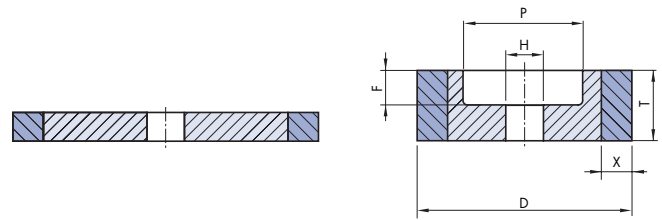
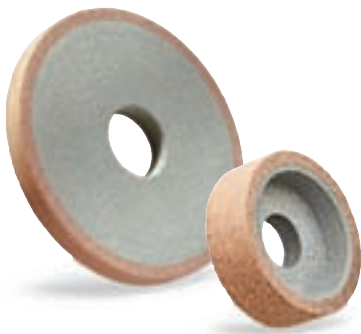




Internal cylindrical grinding with superabrasives

1A1

D x T x X x H
Flat grinding wheel*



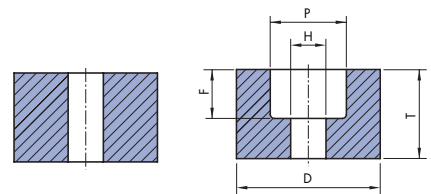
Order printout sample:
1A1 100x15x3x20
02B126P4VC100

D	T	H	X	P	F
25	6-20		3		F = max. T/2
32	6-20		3		
40	6-20	by	3.5	by	
100	6-20	agreement	3.5	agreement	

*abrasive ceramic core

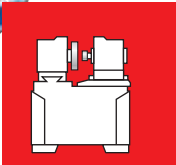
1A8

D x T x H - P x F
Grinding roll



Order printout sample:
1A8 16x16x4 - 6x8
01D107P4VC125

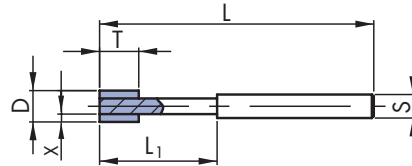
D	T	H	P	F
6	4-15	3		F = max. T/2
8	2-15	3 (4)		
10	4-16	3 (4)	by	
13	4-16	4 (6)	agreement	
16	4-16	4 (6,8)		
18	4-16	4 (6)		
20	4-20	6 (8,10)		



1A8W

D x T x X x S x L

Grinding tool - mounted point

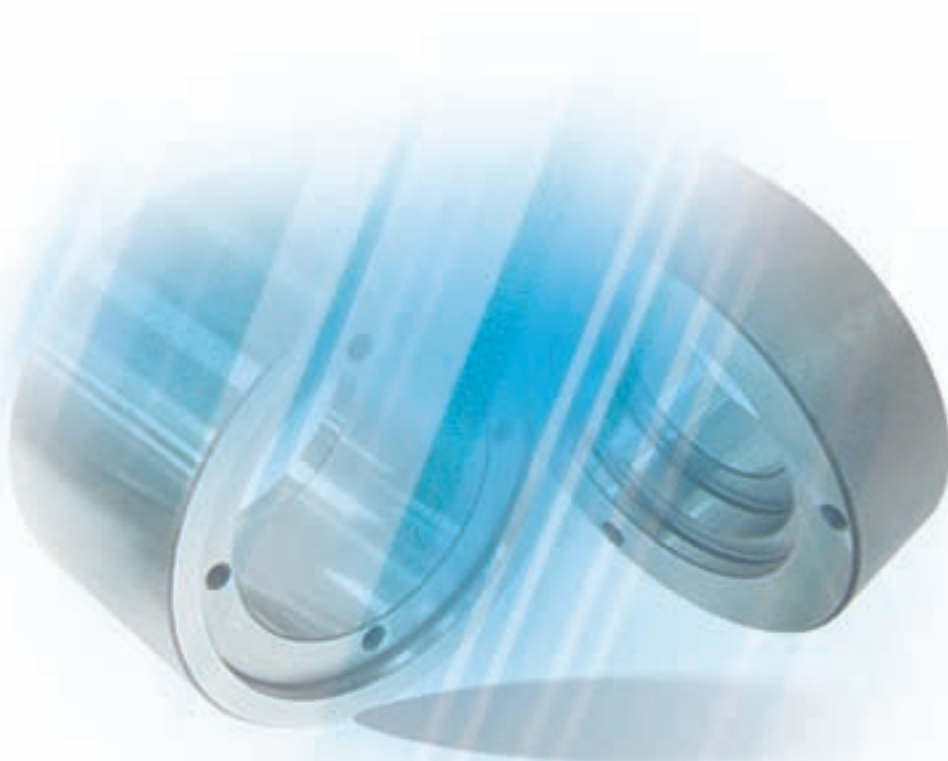


D	T	X	S	L	L1
6	6	3	6	70	20
8	8-10	3(4)	6	70	20
10	8-10	3(4)	6	70	
13	8-10	4(6)	6	70	
16	8-15	4(6)	(6) 8	70	
18	8-15	4(6)	(6) 8	70	
20	8-15	6(8)	(6) 8	70	

Order printout sample:

1A8 16x10x4x8x70

01D107P4VC125





Internal cylindrical grinding

Grinding tool NB F1

D x T x H

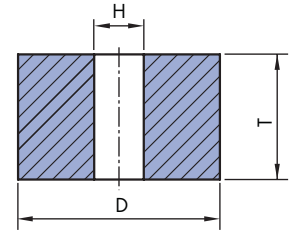
Flat grinding tools
for internal grinding



Order printout sample:

NB F1 20x20x8

3LA8018VL



D	T	H
6	6, 10, 13	2, 5, 3
8	8, 10, 16	2, 5, 3
10	6, 10, 13, 20	3, 4
13	6, 13, 20	3, 6
16	6, 10, 16	6
20	13, 20, 25, 32	6, 8
25	13, 20, 25, 32, 40	6, 8, 10
32	13, 20, 25, 32, 40	6, 8, 10, 13
40	13, 20, 25, 32, 40	6, 10, 13, 16
50	13, 20, 25, 32, 40	10, 13, 16, 20
63	13, 20, 25, 32, 40	13, 16, 20
80	13, 20, 25, 32, 40	16, 20, 25
100	16, 25, 32, 40, 50	16, 20, 25

Grinding tool NB F5

D x T x H - P x F

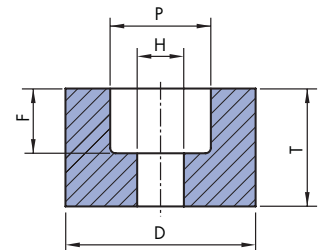
Grinding tools for internal grinding,
recessed on one side



Order printout sample:

NB F5 40x25x10-25x12

3SA60J7VL

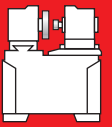


D	T	H	P	F,G
16	10, 16	6	10	
20	13, 20	6, 8	13	
25	10, 16, 25	6, 8, 10	16	
32	16, 20, 25, 32	8, 10, 13	20	
40	20, 25, 32, 40	10, 13	25	
50	20, 25, 32, 40	16, 20	32	
63	25, 32, 40, 50	16, 20	32	
80	40, 50, 63	20, 25	40	
100	32, 40, 50	20, 25, 32	52	

F+G = max. T/2

Quality of grinding tools for internal cylindrical grinding

07



Ground material		Quality
Steel 	Universal Non-hardened steel Hardened up to 62 HRc Hardened over 62 HRc High-speed steels (HSS) Stainless steel For bearings	3LA80I8VL 22A60K7VL 40A60I8VL 03B91P4VC125, 3LA80I8VL, 3SA60J7VL 03B91P4VC125, 62A60I8VL, 10C80H7VL 22A60I8VL 82A80K6V80L, 82A120K6V80L, 5LA150/5L6V63WL, 5LA180/5L6V63WL
Hard metals 	Tungsten carbides	01D91P4VC100, 10C80H7VL
Non-ferrous metals 	Al and alloys Cu and alloys	90C60H7VWL, 90C80H7VWL 90C60H7VWL, 90C80H7VWL
Non-metals 	Plastic materials	90C60H8VWL

