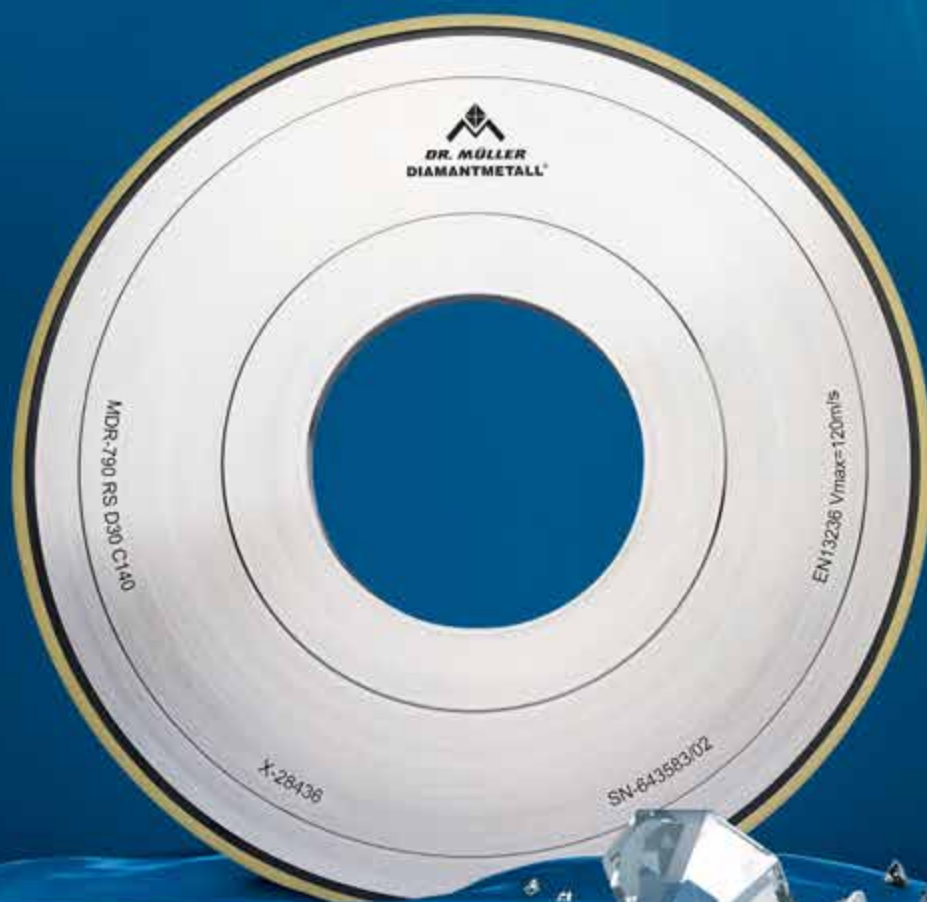




# INDIVIDUAL **PREMIUM**



GENERAL CATALOGUE  
**DIAMOND AND  
CBN TOOLS**



CHAIRMAN OF  
THE BOARD OF MANAGEMENT:  
Michael Schulze

CHAIRPERSON OF  
THE SUPERVISORY BOARD:  
Prof. Dr. Dr. Claudius Schikora

BANK DETAILS:  
Vereinigte Sparkassen Weilheim i. Ob.  
IBAN: DE37703510300009278888  
SWIFT/BIC: BYLADEM1WHM

BANK DETAILS:  
District court of Weilheim,  
Upper Bavaria

COMMERCIAL REGISTER:  
Munich, HRB 168843

VAT ID NO.: DE255272026  
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For **MAXIMUM EFFICIENCY**  
in the grinding process







DR. MÜLLER  
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# INDIVIDUAL PREMIUM

Tell us what grinding operation you are currently planning. We will advise you personally and develop the grinding wheel that meets your individual needs exactly. For the highest quality or reliable reproducibility. For productive processes, extended life and calculable investment security. For fascinating grinding performance and continuous optimisation – your requirements are our challenges.

MDT-532 ES D126

X-48167

EN13236 Vmax:80m/s

676368/01





## THE COMPANY **MANUFACTURING**

Dr. Müller Diamantmetall AG is located just a stone's throw from Starnberger See. It is a manufacturer like those in the Swiss watch making industry – precision in all respects.



### THE COMPANY

Dr. Müller Diamantmetall AG is a company with a remarkable tradition. Its founder, Dr. Wilhelm Müller, invented the metal-bonded diamond grinding wheel in 1935, laying the foundation stone for the company, and to the present day Dr. Müller Diamantmetall AG remains an owner-operated enterprise, with the third generation of the family in charge of its operations.

### KNOW-HOW

Thanks to the use of cutting-edge database technology, we are now able to draw on expert knowledge acquired over more than 80 years of diamond tool production. Our own R&D department develops innovative solutions to meet the most complex requirements, while countless innovations and patents highlight our creativity when it comes to developing ingenious technical solutions. This extensive competence in the development of solutions for all application areas guarantees added value from close cooperation with the customer – ensuring the added value that leads to outstanding customer products.

### QUALITY

We guarantee ultimate quality and precision for our customers. This professionalism is backed by a database-driven process error management system and DIN ISO 9001:2008 certification since the year 2000.

Thus, you are assured of end-to-end quality control, reproducible product quality and maximum efficiency in your grinding process.







# COMPANY HISTORY INNOVATION FOR MORE THAN 80 YEARS

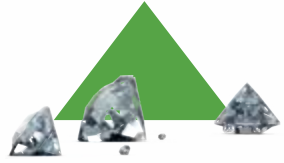
As an experienced solution partner, Dr. Müller Diamantmetall AG with its Individual Premium brand Dr. Müller Diamantmetall has been there for over 5,000 customers worldwide since more than 80 years.

- ▲ 2017  
Ferox – the multi-talent for circumference and face machining.
- ▲ 2014  
Progress in occupational safety. Drastic reduction of permanent grinding noise in peel grinding with the SilencePro product innovation.
- ▲ 2011  
Extension of digital production control and expansion of company management.
- ▲ 2008  
Relocation of production and administration to the new facilities of the third plant in Weilheim, Upper Bavaria.
- ▲ 2008  
The XT690 bonding concept makes the grinding process even more efficient and expands the portfolio with a new high-performance bond.
- ▲ 2006  
Acquisition and continuation of the company in the third generation by Michael Schulze, grandson of the company's founder.

- ▲ 2004  
Beginning of a new technical era through the development of the novel high-performance bonding concept PowerOne.
- ▲ 2002  
Expansion of production space with the construction of a second plant in Weilheim, Upper Bavaria.
- ▲ 1989  
Start of production of ceramic-bonded diamond and CBN grinding wheels.
- ▲ 1970  
Start of production and sales of diamond dressing rolls.
- ▲ 1969  
Start of production of resin- and metal bonded CBN grinding wheels.
- ▲ 1965  
Start of production of resin-bonded diamond grinding wheels.
- ▲ 1963  
Start of production of diamond dressing tools.
- ▲ 1962  
Continuation of the company by the second generation after the death of its founder.
- ▲ 1955  
Relocation to our own production facilities in Feldafing on the Starnberger See.
- ▲ 1947  
Resumption of production in the greater Munich area.
- ▲ 1944  
Destruction of the company in the war.
- ▲ 1935  
Founding of the company by Dr. Wilhelm Müller in Berlin. Patent registration and production of metal-bonded diamond grinding wheels.







# MAXIMUM EFFICIENCY

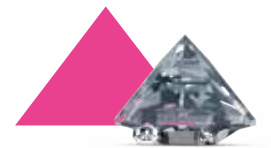
Tell us what technical project you are currently planning. We provide you with personal, competent advice. We develop the best solution for your grinding application – as individual as you wish. That guarantees maximum efficiency in your grinding process.







## INCREDIBLE DIVERSITY



More than 155,000 grinding wheel versions in the precision abrasives segment await you in our product portfolio. Our R&D department develops innovative solutions to meet the most complex requirements. We are your partner for completely new development with outstanding vertical integration, based on our knowledge of an incredible diversity of existing solutions.

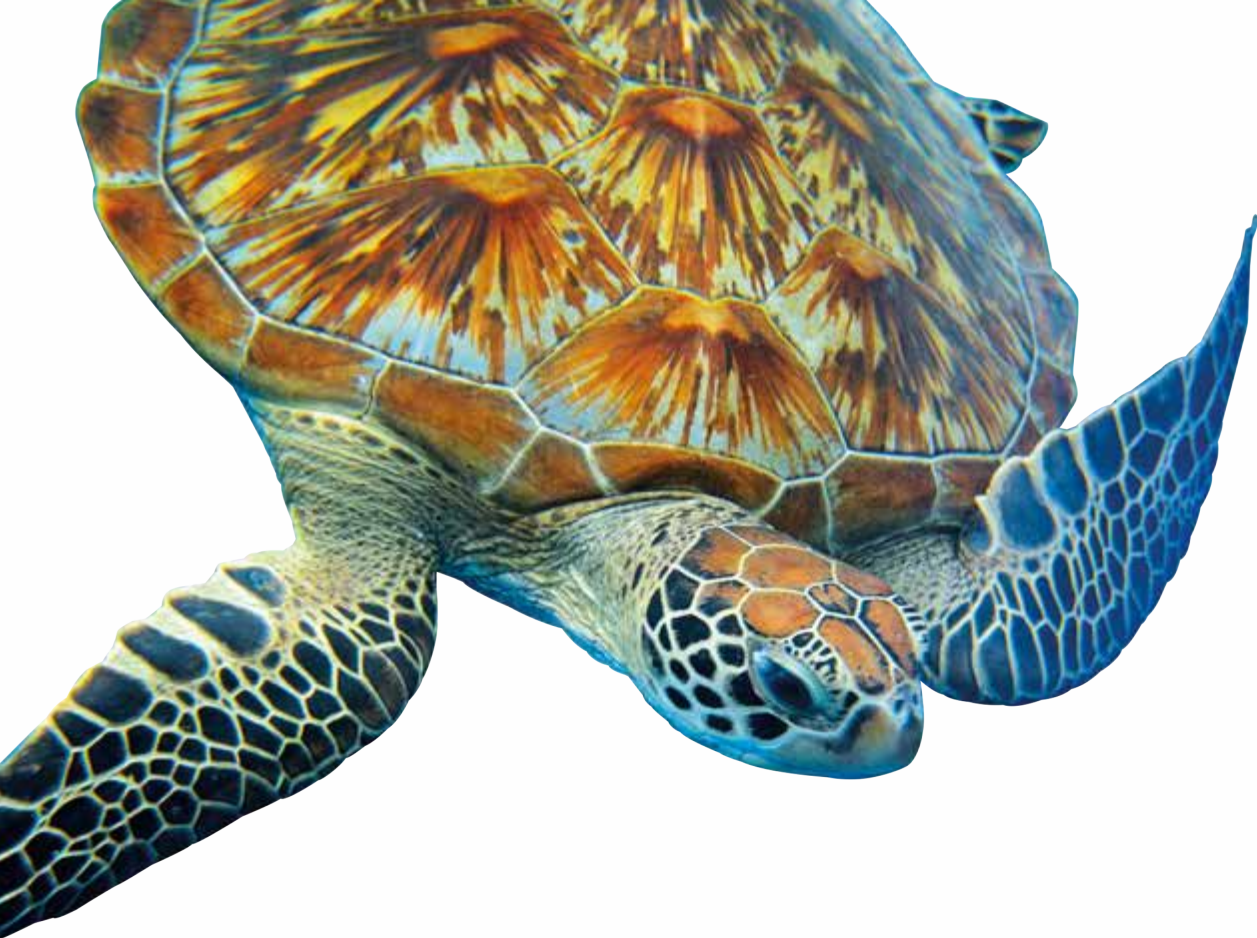


# EXTREMELY LONG LIFE

Our company is your partner for high-quality products with more than 80 years of experience in the production of CBN and diamond tools.







## REASSURING CONSISTENCY

As the inventor of the metal-bonded diamond grinding wheel, we have stood by the side of more than 5,000 customers worldwide since 1935. Reap the benefits of our technical solution creativity and our reliable, reproducible product quality for better performance and enhanced safety in your processes.







# PERSONAL CONSULTING INDIVIDUAL SERVICE



We are committed to facing the challenges of the future in close collaboration and at eye level with our customers.

Perhaps you would like to exchange ideas, technician to technician, leading up to new technical challenges. Maybe you want to pursue the continuous improvement of your grinding methods in operational practice as part of dedicated after-sales support, or you need to re-profile and re-sharpen your Dr. Müller Diamantmetall grinding tools. We are available directly on site when needed, getting you ahead with supplementary services.

## IMPLEMENTATION AND START-UP PHASE

In order to put your new grinding wheel from Dr. Müller Diamantmetall to use as quickly and easily as possible, one of our experienced application engineers will be happy to assist you in the implementation and start-up phase by request.

## AFTER-SALES SUPPORT

New processes require ongoing review. We consider after-sales support an important part of our work in order to guarantee the ongoing improvement of your processes.

## REPAIR MANAGEMENT

Trouble-free production without unoccupied time is the main goal of any production manager. We are happy to help you reach this goal with our competent repair service.

## EDUCATION AND USER TRAINING

Your employees have extensive knowledge of your existing processes. We design user education and training by customer request for specific, defined technical topics. The objective is to teach your employees about grinding-related topics and therefore enhance their knowledge.







# NEW REQUIREMENTS DAILY FOCUS INDUSTRIES

The continuous success of a technical solution provider at our level depends on the ability to consider the specific requirements of our customers in their various industries. We have always risen to this special challenge.



## TOOL INDUSTRY

- A grinding wheel optimised to meet your requirements guarantees process stability and high removal rates, even in particularly rough production environments.
- Outstanding results in terms of the material removal rate, ease of cutting and edge stability for all drilling, milling, turning and grinding needs.



## MECHANICAL ENGINEERING

- Your number one choice for special tools and standard products with the highest machining performance, dimensional accuracy, edge stability and profile accuracy.
- Comprehensive consulting for the design of individual CBN and diamond tools for process security in outer circular grinding, flat/slideway and ball bearing spindle grinding.



## AVIATION AND AEROSPACE

- Our custom-made solutions ensure you consistently get the optimum precision tool: even for materials with very high machining demands, such as Titanium, Hastelloy and Astelloy.
- New development of customer-specific products with a clear focus on maximum edge stability, reproducible quality, ease of cutting and machining accuracy.



## OPTICAL INDUSTRY

- Precision from A to Z ensures flawless surface finishes as well as reliability and reproducibility for all cutting, drilling and fine grinding applications.
- Industry-optimised solutions: scooping, complex combination and micro-tools, aspheric fine grinding and sapphire and quartz processing.



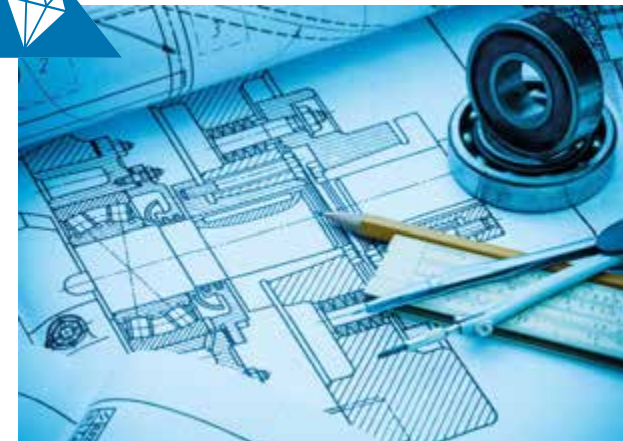
## AUTOMOTIVE

- Our flexible production, warehousing and shipping system ensures the fast and reliable delivery of your individual abrasives.
- Efficient precision tools with an extended life and long dressing intervals for grinding valves, camshafts and gear shafts, among other applications.



## GENERAL APPLICATIONS

- 155,000 grinding wheel versions: including the ideal solution for your increasingly complex grinding operations.
- More than 80 years of proven competency in developing solutions for all fields of application: added value through partnership and cooperation, added value through your outstanding end product.







# AT HOME IN BAVARIA AND ACTIVE AROUND THE WORLD MADE IN GERMANY

We are active in the following countries:

- Central, Northern,  
Eastern, Southern and  
Western Europe

- Turkey

- Israel

- Russian Federation

- India
- Sri Lanka

- Thailand

- Singapore

- Malaysia

- Hong Kong

- China

- Japan
- South Korea

- Canada

- USA

- Chile

- Mexico

- Brazil

- South Africa

## CONTENTS

Application overview	24
Diamond and CBN tools for general applications	26
Table of wheel shapes Diamond and CBN tools for the tool industry, mechanical engineering, general applications, automotive, aviation & aerospace	36
Diamond tools for the optical industry	62
Diamond and CBN tools for the woodworking and plastics industry	76
Accessories	80
General information	89

APPLICATION OVERVIEW
TABLE OF WHEEL SHAPES
TOOLS BY INDUSTRIES
OPTICAL INDUSTRY
WOODWORKING AND PLASTICS INDUSTRY
ACCESSORIES
GENERAL INFORMATION



# APPLICATION OVERVIEW

Applications	Type of tool with [page number]
Aspheric and free-form machining	12C9 [45], 1F1 [62]
Aspheric machining	KW [68], 1L1 [41], 4A9 [53], 1F1W [62]
Back off grinding	14A1 [48], 14V1 [51], 1A1 [36], 1V1 [42], 1V8 [42], 3A1 [51], 3V1 [52]
Bevel and edge	KW [68]
C-edge processing	1FF6Y [41]
Centreless through-feed grinding	1A1-CL-D [36]
Centring	14L1 [50], D [64], E [64], F [64], EZ3 [65], EZ3/A [65], EZ4 [65], EZ4/A [66], EZ5 [66], EZ5/A [66]
Chip surface (tooth-face grinding)	F100SG [76], F105SG [77], F145SG [77], F160SG [77]
Chip surface grinding	11V2W [43], 14F1 [49], 4A2 [52], 4A5 [53], 4BT9 [54], 4E9P [54], 4ET9 [55], 4V5 [56], 4Y9 [56], 12V5 [46], 12V4 [46], 12V2 [46], 14K9 [50]
Clearance angle grinding	12A2/45° [45], 12A2/60° [45], 12C9 [45], 6V5 [57], 9A3 [58]
Complete surface machining	KW [68]
Corner bevel grinding	11A2 [42], 11V2 [43], 11V9 [44], 11V9C [44], 6A2 [57], 6A2G [76], 6A9 [57]
Cutting	1A1R [37], 1A1R(S) [37]
Cylindrical grinding	12A2/20° [44], 12A2/45° [45], 12A2/60° [45], 4A2 [52]
Deburring	1A1W-PS(S) [60], 1A1W-PSU(S) [60], 1A1W-R(S) [61], 1A1W-S(S) [61], 1A1W-ZR(S) [61], RF [69]
Deburring of springs	1FF1W [41]
Diamond riffler	RF [69]
Dressing of ceramic-bonded corundum and silicon carbide grinding wheels	APMK [81], APN [83] oder APS [84], APN/Z [84] oder APS/Z [86]
Dressing of polishing tools	RF(S) [69]
Edging	14L1 [50], KW [68]
End face/lateral relief angle grinding	4A9 [53]
External and internal cylindrical grinding	14U1 [51], 14V1 [51], 1FF1 [40]
External and internal non-circular grinding	14A1 [48], 1V1 [42], 1V8 [42], 3A1 [51], 3V1 [52]
External cylindrical grinding	1C1 [38], 1L1 [41]
Face grinding	11A2 [42], 11V9 [44], 11V9C [44], 12A2/20° [44], 12A2/45° [45], 12A2/60° [45], 4A2 [52], 6A2 [57], 6A2G [76], 6A9 [57], 9A3 [58]
Face machining	C [63], CPP [58]
Flank grinding	F240SG [78], F240SG(1) [79], F240SG(2) [79], F240SG/A [79]

Applications	Type of tool with [page number]
Glass drilling	HB1 [67], HB2 [68]
Groove cutting	12V9 [47], 12V9/30° [47], 12V9C [47], 14A1 [48], 14F1 [49], 14L1 [50], 14V1 [51], 1A1 [36], 1C1 [38], 1DD1 [39], 1DU1 [39], 1F1 [62], 1F8 [40], 1FF1 [40], 1L1 [41], 1V1 [42], 1V8 [42], 3A1 [51], 3V1 [52], 4A9 [53]
Hob	4A5 [53]
Internal cylindrical grinding	1A1W-1 [59], 1A1W-1(S) [59], 1A1W-2 [59], 1A1W-2(S) [60], 1A1W-PS(S) [60], 1A1W-PSU(S) [60], 1A1W-R(S) [61], 1A1W-S(S) [61], 1A1W-ZR(S) [61], 1A8 [38], 1A8W-1 [38], 1F8 [40]
Lateral and radial grinding	11V5 [43]
Lateral clamping surface (Weldon, Whistle Notch)	1DD1 [39], 1DU1 [39]
Lateral/end face relief angle grinding	11A2 [42], 11V2 [43], 11V9C [44], 12V9 [47], 12V9/30° [47], 12V9C [47], 6A2 [57], 6A2G [76], 6A9 [57]
Lens bevelling	A [63], B [63], FK [67], FKE [67], 14A1 [48], 1A1 [36]
Peel grinding	14A1 [48], 1A1 [36], 3A1 [51], 3A1-SP [52]
Peripheral grinding	11A2 [42]
Plunge-cut grinding	1A1-CL-E [37]
Point thinning	12V9 [47], 14V1 [51], 1V1 [42], 3V1 [52], 4A9 [53], 12V9/30° [47], 12V9C [47]
Prismatic machining	PF/R [69], TF [74], TF/S [75]
Profile dressing	Dressing roll [58]
Profile grinding	12V9 [47], 12V9C [47], 14E1 [48], 14E9 [48], 14EE1 [49], 14F1 [49], 14FF1 [49], 14K1 [50], 14K9 [50], 14V1 [51], 1A1W-PS(S) [60], 1A1W-PSU(S) [60], 1A1W-R(S) [61], 1A1W-S(S) [61], 1A1W-ZR(S) [61], 1A8W-1 [38], 1E1 [39], 1EE1 [40], 1F1 [62], 1F8 [40], 4B4 [53], 4B9 [54], 4F5 [55], 4F9 [55], 4K9 [56]
Radial corner bevel	12V9 [47], 12V9/30° [47], 12V9C [47], 14V1 [51], 1V1 [42], 3V1 [52]
Radial grinding	12C9 [45], 12V5 [46], 6V5 [57]
Radius grinding	PF [68], SP [74], SR [74], RF [69]
Radius grooves	1FF1W [41]
Relief angle grinding	12V2 [46], 12V5 [46], 14K1 [50], 14K9 [50], 4A2 [52]
Sharpening, sharpening stick	whetstones [80]
Slotting	1A1R [37]
Surface grinding	1A1 [36], 1L1 [41], 3A1 [51]
Top grinding	F190SG [78], F190SG/A [78]
Wedge angle grinding	11A2 [42], 11V9 [44], 11V9C [44], 6A2 [57], 6A2G [76], 6A9 [57]



# TABLE OF WHEEL SHAPES

SHAPE	PAGE	FIGURE
<b>TABLE OF WHEEL SHAPES</b> Diamond and CBN tools for the tool industry, mechanical engineering, general applications, automotive, aviation & aerospace		
1A1	36	
1A1-CL-D	36	
1A1-CL-E	37	
1A1R	37	
1A1R(S)	37	

SHAPE	PAGE	FIGURE
1A8	38	
1A8W-1	38	
1C1	38	
1DD1	39	
1DU1	39	
1E1	39	

SHAPE	PAGE	FIGURE
1EE1	40	
1F8	40	
1FF1	40	
1FF1W	41	
1FF6Y	41	
1L1	41	
1V1	42	
1V8	42	
11A2	42	

SHAPE	PAGE	FIGURE
11V2	43	
11V2W	43	
11V5	43	
11V9	44	
11V9C	44	
12A2/20°	44	
12A2/45°	45	
12A2/60°	45	
12C9	45	



SHAPE	PAGE	FIGURE
12V2	46	
12V4	46	
12V5	46	
12V9	47	
12V9/30°	47	
12V9C	47	
14A1	48	
14E1	48	
14E9	48	

SHAPE	PAGE	FIGURE
14EE1	49	
14F1	49	
14FF1	49	
14K1	50	
14K9	50	
14L1	50	
14U1	51	
14V1	51	
3A1	51	

SHAPE	PAGE	FIGURE
3A1-SP	52	
3V1	52	
4A2	52	
4A5	53	
4A9	53	
4B4	53	
4B9	54	
4BT9	54	
4E9P	54	

SHAPE	PAGE	FIGURE
4ET9	55	
4F5	55	
4F9	55	
4K9	56	
4V5	56	
4Y9	56	
6A2	57	
6A9	57	
6V5	57	



SHAPE	PAGE	FIGURE
9A3	58	
CPP	58	
DRESSING ROLL	58	
1A1W-1	59	
1A1W-1(S)	59	
1A1W-2	59	
1A1W-2(S)	60	
1A1W-PS(S)	60	
1A1W-PSU(S)	60	

SHAPE	PAGE	FIGURE
1A1W-R(S)	61	
1A1W-S(S)	61	
1A1W-ZR(S)	61	
TABLE OF WHEEL SHAPES Diamond tools for the optical industry		
1F1	62	
1F1W	62	
A	63	

SHAPE	PAGE	FIGURE
B	63	
C	63	
D	64	
E	64	
F	64	
EZ3	65	
EZ3/A	65	
EZ4	65	

SHAPE	PAGE	FIGURE
EZ4/A	66	
EZ5	66	
EZ5/A	66	
FK	67	
FKE	67	
HB1	67	
HB2	68	



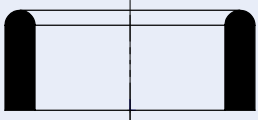
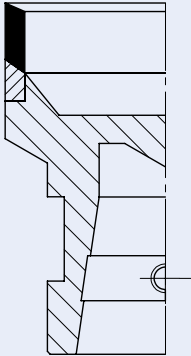
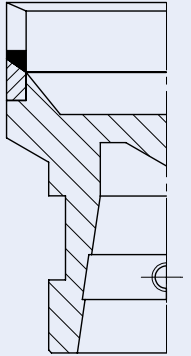
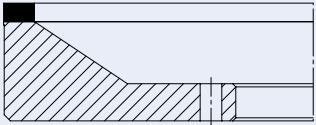
SHAPE	PAGE	FIGURE
KW	68	
PF	68	
PF/R	69	
RF	69	
RF(S)	69	

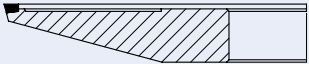
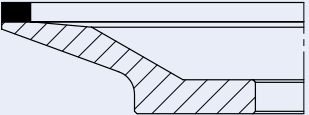
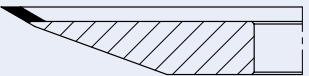

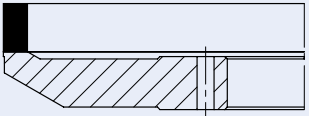
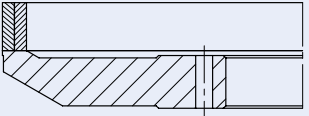

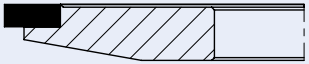

SHAPE	PAGE	FIGURE
MOUNTING for HD-12 SR	70	
MOUNTING for HD-25 SR	70	
MOUNTING for Z12 according to DIN	70	
MOUNTING for Z25 according to DIN	71	


SHAPE	PAGE	FIGURE
MOUNTING for Z40 according to DIN	71	
MOUNTING for Z6	71	
MOUNTING for SPM100	72	
MOUNTING for RF1-B	72	

SHAPE	PAGE	FIGURE
MOUNTING for RF1-C	72	
MOUNTING for AM+PZ	73	
MOUNTING for BM+PZ	73	
SP	74	



SHAPE	PAGE	FIGURE
SR	74	
TF	74	
TF/S with flushing slots	75	
TABLE OF WHEEL SHAPES Diamond and CBN tools for the woodworking and plastics industry		
6A2G	76	

SHAPE	PAGE	FIGURE
F100SG	76	
F105SG	77	
F145SG	77	
F160SG	77	
F190SG	78	
F190SG/A	78	
F240SG	78	
F240SG(1)	79	
F240SG(2)	79	

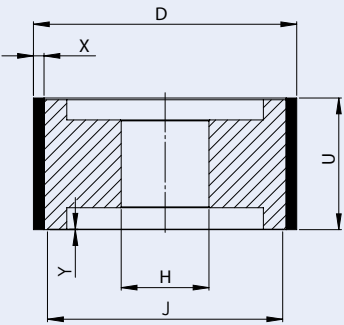
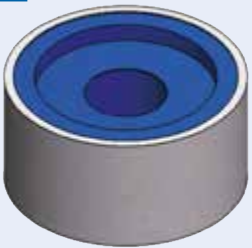
SHAPE	PAGE	FIGURE
F240SG/A	79	
TABLE OF WHEEL SHAPES Accessories		
WHETSTONES	80	
DRESSER	81	



# DIAMOND AND CBN TOOLS

Diamond and CBN tools for the tool industry, mechanical engineering, general applications, automotive, aviation & aerospace

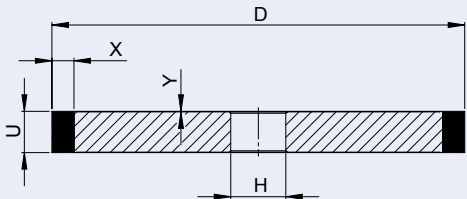
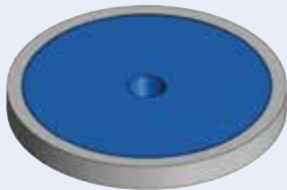
## 1A1-CL-E



SPECIFICATIONS	DIMENSIONS:	D 150-450mm; X 5-12mm								
	BONDS:	MDT (resin)								
	APPLICATIONS:	plunge-cut grinding								
SAMPLE ORDER	SHAPE	D	U	X	H	J	Y	BOND	GRIT	CONCENTRATION
	1A1-CL-E	400	100	6	304,8	0	0,2	MDT	D15	C50

Individual tool configuration on request

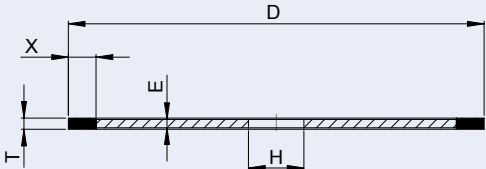
## 1A1



SPECIFICATIONS	DIMENSIONS: D 10-600mm (MDX up to max. D 400mm); U 4-100mm; X 2-30mm								
	BONDS: MDT (resin), MDX (metal), MDR (ceramic)								
	APPLICATIONS: external/internal non-circular grinding, peel grinding, surface grinding, groove cutting, back off grinding								
SAMPLE ORDER	SHAPE	D	U	X	H	Y	BOND	GRIT	CONCENTRATION
	1A1	300	20	3	127	0,2	MDT	D126	C75

Individual tool configuration on request

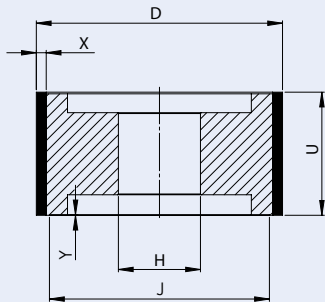
## 1A1R



SPECIFICATIONS	DIMENSIONS:		D 50-350mm; X 5-10mm; T 0,8-2,5mm						
	BONDS:		MDT (resin), MDX (metal)						
	APPLICATIONS:		cutting						
SAMPLE ORDER	SHAPE	D	X	T	H	E	BOND	GRIT	CONCENTRATION
	1A1R	150	7	1	20	0,8	MDT	D126	C100

Individual tool configuration on request

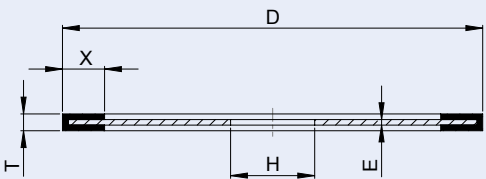
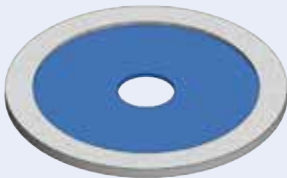
## 1A1-CL-D



SPECIFICATIONS	DIMENSIONS:	D 100 - 600mm; X 6-25mm								
	BONDS:	MDT (resin)								
	APPLICATIONS:	centreless through-feed grinding								
SAMPLE ORDER	SHAPE	D	U	X	H	J	Y	BOND	GRIT	CONCENTRATION
	1A1-CL-D	450	305	25	228,6	0	0,2	MDT	D91	C75

Individual tool configuration on request

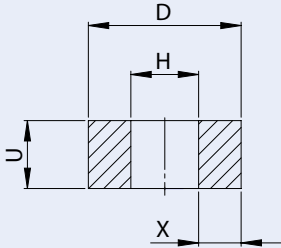
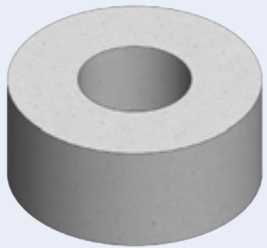
## 1A1R(S)



SPECIFICATIONS	DIMENSIONS:		D 125-400mm; X 5-10mm					
	BONDS:		MDS (electroplated bond)					
	APPLICATIONS:		cutting, slotting					
SAMPLE ORDER	SHAPE	D	X	T	H	E	BOND	GRIT
	1A1R(S)	150	2	0,8	20	0,7	MDS	D126

Individual tool configuration on request

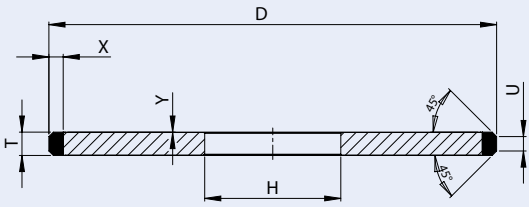
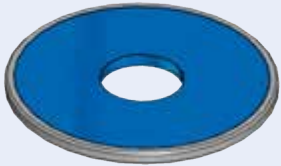
1A8



SPECIFICATIONS	DIMENSIONS: BONDS: APPLICATIONS:	D 25-80mm; U 3-90mm; X 1-35mm MDT (resin), MDX (metal), MDR (ceramic) groove cutting, internal cylindrical grinding						
SAMPLE ORDER	SHAPE	D	U	X	H	BOND	GRIT	CONCENTRATION
	1A8	40	20	10	20	MDT	D46	C100

Individual tool configuration on request

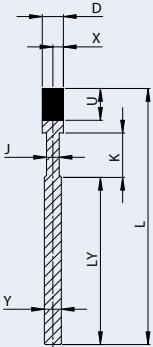
1DD1



SPECIFICATIONS	DIMENSIONS: BONDS: APPLICATIONS:	D 100-250mm; U 6-25mm; X 2-20mm MDT (resin), MDX (metal), MDS (electroplated bond) lateral clamping surface (Weldon, Whistle Notch), groove cutting								
SAMPLE ORDER	SHAPE	D	U	X	T	H	Y	BOND	GRIT	CONCENTRATION
	1DD1	250	8	5	13	76	0	MDT	D126	C100

Individual tool configuration on request

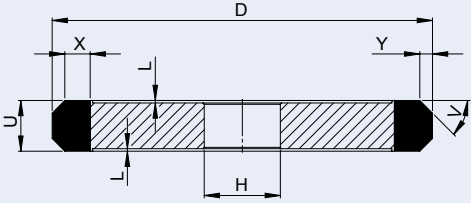
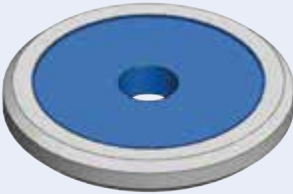
1A8W-1



SPECIFICATIONS	DIMENSIONS: BONDS: APPLICATIONS:	D 2-55mm; X 0,25-13mm; T 0,6-200mm MDT (resin), MDX (metal), MDR (ceramic) profile grinding, internal cylindrical grinding										
SAMPLE ORDER	SHAPE	U	Y	L	LY	J	K	D	X	BOND	GRIT	CONCENTRATION
	1A8W-1	6	6	60	40	5	10	50	5	MDT	D151	C75

Individual tool configuration on request

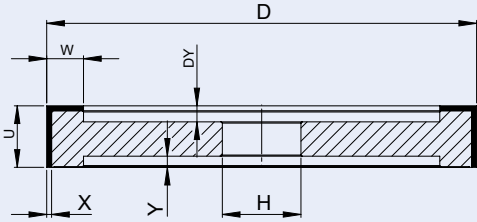
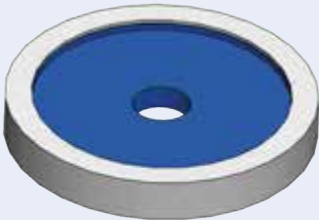
1DU1



SPECIFICATIONS	DIMENSIONS: BONDS: APPLICATIONS:	D 100-300mm; U 8-45mm; X 5-20mm MDT (resin), MDX (metal) groove cutting, lateral clamping flat (Weldon, Whistle Notch)									
SAMPLE ORDER	SHAPE	D	U	X	V	H	L	Y	BOND	GRIT	CONCENTRATION
	1DU1	100	20	2	45	30	0,2	0,5	MDT	D54	C100

Individual tool configuration on request

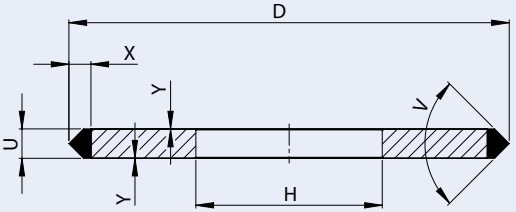

1C1



SPECIFICATIONS	DIMENSIONS: BONDS: APPLICATIONS:	D 75-300mm; W 10-20mm; U 10-25mm; X 2-10mm MDT (resin) external cylindrical grinding, groove cutting									
SAMPLE ORDER	SHAPE	D	U	W	X	H	Y	DY	BOND	GRIT	CONCENTRATION
	1C1	175	25	15	2	32	4,5	6,5	MDT	D181	C75

Individual tool configuration on request

1E1

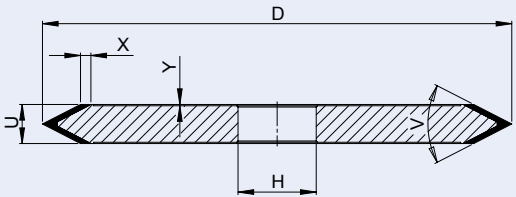
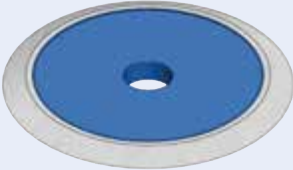


SPECIFICATIONS	DIMENSIONS: BONDS: APPLICATIONS:	D 50-300mm; U 5-30mm; X 4-20mm MDT (resin), MDX (metal), MDR (ceramic), MDS (electroplated bond) profile grinding									
SAMPLE ORDER	SHAPE	D	U	X	V	H	Y	BOND	GRIT	CONCENTRATION	
	1E1	300	20	15	90	127	0,2	MDT	D126	C85	

Individual tool configuration on request



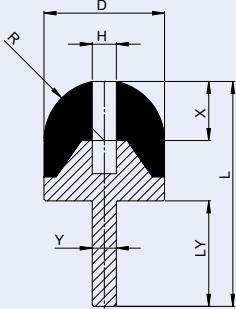

1EE1



SPECIFICATIONS	DIMENSIONS: D 25-450mm; U 2-40mm; X 1-15mm BONDS: MTD (resin), MDX (metal) APPLICATIONS: profile grinding									
SAMPLE ORDER	SHAPE	D	U	X	V	Y	H	BOND	GRIT	CONCENTRATION
	1EE1	75	6	4	90	0,2	20	MDT	B76	C100

Individual tool configuration on request

1FF1W



SPECIFICATIONS	DIMENSIONS: D 5-40; X 5-35; R 5-20 BONDS: MDX (metal) APPLICATIONS: deburring of springs, radius grooves										
SAMPLE ORDER	SHAPE	D	X	H	Y	L	LY	R	BOND	GRIT	CONCENTRATION
	1FF1W	40	20	8	8	75	35	20	MDX	B427	C50

Individual tool configuration on request

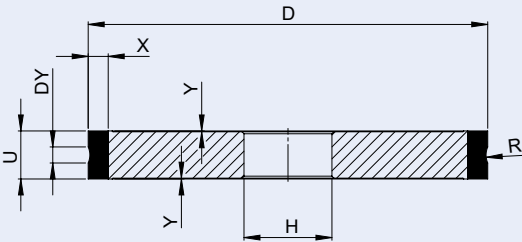
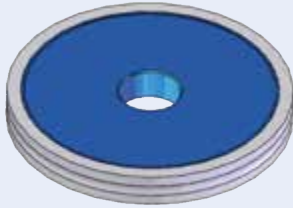
1F8



SPECIFICATIONS	DIMENSIONS: D 25-60mm; U 2-10mm; X 10-20mm BONDS: MDT (resin), MDX (metal) APPLICATIONS: groove cutting, internal cylindrical grinding, profile grinding									
SAMPLE ORDER	SHAPE	D	U	R	X	H	BOND	GRIT	CONCENTRATION	
	1F8	40	3,2	1,6	17	6	MDT	B126	C100	

Individual tool configuration on request

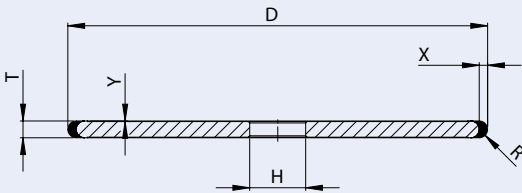
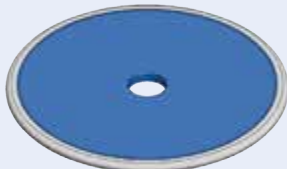
1FF6Y



SPECIFICATIONS	DIMENSIONS: D 50-200mm; U 5-20mm; X 5-10mm; R 2,5-14mm BONDS: MDS (electroplated bond), MDT (resin) APPLICATIONS: C-edge processing										
SAMPLE ORDER	SHAPE	D	U	X	H	Y	R	DY	BOND	GRIT	CONCENTRATION
	1FF6Y	100	12	5	22	0,2	5	4	MDX	D91	C50

Individual tool configuration on request

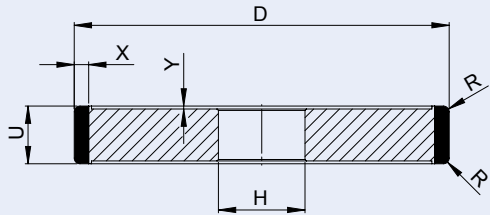
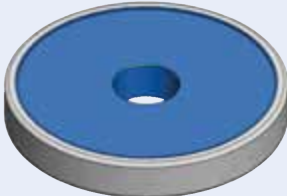
1FF1



SPECIFICATIONS	DIMENSIONS: D 25-300mm; X 1-10mm; T 6-35mm BONDS: MDT (resin), MDX (metal), MDR (ceramic) APPLICATIONS: groove cutting, external and internal cylindrical grinding, profile grinding									
SAMPLE ORDER	SHAPE	D	X	R	T	H	Y	BOND	GRIT	CONCENTRATION
	1FF1	125	4	R4	8	20	0,2	MDT	D126	C75

Individual tool configuration on request

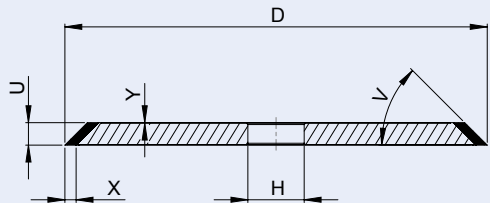
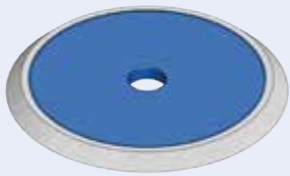
1L1



SPECIFICATIONS	DIMENSIONS: D 50-400mm; U 5-40mm; X 3-6mm BONDS: MDT (resin), MDX (metal) APPLICATIONS: surface grinding, groove cutting, aspheric machining, external cylindrical grinding									
SAMPLE ORDER	SHAPE	D	U	X	R	H	Y	BOND	GRIT	CONCENTRATION
	1L1	100	8	5	2	20	0,2	MDT	D64	C100

Individual tool configuration on request

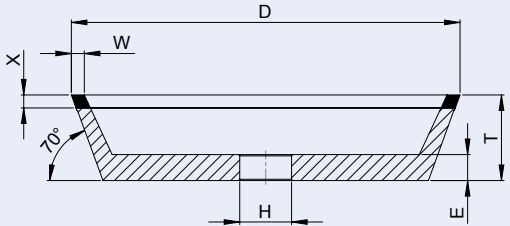
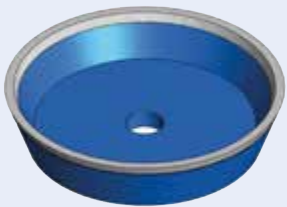
1V1



SPECIFICATIONS	DIMENSIONS:	D 40-500mm (MDX up to max. D 400mm); U 4-35mm; X 2-20mm								
	BONDS:	MDT (resin), MDX (metal)								
	APPLICATIONS:	external and internal non-circular grinding, groove cutting, back off grinding, point thinning, radial corner bevel, profile grinding								
SAMPLE ORDER	SHAPE	D	U	X	V	H	Y	BOND	GRIT	CONCENTRATION
	1V1	125	6	4	70°	20	0,2	MDT	D126	C75

Individual tool configuration on request

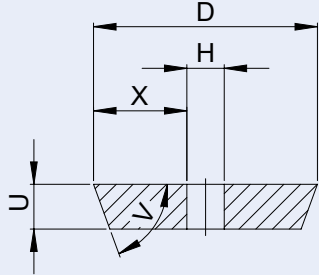
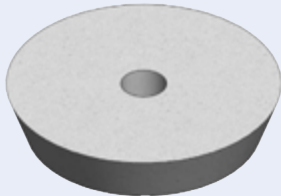
11V2



SPECIFICATIONS	DIMENSIONS:	D 15-250mm; W 1,5-18mm; X 1-10mm								
	BONDS:	MDT (resin), MDX (metal), MDR (ceramic)								
	APPLICATIONS:	lateral/end face grinding, corner bevel grinding, chip surface grinding								
SAMPLE ORDER	SHAPE	D	W	X	T	H	E	BOND	GRIT	CONCENTRATION
	11V2	75	4	3	33	20	10	MDT	D126	C75

Individual tool configuration on request

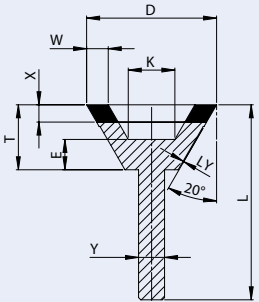

1V8



SPECIFICATIONS	DIMENSIONS:	D 30-75mm; U 3-10mm; X 5-15mm								
	BONDS:	MDT (resin), MDX (metal)								
	APPLICATIONS:	external and internal non-circular grinding, groove cutting, back off grinding								
SAMPLE ORDER	SHAPE	D	U	X	V	H	BOND	GRIT	CONCENTRATION	
	1V8	50	6	15	85	20	MDT	B126	C100	

Individual tool configuration on request

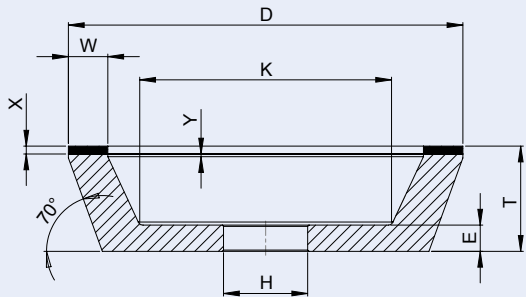
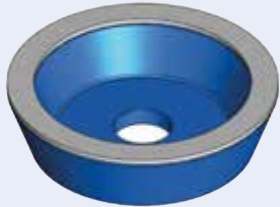
11V2W



SPECIFICATIONS	DIMENSIONS:	D 20-40mm ; W 2-5mm ; X 3-6 mm											
	BONDS:	MDT (resin), MDX (metal)											
	APPLICATIONS:	chip surface grinding											
SAMPLE ORDER	SHAPE	D	W	X	T	E	K	Y	L	LY	BOND	GRIT	CONCENTRATION
	11V2W	30	5	4	15	7	10,76	6	45	0,2	MDT	D91	C75

Individual tool configuration on request

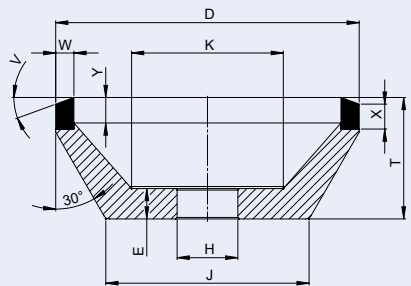
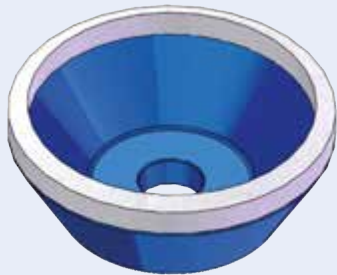
11A2



SPECIFICATIONS	DIMENSIONS:	D 30-400mm; W 5-30mm; X 2-15mm										
	BONDS:	MDT (resin), MDX (metal), MDR (ceramic)										
	APPLICATIONS:	lateral/end face grinding, corner bevel grinding, face grinding, wedge angle grinding, peripheral grinding										
SAMPLE ORDER	SHAPE	D	W	X	T	H	E	K	Y	BOND	GRIT	CONCENTRATION
	11A2	125	12,5	4	27	20	10	89	1	MDT	D64	C50

Individual tool configuration on request

11V5

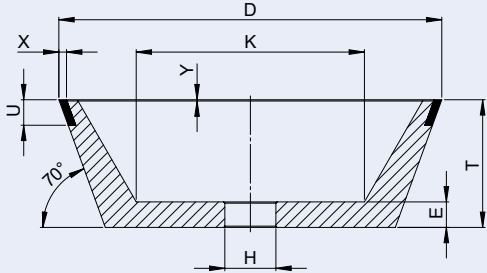
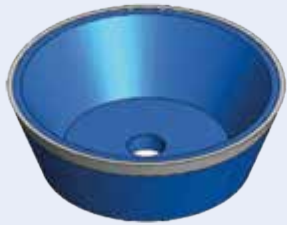


SPECIFICATIONS	DIMENSIONS:	D 50-300mm; W 3-12 mm; X 3-8												
	BONDS:	MDT (resin)												
	APPLICATIONS:	clearance angle, lateral and radial grinding												
SAMPLE ORDER	SHAPE	D	W	X	V	T	H	E	K	J	Y	BOND	GRIT	CONCENTRATION
	11V5	100	6	8	20	40	20	10	50	66,98	8,4	MDT	D46	C100

Individual tool configuration on request



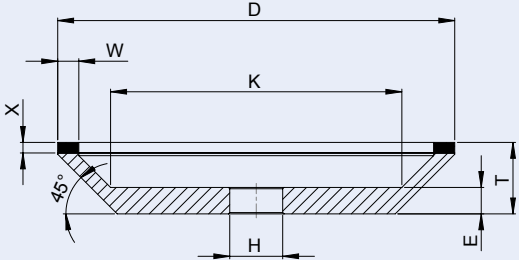
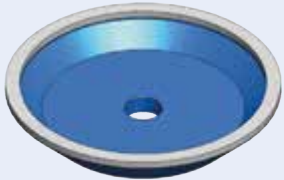
11V9



SPECIFICATIONS	DIMENSIONS:	D 40-200mm; U 6-20mm; X 1,5-10mm										
	BONDS:	MDT (resin), MDX (metal), MDR (ceramic)										
	APPLICATIONS:	lateral/end face grinding, corner bevel grinding, face grinding, wedge angle grinding										
SAMPLE ORDER	SHAPE	D	U	X	T	H	E	K	Y	BOND	GRIT	CONCENTRATION
	11V9	125	10	3	40	20	10	76	1	MDT	D64	C75

Individual tool configuration on request

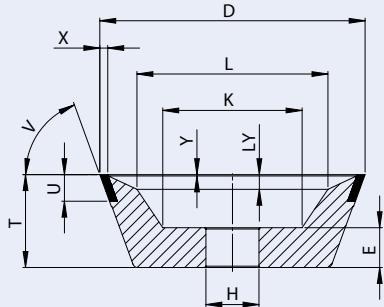
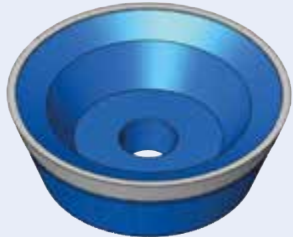
12A2/45°



SPECIFICATIONS	DIMENSIONS:	D 50-400mm; W 5-30mm; X 2-15mm									
	BONDS:	MDT (resin), MDX (metal), MDR (ceramic)									
	APPLICATIONS:	clearance angle grinding, cylindrical grinding, face grinding									
SAMPLE ORDER	SHAPE	D	W	X	T	H	E	K	BOND	GRIT	CONCENTRATION
	12A2/45°	125	10	2	25	20	10	79	MDT	D126	C75

Individual tool configuration on request

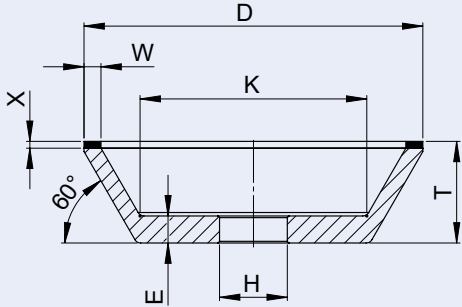

11V9C



SPECIFICATIONS	DIMENSIONS:	D 50-150mm; U 10mm; X 2-5mm										
	BONDS:	MDT (resin), MDX (metal)										
	APPLICATIONS:	lateral/end face grinding, corner bevel grinding, face grinding, wedge angle grinding										
SAMPLE ORDER	SHAPE	D	U	X	H	T	E	K	V	BOND	GRIT	CONCENTRATION
	11V9C	100	10	3	20	35	15	52	75°	MDT	D46	C100

Individual tool configuration on request

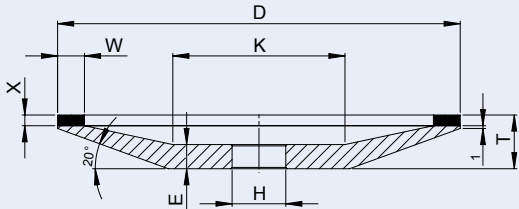
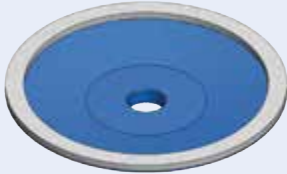
12A2/60°



SPECIFICATIONS	DIMENSIONS:	D 50-300mm; W 5-20mm; X 2-15mm									
	BONDS:	MDT (resin), MDX (metal), MDR (ceramic)									
	APPLICATIONS:	clearance angle grinding, cylindrical grinding, face grinding									
SAMPLE ORDER	SHAPE	D	W	X	T	H	E	K	BOND	GRIT	CONCENTRATION
	12A2/60°	100	5	2	30	20	8	66,91	MDT	D20	C50

Individual tool configuration on request

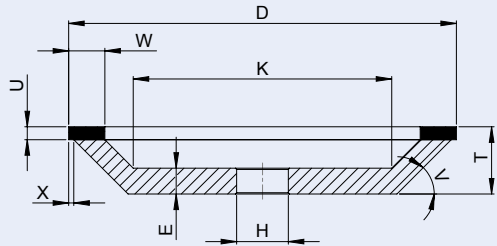
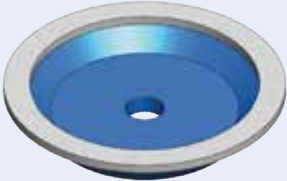
12A2/20°



SPECIFICATIONS	DIMENSIONS:	D 50-300mm; W 2-20mm; X 1-10mm									
	BONDS:	MDT (resin), MDX (metal), MDR (ceramic)									
	APPLICATIONS:	clearance angle grinding, cylindrical grinding, face grinding									
SAMPLE ORDER	SHAPE	D	W	X	T	H	E	K	BOND	GRIT	CONCENTRATION
	12A2/20°	200	6	2	22	32	11	99	MDT	D64	C75

Individual tool configuration on request

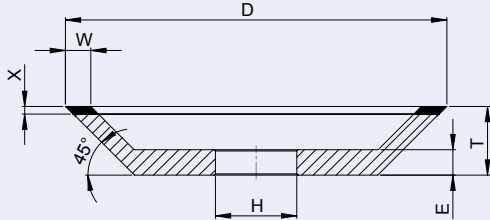
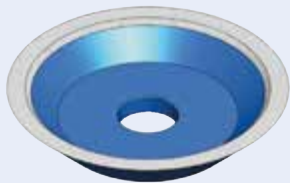
12C9



SPECIFICATIONS	DIMENSIONS:	D 40-250mm; W 4-20mm; U 3-22mm; X 2-5mm											
	BONDS:	MDT (resin), MDX (metal), MDR (ceramic)											
	APPLICATIONS:	aspheric and free-form machining, clearance angle grinding, radial grinding											
SAMPLE ORDER	SHAPE	D	W	U	X	V	H	K	T	E	BOND	GRIT	CONCENTRATION
	12C9	125	10	4	2	45°	20	81	26	10	MDT	D91	C75

Individual tool configuration on request

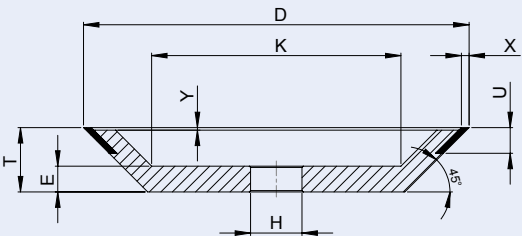
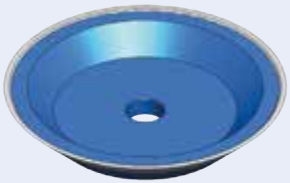
12V2



SPECIFICATIONS	DIMENSIONS: D 30-250mm; W 3-25mm; X 2-10mm									
	BONDS: MDT (resin), MDX (metal), MDR (ceramic)									
	APPLICATIONS: chip surface grinding, relief angle grinding									
SAMPLE ORDER	SHAPE	D	W	X	T	H	E	BOND	GRIT	CONCENTRATION
	12V2	100	7	2	26	20	10	MDT	D46	C75

Individual tool configuration on request

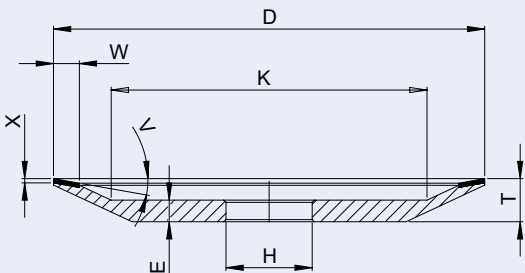
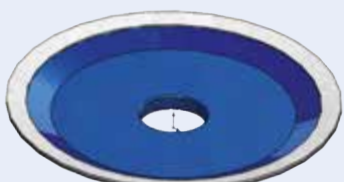
12V9



SPECIFICATIONS	DIMENSIONS: D 25-400mm; U 6-15mm; X 1-10mm											
	BONDS: MDT (resin), MDX (metal), MDR (ceramic)											
	APPLICATIONS: point thinning, lateral/end face relief angle grinding, groove cutting, radial corner bevel, profile grinding											
SAMPLE ORDER	SHAPE	D	U	X	T	H	E	K	Y	BOND	GRIT	CONCENTRATION
	12V9	100	10	2	20	20	10	62	1	MDT	D64	C75

Individual tool configuration on request

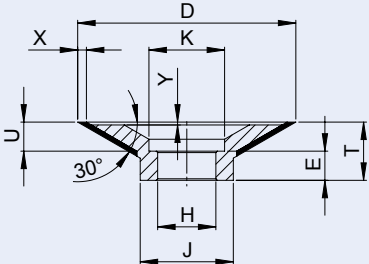
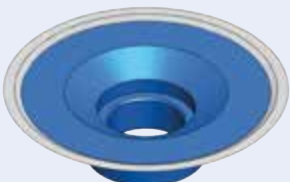
12V4



SPECIFICATIONS	DIMENSIONS: D 75-350mm; W 5-10mm; X 1-3mm											
	BONDS: MDT (resin)											
	APPLICATIONS: chip surface grinding											
SAMPLE ORDER	SHAPE	D	W	X	V	T	H	E	K	BOND	GRIT	CONCENTRATION
	12V4	100	6	1	10	10	20	5	73,24	MDT	D54	C75

Individual tool configuration on request

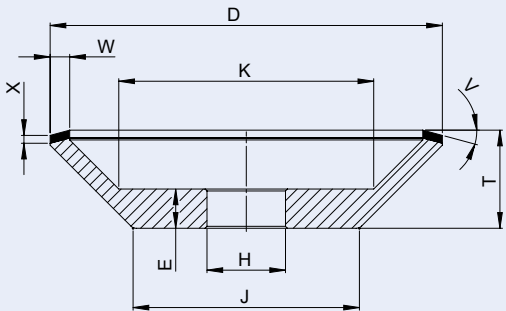
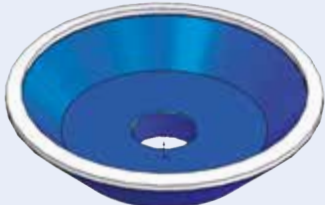
12V9/30°



SPECIFICATIONS	DIMENSIONS: D 75-250mm; U 6-10mm; X 2-3mm												
	BONDS: MDT (resin), MDX (metal)												
	APPLICATIONS: point thinning, lateral/end face relief angle grinding, groove cutting, radial corner bevel, profile grinding												
SAMPLE ORDER	SHAPE	D	U	X	E	K	Y	T	H	J	BOND	GRIT	CONCENTRATION
	12V9/30°	100	10	3	10	44	1	20	20	40	MDT	D107	C75

Individual tool configuration on request

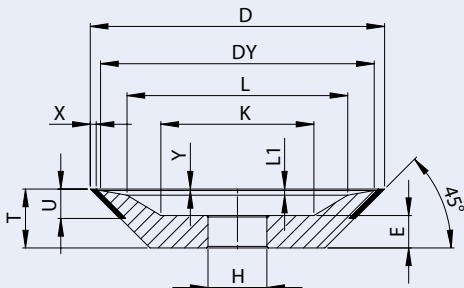
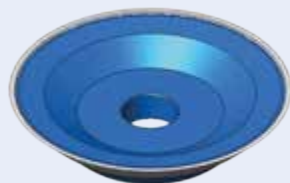
12V5



SPECIFICATIONS	DIMENSIONS: D 100-300mm; W 5-20mm; X 3-10mm												
	BONDS: MDT (resin), MDX (metal), MDR (ceramic)												
	APPLICATIONS: chip surface grinding, relief angle grinding, radial grinding												
SAMPLE ORDER	SHAPE	D	W	X	V	T	H	E	K	J	BOND	GRIT	CONCENTRATION
	12V5	100	5	2	15	25	20	10	65	57,68	MDT	D91	C100

Individual tool configuration on request

12V9C

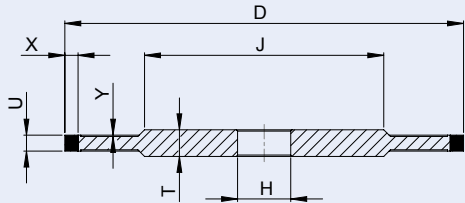
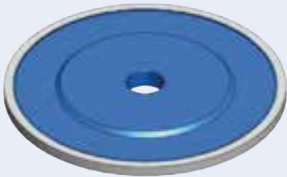


SPECIFICATIONS	DIMENSIONS: D 75-150mm; U 10-15mm; X 2-3mm														
	BONDS: MDT (resin), MDX (metal)														
	APPLICATIONS: point thinning, lateral/end face relief angle grinding, groove cutting, radial corner bevel, profile grinding														
SAMPLE ORDER	SHAPE	D	U	X	H	Y	DY	T	E	K	L	LY	BOND	GRIT	CONCENTRATION
	12V9C	100	10	3	20	0,5	93	20	11	48	71	2	MDT	D46	C100

Individual tool configuration on request



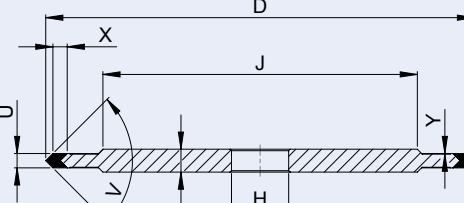

14A1



SPECIFICATIONS	DIMENSIONS:	D 10-600mm (MDX up to max. D 400mm); U 0,6-35mm; X 2-20mm									
	BONDS:	MDT (resin), MDX (metal), MDR (ceramic)									
	APPLICATIONS:	external and internal non-circular grinding, peel grinding, surface grinding, groove cutting, back off grinding									
SAMPLE ORDER	SHAPE	D	U	X	T	H	J	Y	BOND	GRIT	CONCENTRATION
	14A1	300	10	4	15	127	250	0,2	MDT	D126	C75

Individual tool configuration on request

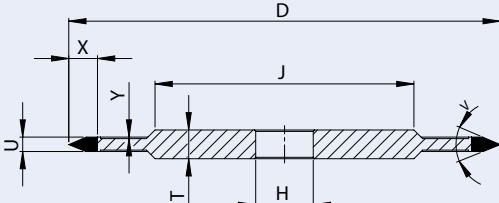
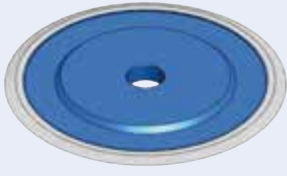
14EE1



SPECIFICATIONS	DIMENSIONS:	D 25-450mm (MDX up to max. D 400mm); U 2-40mm; X 1-15mm										
	BONDS:	MDT (resin), MDX (metal)										
	APPLICATIONS:	profile grinding										
SAMPLE ORDER	SHAPE	D	U	X	V	T	H	J	Y	BOND	GRIT	CONCENTRATION
	14EE1	150	3	2	60°	6	30	120	0,2	MDX	D126	C150

Individual tool configuration on request

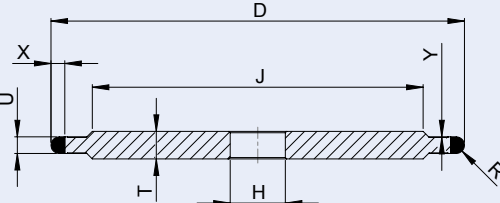
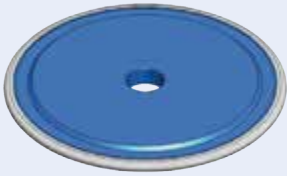
14E1



SPECIFICATIONS	DIMENSIONS:	D 100-400mm; U 3-26mm; X 3-20mm										
	BONDS:	MDT (resin), MDX (metal), MDR (ceramic)										
	APPLICATIONS:	profile grinding										
SAMPLE ORDER	SHAPE	D	U	X	V	T	H	J	Y	BOND	GRIT	CONCENTRATION
	14E1	100	5	5	80	8	20	58	0,2	MDT	D54	C150

Individual tool configuration on request

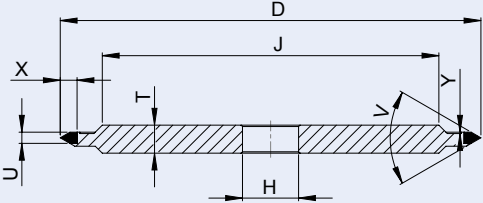
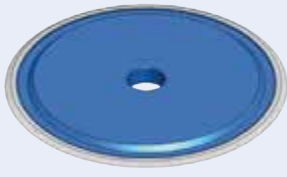
14F1



SPECIFICATIONS	DIMENSIONS:	D 20-500mm (MDX up to max. D 400mm); U 0,6-30mm; X 2-20mm										
	BONDS:	MDT (resin), MDX (metal), MDR (ceramic)										
	APPLICATIONS:	groove cutting, profile grinding, chip surface grinding										
SAMPLE ORDER	SHAPE	D	U	X	R	T	H	J	Y	BOND	GRIT	CONCENTRATION
	14F1	100	2	3	R1	6	20	70	0,2	MDT	D91	C100

Individual tool configuration on request

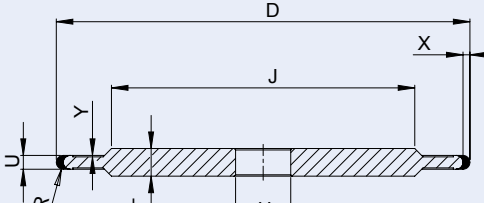
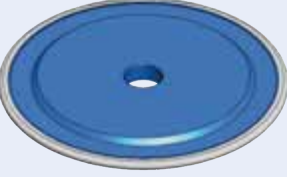
14E9



SPECIFICATIONS	DIMENSIONS:	D 35-350mm; U 0,8-5mm; X 5-10mm										
	BONDS:	MDT (resin), MDX (metal)										
	APPLICATIONS:	profile grinding										
SAMPLE ORDER	SHAPE	D	U	X	V	T	H	J	Y	BOND	GRIT	CONCENTRATION
	14E9	75	3	6	60°	7	20	45	0,2	MDX	D91	C125

Individual tool configuration on request

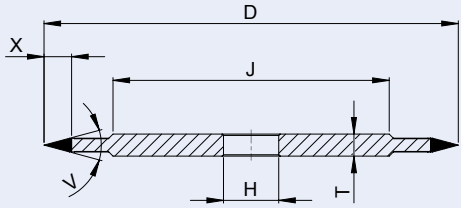
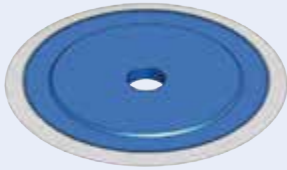
14FF1



SPECIFICATIONS	DIMENSIONS:	D 25-300mm; U 1-10mm; T 6-35mm										
	BONDS:	MDT (resin), MDX (metal), MDR (ceramic)										
	APPLICATIONS:	groove cutting, profile grinding										
SAMPLE ORDER	SHAPE	D	U	X	R	T	H	J	Y	BOND	GRIT	CONCENTRATION
	14FF1	200	12,2	5	6,1	16	127	145	0,2	MDX	D126	C125

Individual tool configuration on request

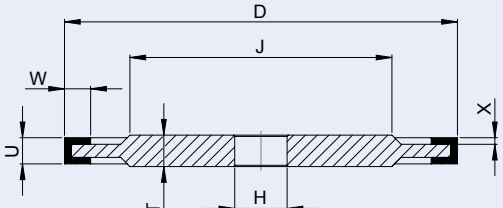
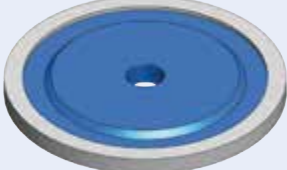
14K1



SPECIFICATIONS	DIMENSIONS:	D 35-300mm; X 3-10mm								
	BONDS:	MDT (resin), MDX (metal)								
	APPLICATIONS:	profile grinding, relief angle grinding								
SAMPLE ORDER	SHAPE	D	X	V	T	H	J	BOND	GRIT	CONCENTRATION
	14K1	150	4	30°	8	22	120	MDT	D64	C100

Individual tool configuration on request

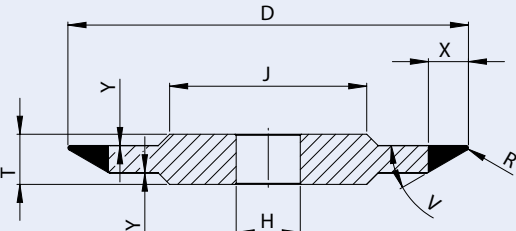

14U1



SPECIFICATIONS	DIMENSIONS:	D 75-500mm (MDX up to max. D 400mm); W 2-10mm; U 4-20mm; X 1-6mm									
	BONDS:	MDT (resin), MDX (metal), MDR (ceramic)									
	APPLICATIONS:	external and internal cylindrical grinding									
SAMPLE ORDER	SHAPE	D	W	U	X	T	H	J	BOND	GRIT	CONCENTRATION
	14U1	125	6	8	2	10	20	80	MDT	D91	C75

Individual tool configuration on request

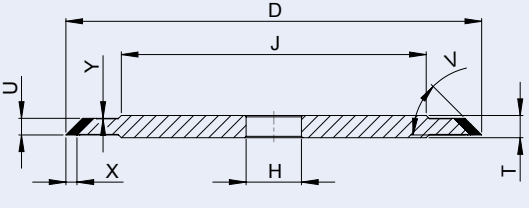
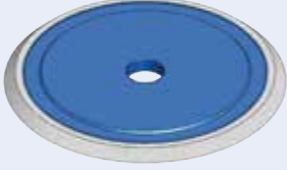
14K9



SPECIFICATIONS	DIMENSIONS:	D 100-300mm; X 10-20mm										
	BONDS:	MDT (resin), MDR (ceramic)										
	APPLICATIONS:	profile grinding, relief angle grinding, chip surface grinding										
SAMPLE ORDER	SHAPE	D	X	V	T	H	J	Y	R	BOND	GRIT	CONCENTRATION
	14K9	200	20	30	25	32	98,04	0,2	1,2	MDR	D181	C150

Individual tool configuration on request

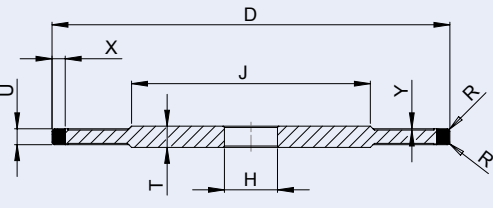
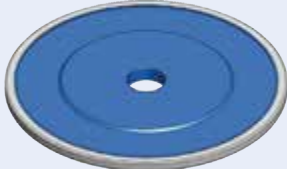
14V1



SPECIFICATIONS	DIMENSIONS:	D 40-500mm (MDX up to max. D 400mm); U 2-20mm; X 2-15mm										
	BONDS:	MDT (resin), MDX (metal)										
	APPLICATIONS:	groove cutting, back off- and profile grinding, external/ternal non-circular grinding, point thinning, radial corner bevel										
SAMPLE ORDER	SHAPE	D	U	X	V	T	H	J	Y	BOND	GRIT	CONCENTRATION
	14V1	175	6	3	60°	10	32	140	0,2	MDT	B126	C100

Individual tool configuration on request

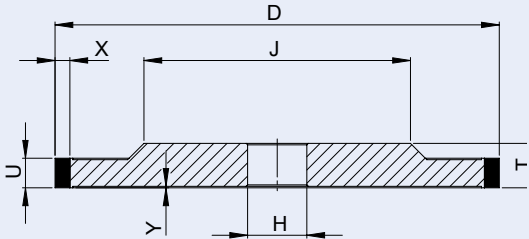

14L1



SPECIFICATIONS	DIMENSIONS:	D 30-600mm (MDX up to max. D 400mm); U 2-25mm; X 1-10mm										
	BONDS:	MDT (resin), MDX (metal), MDR (ceramic)										
	APPLICATIONS:	groove cutting, edging, centring										
SAMPLE ORDER	SHAPE	D	U	X	R	T	H	J	Y	BOND	GRIT	CONCENTRATION
	14L1	125	5	2	0,5	8	20	100	0,2	MDT	D64	C100

Individual tool configuration on request

3A1

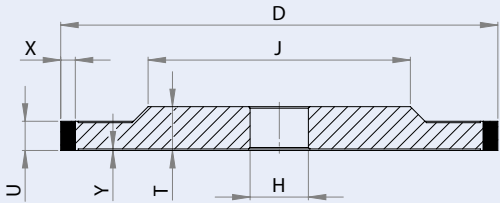



SPECIFICATIONS	DIMENSIONS:	D 10-600mm (MDX up to max. D 400mm); U 0,6-35mm; X 2-20mm									
	BONDS:	MDT (resin), MDX (metal), MDR (ceramic)									
	APPLICATIONS:	external and internal non-circular grinding, peel grinding, surface grinding, groove cutting, back off grinding									
SAMPLE ORDER	SHAPE	D	U	X	T	H	J	Y	BOND	GRIT	CONCENTRATION
	3A1	300	10	3	15	127	250	0,2	MDT	D126	C75

Individual tool configuration on request



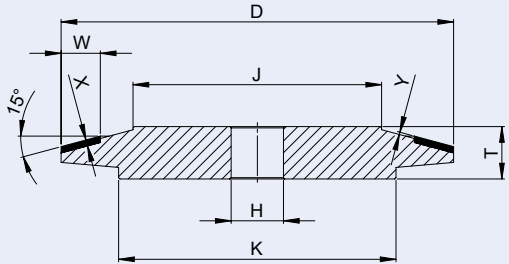
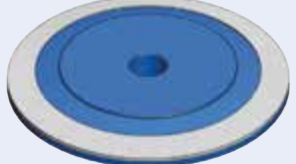
3A1-SP



SPECIFICATIONS	DIMENSIONS:	D 200-400mm; U 4-5mm; X 5-6mm									
	BONDS:	MDX (metal)									
	APPLICATIONS:	peel grinding									
SAMPLE ORDER	SHAPE	D	U	X	T	H	J	Y	BOND	GRIT	CONCENTRATION
	3A1-SP	350	5	5	18	127	276	0,4	MDX	D91	C150

Individual tool configuration on request

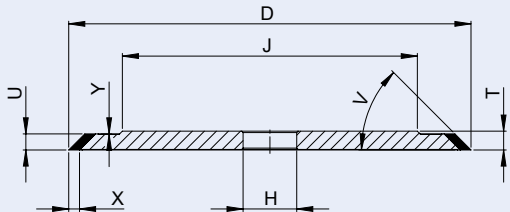
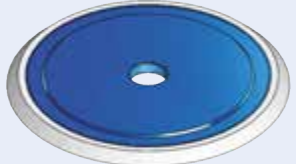
4A5



SPECIFICATIONS	DIMENSIONS:	D 50-250mm; W 4-34mm; X 1-6mm										
	BONDS:	MDT (resin), MDX (metal), MDR (ceramic)										
	APPLICATIONS:	hob, chip surface grinding										
SAMPLE ORDER	SHAPE	D	W	X	T	H	K	J	Y	BOND	GRIT	CONCENTRATION
	4A5	200	15	1	27	50,8	160	100	0,5	MDT	B151	C100

Individual tool configuration on request

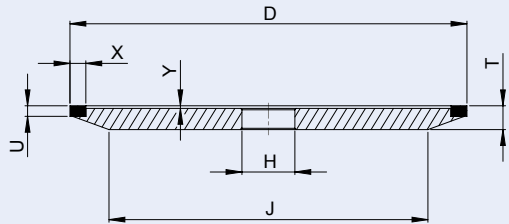
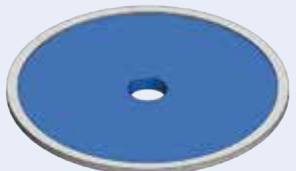
3V1



SPECIFICATIONS	DIMENSIONS:	D 40-500mm (MDX up to max. D400mm); U 4-35mm; X 2-20mm										
	BONDS:	MDT (resin), MDX (metal)										
	APPLICATIONS:	external and internal non-circular grinding, groove cutting, back off grinding, point thinning, radial corner bevel, profile grinding										
SAMPLE ORDER	SHAPE	D	U	X	V	T	H	J	Y	BOND	GRIT	CONCENTRATION
	3V1	125	6	9	45	8	31,75	70,6	0,2	MDX	D64	C125

Individual tool configuration on request

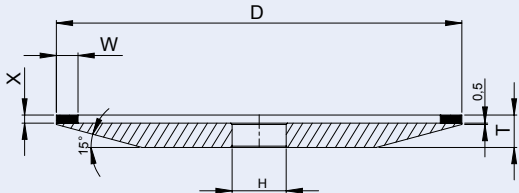
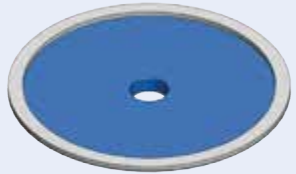
4A9



SPECIFICATIONS	DIMENSIONS:	D 35-500mm (MDX up to max. D 400mm); U 0,5-16mm; X 2-16mm									
	BONDS:	MDT (resin), MDX (metal), MDR (ceramic)									
	APPLICATIONS:	groove cutting, point thinning, relief angle grinding									
SAMPLE ORDER	SHAPE	D	U	X	T	H	J	Y	BOND	GRIT	CONCENTRATION
	4A9	125	2	6	8	20	88	0,2	MDT	D126	C100

Individual tool configuration on request

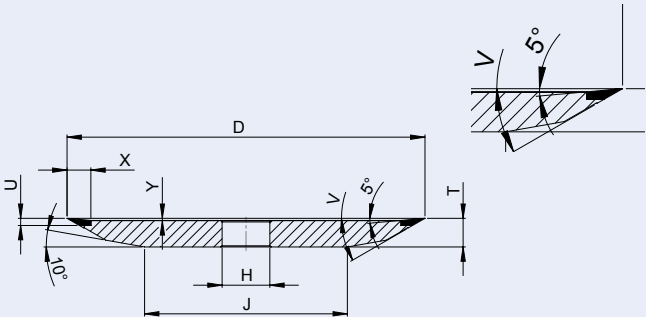

4A2



SPECIFICATIONS	DIMENSIONS:	D 40-400mm; W 2-90mm; X 1-10mm									
	BONDS:	MDT (resin), MDX (metal), MDR (ceramic)									
	APPLICATIONS:	cylindrical grinding, face grinding, chip surface, clearance surface									
SAMPLE ORDER	SHAPE	D	W	X	T	H	BOND	GRIT	CONCENTRATION		
	4A2	125	5	2	9	20	MDT	D64	C75		

Individual tool configuration on request

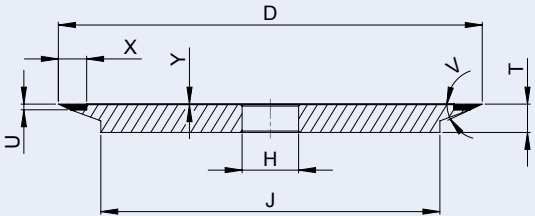
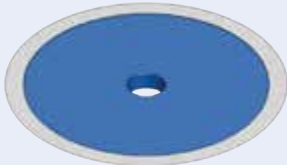
4B4



SPECIFICATIONS	DIMENSIONS:	D 25-200mm; U 1,5-4mm; X 3-10mm										
	BONDS:	MDT (resin), MDX (metal)										
	APPLICATIONS:	profile grinding										
SAMPLE ORDER	SHAPE	D	U	X	V	T	H	J	Y	BOND	GRIT	CONCENTRATION
	4B4	150	2	6	30°	10	22	85	0,7	MDT	D64	C100

Individual tool configuration on request

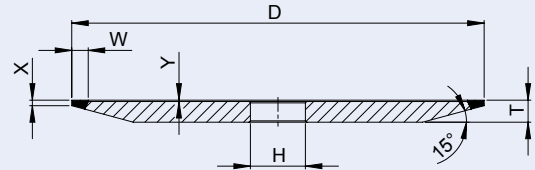

4B9



SPECIFICATIONS	DIMENSIONS: D 75-200mm; U 0,75-5mm; X 3-15mm BONDS: MDT (resin), MDX (metal) APPLICATIONS: profile grinding											
SAMPLE ORDER	SHAPE	D	U	X	V	T	H	J	Y	BOND	GRIT	CONCENTRATION
	4B9	150	1	6	20°	8	32	130	0,2	MDT	D64	C100

Individual tool configuration on request

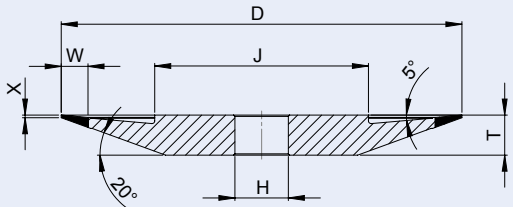
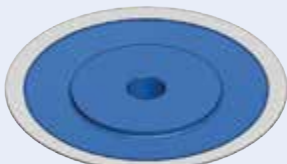
4ET9



SPECIFICATIONS	DIMENSIONS: D 50-200mm; W 2-10mm; X 1-5mm BONDS: MDT (resin), MDX (metal) APPLICATIONS: chip surface grinding										
SAMPLE ORDER	SHAPE	D	W	X	H	T	Y	BOND	GRIT	CONCENTRATION	
	4ET9	125	5	2	20	8	1	MDT	D64	C75	

Individual tool configuration on request

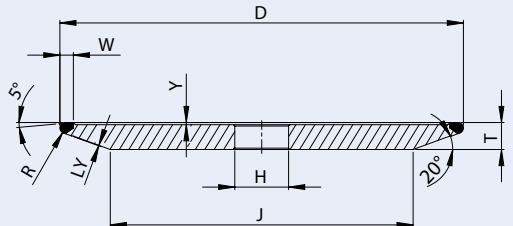

4BT9



SPECIFICATIONS	DIMENSIONS: D 30-250mm; W 4-15mm; X 0,2-10mm BONDS: MDT (resin), MDX (metal) APPLICATIONS: chip surface grinding										
SAMPLE ORDER	SHAPE	D	W	X	T	H	J	BOND	GRIT	CONCENTRATION	
	4BT9	100	10	1	10	32	50	MDT	B151	C100	

Individual tool configuration on request

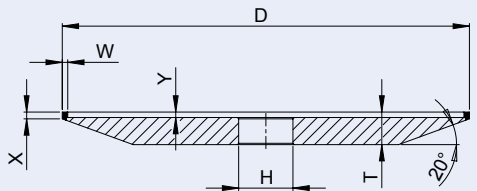

4F5



SPECIFICATIONS	DIMENSIONS: D 50-150mm; W 3-6mm BONDS: MDT (resin), MDX (metal), MDR (ceramic) APPLICATIONS: profile grinding, aspheric machining											
SAMPLE ORDER	SHAPE	D	W	R	T	H	J	Y	LY	BOND	GRIT	CONCENTRATION
	4F5	150	5	2	10	20	110	0,8	0,8	MDT	D126	C75

Individual tool configuration on request

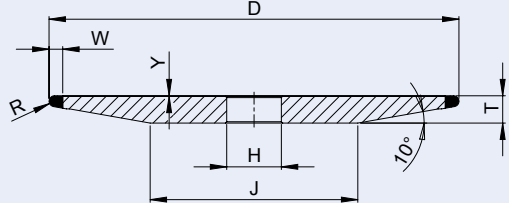

4E9P



SPECIFICATIONS	DIMENSIONS: D 50-350mm; W 2-5mm; X 1-5mm BONDS: MDT (resin), MDX (metal) APPLICATIONS: chip surface grinding										
SAMPLE ORDER	SHAPE	D	W	X	T	H	Y	BOND	GRIT	CONCENTRATION	
	4E9P	200	2	2,5	22	50,8	2	MDT	B151	C125	

Individual tool configuration on request

4F9

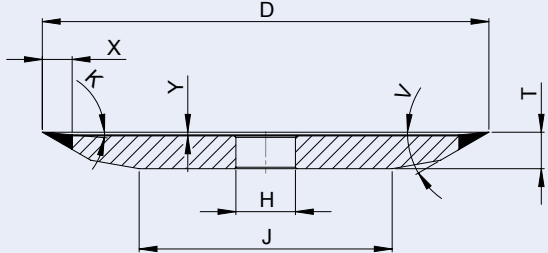



SPECIFICATIONS	DIMENSIONS: D 35-400mm; W 2-15mm BONDS: MDT (resin), MDX (metal), MDR (ceramic) APPLICATIONS: profile grinding										
SAMPLE ORDER	SHAPE	D	W	R	T	H	J	Y	BOND	GRIT	CONCENTRATION
	4F9	100	6	R1	8	20	40	0,2	MDT	B151	C75

Individual tool configuration on request



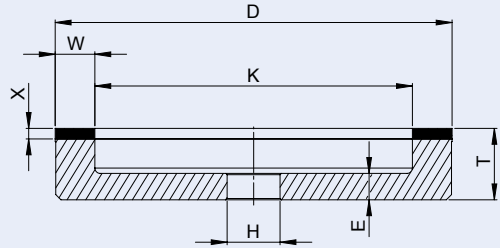
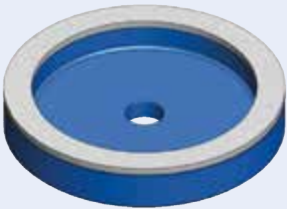
4K9



SPECIFICATIONS	DIMENSIONS: D 30-350mm; X 2-20mm BONDS: MDT (resin), MDX (metal) APPLICATIONS: profile grinding											
SAMPLE ORDER	SHAPE	D	X	V	H	K	J	Y	T	BOND	GRIT	CONCENTRATION
	4K9	150	7	20°	22	0,5°	105	0,2	7	MDT	D64	C125

Individual tool configuration on request

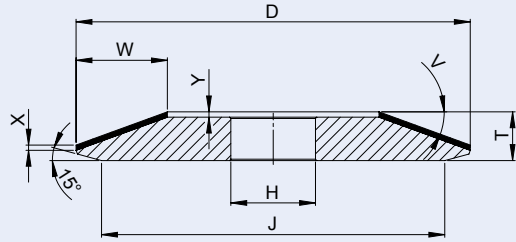
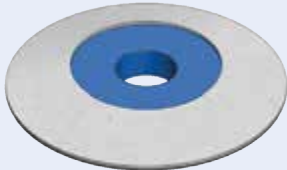
6A2



SPECIFICATIONS	DIMENSIONS: D 12-500mm (MDX up to max. D 400mm); W 5-100mm; X 2-20mm BONDS: MDT (resin), MDX (metal), MDR (ceramic) APPLICATIONS: lateral/end face relief angle grinding, corner bevel grinding, face grinding, wedge angle grinding											
SAMPLE ORDER	SHAPE	D	W	X	T	H	E	K	BOND	GRIT	CONCENTRATION	
	6A2	150	6	2	25	20	10	138	MDT	D126	C75	

Individual tool configuration on request

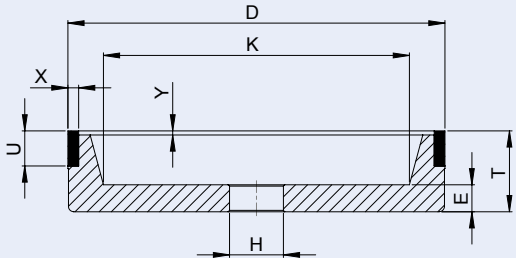
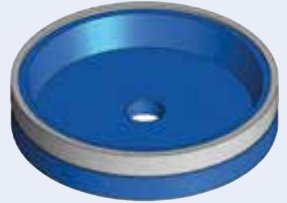
4V5



SPECIFICATIONS	DIMENSIONS: D 60-350mm; W 8-60mm; X 1,5-5mm BONDS: MDT (resin), MDX (metal), MDR (ceramic) APPLICATIONS: chip surface grinding											
SAMPLE ORDER	SHAPE	D	W	X	V	T	H	J	Y	BOND	GRIT	CONCENTRATION
	4V5	150	30	1,5	20	18	20	130	0,5	MDT	D64	C100

Individual tool configuration on request

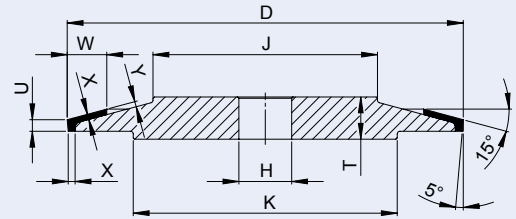
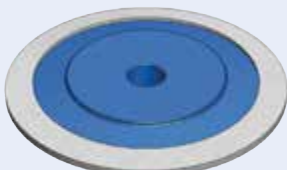
6A9



SPECIFICATIONS	DIMENSIONS: D 15-600mm (MDX up to max. D 400mm); U 6-25mm; X 2-10mm BONDS: MDT (resin), MDX (metal), MDR (ceramic) APPLICATIONS: lateral/end face relief angle grinding, corner bevel grinding, face grinding, wedge angle grinding, peripheral grinding WP											
SAMPLE ORDER	SHAPE	D	U	X	T	H	E	K	Y	BOND	GRIT	CONCENTRATION
	6A9	125	10	2	30	20	10	101	1,5	MDT	D126	C100

Individual tool configuration on request

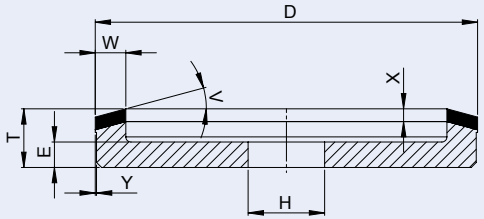
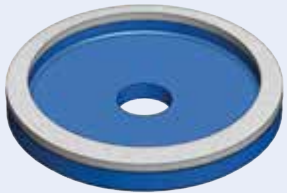
4Y9



SPECIFICATIONS	DIMENSIONS: D 50-350mm; W 10-80mm; X 1-15mm BONDS: MDT (resin), MDX (metal), MDR (ceramic) APPLICATIONS: chip surface grinding												
SAMPLE ORDER	SHAPE	D	W	U	X	T	H	K	J	Y	BOND	GRIT	CONCENTRATION
	4Y9	250	15	2,8	1	27	50,8	214	180	0,5	MDT	B151	C100

Individual tool configuration on request

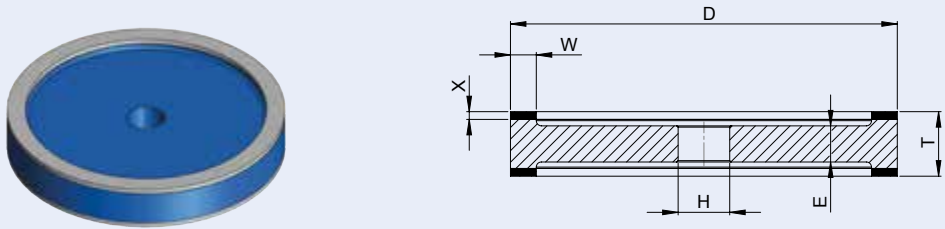
6V5



SPECIFICATIONS	DIMENSIONS: D 50-300mm; W 3-50mm; X 2-10mm BONDS: MDT (resin), MDX (metal) APPLICATIONS: clearance angle grinding, radial grinding											
SAMPLE ORDER	SHAPE	D	W	X	V	H	T	E	Y	BOND	GRIT	CONCENTRATION
	6V5	75	5	5	30	20	30	10	0,2	MDT	B126	C100

Individual tool configuration on request

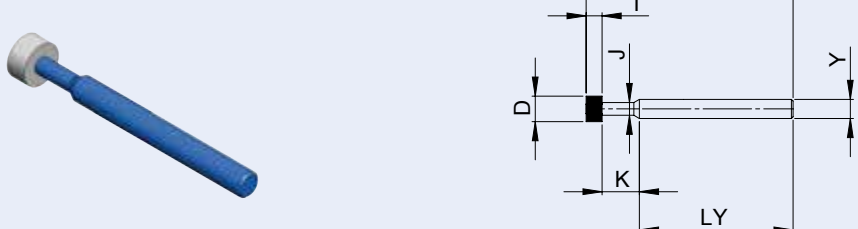
9A3



SPECIFICATIONS	<b>DIMENSIONS:</b> D 50-600mm (MDX up to max. D 400mm); W 2-15mm; X 1-8mm <b>BONDS:</b> MDT (resin), MDX (metal), MDR (ceramic) <b>APPLICATIONS:</b> clearance angle grinding, face grinding									
SAMPLE ORDER	SHAPE	D	W	X	T	H	E	BOND	GRIT	CONCENTRATION
	9A3	175	6	3	35	20	14	MDT	D64	C75

Individual tool configuration on request

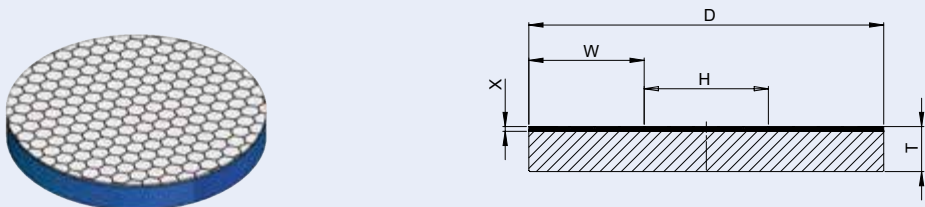
1A1W-1



SPECIFICATIONS	<b>DIMENSIONS:</b> D 3-55mm; T 0,6-200mm <b>BONDS:</b> MDT (resin), MDX (metal), MDR (ceramic) <b>APPLICATIONS:</b> internal cylindrical grinding <b>MINIMUM ORDER QUANTITY:</b> 5 pieces										
SAMPLE ORDER	SHAPE	D	T	K	J	L	Y	LY	BOND	GRIT	CONCENTRATION
	1A1W-1	8	5	10	4	45	6	30	MDT	D76	C125

Individual tool configuration on request

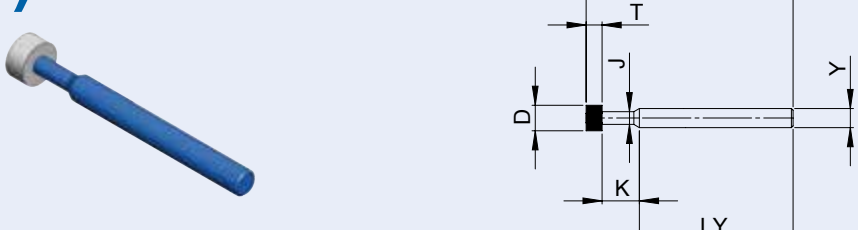
CPP



SPECIFICATIONS	<b>DIMENSIONS:</b> D 150-810mm; W 6-250mm; X 3-7mm <b>BONDS:</b> MDT (resin) <b>APPLICATIONS:</b> face machining									
SAMPLE ORDER	SHAPE	D	W	X	T	H	BOND	GRIT	CONCENTRATION	
	CPP	300	150	3	38	0	MDT	D126	C50	

Individual tool configuration on request

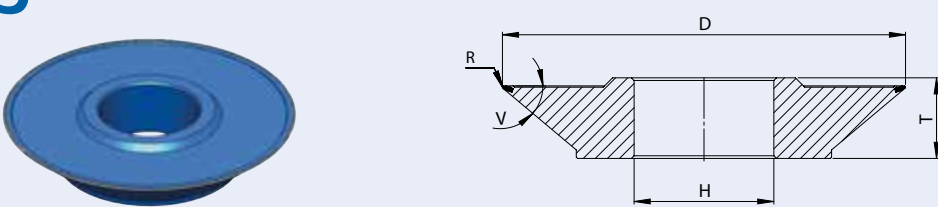
1A1W-1(S)



SPECIFICATIONS	<b>DIMENSIONS:</b> D 0,5-6mm; T 2-29mm <b>BONDS:</b> MDS (electroplated bond) <b>APPLICATIONS:</b> internal cylindrical grinding <b>MINIMUM ORDER QUANTITY:</b> 5 pieces									
SAMPLE ORDER	SHAPE	D	T	K	J	L	Y	LY	BOND	GRIT
	1A1W-1(S)	8	5	10	4	45	6	30	MDS	D76

Individual tool configuration on request


Dressing roll



SPECIFICATIONS	<b>DIMENSIONS:</b> D 30-400mm <b>BONDS:</b> MDX (metal) <b>APPLICATIONS:</b> profile dressing						
SAMPLE ORDER	SHAPE	D	V	R	T	H	BOND
	FORO	150	40	0,25	30	52	MDX

Individual tool configuration on request

1A1W-2

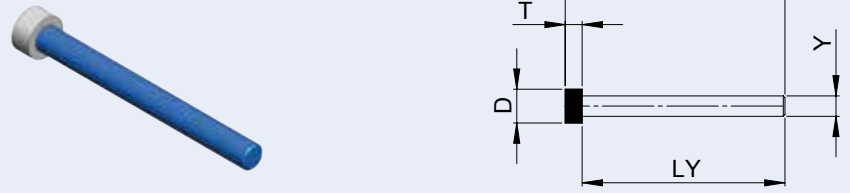


SPECIFICATIONS	<b>DIMENSIONS:</b> D 3-55mm; U 1-10mm; T 0,6-200mm <b>BONDS:</b> MDT (resin), MDX (metal), MDR (ceramic) <b>APPLICATIONS:</b> internal cylindrical grinding <b>MINIMUM ORDER QUANTITY:</b> 5 pieces									
SAMPLE ORDER	SHAPE	D	T	L	Y	LY	BOND	GRIT	CONCENTRATION	
	1A1W-2	8	10	70	6	60	MDT	D76	C125	

Individual tool configuration on request



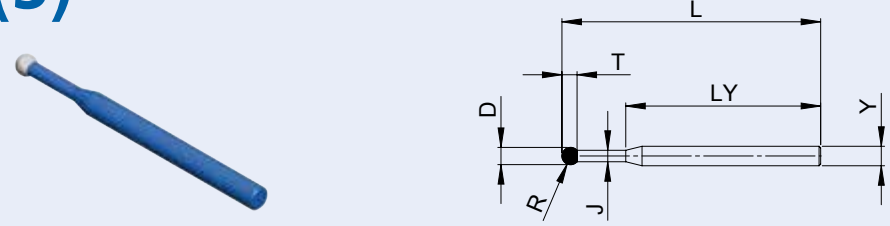
1A1W-2(S)



SPECIFICATIONS	DIMENSIONS: D 3,5-60mm; T 5-55mm							
	BONDS: MDS (electroplated bond)							
	APPLICATIONS: internal cylindrical grinding							
	MINIMUM ORDER QUANTITY: 5 pieces							
SAMPLE ORDER	SHAPE	D	T	L	Y	LY	BOND	GRIT
	1A1W-2(S)	8	10	70	6	60	MDS	D76

Individual tool configuration on request

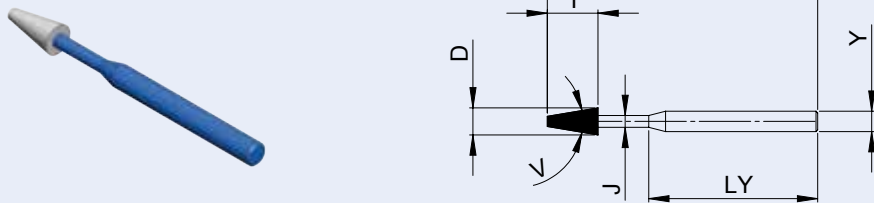
1A1W-R(S)



SPECIFICATIONS	DIMENSIONS: D 1-25,3mm; T 6-80mm									
	BONDS: MDS (electroplated bond)									
	APPLICATIONS: internal cylindrical grinding, profile grinding, deburring									
	MINIMUM ORDER QUANTITY: 5 pieces									
SAMPLE ORDER	SHAPE	D	R	T	J	L	Y	LY	BOND	GRIT
	1A1W-R(S)	4	2	2,5	3	50	3	30	MDS	D126

Individual tool configuration on request

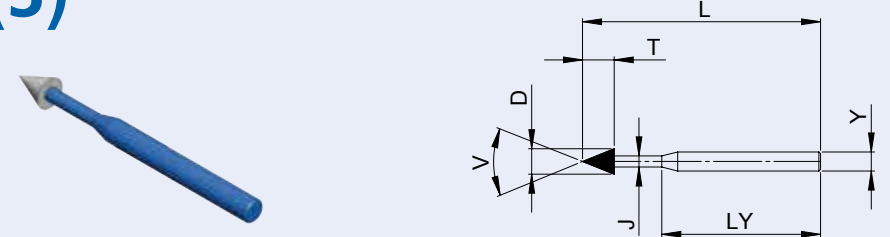
1A1W-PS(S)



SPECIFICATIONS	DIMENSIONS: D 2,8-38mm; T 3-16mm									
	BONDS: MDS (electroplated bond)									
	APPLICATIONS: internal cylindrical grinding, profile grinding, deburring									
	MINIMUM ORDER QUANTITY: 5 pieces									
SAMPLE ORDER	SHAPE	D	V	T	J	L	Y	LY	BOND	GRIT
	1A1W-PS(S)	8	50°	10	2,5	30	3	20	MDS	D126

Individual tool configuration on request

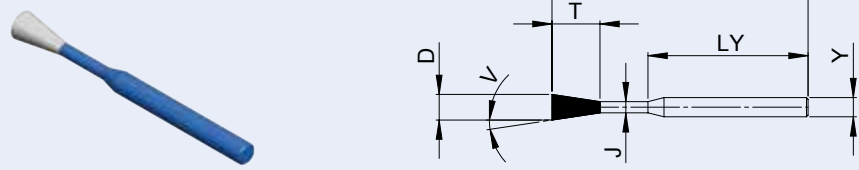
1A1W-S(S)



SPECIFICATIONS	DIMENSIONS: D 3-20mm; T 1,75-100mm									
	BONDS: MDS (electroplated bond)									
	APPLICATIONS: internal cylindrical grinding, profile grinding, deburring									
	MINIMUM ORDER QUANTITY: 5 pieces									
SAMPLE ORDER	SHAPE	D	V	T	J	L	Y	LY	BOND	GRIT
	1A1W-S(S)	4	90°	3	2,5	50	3	30	MDS	D126

Individual tool configuration on request

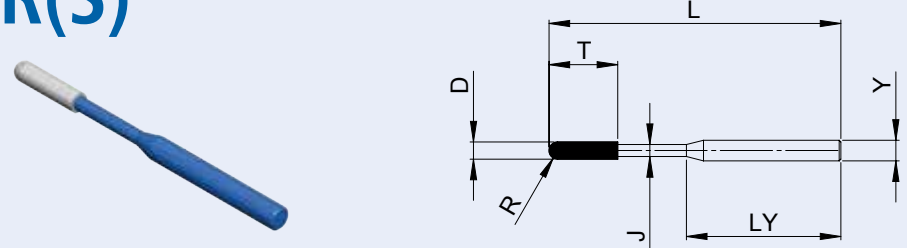
1A1W-PSU(S)



SPECIFICATIONS	DIMENSIONS: D 4-50mm; T 6-20mm									
	BONDS: MDS (electroplated bond)									
	APPLICATIONS: internal cylindrical grinding, profile grinding, deburring									
	MINIMUM ORDER QUANTITY: 5 pieces									
SAMPLE ORDER	SHAPE	D	V	T	J	L	Y	LY	BOND	GRIT
	1A1W-PSU(S)	4	8°	4	3	45	3	40	MDS	D126

Individual tool configuration on request

1A1W-ZR(S)



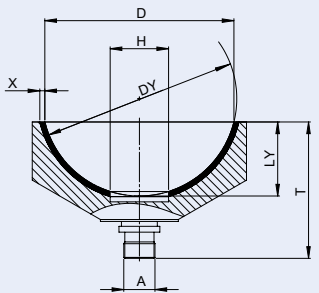
SPECIFICATIONS	DIMENSIONS: D 0,5-6mm; T 2-29mm									
	BONDS: MDS (electroplated bond)									
	APPLICATIONS: internal cylindrical grinding, profile grinding, deburring									
	MINIMUM ORDER QUANTITY: 5 pieces									
SAMPLE ORDER	SHAPE	D	R	T	J	L	Y	LY	BOND	GRIT
	1A1W-ZR(S)	4	2	20	3,5	60	6	30	MDS	D126

Individual tool configuration on request

# DIAMOND TOOLS

for the optical industry

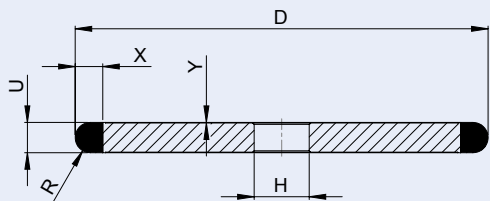
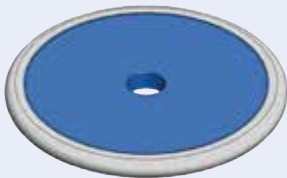
A



SPECIFICATIONS	DIMENSIONS:	D 3,6-235mm; X 1-15mm									
	BONDS:	MDT (resin), MDX (metal), MDS (electroplated bond)									
	APPLICATIONS:	lens bevelling									
	DIN:	58723									
SAMPLE ORDER	ATTENTION:	LY = DY x 0,35mm									
	SHAPE	D	X	T	H	LY	DY	A	BOND	GRIT	CONCENTRATION
	A	83	1	70	20	30,5	87	-	MDX	D25	C50

Individual tool configuration on request

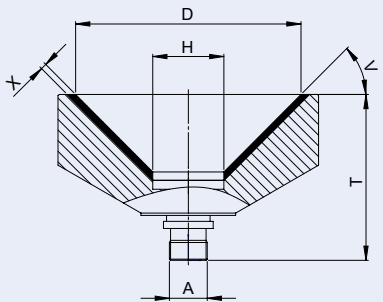
1F1



SPECIFICATIONS	DIMENSIONS:	D 25-200mm; U 6-12mm; X 4-6mm									
	BONDS:	MDT (resin), MDX (metal), MDS (electroplated bond)									
	APPLICATIONS:	groove cutting, profile grinding									
SAMPLE ORDER	SHAPE	D	U	X	R	H	Y	BOND	GRIT	CONCENTRATION	
	1F1	100	6	6	3	20	0,2	MDT	D91	C100	

Individual tool configuration on request

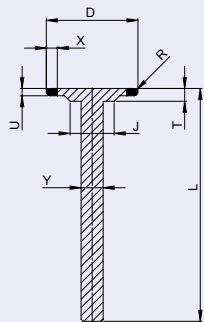
B



SPECIFICATIONS	DIMENSIONS:	D 10-200mm; X 1-1,5mm									
	BONDS:	MDT (resin), MDX (metal), MDS (electroplated bond)									
	APPLICATIONS:	lens bevelling									
	DIN:	58723									
SAMPLE ORDER	SHAPE	D	X	V	T	H	A	BOND	GRIT	CONCENTRATION	
	B	12,5	1	45°	40	2	-	MDX	D15	C50	

Individual tool configuration on request

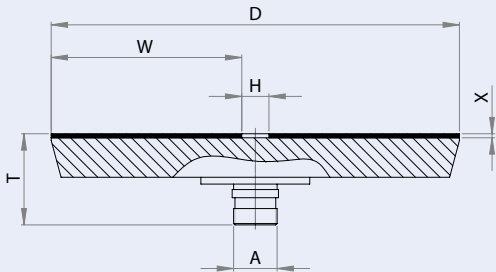
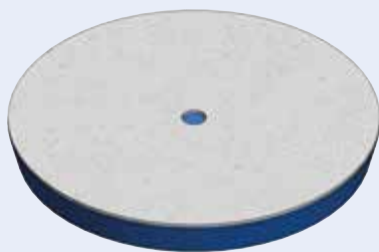
1F1W



SPECIFICATIONS	DIMENSIONS: D 8-50; U 1-10; X 2-10											
	BONDS: MDT (resin), MDX (metal), MDR (ceramic)											
	APPLICATIONS: aspheric and free-form machining											
SAMPLE ORDER	SHAPE	D	U	X	T	J	Y	L	R	BOND	GRIT	CONCENTRATION
	1F1W	25	2	3	3,5	12	6	60	1	MDT	B151	C100

Individual tool configuration on request

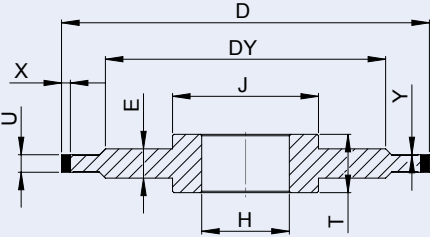
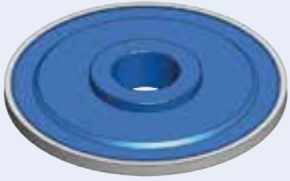
C



SPECIFICATIONS	DIMENSIONS:	D 35-410mm; W 28-185mm; X 2-5mm									
	BONDS:	MDT (resin), MDX (metal), MDS (electroplated bond)									
	APPLICATIONS:	face machining									
	DIN:	58723									
SAMPLE ORDER	SHAPE	D	W	X	T	H	A	BOND	GRIT	CONCENTRATION	
	C	200	55	3	32	90	-	MDX	D15	C50	

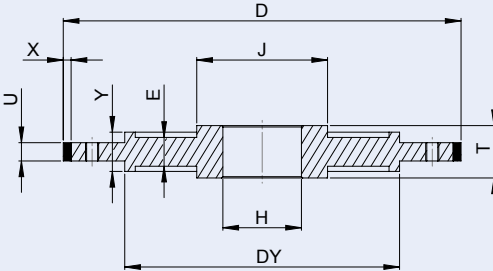
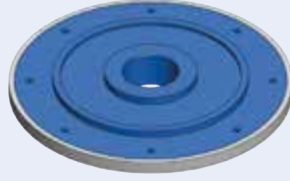
Individual tool configuration on request



D

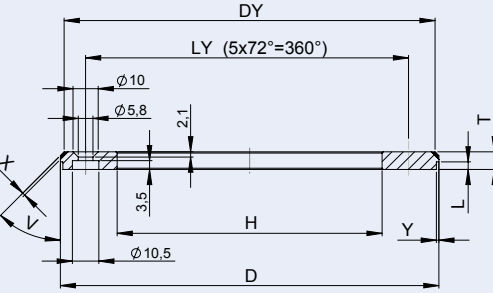

SPECIFICATIONS	<b>DIMENSIONS:</b> D 50-250mm; U 2-50mm; X 2-15mm <b>BONDS:</b> MDT (resin), MDX (metal), MDS (electroplated bond) <b>APPLICATIONS:</b> centring <b>DIN:</b> 58742												
SAMPLE ORDER	SHAPE	D	U	X	T	H	E	J	Y	DY	BOND	GRIT	CONCENTRATION
	D	160	8	2	20	30	7,6	50	0,2	130	MDX	D64	C90

Individual tool configuration on request

E

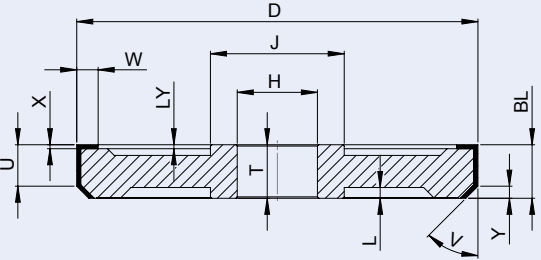
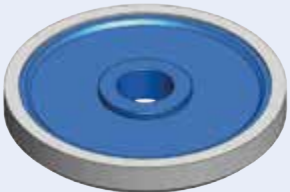
SPECIFICATIONS	<b>DIMENSIONS:</b> D 60-210mm; U 4-60mm; X 2-4mm <b>BONDS:</b> MDT (resin), MDX (metal), MDS (electroplated bond) <b>APPLICATIONS:</b> centring <b>DIN:</b> 58742												
SAMPLE ORDER	SHAPE	D	U	X	T	H	E	J	Y	DY	BOND	GRIT	CONCENTRATION
	E	100	8	2	20	20	6	35	15	65	MDX	D64	C90

Individual tool configuration on request

F

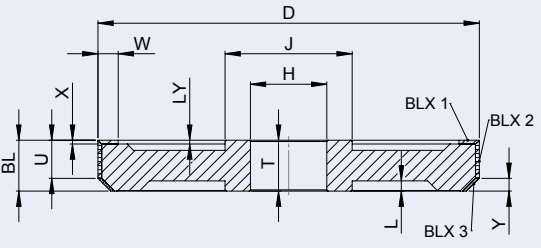
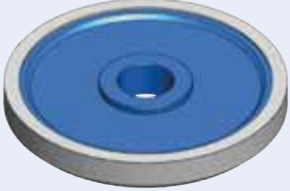
SPECIFICATIONS	<b>DIMENSIONS:</b> D 90-220mm; X 2-4mm <b>BONDS:</b> MDT (resin), MDX (metal), MDS (electroplated bond) <b>APPLICATIONS:</b> centring <b>DIN:</b> 58742												
SAMPLE ORDER	SHAPE	D	X	V	T	H	L	Y	LY	DY	BOND	GRIT	CONCENTRATION
	F	101	1	45°	6	65	2	0,5	80	100	MDX	D64	C90

Individual tool configuration on request

EZ3

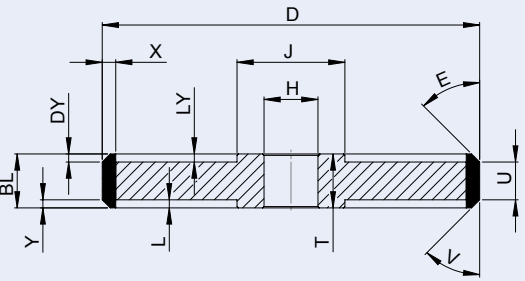
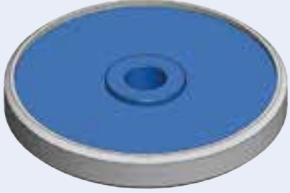
SPECIFICATIONS	<b>DIMENSIONS:</b> D 48-200mm; W 1,5-22mm; U 3,5-45mm; X 1-6mm <b>BONDS:</b> MDT (resin), MDX (metal), MDS (electroplated bond) <b>APPLICATIONS:</b> centring																
SAMPLE ORDER	SHAPE	D	W	U	X	V	T	H	J	L	Y	LY	BL	BOND	GRIT	CONCENTRATION	
	EZ3	100	5	15	1	45°	20	20	40	2	5	1	20	MDX	D46	C125	

Individual tool configuration on request

EZ3/A

SPECIFICATIONS	<b>DIMENSIONS:</b> D 48-200mm; W 1,5-22mm; U 3,5-45mm; X 1-6mm <b>BONDS:</b> MDT (resin), MDX (metal) <b>APPLICATIONS:</b> centring																		
SAMPLE ORDER	SHAPE	D	W	U	X	T	H	J	L	Y	LY	BL	BOND	GRIT			CONCENTRATION		
														FACING					
														BLX1	BLX2	BLX3	BLX1	BLX2	BLX3
	EZ3/A	100	5	15	1	20	20	40	2	5	1	20	MDX	D25	D46	D35	C125	C90	C125

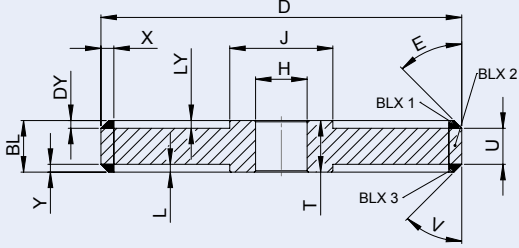
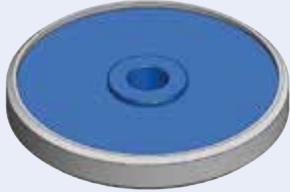
Individual tool configuration on request

EZ4

SPECIFICATIONS	<b>DIMENSIONS:</b> D 48-200mm; U 3,5-45mm; X 2-6mm <b>BONDS:</b> MDT (resin), MDX (metal) <b>APPLICATIONS:</b> centring																
SAMPLE ORDER	SHAPE	D	U	X	V	E	T	H	J	L	Y	DY	LY	BL	BOND	GRIT	CONCENTRATION
	EZ4	100	6	2,5	45°	30°	20	20	40	2	2	2	2	10	MDX	D46	C125

Individual tool configuration on request


# EZ4/A



SPECIFICATIONS	DIMENSIONS: D 48-200mm; U 3,5-45mm; X 2-6mm																					
	BONDS: MDT (resin), MDX (metal)																					
APPLICATIONS: centring																						
SAMPLE ORDER	SHAPE	D	U	X	V	E	T	H	J	L	Y	LY	BL	DY	BOND	GRIT	CONCENTRATION					
	EZ4/A	100	6	2,5	45°	30°	20	20	40	2	2	2	10	2	MDX	FACING						
																BLX1	BLX2	BLX3	BLX1	BLX2	BLX3	
															D25	D46	D35	C125	C90	C125		

Individual tool configuration on request

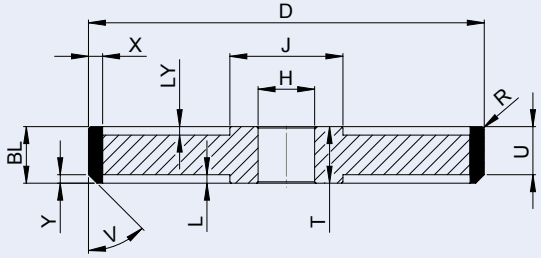
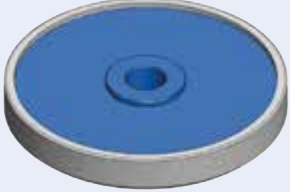
# FK



SPECIFICATIONS	DIMENSIONS: D 5,2-200mm; X 1-15mm										
	BONDS: MDT (resin), MDX (metal), MDS (electroplated bond)										
APPLICATIONS: lens bevelling											
DIN: 58723											
ATTENTION: LY = DY x 0,35mm											
SAMPLE ORDER	SHAPE	D	X	R	T	H	LY	A	BOND	GRIT	CONCENTRATION
	FK	50	1	30	39	10	13	-	MDX	D25	C50

Individual tool configuration on request

# EZ5



SPECIFICATIONS	DIMENSIONS: D 48-200mm; U 3,5-45mm; X 2-6mm															
	BONDS: MDT (resin), MDX (metal)															
APPLICATIONS: centring																
SAMPLE ORDER	SHAPE	D	U	X	V	R	T	H	J	L	Y	LY	BL	BOND	GRIT	CONCENTRATION
	EZ5	100	6	2,5	45°	0,5	20	20	40	0,5	1,5	0,5	7,5	MDX	D46	C125

Individual tool configuration on request

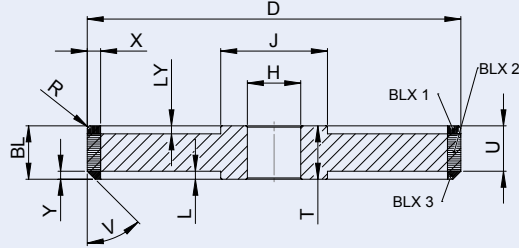
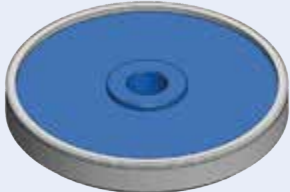
# FKE



SPECIFICATIONS	DIMENSIONS: D 3-200mm; X 1-6mm									
	BONDS: MDT (resin), MDX (metal), MDS (electroplated bond)									
APPLICATIONS: lens bevelling										
DIN: 58723										
SAMPLE ORDER	SHAPE	D	X	V	T	H	A	BOND	GRIT	CONCENTRATION
	FKE	70	1	90°	90	40	-	MDX	D15	C50

Individual tool configuration on request

# EZ5/A



SPECIFICATIONS	DIMENSIONS: D 48-200mm; U 3,5-45mm; X 2-6mm																					
	BONDS: MDT (resin), MDX (metal)																					
APPLICATIONS: centring																						
SAMPLE ORDER	SHAPE	D	U	X	V	R	T	H	J	L	Y	LY	BL	BOND	GRIT	CONCENTRATION						
	EZ5/A	100	6	2,5	45°	0,5	20	20	40	0,5	1,5	0,5	7,5	MDX	FACING							
																BLX1	BLX2	BLX3	BLX1	BLX2	BLX3	
															D25	D46	D35	C125	C90	C125		

Individual tool configuration on request

# HB1

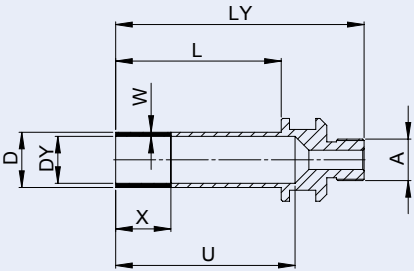
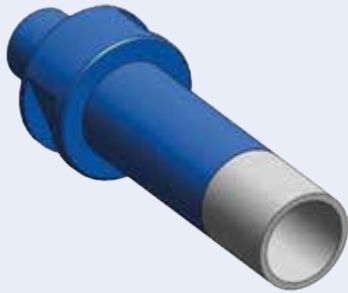


SPECIFICATIONS	DIMENSIONS: D 2,5-100mm; W 1-2mm; X 5-10mm									
	BONDS: MDX (metal), MDS (electroplated bond)									
APPLICATIONS: glass drilling										
SAMPLE ORDER	SHAPE	D	W	H	L	DY	BOND	GRIT	CONCENTRATION	
	HB1	5	1	10	50	3	MDX	D126	C50	

Individual tool configuration on request



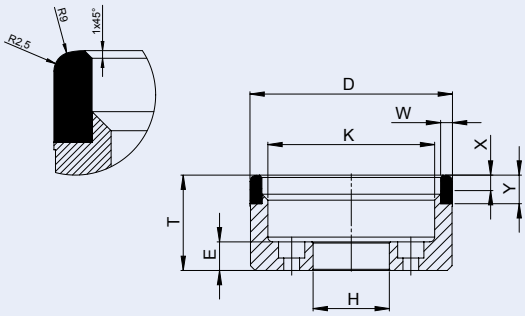
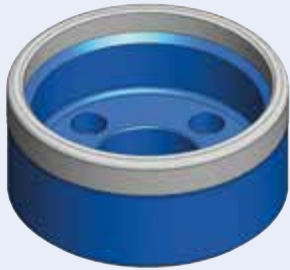
HB2



SPECIFICATIONS	DIMENSIONS: BONDS: APPLICATIONS:	D 2,5-100mm; W 1-2mm; X 5-10mm MDX (metal), MD5 (electroplated bond) glass drilling										
SAMPLE ORDER	SHAPE	D	W	U	X	L	LY	DY	A	BOND	GRIT	CONCENTRATION
	HB2	6,2	1	45	10	40	75	4,2	G1/2	MDX	D126	C50

Individual tool configuration on request

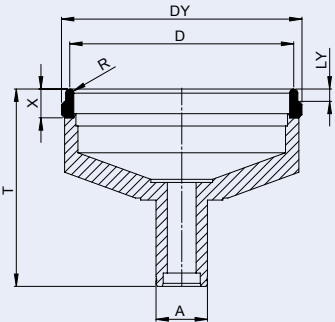

PF/R



SPECIFICATIONS	DIMENSIONS: BONDS: APPLICATIONS:	D 30-350mm; W 1-15mm; X 4-10mm MDT (resin), MDX (metal) prismatic machining										
SAMPLE ORDER	SHAPE	D	W	X	T	H	E	K	Y	BOND	GRIT	CONCENTRATION
	PF/R	100	5	6	25	35	12	76	6	MDX	D76	C75

Individual tool configuration on request

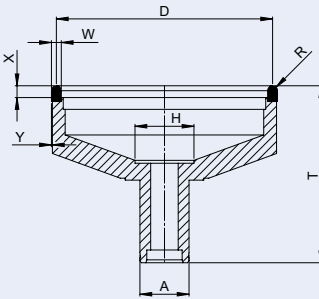
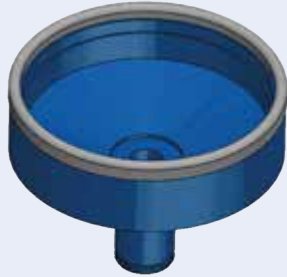
KW



SPECIFICATIONS	DIMENSIONS: BONDS: APPLICATIONS:	D 6,3-240mm; X 2-25mm MDT (resin), MDX (metal) aspheric machining, edging, complete machining of faces, facets and edges										
SAMPLE ORDER	SHAPE	D	X	T	R	LY	DY	A	BOND	GRIT	CONCENTRATION	
	KW	20	12	88	1,25	5	22,5	25	MDX	D46	C90	

Individual tool configuration on request

RF



SPECIFICATIONS	DIMENSIONS: BONDS: APPLICATIONS: DIN:	D 3-350mm; W 1-10mm; X 4-10mm MDT (resin), MDX (metal) radius grinding 58741										
SAMPLE ORDER	SHAPE	D	W	X	R	T	H	Y	A	BOND	GRIT	CONCENTRATION
	RF	100	5	6	2,5	90	30	0,5	HD-25SR	MDX	D64	C50

Individual tool configuration on request

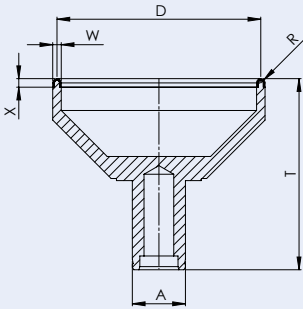

PF



SPECIFICATIONS	DIMENSIONS: BONDS: APPLICATIONS: DIN:	D 3-450mm (MDX up to max. D 400mm); W 1-30mm; X 4-25mm MDT (resin), MDX (metal) radius grinding 58741										
SAMPLE ORDER	SHAPE	D	W	X	T	H	E	Y	A	BOND	GRIT	CONCENTRATION
	PF	75	3	6	105	30	5	0,5	Z25	MDX	D76	C75

Individual tool configuration on request

RF(S)

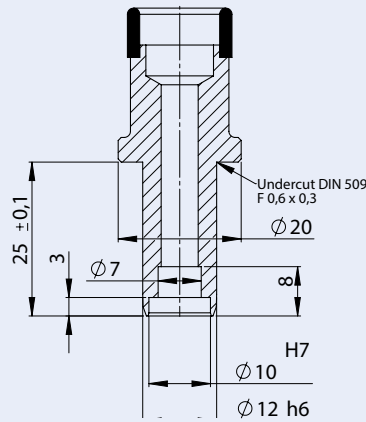


SPECIFICATIONS	DIMENSIONS: BONDS: APPLICATIONS:	D 3-300mm; W 1-10mm; X 2-4mm MDS (electroplated bond) dressing of polishing tools										
SAMPLE ORDER	SHAPE	D	W	X	R	T	A	BOND	GRIT			
	RF(S)	20	3	4	1,5	40	HD-25SR	MDS	D64			

Individual tool configuration on request

# Mounting

for HD-12 SR



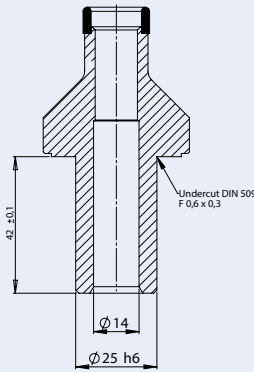
SPECIFICATIONS

MACHINE TYPE: Satisloh, OptoTech, Schneider

Individual tool configuration on request

# Mounting

for Z25 according to DIN



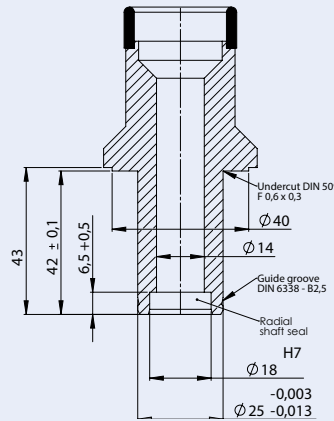
SPECIFICATIONS

MACHINE TYPE: Satisloh, OptoTech, Schneider  
DIN: 58741

Individual tool configuration on request

# Mounting

for HD-25 SR



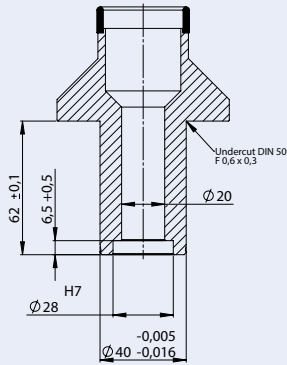
SPECIFICATIONS

MACHINE TYPE: Satisloh, OptoTech, Schneider

Individual tool configuration on request

# Mounting

for Z40 according to DIN



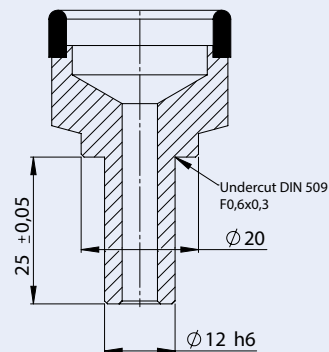
SPECIFICATIONS

MACHINE TYPE: Satisloh, OptoTech, Schneider  
DIN: 58741

Individual tool configuration on request

# Mounting

for Z12 according to DIN



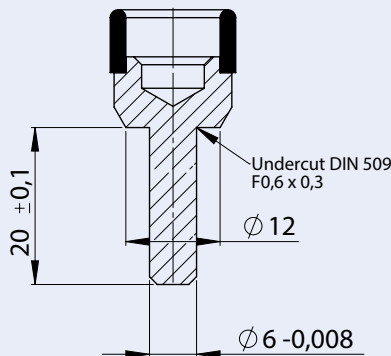
SPECIFICATIONS

MACHINE TYPE: Satisloh, OptoTech, Schneider  
DIN: 58741

Individual tool configuration on request

# Mounting

for Z6



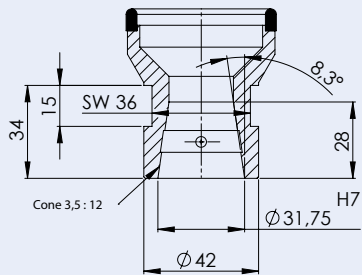
SPECIFICATIONS

MACHINE TYPE: Satisloh, OptoTech, Schneider  
SHAFT STANDARD LENGTH: 20mm according to DIN

Individual tool configuration on request

# Mounting

for SPM100

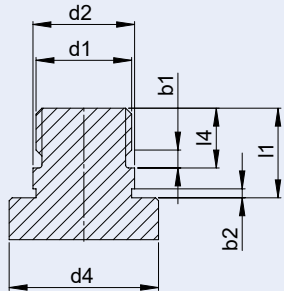
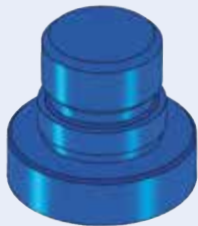


**SPECIFICATIONS** MACHINE TYPE: Satisloh RF 3A (bayonet), Satisloh RXT, Satisloh SPM100

Individual tool configuration on request

# Mounting

for AM+PZ

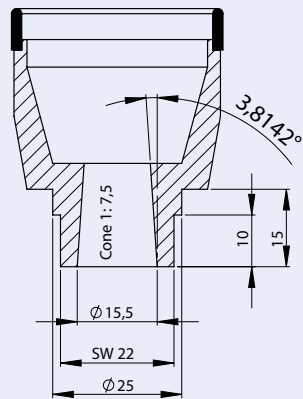


**SPECIFICATIONS** MACHINE TYPE: diverse

Individual tool configuration on request

# Mounting

for RF1-B

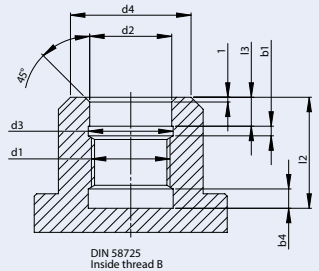
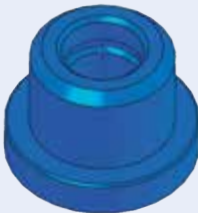


**SPECIFICATIONS** MACHINE TYPE: Satisloh RF1 <= diameter 60, Shape B

Individual tool configuration on request

# Mounting

for BM+PZ

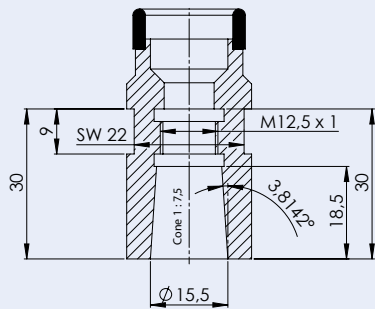


**SPECIFICATIONS** MACHINE TYPE: diverse

Individual tool configuration on request

# Mounting

for RF1-C



**SPECIFICATIONS** MACHINE TYPE: Satisloh RF1 <= diameter 25, Shape C

Individual tool configuration on request

d <sub>1</sub>	d <sub>2</sub> G7/h6	d <sub>3</sub>	d <sub>4</sub>	b <sub>1</sub> <sup>a</sup>	b <sub>2</sub> <sup>b</sup>	b <sub>4</sub> (2 <sub>p</sub> )	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	l <sub>4</sub>	p
M5	5,6	—	9	1,6	1	1,6	7	8, 6	3	4	0,8
M10	11	11,6	16	2c		3	10,5	13,5	5	7,5	1,5
M12	13	13,6	19	3,5	1,5	3,5	13	16,5	4	9	1,75
M16	17	17,6	25	2c		4	15	19	6	10	2
M20	21	22	32	5	2,5	5	18	23	5, 5	12,5	2,5
			40								
			70								
M27	28	29	45	4		21	21	27	6	15	3
M39	40	41	63	8		29	29	37	9	20	4
M60	62	63	90	12		12	40	51	12,5	27,5	6



SP



SPECIFICATIONS

DIMENSIONS:

BONDS:

APPLICATIONS:

D ACCORDING TO DIN:

D 3-200mm; W 1-20mm; X 6-15mm

MDT (resin), MDX (metal)

radius grinding

58741

SAMPLE ORDER

SHAPE	D	W	X	BOND	GRIT	CONCENTRATION
SP	50	3	6	MDX	D46	C75

Individual tool configuration on request

SR



SPECIFICATIONS

DIMENSIONS:

BONDS:

APPLICATIONS:

D ACCORDING TO DIN:

D 3-200mm; W 1-20mm; X 6-15mm

MDT (resin), MDX (metal)

radius grinding

58741

SAMPLE ORDER

SHAPE	D	W	X	R	BOND	GRIT	CONCENTRATION
SR	10	2	6	1	MDX	D46	C75

Individual tool configuration on request

TF



SPECIFICATIONS

DIMENSIONS:

BONDS:

APPLICATIONS:

D 60-112mm; X 8-10mm

MDT (resin), MDX (metal), MDS (electroplated bond)

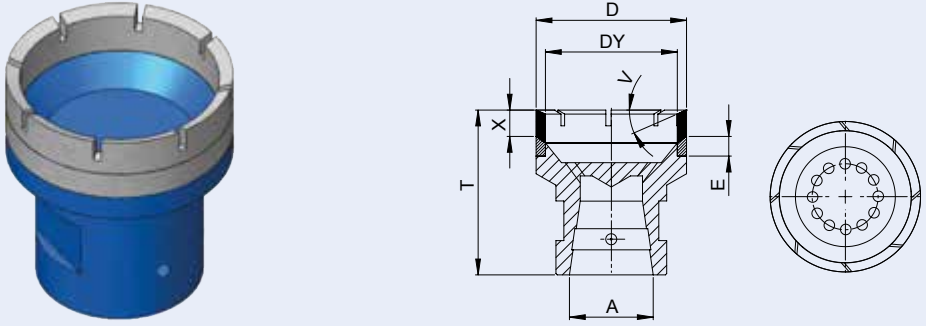
prismatic machining

SAMPLE ORDER

SHAPE	D	X	V	T	E	DY	A	BOND	GRIT	CONCENTRATION
TF	90	8	15°	78	11	77	—	MDX	D181	C35

Individual tool configuration on request

TF/S



SPECIFICATIONS

DIMENSIONS:

BONDS:

APPLICATIONS:

D 60-112mm; X 8-10mm

MDT (resin), MDX (metal), MDS (electroplated bond)

prismatic machining

SAMPLE ORDER

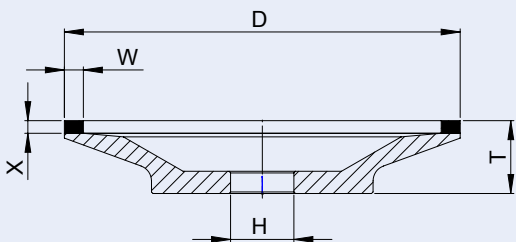
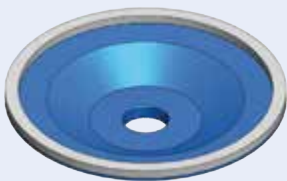
SHAPE	D	X	V	T	E	DY	A	BOND	GRIT	CONCENTRATION
TF/S	90	8	15°	78	7	77	—	MDX	D181	C35

Individual tool configuration on request

# DIAMOND AND CBN TOOLS

for the woodworking and plastics industry

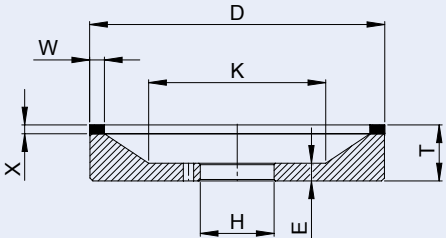
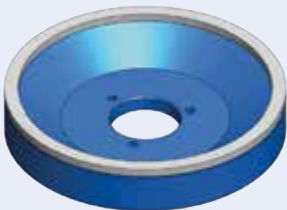
## F105SG



SPECIFICATIONS	DIMENSIONS: D 75-200mm; W 3-7mm; X 1,5-5mm									
	BONDS: MDT (resin)									
	APPLICATIONS: chip surface (tooth-face grinding)									
	MACHINE TYPE RECOMMENDATION: Vollmer-Dornhan, Universal tool grinding machine									
SAMPLE ORDER	SHAPE	D	W	X	T	H	BOND	GRIT	CONCENTRATION	
	F105SG	125	5	4	23	20	MDT	D64	C75	

Individual tool configuration on request

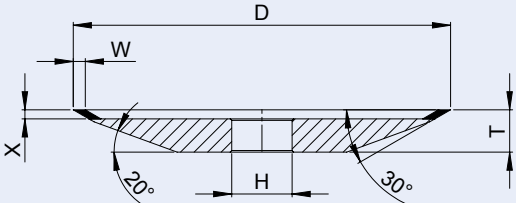
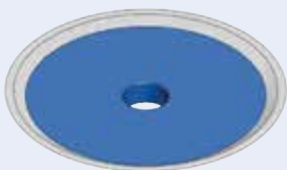
## 6A2G



SPECIFICATIONS	DIMENSIONS: D 150-250mm; W 4-10mm; X 2-10mm											
	BONDS: MDT (resin), MDX (metal)											
	APPLICATIONS: lateral/end face relief angle grinding, corner bevel grinding, face grinding, wedge angle grinding											
	MACHINE TYPE RECOMMENDATION: Göckel											
SAMPLE ORDER	SHAPE	D	W	X	T	H	E	K	BOND	GRIT	CONCENTRATION	
	6A2G	200	6	2	30	50	13	120	MDT	D91	C75	

Individual tool configuration on request

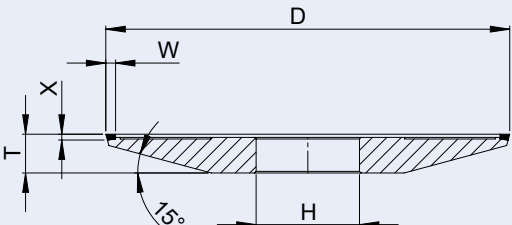
## F145SG



SPECIFICATIONS	DIMENSIONS: D 75-200mm; W 2-8mm; X 2-4mm									
	BONDS: MDT (resin)									
	APPLICATIONS: chip surface (tooth-face grinding)									
	MACHINE TYPE RECOMMENDATION: WIDMA, Akemat, Vollmer-Biberach, Vollmer-Dornhan									
SAMPLE ORDER	SHAPE	D	W	X	T	H	BOND	GRIT	CONCENTRATION	
	F145SG	125	8	4	12	25	MDT	D64	C75	

Individual tool configuration on request

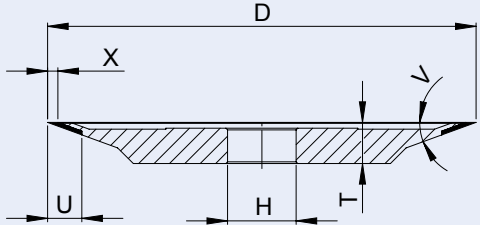
## F100SG



SPECIFICATIONS	DIMENSIONS: D 50-200mm; W 2-10mm; X 1-5mm									
	BONDS: MDT (resin)									
	APPLICATIONS: chip surface (tooth-face grinding)									
	MACHINE TYPE RECOMMENDATION: Walter AG, Akemat, Vollmer-Biberach, Vollmer-Dornhan, WIDMA									
SAMPLE ORDER	SHAPE	D	W	X	T	H	BOND	GRIT	CONCENTRATION	
	F100SG	100	5	2	10	20	MDT	D46	C50	

Individual tool configuration on request

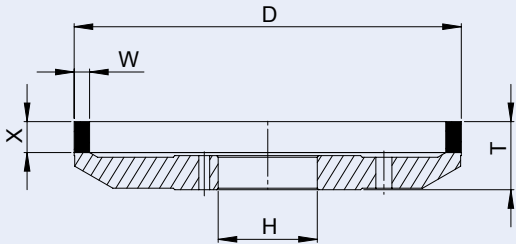
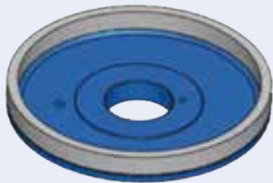
## F160SG



SPECIFICATIONS	DIMENSIONS: D 75-200mm; U 4-16mm; X 2-10mm									
	BONDS: MDT (resin)									
	APPLICATIONS: chip surface (tooth-face grinding)									
	MACHINE TYPE RECOMMENDATION: Walter AG, Akemat, Vollmer-Biberach, Vollmer-Dornhan, Universal tool grinding machine									
SAMPLE ORDER	SHAPE	D	U	X	V	T	H	BOND	GRIT	CONCENTRATION
	F160SG	75	7,1	2,3	45°	26	20	MDT	D64	C75

Individual tool configuration on request

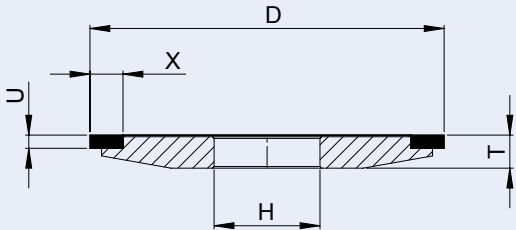
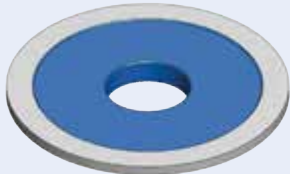
F190SG



SPECIFICATIONS	DIMENSIONS: D 75-125mm; W 2-6mm; X 3-10mm								
	BONDS: MDT (resin)								
	APPLICATIONS: top grinding								
	MACHINE TYPE RECOMMENDATION: Vollmer-Biberach, Vollmer-Dornhan, WIDMA								
SAMPLE ORDER	SHAPE	D	W	X	T	H	BOND	GRIT	CONCENTRATION
	F190SG	125	5	10	22	32	MDT	D126	C125

Individual tool configuration on request

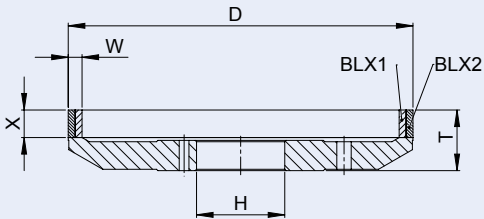
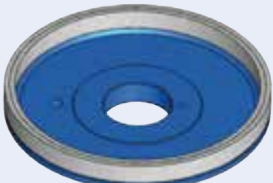
F240SG(1)



SPECIFICATIONS	DIMENSIONS: D 50-200mm; U 2-6,5mm; X 4-8mm								
	BONDS: MDT (resin)								
	APPLICATIONS: flank grinding								
	MACHINE TYPE RECOMMENDATION: WEINIG RONDAMAT, Walter AG, Akemat, Vollmer-Biberach, Vollmer-Dornhan, WIDMA								
SAMPLE ORDER	SHAPE	D	U	X	T	H	BOND	GRIT	CONCENTRATION
	F240SG(1)	100	6,5	4	14	20	MDT	D91	C50

Individual tool configuration on request

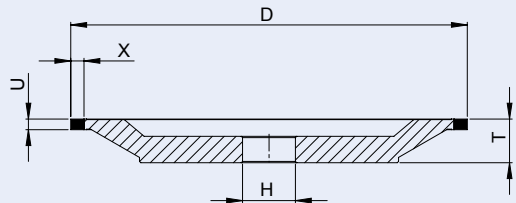
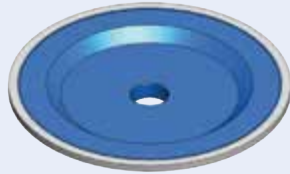
F190SG/A



SPECIFICATIONS	DIMENSIONS: D 75-125mm; W 2-6mm; X 3-10mm										
	BONDS: MDT (resin)										
	APPLICATIONS: top grinding										
	MACHINE TYPE RECOMMENDATION: Vollmer-Biberach, Vollmer-Dornhan, WIDMA										
SAMPLE ORDER	SHAPE	D	W	X	T	H	BOND	GRIT	CONCENTRATION		
								FACING			
								BLX1	BLX2	BLX1	BLX2
								D46	D126	C75	C100

Individual tool configuration on request

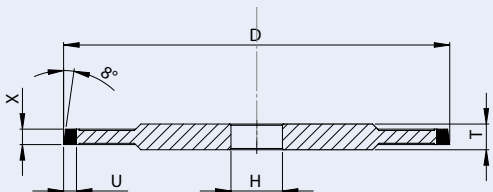
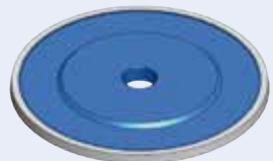
F240SG(2)



SPECIFICATIONS	DIMENSIONS: D 50-200mm; U 2-6,5mm; X 4-8mm								
	BONDS: MDT (resin)								
	APPLICATIONS: flank grinding								
	MACHINE TYPE RECOMMENDATION: WEINIG RONDAMAT, Walter AG, Akemat, Vollmer-Biberach, Vollmer-Dornhan, WIDMA								
SAMPLE ORDER	SHAPE	D	U	X	T	H	BOND	GRIT	CONCENTRATION
	F240SG(2)	100	4	4	16,5	20	MDT	D126	C85

Individual tool configuration on request

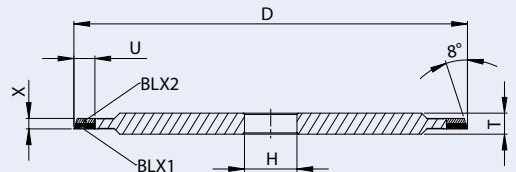
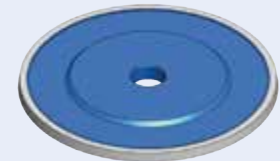
F240SG



SPECIFICATIONS	DIMENSIONS: D 50-200mm; U 2-6,5mm; X 4-8mm								
	BONDS: MDT (resin)								
	APPLICATIONS: flank grinding								
	MACHINE TYPE RECOMMENDATION: WEINIG RONDAMAT, Walter AG, Akemat, Vollmer-Biberach, Vollmer-Dornhan, WIDMA								
SAMPLE ORDER	SHAPE	D	U	X	T	H	BOND	GRIT	CONCENTRATION
	F240SG	127	5	7	8	32	MDT	D126	C100

Individual tool configuration on request

F240SG/A



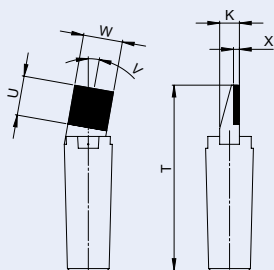
SPECIFICATIONS	DIMENSIONS: D 50-200mm; U 2-6,5mm; X 4-8mm										
	BONDS: MDT (resin)										
	APPLICATIONS: flank grinding										
	MACHINE TYPE RECOMMENDATION: WEINIG RONDAMAT, Walter AG, Akemat, Vollmer-Biberach, Vollmer-Dornhan, WIDMA										
SAMPLE ORDER	SHAPE	D	U	X	T	H	BOND	GRIT	CONCENTRATION		
								FACING			
								BLX1	BLX2	BLX1	BLX2
								D46	D107	C75	C100

Individual tool configuration on request



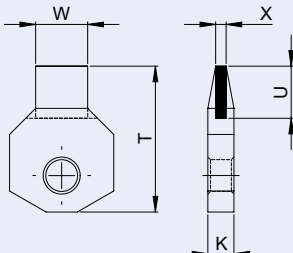
ACCESSORIES

Dresser APMK-SX



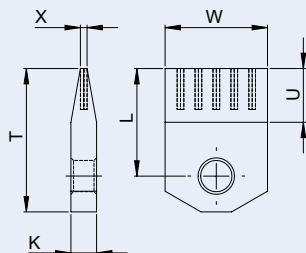
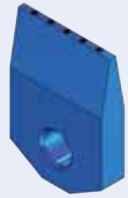
<b>X-NO.</b> 24031	<b>W</b> 10	<b>U</b> 10	<b>X</b> 1,5	<b>V</b> 10	<b>T</b> 47	<b>K</b> 5
<b>MOUNTING</b> MK1 - 30 mm	<b>ADDITIONAL INFORMATION</b> SW11 x 3 mm, 10° tilted left		<b>FOR GRINDING WHEEL GRIT</b> 80 – 120		<b>FOR GRINDING WHEELS</b> up to Ø 300 mm, width up to 30 mm	<b>PROCESSING OF</b> fused corundum

Dresser APMK-SX



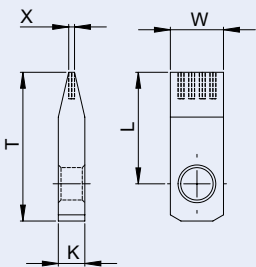
<b>X-NO.</b> 49237	<b>W</b> 10	<b>U</b> 10	<b>X</b> 2	<b>T</b> 28	<b>K</b> 5	
<b>MOUNTING</b> base body 20 mm x 20 mm	<b>ADDITIONAL INFORMATION</b> —		<b>FOR GRINDING WHEEL GRIT</b> 80 – 120		<b>FOR GRINDING WHEELS</b> up to Ø 300 mm, width up to 80 mm	<b>PROCESSING OF</b> fused corundum

Dresser APMK-SX



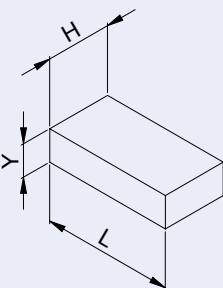
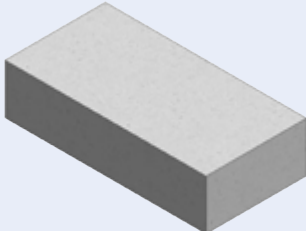
<b>X-NO.</b> 43445	<b>W</b> 20	<b>U</b> 10	<b>X</b> 1,3	<b>T</b> 28	<b>K</b> 5	<b>L</b> 21
<b>MOUNTING</b> —	<b>ADDITIONAL INFORMATION</b> —		<b>FOR GRINDING WHEEL GRIT</b> 46 – 80		<b>FOR GRINDING WHEELS</b> Ø > 600 mm, width up to 220 mm	<b>PROCESSING OF</b> fused corundum

Dresser APMK-SX



X-NO. 11402	W 10	X 1,1	T 28	K 5	L 21	
MOUNTING —	ADDITIONAL INFORMATION —		FOR GRINDING WHEEL GRIT 80 – 120		FOR GRINDING WHEELS Ø 300 mm, width up to 120 mm	PROCESSING OF fused corundum

Whetstones



<b>SPECIFICATIONS</b>	<b>DIMENSIONS:</b>	H 13-50mm; L 100-200mm; Y 13-160mm				
	<b>BONDS:</b>	—				
	<b>APPLICATIONS:</b>	sharpening				
<b>SAMPLE ORDER</b>	<b>SHAPE</b> SST	<b>H</b> 50	<b>L</b> 100	<b>Y</b> 25	<b>GRIT</b> 180	

Individual tool configuration on request

X-NO.	Colour	Material	Bond	Dimensions	Application	
					grit	DMD bond
12883	brown	silicon carbide	180	100x13x25	D30 - D91	MDX-665 / MDX587
12369	brown	silicon carbide	180	200x50x25	D30 - D91	MDX-665 / MDX587
11911	white	refined corundum	180	100x24x14	D/B54 up to D/B251	MDT, MDX
12252	white	refined corundum	180	100x50x25	D/B54 up to D/B251	MDT, MDX
12885	green/grey	silicon carbide	400	100x24x14	PKD Scheiben	MDR
12669	white	refined corundum	500	100x24x14	D10 - D30	PI
12886	orange	refined corundum	150	100x50x25	D/B54 up to D/B251	MDT, MDX
12889	green/mud	silicon carbide	1000	200x25x20	D5 - D20	MDX
13169	purple/mud	silicon carbide	25	200x25x20	D30 - D91	MDX-665 / MDX587
13936	blue	refined corundum	151	100x25x13	D30 - D91	MDX-665 / MDX587

Dresser APMK-SX

X-NO.  
11458

W  
10

X  
0,8

T  
28

K  
5

L  
21

MOUNTING  
—

ADDITIONAL INFORMATION  
—

FOR GRINDING WHEEL GRIT  
80 – 120

FOR GRINDING WHEELS  
Ø 300 mm, width up to 80 mm

PROCESSING OF  
fused corundum



Dresser APMK-SX

X-NO.  
11784

W  
10

U  
15

X  
1,5

T  
33

K  
5

L  
26

MOUNTING  
—

ADDITIONAL INFORMATION  
—

FOR GRINDING WHEEL GRIT  
120 and finer

FOR GRINDING WHEELS  
up to Ø 300, width up to 80 mm

PROCESSING OF  
fused corundum



Dresser APMK-SX

X-NO.  
43522

W  
10

U  
10

X  
1,5

T  
28

K  
5

L  
21

MOUNTING  
—


ADDITIONAL INFORMATION  
—

FOR GRINDING WHEEL GRIT  
120 and finer

FOR GRINDING WHEELS  
up to Ø 300, width up to 80 mm

PROCESSING OF  
fused corundum



Dresser APMK-SX

X-NO.  
38034

W  
20

X  
1

T  
28

K  
5

L  
21

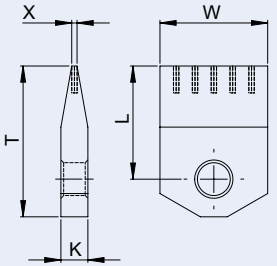
MOUNTING  
—


ADDITIONAL INFORMATION  
—

FOR GRINDING WHEEL GRIT  
120 and finer

FOR GRINDING WHEELS  
Ø > 600, width up to 220 mm

PROCESSING OF  
fused corundum



Dresser APMK-SX

X-NO.  
36439

W  
15

U  
15

X  
1,3

V  
10

T  
43

K  
5

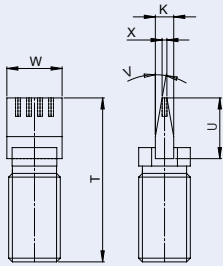
MOUNTING  
outside thread  
M14 x 1


ADDITIONAL INFORMATION  
SW14 x 5 mm

FOR GRINDING WHEEL GRIT  
46 – 80

FOR GRINDING WHEELS  
Ø von 300 mm – 600 mm,  
width up to 150 mm

PROCESSING OF  
fused corundum



Dresser APN

X-NO.  
22537

W  
10

U  
15

X  
1,8

T  
54

K  
5

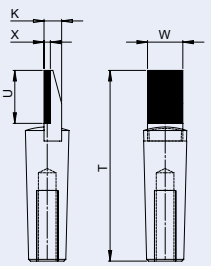
MOUNTING  
MK1 - 31 mm

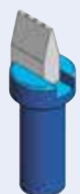
ADDITIONAL INFORMATION  
—

FOR GRINDING WHEEL GRIT  
46 – 80

FOR GRINDING WHEELS  
Ø 150 mm – 500 mm,  
width 100m – 200 mm

PROCESSING OF  
silicon carbide



Dresser APMK-SX

X-NO.  
30672

W  
10

U  
15

X  
0,8

T  
43

K  
5

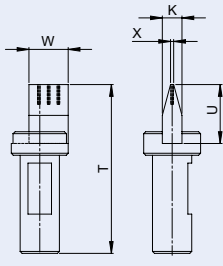
MOUNTING  
shaft dimension  
10 mm x 25 mm

ADDITIONAL INFORMATION  
SW9 x 13 mm

FOR GRINDING WHEEL GRIT  
80 – 120

FOR GRINDING WHEELS  
up to Ø 300, width up to 80 mm

PROCESSING OF  
fused corundum



Dresser APN

X-NO.  
15210

W  
20

U  
10

X  
1,8

T  
60

K  
5

MOUNTING  
MK1 - 40 mm

ADDITIONAL INFORMATION  
SW11 x 6 mm

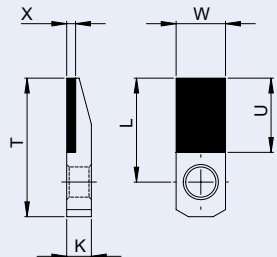
FOR GRINDING WHEEL GRIT  
46 – 80

FOR GRINDING WHEELS  
Ø ≥ 500 mm,  
width 200 mm – 350 mm

PROCESSING OF  
silicon carbide

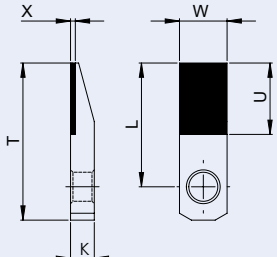


Dresser APN-SX



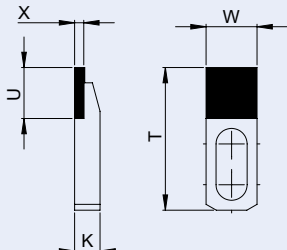
X-NO. 19807	W 10	U 15	X 1,8	T 28	K 5	L 21	
MOUNTING —	ADDITIONAL INFORMATION —		FOR GRINDING WHEEL GRIT 46 – 80		FOR GRINDING WHEELS Ø 150 mm – 500 mm, width 100 mm – 200 mm		PROCESSING OF silicon carbide

Dresser APS



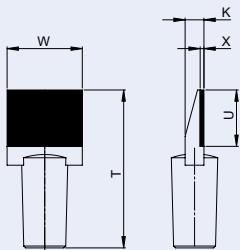
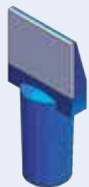
X-NO. 11893	W 10	U 15	X 1	T 33	K 5	L 26	
MOUNTING —	ADDITIONAL INFORMATION —		FOR GRINDING WHEEL GRIT 80 and finer		FOR GRINDING WHEELS Ø 150 mm – 500 mm, width 100 mm – 200 mm		PROCESSING OF fused corundum

Dresser APN-SX



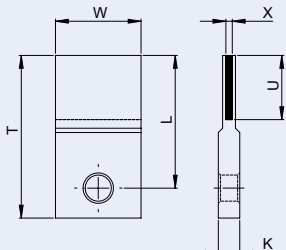
X-NO. 11070	W 10	U 10	X 1,8	T 28	K 5		
MOUNTING —	ADDITIONAL INFORMATION slotted hole, 3 mm offset		FOR GRINDING WHEEL GRIT 46 – 80		FOR GRINDING WHEELS Ø 150 mm – 500 mm, width 100 mm – 200 mm		PROCESSING OF silicon carbide

Dresser APS



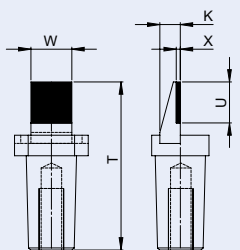
X-NO. 12022	W 20	U 15	X 1	T 42	K 5	
MOUNTING MK1 - 19 mm	ADDITIONAL INFORMATION —		FOR GRINDING WHEEL GRIT 80 and finer		FOR GRINDING WHEELS Ø ≥ 500 mm, width 200 mm – 350 mm	PROCESSING OF fused corundum

Dresser APN/Z



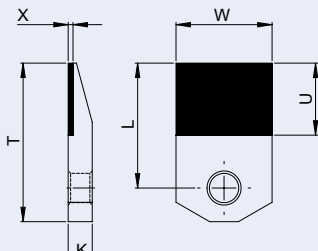
X-NO. 11452	W 20	U 15	X 1,5	T 38	K 5	L 31	
MOUNTING —	ADDITIONAL INFORMATION —		FOR GRINDING WHEEL GRIT 46 – 80		FOR GRINDING WHEELS Ø ≥ 500 mm, width 200 mm – 350 mm		PROCESSING OF fused corundum

Dresser APS-SX



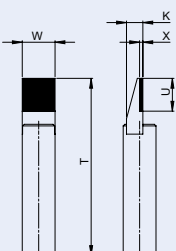
X-NO. 15044	W 10	U 10	X 1	T 41	K 5		
MOUNTING MK1 - 19 mm	ADDITIONAL INFORMATION SW14 x 5 mm		FOR GRINDING WHEEL GRIT 80 and finer		FOR GRINDING WHEELS Ø 150 mm – 500 mm, width 100 mm – 200 mm		PROCESSING OF fused corundum

Dresser APS



X-NO. 11617	W 20	U 15	X 1	T 33	K 5	L 26	
MOUNTING —	ADDITIONAL INFORMATION —		FOR GRINDING WHEEL GRIT 80 and finer		FOR GRINDING WHEELS Ø ≥ 500 mm, width 200 mm – 350 mm		PROCESSING OF fused corundum

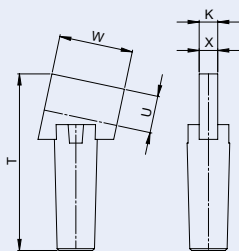
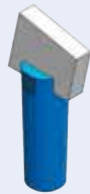
Dresser APS-SX



X-NO. 65965	W 10	U 10	X 1	T 54	K 5
MOUNTING shaft dimension 10 mm x 40 mm	ADDITIONAL INFORMATION —	FOR GRINDING WHEEL GRIT 80 and finer		FOR GRINDING WHEELS Ø 150 mm – 500 mm, width 100 mm – 200 mm	PROCESSING OF fused corundum

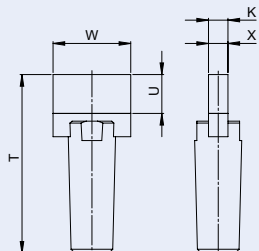
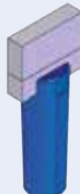


Dresser APS/Z



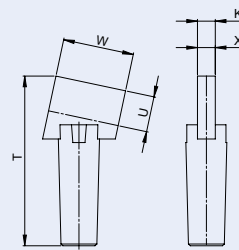
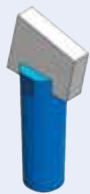
X-NO. 35417	W 20	U 10	X 5	T 45,6	K 5	K —
MOUNTING MK1 - 28 mm - 12°	ADDITIONAL INFORMATION SW11 x 5 mm	FOR GRINDING WHEEL GRIT 80 – 120	FOR GRINDING WHEELS Ø ≥ 500 mm, width 200 mm – 350 mm	PROCESSING OF fused corundum		

Dresser APS/Z-SX



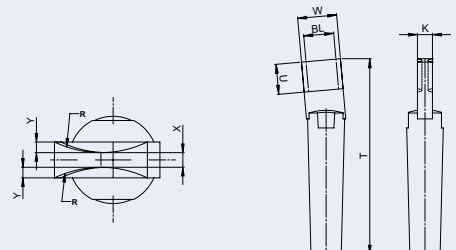
X-NO. 15170	W 20	U 10	X 5	T 46	K 5	
MOUNTING MK1 - 28 mm	ADDITIONAL INFORMATION SW11 x 5 mm	FOR GRINDING WHEEL GRIT 36 – 60	FOR GRINDING WHEELS Ø ≥ 500 mm, width 200 mm – 350 mm	PROCESSING OF fused corundum		

Dresser APS/Z



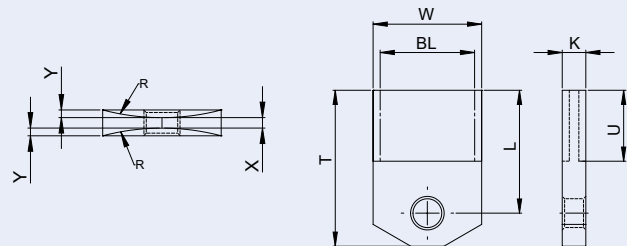
X-NO. 11446	W 20	U 10	X 5	T 46	K 5	
MOUNTING MK1 - 28 mm	ADDITIONAL INFORMATION SW11 x 5 mm, 12° tilted	FOR GRINDING WHEEL GRIT 36 – 60	FOR GRINDING WHEELS Ø ≥ 500 mm, width 200 mm – 350 mm	PROCESSING OF fused corundum		

Dresser APS/Z-SX



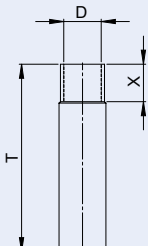
X-NO. 14069	W 13	U 10	X 1	R 15	T 65	K 5	Y 1,48
MOUNTING MK1 - 40 mm	ADDITIONAL INFORMATION SW11 x 6 mm, 5° tilted	FOR GRINDING WHEEL GRIT 80 and finer	FOR GRINDING WHEELS Ø 150 mm – 500 mm, width 100 mm – 200 mm	PROCESSING OF silicon carbide			

Dresser APS/Z



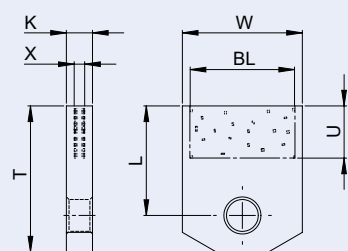
X-NO. 14296	W 23	U 15	X 1	R 45	T 33	K 5	L 26	Y 1,49	BL 20
MOUNTING —	ADDITIONAL INFORMATION —	FOR GRINDING WHEEL GRIT 80 and finer	FOR GRINDING WHEELS Ø ≥ 500 mm, width 200 mm – 350 mm	PROCESSING OF silicon carbide					

Dresser TK



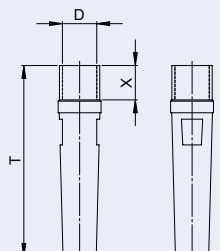
X-NO. 12021	D 8	X 8	T 40		
MOUNTING shaft dimension 10 mm x 32 mm	ADDITIONAL INFORMATION —	FOR GRINDING WHEEL GRIT 60 – 80	FOR GRINDING WHEELS Ø ≥ 400, width up to 40 mm	PROCESSING OF fused corundum	

Dresser APS/Z-SX



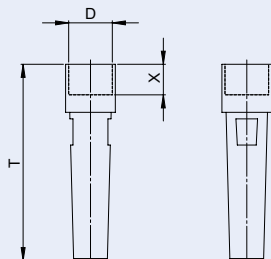
X-NO. 15488	W 23	U 10	X 2	T 28	K 5	L 21	BL 20
MOUNTING —	ADDITIONAL INFORMATION —		FOR GRINDING WHEEL GRIT 80 and finer		FOR GRINDING WHEELS Ø ≥ 500 mm, width 200 mm – 350 mm		PROCESSING OF fused corundum

Dresser TK-SX



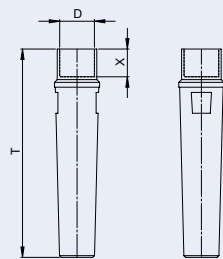
X-NO. 16899	D 8	X 8	T 45		
MOUNTING MK0 - 25,5 mm	ADDITIONAL INFORMATION SW8 x 6 mm	FOR GRINDING WHEEL GRIT 60 – 80	FOR GRINDING WHEELS Ø ≥ 400, width up to 40 mm	PROCESSING OF silicon carbide	

Dresser VS-SX



X-NO. 12529		D 10	X 7	T 45	
MOUNTING MK0 - 25,5 mm	ADDITIONAL INFORMATION SW8 x 6 mm	FOR GRINDING WHEEL GRIT 36 – 46		FOR GRINDING WHEELS up to Ø 400 mm, width up to 250 mm	PROCESSING OF silicon carbide

Dresser VS-SX



X-NO. 17011		D 10	X 7	T 60		
MOUNTING MK1 - 40 mm	ADDITIONAL INFORMATION SW11 x 6 mm		FOR GRINDING WHEEL GRIT 36 – 46		FOR GRINDING WHEELS up to Ø 400 mm, width up to 250 mm	PROCESSING OF silicon carbide

GENERAL INFORMATION

Diamond	90
CBN	90
Application range for diamond and CBN wheels	91
Selection criteria for diamond and CBN wheels	91
1. Shape	91
2. Dimensions	92
3. Diamond and CBN grit sizes	93
4. Bonds	94
5. Concentration	94
6. Order information	95
7. Guidelines for the usage of diamond and CBN wheels	97

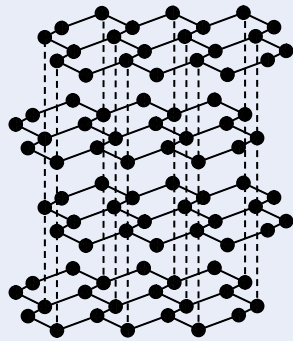
Diamond

Due to its hardness, diamond is an ideal abrasive for very hard materials. Almost 90 % of the diamonds nowadays used in grinding tools are manufactured synthetically. The basic material is graphite which is transformed into the crystal lattice of the diamond with the aid of pressure and temperature in the presence of catalysts. On account of the controlled synthesis, it is possible to produce diamonds with specific grinding properties for the most diverse bonding systems and grinding operations.

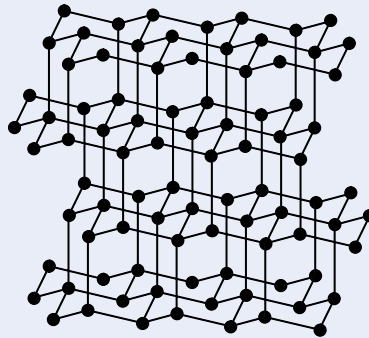
While the diamonds in metal bonds are typically used without a coating, diamonds coated in nickel and copper are used for resin bonds in the majority of cases. It is primarily the uneven surface of these coats which reinforces the fixation of the diamonds in the bonds and accelerates heat dissipation

Synthetic diamonds are produced in diverse qualities and grit sizes.

CRYSTAL LATTICE OF GRAPHITE



CRYSTAL LATTICE OF DIAMOND



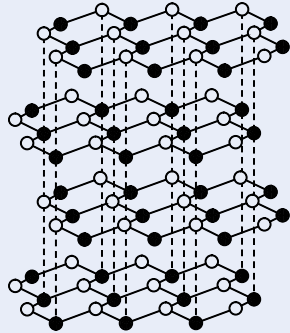
● = Carbon atoms

CBN

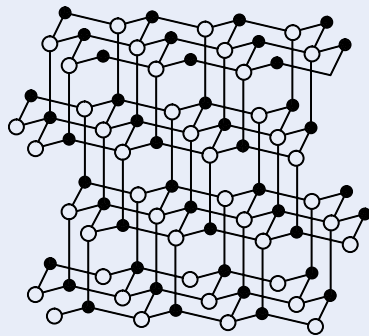
Cubic crystalline boron nitride presently is the second hardest material after diamonds. It is synthesised from hexagonal boron nitride (a nitrogen boron compound) under pressure and temperature in the presence of catalysts, in a manner similar to the synthesis of diamonds.

Cubic crystalline boron nitride is also available in diverse qualities and grit sizes and with a nickel coating. The preferred application of CBN is the grinding of HSS grades and hardened steels.

CRYSTAL LATTICE OF HEXAGONAL BORON NITRIDE



CRYSTAL LATTICE OF CUBIC BORON NITRIDE



● = Boron atoms ○ = Nitrogen atoms

Application range  
for diamond and CBN wheels

DIAMOND WHEELS ARE USED FOR  
THE GRINDING OF:

- ♦ Carbide
- ♦ Cermet
- ♦ Carbide/steel combinations
- ♦ Glass
- ♦ Sapphire
- ♦ Quartz
- ♦ Ceramic materials of all kinds
- ♦ Ferrotitanite
- ♦ Carbide-based powder coatings
- ♦ Graphite
- ♦ Polycrystalline diamond and CBN blanks
- ♦ Ceramic magnetic materials
- ♦ Glass-fibre and carbon-fibre reinforced synthetic materials
- ♦ Tungsten carbide

CBN WHEELS ARE USED FOR  
THE GRINDING OF:

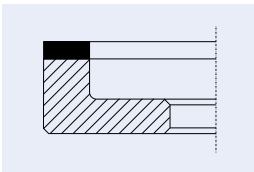
- ♦ Hardened high-speed steels (HSS)
- ♦ High-alloyed tool steels with at least 55 HRC
- ♦ Case-hardened steels
- ♦ Iron-based powder coatings
- ♦ Chilled casting
- ♦ Soft steels in certain applications
- ♦ Stellite
- ♦ Surgical steel
- ♦ PM steels

Selection criteria  
for diamond and CBN wheels

Below, we have compiled the most important selection criteria for diamond and CBN wheels.

1. SHAPE

The shape of the various diamond/CBN wheels is expressed by a combination of figures and letters. (e.g. 6 A 2)



The basis for this designation system is the FEPA standard (Fédération Européenne des Fabricants de Produits Abrasifs / cf. also DIN standard 69800 and following). First, choose the wheel shape suited for your grinding job. The standard shapes are compiled in the table of wheel shapes on pages 26 – 35. If you require different shapes, this can be done any time. In that event, please let us have your sketch or drawing.

As a rule, the shape is determined by the workpiece, the machine and the grinding method. We recommend using a wheel shape which is as stable as possible to avoid oscillations during grinding. The carriers for the grinding wheels are made of different materials, depending on the bonds.

BOND	BODY MATERIAL
Resin bond (MDT)	Aluminium
	Aluminium synthetic resin
	Graphite synthetic resin
Metal bond (MDX)	Steel
	Bronze
Vitrified bond (MDR)	Aluminium
	Steel
Electroplated bond (MDS)	Aluminium
	Steel

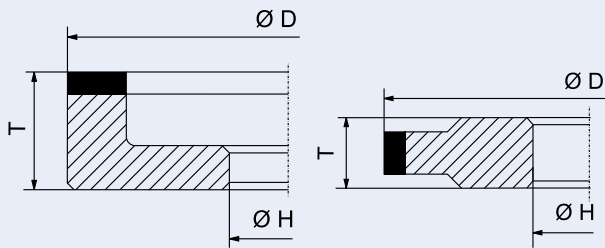
We select the suitable wheel carrier, corresponding to the wheel shape as well as the thermal stress and mechanical load.



2. DIMENSIONS

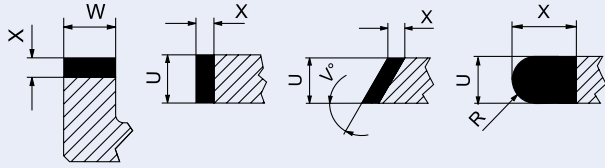
**THE MOST IMPORTANT DIMENSIONS FOR A DIAMOND/CBN WHEEL ARE:**

- ♦ the diameter **D**
- ♦ the total height **T**
- ♦ the hole **H**



**AND THE DIMENSIONS OF THE DIAMOND/CBN LAYER:**

- ♦ the width of the layer **W** or **U**
- ♦ the layer depth **X**
- ♦ the profile angle **V°**
- ♦ the radius **R**



2A. DIAMETER D

Determine the diameter in accordance with the grinding operation you have to perform, your machine and our cutting speed recommendations on page 98. The larger the wheel diameter, the more economically you will grind, thanks to the then more favourable thermal and kinematic conditions. You will find the possible dimensions among the individual shapes.

2B. TOTAL HEIGHT T

This dimension, in general, is determined depending on the diameter and layer dimensions. Deviations are possible, however, for cases of limited space in the machine or on the workpiece. When placing your order, please point this out by providing exact space requirements.

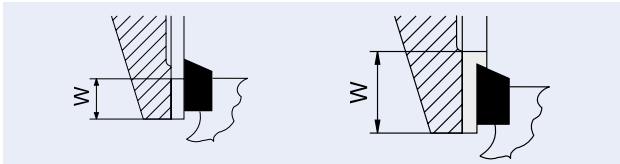
2C. BORE H

We manufacture the bores of our diamond and CBN wheels conforming to quality H6. For an extra charge, we are also prepared to deliver our wheels with individual bore dimensions.

2D. LAYER WIDTH W AND U

The layer widths W for front end layers and U for peripheral layers depend on the grinding operation to be performed. On principle, when grinding with diamond or CBN wheels, the contact surfaces should be as small as possible. Small layers allow faster and cooler grinding with cup wheels and plate-shaped wheels. The chip flow is better, and the wheel gives a feeling of improved performance. A broader layer is preferable in free-hand grinding, since better guidance is provided.

The layer width should always be smaller than the workpiece to be ground.



If the layer width is larger than the workpiece to be ground, a shoulder is formed in the layer, which damages the cutting edges.

2E. LAYER DEPTH X

Always choose a large X-dimension. The manufacturing costs are almost the same – whether the wheel has a layer depth of, e.g. X = 2 or 4 or 6 mm. The price difference then results solely from the different diamond or CBN content. Bigger layer depths are thus considerably more economical.

2F. PROFILE ANGLE V°

Please note the angle position with wheel type 1V1/14V1. The angle indication always relates to the angle formed – see drawing on page 42 and 51.

2G. RADIUS R

For the wheel shapes 1FF1 and 14F1 (page 40 and 49), we have restricted ourselves to the most common radii. However, particularly with type 14F1, almost all wheel diameters and intermediate radius sizes can be manufactured.

3. DIAMOND AND CBN GRIT SIZES

In order to meet the various grinding requirements, a great number of sizes are available. These sizes have been compiled in a standard by the FEPA (Fédération Européenne des Fabricants de Produits Abrasives). The same grit sizes apply for diamond and CBN. Diamond grit is identified by a preceding D (e.g. D 126), CBN by a B (e.g. B 126).

The sizes shown in Table 1 are mesh sizes. For comparison, we have also included the American standard ASTM E11.

Below the mesh grit sizes D46/B46, the series is continued by the fine grits. Grading is essentially done by charging with water.

The grit size determines both the removal rate of diamond and CBN wheels and the surface quality that can be achieved on the workpiece. A higher removal rate is generally obtained with coarser grit sizes. With finer grit sizes, the grinding quality is improved but the removal rate is reduced.

MESH GRIT SIZES\*)

FEPA / DIN STANDARD						U.S. STANDARD ASTM E11 (MESH)	
DIAMOND		CBN		NOMINAL MESH WIDTH IN µm ISO R565 - 1990		DIAMOND AND CBN	
NARROW	WIDE	NARROW	WIDE	NARROW	WIDE	NARROW	WIDE
D1181	D1182			1180/1000	1180/850	16/18	16/20
D1101				1000/850		18/20	
D851	D852			850/710	850/600	20/25	20/30
D711	D711			710/600		25/30	
D601	D602			600/500	600/425	30/35	30/40
D501	500/425	35/40					
D426	D427	B426	B427	425/355	425/300	40/45	40/50
D356		B356		355/300		45/50	
D301		B301		300/250		50/60	
D251	D252	B251	B252	250/212	250/180	60/70	60/80
D213		B213		212/180		70/80	
D181		B181		180/150		80/100	
D151		B151		150/125		100/120	
D126		B126		125/106		120/140	
D107		B107		106/90		140/170	
D91		B91		90/75		170/200	
D76		B76		75/63		200/230	
D64		B64		63/53		230/270	
D54		B54		53/45		270/325	
D46		B46		45/38		325/400	

FINE GRIT SIZES\*)

DIAMOND		CBN	
DR. MÜLLER DESIGNATION	AVERAGE GRIT SIZE RANGE IN µm	DR. MÜLLER DESIGNATION	AVERAGE GRIT SIZE RANGE IN µm
D35	30 – 40		
D30	25 – 35	B30	25 – 35
D20	15 – 25		
D15	10 – 20	B15	10 – 20
D9	6 – 12	B9	6 – 12
D6	4 – 8		
D5	4 – 6		
D3	2 – 4		

\*) Sometimes there is a deviation between the grit size ordered by you and the grit size confirmed by us due to our computer-generated average values. This is caused by our IT system, which automatically calculates the grit size for the technical definition of the tool. Since the fine grit sizes consist of different grit size classes, our IT system calculates and confirms the average value of the corresponding grit size class. As a result, our confirmed grit sizes will sometimes deviate from those in your order. However, we assure you with 100 % certainty that we will produce and supply your product with the grit sizes you have requested. Please consider the fact that not every grit size is available. Also, not all grit grades are suitable for all bonds.

4. BONDS

The grinding behaviour of diamond and CBN wheels essentially depends on the bond. It is the bond's job to optimally hold the grinding grit at the grinding temperatures and forces that occur, whilst simultaneously providing enough space for the chips so as to permit an easy discharge of the abraded material. A large range of bonds is required in view of the great number of grinding problems that occur: resin bonds, metal bonds, electroplated bonds, ceramic bonds.

4A. RESIN BONDS (MDT)

More than 50 % of all grinding operations can be carried out by means of resin bonds, since they support many bonding variants and high removal rates on the workpiece.

4B. METAL BONDS (MDX)

Metal bonds distinguish themselves with very high grit holding forces. High infeed forces are required for the continuous self-sharpening of blunted diamond tips, resulting in increased heat amount. Therefore, metal bonds always have to be used in wet grinding. Dry grinding is possible only for small contact areas and light cuts (profile grinding on PETEWE, Hommel and Loewe).

4C. CERAMIC BONDS (MDR)

These bonds are distinguished by porosity and profiling capability. At present, we are manufacturing only a selection of the shapes and dimensions contained in this catalogue, and therefore request your inquiry in case of need.

4D. ELECTROPLATED BONDS (MDS)

In the nickel bond deposited by electro-plating usually only one grit layer of diamond or CBN is held firm (2 or 3 layers are contingently possible). The electroplated S-bond with diamond as abrasant is particularly suited for machining less hard materials which are subject to wear, however, such as graphite, mineral or glass-fibre reinforced synthetic materials, and the like. A special field of application of the S-bond with CBN as abrasive is the grinding of profiles in the construction of turbines.

5. CONCENTRATION

By international agreement, the basis for indicating concentration is the value C100, corresponding to 25 % by volume of pure diamond or CBN within the abrasive layer.

Thus the following formula applies for diamond and CBN:  
C100 = 25 %vol = 4.4 carats/cm³ of grinding wheel layer; 1 ct = 0.2 g

We manufacture diamond and CBN wheels in the following common concentrations:

CONCENTRATION	PROCESSED CARAT WEIGHT / cm³ OF GRINDING WHEEL LAYER	VOLUME %
C200	8,8 ct	50
C175	7,7 ct	43,75
C165	7,3 ct	41,25
C150	6,6 ct	37,5
C135	5,9 ct	33,75
C125	5,5 ct	31,75
C115	5,1 ct	28,75
C100	4,4 ct	25,0
C90	4,0 ct	22,5
C85	3,7 ct	21,25
C80	3,5 ct	20,0
C75	3,3 ct	18,75
C68	3,0 ct	17,0
C65	2,8 ct	16,25
C60	2,6 ct	15,0
C55	2,4 ct	13,75
C50	2,2 ct	12,5
C45	2,0 ct	11,25
C38	1,7 ct	9,5
C35	1,5 ct	8,75
C25	1,1 ct	6,25
C20	0,9 ct	5,0
C15	0,7 ct	3,75
C10	0,4 ct	2,5

CBN wheels with the following concentrations are also available on request:

CONCENTRATION	PROCESSED CARAT WEIGHT / cm³ OF GRINDING WHEEL LAYER	VOLUME %
V360	6,26 ct	35,6
V300	5,22 ct	29,7
V240	4,17 ct	23,7
V210	3,65 ct	20,8
V180	3,13 ct	18,0
V150	2,61 ct	14,8
V120	2,09 ct	11,9
V90	1,75 ct	8,9

The concentration on the one hand largely determines the price, but on the other hand also the overall grinding behaviour of the wheel. An optimal relationship between wheel dimension, grit size, bond and concentration is crucial. Higher concentrations (C100-C125-C150/V240-V360) are appropriate when high profile stability is required, for narrow layer widths, for high bonding hardness and in deep cutting. Average concentrations (C50-C75/V120-V180) are recommended with cup wheels and peripheral wheels having larger layer widths and finer grit sizes. Lower concentrations (C38-C50/V120) are primarily used with very fine grit sizes.

6. ORDER INFORMATION

OUR LABEL FOR YOUR TOOL:

Since the introduction of our slogan "We personalise your tools!", our focus has been on achieving improved reliability, greater transparency and easier communication between you and Dr. Müller DIAMANTMETALL®. All of our tools now feature a new and unique label. This guarantees the highest quality.

OUR LABEL HAS THE FOLLOWING BENEFITS FOR YOU:

- ♦ FULL TRANSPARENCY of the grinding wheel configuration
- ♦ CLEAR TRACEABILITY of technical improvements
- ♦ HIGH RELIABILITY for ordering items
- ♦ EASY COMMUNICATION due to clear identification

MDR-319 ES / B126 / C150

1

2

3

4

1

The letters "MD" stand for a genuine Dr. Müller DIAMANTMETALL® tool

2

The combination of numbers and letters stands for the type of bond and the mixture of grit grade and grit quality

3

The combination of numbers and letters defines the size of the CBN or diamond grit\*)

4

The combination of numbers and letters defines the concentration of the CBN or diamond grit\*)

The "Dr. Müller DIAMANTMETALL® CARD" provides you with an overview of the new label's structure. In this handy format, you always have the new label design close at hand!

PLEASE FEEL FREE TO ORDER THIS CARD FROM US!

Telephone: +49 (0) 881 / 90 11 550

Fax: +49 (0) 881 / 90 11 55100

vertrieb@muedia.de

LETTER COMBINATIONS FOR GRIT GOODNESS AND GRIT QUALITY		
GRIT GOODNESS	GRIT QUALITY	COMBINATIONS
G(enius)	S(tandard) or P(rofessional)	GS or GP
C(uda)	S(tandard) or P(rofessional)	CS or CP
A(tlantis)	S(tandard) or P(rofessional)	AS or AP
T(esla)	S(tandard) or P(rofessional)	TS or TP
R(azor)	S(tandard) or P(rofessional)	RS or RP
E(dison)	S(tandard) or P(rofessional)	ES or EP

\*) Our label, which is automatically and electronically generated, contains the factors "grain grade" and "grain quality". These two factors can individually affect the specified grain size and concentration. This may result in a differing technical description of our tool, as compared to your order or request. We ensure you with 100 % certainty, however, that we always manufacture and deliver your product with your desired configuration.

94

95

GENERAL INFORMATION

**THE BIOMETRY OF YOUR ORDER IS YOUR X-NUMBER.**

The nice thing about an X-number order is that it saves you time!

We would like to briefly explain how.

**YOUR FIRST ORDER**

We engrave your unique x-number in addition to our tool label on every one of your tools. All of the technical details and the manufacturing process which our technician worked out for you with your first order of this tool are stored behind this x-number.

**YOUR SECOND ORDER WITH YOUR X-NUMBER**

Enter your X-number to order the same tool again today. This tool is then sent directly to the production department without any de-tours. The time-intensive processing by our technical department and a calculation by our sales department are not required in this case. This saves you time!

**INFORMATION FOR ENGRAVING YOUR TOOL**

- 1 Technically defined tool labeling
- 2 Serial number
- 3 Your X-number / article number
- 4 Customer material number (at customer request)
- 5 Technical safety requirements
- 6 Brand name of a Dr. Müller DIAMANTMETALL® HighTec bond

## 7. GUIDELINES FOR THE USE OF DIAMOND AND CBN WHEELS

### 7A. MACHINE

All of the grinding machines for diamond and CBN wheels should be of a highly sturdy design, be equipped with properly running grinding spindles and wheel mounts, and be set up for vibration-free operation. Diamond and CBN wheels operated without proper peripheral and transversal concentricity achieve only low abrading performance and a poor surface finish since only a portion of the diamond or CBN layer makes contact, and this portion is then quickly overloaded. The motor output must be adjusted in such a way that higher cutting speeds can also be used and that no substantial loss of speed occurs, even when infeed is high. All of the machine guides must operate without backlash. During deep grinding, i.e. at low feed speed but high surface pressure, the bench must operate without jolting. Coolant pumps, the inlet nozzle and the volume must be configured to ensure a strong coolant flow, especially for deep grinding.

### 7B. MOUNTING OF DIAMOND AND CBN WHEELS

Diamond and CBN wheels should have proper concentricity and axial run-out to ensure superior abrading performance and a high quality surface finish. The wheels that are ground to a concentricity and axial run-out of 0.01 – 0.02 mm are supplied in balanced form, and they should be attached to the wheel mount as follows:

- ♦ Check wheel mount on the spindle with a dial gauge for true running in the peripheral and transversal directions. Correct any errors.
- ♦ Slide the diamond or CBN wheel onto the mount. Tighten the mount slightly and check wheel running with a dial gauge.
- ♦ Eliminate any radial runout due to bore clearance by lightly tapping on a piece of wood placed on the mount. Tighten the mount firmly and check it again with the dial gauge.

In case of large diamond and CBN wheels, and especially profile wheels, we recommend that you send us the mount and the matching grinding or balancing mandrel so that we can grind the wheels directly on the mount, keeping true running deviations within the tightest limits. All diamond and CBN wheels should remain on their mounts until they completely wear out to avoid concentricity deviations due to the change of mounts.

### 7C. COOLING

#### Wet grinding:

Wet grinding is preferable for almost all grinding tasks with diamond and CBN wheels. A sufficient quantity of the coolant under pressure should be supplied directly to the grinding position. This dissipates the machining heat generated during the grinding process, washes away the machined material and increases the life of the grinding wheel.

Emulsions with a mixing ratio of 1:50 to 1:100 result in the best removal rate and longest life for diamond grinding wheels. For mechanical engineering reasons, oil is also generally used as a coolant in addition to emulsions on CNC machines. However, the cooling effect is considerably reduced with oil.

CBN grinding wheels are used both with oil and emulsion, and low-viscosity oils (viscosity ~4) produce the best grinding results. It is often necessary to use both diamond and CBN wheels for wet grinding on a single machine. Using a low-viscosity grinding oil as the cooling medium is recommended here. However, somewhat slower infeed rates and a reduced life of the diamond grinding wheels must be expected in this case.

Special attention should be paid to optimal filtering of the cooling medium, since this has a considerable influence on the life of the grinding wheel and the surface quality of the workpiece. With grinding oils in particular, the temperature needs to be monitored as well. Additional cooling may need to be implemented, since the oil is intended not only as a lubricant but also as a coolant.

Paying adequate attention to the choice of coolant is recommended, since grinding wheel costs can be considerably reduced by using a good cooling medium. Diamond and CBN wheels with a bond designed for wet grinding should only be used for dry grinding in exceptional cases, and then only with a reduced rotational speed and infeed.

#### Dry grinding:

Due to their characteristics, grit quality and bond composition, diamond and CBN wheels engage well and keep their soft grinding capacity even in dry grinding. The applied contact pressures and infeeds, however, should be lower than those used for wet grinding. Those diamond and CBN wheels with bonds designed for dry grinding may also be used for wet grinding.



## 7D. DRESSING AND SHARPENING DIAMOND AND CBN WHEELS

Dressing means restoring the running accuracy of a diamond or CBN wheel.

**THE FOLLOWING OPTIONS ARE AVAILABLE:**

## Dressing of cup wheels

Pulverized silicon carbide of 80 – 120 mesh is strewn onto a steel plate, and the diamond or CBN wheel is moved over it under slight pressure, thereby partially removing the bond and exposing the grinding grit.

## Dressing of peripheral wheels

There are several methods for achieving this:

- ◆ Dressing by centrifugal force braking device
- ◆ Dressing with ST37 workpieces
- ◆ Dressing with galvanic diamond stripping tools

Following application of the dressing methods described above, it is imperative that the diamond or CBN wheel still be sharpened, i.e. that the bond be retracted so as to expose the grinding grit.

The best way to do this:

- ◆ In case of resin-bonded wheels:  
using our whetstone No. 2 or No. 5
- ◆ In case of metal-bonded wheels:  
using our whetstone No. 6
- ◆ Stone no. 8 is recommended  
for fine grit sizes.

The wheels have reached an optimal degree of sharpness  
if your fingernail catches on the grinding grit ("fingernail test").

## 7E. CUTTING SPEEDS FOR DIAMOND AND CBN WHEELS

The cutting speeds indicated in the table below are values from practical experience which should be observed as far as possible. With special materials or grinding methods, different cutting speeds may give optimal results. Thus variable speed adjustment is advantageous for obtaining a high grinding performance and superior grinding quality.

## 7F. MATERIAL REMOVAL RATE

The material removal rate is the material volume removed in a unit of time, expressed in ( $\text{mm}^3/\text{s}$ ). The specific material removal rate  $Q'$  is calculated on 1 mm of contact width [ $\text{mm}^3/(\text{s} \cdot \text{mm})$ ].

## CUTTING SPEEDS

REVOLUTIONS PER MINUTE AT A CUTTING SPEED OF									
Ø MM	10 M/SEC.	15 M/SEC.	20 M/SEC.	25 M/SEC.	30 M/SEC.	35 M/SEC.	40 M/SEC.	45 M/SEC.	50 M/SEC.
20	9550	14725	19100	23875	28650	33440	38215	42990	47770
25	7640	11460	15280	19100	22920	26750	30570	34390	38215
30	6365	9550	12730	15915	19100	22290	25475	28660	31845
50	3820	5730	7640	9550	11460	13375	15285	17195	19105
70	2545	3820	5095	6370	7640	8915	10190	11465	12735
100	1910	2865	3820	4775	5730	6685	7640	8600	9550
125	1530	2290	3055	3820	4580	5350	6115	6880	7640
150	1275	1910	2545	3180	3820	4460	5095	5730	6370
175	1090	1640	2185	2730	3280	3820	4367	4910	5460
200	955	1435	1910	2390	2865	3340	3820	4300	4780
250	765	1146	1530	1910	2290	2675	3055	3440	3820
300	635	905	1275	1590	1910	2230	2545	2865	3185
350	545	820	1090	1365	1640	1910	2180	2455	2730
400	480	715	955	1194	1435	1670	1910	2150	2390
450	425	635	850	1060	1275	1485	1700	1910	2120
450	382	573	764	955	1146	1337	1528	1719	1918
550	347	521	694	868	1042	1215	1389	1563	1737
600	318	477	636	796	955	1114	1273	1433	1592

## NOTES

[illegible]

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