

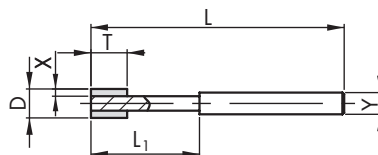


Internal cylindrical grinding

DIACOM 1A1W

D x T x X x Y x L

Grinding tool - mounted point

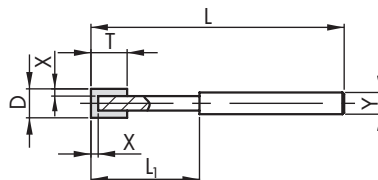


D	T	X	L	L1	Y
4	5	1	(45) 70	20	6
5	6	1.5	(45) 70	20	6
6	6	2	70	20	6
7	6 8 10	2	70	20	6
8	8 10	2	70	20	6
9	8 10	2	70	20	6
10	8 10	2	70		6
12	8 10	2	70		6
15	8 10 15	2	70		(6) 8
18	8 10 15	2	70		(6) 8
20	8 10 15	3	70		(6) 8

DIACOM 1A8W

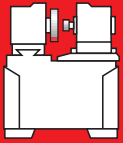
D x T x X x Y x L

Grinding tool - mounted point



D	T	X	L	L1	Y
4	5	1	(45) 70	20	6
5	6	1.5	(45) 70	20	6
6	6	2	70	20	6
7	6 8 10	2	70	20	6
8	8 10	2	70	20	6
9	8 10	2	70	20	6
10	8 10	2	70		6
12	8 10	2	70		6
15	8 10 15	2	70		(6) 8
18	8 10 15	2	70		(6) 8
20	8 10 15	3	70		(6) 8

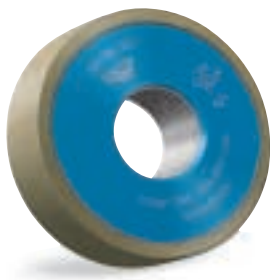
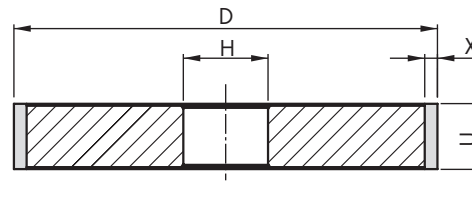




DIACOM 1A1

D x U x X x H

Grinding tool - roll



D	H	X	T=U
6	3	2	6 8 10
7	3	2	6 8 10
8	4	2	6 8 10
9	4 5	2	10 15
10	4 6	2	10 15
12	4 6 8	2	10 15
15	*	2	10 15 20
18	*	2	10 15 20
20	*	2 3	10 15 20
22	*	3 5	10 15 20
25	*	3 5	10 15 20
30	*	3 5	10 15 20
35	*	3	6 10
40	*	3 5	5 6 8 10 15 20
45	*	4	5 6 8 10 15 20
50	*	3	5 6 8 10 15 20
55	*	3	5 6 8 10 12
63	*	5	5 6 8 10 12
75	*	3 4 5	5 6 8 10 12 15
80	*	3	6 8 10 12 15
85	*	3	6 8 10 12 15
90	*	3	6 8 10 12 15
100	*	2 3 4 5	6 8 10 12 15

* Bore diameter (H) manufactured to order

Quality of grinding tools for internal cylindrical grinding

Ground material	Grit type	Grit size	Bond	Concentration	Notes
Steels 	Non-hardened steel	B	107 - 181	BMK	75 - 100
	Tool steel	B	64 - 126	BMK	100
Hard metals 	Tungsten carbides	D	46 - 151	V80, V80T	100