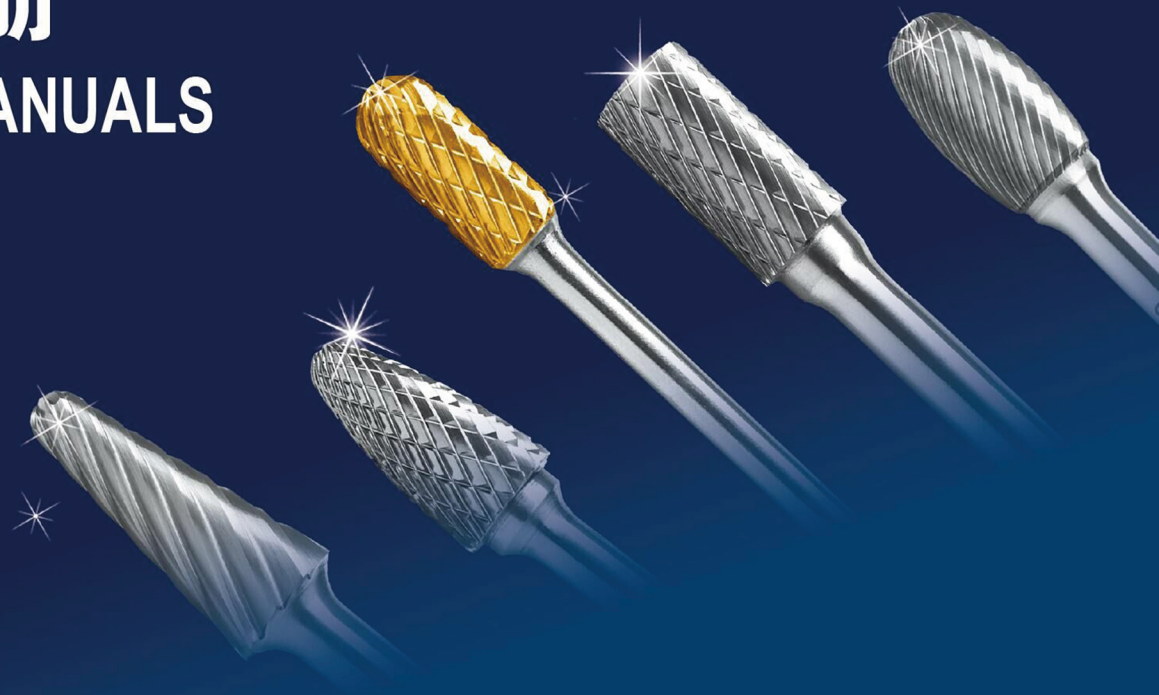




产品手册

PRODUCT MANUALS

CUTTING TOOLS



株洲市格威硬质合金工具有限责任公司
Zhuzhou Grewin Tungsten Carbide Tools Cor., Ltd

旋转锉用途与特点

硬质合金旋转锉是钳工机械化不可缺少的工具，其用途极为广泛，尤其在航空、船舶、汽车、机械、化工等工业部门使用效果更为显著。它可以用来加工铸铁、铸钢、碳素钢、合金钢、不锈钢、淬硬钢、铜和铝等。

- 可以加工各种金属材料，还能加工≤HRC65. 淬硬钢。
- 可以代替带柄小砂轮加工，无粉尘污染。
- 生产效率比用一般手工锉刀加工可提高数十倍，比用小砂轮加工也可提高效率3~5倍。
- 刀具耐用度比高速钢刀具可提高十倍，比用小砂轮的耐用度也可提高50倍以上。
- 可以精加工各种形状的金属膜腔。
- 清理铸、锻、焊件的飞边、焊缝和毛刺。
- 各种机械零件的倒角、倒圆和沟槽加工。
- 清理管道。
- 叶轮流道的光整加工。
- 精加工机械零件的内孔表面。

ADVANTAGES AND APPLICATION

Using Carbide Rotary Burrs is a effective way to realize mechanization in hand work operations. In the industries of airplane, ship building automobile, machinery, chemistry etc. Carbide Rotary Burrs can be widely used in machining iron, steel casting, carbon steel, alloy steel, stainless steel, hardened steel, copper, aluminium etc.

- Machining various kinds of metal material including ≤HRC65 hardened steel.
- Instead of small emery wheels, without powder pollution.
- Increasing productively of several ten times than using hard tools and three to five times than using small emery wheels.
- Having long life of ten times than high speed steel burrs and fifty times than small emery wheels.
- Finish machining various kinds of die cavities.
- Removing the burrs of the castings, forgings and the welding spatter on the weld assemblies.
- Chamfering angle, circular bead or flute on the mechanical components.
- Chamfering or burring the pipes.
- Polishing the impeller channel.
- Grinding the hole to an accurate shape.

硬质合金旋转锉主要用于手持风动或电动工具驱动（也可用在机床上）使用时须把旋转锉夹紧夹正。硬质合金旋转锉只有在高的切削速度下工作，方能发挥其卓越的性能，推荐用主轴转速。

The machines which are used for Carbide Rotary Burrs are usually hand-held, powered either by compressed air or eletricity. Becarefull about mounting and handling the burr correctly.

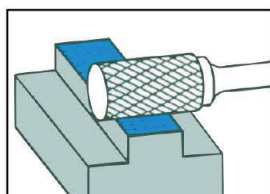
Only at high speed, can carbide rotary burrs show their remarable performance. Recommended spindle speeds.

旋转锉直径mm DIAMETER OF BURR	推荐主轴转速/min RECOMMENDED SPINDLE SPEEDS
3	65000~75000
6	30000~40000
8	25000~28000
10	20000~23000
12	15000~18000
16	10000~14000

被切削材料较软时宜选用较高的转速。
The higher speeds are applied to softer machined materials.

● Carbide Burrs, Metric, ISO7755 standard

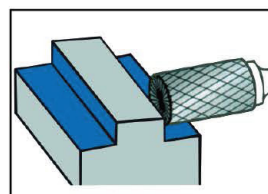
柱型平顶 Cylinder





编号 Style	刃径 Cutting Diameter	刃长 Cutting Length	柄径 Shank Diameter	总长 The total Length
A0210M06	2mm	10mm	6mm	55mm
A0314M06	3mm	14mm	6mm	55mm
A0414M06	4mm	14mm	6mm	55mm
A0616M06	6mm	16mm	6mm	65mm
A0820M06	8mm	20mm	6mm	65mm
A1020M06	10mm	20mm	6mm	65mm
A1225M06	12mm	25mm	6mm	65mm
A1625M06	16mm	25mm	6mm	65mm

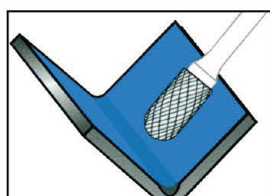
柱型端刃 Cylinder with End Cutter





编号 Style	刃径 Cutting Diameter	刃长 Cutting Length	柄径 Shank Diameter	总长 The total Length
B0210M06	2mm	10mm	6mm	55mm
B0314M06	3mm	14mm	6mm	55mm
B0414M06	4mm	14mm	6mm	55mm
B0616M06	6mm	16mm	6mm	65mm
B0820M06	8mm	20mm	6mm	65mm
B1020M06	10mm	20mm	6mm	65mm
B1225M06	12mm	25mm	6mm	65mm
B1625M06	16mm	25mm	6mm	65mm

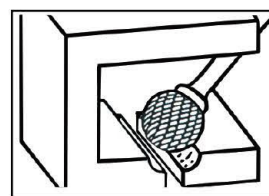
柱型圆头 Cylinder with Ball Top





编号 Style	刃径 Cutting Diameter	刃长 Cutting Length	柄径 Shank Diameter	总长 The total Length	R
C0210M06	2mm	10mm	6mm	55mm	1mm
C0314M06	3mm	14mm	6mm	55mm	1.5mm
C0414M06	4mm	14mm	6mm	55mm	2mm
C0616M06	6mm	16mm	6mm	65mm	3mm
C0820M06	8mm	20mm	6mm	65mm	4mm
C1020M06	10mm	20mm	6mm	65mm	5mm
C1225M06	12mm	25mm	6mm	65mm	6mm
C1625M06	16mm	25mm	6mm	65mm	8mm

球型 Sphere



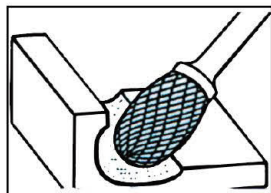


编号 Style	刃径 Cutting Diameter	刃长 Cutting Length	柄径 Shank Diameter	总长 The total Length
D0202M06	2mm	1.8mm	6mm	55mm
D0303M06	3mm	2.7mm	6mm	55mm
D0403M06	4mm	3mm	6mm	55mm
D0605M06	6mm	5mm	6mm	65mm
D0807M06	8mm	7mm	6mm	65mm
D1009M06	10mm	9mm	6mm	65mm
D1210M06	12mm	10mm	6mm	65mm
D1614M06	16mm	14mm	6mm	65mm

旋转锉系列 Carbide Rotary Burrs

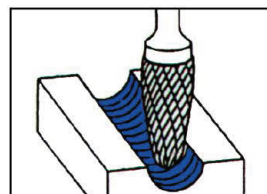
● Carbide Burrs, Metric, ISO7755 standard

椭圆型 Elliptic Cylinder



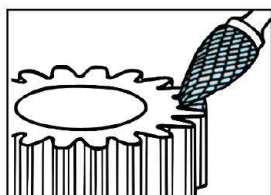
编号 Style	刃径 Cutting Diameter	刃长 Cutting Length	柄径 Shank Diameter	总长 The total Length	R
E0307M06	3mm	7mm	6mm	55mm	1.2mm
E0610M06	6mm	10mm	6mm	65mm	2.5mm
E0813M06	8mm	13mm	6mm	65mm	7mm
E1016M06	10mm	16mm	6mm	65mm	4mm
E1220M06	12mm	20mm	6mm	65mm	5mm
E1625M06	16mm	25mm	6mm	65mm	6.5mm

弧型圆头 Arc Cylinder with Ball Top



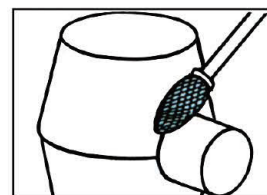
编号 Style	刃径 Cutting Diameter	刃长 Cutting Length	柄径 Shank Diameter	总长 The total Length	R
F0313M06	3mm	13mm	6mm	55mm	0.8mm
F0618M06	6mm	18mm	6mm	65mm	1.5mm
F0820M06	8mm	20mm	6mm	65mm	2mm
F1020M06	10mm	20mm	6mm	65mm	2.5mm
F1225M06	12mm	25mm	6mm	65mm	3mm
F1625M06	16mm	25mm	6mm	65mm	3.5mm

弧型尖顶 Arc Cylinder with Sharp Top



编号 Style	刃径 Cutting Diameter	刃长 Cutting Length	柄径 Shank Diameter	总长 The total Length	R
G0313M06	3mm	13mm	6mm	55mm	15mm
G0618M06	6mm	18mm	6mm	65mm	26mm
G0820M06	8mm	20mm	6mm	65mm	27mm
G1020M06	10mm	20mm	6mm	65mm	28mm
G1225M06	12mm	25mm	6mm	65mm	30mm
G1625M06	16mm	25mm	6mm	65mm	40mm

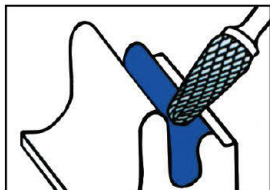
火炬型 Torch Cylinder



编号 Style	刃径 Cutting Diameter	刃长 Cutting Length	柄径 Shank Diameter	总长 The total Length	R
H0313M06	3mm	13mm	6mm	55mm	0.8mm
H0618M06	6mm	18mm	6mm	65mm	1mm
H0820M06	8mm	20mm	6mm	65mm	1.5mm
H1025M06	10mm	25mm	6mm	65mm	2mm
H1232M06	12mm	32mm	6mm	80mm	2.5mm
H1636M06	16mm	36mm	6mm	80mm	2.5mm

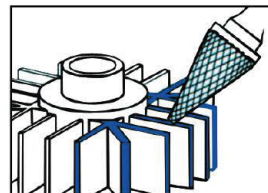
● Carbide Burrs, Metric, ISO7755 standard

锥型圆头 Taper with Ball Top



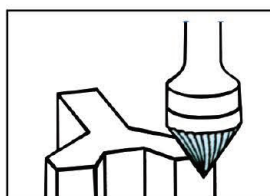
	编号 Style	刃径 Cutting Diameter	刃长 Cutting Length	柄径 Shank Diameter	总长 The total Length	α	R
	L0313M06	3mm	13mm	6mm	55mm	14°	9mm
	L0616M06	6mm	16mm	6mm	65mm	14°	1.2mm
	L0822M06	8mm	22mm	6mm	65mm	14°	14mm
	L1025M06	10mm	25mm	6mm	65mm	14°	2.2mm
	L1228M06	12mm	28mm	6mm	80mm	14°	3mm
	L1633M06	16mm	33mm	6mm	80mm	14°	4.5mm

锥形 Taper



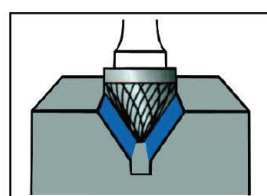
	编号 Style	刃径 Cutting Diameter	刃长 Cutting Length	柄径 Shank Diameter	总长 The total Length	R
	M0311M06	3mm	11mm	6mm	55mm	14°
	M0618M06	6mm	18mm	6mm	65mm	14°
	M0820M06	8mm	20mm	6mm	65mm	20°
	M1020M06	10mm	20mm	6mm	65mm	25°
	M1225M06	12mm	25mm	6mm	65mm	25°
	M1625M06	16mm	25mm	6mm	65mm	25°

60度锥型 Taper with 60 Degree Angle



	编号 Style	刃径 Cutting Diameter	刃长 Cutting Length	柄径 Shank Diameter	总长 The total Length	α
	J0303M06	3	2.6	6	55	60°
	J0605M06	6	5.2	6	55	60°
	J0807M06	8	6.9	6	55	60°
	J1009M06	10	8.7	6	55	60°
	J1210M06	12	10.4	6	55	60°
	J1614M06	16	13.8	6	55	60°

90度锥型 Taper with 90 Degree Angle

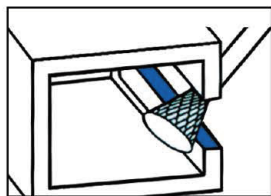


	编号 Style	刃径 Cutting Diameter	刃长 Cutting Length	柄径 Shank Diameter	总长 The total Length	α
	K0302M06	3mm	2mm	6mm	55mm	90°
	K0603M06	6mm	3mm	6mm	55mm	90°
	K0804M06	8mm	4mm	6mm	55mm	90°
	K1005M06	10mm	5mm	6mm	55mm	90°
	K1206M06	12mm	6mm	6mm	55mm	90°
	K1608M06	16mm	8mm	6mm	55mm	90°

旋转锉系列 Carbide Rotary Burrs

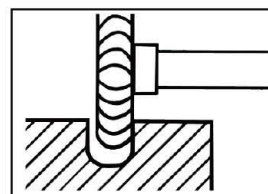
● Carbide Burrs, Metric, ISO7755 standard

倒锥型 Opposite Taper



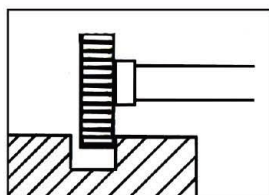
	编号 Style	刃径 Cutting Diameter	刃长 Cutting Length	柄径 Shank Diameter	总长 The total Length	α
	N0304M06	3mm	4mm	6mm	55mm	10°
	N0607M06	6mm	7mm	6mm	65mm	10°
	N0810M06	8mm	10mm	6mm	65mm	10°
	N1010M06	10mm	10mm	6mm	65mm	20°
	N1213M06	12mm	13mm	6mm	65mm	20°
	N1616M06	16mm	16mm	6mm	65mm	20°

圆弧盘型 Disc Type With Arc Edge



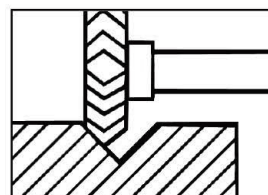
	编号 Style	刃径 Cutting Diameter	刃长 Cutting Length	柄径 Shank Diameter	总长 The total Length	R
	W2504M06	25mm	4mm	6mm	45mm	3.5mm
	W1603M06	16mm	3mm	6mm	45mm	2.8mm

圆片型 Disc Type



	编号 Style	刃径 Cutting Diameter	刃长 Cutting Length	柄径 Shank Diameter	总长 The total Length
	X2504M06	25mm	4mm	6mm	45mm
	X1603M06	16mm	3mm	6mm	45mm
	X1202M06	12mm	2mm	6mm	45mm

90度盘型 Disc Type with 90°Angle Edge



	编号 Style	刃径 Cutting Diameter	刃长 Cutting Length	柄径 Shank Diameter	总长 The total Length	α
	Y2505M06	25mm	5mm	6mm	45mm	90°
	Y1603M06	16mm	3mm	6mm	45mm	90°



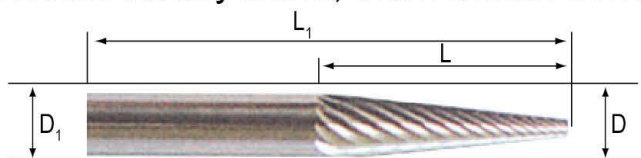
Shank Φ 6 can be extended to 500mm according to requirement

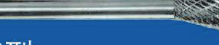
硬质合金旋转锉套装 Carbide Rotary Burr Sets



柄径Φ3系列钨钢滚磨刀

Carbide Rotary Burrs, 3mm Shank Series



Shape 外型	Item No. 型号	Size尺寸 (mm)		
		D 刃径	L 刃长	L ₁ 总长
 A型	A4	4	13	40
	A5	5	13	40
	A6	6	13	48
 C型	C4	4	13	40
	C5	5	13	40
	C6	6	13	48
 D型	D4	4	4	40
	D5	5	5	40
	D6	6	6	48
 E型	E4	4	7	40
	E5	5	8	40
	E6	6	10	48
 F型	F4	4	13	40
	F5	5	13	40
	F6	6	13	48
 G型	G4	4	13	40
	G5	5	13	40
	G6	6	13	48
 H型	H4	4	13	40
	H5	5	13	40
	H6	6	13	48
 L型	L4	4	13	40
	L5	5	13	40
	L6	6	13	48
 M型	M4	4	13	40
	M5	5	13	40
	M6	6	13	48
 N型	N4	4	6	40
	N5	5	7	40
	N6	6	7	48

Shape 外型	Item No. 型号	Size尺寸 (mm)		
		D 刃径	L 刃长	L ₁ 总长
 A型	A41	1.5	6	38
	A41L	2	12	38
	A42	2.5	14	38
	A43	3	16	38
 C型	C41L1	1.5	6	38
	C41L 2	2	12	38
	C41	2.5	14	38
	C42	3	16	38
 D型	D41L	1	1	38
	D41L1	1.5	1.3	38
	D41L2	2	1.8	38
	D41L3	2.5	2.3	38
	D42	3	3	38
 E型	E41	3	5.5	38
	F42	3	12	38
 F型	F42L	3	16	38
	G41	3	6	38
 G型	G43	3	12	38
	G43L	3	16	38
	G44	3	16	38
	H41	3	6.3	38
 L型	L41	3	10	38
	L42	3	12	38
	L43	3	16	38
 M型	M41	3	9	38
	M42	3	12	38
	M43	3	16	38
 N型	N42	3	4	38



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