CONVENTIONAL ABRASIVES FOR PRECISION GRINDING

molemab®
we shape your world

Special thanks to:
A.Z. Spa, Rosa Ermando Spa and Samputensili Machine Tools S.r.l.
for kindly allowing us to use their facilities
and equipment in the photographs of this catalogue.

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we shape your world

THE GROUP

THE HEADQUARTERS

molemab's head office is located in Ome, province of Brescia, in the Franciacorta winegrowing area of northern Italy. From here the molemab group is organised. This is the main factory where the conventional and superabrasive vitrified bonded wheels are manufactured.
Another facility, located in Maclodio, in the province of Brescia, is where some types of vitrified and resinoid bonded wheels are produced using a highly automated technology.
The factories in Ome and Maclodio are amongst the best organised facilities in Europe, including a manufacturing line with presses up to 2,500 tons as well as a modern research and development department.

THE PRODUCTION FACILITIES

The presence of molemab worldwide has been spreading throughout the years thanks to the growing potential and market demand of hi-tech products.
molemab Inotech GmbH is located in Launsdorf, Austria. This is an advanced factory, focused on resinoid and metal bonded Diamond and CBN hi-tech wheels produced by the most modern machinery.
In Oswego, Illinois (USA) molemab USA Corp. there is a productive unit of Diamond and CBN vitrified bonded wheels produced by latest generation plants.
Having over 50 years of experience, the molemab Group is now able to produce 5,000 tons of wheels per year, with diameters up to 2,100 mm.

THE COMMERCIAL BRANCHES

In addition to the production facilities molemab has various commercial branches.
They follow customers worldwide, providing technical and commercial support for every industrial sector.
The European market is serviced by molemab Iberica SLU (Barcelona, Spain), molemab Super-abrasifs France Sas (Chassieu, France), molemab Schleifmittel GmbH (Ottobrunn, Germany); molemab Abrasives Hungary (Budapest); whilst in North America molemab Canada (Sainte-Julie), molemab USA (Queensbury) and molemab de Mexico (Queretaro) operate.
Supported by qualified distributors and agents worldwide, molemab can reach all of its customers, wherever they are.

molemab in the world


Chassieu
(France)
Ome, Brescia
(Italy)
Maclodio, Brescia
(Italy)
Pszczyna
(Poland)
Ottobrunn
(Germany)
Launsdorf
(Austria)
Budapest
(Hungary)
Shanghai
(China)

OUR VISION

molemab aspires to a well-distributed and sustainable technological progress, respecting human dignity and environment.

OUR MISSION

molemab designs modern and efficient technological solutions in the abrasives' field. The company's goal is to offer its customers
the confidence to work with the most reliable products.

HIGHLIGHTS

molemab finds its roots in the heritage of its territory: the passion for work, moral coherence and concreteness. Great successes over the years have been achieved thanks to the quality of work of all the employees. With its endless research for the best products, machinery and raw materials, molemab has been able to build a strong and solid business history.
A continuous, harmonious growth with its customers, partners and suppliers remains the main goal for molemab in Italy and worldwide.
molemab is proud of its work and its values and retains them with passion and integrity.

OUR VALUES

Since 1961, when molemab started its activity, the world has changed and so have the markets, the manufacturing processes materials and the technological challenges. molemab values still remain the same: innovation, safety, quality and strong collaboration with customers and suppliers.

INNOVATION Since its foundation molemab has strived for constant improvement. Original patents, unique and custom made equipment and the most modern solutions have always characterised molemab history. molemab takes on the most difficult challenges: conventional wheels for the toughest applications and special superabrasive wheels reaching almost the speed of sound.

SAFETY molemab aims to ensure its customers and partners the safest working conditions and environment. molemab applies the strictest safety rules in manufacturing while making accurate security tests in its laboratories.

QUALITY The certifications ISO 9001 and OSA accredited to molemab in all the production facilities are the result of constant research. molemab quality is granted by meticulous production controls together with the continuous improvement of its technicians' skills and a scrupulous analysis of the market requirements.

COLLABORATION Sharing experiences between the manufacturer and the end user leads to the best results. The feedback exchange and dialogue are the two pillars on which molemab's success is based. Sharing ideas, ambitions and problems with our partners while keeping an eye on market evolution and dynamics is the key to step by step growth.

11

GENERAL INFORMATION ABOUT ABRASIVES AND GRINDING WHEELS

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STANDARD SIZES AND SPECIFICATIONS

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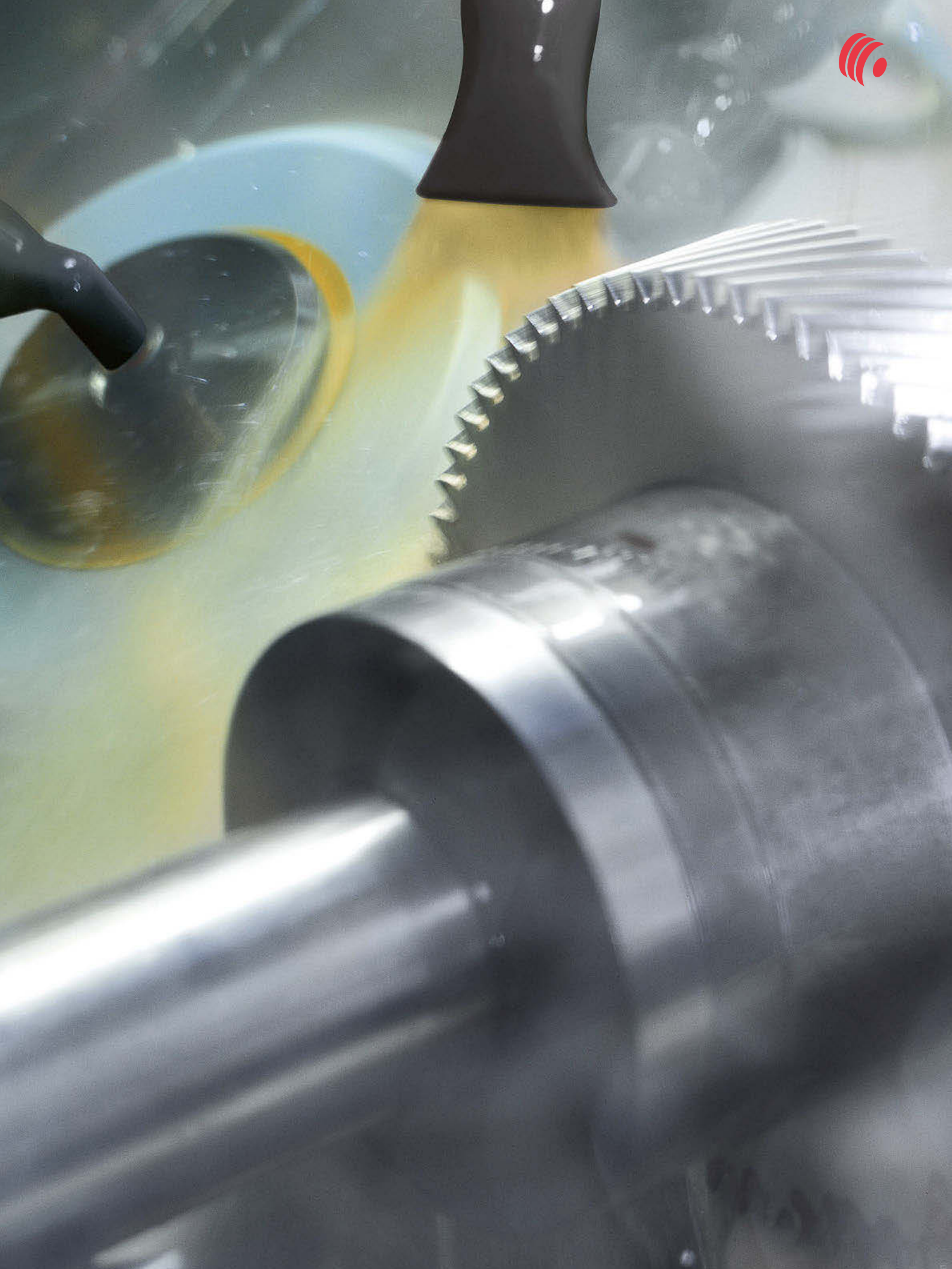
GENERAL INFORMATION ABOUT WHEEL DRESSING, DIAMOND TOOLS

GENERAL INFORMATION ABOUT THE ABRASIVES AND WHEELS



E.G. LINE

Easy Grind is the latest generation of wheels born in the Research & Development department of molemab. New bond types give unique characteristics to the vitrified wheels of THE E.G. line.

- they offer a cold cutting
- they facilitate the introduction of the refrigerant into the area between wheel and piece
- they allow a better chip removal
- they guarantee the respect of geometry
- they reduce the diamond dressing cycles
- they increase the life of the wheel
- they increase the productivity

APPLICATION	VITRIFIED FOR ALLUMINIUM OXIDE
General	VX
External grinding	VK
Surface grinding	VG
Gear grinding	V40

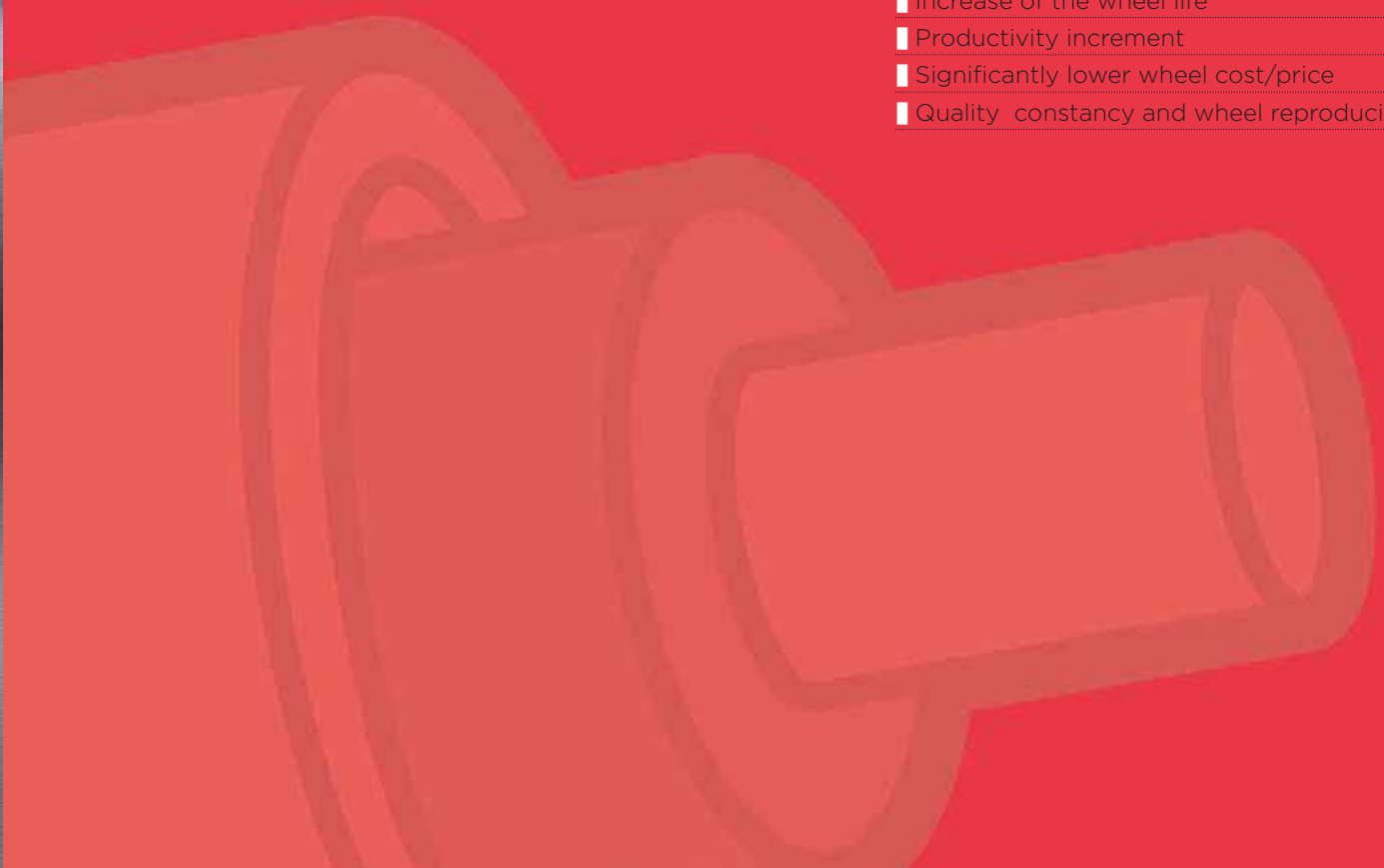
APPLICATION	VITRIFIED FOR SILICON CARBIDE
General	VJ

PERFECTA, PERFECTA MVC AND PERFECTA ROLL

The abrasive wheels of the new Perfecta line, fruit of years of continuous research and technical experimentation are manufactured specifically for the centreless grinding of bars and tubes and for cylindrical grinding for the hot and cold rolling.
The Perfecta abrasive wheels are manufactured by using new abrasives, bond types of exclusive formulation and with special and innovative firig cycles.
Each phase ofthe molemab production cycle is followed by highly specialized personnel constantly helped by the internal information network with programs dedicated to the total monitoring of the transformation process of the abrasive product; also the abrasive wheels of the new Perfecta series are manufactured by following this rigid methodology and this allows guaranteeing our customers a very high quality standard, the utmost safety and reliability for the use and the absolute reproducibility over time.

COLD CUTTING

- High respect of geometry
- Reduction of the diamond dressing cycles
- Increase of the wheel life
- Productivity increment
- Significantly lower wheel cost/price
- Quality constancy and wheel reproducibility



WHEEL SHAPES

ACCORDING TO FEPA STANDARDS

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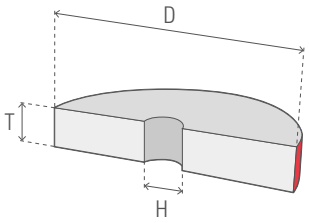

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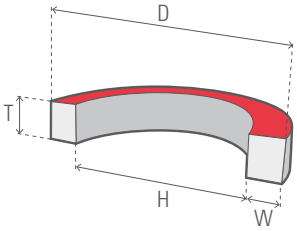

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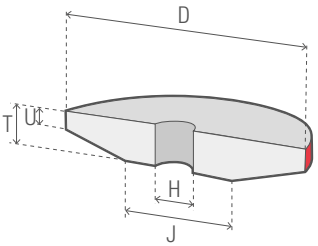

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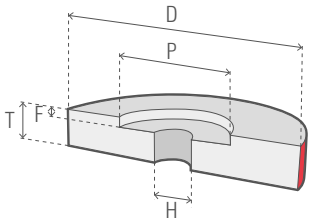

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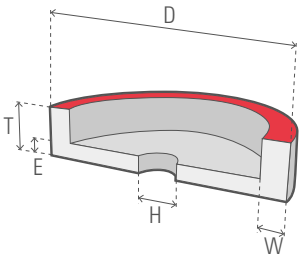

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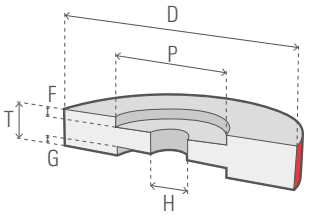

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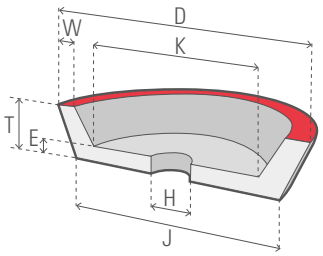

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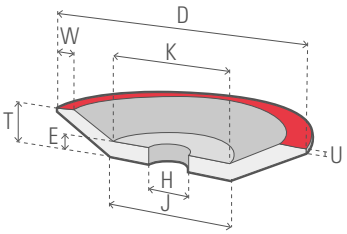

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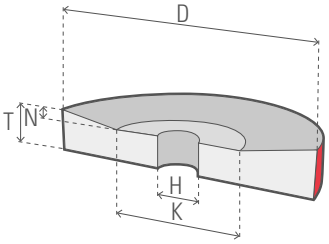

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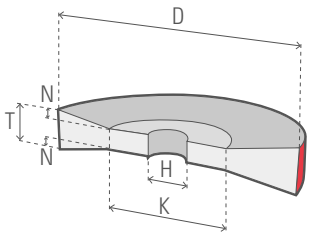

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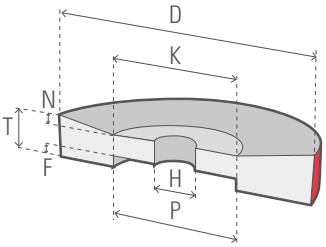

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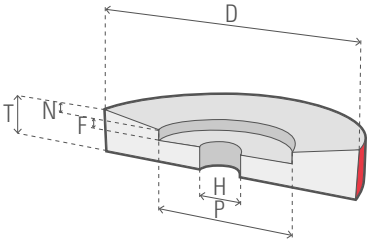

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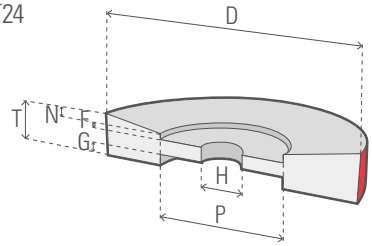

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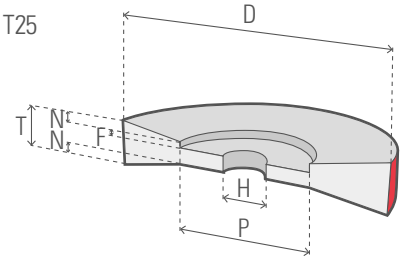

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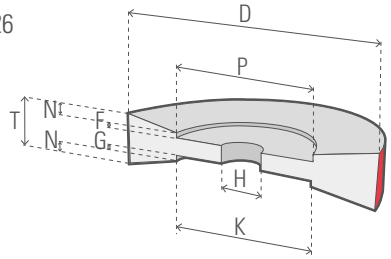

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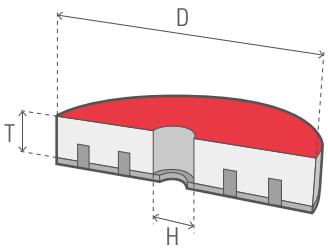

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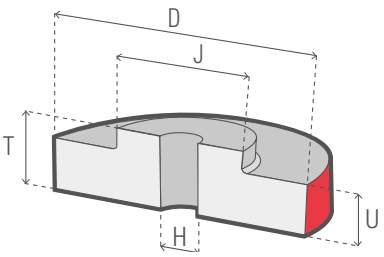

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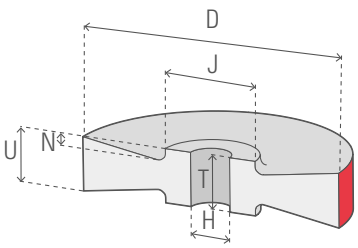

STANDARD PROFILES

ACCORDING TO FEPA STANDARDS

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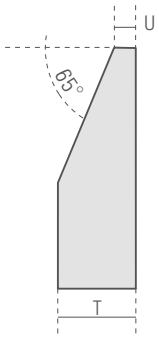

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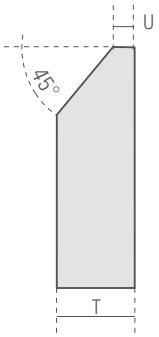

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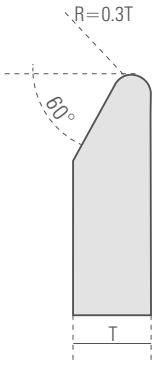

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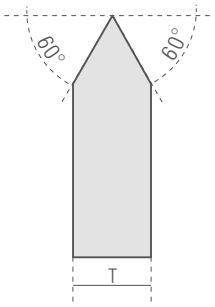

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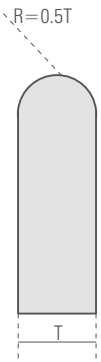

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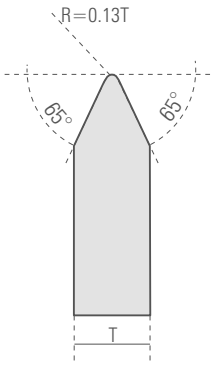

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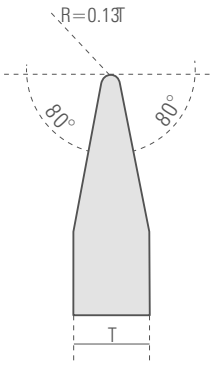

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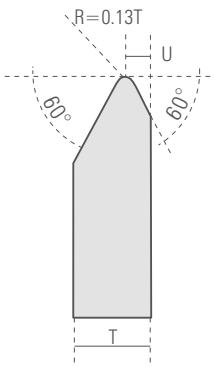

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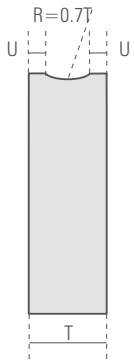

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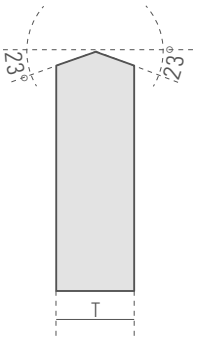

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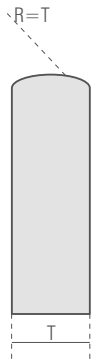

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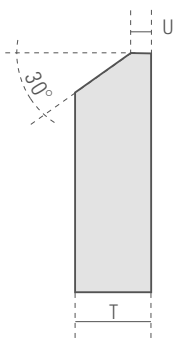

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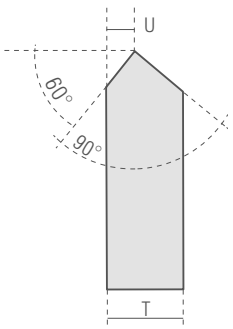

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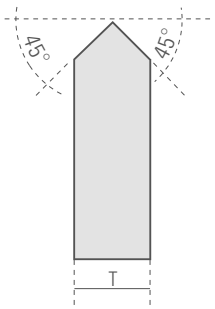
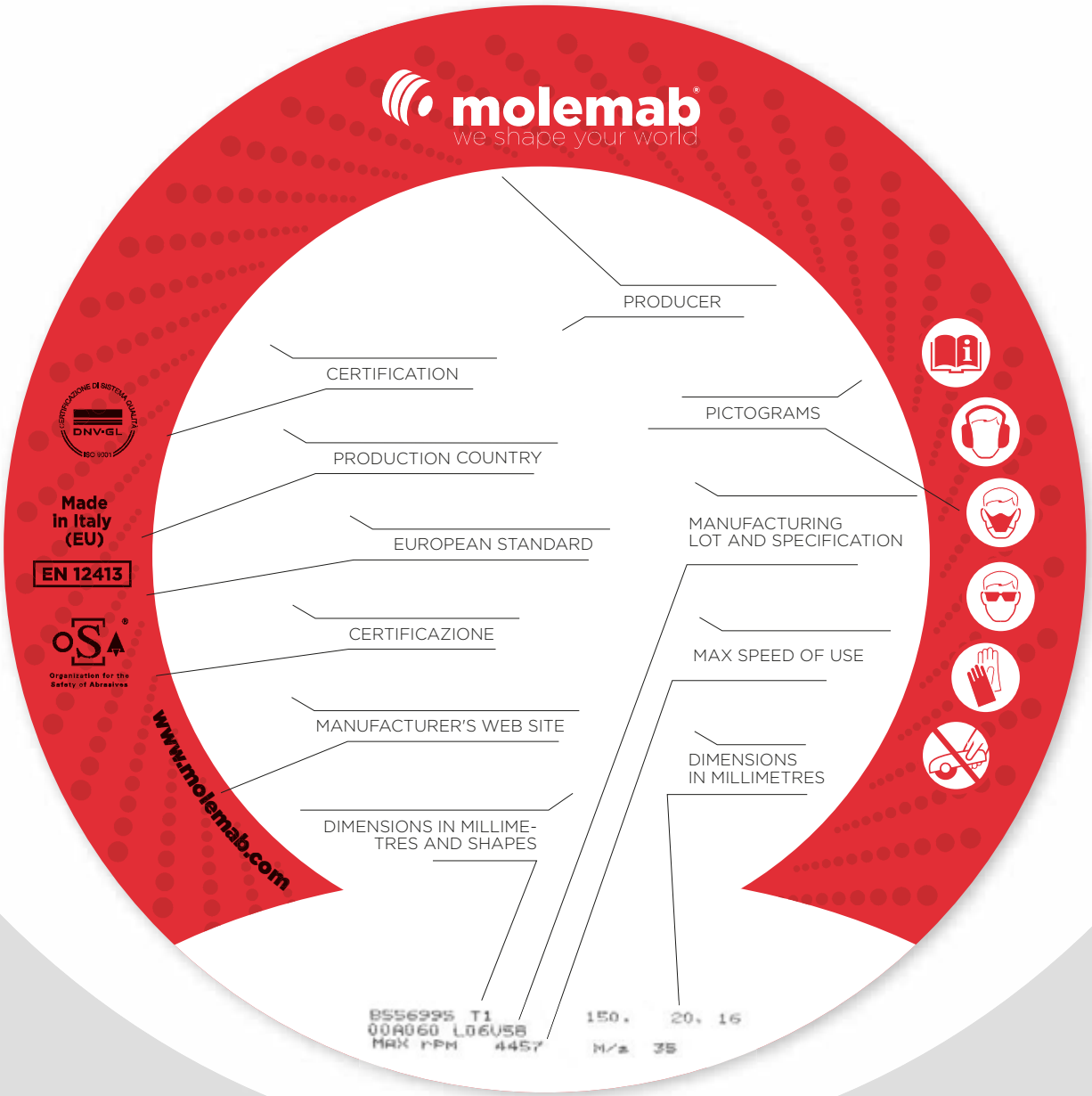


Special profiles available upon request

To modify the standard FEPA profile, add 1 after the letter (e.g..: PRQ1) and then the desired values.

molemab MARKING

IN COMPLIANCE WITH THE SAFETY RULES
THE WHEELS ARE MARKED AS FOLLOWS



Specifications

OOA 060 L 06 V58 PA

Abrasive type
- Conventional aluminium oxide
- Silicon carbide
- Microcrystalline aluminium oxide

Grit size
- Very coarse
- Coarse
- Medium
- Fine
- Very fine

Hardness
- Very soft /soft medium
- Hard
- Very Hard

Structure
- natural porosity closed/open
- Open induced porosity
- High induced porosity
- Very high induced porosity

Bond type
- Vitrified for regular Aluminium Oxide
- Vitrified for silicon carbide
- Vitrified for microcrystal-line Aluminium Oxide
- Resinoid for Aluminium Oxide and Silicon Carbide
- Rubber for regulating wheels

Porosity
- Porous fine
- Porous
- Super-porous
- Porous structured

Abrasive Type	Typology	Grit Size	Wheel hardness	Structure	Bond type	Induced porosity
Classification molemab	Conventional aluminium oxide	Coarse	Very soft	Closed	Vitrified for aluminium oxide	Porous fine
00A	Semi-pure	14	C	3	V11	PF0
09A	White	16	D	4	V20	PF1
11A	Pink	20	E	5	V27	Porous
14A	Mix of special aluminium	24	F	6	V30	P1
15A	Mix Grey and white	Medium	Soft	Medium	V34	P2
31A	Ruby	30	G	7	V85	Super porous
43A	Monocrystalline	36	H	8	V86	P3
45A	Mix of Monocrystalline	46	I	Open	V92	P4
51A	Mix of special aluminium	54	J	10	EG Line	Structured porous
75A	Semi-friable	60	K	11	VX	
91A	Mix of white and pink	Fine	Medium	12	VK	P12
	Silicon carbide	70	L	13	VG	P13
04C	Black	80	M	14	V40	
06C	Mixing	100	N	Very open	Vitrified for silicon carbide	
08C	Green	120	O	15		
	Sintered aluminium oxide	150	Hard	16	V01	
OMA	Mix special Arctic	180	P	17	V11	
SA	Ceramic Abrasive	Very fine	Q	18	V55	
AZ	Ceramic Abrasive NG	220	R		EG Line	
TA	Ceramic Abrasive	240	S		VJ	
		280	T		For Perfecta aluminium oxide and silicon carbide	
		320	Very hard			
		400	U		BGL	
			V		BGT	
			W		BGW	
			X		Resinoid MVC	
			Y		BGT	
			Z			
					Rubber	
					R	

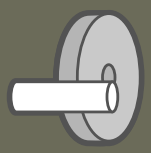
GRINDING WHEEL SPEED TABLE

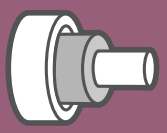
RPM AND M/SEC CORRESPONDING
PERIPHERAL SPEED FOR SOME WHEEL DIAMETERS

	m/sec									
diameter	20	25	32	35	40	45	50	63	80	100
6	64.000	80.000	102.000	112.000	128.000	143.500	160.000	201.000		
8	48.000	60.000	76.500	84.000	95.500	107.500	120.000	150.500	191.000	
10	38.200	48.000	61.200	67.000	76.500	86.000	95.500	120.500	153.000	153.000
13	29.500	36.800	47.100	51.500	58.800	66.200	73.500	92.600	118.000	147.000
16	23.900	29.850	38.200	41.800	47.800	53.750	59.700	75.200	95.500	120.000
20	19.500	23.900	30.600	33.500	38.200	43.000	47.800	60.200	76.500	95.500
25	15.300	19.100	24.500	26.800	30.600	34.500	38.200	48.200	61.200	76.500
32	11.950	14.950	19.100	20.900	23.900	27.000	30.000	37.600	48.000	60.000
40	9.550	11.950	15.300	16.750	19.100	21.500	23.900	30.100	38.200	47.800
50	7.650	9.550	12.550	13.400	15.300	17.200	19.100	24.100	30.600	38.200
63	6.100	7.600	9.750	10.650	12.150	13.650	15.200	19.100	24.300	30.350
80	4.800	6.000	7.650	8.400	9.550	10.750	12.000	15.100	19.100	23.900
100	3.850	4.800	6.150	6.700	7.650	8.600	9.550	12.100	15.300	19.100
125	3.100	3.850	4.900	5.350	6.150	6.900	7.650	9.650	12.250	15.300
150	2.550	3.200	4.100	4.500	5.100	5.750	6.400	8.050	10.200	12.750
180	2.150	2.700	3.400	3.750	4.250	4.780	5.350	6.700	8.500	10.650
200	1.950	2.400	3.100	3.350	3.850	4.300	4.800	6.050	7.650	9.550
230	1.700	2.100	2.700	2.950	3.350	3.750	4.200	5.250	6.650	8.350
250	1.550	1.950	2.450	2.700	3.100	3.450	3.850	4.850	6.150	7.650
300	1.300	1.600	2.050	2.250	2.550	2.870	3.200	4.050	5.100	6.400
350/356	1.100	1.400	1.750	1.950	2.200	2.460	2.750	3.450	4.400	5.500
400/406	960	1.200	1.550	1.700	1.950	2.150	2.400	3.050	3.850	4.800
450/457	850	1.100	1.400	1.500	1.700	1.910	1.700	2.700	3.400	4.250
500/508	765	960	1.250	1.350	1.550	1.720	1.950	2.450	3.100	3.850
600/610	640	800	1.050	1.150	1.300	1.450	1.600	2.050	2.550	3.200
660	580	725	930	1.050	1.200	1.300	1.450	1.850	2.350	2.900
750/762	510	640	820	895	1.050	1.150	1.300	1.650	2.050	2.550
800/813	480	600	765	840	960	1.075	1.200	1.550	1.950	2.400
900/914	425	535	680	750	850	955	1.100	1.350	1.700	2.150
1000/1016	385	480	615	670	765	860	960	1.250	1.550	1.950
1050/1067	365	455	585	640	730	820	910	1.150	1.500	1.850
1100/1120	350	435	560	610	695	785	870	1.100	1.400	1.750
1200/1220	320	400	510	560	640	720	800	1.050	1.300	1.600

STANDARD WORKING PARAMETERS FOR CONVENTIONAL GRINDING WHEELS

Parameters for aluminium oxide and silicon carbide grinding wheels	Operation / Material	Surface grinding	External grinding	Internal grinding
Peripheral speed of the grinding wheel (m/sec)		20 ÷ 35 m/sec	30 ÷ 50 m/sec	25 ÷ 35 m/sec
Workpiece speed m/min $\frac{\text{m/min}}{3{,}14 \times D \text{ in m}}$ = revolutions per min	Roughing or unhardened	10 ÷ 20 m/minute	20 ÷ 50 m/minute	30 ÷ 60 m/minute
	Finishing or hardened	5 ÷ 10 m/minute	10 ÷ 15 m/minute	20 ÷ 40 m/minute
Ratio between peripheral Wheel speed and peripheral Working speed	Roughing	-	40 ÷ 60	60 ÷ 70
	Medium removal	-	60 ÷ 80	70 ÷ 80
	Finishing	-	80 ÷ 120	80 ÷ 90
Transverse movement t=grinding wheel thickness	Roughing or unhardened	1/4 ÷ 1/2 t	1/4 ÷ 1/2 t	1/4 ÷ 1/2 t
	Finishing or hardened	1/10 ÷ 1/5 t	1/10 ÷ 1/5 t	1/10 ÷ 1/5 t
Depth of cut (measured on the radius for external and internal grinding)	Roughing or unhardened	0,01 ÷ 0,05 mm	0,01 ÷ 0,05 mm	0,005 ÷ 0,02 mm
	Finishing or hardened	0,005 ÷ 0,02 mm	0,005 ÷ 0,02 mm	0,005 ÷ 0,01 mm





GRINDING WHEEL SAFETY

molemab products are manufactured in compliance with international safety standards. To guarantee compliance to European Standards, molemab is a member of FEPA, the European Abrasives Federation, and o.S.a. (Abrasive Safety Organization).
The United States apply the 1988 ANSI (American National Standard Institute) Safety Code Standard B7.1 and the 1970 OSHA (Occupational Health and Safety Act) Regulations. Other European and non-European countries have their own regulations regarding safety and the use of grinding wheels. The procedures described below must be carefully followed to minimize the risk of accidents.

1. RECEPTION AND STORAGE

Handling: Grinding wheels must be handled with care, avoiding impacts and falls.

Visual check: Upon reception, the wheels must be checked visually.

Storage: Except for thin grinding wheels, all wheels must be stored vertically on suitable shelves. The storage location must be dry and not subject to significant or sudden temperature changes.

Expiry date: Resin bond wheels have a "Use Before Date" and must be stored for use in chronological order. Vitrified bond wheels can be stored for an indefinite period of time.

2. BEFORE MOUNTING

Visual check: Never use broken or cracked grinding wheels.

Sound test: A sound test must be carried out on new or partially used wheels. Smaller wheels can be held on a finger or mounted on the spindle vertically, heavier wheels must be placed standing vertically on the floor.

Using a small non-metal mallet, hit the wheel on the right and at the left of the vertical centre line. If the sound is ringing and clear, the grinding wheel is free of cracks or breakages. A dull, hollow sound indicates the presence of cracks.

Machine conditions: All machine parts subject to wear must be in good condition and regularly checked.

3. MOUNTING THE WHEEL

Carton labels: Always use carton labels that are slightly larger than the diameter of the flanges, to ensure that the clamping pressure of the flanges on the wheel is uniform.

Bore: The grinding wheel must fit the spindle correctly. Never force the wheel onto the spindle and do not use grinding wheels with a bore that is too large for the spindle.

Flanges: Carefully follow the instructions regarding type of flange and installation of the wheel.

Speed: Confirm the maximum working speed shown on the grinding wheel and check it against the speed of the machine. Never exceed the maximum speed specified by the manufacturer

Safety cover: Check that all safety covers and guards are in good conditions to ensure containment of airborne fragments in case the wheel should break.

4. OPERATION

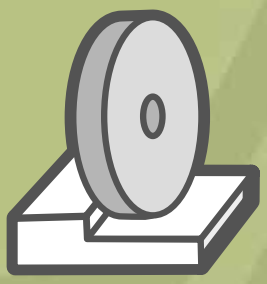
Balancing: All wheels are systematically balanced by molemab.
The first on-machine balancing must be carried out after mounting the grinding wheel with the arrow located at the bottom (unless otherwise specified).
New generation grinding machines are often equipped with an automatic balancing system.
However, it necessary to check again the wheel balancing when it is disassembled and reassembled after working, and when the flanges are replaced.

Starting the wheel: Before starting to remove material, the grinding wheel must be run at maximum speed for at least one minute.
During this operation, all personnel must remain in safe areas.

Dressing and sharpening the wheel: Dressing frequency depends on the type of operation.

All the operations described above must be carried out by qualified personnel.

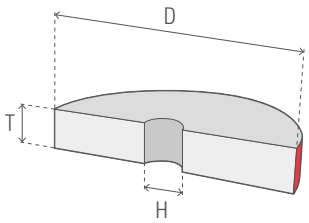
Surface grinding



Horizontal spindle surface grinding wheels

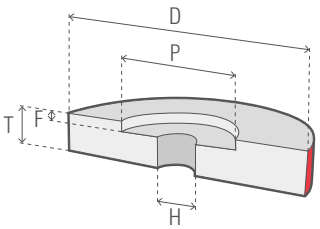
SHAPES AND DIMENSIONS			
Shape	D	T	H
T1	150	20	31,75 - 32
	180	6 - 8 - 10 - 13 - 16 - 20	31,75 - 32
	200	6 - 8 - 10 - 13 - 16 - 20	31,75 - 32
	225	20	50,8
	250	25	76,2
	300	25 - 32 - 40	76,2 - 127
	350	32 - 40 - 50	127
	400	40 - 50 - 60 - 76	127
	450	50 - 63 - 76	203,2
	508	50 - 63 - 80	203,2

SHAPE T1



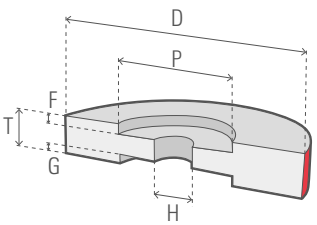
SHAPES AND DIMENSIONS					
Shape	D	T	H	P	F
T5	180	20	31,75	100	6
	200	25	31,75	110	10
	225	25	50,8	110	10
	250	32	76,2	125	12
	300	40	127	190	13
	300	50	127	190	13
	350	50	127	210	10
	400	50	127	210	10

SHAPE T5



SHAPES AND DIMENSIONS						
Shape	D	T	H	P	F	G
T7	300	50	76,2	155	10	10
	300	50	127	155	10	10
	350	50	127	210	10	10
	400	60	127	210	10	10
	400	76	127	210	20	10
	450	80	203,2	290	13	13
	508	100	203,2	300	15	15
	600	100	304,8	390	15	15

SHAPE T7



Other sizes available upon request

Horizontal spindle surface grinding wheels

MILD, ANNEALED QUENCHED AND TEMPERED STEEL < 35 HRC

T1-T5	thickness 25 to 40	T1-T5-T7	thickness 50 to 90	T1-T5-T7	thickness 100 to 150	application
300	11A 036 I 10 V86					SURFACE
	11A 046 I 10 V86					SURFACE
350	11A 036 I 10 V86	350	11A 036 I 10 V86			SURFACE
	11A 046 I 10 V86		11A 046 I 10 V86			SURFACE
400	11A 036 I 10 V86	400	11A 036 I 10 V86	400	11A 036 H 10 V86	SURFACE
	11A 046 I 10 V86		11A 46 FG12 VX P4		11A 46 F12 VX P4	SURFACE
	11A 046 G12 VXP4		09A 046 FG12 V34 P3		09A 046 FG12 V34 P3	SURFACE
			09A 054 FG12 VG P13		09A 054 FG12 VG P13	SURFACE
		450	11A 036 I 10 V86			SURFACE
			11A 46 FG12 VX P4			SURFACE
			09A 046 FG12 V34 P3	450	09A 046 FG12 V34 P3	SURFACE
			09A 054 FG12 VG P13		09A 054 FG12 VG P13	SURFACE
		500	11A 036 I 10 V86			SURFACE
			11A 46 FG12 VX P4			SURFACE
			09A 046 FG12 V34 P3	500	09A 046 FG12 V34 P3	SURFACE
			09A 054 FG12 VG P13		09A 054 FG12 VG P13	SURFACE
				610	11A 036 I 10 V86	SURFACE
					09A 046 FG12 V34 P3	SURFACE
					09A 054 FG12 VG P13	SURFACE

QUENCHED AND TEMPERED (HIGH RESISTANCE) AND HARDENED STEEL < 54 HRC

T1-T5	thickness 25 to 40	T1-T5-T7	thickness 50 to 90	T1-T5-T7	thickness 100 to 150	application
300	09A 046 FG12 V34 P3					SURFACE
	09A 054 FG12 VG P13					SURFACE
350	09A 046 FG12 V34 P3	350	09A 046 FG12 V34 P3			SURFACE
	09A 054 FG12 VG P13		09A 054 FG12 VG P13			SURFACE
	45A 54/60 E14 VK P1		45A 54/60 DE14 VK P1			SURFACE
	0MA 54/60 FG11 VG5 P13		0MA 54/60 F11 VG5 P13			SURFACE
400	09A 046 FG12 V34 P3	400	09A 046 FG12 V34 P3	400	09A 046 FG12 V34 P3	SURFACE
	09A 054 FG12 VG P13		09A 054 FG12 VG P13		09A 054 F12 VG P13	SURFACE
	45A 54/60 E14 VK P1		45A 54/60 DE14 VK P1		45A 54/60 DE14 VK P1	SURFACE
	0MA 54/60 FG11 VG5 P13		0MA 54/60 F11 VG5 P13		0MA 54/60 F11 VG5 P13	SURFACE
		450	09A 046 FG12 V34 P3	450	09A 046 FG12 V34 P3	SURFACE
			09A 054 FG12 VG P13		09A 054 F12 VG P13	SURFACE
			45A 54/60 DE14 VK P1		45A 54/60 DE14 VK P1	SURFACE
			0MA 54/60 F11 VG5 P13		0MA 54/60 EF11 VG5 P13	SURFACE

The coloured dot shows the actual colour of the wheel = (yellow wheel)

Horizontal spindle surface grinding wheels

QUENCHED AND TEMPERED (HIGH RESISTANCE) AND HARDENED STEEL < 54 HRC

T1-T5	thickness 25 to 40	T1-T5-T7	thickness 50 to 90	T1-T5-T7	thickness 100 to 150	application
		500	09A 046 FG12 V34 P3	500	09A 046 FG12 V34 P3	SURFACE
			09A 054 FG12 VG P13		09A 054 F12 VG P13	SURFACE
			45A 54/60 DE14 VK P1		45A 54/60 DE14 VK P1	SURFACE
			0MA 54/60 F11 VG5 P13		0MA 54/60 EF11 VG5 P13	SURFACE
		610		610	09A 046 FG12 V34 P3	SURFACE
					09A 054 F12 VG P13	SURFACE
			45A 54/60 DE14 VK P1		45A 54/60 DE14 VK P1	SURFACE
					0MA 54/60 EF11 VG5 P13	SURFACE

HARDENED AND CEMENTED STEEL < 58 HRC

T1-T5	thickness 25 to 40	T1-T5-T7	thickness 50 to 90	T1-T5-T7	thickness 100 to 150	application
400	0MA 54/60 F11 VG5 P13	400	0MA 54/60 F11 VG5 P13	400	0MA 54/60 EF11 VG5 P13	SURFACE
	43A 060 FG12 VG4 P13		43A 060 FG12 VG4 P13		43A 060 F12 VG4 P13	SURFACE
		450	0MA 54/60 F11 VG5 P13	450	0MA 54/60 EF11 VG5 P13	SURFACE
			43A 060 FG12 VG4 P13		43A 060 F12 VG4 P13	SURFACE
		500	0MA 54/60 F11 VG5 P13	500	0MA 54/60 EF11 VG5 P13	SURFACE
			43A 060 FG12 VG4 P13		43A 060 F12 VG4 P13	SURFACE
				610	0MA 54/60 EF11 VG5 P13	SURFACE
					43A 060 F12 VG4 P13	SURFACE

HARDENED AND CEMENTED STEEL < 62 HRC

T1-T5	thickness 25 to 40	T1-T5-T7	thickness 50 to 90	T1-T5-T7	thickness 100 to 150	application
400	1TA 046 FG12 VG4 P3	400	1TA 046 F12 VG4 P3	400	1TA 046 F12 VG4 P3	SURFACE
	2SA 054 F12 VG4 P13		2SA 054 EF12 VG4 P13		2SA 054 EF12 VG4 P13	SURFACE
		450	1TA 046 F12 VG4 P3	450	1TA 046 F12 VG4 P3	SURFACE
			2SA 054 EF12 VG4 P13		2SA 054 EF12 VG4 P13	SURFACE
		500	1TA 046 F12 VG4 P3	500	1TA 046 F12 VG4 P3	SURFACE
			3SA 054 EF12 VG4 P13		3SA 054 EF12 VG4 P13	SURFACE
				610	1TA 046 F12 VG4 P3	SURFACE
					3SA 054 EF12 VG4 P13	SURFACE

Horizontal spindle surface grinding wheels

FERRITIC STAINLESS STEEL, SERIES 400 AND INCONEL						
T1-T5	thickness 25 to 40	T1-T5-T7	thickness 50 to 90	T1-T5-T7	thickness 100 to 150	application
300	09A 060 FG12 VG P13					SURFACE
350	09A 060 FG12 VG P13					SURFACE
400	09A 060 FG12 VG P13	400	09A 060 FG12 VG P13	400		SURFACE
	9A 060 EF16 VK2 P13					CREEP-FEED
	09A 070/2 H10 V86 P1		09A 070/2 H10 V86 P1			CREEP-FEED
	09A 100 I14 VG PF1		09A 100 I14 VG PF1			CREEP-FEED
		450	09A 060 FG12 VG P13	450	09A 060 F12 VG P13	SURFACE
		500	09A 060 FG12 VG P13	500	09A 060 F12 VG P13	SURFACE

HARDENED STAINLESS STEEL						
T1-T5	thickness 30 to 50	T1-T5-T7	thickness 60 to 80	T1-T5-T7	thickness 100 to 150	application
350	08C 046 G12 VJ P3					SURFACE
400	08C 046 G12 VJ P3	400	08C 046 G12 VJ P3			SURFACE
450	08C 046 G12 VJ P3	450	08C 046 G12 VJ P3			SURFACE
500	08C 046 G12 VJ P3	500	08C 046 G12 VJ P3	500	08C 046 F12 VJ P3	SURFACE

AUSTENITIC STAINLESS STEEL SERIES 300 AND NIMONIC						
T1-T5	thickness 30 to 50	T1-T5-T7	thickness 60 to 80	T1-T5-T7	thickness 100 to 150	application
350	45A 060 E14 VK P13					SURFACE
400	45A 060 E14 VK P13	400	45A 060 DE14 VK P13			SURFACE
450	45A 060 E14 VK P13	450	45A 060 DE14 VK P13			SURFACE
500	45A 060 E14 VK P13	500	45A 060 DE14 VK P13	500	45A 060 DE14 VK P13	SURFACE
				610	45A 060 DE14 VK P13	SURFACE

Horizontal spindle surface grinding wheels

FERRITIC, NODULAR PEARLITIC AND HARDENED CAST IRON

T1-T5	thickness 30 to 50	T1-T5-T7	thickness 60 to 80	T1-T5-T7	thickness 100 to 150	application
400	09A 046 FG12 V34 P3	400	09A 046 FG12 V34 P3	400	09A 046 FG12 V34 P3	SURFACE
	09A 054 FG12 VG P4		09A 054 FG12 VG P4		09A 054 F12 VG P4	SURFACE
			91A 70/1 G12 VG P2		91A 70/1 G12 VG P2	SURFACE
		500	09A 046 FG12 V34 P3	500	09A 046 FG12 V34 P3	SURFACE
			09A 054 FG12 VG P4		09A 054 F12 VG P4	SURFACE
			91A 70/1 G12 VG P2		91A 70/1 G12 VG P2	SURFACE
		610	91A 70/1 G12 VG P2	610	91A 70/1 G12 VG P2	SURFACE

GREY CAST IRON

T1-T5	thickness 30 to 50	T1-T5-T7	thickness 60 to 80	T1-T5-T7	thickness 100 to 150	application
400	08C 060 H10 V11 P1	400	08C 060 H10 V11 P1	400	08C 060 G10 V11 P1	SURFACE
	08C 060 G10 VJ P3		08C 060 G10 VJ P3		08C 060 FG10 VJ P3	SURFACE
		500	08C 060 H10 V11 P1	500	08C 060 G10 V11 P1	SURFACE
			08C 060 G10 VJ P3		08C 060 FG10 VJ P3	SURFACE

NON FERROUS METALS, ALUMINIUM, BRONZE, COPPER AND NON FERROUS ALLOYS

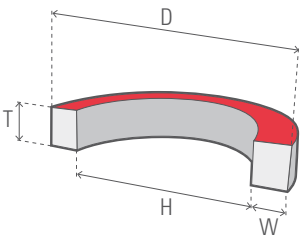
T1-T5	thickness 30 to 50	T1-T5-T7	thickness 60 to 80	T1-T5-T7	thickness 100 to 150	application
300	08C 060 H10 V11 P1					SURFACE
	08C 060 G10 VJ P3					SURFACE
350	08C 060 H10 V11 P					SURFACE
	08C 060 G10 VJ P3					SURFACE
400	08C 060 H10 V11 P1	400	08C 060 H10 V11 P1			SURFACE
	08C 060 G10 VJ P3		08C 060 G10 VJ P3			SURFACE
		450	08C 060 H10 V11 P1	450	08C 060 G10 V11 P1	SURFACE
			08C 060 G10 VJ P3		08C 060 FG10 VJ P3	SURFACE

EXAMPLE OF ORDER

SHAPE	DIMENSIONS (mm)	NOTE	SPEED	SPECIFICATION	
T5	500x80x203,2	P=280 F=15	35 m/sec	09A 046 FG12 V34 P3	The coloured dot shows the actual colour of the wheel

Ring wheels and cylindrical cup for surface grinding

SHAPE T2



SHAPES AND DIMENSIONS			
Shape	D	T	H
T2	175	80	135
	200	100	160
	250	100	200

MILD, QUENCHED AND TEMPERED AND HARDENED STEEL ≤ 52 HRC				
T2	T= 80	T2	T= 100	application
175	09A 036 G08 V86			SURFACE
	09A 046 G08 V86			SURFACE
200			09A 036 G08 V86	SURFACE
			09A 046 G08 V86	SURFACE
250			09A 036 G08 V86	SURFACE
			09A 046 G08 V86	SURFACE

HARDENED AND CEMENTED STEEL ≥ 58 HRC				
T2	T= 80	T2	T= 100	application
175	09A 036 F12 V34P3			SURFACE
	09A 046 F12 V34P3			SURFACE
200			09A 036 F12 V34P3	SURFACE
			09A 046 F12 V34P3	SURFACE
250			09A 036 F12 V34P3	SURFACE
			09A 046 F12 V34P3	SURFACE

SHAPE T6

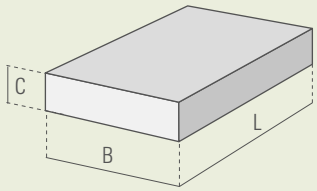
SHAPES AND DIMENSIONS					
Shape	D	T	H	W	E
T6	178	78	78	19	19
	200	80	78	22	22

MILD, QUENCHED AND TEMPERED AND HARDENED STEEL ≤ 58 HRC				
T6	T= 78	T6	T= 80	application
178	09A 30 H08 V86			SURFACE
	09A 36 H08 V86			SURFACE
200			09A 30 H08 V20	SURFACE
			09A 36 H08 V20	SURFACE

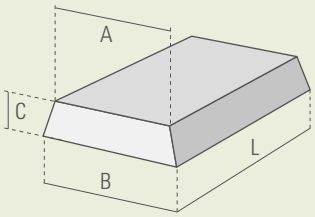
HARDENED AND CEMENTED STEEL ≥ 58 HRC				
T6	T= 78	T6	T= 80	application
178	09A 36 G10 V34P			SURFACE
200			09A 36 G10 V34P	SURFACE

Abrasive segments

SHAPE 1



SHAPE 2



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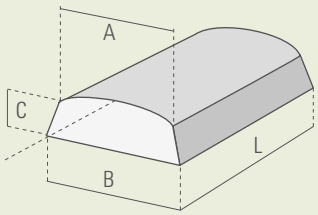
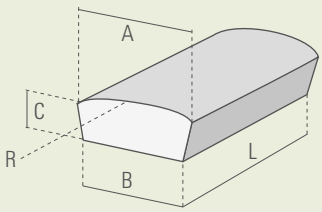
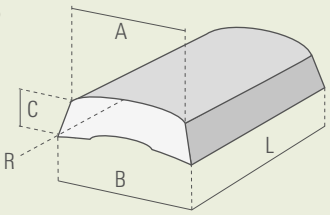


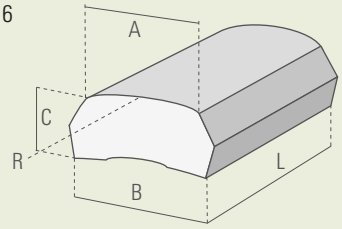
SHAPE 4



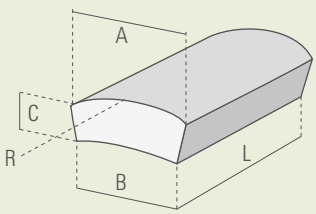
SHAPE 5



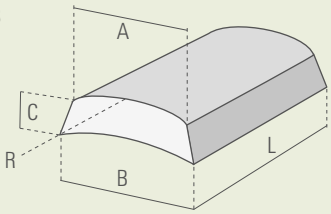
SHAPE 6



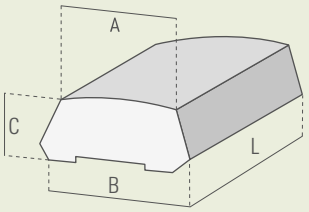
SHAPE 7



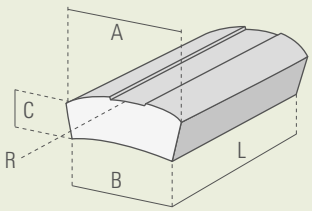
SHAPE 8



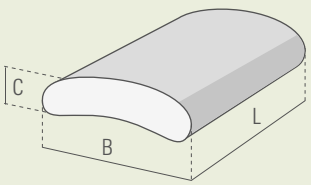
SHAPE 9



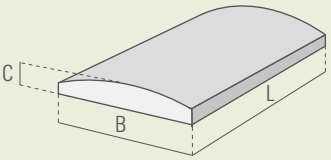
SHAPE 10



SHAPE 11

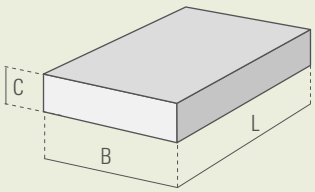


SHAPE 12



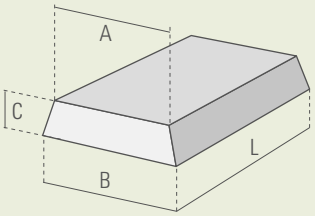
HOW TO IDENTIFY SIZES

SHAPE 1D



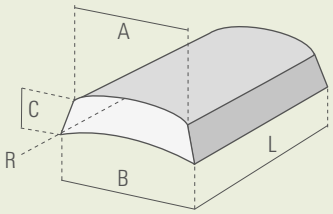
B x C x L

SHAPE 2D



B/A x C x L

SHAPE 3D



B/A x C x L

Surface grinding segments

The following tables list the most common abrasive segment shapes and sizes.
Other specifications and shapes are available upon request

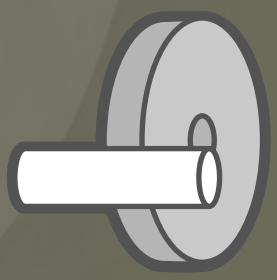
SPECIFICATIONS					
MATERIAL	TYPE	CONTINUOUS CUTTING		DISCONTINUOUS CUTTING	
		SPECIFICATION		SPECIFICATION	
Steel	Mild steel Low/medium hardness steel	09A036H08V86		11A024I08V86	
				11A030H09V86	
	Hardened steel Alloy steel Hardness ≤ 58 HRC	09A036G10V20P		11A036G08V86	
		09A030G10V92			
	High alloy steels Tools steel HSS Hardness ≥ 58 HRC	09A036F12V34P		3SA046F12V114P 3AZ046F10VG4P13	
Stainless steel	Unhardened stainless steel Hardened and alloyed steel	09A024H09V86		11A024I08V86	
		09A36G09V86		11A036G09V86	
Cast iron	Steel cast iron, Grey cast iron	09A024H09V86		11A024I08V86	
	Engine head cast iron	06C036I07V11			
	Annealed and ductile iron				
Hard metal	Tungstene carbide	08C060G08V01			
Non ferrous metals	Aluminium, bronze, copper, non-ferrous alloys	08C046G05V01			
		08C046H05V11			

EXAMPLE OF ORDER

SHAPE	DIMENSIONS (mm)	SPECIFICATION	
8	50/45 x 16 x 90	09A 36 G10 V34P	

The coloured dot shows the actual colour of the wheel

External grinding



Cylindrical grinding wheels

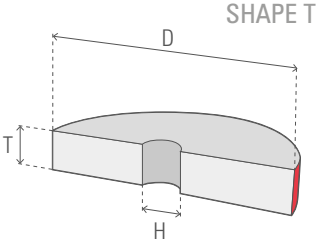
Cylindrical grinding wheels are available with diameters ranging from 300 to 1200 mm and bores from 76,2 to 508 mm

SHAPES AND DIMENSIONS		
Shape	D	H
T1	300	76,2 - 127
	350	127
	400	127 - 203,2
	450	127 - 203,2
	508	203,2 - 304,8
	610	203,2 - 304,8
	760	304,8
	800	304,8
	915	304,8 - 508
	1060	304,8
	1200	

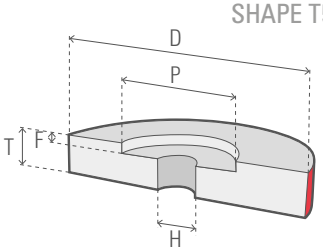
SHAPES AND DIMENSIONS					
Shape	D	H	P/K	F	N
T1	300	127	210	RECESS AND TAPER SIZE UPON REQUEST	
	350	127	210		
	400	203,2	290		
	450	203,2	290		
	508	304,8	390		
	610	203,2	290		
	760	304,8	390		
	800	304,8	410		
	915	304,8	410		
	1060				
	1200				

SHAPES AND DIMENSIONS						
Shape	D	H	P/K	F	G	N
T1	300	127	210	RECESS AND TAPER SIZE UPON REQUEST		
	350	127	210			
	400	203,2	290			
	450	203,2	290			
	508	304,8	390			
	610	203,2	290			
	760	304,8	390			
	800	304,8	410			
	915	304,8	410			
	1060					
	1200					

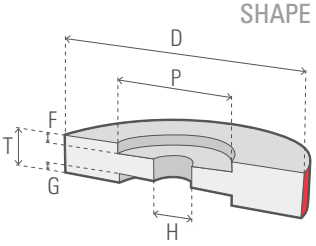
SHAPE T1



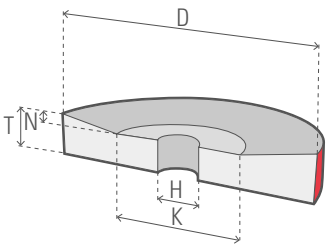
SHAPE T5



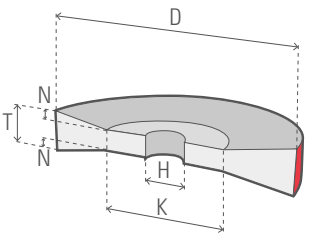
SHAPE T7



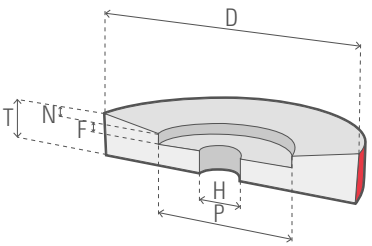
SHAPE T20



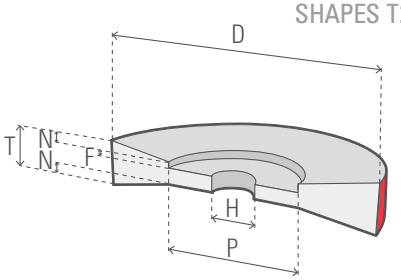
SHAPE T21



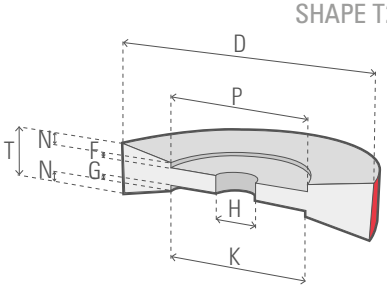
SHAPE T23



SHAPES T25



SHAPE T26



MILD, ANNEALED AND QUENCHED AND TEMPERED STEEL < 35 HRC						
T1-T5	thickness 25 to 45	T1-T5	thickness 50 to 80	T1-T5-T7	thickness from 85 to 12	application
350	15A 060 K08 V92					THROUGH-FEED
	14A 060 K08 V85					THROUGH-FEED
400	15A 060 K08 V92	400	15A 060 K08 V92			THROUGH-FEED
	14A 060 K08 V85		14A 060 K08 V85			THROUGH-FEED
	11A 060 K08 VK PF		11A 060 K08 VK PF			THROUGH-FEED
	11A 080 K08 VK PF		11A 080 K08 VK PF			THROUGH-FEED
450	15A 060 K08 V92	450	15A 060 K08 V92			THROUGH-FEED
	14A 060 K08 V85		14A 060 K08 V85			THROUGH-FEED
	11A 060 K08 VK PF		11A 060 K08 VK PF			THROUGH-FEED
	11A 080 K08 VK PF		11A 080 K08 VK PF			THROUGH-FEED
500	15A 060 K08 V92	500	15A 060 K08 V92	500	15A 060 J08 V92	THROUGH-FEED
	14A 060 K08 V85		14A 060 K08 V85		14A 060 J08 V85	THROUGH-FEED
	11A 060 K08 VK PF		11A 060 K08 VK PF		11A 060 JK08 VK PF	THROUGH-FEED
	11A 080 K08 VK PF		11A 080 K08 VK PF		11A 080 JK08 VK PF	THROUGH-FEED
610	14A 060 K08 V85	610	14A 060 K08 V85	610	14A 060 J08 V85	THROUGH-FEED
	11A 060 K08 VK PF		11A 060 K08 VK PF		11A 060 JK08 VK PF	THROUGH-FEED
	11A 080 K08 VK PF		11A 080 K08 VK PF		11A 080 JK08 VK PF	THROUGH-FEED

QUENCHED AND TEMPERED (HIGH RESISTANCE) AND HARDENED STEEL < 56 HRC						
T1-T5	thickness 25 to 45	T1-T5	thickness 50 to 80	T1-T5-T7	thickness 50 to 80	application
350	09A 060 K07 V86					THROUGH-FEED
	09A 070 JK8 VK PF					THROUGH-FEED
400	09A 060 K07 V86	400	09A 060 J07 V86			THROUGH-FEED
	09A 070 JK8 VK PF		09A 070 JK8 VK PF			THROUGH-FEED
	09A 080 JK8 VK PF		09A 080 JK8 VK PF			THROUGH-FEED
	09A 100 I14 VG PF		09A 100 HI14 VG PF			THROUGH-FEED
	09A 120 I14 VG PF		09A 120 HI14 VG PF			THROUGH-FEED
	09A 180 I14 VG PF		09A 180 I14 VG PF			THROUGH-FEED
	45A 070 JK8 VK4 PF		45A 070 J08 VK4 PF			THROUGH-FEED
	53A 100 JK8 VK4		53A 100 J08 VK4			THROUGH-FEED
450	09A 060 K07 V86	450	09A 060 J07 V86			THROUGH-FEED
	09A 070 JK8 VKPF		09A 070 JK8 VK PF			THROUGH-FEED
	09A 080 JK8 VKPF		09A 080 JK8 VK PF			THROUGH-FEED
	09A 100 I14 VG PF		09A 100 HI14 VG PF			THROUGH-FEED
	09A 120 I14 VG PF		09A 120 HI14 VG PF			THROUGH-FEED
	09A 180 I14 VG PF		09A 180 I14 VG PF			THROUGH-FEED
	45A 070 JK8 VK4 PF		45A 070 J08 VK4 PF			THROUGH-FEED
	53A 100 JK8 VK4		53A 100 J08 VK4			THROUGH-FEED

The coloured dot shows the actual colour of the wheel = (pink wheel)

QUENCHED AND TEMPERED (HIGH RESISTANCE) AND HARDENED STEEL < 56 HRC						
T1-T5	thickness 25 to 45	T1-T5	thickness 50 to 80	T1-T5-T7	thickness 85 to 120	application
500	09A 060 K07 V86	500	09A 060 J07 V86	500	09A 060 J07 V86	THROUGH-FEED
	09A 070 JK8 VK PF		09A 070 JK8 VK PF		09A 070 J08 VK PF	THROUGH-FEED
	09A 080 JK8 VK PF		09A 080 JK8 VK PF		09A 080 J08 VK PF	THROUGH-FEED
	09A 100 I14 VG PF		09A 100 HI14 VG PF			THROUGH-FEED
	09A 120 I14 VG PF		09A 120 HI14 VG PF			THROUGH-FEED
	09A 180 I14 VG PF		09A 180 I14 VG PF			THROUGH-FEED
	45A 070 JK8 VK4 PF		45A 070 JK8 VK4 PF		45A 070 J08 VK4 PF	THROUGH-FEED
	53A 100 JK8 VK4		53A 100 JK8 VK4		53A 100 J08 VK4	THROUGH-FEED
		610	09A 060 J07 V86	610	09A 060 J07 V86	THROUGH-FEED
			09A 070 JK8 VK PF		09A 070 J08 VK PF	THROUGH-FEED
			09A 080 JK8 VK PF		09A 080 J08 VK PF	THROUGH-FEED
			45A 070 J08 VK4 PF		45A 070 J08 VK4 PF	THROUGH-FEED
			53A 100 J08 VK4		53A 100 J08 VK4	THROUGH-FEED

HARDENED AND CEMENTED STEEL < 60 HRC						
T1-T5	thickness 25 to 45	T1-T5	thickness 50 to 80	T1-T5-T7	thickness 85 to 120	application
400	45A 070 JK8 VK4 PF	400	45A 070 JK8 VK4 PF			THROUGH-FEED
	43A 080 J08 VK4 PF		43A 080 J08 VK4 PF			THROUGH-FEED
	43A 100 J09 VK PF		43A 100 J09 VK PF			THROUGH-FEED
	43A 120 J09 VK PF		43A 120 J09 VK PF			THROUGH-FEED
500	45A 070 JK8 VK4 PF	500	45A 070 JK8 VK4 PF	500	45A 070 IJ8 VK4 PF	THROUGH-FEED
	43A 080 J08 VK4 PF		43A 080 J08 VK4 PF		43A 080 IJ8 VK4 PF	THROUGH-FEED
	43A 100 J09 VK PF		43A 100 J09 VK PF		43A 100 IJ9 VK PF	THROUGH-FEED
	43A 120 J09 VK PF		43A 120 J09 VK PF		43A 120 IJ9 VK PF	THROUGH-FEED
		610	45A 070 JK8 VK4 PF	610	45A 070 IJ8 VK4 PF	THROUGH-FEED
			43A 080 J08 VK4 PF		43A 080 IJ8 VK4 PF	THROUGH-FEED
			43A 100 J09 VK PF		43A 100 IJ9 VK PF	THROUGH-FEED
			53A 100 J08 VK4		53A 100 J08 VK4	THROUGH-FEED

HARDENED AND CEMENTED STEEL < 68 HRC						
T1-T5	hickness 25 to 45	T1-T5	thickness 50 to 80	T1-T5-T7	thickness 85 to 120	application
400	1SA 070/1 IJ8 VK4 PF	400	1SA 070/1 IJ8 VK4 PF			THROUGH-FEED
	1SA 150/1 K09 VK4 PF		1SA 150/1 J09 VK4 PF			THROUGH-FEED
	3SA 70/1 J08 VK4 PF		3SA 70/1 J08 VK4 PF			THROUGH-FEED
	3SA 100 K09 VK4 PF		3SA 100 IJ9 VK4 PF			THROUGH-FEED
450	1SA 070/1 IJ8 VK4 PF	450	1SA 070/1 IJ8 VK4 PF			THROUGH-FEED
	1SA 150/1 K09 VK4 PF		1SA 150/1 J09 VK4 PF			THROUGH-FEED
	3SA 70/1 J08 VK4 PF		3SA 70/1 J08 VK4 PF			THROUGH-FEED
	3SA 100 K09 VK4 PF		3SA 100 IJ9 VK4 PF			THROUGH-FEED
500	1SA 070/1 IJ8 VK4 PF	500	1SA 070/1 IJ8 VK4 PF	500	1SA 070/1 I08 VK4 PF	THROUGH-FEED
	1SA 150/1 K09 VK4 PF		1SA 150/1 J09 VK4 PF		1SA 150/1 J09 VK4 PF	THROUGH-FEED
	3SA 70/1 J08 VK4 PF		3SA 70/1 J08 VK4 PF		3SA 70/1 IJ08 VK4 PF	THROUGH-FEED
		610	1SA 070/1 IJ8 VK4 PF	610	1SA 070/1 IJ8 VK4 PF	THROUGH-FEED
			1SA 150/1 J09 VK4 PF		1SA 150/1 J09 VK4 PF	THROUGH-FEED
			3SA 70/1 J08 VK4 PF		3SA 70/1 IJ08 VK4 PF	THROUGH-FEED
			3SA 100 J09 VK4 PF		3SA 100 J09 VK4 PF	THROUGH-FEED

CHROME PLAITED STEEL						
T1-T5	hickness 25 to 45	T1-T5	thickness 50 to 80	T1-T5-T7	thickness 85 to 120	application
350	09A 080 J08 V86	350	09A 080 I08 V86			THROUGH-FEED
	09A 080 HI8 VK2 PF		09A 080 HI8 VK2 PF			THROUGH-FEED
400	09A 080 J08 V86	400	09A 080 I08 V86			THROUGH-FEED
	09A 080 HI8 VK2 PF		09A 080 HI8 VK2 PF			THROUGH-FEED
450	09A 080 J08 V86	450	09A 080 I08 V86	450	09A 080 H08 V86	THROUGH-FEED
	09A 080 HI8 VK2 PF		09A 080 HI8 VK2 PF		09A 080 H08 VK2 PF	THROUGH-FEED
500	09A 080 J08 V86	500	09A 080 I08 V86	500	09A 080 H08 V86	THROUGH-FEED
	09A 080 HI8 VK2 PF		09A 080 HI8 VK2 PF		09A 080 H08 VK2 PF	THROUGH-FEED
		610	09A 080 I08 V86	610	09A 080 H08 V86	THROUGH-FEED
			09A 080 HI8 VK2 PF		09A 080 H08 VK2 PF	THROUGH-FEED

FERRITIC STAINLESS STEEL, SERIES 400 AND INCONEL

T1-T5	thickness 25 to 45	T1-T5	thickness 50 to 80	T1-T5-T7	thickness 85 to 120	application
350	09A 060 J08 V86	350	09A 060 J08 V86			THROUGH-FEED
	09A 070 JK8 VK PF		09A 070 JK8 VK PF			THROUGH-FEED
400	09A 060 J08 V86	400	09A 060 J08 V86			THROUGH-FEED
	09A 070 JK8 VK PF		09A 070 JK8 VK PF			THROUGH-FEED
450	09A 060 J08 V86	450	09A 060 J08 V86	450	09A 060 I08 V86	THROUGH-FEED
	09A 070 JK8 VK PF		09A 070 JK8 VK PF		09A 070 J08 VK PF	THROUGH-FEED
500	09A 060 J08 V86	500	09A 060 J08 V86	500	09A 060 I08 V86	THROUGH-FEED
	09A 070 JK8 VK PF		09A 070 JK8 VK PF		09A 070 J08 VK PF	THROUGH-FEED
		610	09A 060 J08 V86	610	09A 060 I08 V86	THROUGH-FEED
			09A 070 JK8 VK PF		09A 070 J08 VK PF	THROUGH-FEED

HARDENED STAINLESS STEEL

T1-T5	thickness 25 to 45	T1-T5	thickness 50 to 80	T1-T5-T7	thickness 100 to 150	application
350	08C 070 K08 V11					THROUGH-FEED
400	08C 070 K08 V11	400	08C 070 J08 V11			THROUGH-FEED
450	08C 070 K08 V11	450	08C 070 J08 V11			THROUGH-FEED
500	08C 070 K08 V11	500	08C 070 J08 V11	500	08C 070 I08 V11	THROUGH-FEED
					08C 070 I08 V11	THROUGH-FEED

AUSTENITIC STAINLESS STEEL SERIES 300 AND NIMONIC

T1-T5	thickness 25 to 45	T1-T5	thickness 50 to 80	T1-T5-T7	thickness 85 to 120	application
350	43A 060 K08 V86					THROUGH-FEED
	45A 070 JK8 VK PF					THROUGH-FEED
400	43A 060 K08 V86	400	43A 060 J08 V86			THROUGH-FEED
	45A 070 JK8 VK PF		45A 070 J08 VK PF			THROUGH-FEED
450	43A 060 K08 V86	450	43A 060 J08 V86	450	43A 060 J08 V86	THROUGH-FEED
	45A 070 JK8 VK PF		45A 070 J08 VK PF		45A 070 J08 VK PF	THROUGH-FEED
500		500	43A 060 J08 V86	500	43A 060 J08 V86	THROUGH-FEED
			45A 070 J08 VK PF		45A 070 J08 VK PF	THROUGH-FEED
				610	43A 060 J08 V86	THROUGH-FEED
					45A 070 J08 VK PF	THROUGH-FEED

FERRITIC, NODULAR PEARLITIC AND HARDENED CAST IRON							
T1-T5	thickness 25 to 45		T1-T5	thickness 50 to 80	T1-T5-T7	thickness 85 to 120	application
400	43A 060 K08 V86	○	400	43A 060 J08 V86	○		THROUGH-FEED
	43A 080 K08 V86	○		43A 080 J08 V86	○		THROUGH-FEED
450	43A 060 K08 V86	○	450	43A 060 J08 V86	○		THROUGH-FEED
	43A 080 K08 V86	○		43A 080 J08 V86	○		THROUGH-FEED
500	43A 060 K08 V86	○	500	43A 060 J08 V86	○	500 43A 060 J08 V86 ○	THROUGH-FEED
	43A 080 K08 V86	○		43A 080 J08 V86	○	43A 080 J08 V86 ○	THROUGH-FEED
						610 43A 060 J08 V86 ○	THROUGH-FEED
						43A 080 J08 V86 ○	THROUGH-FEED

GREY CAST IRON							
T1-T5	thickness 25 to 45		T1-T5	thickness 50 to 80	T1-T5-T7	thickness 85 to 120	application
400	06C 060J07 V11	●	400	06C 060 I07 V11	●		THROUGH-FEED
	06C 060 J07 V11	●		06C 060 I07 V11	●		THROUGH-FEED
450	06C 060J07 V11	●	450	06C 060 I07 V11	●		THROUGH-FEED
	06C 060 J07 V11	●		06C 060 I07 V11	●		THROUGH-FEED
500	06C 060J07 V11	●	500	06C 060 I07 V11	●	500 06C 060 I07 V11 ●	THROUGH-FEED
	06C 060 J07 V11	●		06C 060 I07 V11	●	06C 060 I07 V11 ●	THROUGH-FEED
						610 06C 060 I07 V11 ●	THROUGH-FEED
						06C 060 I07 V11 ●	THROUGH-FEED

NON FERROUS METALS: ALUMINIUM, BRONZE, COPPER AND NON FERROUS ALLOYS							
T1-T5	thickness 25 to 45		T1-T5	thickness 50 to 80	T1-T5-T7	thickness 85 to 120	application
400	08C 046 H10 V11 P1	●	400	08C 046 H10 V11 P1	●		THROUGH-FEED
	08C 080 H10 V11 P1	●		08C 080 H10 V11 P1	●		THROUGH-FEED
450	08C 046 H10 V11 P1	●	450	08C 046 H10 V11 P1	●		THROUGH-FEED
	08C 080 H10 V11 P1	●		08C 080 H10 V11 P1	●		THROUGH-FEED
500	08C 046 H10 V11 P1	●	500	08C 046 H10 V11 P1	●	500 08C 046 H10 V11 P1 ●	THROUGH-FEED
	08C 080 H10 V11 P1	●		08C 080 H10 V11 P1	●	08C 080 H10 V11 P1 ●	THROUGH-FEED
						610 08C 046 H10 V11 P1 ●	THROUGH-FEED
						08C 080 H10 V11 P1 ●	THROUGH-FEED

SHELLAC superfinishing wheels for cylindrical grinding

HARDENED AND CEMENTED < 62 HRC						
T1	various diameters	T5	thickness 55 to 80	T7	thickness 85 to 120	application
	09A 120 E3E		09A 120 E3E		09A 120 E3E	THROUGH-FEED
	09A 220 E3E		09A 220 E3E		09A 220 E3E	THROUGH-FEED
	09A 320 E3E		09A 320 E3E		09A 320 E3E	THROUGH-FEED
	09A 400 E3E		09A 400 E3E		09A 400 E3E	THROUGH-FEED
	09A 500 E3E		09A 500 E3E		09A 500 E3E	THROUGH-FEED

HARDENED STAINLESS STEEL						
T1	various diameters	T5	thickness 55 to 80	T7	thickness 85 to 120	application
	08C 120 E3E		08C 120 E3E		08C 120 E3E	THROUGH-FEED
	08C 220 E3E		08C 220 E3E		08C 220 E3E	THROUGH-FEED
	08C 320 E3E		08C 320 E3E		08C 320 E3E	THROUGH-FEED
	08C 400 E3E		08C 400 E3E		08C 400 E3E	THROUGH-FEED
	08C 500 E3E		08C 500 E3E		08C 500 E3E	THROUGH-FEED

Cylindrical grinding wheels with standard profile

QUENCHED AND TEMPERED (HIGH RESISTANCE) AND HARDENED STEEL < 56 HRC									
T1-PS	thickness 15 to 30		T1-PS	thickness 35 to 50		T1-PS	thickness 60 to 80		application
400	09A 080 J08 VK7 PF	●	400	09A 080 J08 VK7 PF	●				PLUNGE
	09A 100 I14 VG7 PF	●		09A 100 HI14 VG7 PF	●				PLUNGE
	09A 120 I14 VG7 PF	●		09A 120 I14 VG7 PF	●				PLUNGE
	45A 070 K08 VK7 PF	●		45A 070 K08 VK7 PF	●				PLUNGE
	45A 080 JK08 VK7 PF	●		45A 080 JK08 VK7 PF	●				PLUNGE
450	09A 080 J08 VK7 PF	●	450	09A 080 J08 VK7 PF	●				PLUNGE
	09A 100 I14 VG7 PF	●		09A 100 I14 VG7 PF	●				PLUNGE
	09A 120 I14 VG7 PF	●		09A 120 I14 VG7 PF	●				PLUNGE
	45A 070 K08 VK7 PF	●		45A 070 K08 VK7 PF	●				PLUNGE
	45A 080 JK08 VK7 PF	●		45A 080 JK08 VK7 PF	●				PLUNGE
500	09A 080 J08 VK7 PF	●	500	09A 080 J08 VK7 PF	●	500	09A 080 J08 VK7 PF	●	PLUNGE
	09A 100 I14 VG7 PF	●		09A 100 I14 VG7 PF	●		09A 100 HI14 VG7 PF	●	PLUNGE
	09A 120 I14 VG7 PF	●		09A 120 I14 VG7 PF	●		09A 120 I14 VG7 PF	●	PLUNGE
	45A 070 K08 VK7 PF	●		45A 070 K08 VK7 PF	●		45A 070 J08 VK7 PF	●	PLUNGE
	45A 080 JK8 VK7 PF	●		45A 080 JK8 VK7 PF	●		45A 080 J08 VK7 PF	●	PLUNGE

HARDENED AND CEMENTED STEEL < 60 HRC									
T1-PS	thickness 15 to 30		T1-PS	thickness 35 to 50		T1-PS	thickness 60 to 80		application
400	43A 080 JK08 VK7 PF	●	400	43A 080 J08 VK7 PF	●				PLUNGE
	43A 120 JK09 VK7 PF	●		43A 120 J09 VK7 PF	●				PLUNGE
	43A 180 I12 VK7P1	●		43A 180 I12 VK7P1	●				PLUNGE
450	43A 080 JK08 VK7 PF	●	450	43A 080 J08 VK7 PF	●				PLUNGE
	43A 120 JK09 VK7 PF	●		43A 120 J09 VK7 PF	●				PLUNGE
	43A 180 I12 VK7P1	●		43A 180 I12 VK7P1	●				PLUNGE
500	43A 080 JK08 VK7 PF	●	500	43A 080 J08 VK7 PF	●	500	43A 080 J08 VK7 PF	●	PLUNGE
	43A 120 JK09 VK7 PF	●		43A 120 J09 VK7 PF	●		43A 120 J09 VK7 PF	●	PLUNGE
	43A 180 I12 VK7P1	●		43A 180 I12 VK7P1	●				PLUNGE

Cylindrical grinding wheels with standard profile

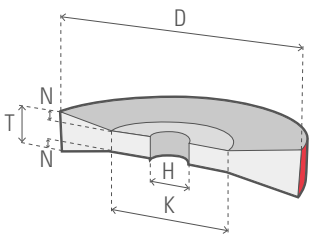
HARDENED AND CEMENTED STEEL < 68 HRC						
T1-PS	thickness 15 to 30	T1-PS	thickness 35 to 50	T1-PS	thickness 60 to 80	application
400	1SA 70/1 IJ8 VK4 PF	400	1SA 70/1 IJ8 VK4 PF			PLUNGE
	1SA 150/1 K09 VK4 PF		1SA 150/1 K09 VK4 PF			PLUNGE
	3SA 70/1 J08 VK4 PF		3SA 70/1 J08 VK4 PF			PLUNGE
	3SA 100 K09 VK4 PF		3SA 100 K09 VK4 PF			PLUNGE
450	1SA 70/1 IJ08 VK4 PF	450	1SA 70/1 IJ8 VK4 PF			PLUNGE
	1SA 150/1 K09 VK4 PF		1SA 150/1 K09 VK4 PF			PLUNGE
	3SA 70/1 J08 VK4 PF		3SA 70/1 J08 VK4 PF			PLUNGE
	3SA 100 K09 VK4 PF		3SA 100 K09 VK4 PF			PLUNGE
500	1SA 70/1 IJ08 VK4 PF	500	1SA 70/1 IJ8 VK4 PF	500	1SA 70/1 I08 VK4 PF	PLUNGE
	1SA 150/1 K09 VK4 PF		1SA 150/1 K09 VK4 PF		1SA 150/1 J09 VK4 PF	PLUNGE
	3SA 70/1 J08 VK4 PF		3SA 70/1 J08 VK4 PF		3SA 70/1 I08 VK4 PF	PLUNGE
	3SA 100 K09 VK4 PF		3SA 100 K09 VK4 PF		3SA 100 J09 VK4 PF	PLUNGE

Crankshaft grinding wheels (reconditioning grinding)

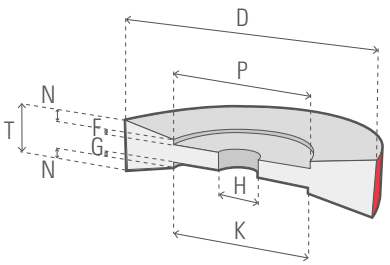
Peripheral speed 35 m/sec

SHAPES AND DIMENSIONS								
Shape	D	T	U	H	J/K	F	G	N
T39A	660	25	19	203,2	320			1,5
T39A	660	25	22	203,2	320			2
T39A	660	25	25	203,2	320			2,5
T21	660	32	-	203,2	320			4
T39A	710	25	19	203,2	320			1,5
T39A	710	25	22	203,2	320			1,5
T39A	710	25	25	203,2	320			2,5
T39A	710	28	28	203,2	320			3
T21	710	32	-	203,2	320			4
T26	710	38	-	203,2	320	4	4	1,5
T39A	760	25	19	203,2	320			1,5
T39A	760	25	22	203,2	320			1,5
T39A	760	25	25	203,2	320			2,5
T39A	760	28	28	203,2	320			3
T21	760	32	-	203,2	320			4
T26	760	38	-	203,2	320	4	4	1,5
T39A	812	25	19	203,2	320			1,5
T39A	812	25	22	203,2	320			1,5
T39A	812	25	25	203,2	320			2,5
T39A	812	28	28	203,2	320			3
T21	812	32	-	203,2	320			4
T26	812	38	-	203,2	320	4	4	1,5
T39A	915	25	22	304,8	400			1,5
T39A	915	25	25	304,8	400			2,5
T39A	915	28	28	304,8	400			3
T21	915	32	-	304,8	400			4
T26	915	38	-	304,8	400	4	4	1,5
T26	915	45	-	304,8	400	6	6	3
T26	915	50	-	304,8	400	7	7	3
T21	1016	32	-	304,8	400			4
T26	1016	38	-	304,8	400	4	4	1,5
T26	1016	45	-	304,8	400	6	6	3
T26	1016	50	-	304,8	400	7	7	3
T26	1016	63	-	304,8	400	13	13	3

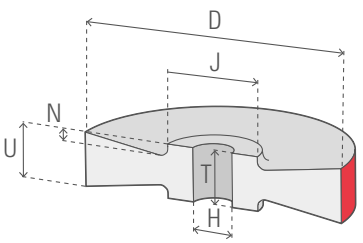
SHAPE T21



SHAPE T26



SHAPE T39A

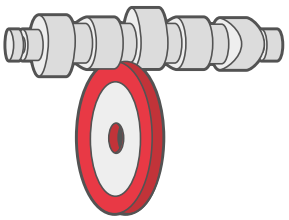


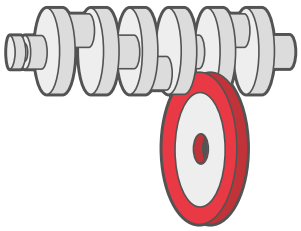
EXAMPLE OF ORDER

SHAPE	DIMENSIONS (mm)	NOTE	SPEED	SPECIFICATION	
T39A	760 x 25 x 203,2	J/K = 320 N = 2,5	35 m/sec	00A054LM06V86	The coloured dot shows the actual colour of the wheel

Crankshaft grinding wheels
Peripheral speed 35 m/sec

SPECIFICATIONS				
materials	diameter ≤ 610 mm specification		diameter ≤ 610 mm specification	use
Hardened steel	15A054K07V86	●	00A054LM06V86	● General use
Cast iron			9A46/2J07V86	○ High removal
Hardened steel			9A70/2J09V86	○ High removal
Chrome plated cast iron			09A080/1J08VK4P1	● High removal





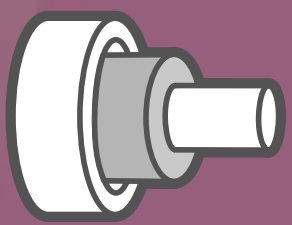
VIT CBN wheels
for camshaft and crankshaft grinding

ON SPECIFIC REQUEST

48

WHEELS FOR INTERNAL GRINDING
SHAPES T1 - T5

Internal grinding



Wheels for internal grinding

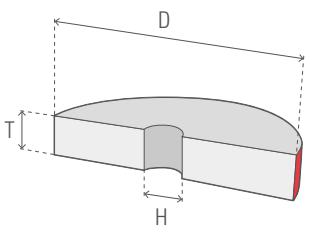
MILD, QUENCHED AND TEMPERED AND HARDENED STEEL ≤ 52 HRC

T1	Specification	T5	Inc.	Specification	Available
		16,0x16,0x6,00	10x6	31A 60 J08 V86	STOCK
20,0x20,0x6,00	31A 60 J08 V86	20,0x20,0x6,00	13x10	31A 60 J08 V86	STOCK
		20,0x20,0x8,00	13x10	31A 60 J08 V86	STOCK
25,0x25,0x6,00	31A 60 J08 V86				STOCK
25,0x25,0x8,00	31A 60 J08 V86	25,0x25,0x8,00	13x10	31A 60 J08 V86	STOCK
32,0x32,0x10,00	31A 60 J08 V86	32,0x32,0x10,00	16x16	31A 60 J08 V86	STOCK
		40,0x25,0x10,00	20x16	31A 60 J08 V86	STOCK
		40,0x40,0x10,00	20x16	31A 60 J08 V86	STOCK
50,0x40,0x16,00	31A 60 J08 V86	50,0x40,0x16,00	25x16	31A 60 J08 V86	STOCK
		60,0x40,0x20,00	32x20	31A 60 J08 V86	STOCK

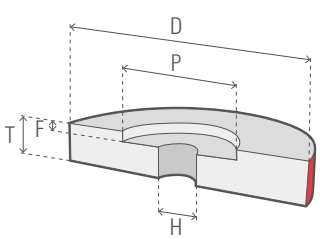
HARDENED AND CEMENTED STEEL ≤ 58 HRC AND STAINLESS

T1	Specification	T5	Inc.	Specification	Available
		16,0x16,0x6,00	10x6	43A 60 J14 VK2PF	STOCK
20,0 x 20,0 x 6,00	43A 60 J14 VK2PF	20,0x20,0x6,00	13x10	43A 60 J14 VK2PF	STOCK
		20,0x20,0x8,00	13x10	43A 60 J14 VK2PF	STOCK
		25,0x25,0x8,00	13x10	43A 60 J14 VK2PF	STOCK
		32,0x32,0x8,00	16x16	43A 60 J14 VK2PF	STOCK
		32,0x32,0x10,00	16x16	43A 60 J14 VK2PF	STOCK
		40,0x25,0x10,00	20x16	43A 60 J14 VK2PF	STOCK
		40,0x40,0x10,00	20x16	43A 60 J14 VK2PF	STOCK
		50,0x40,0x16,00	25x16	43A 60 J14 VK2PF	STOCK
		60,0x32,0x20,00	32x16	43A 60 J14 VK2PF	STOCK
		60,0x40,0x20,00	32x20	43A 60 J14 VK2PF	STOCK
		80,0x40,0x20,00	40x20	43A 60 J14 VK2PF	STOCK
		100,0x40,0x32,00	70x20	43A 60 J14 VK2PF	STOCK

SHAPE T1



SHAPE T5



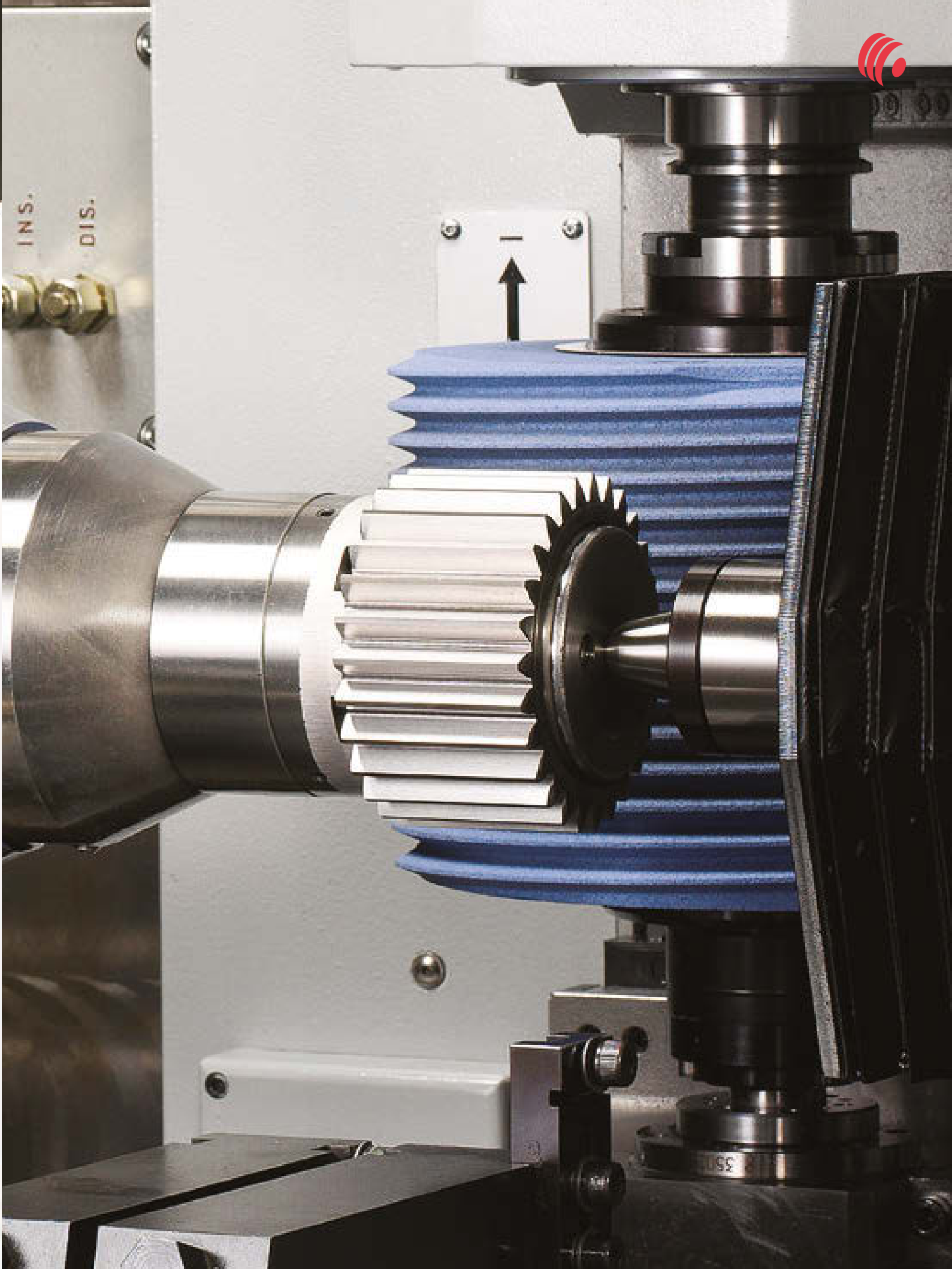
Wheels for internal grinding

HARDENED AND CEMENTED STEEL ≤ 62 HRC

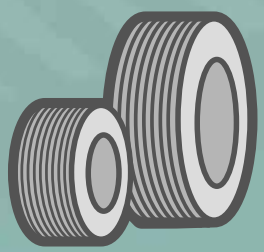
T1	Specification	T5	Inc.	Specification	Available
		16,0x16,0x6,00	10x6	1SA 60 J08 VK4	STOCK
20,0x 20,0x 6,00	1SA 60 J8 VK4	20,0x20,0x6,00	13x10	1SA 60 J08 VK4	STOCK
		20,0x20,0x8,00	13x10	1SA 60 J08 VK4	STOCK
		25,0x25,0x8,00	13x10	1SA 60 J08 VK4	STOCK
		32,0x32,0x8,00	16x16	1SA 60 J08 VK4	STOCK
		32,0x32,0x10,00	16x16	1SA 60 J08 VK4	STOCK
		40,0x25,0x10,00	20x16	1SA 60 J08 VK4	STOCK
		40,0x40,0x10,00	20x16	1SA 60 J08 VK4	STOCK
		50,0x40,0x16,00	25x16	1SA 60 J08 VK4	STOCK
		60,0x32,0x20,00	32x16	1SA 60 J08 VK4	STOCK
		60,0x40,0x20,00	32x20	1SA 60 J08 VK4	STOCK
		80,0x40,0x20,00	40x20	1SA 60 I08 VK4	STOCK
		100,0x40,0x32,00	70x20	1SA 60 I08 VK4	STOCK

CAST IRON AND NON FERROUS METALS

T1	Specification	T5	Inc.	Specification	Available
		16,0x16,0x6,00	10x6	06C 046 J06 V01	TO BE ORDERED
20,0x20,0x6,00	06C 046 J06 V01	20,0x20,0x6,00	13x10	06C 046 J06 V01	TO BE ORDERED
		20,0x20,0x8,00	13x10	06C 046 J06 V01	TO BE ORDERED
25,0x25,0x6,00	06C 046 J06 V01				TO BE ORDERED
25,0x25,0x8,00	06C 046 J06 V01	25,0x25,0x8,00	13x10	06C 046 J06 V01	TO BE ORDERED
32,0x32,0x10,00	06C 046 J06 V01	32,0x32,0x10,00	16x16	06C 046 J06 V01	TO BE ORDERED
		40,0x25,0x10,00	20x16	06C 046 J06 V01	TO BE ORDERED
		40,0x40,0x10,00	20x16	06C 046 J06 V01	TO BE ORDERED
50,0x40,0x16,00	06C 046 J06 V01	50,0x40,0x16,00	25x16	06C 046 J06 V01	TO BE ORDERED
		60,0x40,0x20,00	32x20	06C 046 J06 V01	TO BE ORDERED


INS.
DIS.

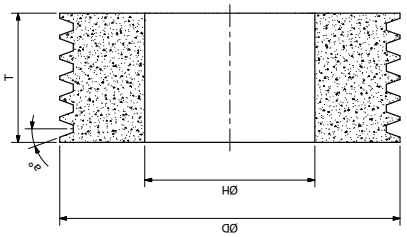
Gear grinding



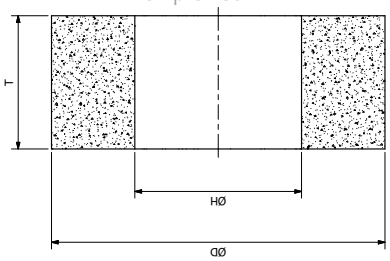
Worm wheel for gear grinding

WORM WHEEL					
T1 - T7	Dimensions	Specification	Module Angle Principles	Machine	speed
SPIR	220x180x90	11A 80 I V45 PF	>1,5 V=> 20° 1:7	Gleason	63 m/sec
T1	220x180x90	11A 80 I V45 PF		Gleason	63 m/sec
SPIR	220x180x90	21A 120/1 I V40 PF	<1,5 V=> 20° 1:7	Gleason	63 m/sec
T1	220x180x90	21A 120/1 I V40 PF		Gleason	63 m/sec
SPIR	240x125x120	11A 80 I V45 PF	>1,5 V=> 20° 1:7	Gleason	63 m/sec
T1	240x125x120	11A 80 I V45 PF		Gleason	63 m/sec
SPIR	240x125x120	21A 120/1 I V40 PF	<1,5 V=> 20° 1:7	Gleason	63 m/sec
T1	240x125x120	21A 120/1 I V40 PF		Gleason	63 m/sec
SPIR	275x125x160	11A 80 I V45 PF	>1,5 V=> 20° 1:7	Reishauer	80 m/sec
T1	275x125x160	11A 80 I V45 PF		Reishauer	80 m/sec
SPIR	275x125x160	21A 120/1 I V40 PF	<1,5 V=> 20° 1:7	Reishauer	80 m/sec
T1	275x125x160	21A 120/1 I V40 PF		Reishauer	80 m/sec
SPIR	275x160x160	11A 80 I V45 PF	>1,5 V=> 20° 1:7	Reishauer	80 m/sec
T1	275x160x160	11A 80 I V45 PF		Reishauer	80 m/sec
SPIR	275x160x160	21A 120/1 I V40 PF	<1,5 V=> 20° 1:7	Reishauer	80 m/sec
T1	275x160x160	21A 120/1 I V40 PF		Reishauer	80 m/sec
SPIR	300x125x160	11A 80 I V45 PF	>1,5 V=> 20° 1:7	Reishauer	80 m/sec
T1	300x125x160	11A 80 I V45 PF		Reishauer	80 m/sec
SPIR	300x125x160	21A 120/1 I V40 PF	<1,5 V=> 20° 1:7	Reishauer	80 m/sec
T1	300x125x160	21A 120/1 I V40 PF		Reishauer	80 m/sec
SPIR	300x145x160	11A 80 I V45 PF	>1,5 V=> 20° 1:7	Reishauer	80 m/sec
T1	300x145x160	11A 80 I V45 PF		Reishauer	80 m/sec
SPIR	300x145x160	21A 120/1 I V40 PF	<1,5 V=> 20° 1:7	Reishauer	80 m/sec
T1	300x145x160	21A 120/1 I V40 PF		Reishauer	80 m/sec
SPIR	350x104x160	11A 80 I V45 PF	>1,5 V=> 20° 1:7	Reishauer	80 m/sec
T1	350x104x160	11A 80 I V45 PF		Reishauer	80 m/sec
SPIR	350x104x160	21A 120/1 I V40 PF	<1,5 V=> 20° 1:7	Reishauer	80 m/sec
T1	350x104x160	21A 120/1 I V40 PF		Reishauer	80 m/sec

Profiled SPIR



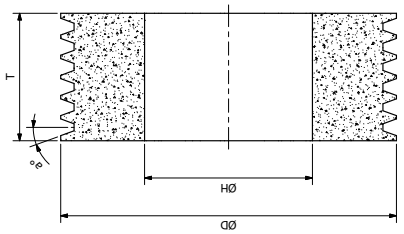
Non profiled T1



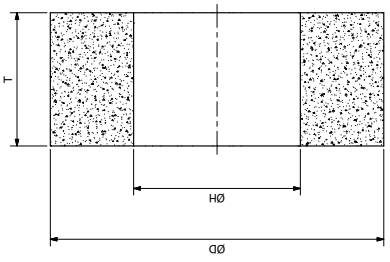
Worm wheel for gear grinding

WORM WHEEL					
T1 - T7	Dimensions	Specification	Module Angle Principles	Machine	speed
SPIR	195x200x90	11A 80 I V45 PF	>1,5 V=> 20° 1:7	Liebherr	80 m/sec
T1	195x200x90	11A 80 I V45 PF		Liebherr	80 m/sec
SPIR	195x200x90	21A 120/1 I V40 PF	<1,5 V=> 20° 1:7	Liebherr	80 m/sec
T1	195x200x90	21A 120/1 I V40 PF		Liebherr	80 m/sec
SPIR	240x230x110	11A 80 I V45 PF	>1,5 V=> 20° 1:7	Liebherr	80 m/sec
T1	240x230x110	11A 80 I V45 PF		Liebherr	80 m/sec
SPIR	240x230x110	21A 120/1 I V40 PF	<1,5 V=> 20° 1:7	Liebherr	80 m/sec
T1	240x230x110	21A 120/1 I V40 PF		Liebherr	80 m/sec
SPIR	280x160x115	11A 80 I V45 PF	>1,5 V=> 20° 1:7	Kapp KX300P	80 m/sec
T1	280x160x115	11A 80 I V45 PF		Kapp KX300P	80 m/sec
SPIR	280x160x115	21A 120/1 I V40 PF	<1,5 V=> 20° 1:7	Kapp KX300P	80 m/sec
T1	280x160x115	21A 120/1 I V40 PF		Kapp KX300P	80 m/sec
SPIR	320x125x115	11A 80 I V45 PF	>1,5 V=> 20° 1:7	Kapp KX300P	80 m/sec
T1	320x125x115	11A 80 I V45 PF		Kapp KX300P	80 m/sec
SPIR	320x125x115	21A 120/1 I V40 PF	<1,5 V=> 20° 1:7	Kapp KX300P	80 m/sec
T1	320x125x115	21A 120/1 I V40 PF		Kapp KX300P	80 m/sec
SPIR	220x104x76,2 - 2inc. 117x10,5	11A 80 I V45 PF	>1,5 V=> 20° 1:7	Samp	63 m/sec
T7	220x104x76,2 - 2inc. 117x10,5	11A 80 I V45 PF		Samp	63 m/sec
SPIR	220x104x76,2 - 2inc. 117x10,5	21A 120/1 IJ V40 PF	<1,5 V=> 20° 1:7	Samp	63 m/sec
T7	220x104x76,2 - 2inc. 117x10,5	21A 120/1 IJ V40 PF		Samp	63 m/sec
SPIR	240x104x76,2 - 2inc. 117x10,5	11A 80 I V45 PF	>1,5 V=> 20° 1:7	Samp	63 m/sec
T7	240x104x76,2 - 2inc. 117x10,5	11A 80 I V45 PF		Samp	63 m/sec
SPIR	240x104x76,2 - 2inc. 117x10,5	21A 120/1 IJ V40 PF	<1,5 V=> 20° 1:7	Samp	63 m/sec
T7	240x104x76,2 - 2inc. 117x10,5	21A 120/1 IJ V40 PF		Samp	63 m/sec
SPIR	240x140x76,2	11A 80 I V45 PF	>1,5 V=> 20° 1:7	Samp	80 m/sec
T1	240x140x76,2	11A 80 I V45 PF		Samp	80 m/sec
SPIR	240x140x76,2	21A 120/1 IJ V40 PF	<1,5 V=> 20° 1:7	Samp	80 m/sec
T1	240x140x76,2	21A 120/1 IJ V40 PF		Samp	80 m/sec

Profiled SPIR



Non profiled T1



Single profile wheels for gear grinding

SINGLE PROFILE WHEELS							
T1	Dimensions	Specification		Table Angle		Machine	speed
PRQ	200x30x50,8	1SA 60 H11 VK4P1		U=	V=	Samp	63 m/sec
T1	200x30x50,8	1SA 60 H11 VK4P1				Samp	63 m/sec
PRQ	240x25x76,2	1SA 60 H11 VK4P1		U=	V=	Samp	63 m/sec
T1	240x25x76,2	1SA 60 H11 VK4P1				Samp	63 m/sec
PRQ	240x30x76,2	1SA 60 H11 VK4P1		U=	V=	Samp	63 m/sec
T1	240x30x76,2	1SA 60 H11 VK4P1				Samp	63 m/sec
PRQ	300x20x50,8	1SA 60 H11 VK4P1		U=	V=	Samp	63 m/sec
PRQ	300x20x50,8	3AZ 060/1 H10 VK4 PF1		U=	V=	Samp	63 m/sec
PRQ	300x20x50,8	3AZ 080 J08 VK4 PF1		U=	V=	Samp	63 m/sec
T1	300x20x50,8	1SA 60 H11 VK4P1				Samp	63 m/sec
T1	300x20x50,8	3AZ 060/1 H10 VK4 PF1				Samp	63 m/sec
T1	300x20x50,8	3AZ 080 J08 VK4 PF1				Samp	63 m/sec
PRQ	300x30x50,8	1SA 60 H11 VK4P1		U=	V=	Samp	63 m/sec
PRQ	300x30x50,8	3AZ 060/1 H10 VK4 PF1		U=	V=	Samp	63 m/sec
PRQ	300x30x50,8	3AZ 080 J08 VK4 PF1		U=	V=	Samp	63 m/sec
T1	300x30x50,8	1SA 60 H11 VK4P1				Samp	63 m/sec
T1	300x30x50,8	3AZ 060/1 H10 VK4 PF1				Samp	63 m/sec
T1	300x30x50,8	3AZ 080 J08 VK4 PF1				Samp	63 m/sec
PRQ	250x32x80	1SA 60 H11 VK4P1		U=	V=	Gleason/Höfler/Niles	63 m/sec
T1	250x32x80	1SA 60 H11 VK4P1				Gleason/Höfler/Niles	63 m/sec
PRQ	300x25x100	1SA 60 H11 VK4P1		U=	V=	Gleason/Höfler/Niles	63 m/sec
PRQ	300x25x100	3AZ 060/1 H10 VK4 PF1		U=	V=	Gleason/Höfler/Niles	63 m/sec
PRQ	300x25x100	3AZ 080 J08 VK4 PF1		U=	V=	Gleason/Höfler/Niles	63 m/sec
T1	300x25x100	1SA 60 H11 VK4P1				Gleason/Höfler/Niles	63 m/sec
T1	300x25x100	3AZ 060/1 H10 VK4 PF1				Gleason/Höfler/Niles	63 m/sec
T1	300x25x100	3AZ 080 J08 VK4 PF1				Gleason/Höfler/Niles	63 m/sec
PRQ	300x30x100	1SA 60 H11 VK4P1		U=	V=	Gleason/Höfler/Niles	63 m/sec
PRQ	300x30x100	3AZ 060/1 H10 VK4 PF1		U=	V=	Gleason/Höfler/Niles	63 m/sec
PRQ	300x30x100	3AZ 080 J08 VK4 PF1		U=	V=	Gleason/Höfler/Niles	63 m/sec
T1	300x30x100	1SA 60 H11 VK4P1				Gleason/Höfler/Niles	63 m/sec
T1	300x30x100	3AZ 060/1 H10 VK4 PF1				Gleason/Höfler/Niles	63 m/sec
T1	300x30x100	3AZ 080 J08 VK4 PF1				Gleason/Höfler/Niles	63 m/sec
PRQ	350x32x127	1SA 60 H11 VK4P1		U=	V=	Gleason/Höfler/Niles	63 m/sec
PRQ	350x32x127	3AZ 060/1 H10 VK4 PF1		U=	V=	Gleason/Höfler/Niles	63 m/sec
PRQ	350x32x127	3AZ 080 J08 VK4 PF1		U=	V=	Gleason/Höfler/Niles	63 m/sec
T1	350x32x127	1SA 60 H11 VK4P1				Gleason/Höfler/Niles	63 m/sec
T1	350x32x127	3AZ 060/1 H10 VK4 PF1				Gleason/Höfler/Niles	63 m/sec
T1	350x32x127	3AZ 080 J08 VK4 PF1				Gleason/Höfler/Niles	63 m/sec

Profiled PRQ

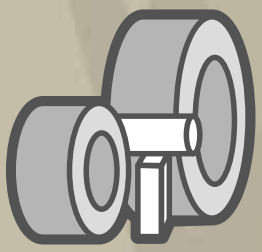
Single profile wheels for gear grinding

SINGLE PROFILE WHEELS					
T1	Dimensions	Specification	Table Angle	Machine	speed
PRQ	350x40x127	1SA 60 H11 VK4P1	U= V=	Gleason/Höfler/Niles	63 m/sec
PRQ	350x40x127	3AZ 060/1 H10 VK4 PF1	U= V=	Gleason/Höfler/Niles	63 m/sec
PRQ	350x40x127	3AZ 080 J08 VK4 PF1	U= V=	Gleason/Höfler/Niles	63 m/sec
T1	350x40x127	1SA 60 H11 VK4P1		Gleason/Höfler/Niles	63 m/sec
T1	350x40x127	3AZ 060/1 H10 VK4 PF1		Gleason/Höfler/Niles	63 m/sec
T1	350x40x127	3AZ 080 I08 VK4 PF1		Gleason/Höfler/Niles	63 m/sec
PRQ	400x32x127	1SA 60 H11 VK4P1	U= V=	Gleason/Höfler/Niles	63 m/sec
PRQ	400x32x127	3AZ 060/1 H10 VK4 PF1	U= V=	Gleason/Höfler/Niles	63 m/sec
PRQ	400x32x127	3AZ 080 J08 VK4 PF1	U= V=	Gleason/Höfler/Niles	63 m/sec
T1	400x32x127	1SA 60 H11 VK4P1		Gleason/Höfler/Niles	63 m/sec
T1	400x32x127	3AZ 060/1 H10 VK4 PF1		Gleason/Höfler/Niles	63 m/sec
T1	400x32x127	3AZ 080 J08 VK4 PF1		Gleason/Höfler/Niles	63 m/sec
PRQ	400x40x127	1SA 60 H11 VK4P1	U= V=	Gleason/Höfler/Niles	63 m/sec
PRQ	400x40x127	3AZ 060/1 H10 VK4 PF1	U= V=	Gleason/Höfler/Niles	63 m/sec
PRQ	400x40x127	3AZ 080 J08 VK4 PF1	U= V=	Gleason/Höfler/Niles	63 m/sec
T1	400x40x127	1SA 60 H11 VK4P1		Gleason/Höfler/Niles	63 m/sec
T1	400x40x127	3AZ 060/1 H10 VK4 PF1		Gleason/Höfler/Niles	63 m/sec
T1	400x40x127	3AZ 080 I08 VK4 PF1		Gleason/Höfler/Niles	63 m/sec
PRQ	450x32x127	1SA 60 H11 VK4P1	U= V=	Gleason/Höfler/Niles	63 m/sec
PRQ	450x32x127	3AZ 060/1 H10 VK4 PF1	U= V=	Gleason/Höfler/Niles	63 m/sec
PRQ	450x32x127	3AZ 080 J08 VK4 PF1	U= V=	Gleason/Höfler/Niles	63 m/sec
T1	450x32x127	1SA 60 H11 VK4P1		Gleason/Höfler/Niles	63 m/sec
T1	450x32x127	3AZ 060/1 H10 VK4 PF1		Gleason/Höfler/Niles	63 m/sec
T1	450x32x127	3AZ 080 J08 VK4 PF1		Gleason/Höfler/Niles	63 m/sec
PRQ	450x40x127	1SA 60 H11 VK4P1	U= V=	Gleason/Höfler/Niles	63 m/sec
PRQ	450x40x127	3AZ 060/1 H10 VK4 PF1	U= V=	Gleason/Höfler/Niles	63 m/sec
PRQ	450x40x127	3AZ 080 J08 VK4 PF1	U= V=	Gleason/Höfler/Niles	63 m/sec
T1	450x40x127	1SA 60 H11 VK4P1		Gleason/Höfler/Niles	63 m/sec
T1	450x40x127	3AZ 060/1 H10 VK4 PF1		Gleason/Höfler/Niles	63 m/sec
T1	450x40x127	3AZ 080 I08 VK4 PF1		Gleason/Höfler/Niles	63 m/sec
Variant with finer grit (better finishing)		3AZ 080 J08 VK4 PF1			
Variant for modules with important dimensions		3AZ 060/1 H10 VK4 PF1			

Cylindrical gear grinding for pumps and hydraulic engines

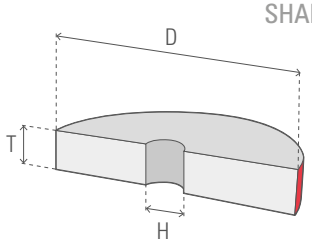
PROFILE N WHEELS							
T1 - PRN	thickness 20 to 30		thickness 35 to 60		thickness 65 to 100		Angle 1 / Angle2
450	43A 080 JK8 VK7 PF		43A 080 J08 VK7 PF				V^1 V^2
	43A 120 JK9 VK7 PF		43A 120 JK9 VK7 PF				V^1 V^2
508	43A 080 JK8 VK7 PF		43A 080 J08 VK7 PF		43A 080 IJ08 VK7 PF		V^1 V^2
	43A 120 JK9 VK7 PF		43A 120 JK9 VK7 PF		43A 120 IJ09 VK7PF		V^1 V^2
610			43A 080 J08 VG7 PF		43A 080 IJ08 VK7 PF		V^1 V^2
			43A 120 JK9 VK7PF		43A 120 IJ09 VK7PF		V^1 V^2

Centreless grinding



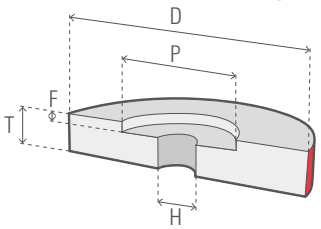
SHAPES AND DIMENSIONS		
Shape	D	H
T1	300	127
	350	127
	400	203,2 - 152,4
	508	254 - 304,8
	610	304,8

SHAPE T1



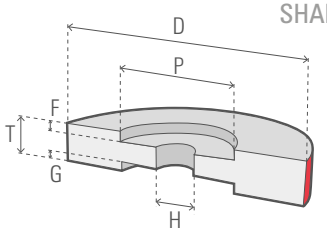
Shape	D	H	P	F
T5	300	127	190	To be specified F max = 1/2T
	350	127	215	
	400	203,2	270	
	508	304,8	390	
	610	304,8	390	

SHAPE T5



Shape	D	H	P	F
T7	300	127	190	To be specified F+G max = 1/2T
	350	127	215	
	400	203,2	270	
	508	304,8	390	
	610	304,8	390	

SHAPE T7

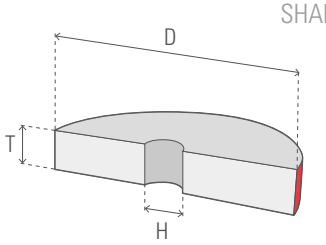


WHEEL THICKNESS UPON REQUEST
For thickness 400, 508 and 610, we supply wheels combined into 2 or 3 pieces, thickness 1/2T or 1/3T

Regulating wheels

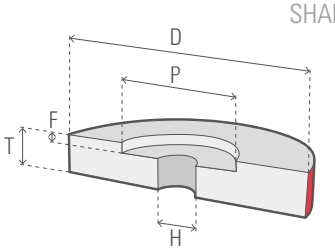
SHAPES AND DIMENSIONS		
Shape	D	H
T1	200	76,2
	250	127
	300	127
	350	127 - 203,2

SHAPE T1



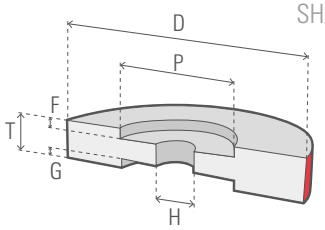
Shape	D	H	P	F
T5	200	76,2	115	To specify
	250	127	190	
	300	127	190	
	350	127	215	
	350	203,2	270	

SHAPE T5



Shape	D	H	P	F
T7	200	76,2	115	To specify
	250	127	190	
	300	127	190	
	350	127	215	
	350	203,2	270	

SHAPE T7



SPECIFICATIONS		
Grinding type	Specification	Use
Through-feed Centerless Plunge Centerless	00A080 RR Rubber bond	General
	00A120 RR	Finishing
	00A180 SR	Superfinishing
	00A080 SV Vitrified bond	Only for specific production of pieces with diameter ≤ 16 mm

WHEEL THICKNESS UPON REQUEST

MILD, ANNEALED AND QUENCHED AND TEMPERED STEEL < 35 HRC							
T1-T5	thickness 100 to 150		T1-T5	thickness 200 to 250	T1-T5-T7	thickness 300 to 500	application
300	15A 060 K8 V86						THROUGH-FEED
300	11A 060 K8 V86						THROUGH-FEED
350	15A 060 K8 V86		350	15A 060 K8 V86			THROUGH-FEED
350	11A 060 K8 V86		350	11A 060 K8 V86			THROUGH-FEED
400	15A 060 K8 V86		400	15A 060 K8 V86			THROUGH-FEED
400	11A 060 K8 V86		400	11A 060 K8 V86			THROUGH-FEED
508	15A 060 K8 V86		508	15A 060 K8 V86	508	15A 060 K8 V86	THROUGH-FEED
508	11A 060 K8 V86		508	11A 060 K8 V86	508	11A 060 K8 V86	THROUGH-FEED
610	15A 060 K8 V86		610	15A 060 K8 V86	610	15A 060 K8 V86	THROUGH-FEED
610	11A 060 K8 V86		610	11A 060 K8 V86	610	11A 060 K8 V86	THROUGH-FEED

QUENCHED AND TEMPERED (HIGH RESISTANCE) AND HARDENED STEEL < 56 HRC							
T1-T5	thickness 100 to 150		T1-T5	thickness 200 to 250	T1-T5-T7	thickness 300 to 500	application
300	09A 080 J08 V86						THROUGH-FEED
300	45A 70/2 JK9 V85						THROUGH-FEED
350	09A 080 J08 V86		350	09A 080 J08 V86			THROUGH-FEED
350	45A 70/2 JK9 V85		350	45A 70/2 JK9 V85			THROUGH-FEED
400	09A 080 J08 V86		400	09A 080 J08 V86			THROUGH-FEED
400	45A 70/2 JK9 V85		400	45A 70/2 JK9 V85			THROUGH-FEED
508	09A 080 J08 V86		508	09A 080 J08 V86	508	09A 080 J08 V86	THROUGH-FEED
508	45A 70/2 JK9 V85		508	45A 70/2 JK9 V85	508	45A 70/2 JK9 V85	THROUGH-FEED
610	09A 080 J08 V86		610	09A 080 J08 V86	610	09A 080 J08 V86	THROUGH-FEED
610	45A 70/2 JK9 V85		610	45A 70/2 JK9 V85	610	45A 70/2 JK9 V85	THROUGH-FEED

HARDENED AND CEMENTED STEEL < 60 HRC							
T1-T5	thickness 100 to 150		T1-T5	thickness 200 to 250	T1-T5-T7	thickness 300 to 500	application
300	43A 080 J08 V86						THROUGH-FEED
350	43A 080 J08 V86		350	43A 080 J08 V86			THROUGH-FEED
400	43A 080 J08 V86		400	43A 080 J08 V86			THROUGH-FEED
508	43A 080 J08 V86		508	43A 080 J08 V86	508	43A 080 J08 V86	THROUGH-FEED
610	43A 080 J08 V86		610	43A 080 J08 V86	610	43A 080 J08 V86	THROUGH-FEED

CHROME PLAITED STEEL							
T1-T5	thickness 100 to 150	T1-T5	thickness 200 to 250	T1-T5-T7	thickness 300 to 500	application
300	11A 060 J08 V30					THROUGH-FEED
350	11A 060 J08 V30	350	11A 060 J08 V30			THROUGH-FEED
400	11A 060 J08 V30	400	11A 060 J08 V30			THROUGH-FEED
508	11A 060 J08 V30	508	11A 060 J08 V30	508	11A 060 J08 V30	THROUGH-FEED
610	11A 060 J08 V30	610	11A 060 J08 V30	610	11A 060 J08 V30	THROUGH-FEED

FERRITIC STAINLESS STEEL, SERIES 400 AND INCONEL						
T1-T5	thickness 100 to 150	T1-T5	thickness 200 to 250	T1-T5-T7	thickness 300 to 500	application
300	45A 70/2 JK9 V85					THROUGH-FEED
350	45A 70/2 JK9 V85	350	45A 70/2 JK9 V85			THROUGH-FEED
400	45A 70/2 JK9 V85	400	45A 70/2 JK9 V85			THROUGH-FEED
508	45A 70/2 JK9 V85	508	45A 70/2 JK9 V85	508	45A 70/2 JK9 V85	THROUGH-FEED
610	45A 70/2 JK9 V85	610	45A 70/2 JK9 V85	610	45A 70/2 JK9 V85	THROUGH-FEED

AUSTENITIC STAINLESS STEEL SERIES 300 AND NIMONIC						
T1-T5	thickness 100 to 150	T1-T5	thickness 200 to 250	T1-T5-T7	thickness 300 to 500	application
300	43A 080 K08 V86					THROUGH-FEED
350	43A 060 K08 V86	350	43A 060 K08 V86			THROUGH-FEED
400	43A 060 K08 V86	400	43A 060 K08 V86			THROUGH-FEED
508	43A 060 K08 V86	508	43A 060 K08 V86	508	43A 060 K08 V86	THROUGH-FEED
610	43A 060 K08 V86	610	43A 060 K08 V86	610	43A 060 K08 V86	THROUGH-FEED

FERRITIC, NODULAR PEARLITIC AND HARDENED CAST IRON

T1-T5	thickness 100 to 150	T1-T5	thickness 200 to 250	T1-T5-T7	thickness 300 to 500	application
300	15A 060 K07 V86					THROUGH-FEED
350	15A 060 K07 V86	350	15A 060 K07 V86			THROUGH-FEED
400	15A 060 K07 V86	400	15A 060 K07 V86			THROUGH-FEED
508	15A 060 K07 V86	508	15A 060 K07 V86	508	15A 060 K07 V86	THROUGH-FEED
610	15A 060 K07 V86	610	15A 060 K07 V86	610	15A 060 K07 V86	THROUGH-FEED

GREY CAST IRON

T1-T5	thickness 100 to 150	T1-T5	thickness 200 to 250	T1-T5-T7	thickness 300 to 500	application
300	08C 080 K07 V11					THROUGH-FEED
350	08C 060 K07 V11	350	08C 060 K07 V11			THROUGH-FEED
400	08C 060 K07 V11	400	08C 060 K07 V11			THROUGH-FEED
508	08C 060 K07 V11	508	08C 060 K07 V11	508	08C 060 K07 V11	THROUGH-FEED
610	08C 060 K07 V11	610	08C 060 K07 V11	610	08C 060 K07 V11	THROUGH-FEED

TITANIUM

T1-T5	thickness 100 to 150	T1-T5	thickness 200 to 250	T1-T5-T7	thickness 300 to 500	application
300	08C 080 K07 V11					THROUGH-FEED
350	08C 080 K07 V11	350	08C 080 K07 V11			THROUGH-FEED
400	08C 080 K07 V11	400	08C 080 K07 V11			THROUGH-FEED
508	08C 080 K07 V11	508	08C 080 K07 V11	508	08C 080 K07 V11	THROUGH-FEED
610	08C 080 K07 V11	610	08C 080 K07 V11	610	08C 080 K07 V11	THROUGH-FEED

NON FERROUS METALS: ALUMINIUM, BRONZE, COPPER, RUBBER AND NON FERROUS ALLOYS

T1-T5	thickness 100 to 150	T1-T5	thickness 200 to 250	T1-T5-T7	thickness 300 to 500	application
300	08C 080 H10 V11P					THROUGH-FEED
350	08C 080 H10 V11P	350	08C 080 H10 V11P			THROUGH-FEED
400	08C 080 H10 V11P	400	08C 080 H10 V11P			THROUGH-FEED
508	08C 080 H10 V11P	508	08C 080 H10 V11P	508	08C 080 H10 V11P	THROUGH-FEED
610	08C 080 H10 V11P	610	08C 080 H10 V11P	610	08C 080 H10 V11P	THROUGH-FEED

HARD METAL AND INDUSTRIAL CERAMICS

T1-T5	thickness 100 to 150	T1-T5	thickness 200 to 250	T1-T5-T7	thickness 300 to 500	application
300	08C 060 H08 V11					THROUGH-FEED
350	08C 060 H08 V11	350	08C 060 H08 V11			THROUGH-FEED
400	08C 060 H08 V11	400	08C 060 H08 V11			THROUGH-FEED
508	08C 060 H08 V11	508	08C 060 H08 V11	508	08C 060 H08 V11	THROUGH-FEED
610	08C 060 H08 V11	610	08C 060 H08 V11	610	08C 060 H08 V11	THROUGH-FEED

MILD, ANNEALED AND QUENCHED AND TEMPERED STEEL < 35 HRC							
T1-T5	thickness 100 to 150		T1-T5	thickness 200 to 250		T1-T5-T7	thickness 300 to 500	application
300	15A 120 L07 V86							PLUNGE
350	15A 120 L07 V86		350	15A 120 k07 V86				PLUNGE
400	15A 120 L07 V86		400	15A 120 k07 V86				PLUNGE
508	15A 080 L07 V86		508	15A 080 K07 V86		508	15A 080 K07 V86	PLUNGE
610	15A 080 L07 V86		610	15A 080 K07 V86		610	15A 080 K07 V86	PLUNGE

QUENCHED AND TEMPERED (HIGH RESISTANCE) AND HARDENED STEEL < 56 HRC							
T1-T5	thickness 100 to 150		T1-T5	thickness 200 to 250		T1-T5-T7	thickness 300 to 500	application
300	09A 120 L07 V86							PLUNGE
300	45A 120 K8 V85							PLUNGE
350	09A 100 L07 V86		350	09A 100 K07 V86				PLUNGE
350	45A 120 K8 V85		350	45A 120 K8 V85				PLUNGE
400	09A 100 L07 V86		400	09A 100 K07 V86				PLUNGE
400	45A 120 K8 V85		400	45A 120 K8 V85				PLUNGE
508	09A 100 L07 V86		508	09A 100 K07 V86		508	09A 100 K07 V86	PLUNGE
508	45A 100 K8 V85		508	45A 100 K8 V85		508	45A 100 K8 V85	PLUNGE
610	09A 100 L07 V86		610	09A 100 K07 V86		610	09A 100 K07 V86	PLUNGE
610	45A 100 K8 V85		610	45A 100 K8 V85		610	45A 100 K8 V85	PLUNGE

HARDENED AND CEMENTED STEEL < 60 HRC							
T1-T5	thickness 100 to 150		T1-T5	thickness 200 to 250		T1-T5-T7	thickness 300 to 500	application
300	43A 120 K08 V86							PLUNGE
350	43A 120 K08 V86		350	43A 120 J08 V86				PLUNGE
400	43A 120 K08 V86		400	43A 120 J08 V86				PLUNGE
508	43A 080 K08 V86		508	43A 080 J08 V86		508	43A 080 J08 V86	PLUNGE
610	43A 080 K08 V86		610	43A 080 J08 V86		610	43A 080 J08 V86	PLUNGE

CHROME PLAITED STEEL							
T1-T5	thickness 100 to 150		T1-T5	thickness 200 to 250		T1-T5-T7	thickness 300 to 500	application
300	11A 120 K08 V11							PLUNGE
350	11A 120 K08 V11		350	11A 120 J08 V11				PLUNGE
400	11A 080 K08 V11		400	11A 080 J08 V11				PLUNGE
508	11A 080 K08 V11		508	11A 080 J08 V11		508	11A 080 J08 V11	PLUNGE
610	11A 080 K08 V11		610	11A 080 J08 V11		610	11A 080 J08 V11	PLUNGE

FERRITIC STAINLESS STEEL, SERIES 400 AND INCONEL							
T1-T5	thickness 100 to 150	T1-T5	thickness 200 to 250	T1-T5-T7	thickness 300 to 500	application
300	45A 120 JK8 V85					PLUNGE
350	45A 120 JK8 V85	350	45A 100 J8 V85			PLUNGE
400	45A 100 K8 V85	400	45A 100 J8 V85			PLUNGE
508	45A 100 K8 V85	508	45A 100 J8 V85	508	45A 100 J8 V85	PLUNGE
610	45A 100 K8 V85	610	45A 100 J8 V85	610	45A 100 J8 V85	PLUNGE

AUSTENITIC STAINLESS STEEL SERIES 300 AND NIMONIC							
T1-T5	thickness 100 to 150	T1-T5	thickness 200 to 250	T1-T5-T7	thickness 300 to 500	application
300	43A 120 K08 V86					PLUNGE
350	43A 120 K08 V86	350	43A 120 JK08 V86			PLUNGE
400	43A 080 K08 V86	400	43A 080 J08 V86			PLUNGE
508	43A 080 K08 V86	508	43A 080 J08 V86	508	43A 080 J08 V86	PLUNGE
610	43A 080 K08 V86	610	43A 080 J08 V86	610	43A 080 J08 V86	PLUNGE

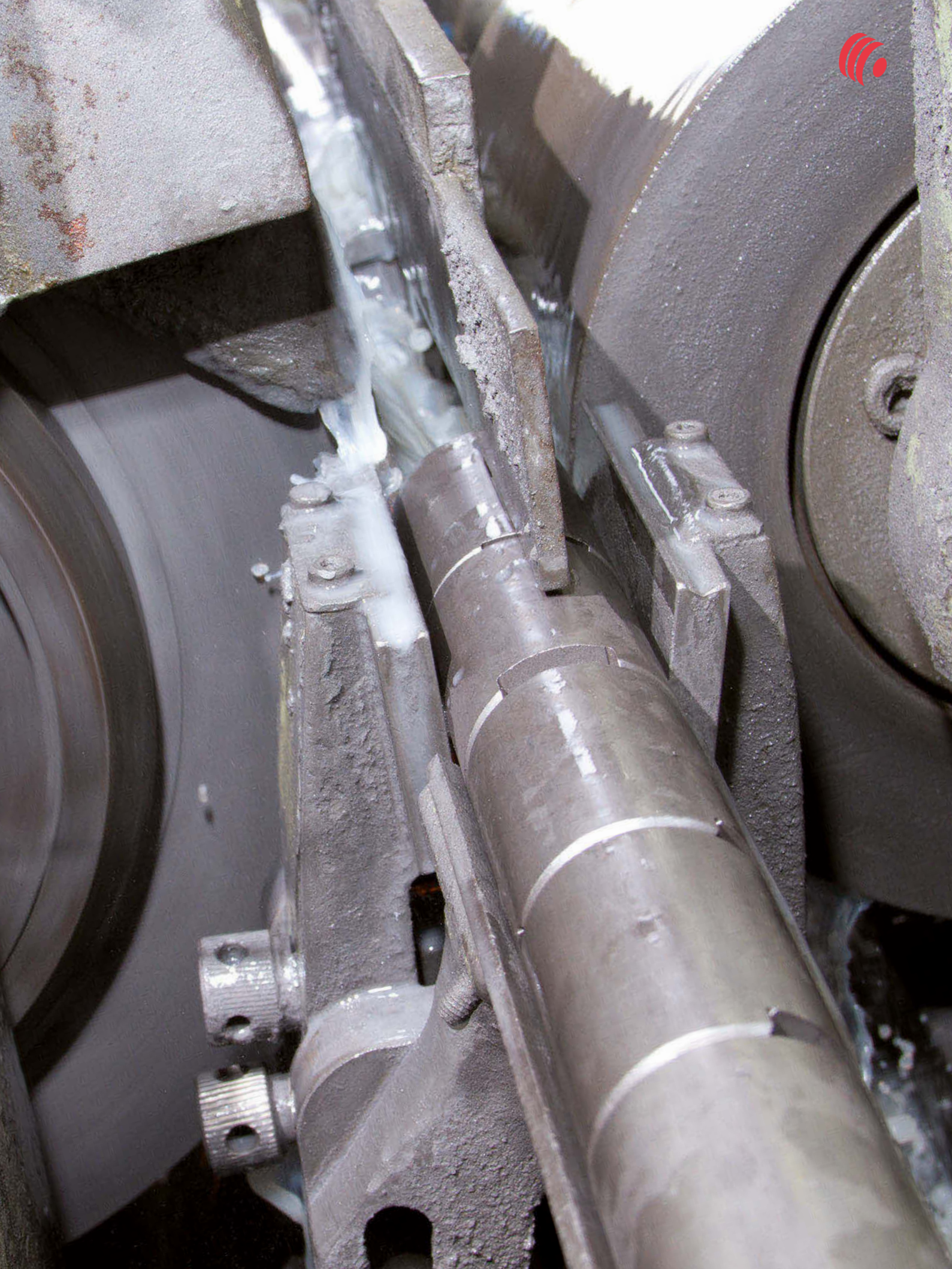
FERRITIC, NODULAR PEARLITIC AND HARDENED CAST IRON							
T1-T5	thickness 100 to 150	T1-T5	thickness 200 to 250	T1-T5-T7	thickness 300 to 500	application
300	15A 120 JK07 V86					PLUNGE
350	15A 120 JK07 V86	350	15A 120 J07 V86			PLUNGE
400	15A 080 K07 V86	400	15A 080 J07 V86			PLUNGE
508	15A 080 K07 V86	508	15A 080 J07 V86	508	15A 080 J07 V86	PLUNGE
610	15A 080 K07 V86	610	15A 080 J07 V86	610	15A 080 J07 V86	PLUNGE

GREY CAST IRON							
T1-T5	thickness 100 to 150	T1-T5	thickness 200 to 250	T1-T5-T7	thickness 300 to 500	application
300	08C 120 J07 V11					PLUNGE
350	08C 120 J07 V11	350	08C 120 J07 V11			PLUNGE
400	08C 080 K07 V11	400	08C 080 J07 V11			PLUNGE
508	08C 080 K07 V11	508	08C 080 J07 V11	508	08C 080 J07 V11	PLUNGE
610	08C 080 K07 V11	610	08C 080 J07 V11	610	08C 080 J07 V11	PLUNGE

TITANIUM BOLTS AND RIVETS							
T1-T5	thickness 100 to 150		T1-T5	thickness 200 to 250		T1-T5-T7	thickness 300 to 500		application
300	08C 120 N07 V11	●							PLUNGE
350	08C 120 N07 V11	●	350	08C 120 N07 V11	●				PLUNGE
400	08C 120 N07 V11	●	400	08C 120 N07 V11	●				PLUNGE
508	08C 120 N07 V11	●	508	08C 120 N07 V11	●	508	08C 120 N07 V11	●	PLUNGE
610	08C 120 N07 V11	●	610	08C 120 N07 V11	●	610	08C 120 N07 V11	●	PLUNGE

NON FERROUS METALS: ALUMINIUM, BRONZE, COPPER, RUBBER AND NON FERROUS ALLOYS									
T1-T5	thickness 100 to 150		T1-T5	thickness 200 to 250		T1-T5-T7	thickness 300 to 500		application
300	08C 120 H10 V11P	●							PLUNGE
350	08C 120 H10 V11P	●	350	08C 120 H10 V11P	●				PLUNGE
400	08C 080 H10 V11P	●	400	08C 080 H10 V11P	●				PLUNGE
508	08C 080 H10 V11P	●	508	08C 080 H10 V11P	●	508	08C 080 H10 V11P	●	PLUNGE
610	08C 080 H10 V11P	●	610	08C 080 H10 V11P	●	610	08C 080 H10 V11P	●	PLUNGE

HARD METAL AND INDUSTRIAL CERAMICS									
T1-T5	thickness 100 to 150		T1-T5	thickness 200 to 250		T1-T5-T7	thickness 300 to 500		application
300	08C 080 H08 V11	●							PLUNGE
350	08C 080 H08 V11	●	350	08C 080 H08 V11	●				PLUNGE
400	08C 060 H08 V11	●	400	08C 060 H08 V11	●				PLUNGE
508	08C 060 H08 V11	●	508	08C 060 H08 V11	●	508	08C 060 H08 V11	●	PLUNGE
610	08C 060 H08 V11	●	610	08C 060 H08 V11	●	610	08C 060 H08 V11	●	PLUNGE



Centreless grinding of bars and tubes
Perfecta line
Resin-bonded

CARBON STEELS AND LOW ALLOY STEEL									
T1-T5	thickness 152 to 203		T1-T5	thickness 254 to 305		T1-T5-T7	thickness 355 to 508		application
406	BGL	S							THROUGH-FEED
406	BGT	M							THROUGH-FEED
406	BGW	H							THROUGH-FEED
508	BGL	S	508	BGL	S	508	BGL	S	THROUGH-FEED
508	BGT	M	508	BGT	M	508	BGT	M	THROUGH-FEED
508	BGW	H	508	BGW	H	508	BGW	H	THROUGH-FEED
			610	BGL	S	610	BGL	S	THROUGH-FEED
			610	BGT	M	610	BGT	M	THROUGH-FEED
			610	BGW	H	610	BGW	H	THROUGH-FEED
			660	BGL	S	660	BGL	S	THROUGH-FEED
			660	BGT	M	660	BGT	M	THROUGH-FEED
			660	BGW	H	660	BGW	H	THROUGH-FEED

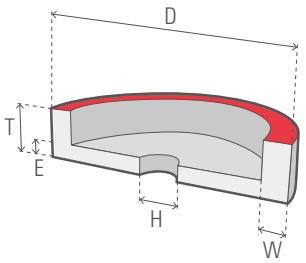
STAINLESS STEEL AND MVC NICKEL-BASED SUPER-ALLOYS					
T1-T5	thickness 152 to 203	T1-T5	thickness 254 to 305	T1-T5-T7	thickness 355 to 508	application
406	BGT					THROUGH-FEED
508	BGT	508	BGT	508	BGT	THROUGH-FEED
		610	BGT	610	BGT	THROUGH-FEED
		660	BGT	660	BGT	THROUGH-FEED

Tool sharpening

Flaring and cylindrical cup wheels
Peripheral speed 35 m/sec

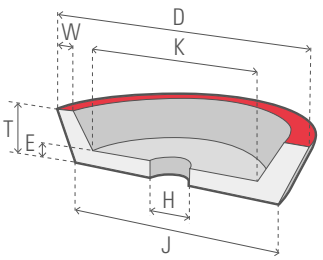
SHAPES AND DIMENSIONS					
Shape	D	T	H	W	E
T6	80	40	20	10	10
	100	50	20 - 32	10	10
	125	50	32	10	10
	150	50	32	10	16
	150	63	32	16	16
	200	40	76,2	40	13

SHAPE T6



SHAPES AND DIMENSIONS							
Shape	D	T	H	W	E	J	K
T11	80	32	20	8	10	57	46
	100	40	20 - 32	8	10	75	65
	125	45	32	8	10	96	78
	150	50	32	10	13	114	95

SHAPE T11



SPECIFICATIONS				
Material	Type	Specification	Use	Remarks
Steel	HSS Alloy steels	09A046K06V86	Roughing General use	
		09A060K06V86	Finishing General use	
		3HA060K07V114	General use Cool grinding without deformationi	
		11A080K06V92	General use	Only for wheels T6 - D100
		31A070J07V86	General use	Only for wheels T6 - D100
Hard metal	Tungsten carbide tools	08C060J08V01	Roughing	
		08C080J08V01	Finishing	

EXAMPLE OF ORDER

SHAPE	DIMENSIONS (mm)	NOTE	SPEED	SPECIFICATION
T6	100 x 50 x20	W=10 E=10	35 m/sec	31A070J07V86

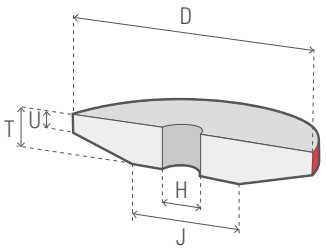
The coloured dot shows the actual colour of the wheel

Tapered and dish wheels for dry application

Peripheral speed 35 m/sec

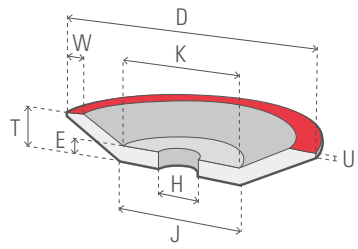
SHAPES AND DIMENSIONS					
Shape	D	T	H	U	J
T3	125	8	20 - 32	2	63
	150	8	20 - 32	2	75

SHAPE T3



SHAPES AND DIMENSIONS							
Shape	D	T	H	W	U	E	J=K
T12	80	10	13	4	2	6	31
	100	13	20	5	3	7	36
	125	14	20 - 32	6	3	7	61
	150	16	20 - 32	8	3	9	66
	200	19	32	10	3	12	90
	200	32	32	10	3	12	90

SHAPE T12

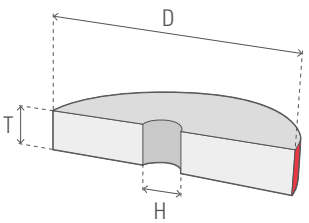


SPECIFICATIONS				
Material	Type	Specification		application
Steel	HSS and alloy steels	09A046K06V86		General use
		3HA060K07V114		General use
Hard metal	Carbide Tungsten carbide tools	08C060J08V01		General use

Grinding wheels for circular saw sharpening
Speed 35 and 60 m/sec

SHAPES AND DIMENSIONS			
Shape	D	T	H
T1	150	1,0 - 1,5 - 2 - 2,5 - 3 - 3,5 - 4 - 4,5 - 5 - 6	32
	175	2 - 3 - 4 - 6 - 8	51
	200	1,0 - 1,5 - 2 - 2,5 - 3 - 3,5 - 4 - 4,5 - 5 - 6 - 8 - 10	32
	250	6 - 8 - 10 - 13	32

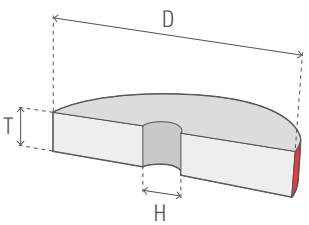
SHAPE T1



SPECIFICATIONS				
Material	Type	Specification		application
Circular saws	HSS and Stellite	11A080N05V86	●	For very narrow toothed saws wheel thickness ≤ 3,5 mm
		11A080M06V86	●	For medium toothed saws wheel thickness 4 ÷ 5mm
		11A054M06V86	●	For wide narrow toothed saws wheel thickness ≥ 6 mm
		09A080K08V20	○	General use high-speed grinding wheels

Grinding wheels for band saw sharpening
Peripheral speed 35 m/sec

SHAPE T1



T1-BD = SHAPE T1 WITH RESIN HARD SIDE

SHAPES AND DIMENSIONS			
Shape	D	T	H
T1	150	6 - 8 - 10	20 - 32
	200	6 - 8 - 10 - 13	32
	225	8 - 10 - 13	32
	250	8 - 10 - 13	32
	300	16 - 20	32

SPECIFICATIONS				
Material	Type	Specification		application
Band saws	High alloy steels HSS and Stellite	09A054M06V86	○	General use
		09A054L06V86 1 resin hardened edge	○	General use improved profile*
		11A054M06V86	●	General use good profile retention
		11A054L06V86 1 resin hardened edge	●	General use improved profile retention*

* Best for stellite saws

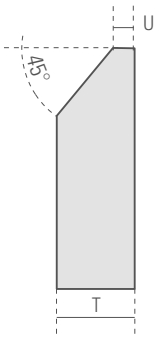
Profiled wheels for conventional band saw sharpening

Peripheral speed 35 m/sec

SHAPES AND DIMENSIONS			
Shape	D	T	H
T1-PR Profile C - 45°	150	6 - 8	20 - 32
	200	6 - 8- 10	20 - 32
	250	10 - 13	32

SPECIFICATIONS				
Material	Type	Specification		application
Conventional band saws	Medium-low hardness steel	15A060N05V12	●	General use
		09A054M06V86	○	General use Best removal
	High alloy steels HSS and Stellite	5SA080O07 BGW	●	For automatic machines type Vollmer and Iseli

SHAPE T1 PROFILE C - 45°



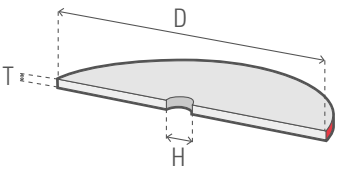
Thin wheels for circular saw sharpening

Speed 50 m/sec

SHAPES AND DIMENSIONS			
Shape	D	T	H
T1-PR	120	2	51
	150	1,5 - 2 - 3	20 - 32
	175	2 - 3	51
	200	1,5 - 2 - 3 - 4	32

SPECIFICATIONS				
Material	Type	Abrasive		application
Circular saws with narrow teeth	Hardened steel - HSS	17A060P05BA	●	General use
		09A054M06V86	○	General use quick removal

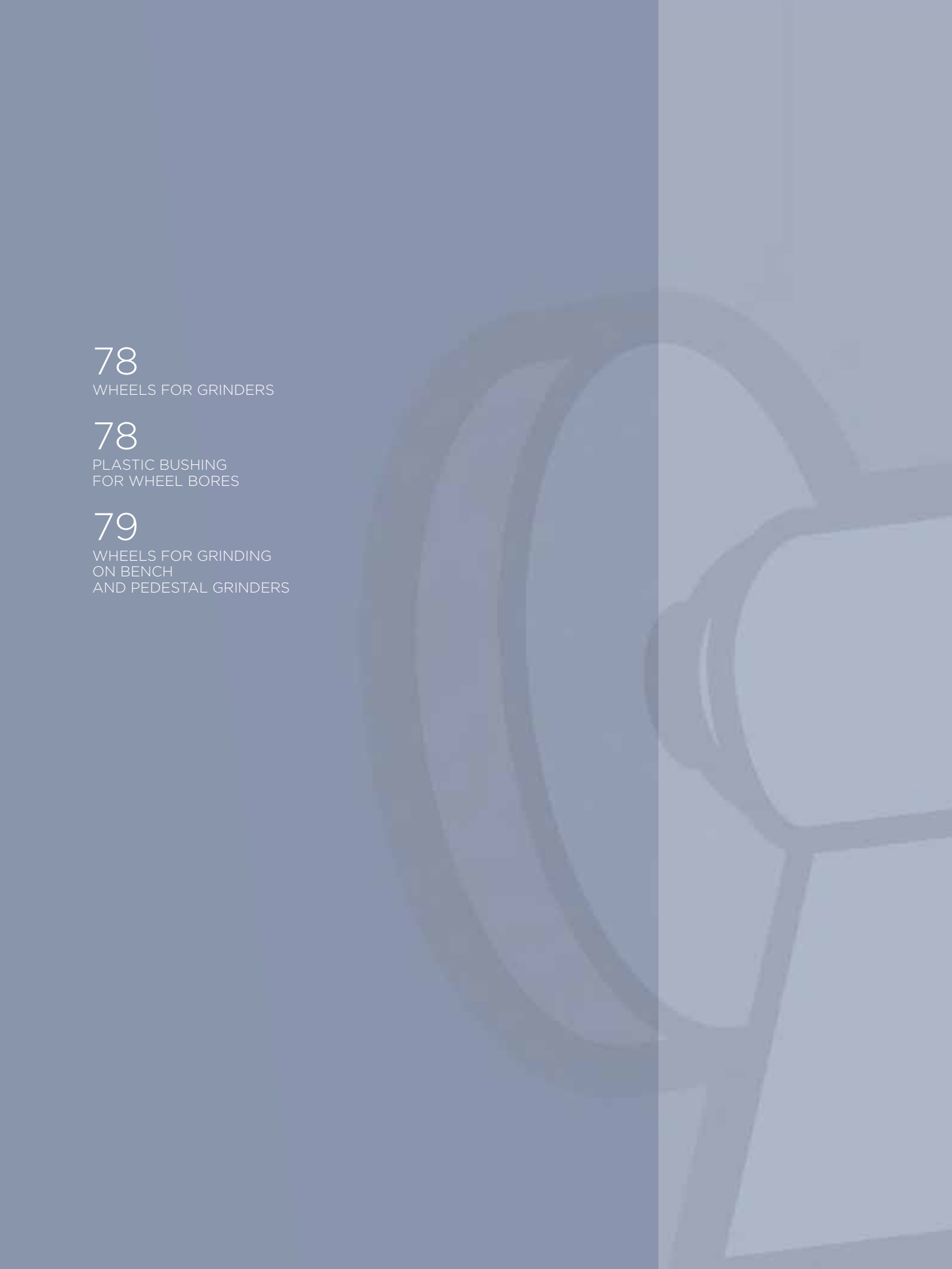
SHAPE T1



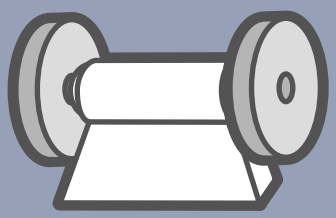
EXAMPLE OF ORDER

SHAPE	DIMENSIONS (mm)	NOTE	SPEED	SPECIFICATION	
T1 - PR	150 x 6 x 20	profile C-45°	35 m/sec	15A060N05V12	●

The coloured dot shows the actual colour of the wheel



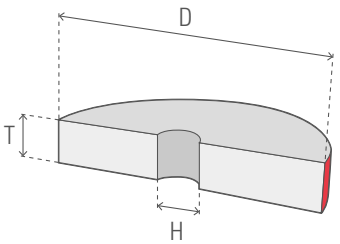
Bench wheels



Wheels for bench and pedestal grinders
Peripheral speed 35 m/sec

BENCH GRINDERS - SHAPES AND DIMENSIONS			
Shape	D	T	H
T1	125	16 - 20	13 - 20 - 32
	150	16 - 20 - 25	16 - 20 - 32
	178	20 - 25	20 - 32
	200	20 - 25 - 30	20 - 32 - 76,2
	250	25 - 30	25 - 32

SHAPE T1



PEDESTAL GRINDERS - SHAPES AND DIMENSIONS			
Shape	D	T	H
T1	300	32 - 40	32 - 127
	300	50	127 - 150
	350	40	32 - 127
	350	50	127 - 150
	400	40 - 50 - 63	40 - 127
	500	50 - 63	50 - 203,2

Plastic bushing for wheel bores

SHAPES AND DIMENSIONS		
Bore	Bushing	Thickness
16	13	6
20	13 - 16	6
25	13 - 16 - 20	6
30	20 - 25	6
31.75	12,7 - 13 - 15,87 - 16 - 20 - 25	6
32	10,05 - 12,75 - 13 -16 - 19 - 20 - 23 - 25	6
35	31.75	6
38	20- 32	6

EXAMPLE OF ORDER

SHAPE	DIMENSIONS (mm)	SPEED	SPECIFICATION	
T1	300 x 32 x 32	35 m/sec	00A036N05V86	●

The coloured dot shows the actual colour of the wheel

Wheels for bench and pedestal grinders

MILD, ANNEALED AND QUENCHED AND TEMPERED STEEL ≤ 35 HRC					
T1	Bench		T1	Pedestal	application
	00A 024 O05 V86			00A 024 O05 V86	Roughing
	00A 036 N05 V86			00A 036 N05 V86	Roughing
	00A 046 L06 V58			00A 046 L06 V58	Semifinitura
	00A 060 L06 V58			00A 060 L06 V58	Finitura

HARDENED AND CEMENTED ≤ 60 HRC					
T1	Bench		T1	Pedestal	application
	09A 046 K06 V86			09A 046 K06 V86	Roughing
	09A 060 K06 V86			09A 060 K06 V86	Finitura
	11A 046 K06 V86				Roughing
	11A 060 K06 V86				Finitura

HARD METAL					
T1	Bench		T1	Pedestal	application
	08C 060 J08 V01			08C 046 J08 V01	Roughing
	08C 080 J08 V01			08C 060 K07 V01	Sharpening
	08C 120 I08 V01				Chip breaker

GENERAL INFORMATION ABOUT DRESSING, DIAMOND TOOLS

DRESSING A GRINDING WHEEL

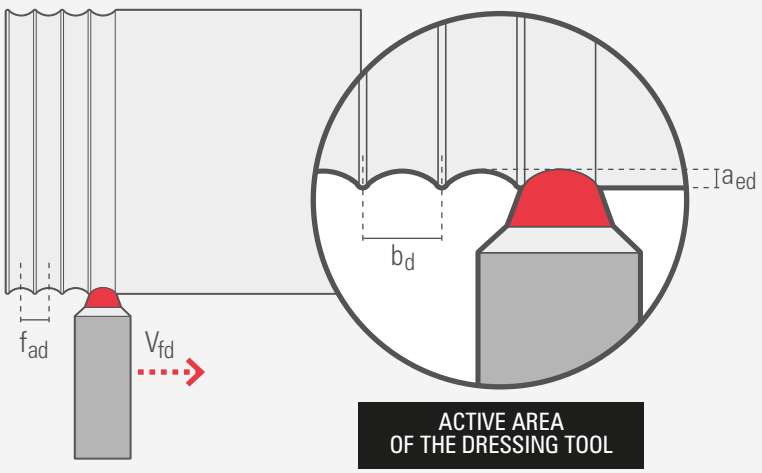
GENERAL CONSIDERATIONS

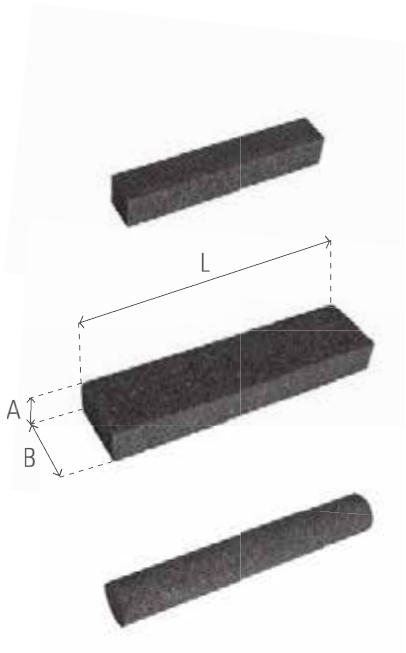
In all grinding operations a correct dressing is essential to obtain the maximum performance of the grinding wheel.
Dressing of conventional abrasive and microcrystalline Aluminium Oxide wheels is carried out using:

- single point diamond dressers
- manually mounted multi point blade type diamond dressers
- PBP type multi point impregnated diamond dressers
- chisel type MCD monocrystalline diamond dressers
- diamond rollers

GENERAL TIPS FOR DRESSING

The dressing operation must always be carried out in the presence of an abundant flow of coolant. To avoid thermal shocks on the diamond, direct the coolant to the dressing area before starting the operation.
The tool carrier must be free from vibrations. Limit the protrusion of the dresser to less than twice the diameter of the shank. Ensure the correct positioning and the correct 10-15° angle of single point diamonds.
Choose the shape and size of the tool based on the size and specification of the grinding wheel and the type of grinding. The carat weight of the diamond must never be less than the recommended value.
The diamond must always be well sharpened.
Single diamond tools have a more marked action on the abrasive grain and are therefore more suitable for profiled and roughing wheels.
Multiple diamond tools are preferable to single diamond tools for dressing grinding wheels with linear peripheral banding, since they are less susceptible to the risk of breakage and cheaper (at the same carat weight).





DRESSING STICKS - SHAPES AND DIMENSIONS

Shape	A	B	L	Specification
Square	15	15	150	04C020S05V55
	20	20	200	
	25	25	150-200	
	50	50	200	
Rectangular	13	25	150	
	25	50	200	
Round	15		100-150	04C020S05V55
	20		150-200	
	25		150-200	
	30		200	

TREBEL DRESSERS - SHAPES AND DIMENSIONS

Shape	D	T	H	Specification
T1	90	40	22,2	04C020S05V55

ALUMINIUM OXIDE DRESSING STICKS FOR DIAMOND WHEELS - SHAPES AND DIMENSIONS

Code	A	B	L	Specification	Grit
A1RTA13251001	13	25	100	9A120G8V86	120
A1RTA13251005	13	25	100	9A240J8V86	240
A1RTA25502001	25	50	100	9A120J7V86	120

RESIN-BONDED SILICON CARBIDE DRESSING STONES FOR DIAMOND WHEELS SHAPES AND DIMENSIONS

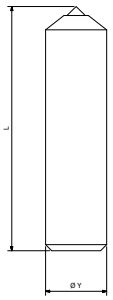
Code	A	B	L	Specification	Grit
A1RTA50252001	50	25	200	08C150G07B	150

Diamond dressers

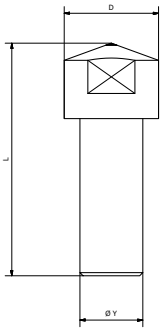
SINGLE POINT DRESSERS WITH CYLINDRICAL SHANK

	Code	Ø Y	L	diamond
		mm	mm	ct
STANDARD	U1SST050G10	10	40	0.5
STANDARD	U1SST100G10	10	40	1,0
STANDARD	U1SST150G10	10	40	1.5
STANDARD	U1SST200G10	10	40	2,0
STANDARD	U1SST250G10	10	40	2,5
STANDARD	U1SST300G10	10	40	3,0
HIG QUALITY	U4SST025G10	10	40	0.25
HIG QUALITY	U4SST050G10	10	40	0.5
HIG QUALITY	U4SST100G10	10	40 square head	1,0
HIG QUALITY	U4SST150G10	10	40 square head	1,5
HIG QUALITY	U4SST200G10	10	40 square head	2,0

Cylindrical Shank



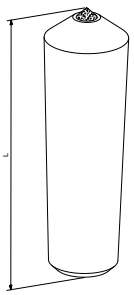
Square head



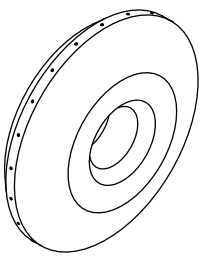
SINGLE POINT DRESSERS WITH MORSE TAPER 1 SHANK

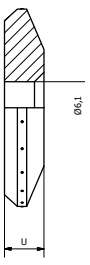
	Code	Ø Y	L	diamond
		gambo		ct
STANDARD	U1SST050CM1	CM1 x 40		0,5
STANDARD	U1SST100CM1	CM1 x 40		1,0
STANDARD	U1SST150CM1	CM1 x 40		1,5
STANDARD	U1SST200CM1	CM1 x 40		2,0
STANDARD	U1SST250CM1	CM1 x 40		2,5
HIG QUALITY	U4SST025CM1	CM1 x 40		0,25
HIG QUALITY	U4SST050CM1	CM1 x 40		0,5
HIG QUALITY	U4SST100CM1	CM1 x 40		1,0
HIG QUALITY	U4SST150CM1	CM1 x 40		1,5
HIG QUALITY	U4SST200CM1	CM1 x 40		2,0

Morse Taper 1



Circular rotary dresser





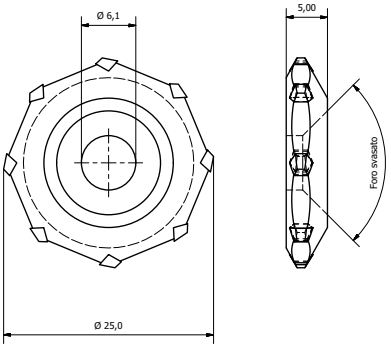
CIRCULAR ROTARY DRESSER

Code	Ø D	u	Bore	diamond ct	
U1MR04F20	20	9	6,1	2,0	STANDARD
U4MR04FD18	21	7	6,1	2,0	HIG QUALITY

Diamond dressers

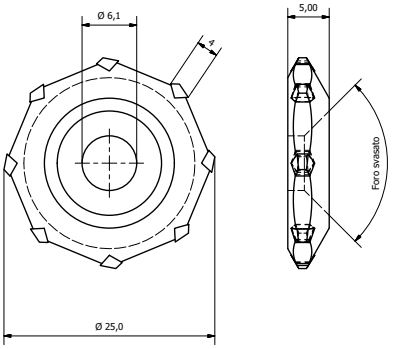
POINT ROTARY DRESSER V=25° (NATURAL STONES)					
Code	Ø D	u	N° points	Bore	
U4MR08PPN2	25	5	8	6,1	HIG QUALITY

8 point rotary dresser v=25°
(natural stones)



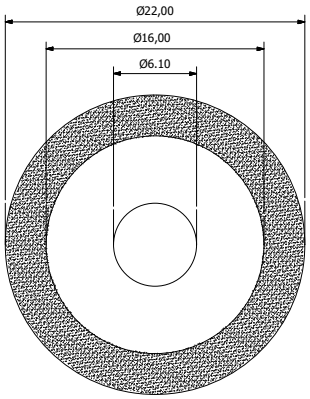
POINT ROTARY DRESSER V=25° (CVD)					
Code	Ø D	u	N° points	Bore	
U4MR08PCVD2	25	5	8	6,1	HIG QUALITY

8 point rotary dresser v=25°
(synthetic diamond)

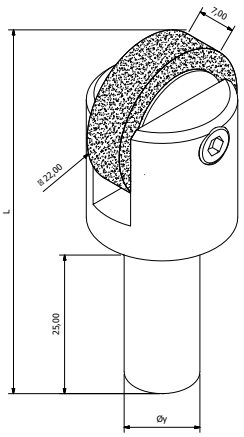


IMPREGNATED CIRCULAR ROTARY DRESSER						
Code	Ø D	u	x	H		Diamond grit
U4-14-ROL1	22	7	x	6,1		600/800 20/30MESH
ROTARY DRESSER WITH CYLINDRICAL SHANK						
Code	Ø D	u	x	Ø y	L	Diamond grit
U4-14-ROL1G10	22	7	3	10	48	600/800 20/30MESH
ROTARY DRESSER WITH MORSE TAPER 1 SHANK						
Code	Ø D	u	x			Diamond grit
U4-14-ROL1CM1	22	7	3	CM1 x 48		600/800 20/30MESH

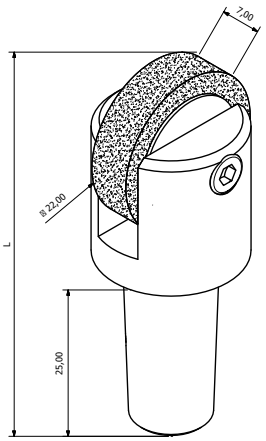
Impregnated circular rotary dresser



Rotary dresser with cylindrical shank



Rotary dresser with Morse taper 1 shank



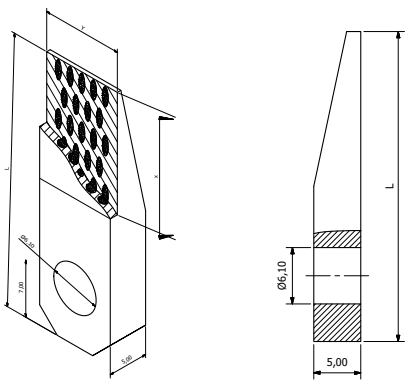
Diamond dressers

HANDSET BLADE DIAMOND DRESSERS

STANDARD

Code	y	x	L			Diamond Ct
U1MSC1015	10	15	33			1.5
U1MSC1020	10	15	33			2,0
U1MSC1025	10	15	33			2.5
U1MSC1030	10	15	33			3,0
U1MSC1515	15	15	33			1.5
U1MSC1520	15	15	33			2,0
U1MSC1525	15	15	33			2.5
U1MSC1530	15	15	33			3,0
U1MSC2015	20	15	33			1.5
U1MSC2020	20	15	33			2,0
U1MSC2025	20	15	33			2.5
U1MSC2030	20	15	33			3,0

Handset blade natural diamond dressers



SA HANDSET BLADE NATURAL DIAMOND DRESSERS

HIG QUALITY

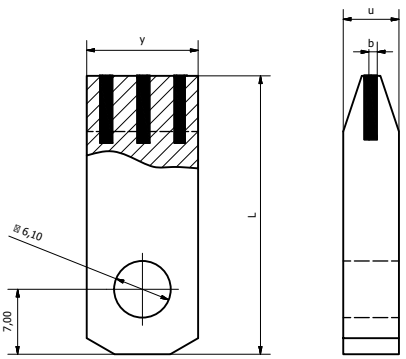
Code	Y	X	U	L	TIPO	Grit of conventio-nal wheel
U4MSC1020F	10	10	5	30	F	80 and higher
U4MSC1020M	10	10	5	30	M	60 - 80
U4MSC1020G	10	10	5	30	G	54 and lower
U4MSC1520F	15	15	5	30	F	80 and higher
U4MSC1520M	15	15	5	30	M	60 - 80
U4MSC1520G	15	15	5	30	G	54 and lower
U4MSC2020F	20	15	5	30	F	80 and higher
U4MSC2020M	20	15	5	30	M	60 - 80
U4MSC2020G	20	15	5	30	G	54 and lower

Blade dressers with CVD bar synthetic diamond

BLADE DRESSERS WITH CVD BAR SYNTHETIC DIAMOND

HIG QUALITY

Code	Y	X	U	L	B	Grit of conventio-nal wheel
U4MSC1006MDL	10	4	5	30	0,6	80 and higher
U4MSC1008MDL	10	4	5	30	0,8	60 and lower

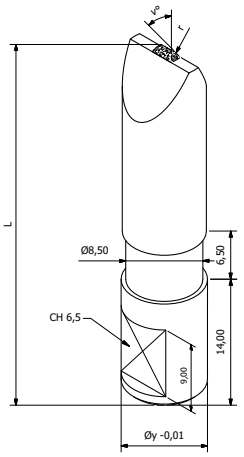


Diamond dressers

TOOLS FOR FORMING (DIAFORM)

				CYLINDRICAL SHANK		
	Code	V°	r	ø y	L	Type
STANDARD	U1D40R125	40°	0,125	9.52	45	Diaform
	U1D40R250	40°	0,250	9.52	45	Diaform
	U1D60R250	60°	0,250	9.52	45	Diaform
	U1D60R500	60°	0,500	9.52	45	Diaform
HIG QUALITY	U4D40R125	40°	0,125	9.52	45	Diaform
	U4D40R250	40°	0,250	9.52	45	Diaform
	U4D40R500	40°	0,500	9.52	45	Diaform
	U4D60R125	60°	0,125	9.52	45	Diaform
	U4D60R250	60°	0,250	9.52	45	Diaform
	U4D60R500	60°	0,500	9.52	45	Diaform

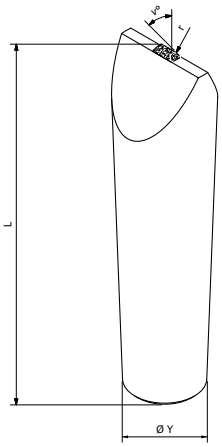
Diaform



CHISEL TOOLS

				CYLINDRICAL SHANK		
	Code	V°	r	ø y	L	Machine
HIG QUALITY	U4D40R125G850	40°	0,125	8	50	MORARA
	U4D40R250G850	40°	0,250	8	50	MORARA
	U4D40R500G850	40°	0,500	8	50	MORARA
	U4D60R125G850	60°	0,125	8	50	MORARA
	U4D60R250G850	60°	0,250	8	50	MORARA
	U4D60R500G850	60°	0,500	8	50	MORARA
	U4D40R125G1050	40°	0,125	10	50	TACCHELLA
	U4D40R250G1050	40°	0,250	10	50	TACCHELLA
	U4D40R500G1050	40°	0,500	10	50	TACCHELLA
	U4D60R125G1050	60°	0,125	10	50	TACCHELLA
	U4D60R250G1050	60°	0,250	10	50	TACCHELLA
	U4D60R500G1050	60°	0,500	10	50	TACCHELLA

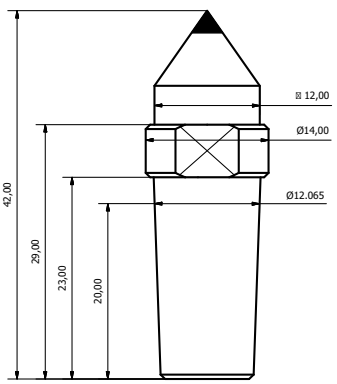
Chisel Cylindrical Shank



CHISEL TOOLS

	Code	V°	r	MORSE TAPER 1	Machine
HIG QUALITY	U4D40R125CM1	40°	0,125	CM1 x 23	STUDER
	U4D40R250CM1	40°	0,250	CM1 x 23	STUDER
	U4D40R500CM1	40°	0,500	CM1 x 23	STUDER
	U4D60R125CM1	60°	0,125	CM1 x 23	STUDER
	U4D60R250CM1	60°	0,250	CM1 x 23	STUDER
	U4D60R500CM1	60°	0,500	CM1 x 23	STUDER

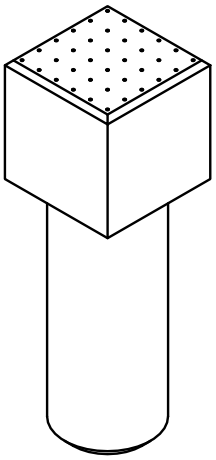
Chisel Morse taper 1

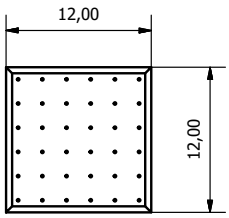


SQUARE HEAD DRESSERS (HANDSET)

	Code	Section		Grit wheel	CYLINDRICAL SHANK ø y	L	Diamond Ct
STANDARD	U1MTQ4S20G10	15	15		10	50	2,0
	U1MTQ4S25G10	15	15		10	50	2,5
	U1MTQ4S30G10	15	15		10	50	3,0
	U1MTQ4S50G10	15	15		10	50	5,0
HIG QUALITY	U4MTQ12Y46G1050	12	12	46	10	50	2,0
	U4MTQ12Y46G1250	12	12	46	12	50	2,0
	U4MTQ12Y60G1050	12	12	60	10	50	2,0
	U4MTQ12Y60G1250	12	12	60	12	50	2,0
	U4MTQ12Y80G1050	12	12	80	10	50	2,0
	U4MTQ12Y80G1250	12	12	80	12	50	2,0
	U4MTQ15Y4625G1050	15	15	46	10	50	2,5
	U4MTQ15Y4625G1250	15	15	46	12	50	2,5
	U4MTQ15Y6025G1050	15	15	60	10	50	2,5
	U4MTQ15Y6025G1250	15	15	60	12	50	2,5
	U4MTQ15Y8025G1050	15	15	80	10	50	2,5
	U4MTQ15Y8025G1250	15	15	80	12	50	2,5
	U4MTQ15Y4630G1050	15	15	46	10	50	3,0
	U4MTQ15Y4630G1250	15	15	46	12	50	3,0
	U4MTQ15Y6030G1050	15	15	60	10	50	3,0
	U4MTQ15Y6030G1250	15	15	60	12	50	3,0
	U4MTQ15Y8030G1050	15	15	80	10	50	3,0
	U4MTQ15Y8030G1250	15	15	80	12	50	3,0

Cylindrical shank



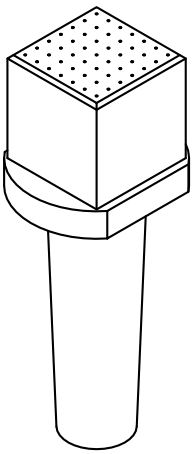


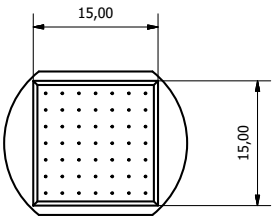
Diamond dressers

SQUARE HEAD DRESSERS (HANDSET)

	Code	Section		Grit wheel	MORSE TAPER 1	Diamond Ct
STANDARD	U1MTQ4S20CM1	15	15		CM1 x 50mm	2,0
	U1MTQ4S25CM1	15	15		CM1 x 50mm	2,5
	U1MTQ4S30CM1	15	15		CM1 x 50mm	3,0
	U1MTQ4S50CM1	15	15		CM1 x 50mm	5,0
HIG QUALITY	U4MTQ12Y46CM125	12	12	46	CM1 x 25mm	2,0
	U4MTQ12Y60CM125	12	12	60	CM1 x 25mm	2,0
	U4MTQ12Y80CM125	12	12	80	CM1 x 25mm	2,0
	U4MTQ12Y46CM1	12	12	46	CM1 x 50mm	2,0
	U4MTQ12Y60CM1	12	12	60	CM1 x 50mm	2,0
	U4MTQ12Y80CM1	12	12	80	CM1 x 50mm	2,0
	U4MTQ12Y46CM180	12	12	46	CM1 x 80mm	2,0
	U4MTQ12Y60CM180	12	12	60	CM1 x 80mm	2,0
	U4MTQ12Y80CM180	12	12	80	CM1 x 80mm	2,0
	U4MTQ1525Y46CM125	15	15	46	CM1 x 25mm	2,5
	U4MTQ1525Y60CM125	15	15	60	CM1 x 25mm	2,5
	U4MTQ1525Y80CM125	15	15	80	CM1 x 25mm	2,5
	U4MTQ1525Y46CM1	15	15	46	CM1 x 50mm	2,5
	U4MTQ1525Y60CM1	15	15	60	CM1 x 50mm	2,5
	U4MTQ1525Y80CM1	15	15	80	CM1 x 50mm	2,5
	U4MTQ1525Y46CM180	15	15	46	CM1 x 80mm	2,5
	U4MTQ1525Y60CM180	15	15	60	CM1 x 80mm	2,5
	U4MTQ1525Y80CM180	15	15	80	CM1 x 80mm	2,5
	U4MTQ1530Y46CM125	15	15	46	CM1 x 25mm	3,0
	U4MTQ1530Y60CM125	15	15	60	CM1 x 25mm	3,0
	U4MTQ1530Y80CM125	15	15	80	CM1 x 25mm	3,0
	U4MTQ1530Y46CM1	15	15	46	CM1 x 50mm	3,0
	U4MTQ1530Y60CM1	15	15	60	CM1 x 50mm	3,0
	U4MTQ1530Y80CM1	15	15	80	CM1 x 50mm	3,0
	U4MTQ1530Y46CM180	15	15	46	CM1 x 80mm	3,0
	U4MTQ1530Y60CM180	15	15	60	CM1 x 80mm	3,0
	U4MTQ1530Y80CM180	15	15	80	CM1 x 80mm	3,0

Morse taper 1





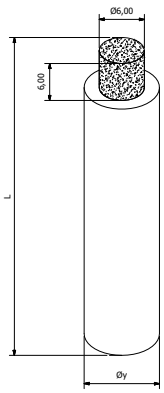
Diamond dressers

ROUND HEAD DRESSERS (CONCRETION)

			CYLINDRICAL SHANK				
Code	ø d	x	ø y	L	Shape	Grit Diamond	
U1820G10	10	10	10	40	PBP-8	600/800 20/30MESH	STANDARD
U4720G10	6	6	10	45	PBP7	600/800 20/30MESH	HIG QUALITY
U4820G10	10	10	10	48	PBP8	600/800 20/30MESH	
U48S20G10	10	10	10	48	PBP8S-15°	600/800 20/30MESH	

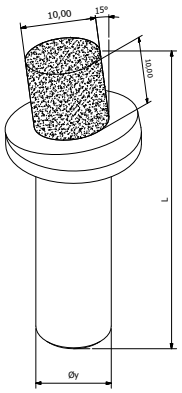
			MORSE TAPER 1			
Code	ø d	x		Shape	Grit Diamond	
U1820CM1	10	10	CM1 x 40	PBP-8	600/800 20/30MESH	STANDARD
U4720CM1	6	6	CM1 x 48	PBP7	600/800 20/30MESH	HIG QUALITY
U4820CM1	10	10	CM1 x 48	PBP8	600/800 20/30MESH	
U48S20CM1	10	10	CM1 x 48	PBP8S-15°	600/800 20/30MESH	

Cylindrical shank



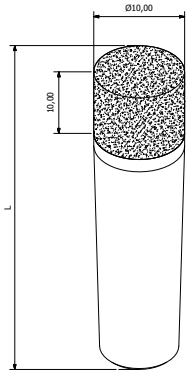
PBP7 - PBP8

Cylindrical shank 15°



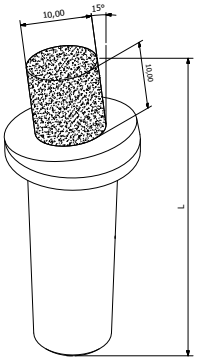
PBP8S-15°

Morse taper 1



PBP7 - PBP8

Morse taper 1 15°



PBP8S-15°

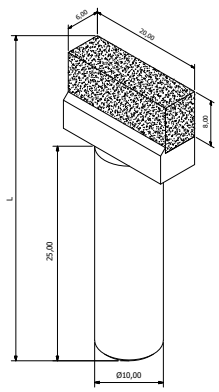
Diamond dressers

RECTANGULAR HEAD DRESSERS (CONCRETION)

			CYLINDRICAL SHANK				
Code	Section	x	ø y	L	Shape	Grit Diamond	
U4320G10	6 x 12	10	10	40	PBP3	600/800 20/30MESH	HIG QUALITY
U43S20G10	6 x 12	10	10	40	PBP3S-15°	600/800 20/30MESH	
U4120G10	6 x 20	10	10	40	PBP1	600/800 20/30MESH	
U41S20G10	6 x 20	10	10	40	PBP1S-15°	600/800 20/30MESH	

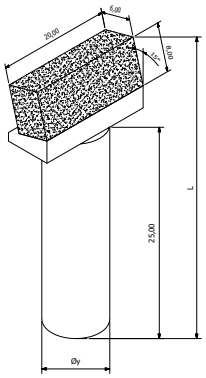
			MORSE TAPER 1				
Code	Section	x			V°	Grit Diamond	
U4320CM1	6 x 12	10	CM1 x 40		PBP3	600/800 20/30MESH	HIG QUALITY
U43S20CM1	6 x 12	10	CM1 x 40		PBP3S-15°	600/800 20/30MESH	
U4120CM1	6 x 20	10	CM1 x 40		PBP1	600/800 20/30MESH	
U41S20CM1	6 x 20	10	CM1 x 40		PBP1S-15°	600/800 20/30MESH	

Cylindrical shank



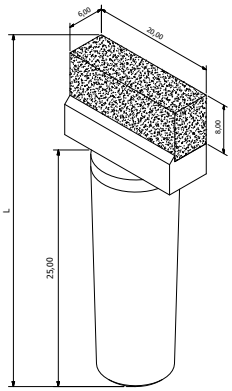
PBP1 - PBP3

Cylindrical shank 15°



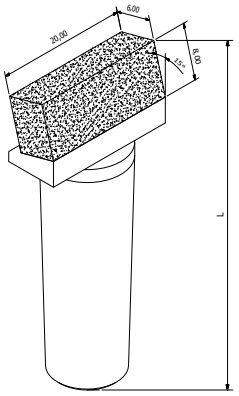
PBP1S-15° - PBP3S-15°

Morse taper 1



PBP1 - PBP3

Morse taper 1 15°



PBP1S-15° - PBP3S-15°

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