

Chinee Diamond Tools

Abrasives Tools Science Institute

Chinee Diamond Tools Co.,Ltd.



DIAMOND

GRINDING

WHEELS



刀具加工中心专用系列砂轮

CNC Machining Centers Special Grinding Wheel

产品特性

- 采用全进口优质金刚石磨料及结合剂
Made by high quality diamond abrasives and binders
- 采用国内先进加工工艺，生产设施完善，严格的检测流程
We have a state-of-the-art process, Production facilities, Rigorous testing process

产品优势

- 适合大进刀、线速度高的强力开槽、可替代部分进口金属强力磨砂轮
Suitable for feed, powerful line speed slotted, and can replace some of the imported metal strength grinding wheel
- 根据不同客户使用要求，可定制特殊配方，更好的加工针对性
We can customize according to the requirements of different customers use a special formula in order to have better processing targeted
- 安装在WALTER、ANCA、SACCKE、SCHURTER及台湾鼎维等五轴联动数控工具磨床
Grinding wheel can be used in WALTER, ANCA, SAACKE, SCHURTER axis CNC tool grinder

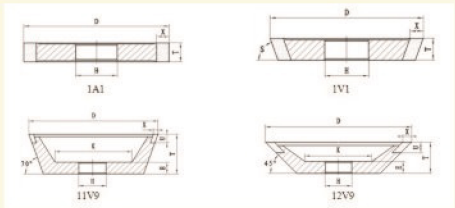


规格	型号	直径(D)	总厚(T)	孔径(H)	环宽(X)	环厚(U)
开槽砂轮	3A1/14A1	75、100	—	20或31.75	10	1
开槽砂轮	3A1/14A1	75、100	—	20或31.75	10	2
开槽砂轮	3A1 / 14A1	75、100	—	20或31.75	10	3
开槽砂轮	1A1/3A1/14A1	75、100	—	20或31.75	10	4
开槽砂轮	1A1/3A1/14A1	75、100	—	20或31.75	10	5
开槽砂轮	1A1/3A1/14A1	100或125	—	20或31.75	10	6
开槽砂轮	1A1/3A1/14A1	100或125	—	20或31.75	10	7
开槽砂轮	1A1 / 1V1	100或125	—	20或31.75	10	8
开槽砂轮	1A1 / 1V1	100或125	—	20或31.75	10	9
开槽砂轮	1A1 / 1V1	100或125	—	20或31.75	10	10
开槽砂轮	1A1 / 1V1	100或125	—	20或31.75	10	11
开槽砂轮	1A1 / 1V1	100或125	—	20或31.75	10	12

规格	型号	直径(D)	总厚(T)	孔径(H)	环宽(X)	环厚(U)
碗型砂轮	11V9/70°	100	35	20或31.75	3	10
碗型砂轮	12V9/45°	100或125	30	20或31.75	3	10

供货范围

- 我公司生产CNC砂轮适用于整体硬质合金铣刀和钻头等精密工具的开槽、铲背、端齿的加工磨削
Our CNC grinding wheel suitable for solid carbide precision tools such as milling and drilling, slotting, shovel back end teeth machining grinding
- 产品性价比高，性能接近或达到进口CNC砂轮水平，国内外客户反馈良好
Products with a high price, Performance approached or reached the level of imported CNC grinding wheel, Good customer feedback



树脂金刚石/CBN双端面砂轮

Resin diamond / CBN double face grinding wheel

产品特性

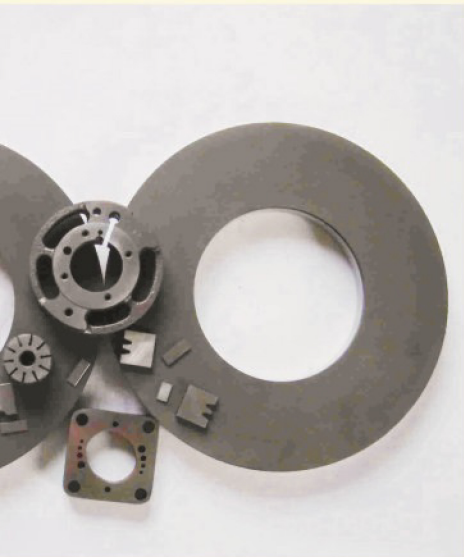
Product Features

- 采用优质的人造钻石、CBN作为磨料，经过特殊处理改性的树脂粉作为结合剂
 - 先进的生产工艺，保证优异的产品性能
 - 严格的生产流程要求，保证始终统一的产品质量
- The grinding wheels are made of high quality diamong/CBN and specially modified resin specially
- The most advanced production technology . Ensure superior product performance
- Strict production process requirements to ensure the quality of products always unified

产品优势

Product advantages

- 端面平面度好，提供更优质的加工精度
 - 耐磨性好，充分降低客户的生产成本
 - 磨削效率高，尽可能的提高生产加工速度
- Face flatness, provide better machining accuracy
- Good wear resistance, lower customer production costs
- Grinding efficiency, as much as possible to improve the speed of production and processing



产品规格	应用范围	砂轮形状
2A2T 305*25*152.4*76.3*3/5 6A2M 305*50*80*50*3/5*28 6A2M 305*50*80*75*3/5*28 6A2M 305*50*80*76.3*3/5*28 6A2M 305*50*80*80*3/5*28 6A2M 355*50*25*55*5*29 6A2M 350*40*127*100*5*30 6A2M 400*25*40*150*5*20 6A2M 500*65*160*100*5*40 2A2T 630*63*305*5 2A2T 700*54*300*200*5 2A2T 750*75*305*5 2A2T 840*60*340*250*7	双端面磨削	图1 双端面磨砂轮2A2T 图2 双端面磨砂轮6A2M

供货范围

Applications

- 适用于磨削硬质合金、精密陶瓷、高速钢、模具钢、轴承钢、碳素钢、弹簧钢、合金铸铁、粉末冶金材料等。可应用于轴承内外轮、变速齿轮、垫圈、填隙片、压缩机零件、水油压泵的叶片及转子、精密弹簧、缸体等的端面加工。可现已在日本东洋，日本富士产机，德国皮特沃尔特，意大利，秦川发展，上海索图，杭州机床等双端面磨床装配使用。
- Suitable for grinding carbide, ceramic, high-speed steel, die steel, bearing steel, carbon steel, spring steel, alloy cast iron, powder metallurgy materials. Face machining can be applied to the bearings, gears, washers, shims, compressor parts, blades, rotor, precision springs, cylinder, etc.. Now it was used at Toyo Electric 、Fuji production machine, Germany Peter Walter, Italy, Qinchuan development, Trihexyphenidyl Figure Hangzhou Machine Tool double end grinder assembly.

陶瓷刀磨削用树脂金刚石砂轮

Resinoid diamond wheel for ceramic knives

产品特性

Product Features

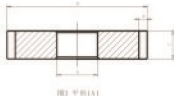
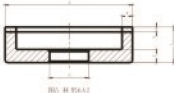
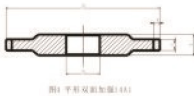
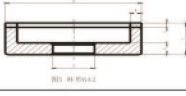
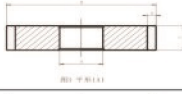
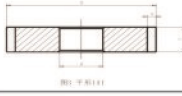
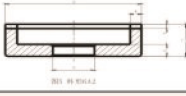
- 采用优质的人造钻石作为磨料，经过特殊处理改性的树脂粉作为结合剂
The grinding wheels are made of high quality diamond and specially modified resin
- 应用国内最为先进的生产工艺和生产设备
The most advanced production technology and production equipment

产品优势

Product advantages

- 优质的表面粗糙度和平面度
Excellent surface roughness and flatness
- 高效的加工速度，使您更快的完成工作
Efficient processing speed, and can make your work done faster



砂轮规格	应用范围	砂轮形状
1A1 350*40*127*10	卧式平磨刀面	
1A1 350*30*127*10		
6A2 450*100*20*12*380	立式平磨刀面	
6A2 400*75*360*15*10		
14A1 220*20*25.4*10*10	夹口磨开大刃	
1A1 175*15*25.4*12		
6A2 400*75*360*20*10	立磨开大刃	
1A1 250*30*40*10	磨刀背	
1A1 200*20*25*10	开小刃	
6A2 530*125*450*50*10		
可根据客户要求加工 According to customer' s requirements		

供货范围

Applications

- 专业应用于氧化锆陶瓷刀具各工序的磨削加工，适用于杭州机床厂、上海机床厂、四川磨床厂、桂北机床厂、阳江国浩机械、茂名怡华机械等国内著名的磨床以及刀剪设备厂家设备。
Applied to zirconia ceramic tool processes grinding, Hangzhou Hangji Machine Tool Co., Ltd. Shanghai Machine Tool Works Ltd, Sichuan Grinding Machine Factory, Guilin Guibei Machine CO., Ltd, Guohao Machine Making Co.,Ltd, Maoming Yi-hua machinery Co.,Ltd. and other famous domestic grinders as well as knives, scissors devicemanufacturers equipment.

磨陶瓷结构件金刚石砂轮

Diamond wheel for grinding ceramic structural parts

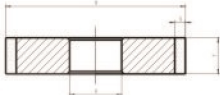
产品特性 Product Features

- 采用优质的人造钻石作为磨料，经过特殊处理改性的树脂粉作为结合剂
The grinding wheels are made of high quality diamond and specially modified resin specially
- 应用国内最为先进的生产工艺和生产设备
The most advanced production technology and production equipment

产品优势 Product advantages

- 提高进给量，缩短单次磨削时间10%—15%
Increase the feed rate, can shorten the the single grinding time by 10% –15%
- 每次修整的间隔时间延长100%—200%
Each trimming time interval can be extended to 100% –200%



产品规格	应用范围	砂轮形状
1A1 400*50*203*10	陶瓷柱塞 陶瓷刮水板 陶瓷阀门 半导体设备	 图3 平形1A1
1A1 400*25*203*10		
1A1 350*40*127*10		
1A1 400*20*203*7	碳化硅密封环	 图3 平形1A1
1A1 350*20*127*5		
1A1 300*20*127*5		
1A1 20*20*6*5		
1A1 30*20*10*5		
1A1 40*20*10*5		
1A1 50*20*10*5	陶瓷刮水板	 图3 平形1A1
6A2 100*32*16*10*10		
6A2 125*50*32*10*10		
6A2 150*50*32*10*10		
6A2 200*50*32*10*10		 图3 平形1A1

供货范围 Applications

●该型金刚石砂轮专业应用于Al₂O₃(氧化铝)、SiC(碳化硅)、ZrO₂(氧化锆)等精密陶瓷的磨削加工。主要应用的行业包括有造纸行业陶瓷刮水板的磨削，密封行业碳化硅密封环的磨削，阀门行业陶瓷件的磨削，石油设备行业陶瓷柱塞，半导体设备陶瓷件的磨削等。如您有进一步的咨询，敬请联系我们的销售工程师。

This type of diamond wheels are used in grinding Al₂O₃ (alumina), SiC (silicon carbide), ZrO₂ (zirconium oxide) precision ceramic . The main application industries include ceramic wiper blade grinding paper industry, silicon carbide seal ring sealing industry grinding, grinding of the valve industry ceramic pieces, oil equipment industry ceramic plunger, the grinding of semiconductor equipment ceramic pieces. If you have further inquiries, please contact our sales engineers.

磨PCD刀具用金刚石砂轮

Diamond wheel for grinding PCD tool

产品特性

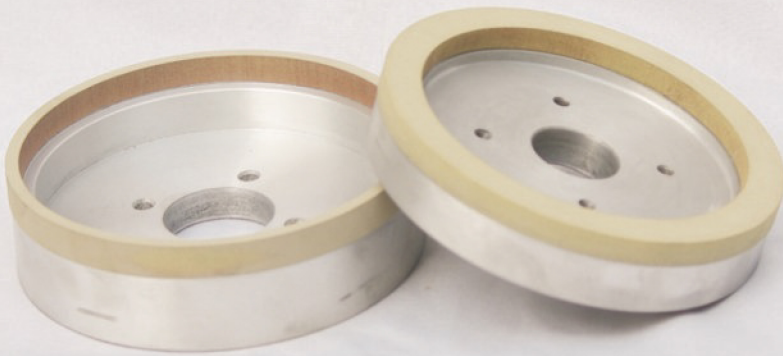
Product Features

- 采用优质的人造金刚石作为磨料，进口树脂粉、自研陶瓷材料作为结合剂
- Use of high-quality synthetic diamond as an abrasive, imported resin powder, ceramic materials as the binding agent since the inquiry
- 应用成熟的特殊生产工艺，经历长期的生产考验
- The applications mature special production process, experienced long-term production test

产品优势

Product advantages

- 优良的表面光洁度及尺寸精度
- Excellent surface finish and dimensional accuracy
- 高效的磨削性能和优良的耐磨性能
- Efficient grinding performance and excellent abrasion resistance



产品规格	应用范围	砂轮形状
6A2 150*40*32(40)*5*12 6A2 150*40*32(40)*10*10 6A2 150*40*32(40)*15*10 结合剂：B、V	磨PCD刀具	图5 杯形6A2

供货范围

Applications

- 该型树脂金刚石砂轮主要应用于PCD车刀精密磨削。陶瓷结合剂主要用于PCD圆盘锯粗、精磨削以及PCD车刀的粗加工。现已装配在台湾、北京等地产的磨床，是您加工PCD刀具的最优选择。
- Resin diamond grinding wheel is mainly used in PCD turning tool precision grinding. Ceramic bonded grinding wheel is mainly used for the the PCD disc saws coarse, fine grinding and roughing PCD turning tools. It is now assembled in Taiwan, Beijing and other real estate grinder, it is the optimal choice for processing PCD tool.

磨高速钢滚刀用CBN砂轮

CBN grinding wheel for grinding high-speed steel hob

产品特性

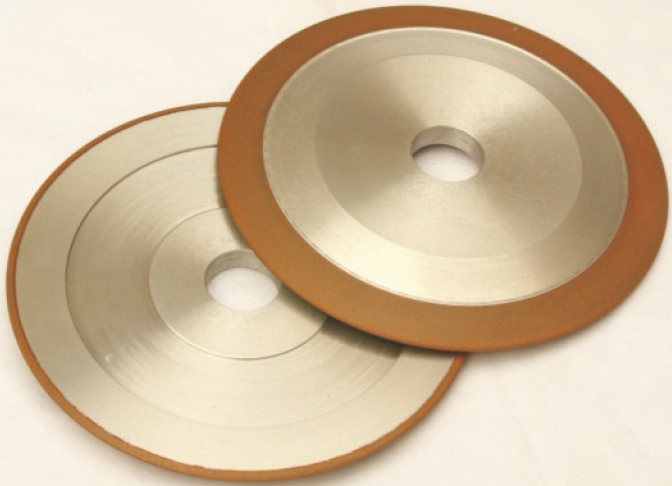
Product Features

- 采用优质的CBN作为磨料，进口树脂粉作为结合剂
- 应用成熟的特殊生产工艺，经历长期的生产考验

产品优势

Product advantages

- 优良的表面光洁度及尺寸精度
- 高效的磨削性能和优良的耐磨性能



产品规格	应用范围	砂轮形状
4B2 150*15*50*3*3 4B2 200*20*40*3*3 4B2 200*22*50.8*3*2 4B2 250*15*32(40)*24*2 4B2 250*20*32(40)*45*2	高速钢滚刀 (及氮化钛涂层)	

供货范围

Applications

- 该型树脂CBN砂轮主要应用于高速钢滚刀磨削。其中黑色结合剂磨削效率高、红色结合剂使用寿命长可以替代电镀结合剂。现已装配在武汉、秦川等地产的磨床，是您加工高速钢滚刀的最优选择。
- This type of resin CBN wheel is mainly used in high-speed steel hob grinding. Wherein the black binders grinding high efficiency, long service life of the red binding agent. The product can replace electroplating bonded grinding wheel. The products are now assembling in Wuhan, Qinchuan estate grinder. It is the optimal choice for customers processing high-speed steel hob.

磨硬质合金密封球系列

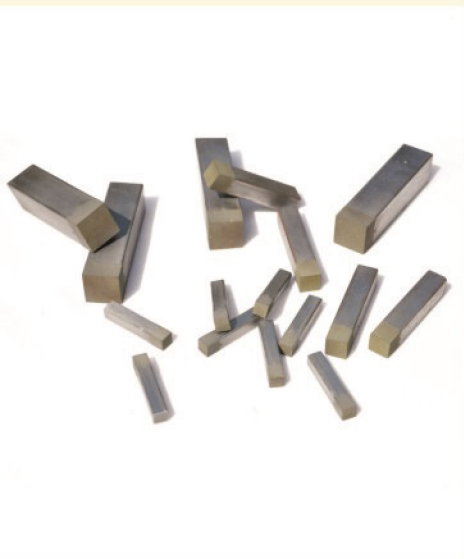
Super abrasives for grinding carbide seal ball

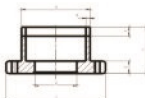
产品特性 Product Features

- 采用优质的人造金刚石作为磨料，经过特殊处理改性的树脂粉作为结合剂
The grinding wheels are made of high quality diamond and specially modified resin specially
- 应用特殊生产工艺，经过长期的生产考验
The applications mature special production process, experienced long-term production test

产品优势 Product advantages

- 磨削效率明显高于现在使用的金属结合剂磨球砂轮、油石条
Grinding efficiency is significantly higher than the metal bond grinding wheel, Whetstone.
- 优异的表面光洁度，提高工件的使用性能
Excellent surface finish, the use of performance of the workpiece can be improved.
- 加工圆球度高，为您提供更好的装配精度
Higher sphericity, better assembly precision



HMA油石规格				应用范围		砂轮形状	
L宽	W深	X厚	T总高	大规格密封球		 图17 磨球油石(HMA)	
8	8	8	40				
12	12	10	60				
20	20	10	80				
6A2T砂轮规格				应用范围		砂轮形状	
D	T	H	W	X	E	J	 图18 磨球砂轮6A2T
20	30	20	3	5	14	49	
20.5	30	20	2.75	5	14	49	
25	30	20	3 3.5 4.2	5	14	49	
30	30	20	3 4	5	14	49	
35	30	20	4 4.5	5	14	49	
40	30	20	4 4.5	5	14	49	
43	30	20	4	5	14	49	
45	40	20	3.5	5	14	49	
45	30	20	4	5	14	49	
50	30	20	4.5	5	14	49	
53	40	20	4	5	14	53	
56	40	20	4	5	14	56	
63	40	20	4	5	14	63	
70	50	20	5	5	15	70	
75	50	20	5	5	15	75	

供货范围 Applications

- 该型金刚石砂轮适用于阀门行业各种材质的软硬密封球体磨削，其中6A2T用于小规格球体，HMA用于大规格密封球的磨削。如您有进一步的咨询，敬请联系我们的销售工程师。
This diamond product is suitable for a variety of materials in the valve industry hard and soft sealing sphere grinding, which 6A2T for small size sphere, HMA for large-sized sealed ball grinding. If you have further inquiries, please contact our sales engineers.

磨硬质合金无芯磨砂轮

Coreless grinding wheel for Grinding carbide materials

产品特性

Product Features

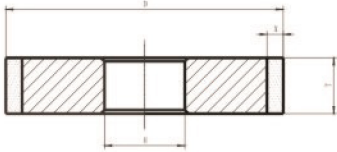
- 采用优质的人造金刚石作为磨料，经过特殊处理改性的树脂粉作为结合剂
- The grinding wheels are made of high quality diamond and specially modified resin specially
- 应用成熟的特殊生产工艺，经历长期的生产考验
- The applications mature special production process, experienced long-term production test

产品优势

Product advantages

- 优良的表面光洁度，没有震纹、划伤等现象
- Excellent surface finish, no shock pattern, scratches and so on
- 高效的磨削性能和优良的耐磨性能
- Efficient grinding performance and excellent abrasion resistance



产品规格	应用范围	砂轮形状
1A1 300*150*120*5 1A1 300*150*120*10 1A1 350*125*127*5 1A1 350*125*127*10 1A1 400*150*203*5 1A1 400*150*203*10 1A1 500*150*350*5 1A1 500*150*350*10	硬质合金等 材料无心磨	 图3 平形1A1

供货范围

Applications

- 该型树脂金刚石砂轮主要应用于硬质合金棒材、线材的表面磨削加工。现已装配在台湾、深圳、无锡等地产的无心磨床，是您进行硬质合金加工的最优选择。
- The resin diamond grinding wheels are grinding for carbide rods, wire rods. It is assembled in Taiwan, Shenzhen, Wuxi and other real estate centerless grinder, it is the optimal choice carbide processing.



DIAMOND GRINDING WHEEL

GRINDING WHEEL



Chinee Diamond Tools Co.,Ltd.

china-diamondtools.com