

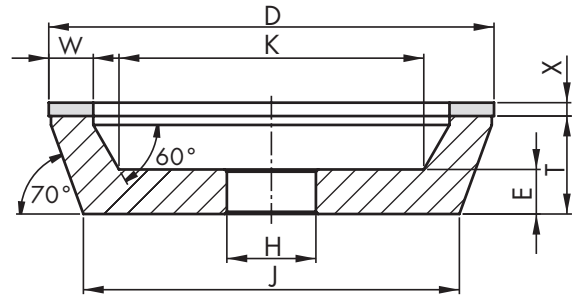


## Face surface grinding

### DIACOM 11A2

D x W x X x H

Grinding tool - cup



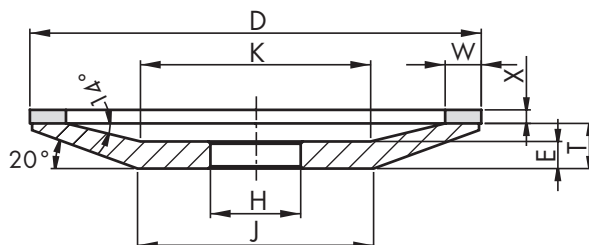
| D   | X     | W                  | T  | E  | K                        | J   |
|-----|-------|--------------------|----|----|--------------------------|-----|
| 50  | 2 3   | 10                 | 13 | 8  | 27                       | 41  |
| 75  | 2 3   |                    | 18 | 10 |                          | 62  |
| 75  |       | 3 4 5 6 10         | 18 | 10 | 62 60 58 56 48           | 62  |
| 100 | 2 3   |                    | 22 | 10 |                          | 84  |
| 100 |       | 3 4 5 6 8 10       | 22 | 10 | 82 80 78 76 72 68        | 84  |
| 125 | 2 3 4 |                    | 23 | 10 |                          | 109 |
| 125 |       | 3 4 5 6 10 12.5 15 | 23 | 10 | 106 104 102 100 92 87 82 | 109 |
| 150 | 2 3 4 |                    | 23 | 10 |                          | 134 |
| 150 |       | 6 8 10 12.5 15 20  | 23 | 10 | 125 121 117 112 107 97   | 134 |
| 175 | 2 3 4 |                    | 23 | 12 |                          | 159 |
| 175 |       | 6 10 15            | 23 | 12 | 153 145 135              | 159 |
| 200 | 2 3 4 |                    | 23 | 12 |                          | 184 |
| 200 |       | 6 8 10 15          | 23 | 12 | 178 174 170 160          | 184 |
| 250 | 2 3 4 |                    | 23 | 12 |                          | 234 |
| 250 |       | 10 15              | 23 | 12 | 220 210                  | 234 |



## DIACOM 12A2-20°

D x W x X x H

Grinding tool - plate



| D   | X     | W                   | T  | E  | K                       | J           |
|-----|-------|---------------------|----|----|-------------------------|-------------|
| 50  | 2 3   |                     | 7  | 5  |                         | 16 19       |
| 50  |       | 3 5                 | 7  | 5  | 28 24                   |             |
| 75  | 2 3 4 | 3                   | 9  | 6  |                         | 30 33 36    |
| 75  |       | 3 4 5 6 10          | 9  | 6  | 45 43 41 39 31          |             |
| 100 | 2 3 4 |                     | 10 | 6  |                         | 50 52 55    |
| 100 |       | 2 3 4 5 6 8 10 13   | 10 | 6  | 64 62 60 58 56 52 48 43 |             |
| 125 | 2 3 4 | 3                   | 14 | 8  |                         | 53 55 58    |
| 125 |       | 3 4 5 6 8 10 13     | 14 | 8  | 71 69 67 65 61 57 52    |             |
| 150 | 2 3 4 |                     | 16 | 9  |                         | 67 69 72    |
| 150 |       | 3 5 6 8 10 13 15 20 | 16 | 9  | 88 84 82 78 74 69 64 54 |             |
| 175 | 2 3 4 |                     | 18 | 10 |                         | 81 83 86    |
| 175 |       | 6 10 15             | 18 | 10 | 99 91 81                |             |
| 200 | 2 3 4 |                     | 20 | 11 |                         | 95 97 100   |
| 200 |       | 3 4 5 6 10 15       | 20 | 11 | 122 120 118 116 108 98  |             |
| 250 | 2 3 4 |                     | 23 | 13 |                         | 128 131 134 |
| 250 |       | 10 15               | 23 | 13 | 150 140                 |             |

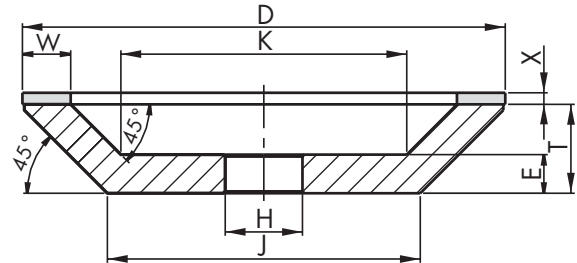


## Face surface grinding

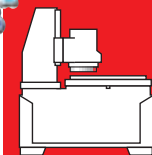
### DIACOM 12A2-45°

D x W x Y x H

Grinding tool - conical plate



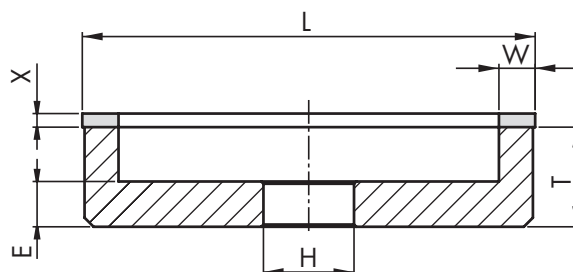
| D   | X       | W               | T  | E  | K                    | J           |
|-----|---------|-----------------|----|----|----------------------|-------------|
| 50  | 2 3     | 10              | 13 | 8  | 20                   | 25 26       |
| 75  | 2 3     |                 | 18 | 10 |                      | 40 41       |
| 75  |         | 3 4 5 6 10      | 18 | 10 | 53 51 49 47 39       |             |
| 100 | 2 3     |                 | 22 | 10 |                      | 57 58       |
| 100 |         | 3 4 5 6 8 10    | 22 | 10 | 70 68 66 64 60 56    |             |
| 125 | 1 2 3 4 |                 | 23 | 10 |                      | 79 80 81 82 |
| 125 |         | 3 4 5 6 10 12.5 | 23 | 10 | 93 91 89 87 79 74    |             |
| 150 | 2 3 4   |                 | 23 | 10 | 112                  | 105 106 107 |
| 150 |         | 6 8 10 12.5 20  | 23 | 10 | 112 108 104 99 94 84 |             |
| 175 | 2 3 4   |                 | 23 | 12 |                      | 130 131 132 |
| 175 |         | 6 10 15         | 23 | 12 | 141 133 123          |             |
| 200 | 2 3 4   |                 | 23 | 12 |                      | 155 156 157 |
| 200 |         | 6 8 10 15       | 23 | 12 | 166 162 158 148      |             |
| 250 | 2 3 4   |                 | 23 | 12 |                      | 205 206 207 |
| 250 |         | 10 15           | 23 | 12 | 148 208 198          |             |



## DIACOM 6A2

D x W x X x H

Grinding tool - cylindrical cup



| D   | W                      | X     | T  | E  |
|-----|------------------------|-------|----|----|
| 30  | 3                      | 2 3   | 18 | 8  |
| 40  | 3 4                    | 2 3   | 20 | 8  |
| 45  | 3                      | 2 3   | 20 | 8  |
| 50  | 3 5                    | 2 3   | 20 | 10 |
| 55  | 10                     | 2 3 4 | 20 | 10 |
| 63  | 5 10                   | 2 3   | 20 | 10 |
| 75  | 2 3 4 5                | 2 3   | 20 | 10 |
| 75  | 6 10                   | 2 3 4 | 20 | 10 |
| 90  | 6                      | 2 3   | 22 | 10 |
| 100 | 2 3 4 4.5 5            | 2 3   | 22 | 10 |
| 100 | 6 8 10 12.5            | 2 3 4 | 22 | 10 |
| 125 | 2 3 4 5 6 8 10 12.5 25 | 2 3 4 | 22 | 10 |
| 150 | 3 5 6 8 10 12.5 15 20  | 2 3 4 | 22 | 10 |
| 175 | 3 4 5 6 10 15 20       | 2 3 4 | 24 | 13 |
| 200 | 4 5 6 8 10 15 20       | 2 3 4 | 25 | 13 |
| 250 | 6 10 15                | 2 3 4 | 25 | 13 |

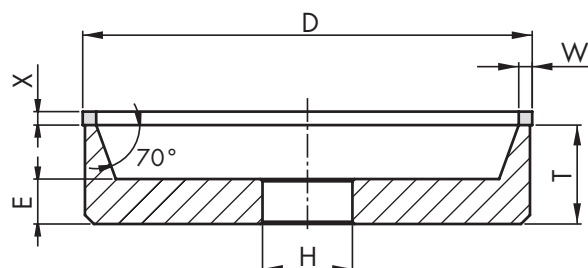


## Face surface grinding

### DIACOM 6A2-1

D x W x X x H

Grinding tool - cup






| D   | X | W       | T  | E  | K               |  |  |
|-----|---|---------|----|----|-----------------|--|--|
| 30  | 2 | 3       | 18 | 8  | 17              |  |  |
| 40  | 2 | 3 4     | 20 | 8  | 25 23           |  |  |
| 45  | 2 | 3       | 20 | 8  | 30              |  |  |
| 50  | 2 | 3 5     | 20 | 10 | 37 33           |  |  |
| 55  | 2 | 10      | 20 | 10 | 28              |  |  |
| 63  | 2 | 5 10    | 20 | 10 | 46 36           |  |  |
| 75  | 2 | 2 3 4 5 | 20 | 10 | 64 62 60 58     |  |  |
| 100 | 2 | 3 4 5   | 22 | 10 | 85 83 82        |  |  |
| 125 | 2 | 3 4 5 6 | 22 | 10 | 110 108 106 104 |  |  |
| 150 | 2 | 3 4 5 6 | 22 | 10 | 135 133 131 129 |  |  |
| 175 | 3 | 5 6     | 24 | 13 | 157 155         |  |  |
| 200 | 4 | 4 5     | 25 | 13 | 183 181         |  |  |

# Quality of grinding tools for face surface grinding

03



| Ground material   | Grit type   | Grit size                         | Bond                | Concentration                  | Notes |
|---|-------------|-----------------------------------|---------------------|--------------------------------|-------|
| <b>Steels</b><br> Non-hardened steel<br>Tool steel<br>High-speed steels (HSS) | B<br>B<br>B | 107 - 181<br>64 - 126<br>64 - 126 | BMR<br>BM75<br>BMRT | 75 - 100<br>50 - 75<br>50 - 75 |       |
| <b>Hard metals</b><br> Tungsten carbides                                      | D           | 46 - 151                          | BMR, BMRT           | 75 - 100                       |       |
| <b>Technical ceramics</b><br>   | D           | 91 - 151                          | BMR                 | 75                             |       |

