

DRILLING





DIAMOND DRILLING TOOLS

CHARACTERISTICS OF PRODUCTS

1. High efficiency, no-chipping, long life.
2. Selectable adaptor sizes: Dia 6/8/10mm shank, M14 thread, 5/8"-11 thread or Gas 1/2" etc.

Product name	Dimension(mm)	Usable Length(mm)	Suggested R.P.M
Plane Bits	6.0-6.5	40	4500
Plane Bits	8.0-9.0	40	4300
Plane Bits	10	40	4100
Plane Bits	12-16	40	3500 - 4000
Segment Bits	18	40-100	3500 - 4000
Segment Bits	19-32	40-100	3000 - 3500
Segment Bits	35-50	40-100	2500 - 2800
Segment Bits	51-100	40-100	1500 - 2500
Segment Bits	100-150	40-100	1500
Crown Bits	10-20	47	3500 - 4300
Crown Bits	20-35	47-100	3000 - 3500
Crown Bits	35-50	47-100	2500 - 2800
Crown Bits	50-60	47-100	2000 - 2500

CORE DRILL BITS

CHARACTERISTICS OF PRODUCTS

1. High efficiency, long life and no breaking of segments.
2. Sizes of adaptor for threaded bit: M14, M16, G1/2", 5/8"-11.
3. Applicable for drilling of brick wall, concrete, concrete with steel.

Type	Code	Description (mm)	Spec (mm)	Tooth (Entries)	Usable Length(mm)	Suggested R.P.M	Feed Speed (mm/min)
Core Drill Bit	CDB	19-22	10x3x10	3	40	3000-3500	70-90
Core Drill Bit	CDB	25	10x3x10	3	40	3000-3500	70-90
Core Drill Bit	CDB	30-32	10x3x10	3	40	3000-3500	70-90
Core Drill Bit	CDB	35-40	10x3x10	3	40	2000-2800	60-80
Core Drill Bit	CDB	45-50	10x3x10	3	40	2000-2800	50-60
Core Drill Bit	CDB	55	10x3x10	3	40	1500-2000	40-60
Core Drill Bit	CDB	60	10x3x10	3	40	1500-2000	40-60
Core Drill Bit	CDB	65	10x3x10	3	40	1500-2000	40-60
Core Drill Bit	CDB	70	10x3x10	3	40	1500-2000	40-60
Core Drill Bit	CDB	75-85	10x3x10	3	40	1500-2000	40-60
Core Drill Bit	CDB	90	10x3x10	3	40	1500-2000	40-60
Core Drill Bit	CDB	95-100	10x3x10	3	40	1000-1500	25-45
Core Drill Bit	CDB	125	10x3x10	3	40	1000-1500	25-45
Core Drill Bit	CDB	150	10x3x10	3	40	1000-1500	25-45



FINGER BITS

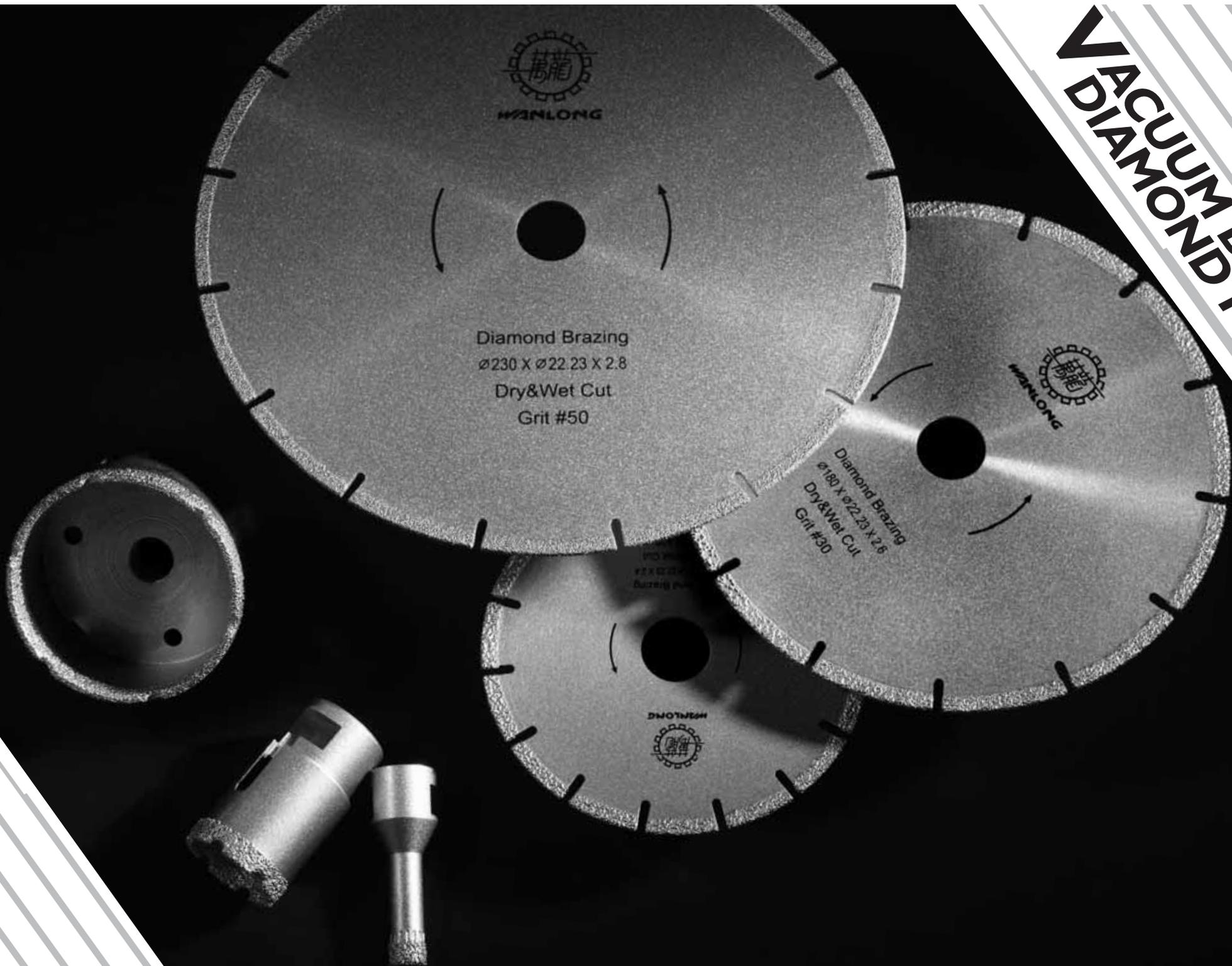
CHARACTERISTICS OF PRODUCTS

1. High efficiency, long life and fast milling speed.
2. Finger bit is a kind of milling cutter, mostly with GAS 1/2" connection.

Type	Diameter (mm)	Length (mm)	Size	Connection	Suggested R.P.M	Feed Speed (mm/min)
Segmented	20	20	5teeth	G1/2"		370-520
Segmented	20	25	5teeth	G1/2"		350-500
Segmented	20	30	5teeth	G1/2"		330-480
Segmented	20	35	5teeth	G1/2"		310-440
Segmented	20	40	5teeth	G1/2"	4400 - 4900	300-400
Segmented	20	45	5teeth	G1/2"		250-330
Segmented	20	50	5teeth	G1/2"		230-300
Segmented	20	55	5teeth	G1/2"		200-280
Segmented	20	60	5teeth	G1/2"		100-180
Segmented	24	20	5teeth	G1/2"		350-500
Segmented	24	25	5teeth	G1/2"		330-480
Segmented	24	30	5teeth	G1/2"		310-460
Segmented	24	35	5teeth	G1/2"		290-420
Segmented	24	40	5teeth	G1/2"	4200 - 4600	280-380
Segmented	24	45	5teeth	G1/2"		230-310
Segmented	24	50	5teeth	G1/2"		200-280
Segmented	24	55	5teeth	G1/2"		180-260
Segmented	24	60	5teeth	G1/2"		80-160

Other specifications are available upon request.

VACUUM BRAZED DIAMOND PRODUCTS





VACUUM BRAZED DIAMOND SAW BLADE

CHARACTERISTICS OF PRODUCTS

1. High bonding strength, good sharpness, high cutting efficiency, good life span.
2. Vacuum brazed diamond saw blade can be used to cut granite, marble, superhard natural stone, walls, glass, ceramic tiles etc.

Specification for vacuum brazed diamond saw blades.

Diameter(mm)	Thickness(mm)	Bore(mm)	Teeth
Φ 105	1.2	20/22.23	12
Φ 110	1.2	20/22.23	12
Φ 115	1.4	20/22.23	13
Φ 125	1.4	20/22.23	15
Φ 150	1.6	20/22.23	11
Φ 180	1.6	20/22.23	13
Φ 230	1.8	20/22.23	16

Other specifications are available upon request.

VACUUM BRAZED DIAMOND CORE BIT

CHARACTERISTICS OF PRODUCTS

1. High efficiency, long life span.
2. Vacuum brazed diamond core bit can be used to drill granite, marble and other stone because of its unique advantage.

Specification for vacuum brazed diamond saw blades.

Diameter(mm)	Connection	Working Layer(mm)
Φ 6	5/8"-11, M14/M16	10
Φ 8	5/8"-11, M14/M16	10
Φ 10	5/8"-11, M14/M16	10
Φ 12	5/8"-11, M14/M16	10
Φ 27	5/8"-11, M14/M16	10
Φ 35	5/8"-11, M14/M16	10
Φ 50	5/8"-11, M14/M16	10
Φ 60	5/8"-11, M14/M16	10
Φ 75	5/8"-11, M14/M16	10

Core bit with diameter 6-250 mm is available upon request.



VACUUM BRAZED DIAMOND WIRE SAW AND BEAD

CHARACTERISTICS OF PRODUCTS

1. High bonding strength, high cutting efficiency, good life span.
2. Vacuum brazed wire saw can be used to cut large size block in quarry and processing.
3. Different bonds and diamond concentrations are available for different kinds of material such as granite, marble, sandstone etc.

Specification for vacuum brazed diamond saw blades.

Bead Diameter(mm)	Number Of Bead	Bead Length(mm)	Fixed Ways
Φ 8.8	33	12	Rubber+Spring
Φ 9.8	33	12	Rubber+Spring
Φ 11	33	12	Rubber+Spring

DIAMOND BLADE TROUBLE SHOOTING

THIS TROUBLE SHOOTING GUIDE WILL HELP YOU IDENTIFY, DIAGNOSE AND CORRECT DIAMOND BLADE PROBLEMS.

MOST PROBLEMS RESULT FROM

1. Using the blade for improper workplace.
2. Using the blade improperly.
3. Equipment problems.

Symptom	Causes	Remedies
Segment is abnormal	Segments fly out	Change to a softer bond, which will wear away more readily allowing the dull diamonds to be released and sharp, new cutting edges to become exposed. Check segment welding solidity.
	Overheating due to lack of water	Check water feed system and make sure the water flow is adequate on both sides of blade.
	Incorrect blade tension	Ensure blade is running at correct rpm.
Blade is abnormal	When feeding speed is increased, amperage becomes excessive	Check if the peripheral speed and motor power match blade diameter. If the sawing is carried out in a single cut: "sharpen" the blade into a soft and abrasive material (sandstone). If the sawing is carried out in a single cut: "sharpen" the blade with soft and abrasive material (e.g. sandstone).
	Insufficient cutting speed, The blade glazes	Increase the feed speed.
	Cutting deviations	Make sure that the work piece is firmly held and the blade is sharpened, if not sharpen", "sharpen" it (see above).
		Check the blade flatness. Make sure that flange diameter is suited to the blade diameter, installation of the shaft.
Dissatisfied cutting surface	Irregular surface finish	Check blade side run-out, shaft radial run-out and tension. Check flange and flange block side run-out.
		Make sure that cutting is correctly carried out.
	Chipped corner arises	Check flange and flange block side run-out. Check blade side run-out, shaft radial run-out, flatness and tension.
Excessive wear of diamond section	Excessive wear of depth	Check the cutting speed and the peripheral speed. Make sure that watering is sufficient and the machine is not subject to excessive vibrations.
		Make sure that watering is sufficient.
	Excessive lateral wear	Check flange and flange block side run-out. Check blade side run-out, shaft radial run-out and tension.