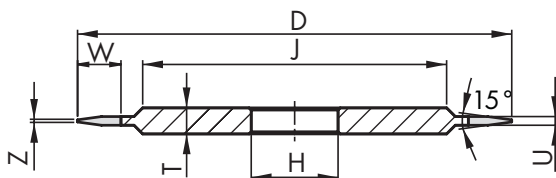




Profile grinding

DIACOM 14E1

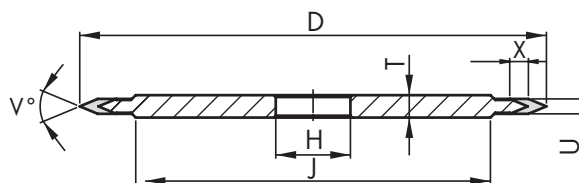
D x W x Z x H
Grinding tool - disc



D	W	Z	T	J	U	V°
100	10	0.5	7	70	3	15
125	10	0.5	7	95	3	15
150	10	0.5	7	120	3	15

DIACOM 14EE1

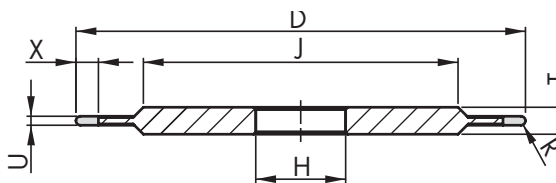
D x U x X/V° x H
Grinding tool - disc



D	U	X	V°	J	T
125	4	5	45	95	6
150	4	3	90	120	6

DIACOM 14F1

D x U x X/R x H
Grinding tool - disc



D	U	X	T	J
50	2 3 4 5	3 5	6	30
75	2 3 4 5	3 5	6	50
100	2 3 4 5	3 5	6	70
125	2 3 4 5	3 5	6	95
150	2 3 4 5	3 5	6	120
175	2 3 4 5	3 5	6	140
200	2 3 4 5	3 5	10	160
250	2 3 4 5	5 8	10	200



*Produced on steel cores

The standard bore diameter (H) is Ø20 H7; other diameters and grinding tools of other dimensions are manufactured to order.

Quality of grinding tools for profile grinding

05



Ground material		Grit type	Grit size	Bond	Concentration	Notes
Steels 	Tool steel	B	76 - 151	BMEG, V80	100 - 125	V80 for wet grinding
	High-speed steels (HSS)	B	76 - 151	BMRG, V80	100 - 125	
Hard metals 	Tungsten carbides	D	46 - 151	BM4R, V80	100 - 125	

