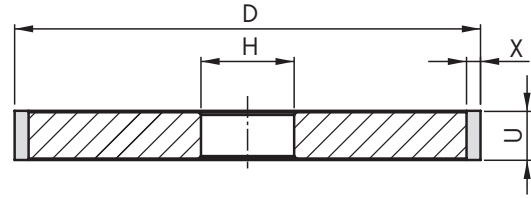


Surface grinding with tool circumference and external cylindrical grinding

DIACOM 1A1

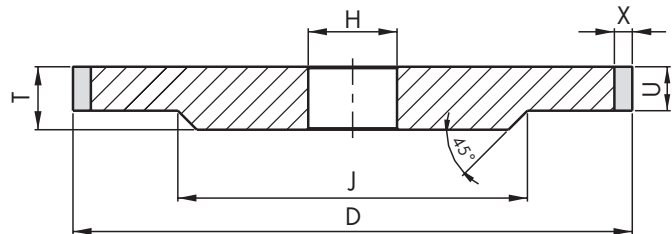
D x U x X x H
Grinding tool - disc



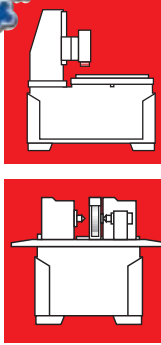
D	X	T=U
100	2 3 4 5	6 8 10 12 15
125	2 3 4 5 6	6 8 10 12 15
150	2 3 4 5	6 8 10 12 15
175	3 5 6 10	6 8 10 15 20 25
200	3 4 5 6	6 10 15 20 25
220	3	10 15 20 25
250	3	10 15 20 25
300	3	10 15 20 25 30
350	3	10 15 20 25 30
400	3	10 15 20 25 30
500	3 6	10 15 20 25 30

DIACOM 3A1

D x U x X x H
Grinding tool - disc

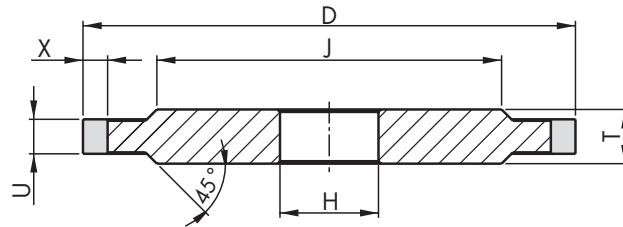


D	U	X	J	T
100	5 10	3 5	70	10 15
125	5 10	3 5	100	10 15
150	5 10	3 5	120	10 15
175	8 10 15	3 5	140	15 25
200	10 15	3 5	160	15 25
220	10 15	3 5	180	15 25
250	10 15	3	200	15 25
300	10 15	3	250	15 25
350	15 25	3	300	15 25
400	10 15	3	350	15 25
500	10 15	3 6	400	15 25



DIACOM 14A1

D x U x X x H
Grinding tool - disc



D	U	X	J	T
125	5 10	5	95	10 15
150	5 10	5	120	10 15
175	5 10	5	140	10 15
200	5 10	5	160	10 15
250	10	3	200	16
300	10	3	240	16
350	10	3	280	16
400	10	3	330	16
500	10	3 6	430	18

Quality of grinding tools for surface and external cylindrical grinding

Ground material	Grit type	Grit size	Bond	Concentration	Notes
Steels Non-hardened steel Tool steel High-speed steels (HSS)	B	107 - 181	BMR	75 - 100	
	B	64 - 126	BM75	50 - 75	
	B	64 - 126	BMRT	50 - 75	
Hard metals Tungsten carbides	D	46 - 151	BMR, BMN	75 - 100	