

责任铸就卓越
Obligation Keeps Excellence



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OKE | 欧科亿
数控精密刀具

产 品 样 品 册

(股票代码: 688308)



Contents

目录

02	硬质合金锯齿刀片 Carbide Saw Tips	41	硬质合金金属开孔器专用齿 Carbide Tips for Hole Saw
04	硬质合金锯齿牌号性能表 Property of Carbide Saw Tips	42	竹木刀用合金刀片 Carbide Tips for Bamboo & Wood
06	硬质合金锯齿牌号应用推荐 Grade Recommendations	42	硬质合金带锯锯齿 Carbide Tips for Band Saw
08	锯齿-JX系列 Carbide Saw Tips-JX Series	43	割草锯片硬质合金刀头 Carbide Tips for Grass Cutting Blade
09	锯齿-JP系列 Carbide Saw Tips-JP Series	43	用TC轴承用硬质合金块 Carbide Blocks For TC Bearing
10	锯齿-JA系列 Carbide Saw Tips-JA Series	44	防滑钉用硬质合金 Tungsten Carbide for Tire Studs
11	金属加工锯齿 Carbide Saw Tips for Metal Cutting	44	硬质合金冲击钻片 Carbide Tips for Drill Bits
12	欧洲标准锯齿 Carbide Saw Tips European Style	45	硬质合金陶瓷钻片 Carbide Tips for Ceramic Drill Bit
13	美国标准锯齿 Carbide Saw Tips U.S.-Canadian Style	45	硬质合金刮刀条 Carbide Scraper for Saw Blade
15	硬质合金圆片 Solid Carbide Saw Discs		
19	硬质合金圆棒 Carbide Rods		
35	硬质合金模具材料 Carbide Die material		
37	硬质合金长条 Carbide Strips		
39	硬质合金木工铣铰刀片 Carbide Tips for Router Bits		
41	指接刀用合金刀片 Carbide Tips for Finger Joint Cutter		

Carbide
Saw Tips

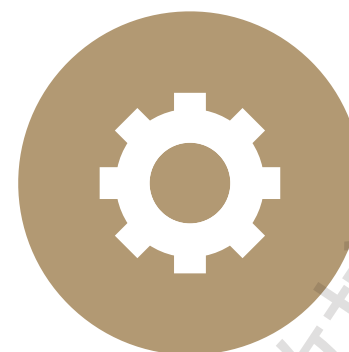
硬质合金锯齿刀片

产品特点

Product
Advantages



稳定
Stability



精度高
High accuracy



易焊
Easy for welding

硬质合金木、铝锯齿牌号性能

Grades for Woodworking and Aluminium

牌号 Grade	粘结相(%) Binder	密度(g/cm³) Density	硬度Hardness		抗弯强度 (MPa) TRS	断裂韧性 (Mpa.m1/2) Kic	ISO标准 Code ISO	美国标准 Code U.S.
			Hv10	HRA				
OKE400	2.0	15.3	2150	95	2500	7.5	-	-
OKE402	2.8	15.2	2100	94.5	2600	7.5	-	-
OKE403	2.8	15.2	2080	94.2	2500	7.5	-	-
OKE406	3.0	15.2	1980	93.8	2500	8.0	-	-
OKE405	3.3	15.2	1920	93.6	2500	8.2	-	-
OKE302	5.0	15	1910	93.6	3000	8.7	-	-
OKE303	4.0	15.15	1880	93.3	2400	8.8	-	-
OKE305	5.5	14.95	1800	92.9	2500	8.9	K05	C3

硬质合金金属锯齿牌号性能

Grades for Metal Cutting

牌号 Grade	粘结相(%) Binder	密度(g/cm³) Density	硬度Hardness		抗弯强度 (MPa) TRS	断裂韧性 (Mpa.m1/2) Kic	ISO标准 Code ISO	美国标准 Code U.S.
			Hv10	HRA				
OKE501	10	12.7	1420	91	2000	9.5	P40	C5/C6
OKE505	10	12.2	1420	91	2050	9.5	P40	C5
OKE509	12	12.5	1440	91.2	2100	10	P40	C5
OKE519	12	12.45	1460	91.3	2200	10.5	P40	C5
OKE511	11	13.15	1360	90.2	2200	10.5	P40	C5
 OKE920(金属陶瓷)	-	6.4	-	91.7	2000	-	P10~P20	-

硬质合金木、铝锯齿牌号性能

Grades for Woodworking and Aluminium

牌号 Grade	粘结相(%) Binder	密度(g/cm³) Density	硬度Hardness		抗弯强度 (MPa) TRS	断裂韧性 (Mpa.m1/2) Kic	ISO标准 Code ISO	美国标准 Code U.S.
			Hv10	HRA				
OKE106	16	12.3	1500	91	2000	13	K30	C2
OKE107	6.0	14.8	1500	91	2300	10.5	K30	C2
OKE109	7.0	14.65	1420	90.3	2500	11.5	K20	C1
OKE114	11.5	12.4	1420	90.5	2700	12	K20	C1
OKE116	33	8.65	1010	86	1800	-	>K40	-
OKE210	7.0	14.75	1500	91	2300	11.5	K20	C2
OKE211	8.0	14.7	1420	90.5	2500	10.5	K20	C1
OKE212	10	14.3	1440	90.7	2400	11.5	K20	C2
OKE213	12	14.35	1200	88.5	2600	-	K40	C1
OKE217	5.5	14.9	1650	92.2	2300	10	K10	C3
OKE218	6.0	14.85	1560	91.5	2400	11	K10	C3
OKE216	8.5	14.7	1570	91.6	2650	11	K10	C3
OKE233	13	14.2	1180	88	2600	-	K40	C1
OKE241	10	14.55	1150	87.5	2500	-	>K40	-

硬质合金锯齿牌号应用推荐

Grade Recommendations

锯切材质 Cutting Applications	锯片名称 Saw Blade Name	推荐合金牌号 Recommended Grade		
		良好 Good	优秀 Very Good	卓越 Excellent
刨花板、密度板 Chipboard、Density Board	电子开料锯/往复锯用锯片 Panel Sizing Saw Blade and Reciprocating Saw Blade	OKE403	OKE402	OKE400
	裁板锯/推台锯用锯片 Panel Sizing Saw Blade and Sliding Table Saw Blade	OKE406	OKE403	OKE402
	单划线锯片 Single Scoring Saw Blade	OKE403	OKE402	OKE400
	双划线锯片 Double Scoring Saw Blade	OKE406	OKE403	OKE402
	加工相框、镜框用锯片 Saw Blade for Photo Frame and Mirror Frame Processing	OKE302	OKE405	OKE403
	音箱V槽机用锯片 V-Cutting Saw Blade	OKE302	OKE403	OKE402
实木（软木/硬木/旧木） Solid Wood (Softwood/Hardwood/Used-wood)	实木横截锯/纵切锯 Cross Cutting and Score Cutting Saw Blade for Solid Wood	OKE217	OKE303	OKE405
	实木精切锯/超薄段付锯 Accurate Cutting Saw Blade for Solid Wood/Super-Thin Rim Saw Blade	OKE303	OKE302	OKE405
	实木多片锯 Multi-ripping Saw Blade for Solid-wood	OKE303	OKE302	OKE405
	细木工板（原生木）专切锯 Saw Blade for Blockboard(Original Wood)	OKE216	OKE217	OKE305
	细木工板（旧木）专切锯 Saw Blade for Blockboard(Used Wood)	OKE107	OKE216	OKE217
	旧木多片锯 Multi-ripping Saw Blade for Used Wood	OKE109	OKE107	OKE216
	硬质合金带锯/框锯(普通木工用) Band Saw Blade/Frame Saw Blade(General Woodworking)	OKE109	OKE217	OKE303
	硬质合金带锯(木工用) Carbide Tips for Bandsaw(Woodworking)	-	-	DNS10
黑色金属（铁、钢、不锈钢） Ferrous Metal (Iron、Steel、Stainless Steel)	无缝钢管锯切冶金锯 Metallurgy Saw Blade for Seamless Steel Pipe	-	OKE509	OKE505
	无缝钢管坯锯切冶金锯 Metallurgy Saw Blade for Seamless Steel Pipe Billet	OKE519	OKE509	OKE505
	彩钢瓦锯切专用锯片 Saw Blade for Color Steel Tile	OKE501	OKE509	OKE505
	不锈钢薄壁管、装饰条专切锯片 Saw Blade for Stainless Steel Thin-Wall Pipe、Decoration Strip	-	OKE616	OKE505
	硬质合金带锯(金工用) Tungsten Carbide Band Saw(For Metalworking)	-	-	DSP10
有色金属（铝、铝合金、黄铜） Non-Ferrous Metal (Aluminum、Aluminium Alloy、Brass)	双头锯断桥铝（建筑门窗用）合金锯切专用锯片 Saw Blade for Two-Cutted Saw	OKE406	OKE403	OKE402
	铝锭、铝管、铝棒切割用锯片 Saw Blade for Aluminium Ingot、Aluminium Pipe、Aluminium Bar	OKE211	OKE217	OKE305
	铝合金角码切割用锯片 Saw Blade for Aluminum Bracket	OKE405	OKE406	OKE403
	铜棒切割锯片 Saw Blade for Copper Bar	OKE217	OKE305	OKE405
有机材料 Other Organic Materials	有机玻璃、亚克力、塑料专切用锯片 Saw Blade for PMMA、Acrylic、Plastic	OKE217	OKE303	OKE302
	泡沫锯切用锯片 Saw Blade for Polystyrene Foam	OKE210	OKE217	OKE303

硬质合金锯齿牌号应用推荐

Grade Recommendations

锯片名称 Saw Blade Name	推荐合金牌号 Recommended Grade		
	良好 Good	优秀 Very Good	卓越 Excellent
便携式电动工具用锯片 Saw Blade for Portable Power Tools	OKE211	OKE210	OKE217
割草专用锯片 Saw Blade for Cutting Grass	-	OKE-GC5	OKE-GC1
超市专售DIY合金锯片 DIY TCT Saw Blade for Supermarket Sale	-	OKE109	OKE107
装修用锯片 Saw Blade for Decoration	-	OKE109	OKE107



锯齿-JX系列

Saw Tips-JX Series



单位/Unit: 毫米/Minllimetre

型号 (Type)	L	T	α °	β °	L1	R
Jx3219652010	3.2	1.9	65	20	1.0	0.5
JX4014601110	4.0	1.4	60	11	1.0	0.5
JX4314602010	4.3	1.4	60	20	1.0	0.5
JX4515602610	4.5	1.5	60	26	1.0	0.5
JX4520653010	4.5	2.0	65	30	1.0	0.5
JX4815702610	4.8	1.5	70	26	1.0	0.5
JX5015602015	5.0	1.5	60	20	1.5	0.5
JX5015702015	5.0	1.5	70	20	1.5	0.5
JX5016652213	5.0	1.6	65	22	1.3	0.5
JX5017602813	5.0	1.7	60	28	1.3	0.5
JX5020602020	5.0	2.0	60	20	2.0	0.5
JX5216652017	5.2	1.6	65	20	1.7	0.5
JX5316602118	5.3	1.6	60	21	1.8	0.5
JX5417602013	5.4	1.7	60	20	1.3	0.5
JX5516601420	5.5	1.6	60	14	2.0	0.5
JX5517602118	5.5	1.7	60	21	1.8	0.5
JX5518602217	5.5	1.8	60	22	1.7	0.5
JX5520602019	5.5	2.0	60	20	1.9	0.5
JX5716602014	5.7	1.6	60	20	1.4	0.5
JX5718602021R06	5.7	1.8	60	20	2.1	0.6
JX5818602014	5.8	1.8	60	20	1.4	0.5
JX5919602016	5.9	1.9	60	20	1.6	0.5
JX6018652418	6.0	1.8	65	24	1.8	0.5
JX6020602014	6.0	2.0	60	20	1.4	0.5
JX6022602014	6.0	2.2	60	20	1.4	0.5
JX6218623012	6.2	1.8	62	30	1.2	0.5
JX6319701820	6.3	1.9	70	18	2.0	0.5
JX6320652521	6.3	2.0	65	25	2.1	0.5
JX6518602014	6.5	1.8	60	20	1.4	0.5
Jx6520602422	6.5	2.0	60	24	2.2	0.5
JX6522602016	6.5	2.2	60	20	1.6	0.5
Jx6525602015	6.5	2.5	60	20	1.5	0.5

锯齿-JX系列

Saw Tips-JX Series



单位/Unit: 毫米/Minllimetre

型号 (Type)	L	T	α °	β °	L1	R
Jx6820702019	6.8	2.0	70	20	1.9	0.5
JX7020702016	7.0	2.0	70	20	1.6	0.5
JX7022601624	7.0	2.2	60	16	2.4	0.5
JX7023652025	7.0	2.3	65	20	2.5	0.5
JX7025652220	7.0	2.5	65	22	2.0	0.5
JX7222652521	7.2	2.2	65	25	2.1	0.5
JX7520622022	7.5	2.0	62	20	2.2	0.5
JX7522601628	7.5	2.2	60	16	2.8	0.5
JX7523602018	7.5	2.3	60	20	1.8	0.5
JX7525652029	7.5	2.5	65	20	2.9	0.5
JX8020701515	8.0	2.0	70	15	1.5	0.5
JX8022601628	8.0	2.2	60	16	2.8	0.5
JX8023652025	8.0	2.3	65	20	2.5	0.5
JX8024701926	8.0	2.4	70	19	2.6	0.5
JX8025602028	8.0	2.5	60	20	2.8	0.5
JX8025752118	8.0	2.5	75	21	1.8	0.5
JX8525622030	8.5	2.5	62	20	3.0	0.5
JX8525702026	8.5	2.5	70	20	2.6	0.5
JX9025652032	9.0	2.5	65	20	3.2	0.5
JX9028652025	9.0	2.8	65	20	2.5	0.5
JX9030603016	9.0	3.0	60	30	1.6	0.5
JX9528652030	9.5	2.8	65	20	3.0	0.5
JX10025652425	10.0	2.5	65	24	2.5	0.5
JX10028602030	10.0	2.8	60	20	3.0	0.5
JX10030622538	10.0	3.0	62	25	3.8	0.5
JX10525601534	10.5	2.5	60	15	3.4	0.5
JX10528602528	10.5	2.8	60	25	2.8	0.5
JX10530652030	10.5	3.0	65	20	3.0	0.5
JX10535603026	10.5	3.5	60	30	2.6	0.5
JX12040603026R	12.0	4.0	60	30	2.6	0.8
JX12540603026	12.5	4.0	60	30	2.6	0.5
JX13040552055R	13.0	4.0	55	20	5.5	0.8

锯齿-JP系列
Saw Tips-JP Series



单位/Unit: 毫米/Minllimetre

型号 (Type)	L	T	α°	R	P
JP45146005-W	4.5	1.4	60	0.5	
JP50156005-W	5.0	1.5	60	0.5×45°	
JP54146005F-W	5.3	1.8	60	0.5×45°	
JP55166005-W	5.5	1.6	60	0.5	
JP55186005-W	5.5	1.8	60	0.5	
JP57207005-W	5.7	2.0	70	0.5	
JP58186005-W	5.8	1.8	60	0.5	
JP60175805-W	6.0	1.7	58	0.5	
JP63206705-W	6.3	2.0	67	0.5	
JP65207005-W	6.5	2.0	70	0.5	
JP70206505-W	7.0	2.0	65	0.5	
JP70236005-W	7.0	2.3	60	0.5	
JP80257505-W	8.0	2.5	75	0.5	
Jp50208205	5.0	2.0	82	0.5	0.2
JP531560F	5.3	1.5	60	0.5×45°	0.2
JP60308205F	6.0	3.0	82	0.5×45°	0.2
JP652070F	6.5	2.0	70	0.5×45°	0.2
JP803090F	8.0	3.0	90	0.5×45°	0.2
JP853082F	8.5	3.0	82	0.5×45°	0.2
JP1004082R15	10.0	4.0	82	1.5	0.2
JP1206082R15	12.0	6.0	82	1.5	0.4
JP1406082R15	14.0	6.0	82	1.5	0.4
JP1504067	15.0	4.0	67	0.5	0.4
JP1606082R15	16.0	6.0	82	1.5	0.4
JP1806082R15	18.0	6.0	82	1.5	0.4
JP2006082R15	20.0	6.0	82	1.5	0.4

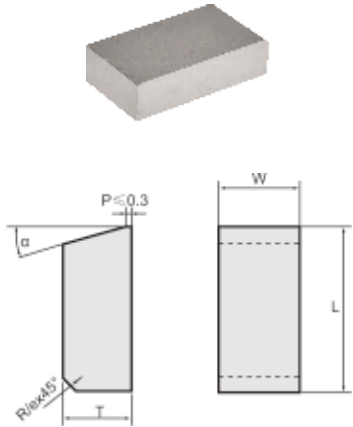
锯齿-JA系列
Saw Tips-JA Series



单位/Unit: 毫米/Minllimetre

型号 (Type)	L	T	$a1^\circ$	$a2^\circ$	L1	R
JA552010-W	5.5	2.0	39	80	1.23	1.0
JA602211-W	6.0	2.2	15	55	2.8	1.1
JA652010-W	6.5	2.0	40	40	1.37	1.0
JA652211-W	6.5	2.2	15	55	2.7	1.1
JA652211A-W	6.5	2.2	25	45	2.7	1.1
JA6522505-W	6.5	2.25	30	30	2.75	0.5
JA6522509-W	6.5	2.25	30	45	2.25	0.9
JA6523115-W	6.5	2.3	23.2	55	2.92	1.15
JA662010-W	6.6	2.0	30	50	1.56	1.0
JA702304-W	7.0	2.3	40	42	2.15	0.4
JA964824-W	9.6	4.8	21	53	3.6	2.4
JA995010-W	9.9	5.0	30	45	3.34	1.0

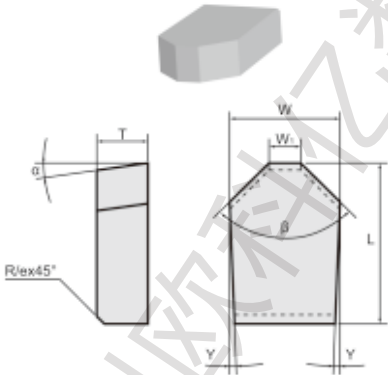
金属加工锯齿
Saw Tips for Metal Cutting



单位/Unit: 毫米/Minllimetre

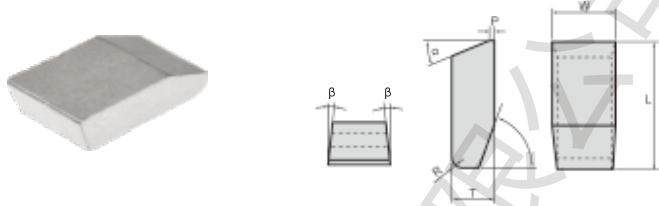
L × W × T	α °	R
5.5 × W × 1.6	8	0.5
5.5 × W × 2.0	10	0.5
6.0 × W × 2.0	10	0.5
6.5 × W × 2.2	10	0.5
7.5 × W × 2.5	8	0.5 × 45°
8.0 × W × 3.0	8	0.5 × 45°
8.5 × W × 3.0	8	0.5 × 45°
9.0 × W × 4.0	8	0.5 × 45°
10.0 × W × 4.0	8	0.5 × 45°
12.0 × W × 4.0	8	0.7 × 45°
13.0 × W × 6.0	8	0.5 × 45°
15.0 × W × 4.0	8	0.5 × 45°
17.0 × W × 5.0	8	0.5 × 45°
20.0 × W × 6.0	8	0.5 × 45°

单位/Unit: 毫米/Minllimetre



L × W × T	α °	W1	β °	γ °	R/e × 45°
7.1 × 7.2 × 4.0	8	2.0	90	/	0.5 × 45°
8.1 × 7.2 × 4.0	8	2.0	90	/	0.5 × 45°
11.8 × 8.7 × 4.0	8	2.3	120	1	0.7 × 45°
12.0 × 7.3 × 4.0	8	2.5	90	1	0.5 × 45°
12.3 × 9.3 × 4.0	8	2.7	90	1	0.7 × 45°
15.3 × 7.8 × 4.0	8	2.6	90	1	0.7 × 45°

欧洲标准锯齿
Saw Tips-European Style

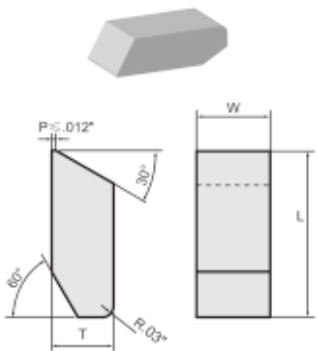


单位/Unit: 毫米/Minllimetre

L	W	T	α °	β °	γ
5.0	1.8/2.2/2.4/2.8/3.2/3.5/4.0	1.5	28	45	0
5.5	2.0/2.3/2.8/3.4/5.5	1.5	20	75	0
6.0	2.3/2.5/2.7/3.0/5.0	1.8	20	65	4
6.0	2.0/2.4/2.6/2.8/3.0/3.2/3.5/3.8/4.5/5.0	1.8	28	45	0
6.0	2.4/2.6/2.8/3.2/3.4/3.6/4.0/5.0	2.0	28	45	0
6.5	1.9/2.2/2.7/3.3/6.5	1.6	28	70	5
6.5	2.6/3.0/3.2/3.4/3.5/3.8/ 4.0/4.2/6.0	2.0	30	65	5
6.5	2.2/2.4/2.6/2.8/3.2/3.3/3.5/3.7/3.8/6.0	2.0	28	56	0
6.5	2.2/2.3/2.5/2.8/3.0/3.1/3.2/3.3/3.6/4.3/4.5/5.3/6.0	2.0	28	56	5
7.0	2.0/2.3/2.5/2.7/3.2/3.3/3.6/3.8/4.4/6.0	2.0	28	70	5
7.0	3.0/3.3/3.6/3.8/4.0/4.2/4.6/5.0	2.2	28	70	5
7.0	2.8/3.0/3.2/3.4/3.7/4.0/6.5/7.0	2.3	20	76	0
7.5	2.0/2.2/2.4/2.8/3.0/3.2/3.6/3.8/6.0	2.0	28	70	5
7.5	2.5/2.8/3.0/3.2/3.4/3.6/3.8/4.0/4.2/4.4/4.5/5.2/6.0	2.5	28	70	5
7.5	2.8/3.2/3.5/3.7/4.5/5.0/5.6/6.0/6.5	2.4	30	50	0
8.0	2.4/2.8/2.9/3.0/3.1/3.2/3.3/3.4/3.5/3.6/3.8/3.9/4.04.3/4.4/4.5/4.8/5.0/5.2/5.5/6.0/6.8/8.0	2.3	28	70	5
8.0	2.8/3.0/3.3/3.5/3.8/4.1/4.2/4.6/5.0/5.2/5.5/10.0	2.5	28	70	5
8.0	3.6/4.1/4.3/4.6/4.8/5.0/5.5/5.5/6.0	3.0	25	45	0
8.5	2.8/3.0/3.3/3.4/3.5/3.6/3.8/4.1/4.2/4.3/4.6/5.0/6.0	2.5	28	70	5
9.0	3.6/4.3/4.5/5.2/5.5	2.7	28	45	5
9.0	3.1/3.3/3.5/3.6/3.8/4.3/4.5/4.7/5.2/5.5/5.8/6.0	2.7	28	70	5
10.0	3.4/3.5/4.3/6.5	2.5	20	68	0
10.0	3.5/3.7/3.9/4.0/4.3/4.5/4.7/5.0/5.5/6.0/6.5/7.0/7.5/10.0	2.8	28	70	5
10.0	3.5/3.8/4.3/4.5/4.7/4.8/5.0/5.3/5.4/5.5/6.0	3.0	15	72	0
10.5	3.0/3.5/3.8/7.0	2.3	28	70	5
10.5	3.0/3.3/3.4/3.5/3.6/3.8/4.0/4.1/4.3/4.4/4.5/4.6/5.2/5.5/6.5	2.5	28	70	5
10.5	3.0/3.4/3.5/3.6/3.8/4.1/4.3/4.5/4.6/4.7/4.8/5.0/5.3/5.5/5.6/6.0/6.5/7.0/7.5/14.5	3.0	28	70	5
10.5	3.5/3.9/4.0/4.2/4.3/4.4/4.5/4.6/4.7/4.8/5.0/5.3/5.5/5.8/6.0/6.5/7.0/8.0/8.5/9.0/10.5	3.5	28	70	5
10.5	3.5/3.9/4.0/4.1/4.3/4.5/4.7/4.8/4.9/5.1/5.5/6.0/6.5/7.0/9.0	3.5	39	59	5
10.5	4.1/4.8/5.0/5.5/6.0/6.5/7.5/8.5/9.5/11.0	3.5	30	75	0
12.0	4.5/4.6/4.7/5.1/5.5/5.8/6.0/6.3/6.5/7.0/8.0/8.5/10.0/12.5/17.0	3.5	30	45	10

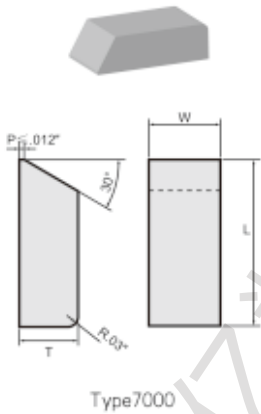
美国标准锯齿

Saw Tips U.S.-Canadian Style



Unit: inch

Code	L	W	T
CWB 7050-CWB 7500	.281	.050-.500	.078
CWD 7050-CWD 7500	.312	.050-.500	.093
CWE 7050-CWE 7500	.375	.050-.500	.093
CWF 7050-CWF 7800	.500	.050-.800	.125
CWG 7050-CWG 7800	.375	.050-.800	.125
CWH 7050-CWH 7800	.344	.050-.800	.125

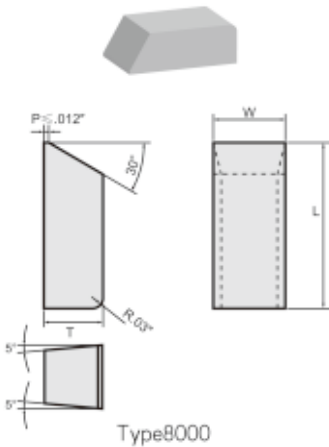


Unit: inch

Code	L	W	T
WA 7050-WA 7500	.250	.050-.500	.062
WB 7050-WB 7500	.281	.050-.500	.078
WC 7050-WC 7500	.281	.050-.500	.093
WD 7050-WD 7800	.312	.050-.800	.093
WE 7050-WE 7800	.375	.050-.800	.093
WF 7050-WF 7800	.500	.050-.800	.125
WG 7050-WG 7800	.375	.050-.800	.125
WH 7050-WH 7800	.344	.050-.800	.125
WQ 7050-WQ 7800	.375	.050-.800	.156

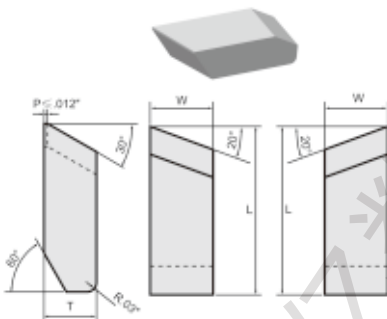
美国标准锯齿

Saw Tips U.S.-Canadian Style



Unit: inch

Code	L	W	T
WA 8050-WA 8500	.250	.050-.500	.062
WB 8050-WB 8500	.281	.050-.500	.078
WC 8050-WC 8500	.281	.050-.500	.093
WD 8050-WD 8800	.312	.050-.800	.093
WE 8050-WE 8800	.375	.050-.800	.093
WF 8050-WF 8800	.500	.050-.800	.125
WG 8050-WG 8800	.375	.050-.800	.125
WH 8050-WH 8800	.344	.050-.800	.125
WQ 8050-WQ 8800	.375	.050-.800	.156



Unit: inch

Code	L	W	T
CWD-R/L 7050-7500	.312	.050-.500	.093
CWE-R/L 7050-7500	.375	.050-.500	.093
CWF-R/L 7050-7500	.500	.050-.500	.125
CWG-R/L 7050-7500	.375	.230-.270	.125

Solid Carbide Saw Discs

硬质合金圆片

硬质合金圆片牌号性能

Grades of Solid Carbide Saw Discs

牌号 Grade	粘结相(%) Binder	密度(g/cm³) Density	硬度Hardness		抗弯强度 (MPa) TRS	ISO标准 Code ISO	推荐用途 Recommended cutting applications
			Hv10	HRA			
OKE600	12	14.10	1700	92.5	3600	K01~K10	超细晶粒，耐磨性及韧性优良，可切割高温合金、钛合金、不锈钢； Submiron grain,High wear resistance and toughness;Cutting high-temperature alloy,titanium alloy,stainless steel;
OKE616	10	14.45	1580	92.0	3500	K10	切割高温合金、钛合金、不锈钢、低碳钢、中碳钢； Cutting high-temperature alloy,titanium alloy,stainless stell,low carbon stell,medium carbon stell;
OKE615	7	14.8	1710	92.5	2700	K01~K10	切割有色金属、铸铁、铝合金（如换向器） Cutting non-ferrous metal, cast Iron, aluminum alloy, such as redirector.
OKE618	11	14.3	1620	92.2	3200	K10	切割高温合金、钛合金、不锈钢（如针机板） Cutting high-temperature alloy, titanium alloy,stainless steel, such as pin machine.
OKE628	10.5	14.50	1600	92.0	3000	K10	切割不锈钢、高温合金、钛合金、低碳钢、中碳钢 Cutting stainless steel, high temperature alloy, titanium alloy, low carbon steel, medium carbon steel.
OKE630	10	14.35	1550	91.7	2500	K10	切割不锈钢、低碳钢、中碳钢 Cutting stainless steel, low carbon steel, medium carbon steel.

硬质合金圆片
有库存型号

Stock Items of Solid Carbide Saw Discs

单位/Unit: 毫米/Minllimetre

规格(ΦD×Φd×T) Specifications	规格(ΦD×Φd×T) Specifications	规格(ΦD×Φd×T) Specifications	规格(ΦD×Φd×T) Specifications
OKEYP001	φ 3.8×φ 3.7×8.3	OKEYP010	φ 81.5×φ 15×1.0
OKEYP002	φ 25×φ 7.5×0.6	OKEYP011	φ 87×φ 30.5×1.3
OKEYP003	φ 25×φ 7.5×0.7	OKEYP012	φ 102×φ 21×1.0
OKEYP004	φ 33×φ 7.5×0.7	OKEYP013	φ 102×φ 20.5×1.0
OKEYP005	φ 41.5×φ 12×0.6	OKEYP014	φ 102×φ 48.5×1.45
OKEYP006	φ 51.5×φ 15.3×1.7	OKEYP015	φ 152×φ 30.5×1.0
OKEYP007	φ 64.5×φ 15.3×0.6	OKEYP016	φ 162×φ 24×1.0
OKEYP008	φ 64.5×φ 15.3×0.7	OKEYP017	φ 162×φ 30.5×1.0
OKEYP009	φ 76.5×φ 15×1.0	OKEYP018	φ 162×φ 30.5×1.2

硬质合金圆片
常用加工切削参数推荐表

Commonly Used Processing Cutting Parameters Recommended
List of Solid Carbide Saw Discs

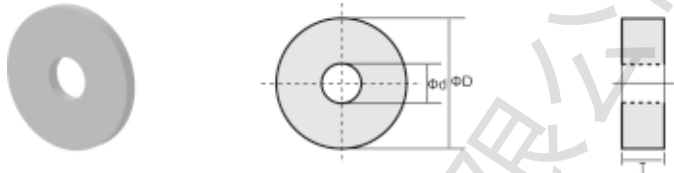
单位/Unit: 毫米/Minllimetre

被加工材料 Processed Material	线速度 (Vc(m/min) Linear Speed		每齿进给f(mm) Feed Rate/1 tooth
	不涂层 Non-coating	涂层 Coating	
铝合金 Aluminium alloy	500-1200	-	0.003-0.10
白铜, 黄铜 Cupronickel,Brass	400-800	-	0.003-0.10
不锈钢 Stainless steel	200-400	300-500	0.003-0.006
钛合金 Titanium alloy	150-250	200-300	0.003-0.006
低碳钢 Low carbon steel	200-350	300-500	0.003-0.10

被加工材料 Processed Material	线速度 (Vc(m/min) Linear Speed		每齿进给f(mm) Feed Rate/1 tooth
	不涂层 Non-coating	涂层 Coating	
中碳钢 Medium carbon steel	150-300	250-400	0.003-0.008
热处理钢HRC30-38° Heat-treatedsteel HRC30-38°	100-200	200-300	0.003-0.006
热处理钢HRC39-47° Heat-treatedsteel HRC39-47°	80-150	150-200	0.003-0.006
热处理钢HRC48-55° Heat-treatedsteel HRC48-55°	50-100	100-150	0.003-0.006
铸铁 Cast iron	250-350	300-400	0.02-0.30

硬质合金圆片
其它规格

Solid Carbide Saw Discs



单位/Unit: 毫米/Minllimetre

规格(ΦD×Φd×T) Specifications	规格(ΦD×Φd×T) Specifications	规格(ΦD×Φd×T) Specifications	规格(ΦD×Φd×T) Specifications	规格(ΦD×Φd×T) Specifications	规格(ΦD×Φd×T) Specifications
Φ5×Φ2.5×T	Φ15.7×Φ5.7×T	Φ33×Φ5.5×T	Φ58×Φ24×T	Φ81.5×Φ24×T	Φ113×Φ18×T
Φ8.7×Φ2.0×T	Φ16×Φ2×T	Φ33×Φ7.2×T	Φ61.5×Φ9.5×T	Φ82×Φ12×T	Φ118×Φ45×T
Φ8.7×Φ3.7×T	Φ16×Φ4.5×T	Φ33×Φ7.5×T	Φ61.5×Φ11.5×T	Φ82×Φ24×T	Φ118×Φ86.5×T
Φ10×Φ3.2×T	Φ16×Φ4.7×T	Φ33×Φ9.2×T	Φ61.5×Φ15×T	Φ82×Φ30.5×T	Φ122×Φ10.5×T
Φ10.7×Φ3.7×T	Φ16.5×Φ3×T	Φ33×Φ11.5×T	Φ61.5×Φ21×T	Φ83×Φ25.5×T	Φ122×Φ21×T
Φ10.7×Φ3×T	Φ16.5×Φ7.7×T	Φ37×Φ7.5×T	Φ61.5×Φ24×T	Φ86.5×Φ15×T	Φ122×Φ24×T
Φ11.7×Φ5.7×T	Φ16.7×Φ5.7×T	Φ37×Φ12×T	Φ64.5×Φ12×T	Φ86.5×Φ21×T	Φ122×Φ38.5×T
Φ11×Φ3×T	Φ17×Φ4.2×T	Φ37.5×Φ12×T	Φ64.5×Φ15×T	Φ87×Φ24×T	Φ126×Φ21.5×T
Φ12×Φ4.2×T	Φ17×Φ4.5×T	Φ39.5×Φ15×T	Φ64.5×Φ21×T	Φ87×Φ30.5×T	Φ127×Φ20.5×T
Φ12×Φ4.5×T	Φ17×Φ4.7×T	Φ41.5×Φ12×T	Φ67×Φ15×T	Φ91.5×Φ21.5×T	Φ127×Φ68.5×T
Φ12.7×Φ3.7×T	Φ17×Φ5.2×T	Φ41.5×Φ8.5×T	Φ67×Φ24.5×T	Φ91.5×Φ24.3×T	Φ127×Φ21×T
Φ12.7×Φ5.7×T	Φ17×Φ5.5×T	Φ41.5×Φ9.5×T	Φ71.5×Φ12×T	Φ92.5×Φ24.5×T	Φ127×Φ24×T
Φ13×Φ3.5×T	Φ17.5×Φ4.2×T	Φ42×Φ5.6×T	Φ71.5×Φ15×T	Φ96.5×Φ20.5×T	Φ132×Φ20.5×T
Φ13×Φ4.5×T	Φ17.5×Φ5.5×T	Φ42×Φ7.5×T	Φ71.5×Φ20.5×T	Φ96.5×Φ24.5×T	Φ132×Φ30.5×T
Φ13×Φ5.6×T	Φ17.7×Φ5.7×T	Φ42×Φ8.5×T	Φ72×Φ12×T	Φ96.5×Φ30.5×T	Φ152×Φ21×T
Φ13×Φ5.6×T	Φ20×Φ5.2×T	Φ46.5×Φ12×T	Φ72×Φ15×T	Φ101.5×Φ15×T	Φ152×Φ24×T
Φ13.5×Φ2.0×T	Φ20×Φ7.5×T	Φ46.5×Φ15×T	Φ72×Φ24×T	Φ102×Φ12×T	Φ152×Φ30.5×T
Φ13.7×Φ5.7×T	Φ21×Φ3×T	Φ47×Φ9.2×T	Φ76.5×Φ15×T	Φ102×Φ20.5×T	Φ162×Φ20.5×T
Φ13.7×Φ3.5×T	Φ21×Φ4.5×T	Φ47×Φ12×T	Φ76.5×Φ21×T	Φ102×Φ21×T	Φ162×Φ24×T
Φ14×Φ4.2×T	Φ21×Φ7.5×T	Φ51.5×Φ8.5×T	Φ76.5×Φ24×T	Φ102×Φ24×T	Φ162×Φ30.5×T
Φ14×Φ4.5×T	Φ22×Φ7.5×T	Φ51.5×Φ9.5×T	Φ76.5×Φ30.5×T	Φ102×Φ30.5×T	Φ162×Φ38.5×T
Φ14×Φ5.2×T	Φ22×Φ9.2×T	Φ51.5×Φ12×T	Φ77×Φ12×T	Φ102×Φ38×T	Φ171×Φ24×T
Φ14×7.5×T	Φ23×Φ7.5×T	Φ51.5×Φ15×T	Φ77×Φ15×T	Φ102×Φ48.5×T	Φ182×Φ30×T
Φ14.5×7.5×T	Φ25×Φ7.5×T	Φ52×Φ7.5×T	Φ77×Φ21×T	Φ102×Φ58×T	Φ203×Φ30.5×T
Φ14.7×Φ5.7×T	Φ26×Φ5.2×T	Φ52×Φ12×T	Φ77.5×Φ15×T	Φ104×Φ30.5×T	Φ228×Φ20.5×T
Φ14.7×Φ7.5×T	Φ26×Φ7.5×T	Φ52×Φ15×T	Φ77.5×Φ24×T	Φ108×Φ24×T	Φ252×Φ30.5×T
Φ15×Φ4×T	Φ26×Φ7.2×T	Φ52×Φ24×T	Φ79×Φ24×T	Φ108×Φ30.5×T	Φ284×Φ20×T
Φ15×Φ4.7×T	Φ26×Φ9.2×T	Φ57×Φ12×T	Φ81.5×Φ15×T	Φ112×Φ24.5×T	Φ263×Φ155×T
Φ15×Φ5.5×T	Φ28.7×Φ8.2×T	Φ57×Φ15×T	Φ81.5×Φ21×T	Φ112×Φ25.4×T	Φ300×Φ152×T
Φ15.7×Φ5.7×T	Φ28.7×Φ7.5×T	Φ58×Φ21×T	Φ81.5×Φ24×T	Φ112×Φ30.5×T	Φ314×Φ217.5×T

Carbide Rods

硬质合金圆棒

金属用硬质合金圆棒 牌号介绍

Grade Introduction Of Carbide Rods For Metal Cutting

牌号 Grade	ISO牌号 ISO	晶粒度 (μm) Grain Size	钴含量(%) Cobalt Content	硬度 (HRA) Hardness	密度 (g/cm^3) Density	抗弯强度 (N/mm^2) T.R.S	推荐用途 Recommended cutting applications
OKE800	K05-K10	0.2	9	94	14.45	4200	纳米晶粒，推荐加工高硬材料（HRC大于58）精加工，适合材料表面高光处理。 Nanometer grain size, recommended to process high hardness material (HRC > 58) finishing, suitable for material surface high gloss treatment.
OKE801	K05-K10	0.4	6	94	14.80	3800	超细晶粒，具有优良的耐磨性，推荐用于制作具有高耐磨性要求的铣刀、雕刻刀，适用于加工PCB、复合材料 Ultrafine grain size, with excellent wear resistance. High wear resistance endmill and engraving tools are recommended. Suitable for cutting PCB and composite material.
OKE805	K20-K40	0.4	12.0	92.6	14.10	4200	超细晶粒，兼容了良好的硬度和韧性，适用于制作立铣刀和铰刀，特别适用于精加工以及加工合金钢（HRC：45-55），铝合金，钛合金等 Ultrafine grain size, higher Co Content, with excellent hardness and toughness. Endmill and reamer are recommended. Especially suitable for finish machining and steel (HRC:45-55), Al alloy and Ti alloy cutting.
OKE812	K20-K40	0.6	10	92.4	14.40	4000	用于制作通用加工钻头，立铣刀，特别适用于不锈钢，耐热合金，铸铁等 Common-use drill and endmill are recommended. Especially suitable for cutting stainless, heat-resistant alloy, cast iron.
OKE816	K20-K40	0.6	12	91.6	14.10	4200	用于制作立铣刀，特别适用于不锈钢，耐热合金，铸铁等 Used to make vertical milling cutter, especially suitable for stainless steel, heat-resistant alloy, cast iron, etc
OKE808	K20-K40	0.8	10	91.8	14.45	4000	用于制作钻头，立铣刀，适用于普通合金钢（HRC<48），灰口铸铁，不锈钢和耐热合金 Drill and endmill are recommended. Suitable for cutting general steel(HRC<48), grey cast iron, stainless steel and heat-resistant alloy.
OKE810	K15	1.0	6.0	92.5	14.95	2600	用于制作钻头，立铣刀和旋转锉刀，特别适用于加工有色金属和石墨制品（需涂层） Drill, endmill and burr are recommended. Especially suitable for cutting non-ferrous metal and graphite (coating is necessary).

牌号推荐

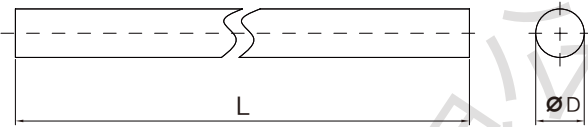
Grade Selection Guide

加工材料 Workpiece		刀具类别 Type of Cutting Tools		OKE800	OKE801	OKE805	OKE816	OKE812	OKE808	OKE810
P	钢 Steel	钻头 Drill						★	★ ★	
		立铣刀 Endmill	粗加工Roughing						★ ★	
			精加工Finishing			★ ★		★ ★	★	
M	不锈钢 Stainless Steel	钻头 Drill					★ ★	★	★ ★	
		立铣刀 Endmill	粗加工Roughing				★ ★		★	
			精加工Finishing	★			★	★ ★		
K	铸铁 Cast Iron	钻头 Drill						★	★ ★	
		立铣刀 Endmill	粗加工Roughing						★ ★	
			精加工Finishing					★	★	★ ★
N	有色金属 Nonferrous Material	钻头 Drill							★ ★	●
		立铣刀 Endmill	粗加工Roughing						★ ★	
			精加工Finishing			★ ★				●
S	耐热合金 Heat Resistance Material	钻头 Drill						★	★ ★	
		立铣刀 Endmill	粗加工Roughing					★	★	
			精加工Finishing			★ ★		★	★	
H	高硬材料 Hardened Material	钻头 Drill			★ ★			★		
		立铣刀 Endmill	粗加工Roughing	★	★					
			精加工Finishing	★ ★	★	★				
Others	复合材料 Composite Material	钻头 Drill			★ ★			★		
		立铣刀 Endmill	粗加工Roughing	★	★ ★					
			精加工Finishing	★	★	★				

推荐图例Notes 可用Acceptable★优选Good★ ★涂层Coating●

公制长棒

Solid Rods-Metric



●=有库存 Stock ○=需订货 Order 单位unit(mm)

直径ΦD	长度L	OKE808/OKE805	OKE812	直径ΦD	长度L	OKE808/OKE805	OKE812
2	330	●	○	10	310	●	●
3	310	●	●	10	330	●	●
3	330	●	●	11	330	●	●
4	310	●	●	12	310	●	●
4	330	●	●	12	330	●	●
5	310	●	●	13	330	●	○
5	330	●	●	14	310	●	●
6	310	●	●	14	330	●	●
6	330	●	●	15	330	●	○
7	330	●	○	16	310	●	●
8	310	●	●	16	330	●	●
8	330	●	●	17	330	●	○
9	330	●	○	18	330	●	●



毛坯 Unground

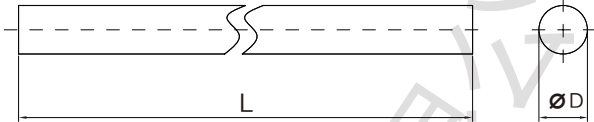


精磨 Ground

毛坯Unground ΦD(mm)		精磨Ground ΦD(mm)		长度L(mm)
范围(Range)	公差(Tol.)	范围(Range)	公差(Tol.)	
2≤ΦD<3	+0.15, +0.30			
3≤ΦD≤6	+0.30, +0.50			
6<ΦD≤12	+0.30, +0.60	2≤ΦD≤42	h5/h6	0,+5
12<ΦD≤16	+0.30, +0.70			
16<ΦD≤42	+0.30, +0.80			

公制长棒

Solid Rods-Metric



●=有库存 Stock ○=需订货 Order 单位unit(mm)

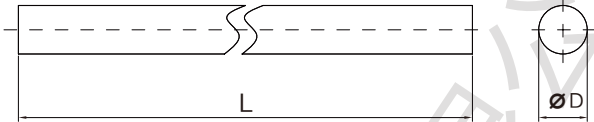
直径ΦD	长度L	OKE808/OKE805	OKE812	直径ΦD	长度L	OKE808/OKE805	OKE812
19	330	●	○	31	330	○	○
20	310	●	○	32	330	○	○
20	330	●	●	33	330	○	○
21	310	○	○	34	330	○	○
22	330	○	○	35	330	○	○
23	310	○	○	36	330	○	○
24	330	○	○	37	330	○	○
25	310	●	○	38	330	○	○
26	330	○	○	39	330	○	○
27	330	○	○	40	330	○	○
28	310	○	○	41	330	○	○
29	330	○	○	42	330	○	○
30	330	○	○				



毛坯Unground ΦD(mm)		精磨Ground ΦD(mm)		长度L(mm)
范围(Range)	公差(Tol.)	范围(Range)	公差(Tol.)	
2≤ΦD<3	+0.15, +0.30	2≤ΦD≤42	h5/h6	0,+5
3≤ΦD≤6	+0.30, +0.50			
6<ΦD≤12	+0.30, +0.60			
12<ΦD≤16	+0.30, +0.70			
16<ΦD≤42	+0.30, +0.80			

英制长棒

Solid Rods-Inch



●=有库存 Stock ○=需订货 Order 单位unit(mm)

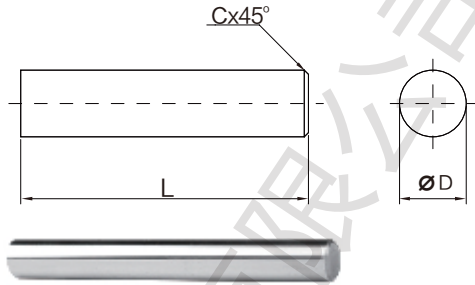
直径ΦD	长度L	OKE808/OKE805	OKE812	直径ΦD	长度L	OKE808/OKE805	OKE812
0.1250	13-1/8	○	○	0.4063	12-1/8	○	○
0.1406	13-1/8	○	○	0.4219	12-1/8	○	○
0.1563	13-1/8	○	○	0.4375	12-1/8	○	○
0.1719	13-1/8	○	○	0.4531	12-1/8	○	○
0.1875	13-1/8	○	○	0.4688	12-1/8	○	○
0.2188	13-1/8	○	○	0.4844	12-1/8	○	○
0.2344	13-1/8	○	○	0.5000	12-1/8	○	○
0.2500	13-1/8	○	○	0.5313	12-1/8	○	○
0.2813	12-1/8	○	○	0.5625	12-1/8	○	○
0.2969	12-1/8	○	○	0.6250	12-1/8	○	○
0.3125	12-1/8	○	○	0.6875	12-1/8	○	○
0.3281	12-1/8	○	○	0.7500	12-1/8	○	○
0.3438	12-1/8	○	○	0.8125	12-1/8	○	○
0.3594	12-1/8	○	○	0.8750	12-1/8	○	○
0.3750	12-1/8	○	○	0.9375	12-1/8	○	○
0.3906	12-1/8	○	○	1.0000	12-1/8	○	○



毛坯Unground ΦD(mm)		精磨Ground ΦD(mm)		长度L(mm)
范围(Range)	公差(Tol.)	范围(Range)	公差(Tol.)	
1/8≤ΦD≤1/4	+0.012,+0.020	1/8≤ΦD≤1	h5/h6	+1/8,+3/8
1/4<ΦD≤31/64	+0.012,+0.024			
31/64<ΦD≤5/8	+0.012,+0.028			
5/8<ΦD≤1	+0.012,+0.032			

精磨倒角短棒
(公制)

Ground Rods with
Chamfer-Metric

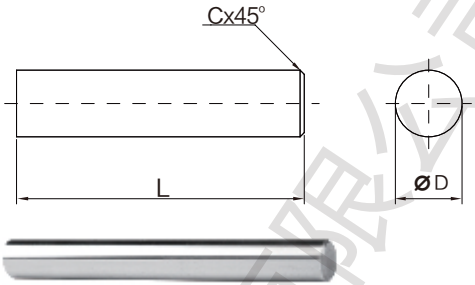


单位unit(mm)

直径 ΦD	长度 L (公差Tol./0,+1)	倒角尺寸 C (公差Tol./±0.1)	倒角角度 Angle of Chamfer (公差Tol./±3°)	直径 ΦD	长度 L (公差Tol./0,+1)	倒角尺寸 C (公差Tol./±0.1)	倒角角度 Angle of Chamfer (公差Tol./±3°)
3	40	0.4	45°	8	80	0.6	45°
3	50	0.4	45°	8	90	0.6	45°
3	70	0.4	45°	8	100	0.6	45°
3	100	0.4	45°	8	150	0.6	45°
3	150	0.4	45°	10	70	0.6	45°
4	40	0.4	45°	10	75	0.6	45°
4	50	0.4	45°	10	90	0.6	45°
4	75	0.4	45°	10	100	0.6	45°
4	100	0.4	45°	10	125	0.6	45°
4	150	0.4	45°	11	110	0.8	45°
5	50	0.5	45°	12	75	0.8	45°
5	55	0.5	45°	12	90	0.8	45°
5	60	0.5	45°	12	100	0.8	45°
5	70	0.5	45°	12	120	0.8	45°
5	80	0.5	45°	14	75	0.8	45°
5	100	0.5	45°	14	110	0.8	45°
5	150	0.5	45°	14	125	0.8	45°
6	50	0.5	45°	16	100	0.8	45°
6	60	0.5	45°	16	125	0.8	45°
6	75	0.5	45°	18	100	0.8	45°
6	100	0.5	45°	18	150	0.8	45°
6	150	0.5	45°	20	100	1.0	45°
7	55	0.6	45°	20	120	1.0	45°
7	60	0.6	45°	20	150	1.0	45°
8	60	0.6	45°	25	100	1.0	45°
8	75	0.6	45°	25	150	1.0	45°

精磨倒角短棒
(英制)

Ground Rods with
Chamfer-Inch

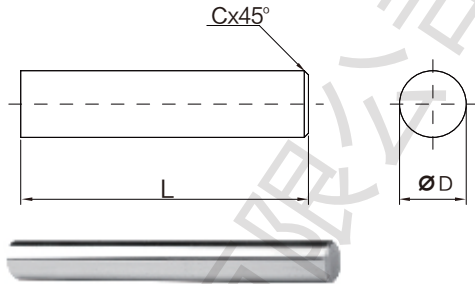


单位unit(mm)

直径 ΦD	长度 L (公差Tol./0,+1/16)	倒角尺寸		倒角角度 Angle of Chamfer (公差Tol./±3°)
		C	公差Tol	
0.1250	1-1/2	0.015	±0.004	45°
0.1250	2	0.015	±0.004	45°
0.1250	2-1/2	0.015	±0.004	45°
0.1250	3	0.015	±0.004	45°
0.1875	2	0.015	±0.004	45°
0.1875	3	0.015	±0.004	45°
0.2500	2	0.015	±0.004	45°
0.2500	2-1/2	0.015	±0.004	45°
0.2500	3	0.015	±0.004	45°
0.2500	4	0.015	±0.004	45°
0.3125	2-1/2	0.015	±0.004	45°
0.3750	2-1/2	0.015	±0.004	45°
0.3750	3	0.015	±0.004	45°
0.5000	2-1/2	0.031	±0.008	45°
0.5000	3	0.031	±0.008	45°
0.5000	4	0.031	±0.008	45°
0.6250	3-1/2	0.031	±0.008	45°
0.7500	4	0.031	±0.008	45°
0.7500	5	0.031	±0.008	45°
1.0000	4	0.031	±0.008	45°

精磨倒角短棒
(DIN)

Ground Rods with
Chamfer-DIN

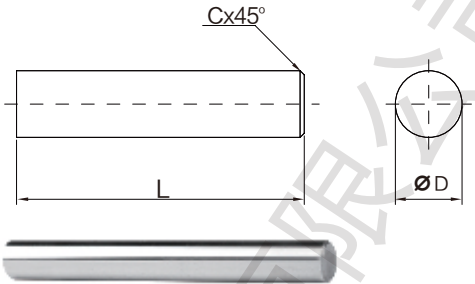


单位unit(mm)

直径 ΦD	长度 L (公差Tol./0,+1/16)	倒角尺寸 C (公差Tol./±0.1)	倒角角度 Angle of Chamfer (公差Tol./±3°)	标准 Standard
3	38	0.4	45°	D6527K/D6527L
3.5	50	0.4	45°	D6528
4	50	0.4	45°	D6528
4.5	50	0.5	45°	D6528
5	50	0.5	45°	D6528
5.5	57	0.5	45°	D6528
6	50	0.5	45°	D6527K
6	57	0.5	45°	D6527L/D6528
6	54	0.5	45°	D6527K
6.5	60	0.6	45°	D6528
7	60	0.6	45°	D6528
7.5	63	0.6	45°	D6528
8	58	0.6	45°	D6527K
8	63	0.6	45°	D6527L/D6528
8.5	67	0.6	45°	D6528
9	67	0.6	45°	D6528
9.5	72	0.6	45°	D6528
10	66	0.6	45°	D6527K
10	72	0.6	45°	D6527L/D6528
11	83	0.8	45°	D6528
12	73	0.8	45°	D6527K
12	83	0.8	45°	D6527L/D6528
13	83	0.8	45°	D6528
14	75	0.8	45°	D6527K
14	83	0.8	45°	D6527L/D6528
15	92	0.8	45°	D6528
16	82	0.8	45°	D6527K
16	92	0.8	45°	D6527L/D6528
18	84	0.8	45°	D6527K
18	92	0.8	45°	D6527L/D6528
20	92	1.0	45°	D6527K
20	104	1.0	45°	D6527L/D6528

精磨倒角短棒
(DIN)

Ground Rods with
Chamfer-DIN



单位unit(mm)

直径 ΦD	长度 L (公差Tol./0,+1/16)	倒角尺寸 C (公差Tol./±0.1)	倒角角度 Angle of Chamfer (公差Tol./±3°)	标准 Standard
3	47	0.4	45°	D6539
4	56	0.4	45°	D6539
5	63	0.5	45°	D6539
6	63	0.5	45°	D6537K
6	67	0.5	45°	D6537K/D6537L/D6539
6	75	0.5	45°	D6537L
6	83	0.5	45°	D6537L
7	75	0.6	45°	D6539
8	80	0.6	45°	D6537K/D6539
8	92	0.6	45°	D6537L
9	85	0.6	45°	D6539
10	90	0.6	45°	D6537K/D6539
10	104	0.6	45°	D6537L
11	96	0.8	45°	D6539
12	103	0.8	45°	D6537K/D6539
12	119	0.8	45°	D6537L
13	103	0.8	45°	D6539
14	108	0.8	45°	D6537K/D6539
14	125	0.8	45°	D6537L
15	112	0.8	45°	D6539
16	116	0.8	45°	D6537K/D6539
16	134	0.8	45°	D6537L
17	120	0.8	45°	D6539
18	124	0.8	45°	D6537K/D6539
18	144	0.8	45°	D6537L
19	128	1.0	45°	D6539
20	132	1.0	45°	D6537K/D6539
20	154	1.0	45°	D6537L



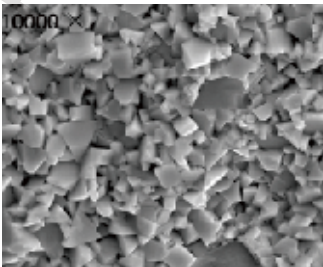
木工用硬质合金圆棒牌号介绍

Carbide Rod Grades for Wood Cutting

牌号 Grade	ISO	成分 Composition	切削应用 Cutting Applications	显微组织 Microstructure
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WP03	<K01	Co:2.850%, WC balance,Other0.65%	刨花板 密度板 Chipboard Density Board
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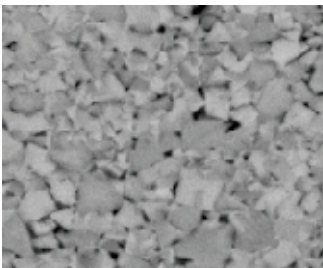
晶粒度 Grainsize	密度 Density	硬度 Hardness	强度 TRS	断裂韧性 Kic
Ultrafine grain 0.2~0.4um	15.2g/cm³	94.5HRA	3200MPa	8.5MPa.m ^{1/2}



牌号 Grade	ISO	成分 Composition	切削应用 Cutting Applications	显微组织 Microstructure
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WP10	<K01	Co:3.0%, WC balance,Other0.55%	密度板 Density Board
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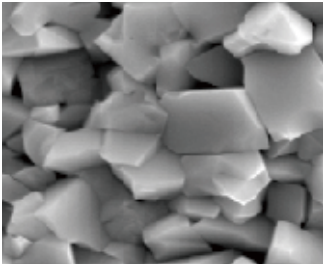
晶粒度 Grainsize	密度 Density	硬度 Hardness	强度 TRS	断裂韧性 Kic
Ultrafine grain 0.6um	15.15g/cm³	93.8HRA	3400MPa	8.8MPa.m ^{1/2}



牌号 Grade	ISO	成分 Composition	切削应用 Cutting Applications	显微组织 Microstructure
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WP20	K20	Co:8.0%, WC balance	实木（软木、硬木） Wood（Soft Wood、Hard Wood）
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晶粒度 Grainsize	密度 Density	硬度 Hardness	强度 TRS	断裂韧性 Kic
Ultrafine grain 1.0~1.2um	14.7g/cm³	91.6HRA	3800MPa	11MPa.m ^{1/2}

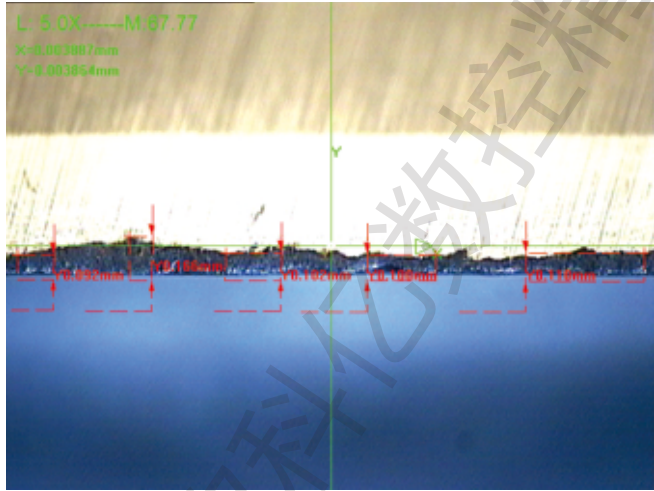
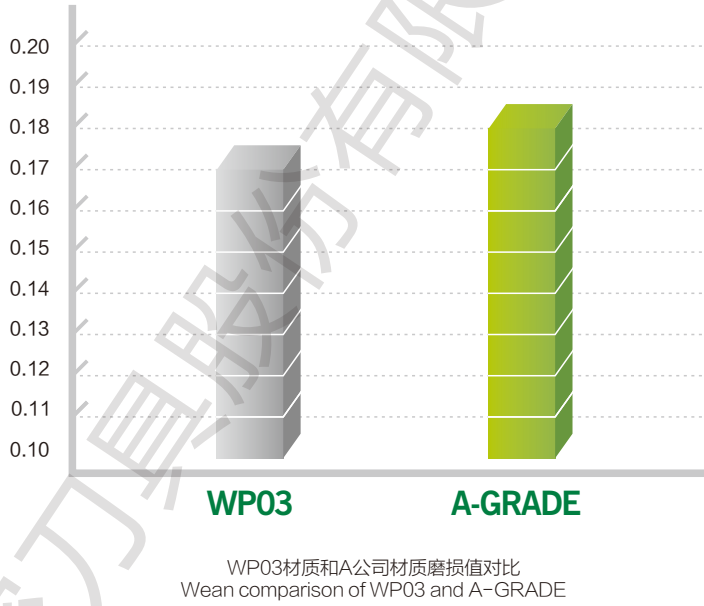


具备优异的抗冲击能力，适用于各类实木材质切削加工

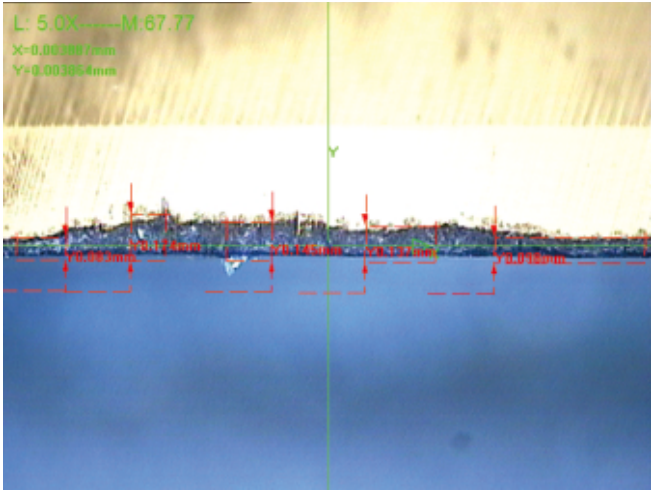
WP03牌号切削实验数据对比

Cutting Experimental Data With WP03

- 切削材质
Cutting Material
- 刨花板
Chipboard
- 切削设备
Cutting Machine
- 数控雕刻机
CNC Engraving Machine
- 切削刀具
Cutting Tool
- 三刃开料刀
TCT 3-Edge Straight Bit



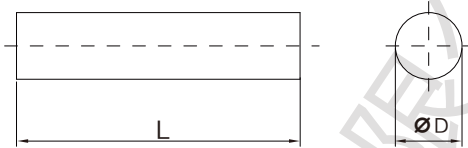
WP03牌号刀具刃口磨损图
WP03 cutter edge wear figure



国外某公司牌号刀具刃口磨损图
A-grade cutter edge wear figure

木工圆棒
常用规格型号

Carbide Rod Common
Specifications for Wood Cutting



单位unit(mm)

直径ΦD	长度L	直径ΦD	长度L	直径ΦD	长度L
6.3	20	8.3	20	10.3	20
6.3	22	8.3	22	10.3	22
6.3	24	8.3	24	10.3	24
6.3	26	8.3	26	10.3	26
6.3	28	8.3	28	10.3	28
6.3	30	8.3	30	10.3	30
6.3	32	8.3	32	10.3	32
6.3	34	8.3	34	10.3	34
6.3	36	8.3	36	10.3	36
6.3	38	8.3	38	10.3	38
6.3	40	8.3	40	10.3	40
6.3	42	8.3	42	10.3	42
6.3	44	8.3	44	10.3	44
6.3	46	8.3	46	10.3	46

外径公差 (mm) D(Tol.)	长度公差 (mm) L(Tol.)
D (+0.05) (+0.0)	L (+0.3) (+0.0)

公差等级

Carbide Rod Tolerances

精磨外径公差

Tol. of Ground Rods' Diameter

“h” 的公差均为+0.0/- “h” Tolerance all +0.0/-

DIAMETER	h5	h6	h7
0-3.0mm	0.004mm	0.006mm	0.010mm
0-0.1181in.	0.00015in.	0.00024in.	0.00039in.
3.001-6.0mm	0.005mm	0.008mm	0.012mm
0.1181-0.2362in.	0.00020in.	0.00031in.	0.00047in.
6.001-10.0mm	0.006mm	0.009mm	0.015mm
0.2363-0.3937in.	0.00024in.	0.00035in.	0.00059in.
10.001-18.0mm	0.008mm	0.011mm	0.018mm
0.3938-0.7087in.	0.00031in.	0.00043in.	0.00071in.
18.001-30.0mm	0.009mm	0.013mm	0.021mm
0.7088-1.1811in.	0.00035in.	0.00051in.	0.00083in.
30.001-50.0mm	0.011mm	0.016mm	0.025mm
1.1812-1.9685in.	0.00043in.	0.00063in.	0.00098in.

棒材表面粗糙度

Surface Roughness of Rods

类型 Type	精度 Accuracy
镜面棒材 Polished Rods	0.00-0.05 μ m
亚光洁度 Dull Finished	0.10-0.20 μ m
精磨棒材 Ground Rods	0.00-0.10 μ m

圆度

Roundness Tolerance

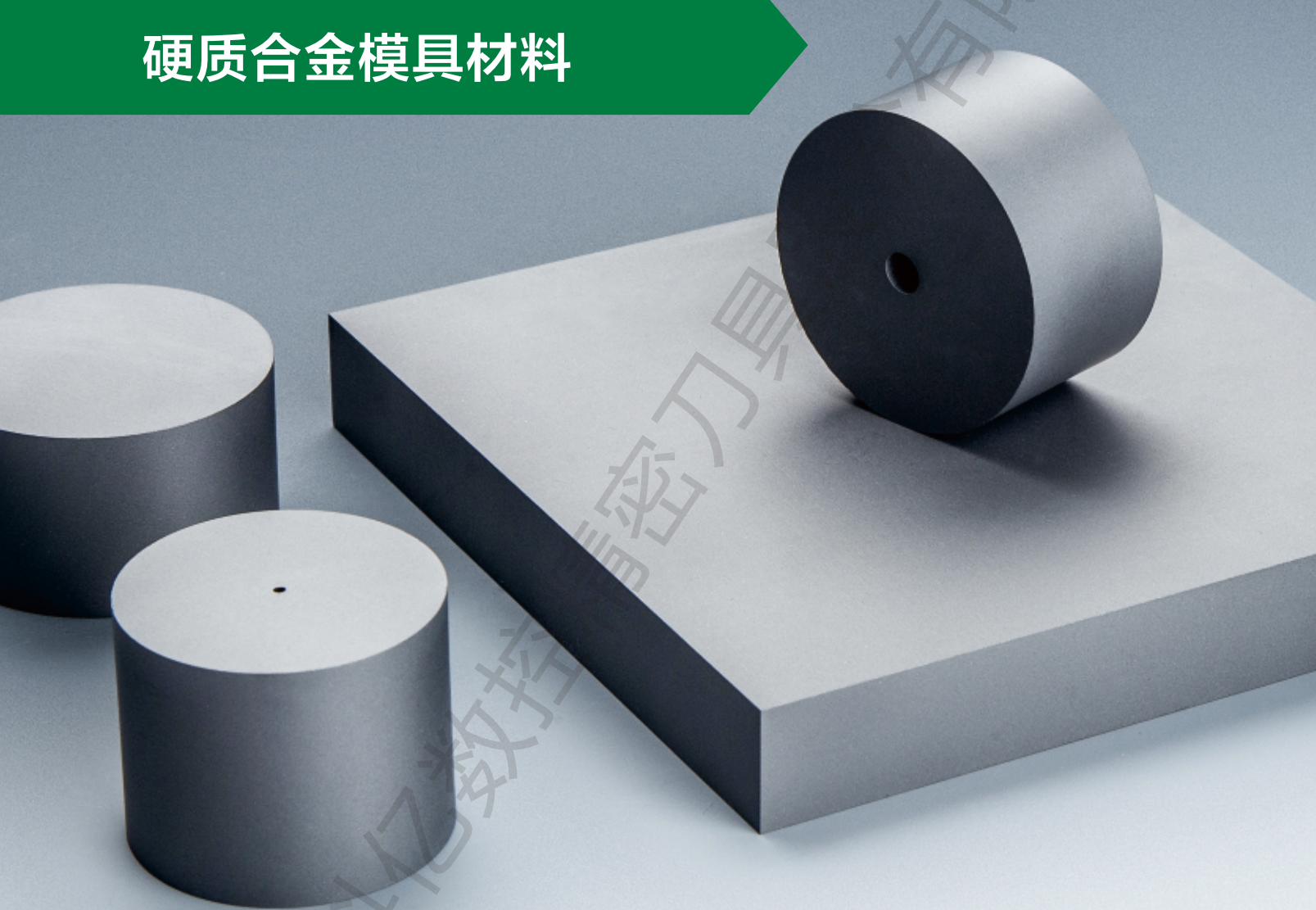
精磨圆棒圆度标准均为0.002 mm

The standard roundness
tolerance of the ground rod is
0.002 mm.



Carbide Die Material

硬质合金模具材料



粉末冶金用模具材料牌号性能及适用范围

Grade Property and Application of Die Material for PM

牌号 Grade	钴含量 Co(%)	WC晶粒度 (μm)	硬度 Hardness	密度(g/m^3) Density	抗弯强度 (MPa) TRS	推荐用途 Recommended Cutting Applications
OKEG8	8	1.6	90.2	14.8	3000	通用性能好，制作一般的粉末压制成型模具 Good general performance, PM pressing forming die
OKE712	12	1.4	89.3	14.2	3500	制作高精密粉末压制成型模具，如数控刀片压制成型模具 High precision powder pressing forming die, like CNC insert pressing forming die
OKE715	15	1.4	88.5	13.9	3500	

电机模用级进模具材料牌号性能及适用范围

Grade Property and Application of Die Material for Electric Tools

牌号 Grade	钴含量 Co(%)	WC晶粒度 (μm)	硬度 Hardness	密度(g/m^3) Density	抗弯强度 (MPa) TRS	推荐用途 Recommended Cutting Applications
OKE712	12	1.4	89.3	14.2	3500	硅钢片（上模）冷轧板（上模）（下模） Silicon steel sheet (upper die) Cold rolled sheet (top die) (bottom die)
OKE715	15	1.4	88.5	13.9	3500	硅钢片（上模）冷轧板（下模） Silicon steel sheet (upper die) Cold rolled sheet (bottom die)
OKE720	20	1.2	86.4	13.5	3200	硅钢片（下模） Silicon steel sheet (bottom die)

IC模用级进模具材料牌号性能及适用范围

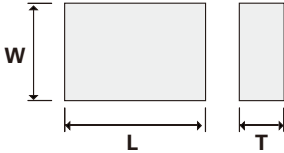
Grade Property and Application of Die Material for IC

牌号 Grade	钴含量 Co(%)	WC晶粒度 (μm)	硬度 Hardness	密度(g/m^3) Density	抗弯强度 (MPa) TRS	推荐用途 Recommended Cutting Applications
OKE710	10	0.8	91.8	14.4	3800	厚度小于0.2毫米的铜、铝等薄片 Thin films of copper, aluminum, etc. less than 0.2 mm in thickness
OKE722	11	0.6	92.2	14.2	3800	铜、铝、不锈钢等薄片 Thin sections of copper, aluminum, stainless steel, etc
OKE725	12	0.4	92.2	14.1	4500	铜、铝、不锈钢等薄片 Thin sections of copper, aluminum, stainless steel, etc
OKE730	15	0.4	90.5	13.9	4500	EI片、SPCC板等 EI chip, SPCC board, etc

板材规格型号及公差范围

Carbide Plate Specification and Tolerance

规格 Specification	长度L宽度W 公差(mm)	厚度T公差(mm)				
		1.5~5	>5~10	>10~30	>30~50	>50~70
100×100	+5.0	+0.3	+0.5	+0.8	+1.0	+1.20
120×120	+5.0	+0.3	+0.5	+0.8	+1.0	+1.20
150×150	+7.0	+0.3	+0.5	+0.8	+1.0	+1.20
200×200	+7.0	/	+0.5	+0.8	/	/



板块供货态：上下面平磨，HIP及去应力处理。

Plate moulds supply state:
surface grinding, HIP and stress treatment

Carbide Strips

硬质合金长条

长条牌号性能

Grades Property

牌号 Grade	粘结相(%) Binder	密度(g/cm³) Density	硬度(HRA) Hardness	抗弯强度 (MPa) TRS
RF17	6.0	14.95	92.3	2300
RF19	10	14.40	91.8	2600
RM36	8	14.70	90.8	2300

切削推荐应用

Recommended Applications

牌号 Grade	软木/硬木 Softwood/Hardwood	密度板 Fiberboard	刨花板 Chipboard
RF17	★	★★	★★
RF19	★★	★★	★
RM36	★★★	☆	☆

推荐图例说明 Notes:
☆ 不合适 Not suitable
★ 可切削 Acceptable
★★ 切削效果好 Good
★★★ 切削效果非常好 Very Good

Carbide Tips for Router Bits

硬质合金木工铣铣刀

铣铣刀牌号性能

Grade Property

牌号 Grade	粘结相(%) Binder	密度(g/cm³) Density	硬度Hardness		抗弯强度 (MPa) TRS	断裂韧性 (Mpa.m ^{1/2}) K _{IC}	ISO标准 Code ISO	美国标准 Code U.S.
			Hv10	HRA				
OKE403	2.8	15.2	2080	94.2	2500	7.8	—	—
OKE302	4	15	1910	93.6	2400	8.7	—	—
OKE217	5.5	14.9	1650	92.2	2300	10	K10	C3
OKE211	8	14.7	1420	90.5	2500	10.5	K30	C1

切削推荐应用

Recommended Applications

牌号 Grade	刨花板 Chipboard	密度板 Fiberboard	胶合板 Plywood	大芯板 Big Core Board	红木 Rosewood	软木 Softwood	亚克力板 Acrylic Board	石墨 Graphite
OKE403	★★★	★★★	★★★	★★★	★	★	★★★	★★
OKE302	★	★	★★	★★	★	★	★★	★★
OKE217	☆	★	★	★	★★	★★	★	☆
OKE211	☆	☆	☆	☆	★★	★★	☆	☆

推荐图例说明 Notes:

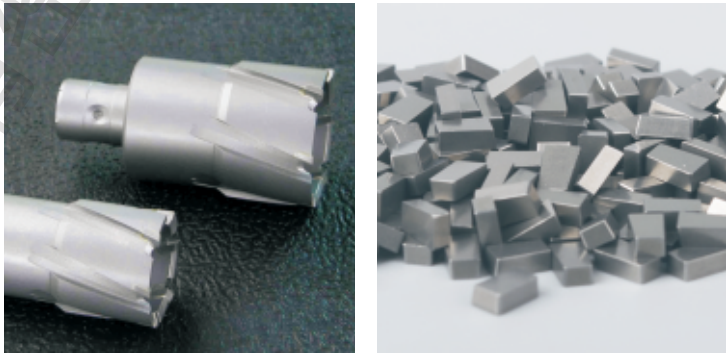
- ☆ 不推荐 Not suitable
- ★ 适当 Acceptable
- ★★ 良好 Good
- ★★★ 卓越 Excellent

指接刀系列
Finger Joint Cutter



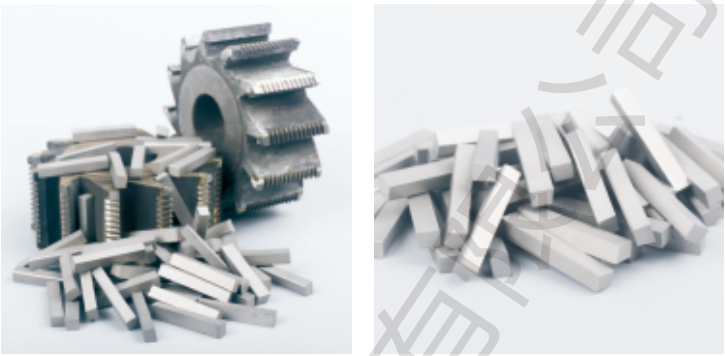
牌号性能 Property							
级别 Level	牌号 Grade	粘结相(%) Binder	密度(g/cm³) Density	硬度(HRA) Hardness	抗弯强度 (MPa) TRS	ISO标准 Code ISO	推荐用途 Recommended Cutting Applications
专业级 Professional	OKE211	8	14.70	90.5	2500	K20	旧木、软木 Used-wood, Softwood
工业级 Industrial	OKE217	5.5	14.90	92.2	2300	K10	硬木 Hardwood

硬质合金金属开孔器
专用齿
Carbide Tips for Hole Saw



牌号性能 Property						
牌号 Grade	粘结相(%) Binder	晶粒度 Grain size	密度(g/cm³) Density	硬度(HRA) Hardness	抗弯强度 (MPa) TRS	推荐用途 Recommended Cutting Applications
JK05P	10	1.4	12.2	91.0	2050	具有极佳的高温红硬性能，适用于中厚板，结构钢等深孔加工。 Great red hardness, suitable for boring middle thick plate and structural steel.
JK11	8	1.0	14.7	90.5	2500	通用性好，适用于不锈钢薄板等材质孔加工。 Good versatility, suitable for boring stainless sheet steel and other materials.

竹木刀用合金刀片
Carbide Tips for Bamboo & Wood



牌号性能 Property								
牌号 Grade	粘结相(%) Binder	密度(g/cm³) Density	硬度Hardness		抗弯强度 (MPa) TRS	断裂韧性 (Mpa.m1/2) Kic	ISO标准 Code ISO	推荐用途 Recommended Cutting Applications
			Hv10	HRA				
OKE309	6	14.9	1820	93	2700	9.2	K05	超细晶粒，耐磨性优良 Ultrafine grain good wear-resistance

带锯锯齿
Carbide Tips
for Band Saw



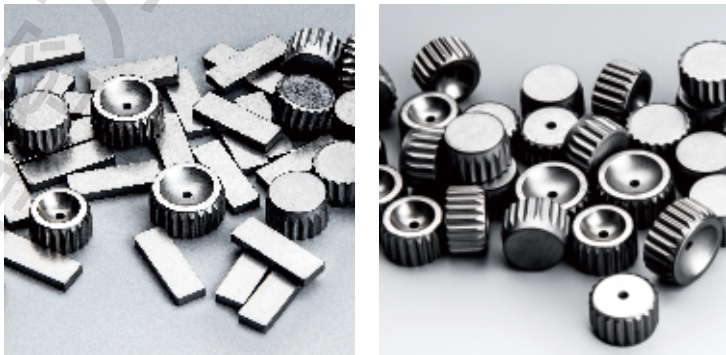
牌号性能 Property								
牌号 Grade	粘结相(%) Binder	密度(g/cm³) Density	硬度Hardness		抗弯强度 (MPa) TRS	断裂韧性 (Mpa.m ^{1/2}) K _{ic}	ISO标准 Code ISO	推荐用途 Recommended Cutting Applications
			Hv10	HRA				
DSN10	10	14.45	1600	92.0	3500	12.0	K10	木用，加工红木、硬木 woodworking, for rosewood and hardwood
DSP10	10	14.45	1580	91.9	3600	13.0	M10	金属加工用 Metalworking

割草锯片
硬质合金刀头
Carbide Tips for Grass
Cutting Blade



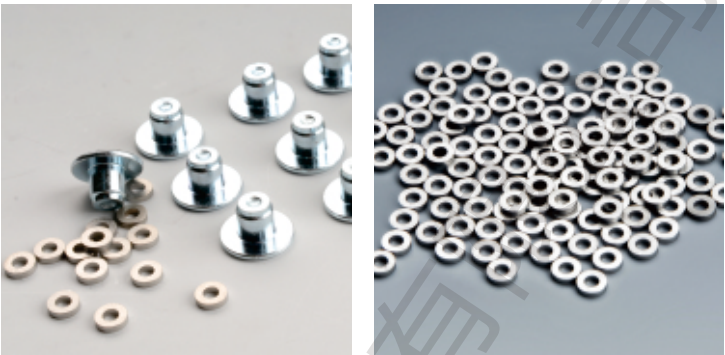
牌号性能 Property					
牌号 Grade	粘结相(%) Binder	密度(g/cm³) Density	硬度HRA Hardness	抗弯强度 (MPa) TRS	级别 Level
OKE-GC5	33	8.65	87	1800	DIY级 Diy
OKE-GC1	12	-	90.5	2600	专业级 Professional

Tc轴承用
硬质合金块
Carbide Blocks For
Tc Bearing



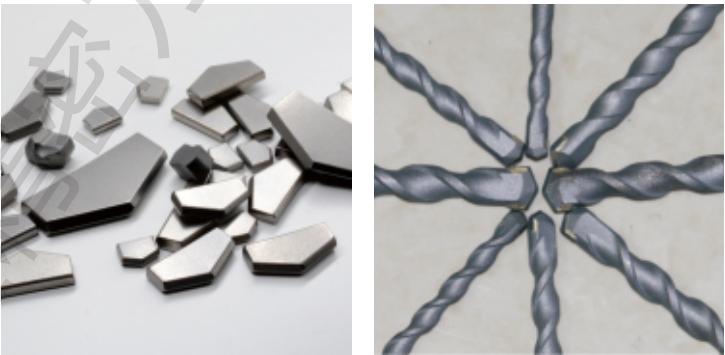
牌号性能 Property								
牌号 Grade	粘结相(%) Binder	密度(g/cm³) Density	硬度Hardness		抗弯强度 (MPa) TRS	断裂韧性 (Mpa.m1/2) Kic	ISO标准 Code ISO	美国标准 Code U.S.
			Hv10	HRA				
OKE211	8	14.7	1350	90.5	2500	10.5	K20	C1
OKE216	8.5	14.7	1520	91.6	2650	11.0	K20	C2

防滑钉用
硬质合金
Tungsten Carbide for
Tire Studs



牌号性能 Property				
牌号 Grade	粘结相(%) Binder	密度(g/cm³) Density	硬度HRA Hardness	抗弯强度 (MPa) TRS
OKE233	13	14.2	88	2600
OKE236	16.5	13.9	87	2800

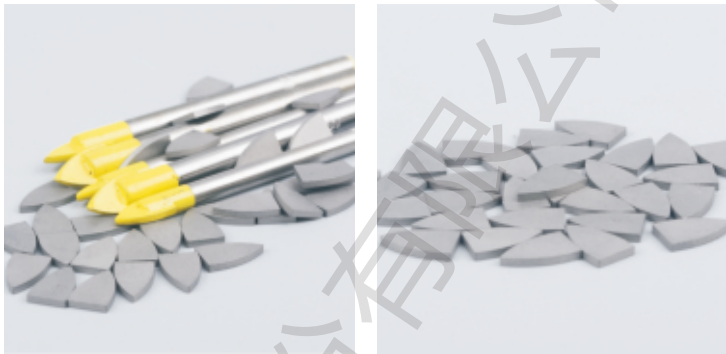
硬质合金
冲击钻片
Carbide Tips for
Drill Bits



牌号性能 Property							
牌号 Grade	粘结相(%) Binder	密度(g/cm³) Density	硬度Hardness		抗弯强度 (MPa) TRS	ISO标准 Code ISO	美国标准 Code U.S.
			Hv10	HRA			
OKE224	9	14.6	1330	89.5	2600	K40	C1
OKE225	8.5	14.72	1280	89.4	2500	K40	C1
OKE227	8	14.75	1430	90	2500	K30	C1
OKE228	8.5	14.72	1250	88.8	2800	>K40	-

硬质合金
陶瓷钻片

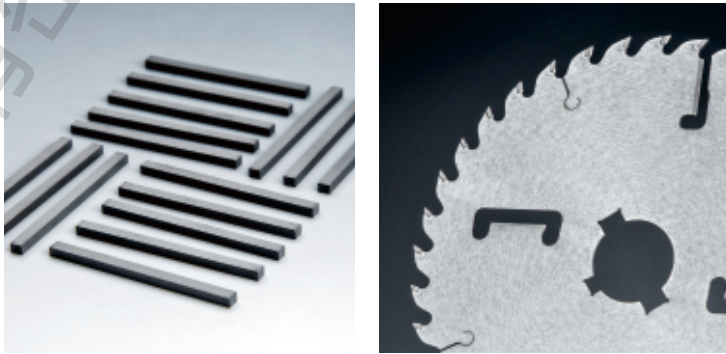
Carbide Tips for
Ceramic Drill Bit



牌号性能 Property								
牌号 Grade	粘结相(%) Binder	密度(g/cm³) Density	硬度Hardness		抗弯强度 (MPa) TRS	断裂韧性 (Mpa.m1/2) Kic	ISO标准 Code ISO	推荐用途 Recommended Cutting Applications
			Hv10	HRA				
OKE303	4	15.15	1880	93.3	2400	8.8	K01	细晶粒 耐磨性能好，韧性优良 Fine grain good wear-resistance good toughness.

硬质合金
锯片刮刀条

Carbide Scraper for
Saw Blade



牌号性能 Property							
牌号 Grade	粘结相(%) Binder	密度(g/cm³) Density	硬度Hardness		抗弯强度 (MPa) TRS	ISO标准 Code ISO	推荐用途 Recommended Cutting Applications
			Hv10	HRA			
OKE212	10	14.3	1400	90.7	2400	K30	实木圆切锯片用刮刀条合金 Solid wood multi-blade saw
OKE210	7	14.75	1450	91.0	2300	K25	