



余姚市东方刃具厂

硬质合金旋转铰筒简介





企业简介

余姚市东方刀具厂位于经济发达的姚北重镇——泗门。东临宁波，西接杭州，地理位置优越，交通便捷。我厂实力雄厚，设施先进，具有三十多年的硬质合金旋转锉（钨钢磨头）生产经验，是国内最早生产硬质合金旋转锉工具的厂家之一。

我厂生产的“狼牙”牌硬质合金旋转锉，按照《GB/T 9217.1-2005》国家标准设计制造。产品规格齐全，质量上乘，产品畅销全国。远销东欧、美国、亚洲等国家和地区，深受广大客户青睐。

时代在进步，企业在前进。我们只有不断地努力，才能为客户提供更好的服务。企业宗旨是“优异的质量，满意的服务。”

我们愿与海内外朋友共建友好合作，共创美好未来。





营业执照

(副本)

统一社会信用代码 91330281144582652U (1/1)

名称 余姚市东方刀具厂
 类型 个人独资企业
 住所 余姚市泗门镇工业园区
 投资人 芦军飞
 成立日期 1984年04月28日
 经营范围 五金工具的制造、加工。(依法须经批准的项目，经相关部门批准后方可开展经营活动)



年报已公示
 (2016年度)
 年报已公示
 (2017年度)

登记机关



2017年02月24日

应当于每年1月1日至6月30日通过浙江省企业信用信息公示系统报送上一年度年度报告

企业信用信息公示系统网址: <http://gsxt.zjaic.gov.cn>

中华人民共和国国家工商行政管理总局监制

1633195



第 230280 号



商标注册证



核定使用商品(第 7 类)

硬质合金高建铁刀 (截止)

注册人 余姚市东方刀具厂

注册地址 浙江省余姚市泗门镇工业园区

注册有效期限 自公元 2005 年 07 月 30 日 至 2015 年 07 月 29 日

局长签发

李建昌





商标续展注册证明

兹核准第 230280 号商标第 7 类续展注册。

续展注册有效期至 2025 年 07 月 29 日

发证机关



注：本证明应与《商标注册证》一并使用。





环通认证中心有限公司
质量管理体系认证证书

编号：02418Q31011011R4M

兹证明

余姚市东方刀具厂

(统一社会信用代码：91330281144582652U)

(注册地址：余姚市泗门镇工业园区 邮编：315470)

(通讯/经营地址：浙江省宁波市余姚市泗门镇工业园区海通路92号 邮编：315470)

质量管理体系符合标准：

GB/T19001-2016/ISO9001:2015

质量管理体系覆盖范围：

“狼牙牌”硬质合金旋转锉的生产和服务

初次获证日期：2007年04月18日

发证日期：2018年01月23日

证书有效期至：2021年04月22日

(本证书有效期内每年需进行监督审核，证书是否继续有效以是否加贴监督合格标志为准。)

机构印章：



签发(主任)：

第一次监督
合格标志加贴处

第二次监督
合格标志加贴处

第三次监督
合格标志加贴处



中国认可
国际互认
管理体系
MANAGEMENT SYSTEM
CNAS C024-M

证书查询方式：可通过深圳市环通认证中心有限公司官网 (www.ucccert.com)，或国家认证认可监督管理委员会官网 (www.cnca.gov.cn) 查询





UNIVERSAL CERTIFICATION CENTRE CO., LTD.
QUALITY MANAGEMENT SYSTEM CERTIFICATE

No.: 02418Q31011011R4M

This is to certify that the quality system of

YUYAO EAST CUTTING TOOLS FACTORY

(UNIFIED SOCIAL CREDIT CODE: 91330281144582652U)

(REGISTERED ADD: YUYAO CITY, SIMEN TOWN INDUSTRIAL PARK TIANLU , P. R. CHINA ZIP: 315470)

(COMMUNICATION/OPERATION ADD: NO. 92, HAITONG ROAD, INDUSTRIAL PARK, SIMEN TOWN,

YUYAO, NINGBO, ZHEJIANG, P. R. CHINA ZIP: 315470)

is in conformity with:

GB/T19001-2016/ISO9001:2015

This system is valid to:

***PRODUCTION AND SERVICE OF THE "WOLF FANG" HARDMETAL
BURRS***

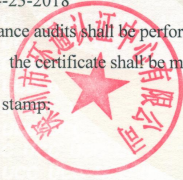
Initial Certification date: 04-18-2007

This Certificate is validity until: 04-22-2021

Issue date: 04-23-2018

(The surveillance audits shall be performed in a yearly manner during the validation. The continual effectiveness of the certificate shall be marked by the surveillance qualification logo as pasted below.)

Organization stamp:



Representative of the centre (Director):

1st surveillance logo

2nd surveillance logo

3rd surveillance logo



中国认可
国际互认
管理体系
**MANAGEMENT SYSTEM
CNAS C024-M**

The most recent information and status of the certificate are available from the UCC website(www.uccert.com) or CNCA website(www.cnca.gov.cn)
UCC telephone number: (+86 755)83355888 Address: 6/F,Yuhe Building,Qiaoxiang Road,Shenzhen,PR.China WeChat account:





安全生产标准化
Work Safety Standardization

证书
CERTIFICATE

证书编号: AQBIVJX 甬 B20140001

余姚市东方刀具厂
安全生产标准化四级企业
(机 械)

有效期至: 2019年11月30日

2014年12月1日

宁波市安全生产监督管理局监制







硬质合金旋转锉的用途： Applications of the Carbide rotary file:

- 清理铸、锻、焊件的飞边、毛刺和焊缝。
- 精加工各种金属模具。
- 叶轮流道的光整加工。
- 各种机械零件的倒角、倒圆和沟槽加工。
- 精加工机械零件内孔表面。
- 各种金属和非金属之工艺雕刻。
- Trimming flash edges, burrs and welding lines of casting, forging and welding parts;
- Finish machining various kinds of metal molds;
- Finishing cast gates of vane wheel;
- Chamfering, rounding and channeling of various kinds of machinery parts;
- Finish machining the surface of inner bore of machinery parts;
- Artistic engraving of all kinds of metal or nonmetal parts.

用户使用经验提示： Instructions for users:

- 使用时必须把刀具夹正夹紧，刀柄在夹具中不能伸到底，以免夹具底部不平整而造成同心度不正的问题。
- 切削方式以逆铣为好，避免往复走刀，且用力不宜过猛，压力不得超过4公斤。
- 操作时刀具接触工件时不宜太快，避免出现爆齿现象。
- 当刀具在运转过程中，严禁碰撞周围其他物件，以防止刀具断裂或者弯曲。
- 在对氧化物及表面粗糙的工件操作时，最好先选用已使用过的刀具去毛后，再使用新刀具进行操作，这样可以提高刀具使用寿命。
- Must clamp cutter tightly, and not let the handle of the cutter reach the bottom, avoiding the problem of askew of concentric degree because of uneven bottom.
- While cutting move the burs evenly from right to left, but not left to right again. Pay attention to exerting pressure too much, usually not exceeding 4kgs.
- It should not be too fast when the cutter touch the workpiece to prevent gear bursting.
- In order to avoid cutter rupture or bend, when the cutter is working, it is forbidden to impact other things.
- When using it for oxide or shaggy things, you'd better use old one to get rid of surface at first, then use the new one. That could prolong the use time.



切削选择 CUTTING CHOICES



粗刀齿：用于INOX钢，工具钢和焊接件的力切除
Coarse cutter tooth for effective cutting removal of INOX steel, tool steel and welding parts.



标准齿：用于不锈钢，淬火钢和铸铁的精加工
Standard tooth for finish machining of stainless steel, hardened steel and cast iron.



通用切齿：可交替用于软硬材料的切削
General-purpose cutter tooth may be alternatively used for cutting soft and hard materials.



特殊刀齿：用于铜、青铜和铝合金切削
Special cutter tooth for cutting copper, bronze and aluminum alloy.



菱形齿：对极硬合金、焊缝、铸铁的粗加工和精加工特别有效。粉碎的切削，可避免对操纵者的伤害。
Rhombic tooth is especially effective for rough machining and finish machining of extra hard alloy, welding line and cast iron. Smashing cut may avoid hurt to the operator.



断屑刀齿：用于未淬硬钢焊缝加工
Discontinuous chip cutter tooth for machining non-hardened hard steel and cast steel welding lines.

旋转锉定货方式：
The Carbide Rotary Burs
order style:

旋转锉选购分为15支组件套及单支订货；亦可根据用户特殊要求定制非标专用旋转锉，刀柄可加长到300mm内。

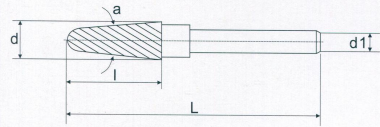
You can choose 15pcs/set and unit ,also can customize unstandard the Carbide Rotary Burs as costumers' requirement,the handle can lengthen to 300mm.

15支套装规格型号如下：
The model of 15pcs/set as follow:

A0616M06
AE1020M06
G0616M06
M0817M06
S1220M06
A1205M06
C0820M06
K1005M06
N1606M06
T1606M06
AX0820M06
D1009M06
L0822M06
S0804M06
W1018M06



EAST CUTTING TOOLS

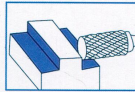
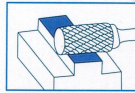
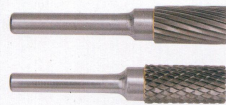


编号说明
Type Specification
例 L1025M0640
Example

L 10 25 M 06 40
外形代号 d l 齿形 柄径 柄长
Form Code Tooth Form Shank Dia Shank Length

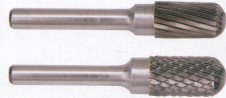
齿形 代号
Tooth Tooth
标准齿 M
Standard Tooth
粗齿 C
Coarse Tooth
细齿 F
Fine Tooth

圆柱形 (A型) Cylinder (Type A)



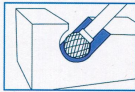
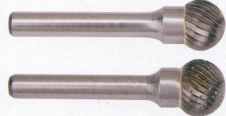
订货编号 Order No.	尺寸 Size					单元价 Unit Price (yuan)	齿形 Tooth form
	d	l	d1	L	a		
A0313M03	3	13	3	50		18	M
A0413M04	4	13	4	50		22	M
A0616M06	6	16	6	56		29	M
A0820M06	8	20	6	60		31	M
A1020M06	10	20	6	60		35	M
A1225M06	12	25	6	65		47	M
A1425M06	14	25	6	65		57	M
A1625M06	16	25	6	65		67	M
A0804M06	8	4	6	44		18	M
A1005M06	10	5	6	45		22	M
A1205M06	12	5	6	45		27	M
A1606M06	16	6	6	46		37	M

圆柱形球头 (C型) Cylinder with Round Head (Type C)



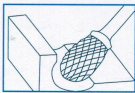
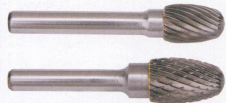
订货编号 Order No.	尺寸 Size					单元价 Unit Price (yuan)	齿形 Tooth form
	d	l	d1	L	a		
C0313M03	3	13	3	50		18	M
C0413M04	4	13	4	50		22	M
C0616M06	6	16	6	56		32	M
C0820M06	8	20	6	60		34	M
C1020M06	10	20	6	60		37	M
C1225M06	12	25	6	65		51	M
C1425M06	14	25	6	65		62	M
C1625M06	16	25	6	65		73	M

球形 (D型) Ball (Type D)



订货编号 Order No.	尺寸 Size					单元价 Unit Price (yuan)	齿形 Tooth form
	d	l	d1	L	a		
D0303M03	3	2.7	3	50		18	M
D0403M04	4	3.6	4	50		22	M
D0605M06	6	5.4	6	45		26	M
D0807M06	8	7.2	6	47		27	M
D1009M06	10	9	6	49		28	M
D1210M06	12	10.8	6	51		40	M
D1412M06	14	12.6	6	53		45	M
D1614M06	16	14.4	6	54		47	M
D2018M06	20	18.5	6	58		56	M

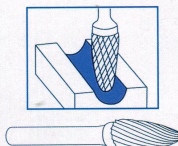
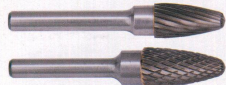
椭圆形 (E型) Oval (Type E)



订货编号 Order No.	尺寸 Size					单元价 Unit Price (yuan)	齿形 Tooth form
	d	l	d1	L	a		
E0610M06	6	10	6	50		36	M
E0813M06	8	13	6	53		40	M
E1016M06	10	16	6	56		45	M
E1220M06	12	20	6	60		51	M
E1422M06	14	22	6	62		62	M
E1625M06	16	25	6	65		72	M

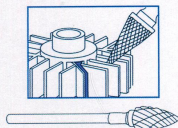
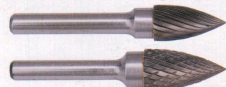


弧形圆头 (F型)
Arc with Round Head (Type F)



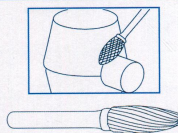
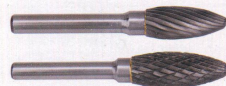
订货编号 Order No.	尺寸 Size					单元价 Unit Price (yuan)	齿形 Tooth form
	d	l	d1	L	a		
F0618M06	6	18	6	58		32	M
F0818M06	8	18	6	58		36	M
F1020M06	10	20	6	60		38	M
F1225M06	12	25	6	65		45	M
F1425M06	14	25	6	65		58	M
F1625M06	16	25	6	65		72	M
F2025M06	20	25	6	65		82	M

弧形尖顶 (G型)
Arc with Pointed Top (Type G)



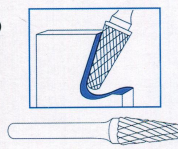
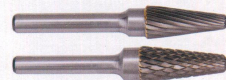
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	d	l	d1	L	a		
G0616M06	6	16	6	56		37	M
G0817M06	8	17	6	57		40	M
G1020M06	10	20	6	60		45	M
G1225M06	12	25	6	65		50	M
G1625M06	16	25	6	65		68	M

火炬形 (H型)
Torch (Type H)



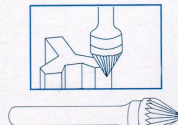
订货编号 Order No.	尺寸 Size					单元价 Unit Price (yuan)	齿形 Tooth form
	d	l	d1	L	a		
H0618M06	6	18	6	58		36	M
H0820M06	8	20	6	60		42	M
H1025M06	10	25	6	65		46	M
H1232M06	12	32	6	72		53	M
H1433M06	14	33	6	73		62	M
H1636M06	16	36	6	76		72	M

锥形圆头 (L型)
Cone with Round Head (Type L)



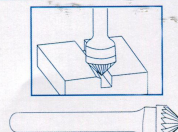
订货编号 Order No.	尺寸 Size					单元价 Unit Price (yuan)	齿形 Tooth form
	d	l	d1	L	a		
L0313M03	3	13	3	50		18	M
L0413M04	4	13	4	50		22	M
L0616M06	6	16	6	56	14°	29	M
L0822M06	8	22	6	62	14°	34	M
L1025M06	10	25	6	65	14°	40	M
L1228M06	12	28	6	68	14°	43	M
L1430M06	14	30	6	70	14°	57	M
L1632M06	16	32	6	72	14°	72	M

60°圆锥形 (J型)
60°Taper (Type J)



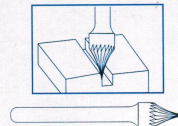
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	d	l	d1	L	a		
J0605M06	6	5.2	6	50	60°	29	M
J0807M06	8	7	6	52	60°	31	M
J1008M06	10	8.7	6	53	60°	33	M
J1210M06	12	10.4	6	65	60°	36	M
J1613M06	16	13.8	6	66	60°	45	M

90°圆锥形 (K型)
90°Taper (Type K)



订货编号 Order No.	尺寸 Size					单元价 Unit Price (yuan)	齿形 Tooth form
	d	l	d1	L	a		
K0603M06	6	3	6	50	90°	29	M
K0804M06	8	4	6	50	90°	31	M
K1005M06	10	5	6	50	90°	33	M
K1206M06	12	6	6	51	90°	36	M
K1608M06	16	8	6	53	90°	45	M

圆锥弧形 (X型)
Taper Arc (Type X)

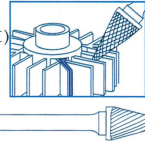


订货编号 Order No.	尺寸 Size					单元价 Unit Price (yuan)	齿形 Tooth form
	d	l	d1	L	a		
X0607M06	6	7	6	47		29	M
X0810M06	8	10	6	50		31	M
X1012M06	10	12	6	52		33	M
X1215M06	12	15	6	55		36	M
X1618M06	16	18	6	60		45	M



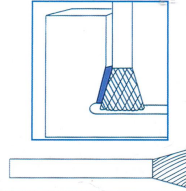
EAST CUTTING TOOLS

锥形尖头 (M型)
Cone with Pointed Head (Type M)



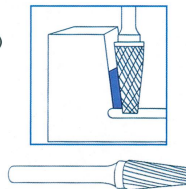
订货编号 Order No.	尺寸 Size					单元价 Unit Price (yuan)	齿形 Tooth form
	d	l	d1	L	a		
M0618M06	6	18	6	50	20°	36	M
M0817M06	8	17	6	57	26°	38	M
M1020M06	10	20	6	60	25°	44	M
M1225M06	12	25	6	65	25°	50	M
M1425M06	14	25	6	65	30°	56	M
M1625M06	16	25	6	65	34°	62	M
M2033M06	20	33	6	73		74	M

倒锥形 (N型)
Inverted Cone (Type N)



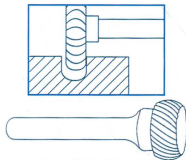
订货编号 Order No.	尺寸 Size					单元价 Unit Price (yuan)	齿形 Tooth form
	d	l	d1	L	a		
N1213M06	12	13	6	53	20°	37	M
N1616M06	16	16	6	56	20°	45	M
N1005M06	10	5	6	45	18°	26	M
N1205M06	12	5	6	45	22°	28	M
N1606M06	16	6	6	46	22°	40	M

圆锥平头 (S型)
Taper with Flat Head (Type S)



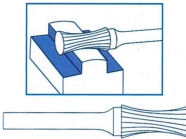
订货编号 Order No.	尺寸 Size					单元价 Unit Price (yuan)	齿形 Tooth form
	d	l	d1	L	a		
S0310M03	3	10	3	50	8°	18	M
S0413M04	4	13	4	50	8°	22	M
S0614M06	6	14	6	54	8°	28	M
S0817M06	8	17	6	57	12°	31	M
S1020M06	10	20	6	60	12°	36	M
S1220M06	12	20	6	60	16°	40	M
S1428M06	14	28	6	68	16°	45	M
S0804M06	8	4	6	44	16°	25	M
S1005M06	10	5	6	45	22°	26	M
S1205M06	12	5	6	45	22°	28	M
S1606M06	16	6	6	46	22°	40	M

半圆形 (T型)
Semi-Circle (Type T)



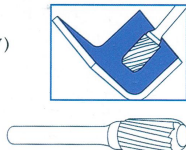
订货编号 Order No.	尺寸 Size					单元价 Unit Price (yuan)	齿形 Tooth form
	d	l	d1	L	a		
T0804M06	8	4	6	44		22	M
T1005M06	10	5	6	45		25	M
T1205M06	12	5	6	45		29	M
T1606M06	16	6	6	46		42	M

凹弧形 (U型)
Recessed Arc (Type U)



订货编号 Order No.	尺寸 Size					单元价 Unit Price (yuan)	齿形 Tooth form
	d	l	d1	L	a		
U0610M06	6	10	6	50		28	M
U0815M06	8	15	6	55		36	M
U1020M06	10	20	6	60		42	M
U1225M06	12	25	6	65		51	M
U1625M06	16	25	6	65		65	M

圆柱半圆形 (W型)
Cylinder Semi-Circle (Type W)

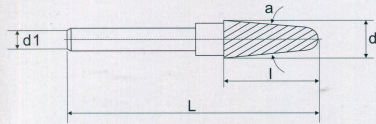


订货编号 Order No.	尺寸 Size					单元价 Unit Price (yuan)	齿形 Tooth form
	d	l	d1	L	a		
W0614M06	6	14	6	54		33	M
W0818M06	8	18	6	58		35	M
W1018M06	10	18	6	58		38	M
W1222M06	12	22	6	62		52	M
W1422M06	14	22	6	62		63	M
W1622M06	16	22	6	62		74	M



浙江余姚市东方刀具厂

ZHEJIANG YUYAO EAST CUTTING TOOLS FACTORY

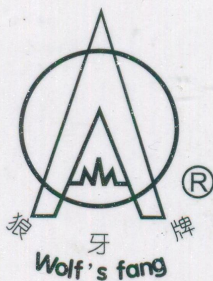


编号说明
Type Specification
例 L613M0345
Example

L 6 13 M 03 45
外形代号 d l 齿形 柄径 总长
Form Code Tooth Form Shank Dia Length

形状名称 Form Denomination	编号 NUMBER	尺寸 SIZE			
		d	l	d1	L
A型	A4	4	12	3	45
	A5	5	12	3	45
	A6	6	13	3	45
C型	C4	4	12	3	45
	C5	5	12	3	45
D型	D4	4	4	3	45
	D5	5	5	3	45
	D6	6	6	3	45
E型	E4	4	7	3	43
	E5	5	8	3	45
	E6	6	10	3	48
F型	F4	4	12	3	45
	F5	5	12	3	45
G型	G4	4	12	3	45
	G5	5	12	3	45
H型	H4	4	13	3	45
	H5	5	13	3	45
L型	L4	4	12	3	45
	L5	5	12	3	45
M型	M4	4	12	3	45
	M5	5	12	3	45
N型	N4	4	6	3	42
	N5	5	7	3	43
	N6	6	7	3	43
上下半双型 D'	D'6	6	3.5	3	45
	D'8	8	4.5	3	45
T型	T1.5	12	1.5	3	45
	T2	12	2	3	45
	T3	12	3	3	45

形状名称 Form Denomination	编号 NUMBER	尺寸 SIZE			
		d	l	d1	L
A型	A41	1.5	6	3	38
	A41L	2	12	3	38
	A42	2.5	14	3	38
	A43	3	16	3	38
C型	C41L	1.5	6	3	38
	C41L ₂	2	12	3	38
	C41	2.5	14	3	38
D型	C42	3	16	3	38
	D41L	1.5	1.3	3	38
E型	D41L ₂	2	1.8	3	38
	D41L ₃	2.5	2.3	3	38
	D42	3	3	3	38
F型	E41	3	5.5	3	38
	F42	3	12	3	38
G型	F43	3	16	3	38
	G41	3	6	3	38
	G42	3	12	3	38
H型	G43	3	16	3	38
	G44	3	16	3	38
L型	H41	3	6.3	3	38
	L41	3	10	3	38
	L42	3	12	3	38
M型	L43	3	16	3	38
	M41	3	9	3	38
N型	M42	3	12	3	38
	M43	3	16	3	38
	N42	3	4	3	38



浙江余姚市东方刃具厂

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