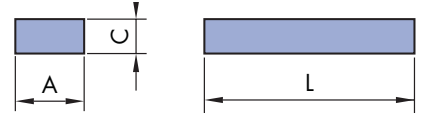




## Surface grinding with grinding segments

### Grinding segment A

A x C x L



A	C	L
80	25	150
90	30	200
102	25	199
102	25	250
120	30	200
154	25	150

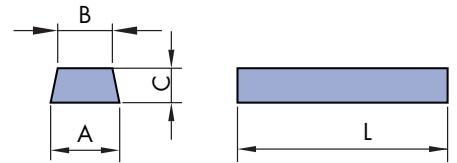
Order printout sample:

S-A 80x25x150

3SA36F16/4NVL

### Grinding segment B

A / B x C x L



A	B	C	L
50	45	25	110
60	54	22	120
70	64	25	110
100	85	35	150
103	94	38	200
120	106	41	200
120	106	41	220

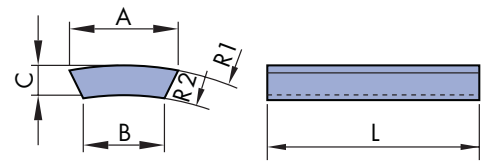
Order printout sample:

S-B 100/85x35x150

12A36F16/1V13L

### Grinding segment C

A / R1 / R2 / B x C x L



A	R1	R2	B	C	L
95	150	125	72	25	120
95	150	125	70	25	120
75	150	125	45	25	120
103	200	175	77	25	150
115	175	145	85	30	120
115	175	145	85	30	180
115	175	145	80	30	180

Order printout sample:

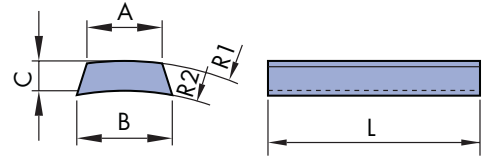
S-C 95/150/125/72x25x120

4LA36D20/2SVL



## Grinding segment D

A / R1 / R2 / B x C x L

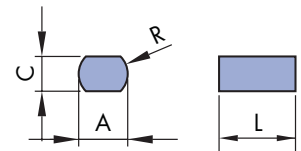


A	R1	R2	B	C	L
45	112	95	50	20	120
45	150	134	50	16	90
45	85	70	50	15	90

Order printout sample:  
S-D 95/150/125/72x25x120  
22A36F16/4NVL

## Grinding segment ARR

A / R x C x L

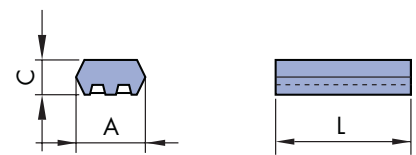


A	R	C	L
85	40	55	63

Order printout sample:  
S-ARR 85/40x55x63  
41A36F16/4NVL

## Grinding segment BBU

A x C x L

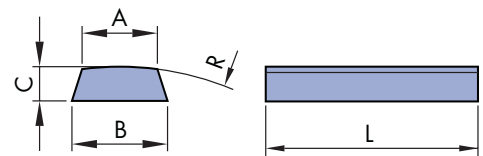


A	C	L
160	60	200

Order printout sample:  
S-BBU 160x60x200  
58A36F16/4NVL

## Grinding segment DR

A / R / B x C x L



A	R	B	C	L
85	150	70	25	120
65	175	56	25	100

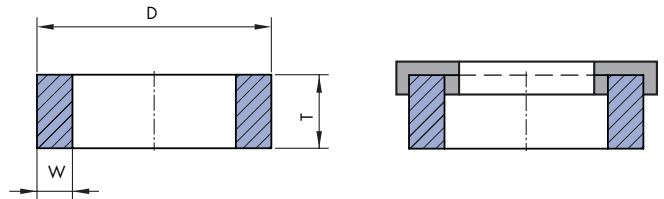
Order printout sample:  
S-DR 160x60x200  
22A36F16/4NVL



# Surface grinding with grinding rings and cups

## Grinding ring F2 and F2P

D x T - W  
Grinding ring

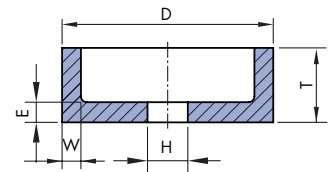


D	T	W
100	90	10
125	80	32
150	90	15
175	90	20
200	90	20
250	100	25
300	120	32
350	125	40
400	125	40

Order printout sample:  
F2 200x90-20  
22A46H14/4NVL

## Grinding cup F6

D x T x H - W x E  
Cylindrical cup

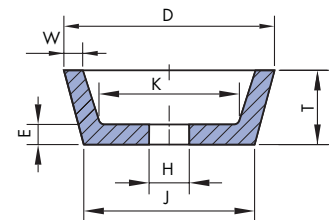


D	T	H	W	E
50	32	13	5	8
80	40	20	6	10
100	50	20	8	10
125	63	20	8	13
150	80	20	10	16
175	100	32	15	20
200	100	32	20	25
250	100	76	20	25

Order printout sample:  
F6 150x80x20-10x16  
40A46H12/4NVL

## Grinding cup F11

D / J x T x H - W x E x K  
Flaring cup



D	J	T	H	W	E	K
50	27	32	13	4	8	22
80	57	32	13	6	8	46
100	71	40	20	8	10	56
125	96	40	20	10	10	81
150	114	45	20	10	13	96
175	135	45	32	12.5	15	120
200	155	50	32	20	20	140
250	200	60	76	30	20	180

Order printout sample:  
F11 125/96x40x20-10x10x81  
3SA46H12/4NVL

Products of other dimensions can be made to special order.

# Quality of grinding wheels for surface grinding

02



Ground material		Quality	
		Grinding rings and cups	Grinding segments
<b>Steels</b> 	Universal	22A46H12/3SV12L	22A36/5G18/2SV12L
	Non-hardened steel	22A36/1G10/0V11L	22A36H10/4NV11L
	Hardened up to 62 HRc	40A36F18/2SV12L	40A46F14/3SV12L
	Hardened over 62 HRc	3SA36F18/2SV12L, 42A46K5B	3SA36F14/4NV12L
	High-speed steels (HSS)	82A36F18/2SV12L, 42A46K5B	3SA36F14/4NV12L
	Stainless steel	22A36F18/2SV12L	22A46F18/2SV12L
	Composite materials		48A24/1I10/4NVL
<b>Alloys</b> 	Steel	3SA46H16/3SV12L	3SA46H16/3SV12L
<b>Non-ferrous metals</b> 	Al and alloys	54A36M5B	12A36G10/1V12L
	Magnetic tables		60A24/3G10/4NV12L

