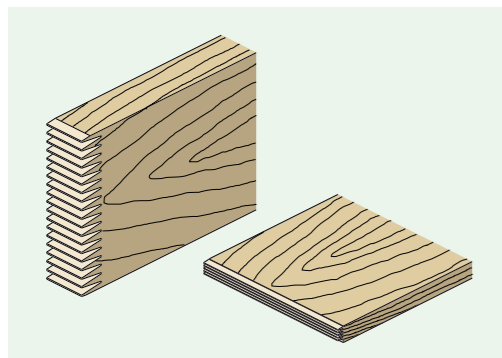


# 指接加工

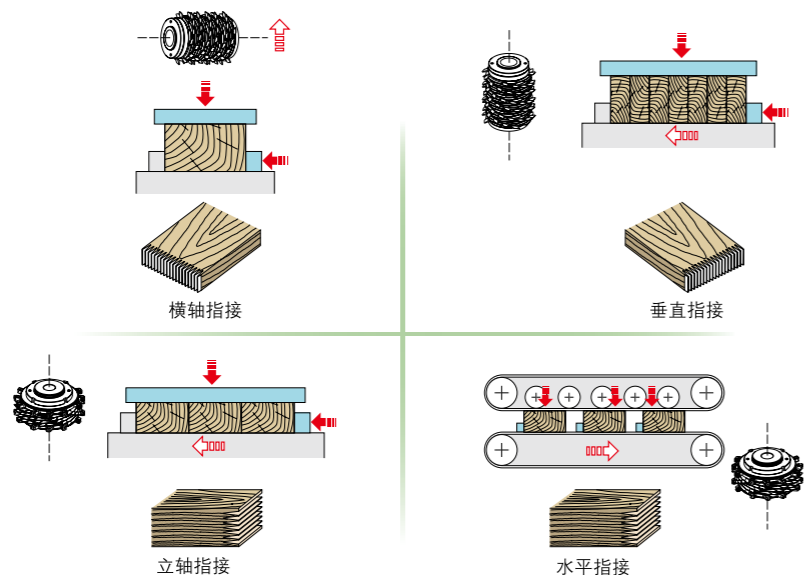
## 指接技术



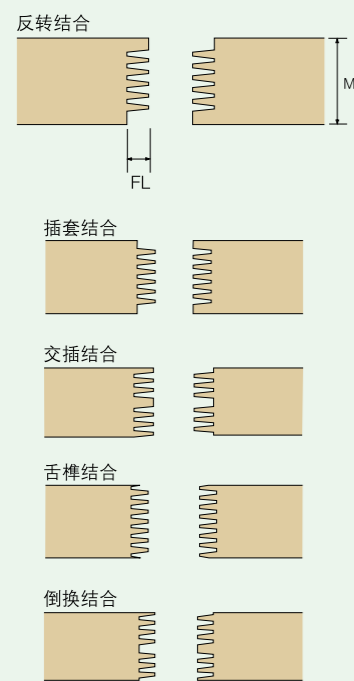
根据成品可有不同的加工方法。一般我们以水平和垂直指接，成批送料和通过送料机区分。

大批送料机；木块一端固定夹住另一端，通过铣刀成型。

通过送料机；木材通过链条，传送过铣刀。



### 标准样式



立轴指接机通常用于生产跨距超过50m较大复合木材。指接长度通常在15mm到25mm之间。

横轴指接用在建筑和非建筑制品。指接长度从4mm到10mm之间，建筑结合达20mm的制品用。

非建筑指接制品包括门窗框，模制品，门制品，木箱等。水平指接也在复合木材，I-横梁和立体建筑木材。

此外不同的加工方法和指接长度，我们以结合样式区分。

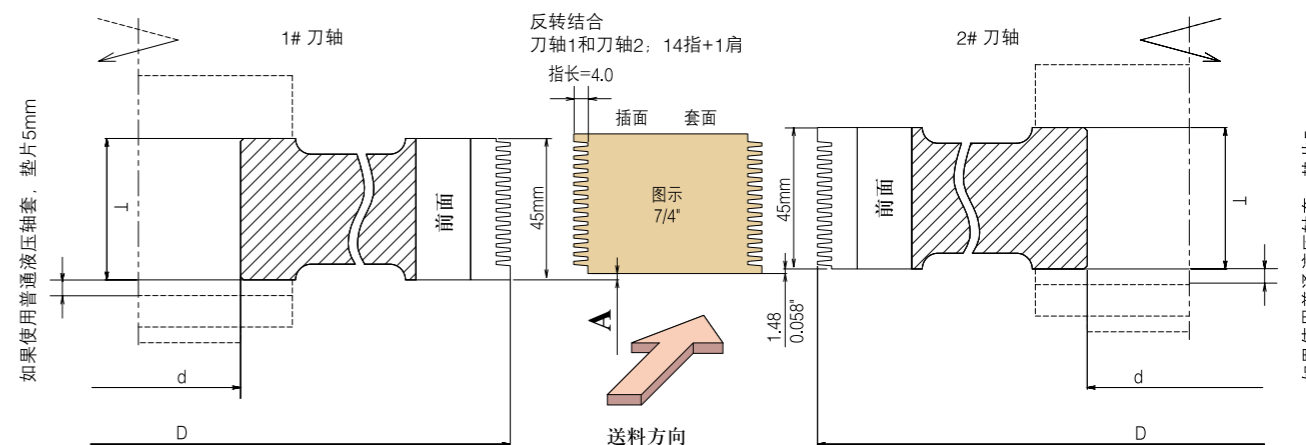
常见的是反转结合式，其次是交插结合式。

二次锯是一种特殊的结合，在木块中心有一个较厚的指接刀，把木块再锯成两块。

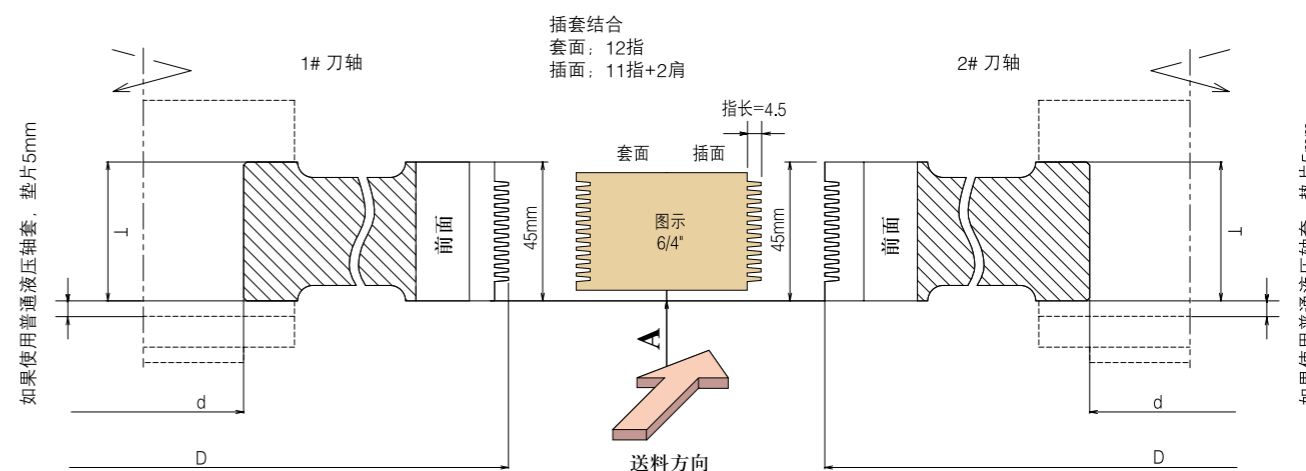
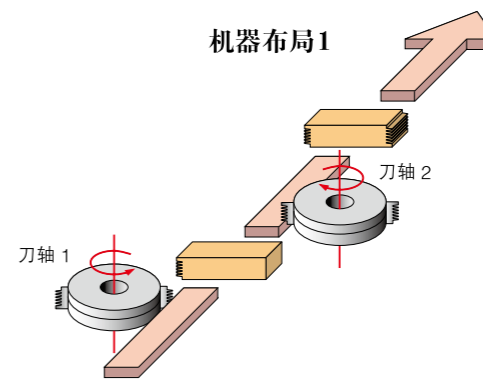
嵌接或舌榫结合用于建筑木制品。

# 指接加工

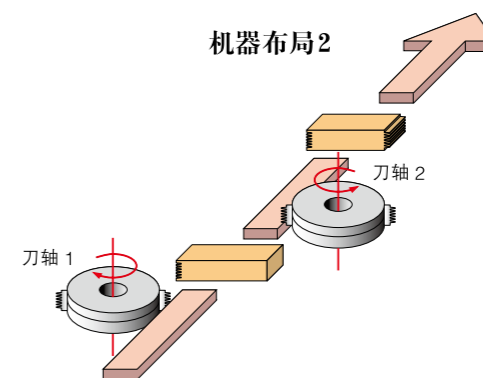
## 水平指接加工



机器布局1



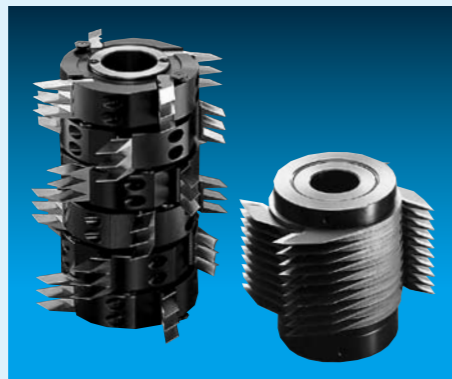
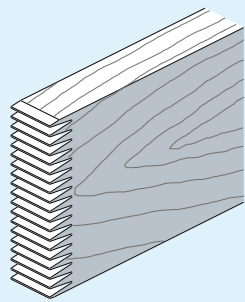
机器布局2



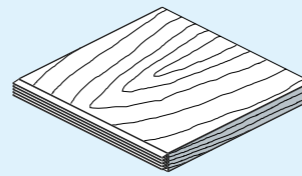
## 高科技涂层指接刀

组合型单刀 / 替换型长颈式指接刀  
指接刀

适用  
用于木接头



Application  
Finger Jointing



## Finger Jointing Cutter

Single Cutter Type, "TA" Finger Cutter  
Finger jointing

### 特长

高科技指接刀分两种，一种是施有表面涂层的钨钢合金 (U-P) 组合型单刀，另一种是施有表面涂层的高速钢 (H-P) 轴型刀。

#### 组合型单刀

- 1) 组合型单刀是用钨钢合金施有表面涂层所制。和普通指接刀相比，寿命最高长5倍。
- 2) 刀体本身经过特殊热处理，对强烈的切削抵抗力也有不变形的效果。
- 3) 减少换刀和调整的时间，维持生产线机械的开动率。

#### 替换型长颈式指接刀

- 1) 替换型长颈式指接刀是高速钢轴型刀施有表面涂层所制。和普通替换型长颈式指接刀相比，最高寿命长5倍。
- 2) 刀尖形状特殊。和普通型相比，有预防树脂附着的效果。
- 3) 减少换刀和调整的时间，维持生产线机械的开动率。

### Features

Single cutter type with U-P coating on tungsten carbide and Block tooth type with H-P coating on HSS are available.

#### Single Cutter type

- 1) Single Cutter type is of "U-P" coating on tungsten carbide. Up to 5 times longer cutting life against other tungsten carbide finger cutter is possible.
- 2) Heat-treated body can withstand hard cutting resistance against possible bending of cutter body.
- 3) Down time for cutter changes and adjustments become minimal. Higher productivity of your manufacturing line and remarkable reduction of running cost are guaranteed.

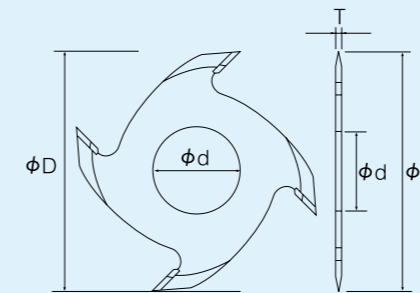
#### "TA" Finger Cutter

- 1) "TA" Finger Cutter is of "H-P" coating on HSS block teeth. Up to 5 times longer cutting life against other normal HSS finger cutter is possible.
- 2) The special cutting edges are much sharper and resin adhesion on teeth is minimized.
- 3) Down time for cutter changes and adjustments become minimal. Higher productivity of your manufacturing line and remarkable reduction of running cost are guaranteed.

刀头材质	Edge Material
HC-UP	HC-UP

## 组合型单刀 / Single cutter type

组合型单刀 / Single cutter type



## 组合型单刀 / Single cutter type

商品编号 Order no.	尺寸 Size				型号 Type	齿距 Pitch	刀头材质 Edge material
	(D)	(T)	(d)	(Z)			
1	160	3.8	70	4	10 / 11	3.8mm	HC-UP
2	160	3.8	70	2	10 / 11	3.8mm	HC-UP
3	160	7.6	70	4	10 / 11	3.8mm x 2	HC-UP
4	160	11.4	70	4	10 / 11	3.8mm x 3	HC-UP
5	250	3.8	70	6	10 / 11	3.8mm	HC-UP
6	250	15.2	70	6	10 / 11	3.8mm x 5	HC-UP

# 指接刀

替换型 (TA) 长颈式指接刀

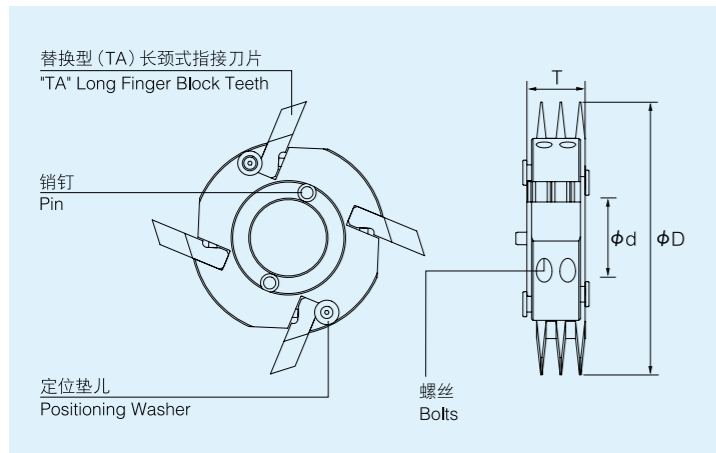
## "Finger Jointing Cutter

"TA" Long Finger Jointing Cutter



刀头材质	Edge Material
HS-HP	HS-HP

### 替换型 (TA) 长颈式指接刀 / "TA" Long Finger Jointing Cutter

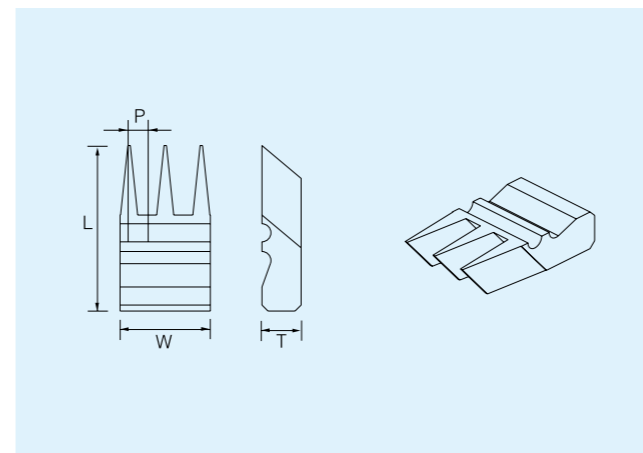


\*有效可用刀数是两刀为4次, 3刀为6次。  
\*其他规格也可制作, 请和我方联络。  
\*Actual working teeth are 2 for 4 teeth and 3 for 6 teeth.  
\*Other specifications are available. Please consult with our staff.

### 替换型 (TA) 长颈式指接刀 / "TA" Long Finger Cutter Body

商品编号 Order no.	尺寸 Size				型号 Type	齿距 Pitch
	(D)	(T)	(d)	(Z)		
1	160	38	50	4	10 / 10	3.8mm
2 887-A020-500	160	38	50	4	10 / 11	3.8mm
3	170	38	50	4	15 / 15 15 / 16.5	3.8mm
4	180	37.2	40	4	20 / 20 20 / 22	6.2mm
5 887-A004-500	250	38	50	6	10 / 10 10 / 11	3.8mm
6	260	38	50	6	15 / 15 15 / 16.5	3.8mm

### 替换型 (TA) 长颈式指接块刀 / "TA" Long Finger Block Tooth



\*型号20 / 22和25 / 27等指接刀可根据具体情况, 用锯片切割两接头长度进行调节。  
\*Model 20/22, 25/27 indicates that the finger length can be adjusted between the two fingers by positioning of cut-off sawblade.

### 替换型 (TA) 长颈式指接块刀 / "TA" Long Finger Block Tooth

商品编号 Order no.	尺寸 Size	型号 Type	齿距 Pitch	刀头材质	
				Edge material	
		(W)	(L)	(T)	(P)
1 779-0034-611	35 x 45 x 13 for 10 fingers / 用 10 指接	10 / 10	3.8mm	HS-HP	
2 779-0068-611	35 x 45 x 13 for 5 fingers / 用 5 指接	10 / 11	3.8mm	HS-HP	
3 779-0042-611	35 x 50 x 13 for 10 fingers / 用 10 指接	15 / 15	3.8mm	HS-HP	
4 779-1503-611	35 x 50 x 13 for 10 fingers / 用 10 指接	15 / 16.5	3.8mm	HS-HP	
5 779-0050-611	32.5 x 55 x 13 for 6 fingers / 用 6 指接	20 / 20	6.2mm	HS-HP	
6 779-0109-611	30 x 55 x 13 for 6 fingers / 用 6 指接	20 / 22	6.0mm	HS-HP	

# 指接刀

替换型 (TA) 指接刀

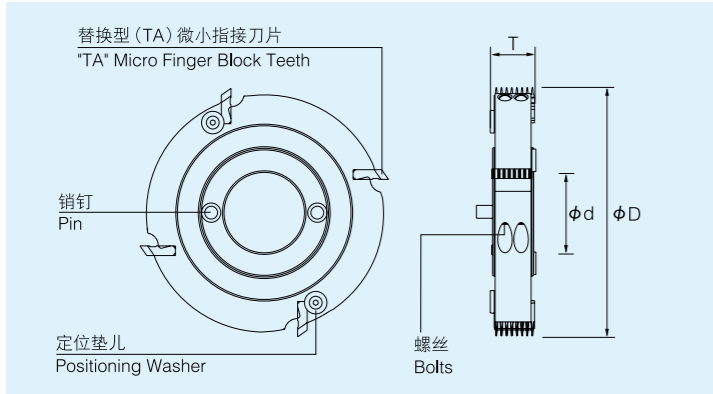
## Finger Jointing Cutter

"TA" Micro Finger Jointing Cutter



刀头材质	Edge Material
HS-HP	HS-HP

### 替换型 (TA) 微小指接刀 / "TA" Micro Finger Cutter

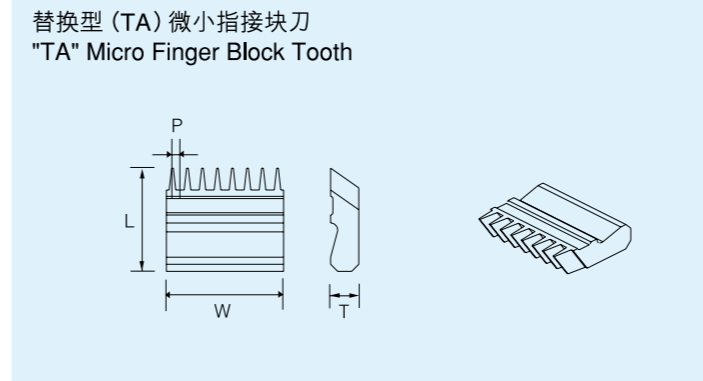


\*有效可用刀数是两刀为4次, 3刀为6次。  
\*其他规格也可制作, 请和我方联络。  
\*Actual working teeth are 2 for 4 teeth and 3 for 6 teeth.  
\*Other specifications are available. Please consult with our staff.

### 替换型 (TA) 微小指接刀体 / "TA" Micro Finger Cutter Body

商品编号 Order no.	尺寸 Size				型号 Type	齿距 Pitch
	(D)	(T)	(d)	(Z)		
1	160	25.6	50	4	3.5 / 4.5	1.6mm
2	210	25.6	50	6	3.5 / 4.5	1.6mm
3	250	25.6	50	6	3.5 / 4.5	1.6mm

### 替换型 (TA) 微小指接块刀 / "TA" Micro Finger Block Tooth



\*型号3.5 / 4.5可根据具体情况, 用锯片切割两接头长度调节从3.5mm到4.5mm。  
\*其他规格也可制作, 请和我方联络。  
\*Model 3.5/4.5 indicates that the finger length can be adjusted from 3.5mm to 4.5mm by positioning of cut-off sawblade.  
A finger length to make "zero" pinhole joint varies according to the various conditions.  
\*Other specifications are available. Please consult with our staff.

### 替换型 (TA) 微小指接块刀 / "TA" Micro Finger Block Tooth

商品编号 Order no.	尺寸 Size			型号 Type	齿距 Pitch	表面涂层 Coating
	(W)	(L)	(T)			
1	25	22	6	3.5 / 4.5	1.6mm	HS-HP

### 替换型 (TA) 微小指接刀轴+块刀 / "TA" Micro Finger Cutter Body+Block Tooth

商品编号 Order no.	尺寸 Size	型号 Type	齿距 Pitch	表面涂层 Coating	
					(D)
1	887-A002-500	160 x 25.6 x 50 x 4	3.5 / 4.5	1.6mm	HS-HP