

CNC CIRCULAR SAW CUTTING MACHINE



数控锯切机床 CNC CIRCULAR SAW CUTTING MACHINE

高速圆锯机/高速板材圆锯机

浙江汉达机械有限公司

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Zhejiang Handa Machinery Co.,LTD.

立己达人 共创双赢

TARWIT, Cooperate to achieve a win-win situation



达人
TARWIT

创锯切行业优异品牌

Famous brand in the saw cutting machine industry,

提供高效的锯切解决方案

Procide high-efficiency saw cutting solutions.

拥有达人机床 不仅是一台机器

Having one set of TARWIT machine,

而是一整套锯切加工的解决方案

You got a problem solver for a series of saw cutting

高效、节能、简易操作

High efficiency, energy-saving and easy operation.

立己达人，共创双赢

TARWIT, Cooperate to achieve a win-win situation.



达人 — 取自孔子《论语·雍也》 己欲立而立人，己欲达而达人



企业简介 INTRODUCTION

浙江汉达机械有限公司创立于1999年，位于浙江省缙云壶镇（丽缙高新区）。是国家高新技术企业，浙江省科技型中小企业，浙江省AAA守合同重信誉企业，公司拥有省级企业研究院，承担了多项省级研发项目研发试产，获得6项发明专利，实用新型专利几十项。

公司拥有马扎克车铣复合中心、大畏龙门加工中心、日立卧式加工中心、导轨磨床、立式加工中心等加工设备300余台，设备完善，机床所需零部件自产率达75%，检测仪器门类齐全设备完好精度如一。

公司创立之初至今一直生产某高端设备的关键零部件，有资深的配套经验和技術积累。2013开始自产零部件加工设备，开发了新能源汽车电池盒加工流水线等一系列机床，涉及到锯切、铣、钻攻等工序。在锯切、铣、钻孔、攻丝积累了近5000多个一体化加工成功案例，销售机床70000余台。

达人机床专业的研发团队，经验丰富的装配和调试技师，快速响应的服务团队，使得客户与汉达之间形成专业，快捷而高效的沟通；公司导入ISO9001和6S管理，并采用ERP.PLM等来管理订单、生产、库存，力求质量交期的双赢；丰富的行业应用经验，点到即通。“达人”发挥三大优势，为客户提供高效的生产解决方案，机器一到，加工效率直线提升，妙不可言。

汉达将不断提升竞争优势，通过技术创新，系统化管理为客户提供更高效的全自动锯切生产解决方案。达人立己，共创双赢！

Zhejiang Handa Machinery Co.,Ltd. was founded in 1999 and is located in Huzhen, Jinyun, Zhejiang Province (Lijin High tech Zone). It is a national high-tech enterprise, a technology-based small and medium-sized enterprise in Zhejiang Province, an AAA contract abiding and trustworthy enterprise in Zhejiang Province. The company has a provincial-level enterprise research institute, has undertaken multiple provincial-level research and development projects, and has obtained 6 invention patents and dozens of utility model patents. The company has more than 300 processing equipment, including Mazak turning and milling compound center, Dawei gantry machining center, Hitachi horizontal machining center, guide rail grinder, vertical machining center, etc. The equipment is complete, and the self-produced rate of required parts for machine tools reaches 75%. The testing instruments are complete in all categories, and the equipment is in good condition with consistent accuracy. Since its establishment, the company has been producing key components for a certain high-end equipment, with senior supporting experience and technical accumulation. Starting from 2013, we started producing our own parts processing equipment and developed a series of machine tools such as a new energy vehicle battery box processing assembly line, which involves processes such as sawing, milling, and drilling. We have accumulated nearly 5000 successful integrated machining cases in sawing, milling, drilling, and tapping, and sold over 70,000 machine tools. A professional R&D team of experts in machine tools, experienced assembly and debugging technicians, and a responsive service team enable professional, fast, and efficient communication between customers and Handa; The company has introduced ISO9001 and 6S management, and adopted ERP PLM and others manage orders, production, inventory, and strive for a win-win situation of quality and delivery time; Rich industry application experience, easy to access with just a click. "Tarwit" leverages its three major advantages to provide customers with efficient production solutions. As soon as machines arrive, processing efficiency improves in a straight line, which is beyond words. Handa will continuously enhance its competitive advantage and provide customers with more efficient fully automatic sawing production solutions through technological innovation and systematic management. Experts stand up for themselves, creating a win-win situation together!

➤ www.darenjc.com

➤ www.tarwitmachine.com



300余台 先进的加工设备

HANDA HAS MORE THAN 300+
ADVANCED PROCESSING
EQUIPMENTS

拥有马扎克车铣复合中心
大畏龙门加工中心
日立卧式加工中心
数控导轨磨

Mazak turning and milling centers
OKUMA gantry machining centers
Hitachi horizontal machining centers
Guideway grinding machines



ISO管理体系 具备完善的检测能力

ISO MANAGEMENT SYSTEM,
WITH COMPREHENSIVE TESTING
CAPABILITIES



三坐标测量仪
CMM



偏摆测量仪
Deflection Measuring Instrument

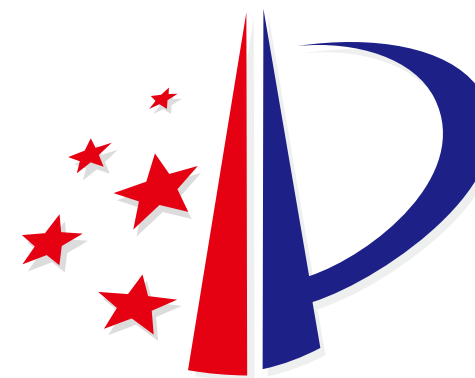


洛氏硬度测量仪
Rockwell Hardness Measuring Instrument



齿轮跳动仪
Gear Runout Instrument

企业荣誉



专利证书

Patents & Certificate

Honors & Awards

- ISO管理三体系（质量+职业健康+环境） ISO Certified (ISO9001 + OHSAS18001 + ISO14001)
- 国家高新技术企业 High-Tech Enterprise of China
- 省科技型中小企业 Provincial Technology Based Enterprise
- 省级企业研究院 Provincial enterprise Institute
- 省AAA级守合同重信用企业 AAA-level Credit Enterprise
- 省商业秘密保护示范企业 Provincial business confidential protection demonstration enterprise
- 省信用管理示范企业 City-level credit management demonstration enterprise
- 省级装备制造业重点领域首台套产品 The first machine in the critical areas in Zhejiang province
- 省级新品鉴定 The Provincial New Product Appraisal Certificate
- 省级科技成果登记 Registration of Technological Achievement
- 县制造业50强 Jinyun Top 50 manufacturing company member

- **发明专利证书:**
多轴钻攻机床
Multiple Spindle Drilling & Tapping Machine
- **外观设计专利证书:**
多轴钻床
Multiple Spindle Drilling Machine
- **实用新型专利证书:**
多轴钻床主轴箱
Multiple Spindle Drill Spindle Box
多轴钻床导轨自动润滑系统
Multiple Spindle Drill Guide Automatic Lubrication System
多轴钻床双电机驱动齿轮箱
Multiple Spindle Drill Double Motor Drive Gear Box
多轴钻床主传动装置
Multiple Spindle Drill Main Transmission Device
多轴钻床钻杆变位装置
Multiple Spindle Drill Pipe Deflection Device
... ..

六大优选设计

6 FEATURES

1

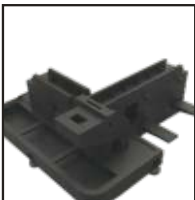
新型齿轮箱
New type gear box



- ★ 实现零间隙传动
 - ★ 保证锯切精度
 - ★ 提高锯片使用寿命
 - ★ LVSK进口轴承
- ★ Precision transmission
 - ★ Ensure cutting precision
 - ★ Extend blade life
 - ★ LVSK bearing

2

铸件整体式底座
Casting integral base



- ★ 选用优质高强度整体铸造
 - ★ 硬度好
 - ★ 刚性好
 - ★ 耐冲击
- ★ High quality casting
 - ★ High hardness
 - ★ High rigidity
 - ★ Skockproof

3

HD

汉力达液压

液压站
Hydraulic



- ★ 液压动力足
 - ★ 液压驱动保证进给稳定
 - ★ 进给力均匀
- ★ Supply enough power
 - ★ Hydraulically driving force to assure stable
 - ★ Stable feed rate

锯切新选择

SAW CUTTING NEW CHOICE



傻瓜式操作，简单易学，采用触摸屏进行参数设定，料头、料尾、工件、切屑均可输送到指定位置，全过程数字化控制。设备集自动翻料，自动送料，残料分离，自动排屑等功能于一体，节省80%人工成本。

Easy to operate,CNC control, auto trim cut, sorting device, chip conveyor, full automatic control, save 80% labor cost.

4

创新型自动送料装置
Innovative automatic feeding device



- ★ 采用伺服电机+高精度滚珠丝杆
先进方式进行送料
 - ★ 独特的送料夹钳偏摆结构
 - ★ 提高了送料精度和可靠性
- ★ Servomotor + Ballscrew
 - ★ Shuttle vise
 - ★ Enhance feed precision and stability

5

喷雾润滑冷却系统
Oil mist cooling system



- ★ 采用先进的锯片喷雾润滑技术，
对切削油进行精准计量的微量喷涂
 - ★ 降低锯片温度
 - ★ 提高生产效率
 - ★ 延长锯片使用寿命
- ★ Advanced oil mist cooling technology
 - ★ Precision spray
 - ★ Cool blade
 - ★ Increase productivity
 - ★ Extend blade life

6

人机界面
HMI

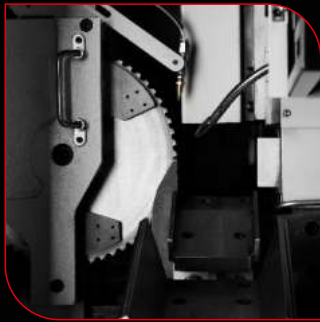


- ★ 界面友好
 - ★ 所有功能都清楚标明
 - ★ 急停按钮
- ★ User friendly
 - ★ All functions are clearly labeled and
conveniently located
 - ★ Emergency-stop push button

高速圆锯机

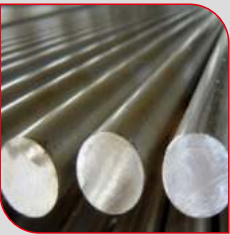
CNC CIRCULAR SAW CUTTING MACHINE

HGY-P50



主要技术参数 Technical Data

锯切能力 Sawing ability			HGY-P50
棒材 Round bar	●	mm	10-50
角材 Square tube	■	mm	10-35
圆管 Round tube	○	mm	10-50
方管 Square tube	□	mm	10-35
尾端残材长度 Remnant length		mm	90-(90+π 切断长度) 90-(90+π cutlength)
送料长度 Feed length		mm	5-800(单次最大送料长度) 5-800(single maximum feed length)
送料精度 Feeding accuracy			± 0.10
设备参数 Device parameters			
使用超硬钨钢圆锯片 Use super hard tungsten steel circular saw blade	mm		Φ250X1.7/2.0
销孔+孔径 Pin hole	mm		4X Φ 11XPCD63X Φ 32
主轴马达 Spindle motor	KW		5.5KW/4P
主轴转速 Spindle speed	rpm		20-220
液压马达 Hydraulic motor	KW		1.5
油压压力 Hydraulic pressure	Mpa		5
油压油容量 Oil pressure capacity	L		60
定寸送料方式 Fixed feeding method			伺服送料 Servo feeding
机头驱动方式 Head drive			伺服平行进给下刀切断 Servo feed swing
送料夹钳 Feed clamp			平行油压式 Shuttle vise
主夹钳 Main clamp			平行油压式+垂直油压式 Parallel hydraulic+vertical hydraulic
工作电压 Operating voltage	V		380 (三相) 380(three phase)
送料伺服电机 Feed servo motor	KW		0.85
进刀伺服电机 Feed servo motor	KW		1.8
排屑电机 Chip discharge motor	KW		0.4
总功率 Total power	KW		10



选配装置 Optional device



可选多种自动化装置
Articulated robot



集束式自动送料架
Incline table



油雾收集箱
Oil mist collector

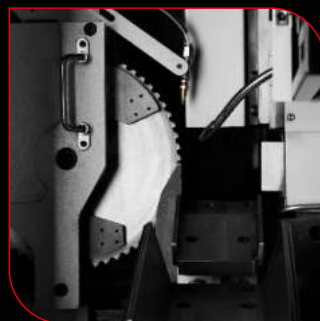


自动出料架
Automatic unloading device



带加热油压站
Hydraulic power pack with heater

HGY-P80



锯切能力 Sawing ability

HGY-P80

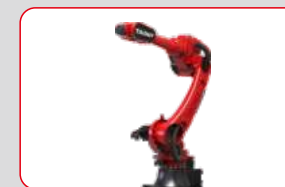
棒材 Round bar	●	mm	10-80
角材 Square tube	■	mm	10-70
圆管 Round tube	○	mm	10-80
方管 Square tube	□	mm	10-70
尾端残材长度 Remnant length		mm	90-(90+π 切断长度) 90-(90+π cutlength)
送料长度 Feed length		mm	5-850(单次最大送料长度) 5-800(single maximum feed length)
送料精度 Feeding accuracy			± 0.10

设备参数 Device parameters

使用超硬钨钢圆锯片 Use super hard tungsten steel circular saw blade	mm	Φ300X1.7/2.0
销孔+孔径 Pin hole	mm	4X Φ 11XPCD63X Φ 32
主轴马达 Spindle motor	KW	7.5kw/6p
主轴转速 Spindle speed	rpm	20~140
液压马达 Hydraulic motor	KW	2.2
油压压力 Hydraulic pressure	Mpa	6
油压油容量 Oil pressure capacity		80
定寸送料方式 Fixed feeding method		伺服送料 Servo feeding
机头驱动方式 Head drive		伺服平行进给下刀切断 Servo feed swing
送料夹钳 Feed clamp		平行油压式 Shuttle vise
主夹钳 Main clamp		平行油压式+垂直油压式 Parallel hydraulic+vertical hydraulic
工作电压 Operating voltage	V	380 (三相) 380(three phase)
送料伺服电机 Feed servo motor	KW	0.85
进刀伺服电机 Feed servo motor	KW	1.8
排屑电机 Chip discharge motor	KW	0.4
总功率 Total power	KW	13



选配装置 Optional device



可选多种自动化装置
Articulated robot



集束式自动送料架
Incline table



油雾收集箱
Oil mist collector



自动出料架
Automatic unloading device



帶加熱油壓站
Hydraulic power pack with heater

HGY-P100



锯切能力 Sawing ability			HGY-P100
棒材 Round bar	●	mm	20-100
角材 Square tube	■	mm	20-85
圆管 Round tube	○	mm	20-100
方管 Square tube	□	mm	20-85
尾端残材长度 Remnant length		mm	90- (90+ π 切断长度) 90-(90+π cutlength)
送料长度 Feed length		mm	5-850 (单次最长送料长度) 5-850(single maximum feed length)
送料精度 Feeding accuracy			± 0.1
设备参数 Device parameters			
使用超硬钨钢圆锯片 Use super hard tungsten steel circular saw blade	mm		Φ330X2/2.25
销孔+孔径 Pin hole	mm		4XΦ11XPCD63XΦ32
主轴马达 Spindle motor	KW		11KW/6P
主轴转速 Spindle speed	rpm		20-170
液压马达 Hydraulic motor	KW		2.2
油压压力 Hydraulic pressure	Mpa		6
油压油容量 Oil pressure capacity			80
定寸送料方式 Fixed feeding method			伺服送料 Servo feeding
机头驱动方式 Head drive			伺服平行进给下刀切断 Servo feed swing
送料夹钳 Feed clamp			平行油压式 Shuttle vise
主夹钳 Main clamp			平行油压式+垂直油压式 Parallel hydraulic+vertical hydraulic
工作电压 Operating voltage	V		380 (三相) 380(three phase)
送料伺服电机 Feed servo motor	KW		1.3
进刀伺服电机 Feed servo motor	KW		1.8
排屑电机 Chip discharge motor	KW		0.4
总功率 Total power	KW		17



集束式自动送料架
Incline table



自动出料架
Automatic unloading device

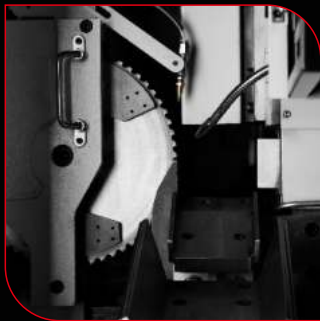




高速圆锯机

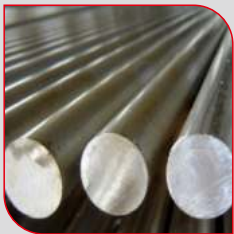
CNC CIRCULAR SAW CUTTING MACHINE

HGY-P150



主要技术参数 Technical Data

锯切能力 Sawing ability			HGY-P150
棒材 Round bar	●	mm	40-150
角材 Square tube	■	mm	40-120
圆管 Round tube	○	mm	40-150
方管 Square tube	□	mm	40-120
尾端残材长度 Remnant length		mm	90-(90+π 切断长度) 90-(90+π cutlength)
送料长度 Feed length		mm	10-850(单次最大送料长度) 10-850(single maximum feed length)
送料精度 Feeding accuracy			± 0.10
设备参数 Device parameters			
使用超硬钨钢圆锯片 Use super hard tungsten steel circular saw blade	mm		Φ460X2.3/2.7
销孔+孔径 Pin hole	mm		4XΦ16XPCD80XΦ50
主轴马达 Spindle motor	KW		15KW/6P
主轴转速 Spindle speed	rpm		18-150
液压马达 Hydraulic motor	KW		3
油压压力 Hydraulic pressure	Mpa		9
油压油容量 Oil pressure capacity			100
定寸送料方式 Fixed feeding method			伺服送料 Servo feeding
机头驱动方式 Head drive			伺服平行进给下刀切断 Servo feed swing
送料夹钳 Feed clamp			平行油压式 Shuttle vise
主夹钳 Main clamp			平行油压式+垂直油压式 Parallel hydraulic+vertical hydraulic
工作电压 Operating voltage	V		380 (三相) 380(three phase)
送料伺服电机 Feed servo motor	KW		1.8
进刀伺服电机 Feed servo motor	KW		4.4
排屑电机 Chip discharge motor	KW		0.4
总功率 Total power	KW		24



选配装置 Optional device



可选多种自动化装置
Articulated robot



集束式自动送料架
Incline table



油雾收集箱
Oil mist collector



自动出料架
Automatic unloading device

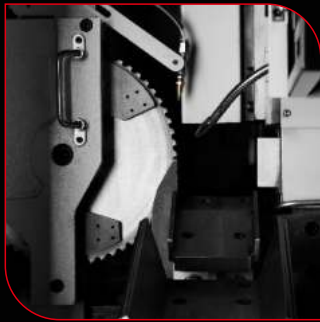


带加热油压站
Hydraulic power pack with heater

高速圆锯机

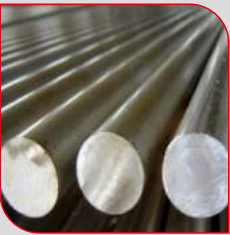
CNC CIRCULAR SAW CUTTING MACHINE

HGY-P200



主要技术参数 Technical Data

锯切能力 Sawing ability			HGY-P200
棒材 Round bar	●	mm	70-200
角材 Square tube	■	mm	70-160
圆管 Round tube	○	mm	70-200
方管 Square tube	□	mm	70-160
尾端残材长度 Remnant length		mm	105-(105+π 切断长度) 105-(105+π cutlength)
送料长度 Feed length		mm	10-850(单次最大送料长度) 10-850(single maximum feed length)
送料精度 Feeding accuracy			± 0.10
设备参数 Device parameters			
使用超硬钨钢圆锯片 Use super hard tungsten steel circular saw blade	mm		Φ630X2.7/3.4
销孔+孔径 Pin hole	mm		4XΦ23XPCD120XΦ80
主轴马达 Spindle motor	KW		22KW/6P
主轴转速 Spindle speed	rpm		18-100
液压马达 Hydraulic motor	KW		4
油压压力 Hydraulic pressure	Mpa		10
油压油容量 Oil pressure capacity			150
定寸送料方式 Fixed feeding method			伺服送料 Servo feeding
机头驱动方式 Head drive			伺服平行进给下刀切断 Servo feed swing
送料夹钳 Feed clamp			平行油压式 Shuttle vise
主夹钳 Main clamp			平行油压式+垂直油压式 Parallel hydraulic+vertical hydraulic
工作电压 Operating voltage	V		380 (三相) 380(three phase)
送料伺服电机 Feed servo motor	KW		2.9
进刀伺服电机 Feed servo motor	KW		5.5
排屑电机 Chip discharge motor	KW		0.4
总功率 Total power	KW		35



选配装置 Optional device



可选多种自动化装置
Articulated robot



集束式自动送料架
Incline table



油雾收集箱
Oil mist collector



自动出料架
Automatic unloading device



带加热油压站
Hydraulic power pack with heater

高速板材圆锯机

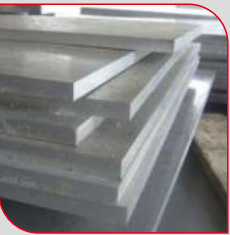
CNC STEEL PLATE CUTTING MACHINE

GK610



主要技术参数 Technical Data

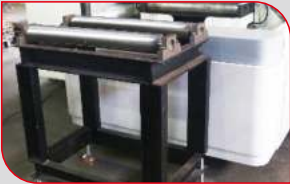
设备参数 Device parameters		GK610
锯片规格 Diameter		Φ425
锯切范围 Cutting capacity	mm	宽 50-610 Width
	mm	厚 20-100 Thickness
锯切长度 Cutting length	mm	≥20
原料长度 Material speed	mm	≤3000
夹紧方式 Clamp		水平垂直夹紧 Horizontal and vertical
主轴转速 Blade speed	r/min	5-160无极调速 Stepless adjust
主轴电机功率 Blade motor	kw	15
进给电机功率 Sawhead feed motor	kw	7.5
送料电机功率 Cut-to-length feed motor	kw	4.4
锯切面粗糙度 Cutting roughness		≤Ra6.3
锯切面垂直度 Cutting verticality	mm	≤0.3/100
锯切面直线度 Cutting linearity	mm	≤0.12/630
锯切长度公差 Cutting length tolerance	mm	± 0.2
主轴进刀方式 Cutting feed		伺服驱动 Servomotor and ballscrew
主轴箱工进速度 Feed rate	mm/min	50-400无极变速 Stepless sadjust
主轴精度 Spindle precision	mm	≤0.01
冷却方式 Cooling		油雾喷雾冷却 Oil mist cooling
一次送料长度 Material feed stroke	mm	一次性最长600, 可循环多次送料 600mm single stroke,multiple feeding available
压缩空气 Compress air	Mpa	0.5-0.6
排屑方式 Chip removal		全自动螺旋排屑/链板排屑 Chip auger/Chip conveyor
下料方式 Unloading		手动出料 Manual
是否循环 Cycle		单循环/多循环 Single cycle/Multiple cycle
机床重量 Net weight	T	8
机床尺寸 Size	mm	3400X2600X2400



选配装置 Optional device



自动出料装置
Auto unloading device



后置送料架
Material feeding rack



高速板材圆锯机

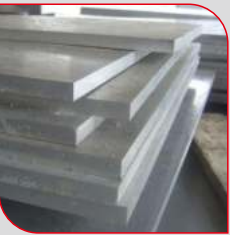
CNC STEEL PLATE CUTTING MACHINE

GK810



主要技术参数 Technical Data

设备参数 Device parameters		GK810
锯片规格 Diameter		Φ425
锯切范围 Cutting capacity	mm	宽 250-810 Width
	mm	厚 20-100 Thickness
锯切长度 Cutting length	mm	≥20
原料长度 Material speed	mm	≤3000
夹紧方式 Clamp		水平垂直夹紧 Horizontal and vertical
主轴转速 Blade speed	r/min	5-160无极调速 Stepless adjust
主轴电机功率 Blade motor	kw	15
进给电机功率 Sawhead feed motor	kw	7.5
送料电机功率 Cut-to-length feed motor	kw	4.4
锯切面粗糙度 Cutting roughness		≤Ra6.3
锯切面垂直度 Cutting verticality	mm	≤0.3/100
锯切面直线度 Cutting linearity	mm	≤0.12/810
锯切长度公差 Cutting length tolerance	mm	± 0.2
主轴进刀方式 Cutting feed		伺服驱动 Servomotor and ballscrew
主轴箱工进速度 Feed rate	mm/min	50-400无极变速 Stepless adjust
主轴精度 Spindle precision	mm	≤0.01
冷却方式 Cooling		油雾喷雾冷却 Oil mist cooling
一次送料长度 Material feed stroke	mm	一次性最长600, 可循环多次送料 600mm single stroke, multiple feeding available
压缩空气 Compress air	Mpa	0.5-0.6
排屑方式 Chip removal		全自动螺旋排屑/链板排屑 Chip auger/Chip conveyor
下料方式 Unloading		手动出料 Manual
是否循环 Cycle		单循环/多循环 Single cycle/Multiple cycle
机床重量 Net weight	T	8
机床尺寸 Size	mm	3600X2600X2400



选配装置 Optional device



自动出料装置
Auto unloading device



后置送料架
Material feeding rack



高速板材圆锯机

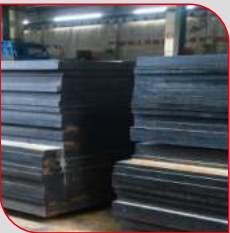
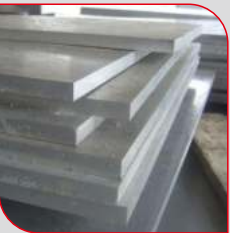
CNC STEEL PLATE CUTTING MACHINE

GK1310



主要技术参数 Technical Data

设备参数 Device parameters		GK1310
锯片规格 Diameter		Φ425
锯切范围 Cutting capacity	mm	宽 110-1300 Width
	mm	厚 20-100 Thickness
锯切长度 Cutting length	mm	≥20
原料长度 Material speed	mm	≤6000
夹紧方式 Clamp		水平垂直夹紧 Horizontal and vertical
主轴转速 Blade speed	r/min	5-160无极调速 Stepless adjust
主轴电机功率 Blade motor	kw	15
进给电机功率 Sawhead feed motor	kw	7.5
送料电机功率 Cut-to-length feed motor	kw	4.4
锯切面粗糙度 Cutting roughness		≤Ra6.3
锯切面垂直度 Cutting verticality	mm	≤0.3/100
锯切面直线度 Cutting linearity	mm	≤0.12/630
锯切长度公差 Cutting length tolerance	mm	± 0.2
主轴进刀方式 Cutting feed		伺服驱动 Servomotor and ballscrew
主轴箱工进速度 Feed rate	mm/min	50-400无极变速 Stepless adjust
主轴精度 Spindle precision	mm	0.005-0.01
冷却方式 Cooling		油雾喷雾冷却 Oil mist cooling
一次送料长度 Material feed stroke	mm	一次性最长900, 可循环多次送料 600mm single stroke,multiple feeding available
压缩空气 Compress air	Mpa	0.5-0.6
排屑方式 Chip removal		全自动螺旋排屑/链板排屑 Chip auger/Chip conveyor
下料方式 Unloading		手动出料/自动出料 Manual
是否循环 Cycle		单循环/多循环 Single cycle/Multiple cycle
机床重量 Net weight	T	15
机床尺寸 Size	mm	7300X4300X2800



选配装置 Optional device



自动出料装置
Auto unloading device



后置送料架
Material feeding rack



圓锯片系列Metal circular saw



V系列V series

可以高快速切削，同时提高锯切寿命，并在常规速度切削的同时也有较高的锯切寿命。切割条件比较复杂的情况下提高锯切寿命切割中高碳钢材料。可克服切割时出现的擦刀现象。

High speed cutting, extended service life, and enables extended service life during regular cutting speed. Under complex cutting working conditions such as cutting medium &high carbon steel materials, the life span of saw still can be improved. Avoid cutting edge phenomenon during cutting.



S系列S series

切割特别容易粘刀的材料
正常普通速度切割精度高
客户对表面切割光泽度高
切铜、铝、低碳钢类材料

Cut materials that are easy to cause sticking phenomenon
High precision under regular normal cutting speed
High requirements for the cutting surface smoothness
Cut copper, aluminium, low carbon steel materials



PVD纳米涂层PVD Nano Coating

适用于高效锯切，切面光滑，切割精度高。减少摩擦系数，降低切削齿尖温度，从而提升切割寿命和效率。通用性较强（如：低碳钢，中碳钢，高碳钢应用特点）PVD纳米涂层比现有V系列、S系列寿命提高30–50%；切割效率提升30–50%

Suitable for high efficiency cutting with smooth cutting surface and high precision. Decrease frictional coefficient, lower the cutter tooth's temperature, enables longer cutting life span and efficiency. Strong generality(for instance, low carbon steel, medium carbon steel, high carbon steel can be applied). PVD nano coating enhances lifespan to 30%–50% compared to V series and S series; cutting efficiency increases 30%–50%.



PVD纳米复合涂层不锈钢

PVD nano composite coating steel

切割面光滑无毛刺，切割过程中不飞铁屑
切割寿命稳定，产品切割精度高
最高切割20平方

Cutting surface smooth with no burrs, no iron filings during cutting
Reliable cutting lifespan, high cutting precision
Maximum cutting 20 square meters

计算公式Calculating Specifications

每齿切削量=进刀速度（每秒进给速度×60）÷齿数÷转数

Amount of Cutting per cutting tooth=feeding speed(feeding speed per second x 60) ÷ number of cutting tooth ÷ rotation rate

线速度=外径（毫米X0.001）×π（3.14）X转速

Linear velocity= outer diameter (mm x 0.001) ×π (3.14) X rotation rate

工作齿数=材料直径X锯片齿数÷锯片直径÷π（3.14）

Number of working cutting tooth= material diameter x number of saw cutting tooth÷ blade diameter÷π (3.14)

冷锯对切割材料的材质选择不同的参数切割，有以下几种：

Cold saw cutting choose different materials with different parameters. Per the following:

被切割材料名称 Name of the cutting material	锯片线速度（V） Blade linear velocity	每齿切削量（Sz） Amount of cutting per cutting tooth	锯片种类 Blade specifications
不锈钢材料 Stainless steel	50~80m/min	0.035~0.05mm	硬质合金涂层 Cemented carbide coating
合金工具钢 Alloy tool steel	70~100m/min	0.04~0.05mm	金属陶瓷涂层 Metal ceramic coating
高碳钢 High carbon steel	100~120m/min	0.05~0.07mm	金属陶瓷 Metal ceramic
中碳钢 Carbon steel	110~140m/min	0.08~0.12mm	金属陶瓷 Metal ceramic

通用型（V系列–S系列）冷锯切割寿命参数表

Universal Purpose(V series, S series) cold saw cutting lifespan specifications

材料型号 Material	锯切平方 Cutting area	锯片直径(mm) Blade diameter	转速(rpm) Blade speed	每齿进刀量（mm） Feeding speed percutting tooth
Q235低碳钢 low carbon steel	50	285–460	85–140	0.04–0.08
45#钢 Steel 45#	60	285–460	85–140	0.08–0.12
55#钢 Steel 55#	60	285–460	85–140	0.08–0.12
Gcr15轴承钢 Gcr15 bearing steel	25	285–460	85–140	0.04–0.07
42CrMo 高强度钢 42 CrMo high strength steel	30	285–460	85–140	0.05–0.08
65Mn 弹簧钢 65 Mn spring steel	15	285–460	85–140	0.04–0.07
40Cr 合金钢 40 Cr Alloy steel	30	285–460	85–140	0.05–0.08
20CrMnti 齿轮钢 Gear steel	30	285–460	85–140	0.05–0.08
6082铝合金 Aluminium alloy	80	285–460	85–140	0.05–0.1
铜合金 copper alloy	80	285–460	85–140	0.04–0.08

以上数据均为平均参数，仅供参考。

All the parameters above are average parameters and are for reference only.

圓鋸片系列Metal circular saw

立己達人 共创双赢

TARWIT, Cooperate to achieve a win-win situation

常用冷锯定位孔参数Blade hole

外径 Outer diameter	内孔 Arbor hole	板厚 Disc thickness	刃宽 Cutting edge thickness	定位孔 Pin hole	机型 Model
250	32	1.7/1.75	2	4/11/63	50
285	32	1.25	1.5		65-70
285	32	1.7/1.75	2.0		
285	40	1.7/1.75	2.0	4/11/80	90
315	32	1.75	2.0	4/11/63	
315	32	2.0	2.25	4/12/90+4/16/80	100
360	40/50	1.75	2.0		120
360	40/50	2.25	2.6		
380	40/50	2.25	2.6		
400	40/50	2.25	2.6/2.7		150
425	40/50	2.25	2.7	4/14/90+4/12/90 4/21/90+4/16/80	
460	50	2.25	2.7	4/14/90+4/16/80	160
480	50	2.25	2.7	4/16/80+4/16/90	
485	50	2.25	2.7	4/16/80+4/14/90	180
520	50	2.5	3.0		
560	50	2.5	3.0	4/21/120	200
630	80	2.7	3.4	4/23/120+4/23/160	
700	80	3.0	3.8	4/23/160+4/23/180	230
750	80	3.2	3.8		
840	70	3.0	3.4	4/22/125	260
840	80	3.2	4.0	4/26/150 4/26/160+4/26/200	
910	80	3.4	4.0	4/26/220	280
960	80	3.4	4.2	4/26/220	300
1200	100	4.0	5.0	8/31/200	400



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