



DR. MÜLLER
DIAMANTMETALL® AG



GENERAL CATALOGUE DIAMOND- AND CBN-TOOLS

Our quality is your success!



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Supervisory board chairman: Prof. Dr. Dr. Claudius Schikora
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Legal venue:
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HRB 168843
USt.-Id.-Nr.: DE255272026
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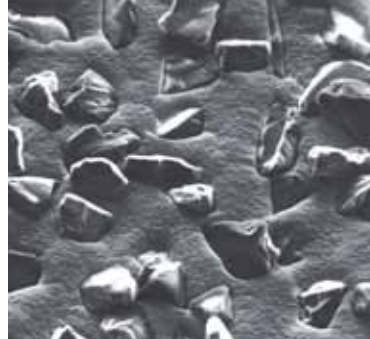
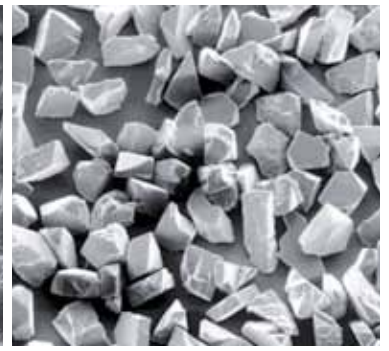
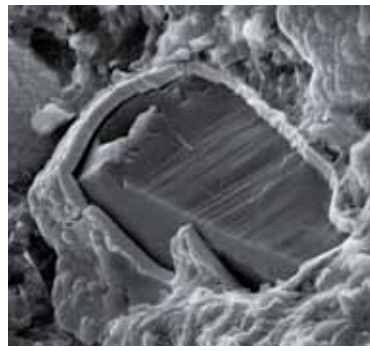
Your personal contact



DR. MÜLLER
DIAMANTMETALL® AG



GENERAL CATALOGUE DIAMOND- AND CBN-TOOLS



The company

Dr. Müller DIAMANTMETALL® AG has a remarkable tradition. Its founder, Dr. Wilhelm Müller, invented the metal-bonded diamond grinding wheel in 1935, laying the foundation stone for the company, and to the present day Dr. Müller DIAMANTMETALL® AG remains an owner-operated enterprise, with the third generation of the family in charge of its operations.

At our level the continued success of a supplier of technical solutions stands and falls with the ability to understand and anticipate the specific requirements of a wide range of customers from different industries. Your requirements are our challenge – a challenge we have met from the very earliest days.

Know-How

Thanks to the use of cutting-edge database technology we are today able to draw on expert knowledge acquired over more than 75 years of diamond tool production. Our own R&D department develops innovative solutions to meet the most complex requirements, while countless innovations and patents highlight our creativity when it comes to developing ingenious technical solutions.

This extensive competence in the development of solutions for all application areas guarantees added value from close cooperation with the customer – ensuring the added value that leads to outstanding customer products.

HISTORY

1935

Dr. Wilhelm Müller set up the company in Berlin and invented and manufactured metal bonded diamond grinding wheels.

1947

resuming production in the county of munich.

1962

the company's founder died and the second generation continued with the company.

1944

the company was destroyed in war.

1955

moving into own buildings in Feldafing at lake Starnberg.



Flexibility

Whether it's a matter of best possible quality or optimum technical reliability, productive processes, long product life, investment security you can rely on, outstanding grinding performance, continuous optimisation or fast new developments: your requirements are our challenge, regardless of batch size. And if needed we can provide you with support services on the spot.

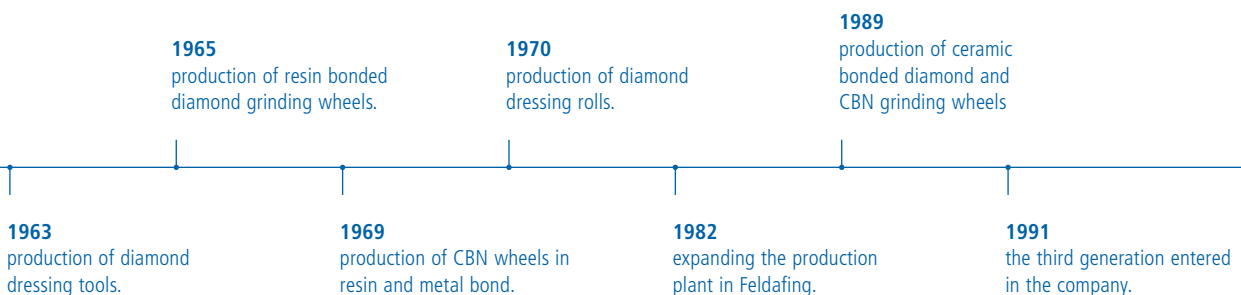
These support services range from training and operator instruction by our experts with experience of a range of industries, right down to backup in the launch phase for new products provided by our applications specialists in order to ensure trouble-free production.

Products

Our product portfolio contains more than 133,000 articles for precision grinding, supported by a powerful database which ensures that each individual series number can be traced back.

The ongoing development of our products by our R&D department ensures that our customers receive maximum efficiency in their grinding operations.

On the 'make or buy' principle we act as your partners not only for standard products but also for complete new developments with outstanding depth of production.



Quality

For more than 75 years now we have been guaranteeing our customers the Highest standards of quality and precision. Our expertise was confirmed in the year 2000 by the award of DIN EN ISO 9001 certification, with quality assurance all along the line ensuring the success of your products.

ZERTIFIKAT ISO 9001:2008



bescheinigt hiermit, dass das Unternehmen

Dr. MÜLLER DIAMANTMETALL AG

Bereiche:
Entwicklung, Herstellung und Vertrieb von Diamant- und CBN-Schleifscheiben und Werkzeugen, Diamantwerkzeuge für die optische Industrie, Diamantabrichtrollen und Diamantabrichtwerkzeugen

Standort:
Leprosenweg 34 * D-82362 Weilheim i. Ob.

ein Qualitätsmanagementsystem entsprechend der oben genannten Norm (11/2008) eingeführt hat und dieses wirksam anwendet. Der Nachweis wurde im Rahmen des Zertifizierungs-Audits Bericht-Nr. A10011004 erbracht. Dieses Zertifikat ist nur in Verbindung mit der erfolgreichen Durchführung der Überwachungsaudits gültig.

Dieses Zertifikat ist gültig ab: 19.03.2010
 Dieses Zertifikat ist gültig bis: 30.11.2012
 Letzter Audittag: 10.03.2010

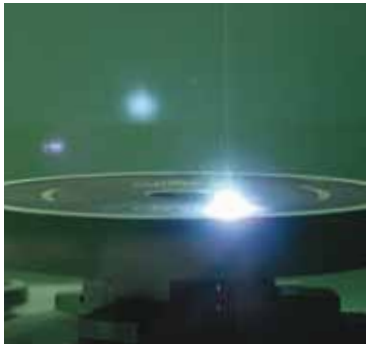
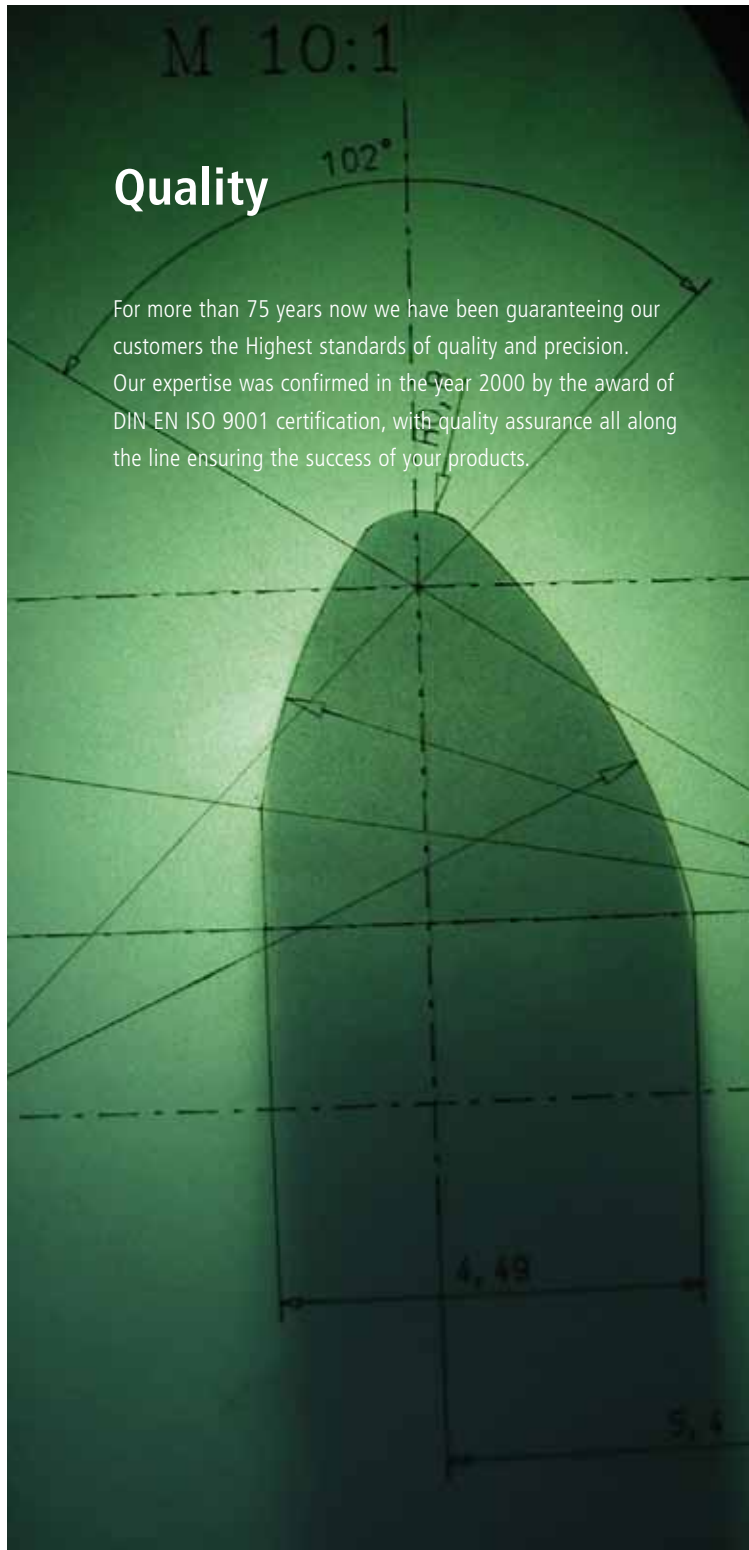
Datum der Erstzertifizierung: 2000
 Zertifikat-Registrier-Nr.: 30310164

Ueifog
 DEKRA Certification GmbH
 Stuttgart, den 19.03.10



GMS-TGA-ZM-05-91-00

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2002
expanding the company to a second plant in Weilheim.

2007
change of corporate form Dr. Wilh. Müller DIAMANTMETALL, Inh. M. Schulze e.K. to Dr. Müller DIAMANTMETALL AG.

2010
Dedication of the new logistic center.

2006
buying and continuation of the company by Michael Schulze. He is the grandchild from company's founder.

2008
Production and administration moved to the third plant in Weilheim/Obb.

2011
Expansion of the digital production control system and extension of the company management.

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TABLE OF WHEEL SHAPES

GENERAL APPLICATIONS

OPTICAL INDUSTRY

WOODWORKING AND PLASTICS INDUSTRY

INTERNAL GRINDING

DIAMOND FILES

DIAMOND PROFILE ROLLS; DIAMOND SHAPE ROLLS

DIAMOND DRESSING TOOLS AND -ABRASIVES

GENERAL INFORMATIONS



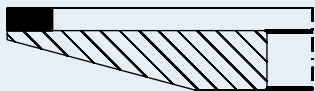
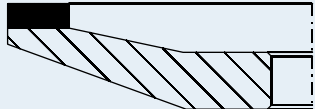
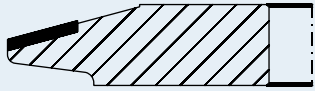
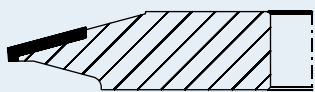
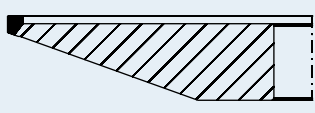
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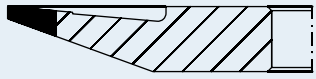
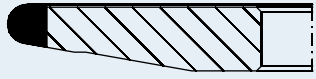
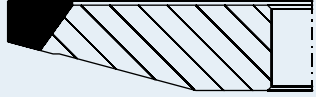
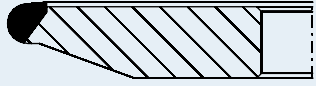
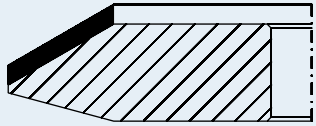
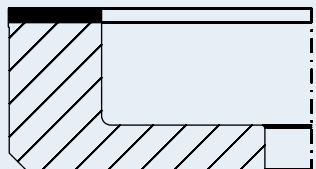
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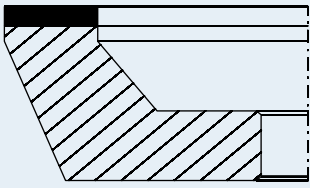
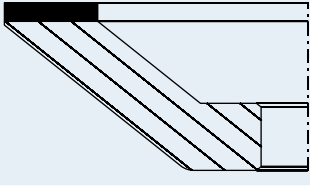
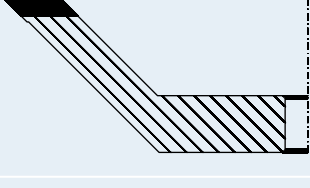
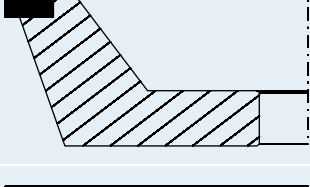
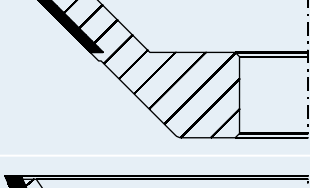
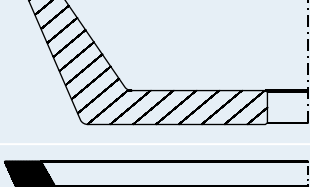
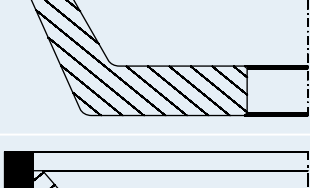
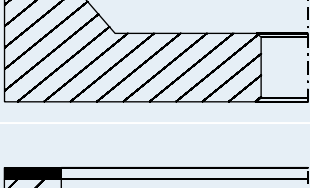
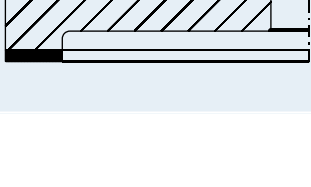
} ... by state of the art standard products

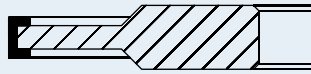
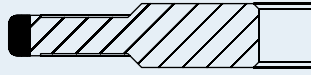


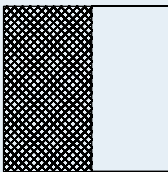
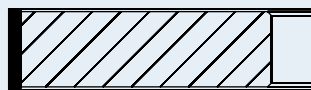

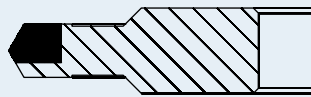
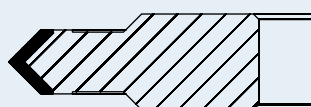
} ... by developing ingenious and customized
technical solutions






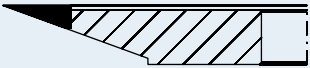
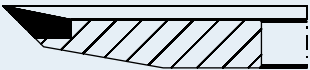
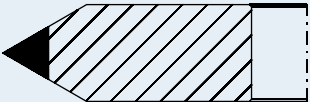
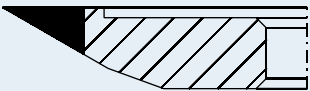
Table of wheel shapes

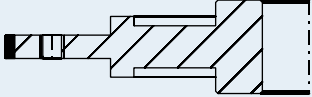

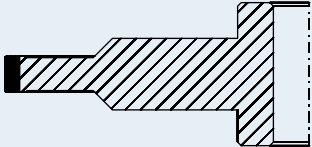


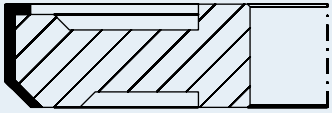
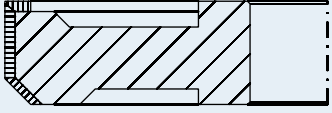
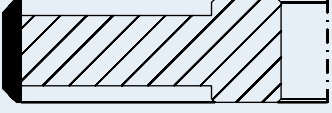
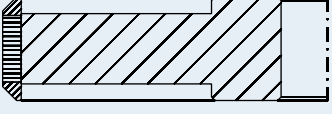
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12A2/20°	19	
4A5	20	
4Y9	20	
4E9P	20	

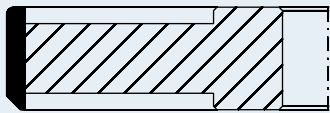
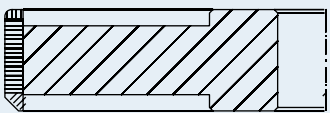
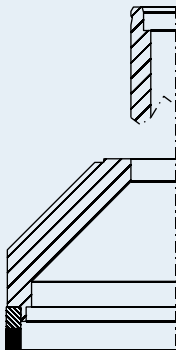
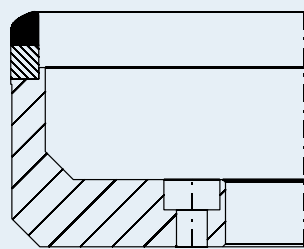
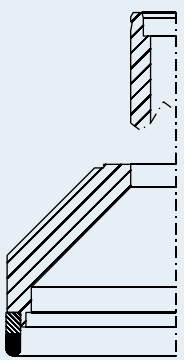
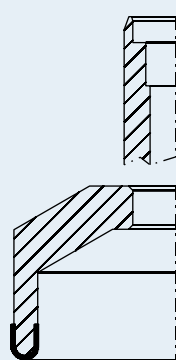
SHAPE	PAGE	ILLUSTRATION
4BT9	21	
4F9	21	
4ET9	21	
4F5	22	
4V5	22	
6A2	22	

SHAPE	PAGE	ILLUSTRATION
11A2	23	
12A2/45°	23	
12V2	23	
12C9	24	
12V9	24	
11V9	24	
11V2	25	
6A9	25	
9A3	25	

SHAPE	PAGE	ILLUSTRATION
14U1	26	
14L1	26	
14A1	26	
3A1	27	
1A8	27	
1A1	27	
1A1R	28	
14E9	28	
14EE1	28	

SHAPE	PAGE	ILLUSTRATION
1FF1	29	
14F1	29	
4A9	29	
14V1	30	
1V1	30	
4B9	30	
4B4	31	
14K1	31	
4K9	31	

SHAPE	PAGE	ILLUSTRATION
TABLE OF WHEEL SHAPES DIAMOND TOOLS FOR THE OPTICAL INDUSTRY		
E	32	
F	32	
D	33	
1A1R(S)	33	
1F1	33	
EZ3	34	
EZ3/A	34	
EZ4	34	
EZ4/A	35	

SHAPE	PAGE	ILLUSTRATION
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EZ5/A	35	
PF	36	
PF/R	36	
RF	37	
RF(S)	37	

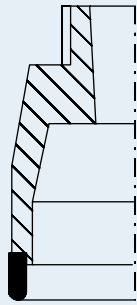
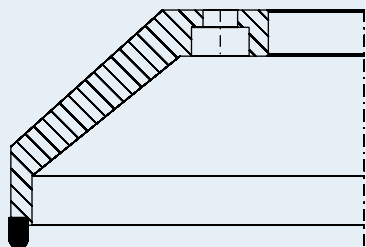
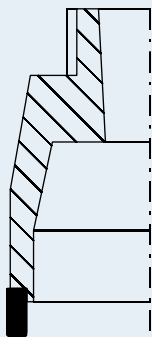
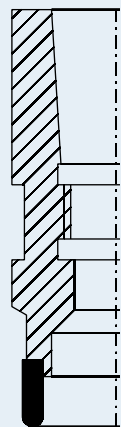
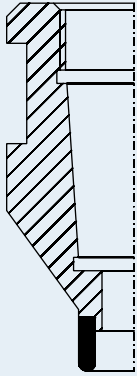
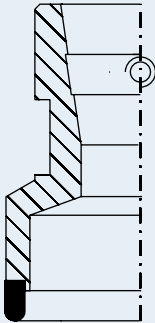
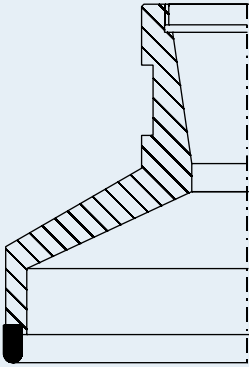
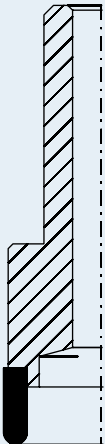
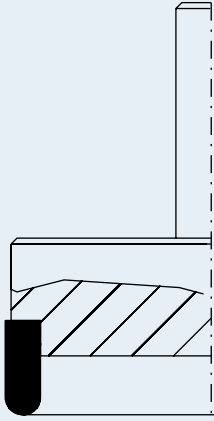
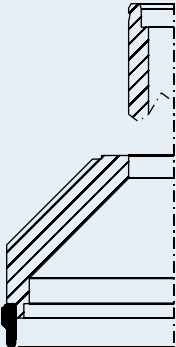
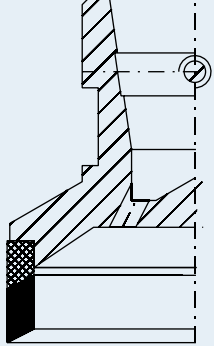
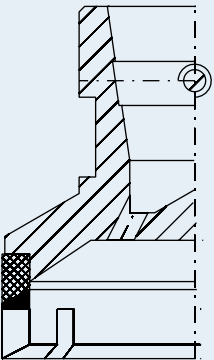
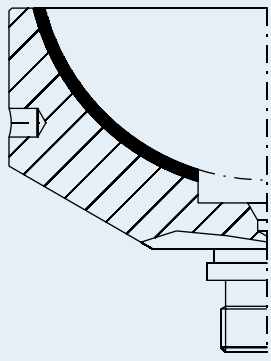
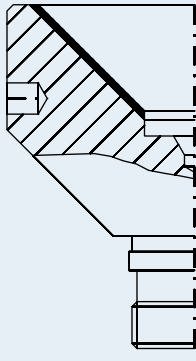
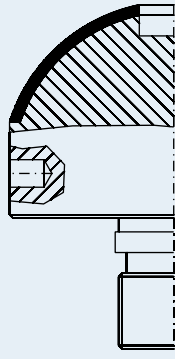
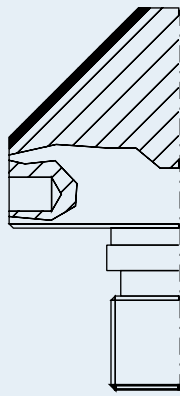
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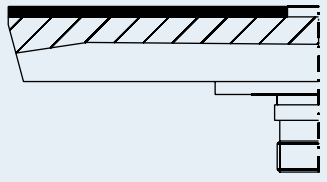
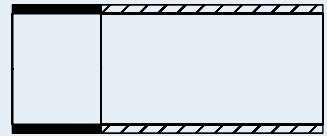
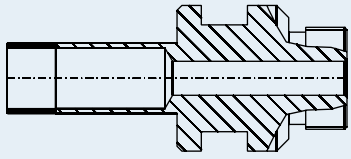


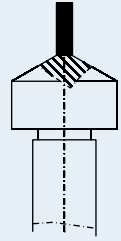
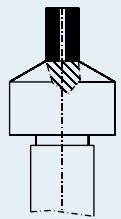

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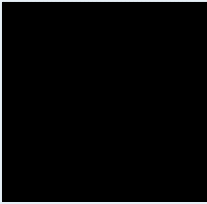

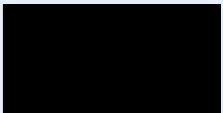
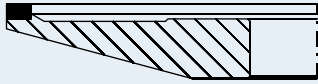
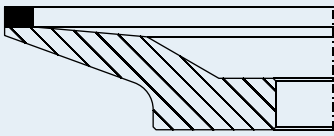
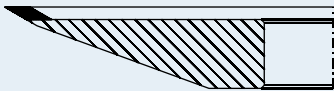
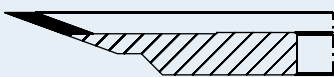
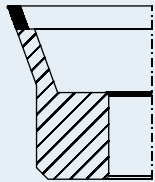
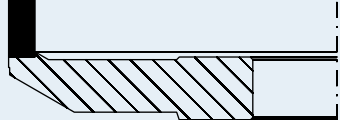
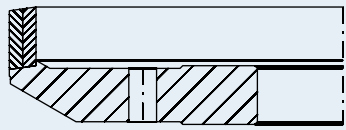



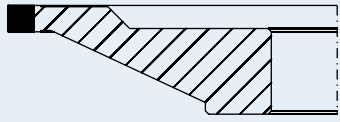

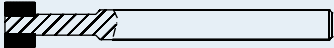
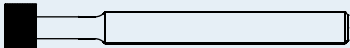

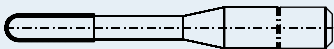


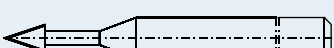

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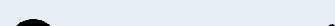
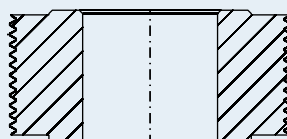
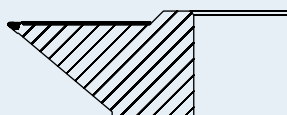
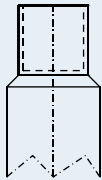
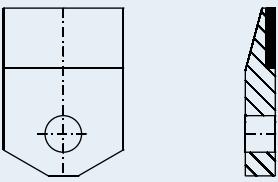
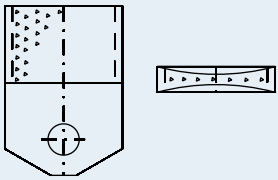
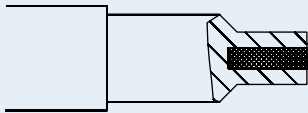
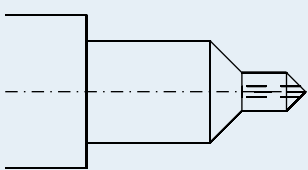
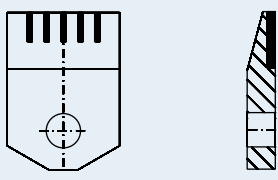
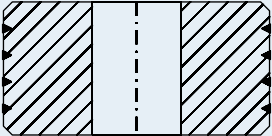
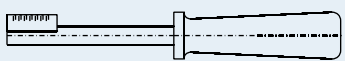
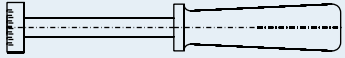





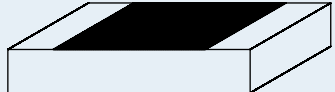
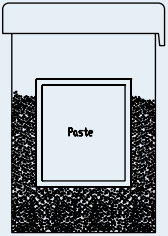
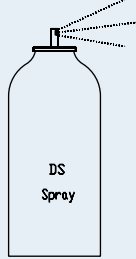

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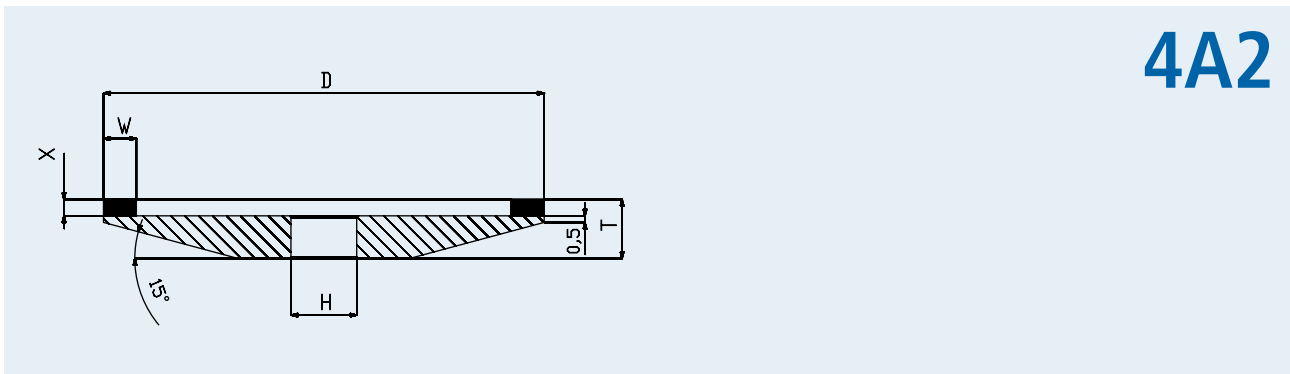
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TOOLS

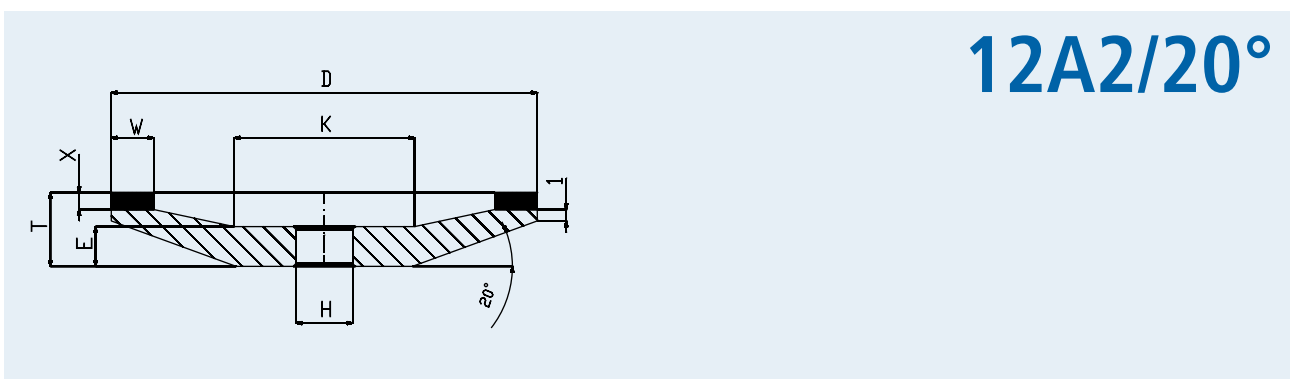
For general applications



4A2

SPECIFICATIONS	DIMENSIONS:	D 40-400mm; W 2-90mm; X 1-10mm								
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)								
	COOLING:	D (Dry), O (Oil), E (Emulsion)								
ORDERING EXAMPLE	SHAPE	D	W	X	T	H	BOND	GRIT	CONCENTRATION	
	4A2	125	5	2	7	20	MDT	D64	C75	

Individual tool configuration on request

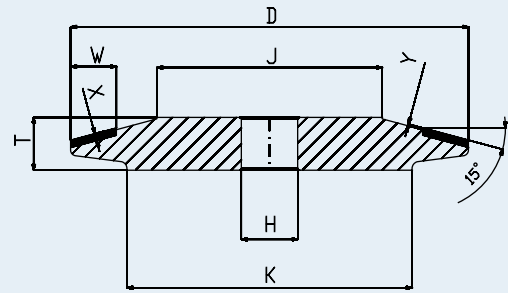


12A2/20°

SPECIFICATIONS	DIMENSIONS:	D 50-300mm; W 2-20mm; X 1-10mm									
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)									
	COOLING:	D (Dry), O (Oil), E (Emulsion)									
ORDERING EXAMPLE	SHAPE	D	W	X	T	H	E	K	BOND	GRIT	CONCENTRATION
	12A2/20°	200	6	2	10	32	5	64	MDT	D64	C75

Individual tool configuration on request

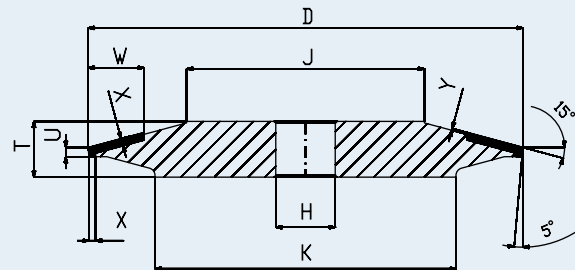
4A5



SPECIFICATIONS	DIMENSIONS:	D 50-250mm; W 4-34mm; X 1-6mm										
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)										
	COOLING:	D (Dry), O (Oil), E (Emulsion)										
ORDERING EXAMPLE	SHAPE	D	W	X	T	H	K	J	Y	BOND	GRIT	CONCENTRATION
	4A5	200	15	1	20	50,8	180	160	1	MDT	B151	C100

Individual tool configuration on request

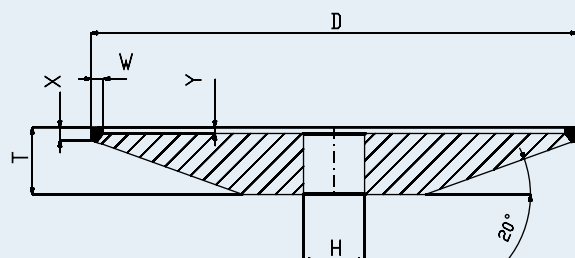
4Y9



SPECIFICATIONS	DIMENSIONS:	D 50-350mm; W 10-80mm; U 2-10mm; X 1-15mm											
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)											
	COOLING:	D (Dry), O (Oil), E (Emulsion)											
ORDERING EXAMPLE	SHAPE	D	W	U	X	T	H	K	J	Y	BOND	GRIT	CONCENTRATION
	4Y9	250	30	1,5	1	20	20	200	160	1	MDT	B151	C100

Individual tool configuration on request

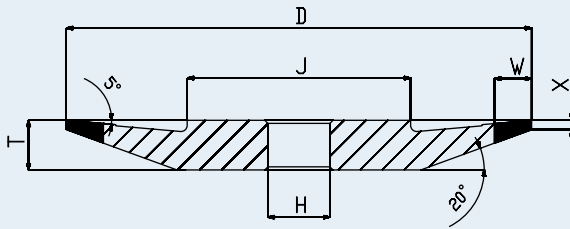
4E9P



SPECIFICATIONS	DIMENSIONS:	D 50-350mm; W 2-5mm; X 1-5mm									
	BONDS:	MDT (Resin bond), MDX (Metal bond)									
	COOLING:	D (Dry), O (Oil), E (Emulsion)									
ORDERING EXAMPLE	SHAPE	D	W	X	T	H	Y	BOND	GRIT	CONCENTRATION	
	4E9P	200	2	2,5	50	50,8	1,5	MDT	B151	C100	

Individual tool configuration on request

4BT9

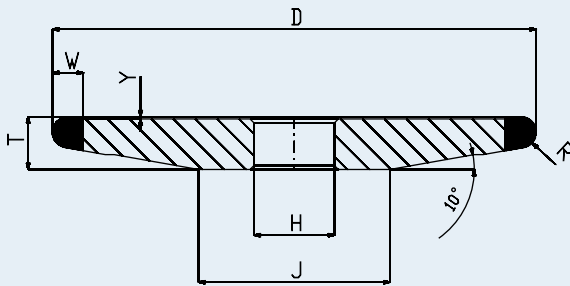


ORDERING EXAMPLE	SHAPE	D	W	X	T	H	J	BOND	GRIT	CONCENTRATION
	4BT9	100	10	1	20	32	50	MDT	B151	C100

SPECIFICATIONS
DIMENSIONS: D 30-250mm; W 4-15mm; X 0,2-10mm
BONDS: MDT (Resin bond), MDX (Metal bond)
COOLING: D (Dry), O (Oil), E (Emulsion)

Individual tool configuration on request

4F9

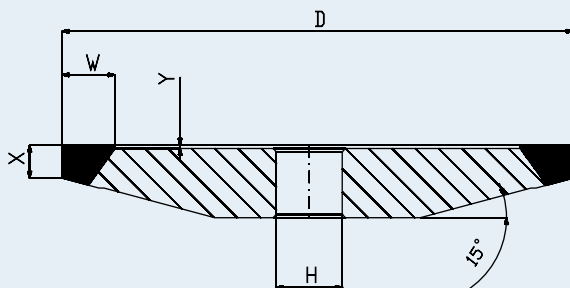


ORDERING EXAMPLE	SHAPE	D	W	R	T	H	J	Y	BOND	GRIT	CONCENTRATION
	4F9	100	4	R1	20	20	40	1,5	MDT	B151	C75

SPECIFICATIONS
DIMENSIONS: D 35-400mm; W 2-15mm
BONDS: MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)
COOLING: D (Dry), O (Oil), E (Emulsion)

Individual tool configuration on request

4ET9

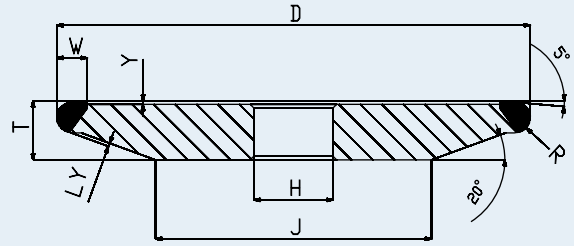


ORDERING EXAMPLE	SHAPE	D	W	X	H	Y	BOND	GRIT	CONCENTRATION
	4ET9	125	5	2	20	1	MDT	D64	C75

SPECIFICATIONS
DIMENSIONS: D 50-200mm; W 2-10mm; X 1-5mm
BONDS: MDT (Resin bond), MDX (Metal bond)
COOLING: D (Dry), O (Oil), E (Emulsion)

Individual tool configuration on request

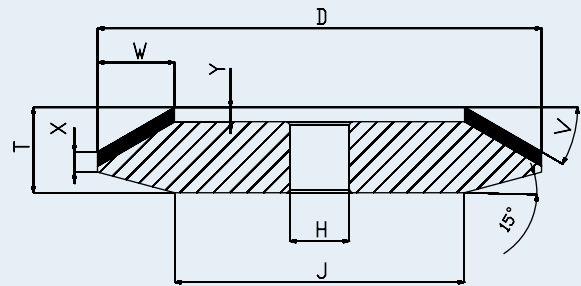
4F5



SPECIFICATIONS	DIMENSIONS:	D 50-150mm; W 3-6mm										
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)										
	COOLING:	D (Dry), O (Oil), E (Emulsion)										
ORDERING EXAMPLE	SHAPE	D	W	R	T	H	J	Y	LY	BOND	GRIT	CONCENTRATION
	4F5	100	5	R2	15	20	75	1,5	2	MDT	D126	C75

Individual tool configuration on request

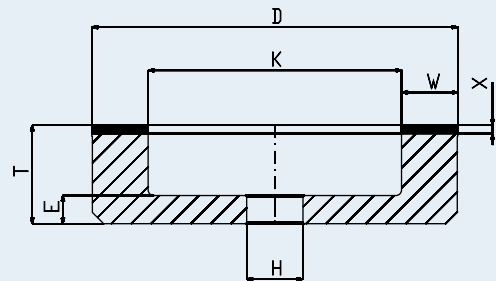
4V5



SPECIFICATIONS	DIMENSIONS:	D 60-350mm; W 8-60mm; X 1,5-5mm										
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)										
	COOLING:	D (Dry), O (Oil), E (Emulsion)										
ORDERING EXAMPLE	SHAPE	D	W	X	V	T	H	J	Y	BOND	GRIT	CONCENTRATION
	4V5	100	5	2	30°	30	20	75	2	MDT	D64	C75

Individual tool configuration on request

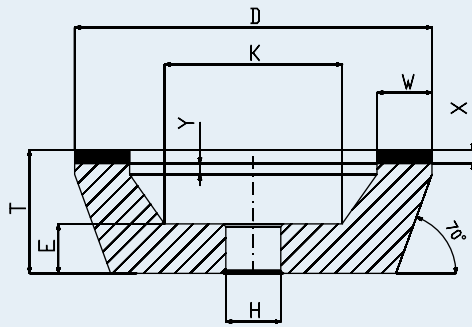
6A2



SPECIFICATIONS	DIMENSIONS:	D 12-500mm; W 5-100mm; X 1-40mm										
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)										
	COOLING:	D (Dry), O (Oil), E (Emulsion)										
ORDERING EXAMPLE	SHAPE	D	W	X	T	H	E	K	BOND	GRIT	CONCENTRATION	
	6A2	150	6	2	40	20	6	138	MDT	D126	C50	

Individual tool configuration on request

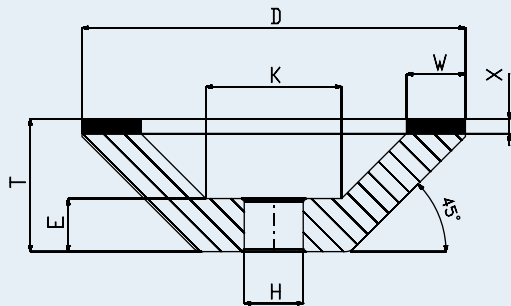
11A2



SPECIFICATIONS	DIMENSIONS: D 30-400mm; W 5-30mm; X 2-20mm										
	BONDS: MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)										
ORDERING EXAMPLE	COOLING: D (Dry), O (Oil), E (Emulsion)										
	SHAPE	D	W	X	T	H	E	K	Y	BOND	GRIT
11A2	125	12,5	2	60	20	20	62	1,5	MDT	D64	C50

Individual tool configuration on request

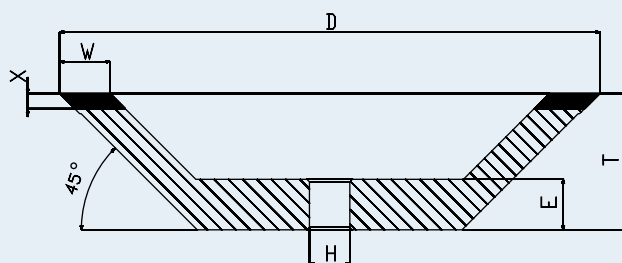
12A2/45°



SPECIFICATIONS	DIMENSIONS: D 50-400mm; W 5-30mm; X 2-15mm										
	BONDS: MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)										
ORDERING EXAMPLE	COOLING: D (Dry), O (Oil), E (Emulsion)										
	SHAPE	D	W	X	T	H	E	K	BOND	GRIT	CONCENTRATION
12A2/45°	125	10	2	50	20	20	40	MDT	D126	C75	

Individual tool configuration on request

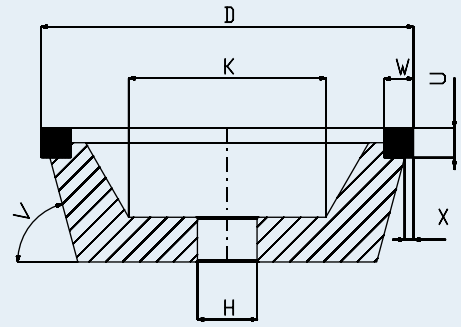
12V2



SPECIFICATIONS	DIMENSIONS: D 30-250mm; W 3-25mm; X 1-10mm										
	BONDS: MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)										
ORDERING EXAMPLE	COOLING: D (Dry), O (Oil), E (Emulsion)										
	SHAPE	D	W	X	T	H	E	BOND	GRIT	CONCENTRATION	
12V2	100	7	2	40	20	20	MDT	D46	C50		

Individual tool configuration on request

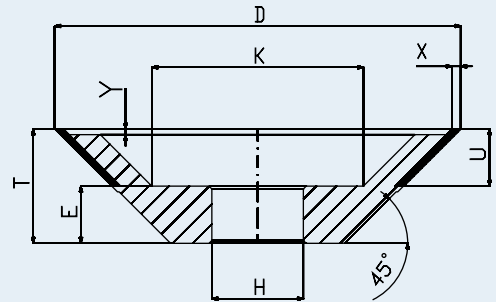
12C9



SPECIFICATIONS	DIMENSIONS:	D 40-250mm; W 4-20mm; U 3-22mm; X 1-22mm									
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)									
	COOLING:	D (Dry), O (Oil), E (Emulsion)									
ORDERING EXAMPLE	SHAPE	D	W	U	X	V	H	K	BOND	GRIT	CONCENTRATION
	12C9	125	10	4	2	70	20	60	MDT	D91	C75

Individual tool configuration on request

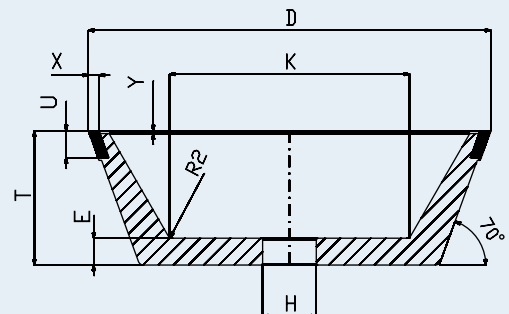
12V9



SPECIFICATIONS	DIMENSIONS:	D 25-400mm; U 6-15mm; X 1-10mm										
	BONDS:	MDT (Resin bond), MDX (Metal bond)										
	COOLING:	D (Dry), O (Oil), E (Emulsion)										
ORDERING EXAMPLE	SHAPE	D	U	X	T	H	E	K	Y	BOND	GRIT	CONCENTRATION
	12V9	100	10	2	20	20	20	60	1,5	MDT	D64	C75

Individual tool configuration on request

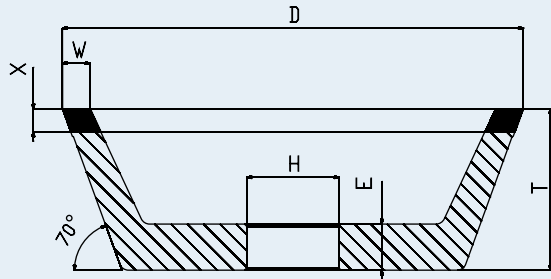
11V9



SPECIFICATIONS	DIMENSIONS:	D 40-200mm; U 6-20mm; X 1,5-10mm										
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)										
	COOLING:	D (Dry), O (Oil), E (Emulsion)										
ORDERING EXAMPLE	SHAPE	D	U	X	T	H	E	K	Y	BOND	GRIT	CONCENTRATION
	11V9	125	6	3	60	20	20	60	1,5	MDT	D64	C75

Individual tool configuration on request

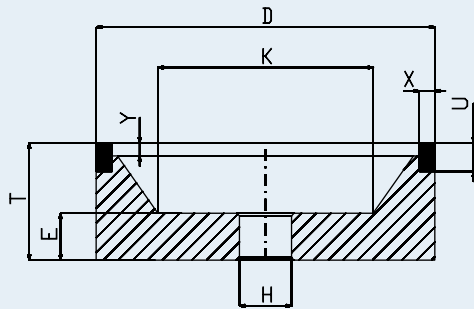
11V2



SPECIFICATIONS	DIMENSIONS: D 15-250mm; W 1,5-18mm; X 1-10mm									
	BONDS: MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)									
COOLING: D (Dry), O (Oil), E (Emulsion)										
ORDERING EXAMPLE	SHAPE	D	W	X	T	H	E	BOND	GRIT	CONCENTRATION
	11V2	75	4	3	40	20	10	MDT	D126	C75

Individual tool configuration on request

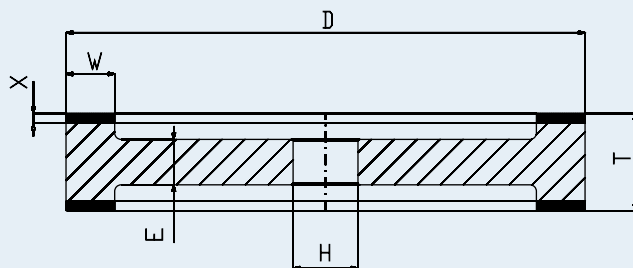
6A9



SPECIFICATIONS	DIMENSIONS: D 15-600mm; U 6-25mm; X 2-10mm											
	BONDS: MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)											
COOLING: D (Dry), O (Oil), E (Emulsion)												
ORDERING EXAMPLE	SHAPE	D	U	X	T	H	E	K	Y	BOND	GRIT	CONCENTRATION
	6A9	125	10	2	60	20	10	75	1,5	MDT	D126	C100

Individual tool configuration on request

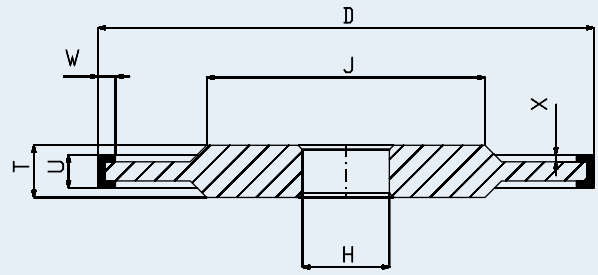
9A3



SPECIFICATIONS	DIMENSIONS: D 50-600; W 2-15; X 1-8									
	BONDS: MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)									
COOLING: D (Dry), O (Oil), E (Emulsion)										
ORDERING EXAMPLE	SHAPE	D	W	X	T	H	E	BOND	GRIT	CONCENTRATION
	9A3	175	6	3	35	20	15	MDT	D64	C75

Individual tool configuration on request

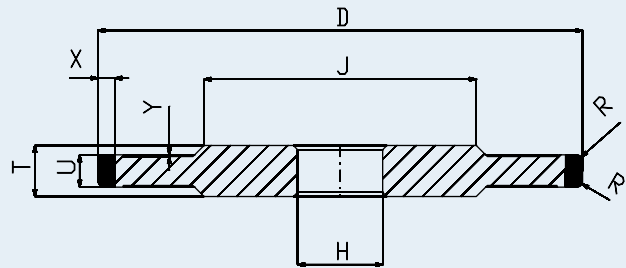
14U1



SPECIFICATIONS	DIMENSIONS:	D 75-500mm; W 2-10mm; U 4-20mm; X 1-6mm									
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)									
	COOLING:	D (Dry), O (Oil), E (Emulsion)									
ORDERING EXAMPLE	SHAPE	D	W	U	X	T	H	J	BOND	GRIT	CONCENTRATION
	14U1	125	6	8	2	15	20	70	MDT	D91	C75

Individual tool configuration on request

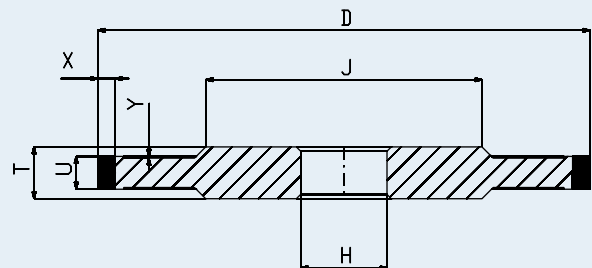
14L1



SPECIFICATIONS	DIMENSIONS:	D 30-600mm; U 2-25mm; X 1-10mm										
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)										
	COOLING:	D (Dry), O (Oil), E (Emulsion)										
ORDERING EXAMPLE	SHAPE	D	U	X	R	T	H	J	Y	BOND	GRIT	CONCENTRATION
	14L1	125	5	2	0,5	15	20	70	1	MDX	D64	C75

Individual tool configuration on request

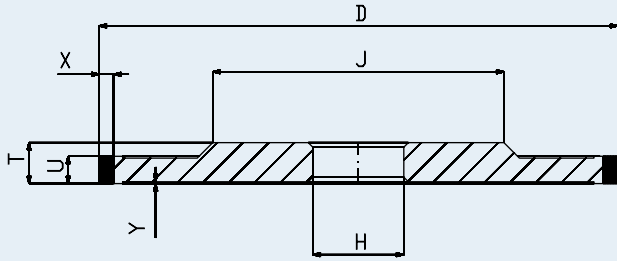
14A1



SPECIFICATIONS	DIMENSIONS:	D 10-600mm; U 0,6-35mm; X 2-20mm									
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)									
	COOLING:	D (Dry), O (Oil), E (Emulsion)									
ORDERING EXAMPLE	SHAPE	D	U	X	T	H	J	Y	BOND	GRIT	CONCENTRATION
	14A1	300	10	2	20	127	170	1,5	MDT	D126	C75

Individual tool configuration on request

3A1

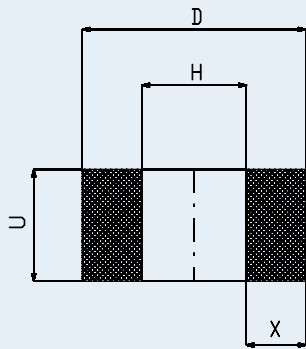


ORDERING EXAMPLE	SHAPE	D	U	X	T	H	J	Y	BOND	GRIT	CONCENTRATION
	3A1	300	10	2	20	127	170	1,5	MDT	D126	C75

SPECIFICATIONS
DIMENSIONS: D 10-600mm; U 0,6-35mm; X 2-20mm
BONDS: MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)
COOLING: D (Dry), O (Oil), E (Emulsion)

Individual tool configuration on request

1A8

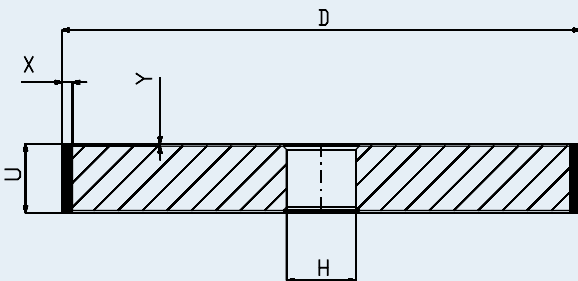


ORDERING EXAMPLE	SHAPE	D	U	X	H	BOND	GRIT	CONCENTRATION
	1A8	40	20	10	20	MDT	D46	C50

SPECIFICATIONS
DIMENSIONS: D 4-80mm; U 3-90mm is possible; X 1-35mm
BONDS: MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)
COOLING: D (Dry), O (Oil), E (Emulsion)

Individual tool configuration on request

1A1

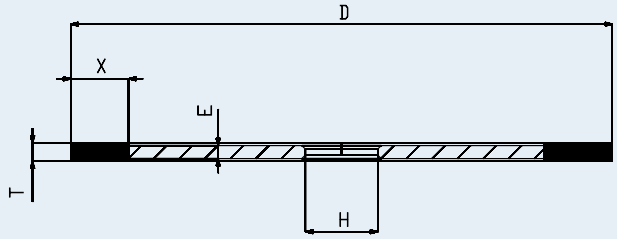


ORDERING EXAMPLE	SHAPE	D	U	X	H	Y	BOND	GRIT	CONCENTRATION
	1A1	300	20	2	127	1,5	MDT	D126	C75

SPECIFICATIONS
DIMENSIONS: D 10-600mm; U 4-100mm; X 2-30mm
BONDS: MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)
COOLING: D (Dry), O (Oil), E (Emulsion)

Individual tool configuration on request

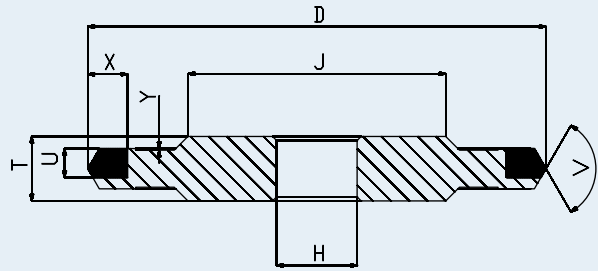
1A1R



SPECIFICATIONS	DIMENSIONS:	D 75-350mm; X 5-10mm; T 0,8-2,5mm								
	BONDS:	MDT (Resin bond), MDX (Metal bond)								
	COOLING:	D (Dry), O (Oil), E (Emulsion)								
ORDERING EXAMPLE	SHAPE	D	X	T	H	E	BOND	GRIT	CONCENTRATION	
	1A1R	150	8	1	20	1	MDT	D126	C75	

Individual tool configuration on request

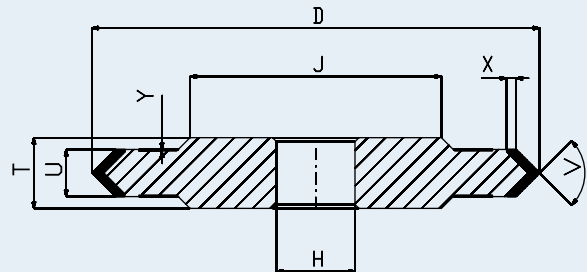
14E9



SPECIFICATIONS	DIMENSIONS:	D 35-350mm; U 0,8-5mm; X 5-10mm										
	BONDS:	MDT (Resin bond), MDX (Metal bond)										
	COOLING:	D (Dry), O (Oil), E (Emulsion)										
ORDERING EXAMPLE	SHAPE	D	U	X	V	T	H	J	Y	BOND	GRIT	CONCENTRATION
	14E9	75	1	6	60°	15	20	45	0,5	MDX	D91	C125

Individual tool configuration on request

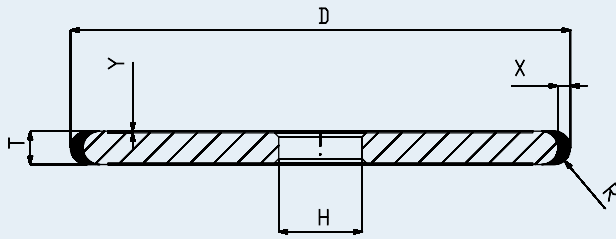
14EE1



SPECIFICATIONS	DIMENSIONS:	D 25-450mm; U 2-40mm; X 1-15mm										
	BONDS:	MDT (Resin bond), MDX (Metal bond)										
	COOLING:	D (Dry), O (Oil), E (Emulsion)										
ORDERING EXAMPLE	SHAPE	D	U	X	V	T	H	J	Y	BOND	GRIT	CONCENTRATION
	14EE1	150	3	2	60°	30	30	100	0,5	MDX	D126	C150

Individual tool configuration on request

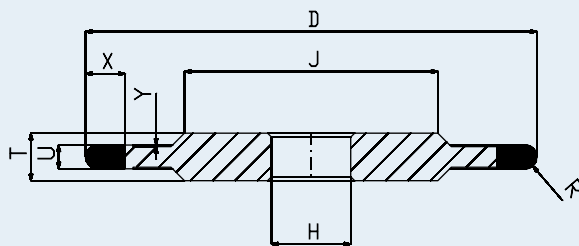
1FF1



SPECIFICATIONS	DIMENSIONS:	D 25-300mm; X 1-10mm; T 6-35mm								
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)								
	COOLING:	D (Dry), O (Oil), E (Emulsion)								
ORDERING EXAMPLE	SHAPE	D	X	R	T	H	Y	BOND	GRIT	CONCENTRATION
	1FF1	125	2	R4	8	20	0,5	MDT	D126	C75

Individual tool configuration on request

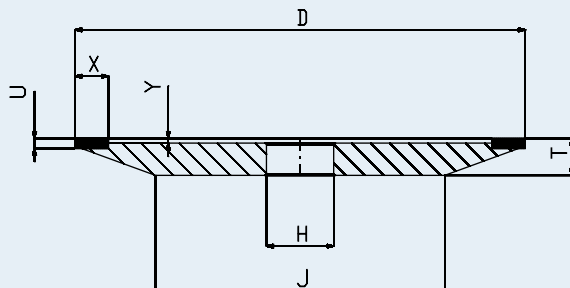
14F1



SPECIFICATIONS	DIMENSIONS:	D 20-500mm; U 0,6-30mm; X 2-20mm										
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)										
	COOLING:	D (Dry), O (Oil), E (Emulsion)										
ORDERING EXAMPLE	SHAPE	D	U	X	R	T	H	J	Y	BOND	GRIT	CONCENTRATION
	14F1	100	2	3	R1	4	10	75	0,5	MDT	D91	C100

Individual tool configuration on request

4A9

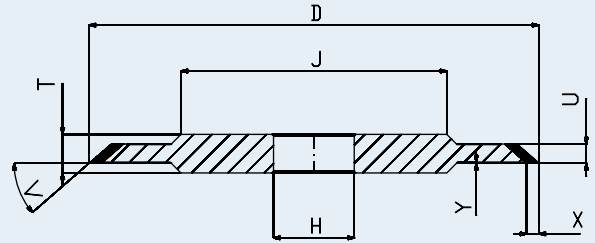


SPECIFICATIONS	DIMENSIONS:	D 35-500mm; U 0,5-16mm; X 2-16mm									
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)									
	COOLING:	D (Dry), O (Oil), E (Emulsion)									
ORDERING EXAMPLE	SHAPE	D	U	X	T	H	J	Y	BOND	GRIT	CONCENTRATION
	4A9	125	2	6	10	20	100	1,5	MDT	D126	C100

Individual tool configuration on request

GENERAL APPLICATIONS

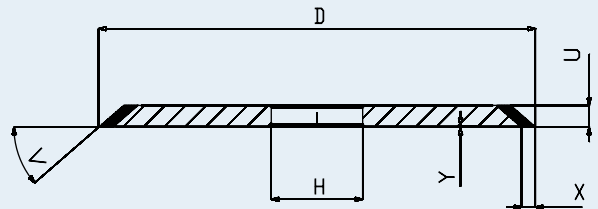
14V1



SPECIFICATIONS	DIMENSIONS:	D 40-500mm; U 2-20mm; X 2-15mm										
	BONDS:	MDT (Resin bond), MDX (Metal bond)										
	COOLING:	D (Dry), O (Oil), E (Emulsion)										
ORDERING EXAMPLE	SHAPE	D	U	X	V	T	H	J	Y	BOND	GRIT	CONCENTRATION
	14V1	175	6	2	60°	10	32	140	0,5	MDT	B126	C100

Individual tool configuration on request

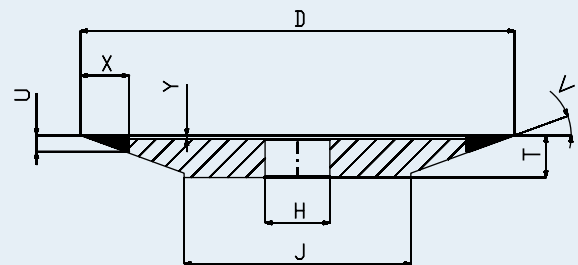
1V1



SPECIFICATIONS	DIMENSIONS:	D 40-500mm; U 4-35mm; X 2-20mm										
	BONDS:	MDT (Resin bond), MDX (Metal bond)										
	COOLING:	D (Dry), O (Oil), E (Emulsion)										
ORDERING EXAMPLE	SHAPE	D	U	X	V	H	Y	BOND	GRIT	CONCENTRATION		
	1V1	125	6	4	70°	20	0,5	MDT	D126	C75		

Individual tool configuration on request

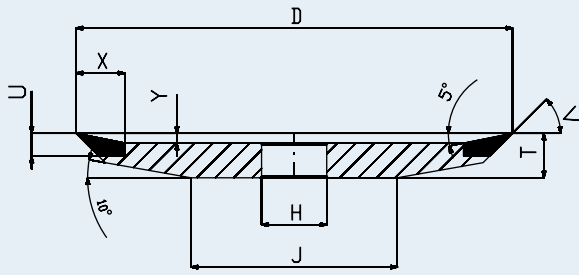
4B9



SPECIFICATIONS	DIMENSIONS:	D 75-200mm; U 0,75-5mm; X 0,5-15mm										
	BONDS:	MDT (Resin bond), MDX (Metal bond)										
	COOLING:	D (Dry), O (Oil), E (Emulsion)										
ORDERING EXAMPLE	SHAPE	D	U	X	V	T	H	J	Y	BOND	GRIT	CONCENTRATION
	4B9	150	1	6	20°	8	32	130	0,5	MDT	D64	C75

Individual tool configuration on request

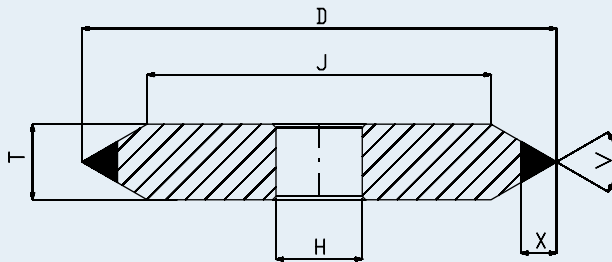
4B4



SPECIFICATIONS	DIMENSIONS: D 25-200mm; U 1,5-4mm; X 3-10mm BONDS: MDT (Resin bond), MDX (Metal bond) COOLING: D (Dry), O (Oil), E (Emulsion)											
ORDERING EXAMPLE	SHAPE	D	U	X	V	T	H	J	Y	BOND	GRIT	CONCENTRATION
	4B4	150	1,5	6	30°	10	30	90	1	MDT	D64	C100

Individual tool configuration on request

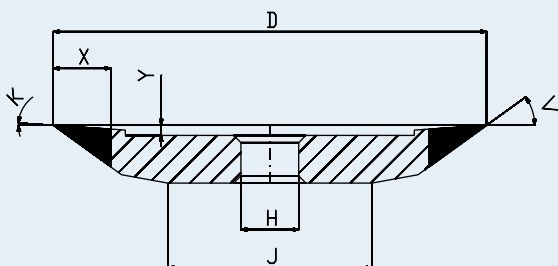
14K1



SPECIFICATIONS	DIMENSIONS: D 35-300mm; X 3-10mm BONDS: MDT (Resin bond), MDX (Metal bond) COOLING: D (Dry), O (Oil), E (Emulsion)										
ORDERING EXAMPLE	SHAPE	D	X	V	T	H	J	BOND	GRIT	CONCENTRATION	
	14K1	150	4	30°	8	30	120	MDT	D164	C100	

Individual tool configuration on request

4K9



SPECIFICATIONS	DIMENSIONS: D 30-350mm; X 2-20mm BONDS: MDT (Resin bond), MDX (Metal bond) COOLING: D (Dry), O (Oil), E (Emulsion)										
ORDERING EXAMPLE	SHAPE	D	X	V	H	K	J	Y	BOND	GRIT	CONCENTRATION
	4K9	150	7	20°	30	5°	95	2,5	MDT	D64	C100

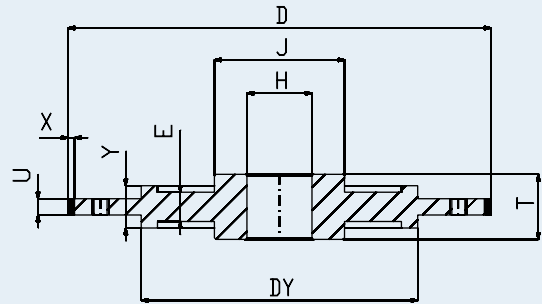
Individual tool configuration on request

GENERAL APPLICATIONS

TOOLS

For the optical industry

E



SPECIFICATIONS

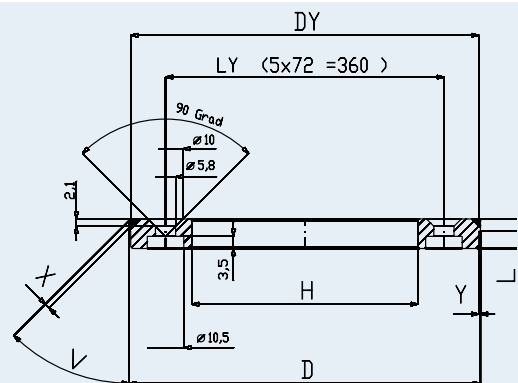
DIMENSIONS: D 60-210mm; U 4-60mm; X 1-4mm
BONDS: MDT (Resin bond), MDX (Metal bond), MDS (Electroplated bond)
COOLING: O (Oil), E (Emulsion)
DIN: 58742

ORDERING EXAMPLE

SHAPE	D	U	X	T	H	E	J	Y	DY	BOND	GRIT	CONCENTRATION
E	100	8	1	25	25	15	45	20	55	MDX	D64	C90

Individual tool configuration on request

F



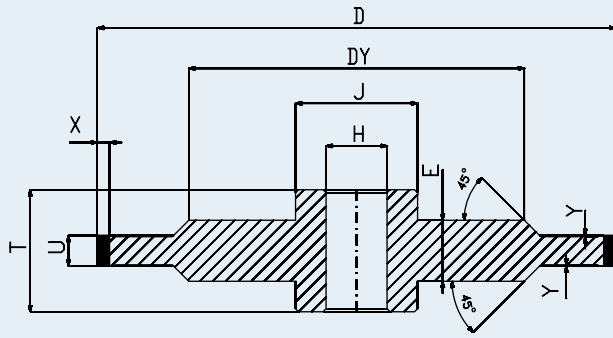
SPECIFICATIONS

DIMENSIONS: D 90-200mm; X 2-3mm
BONDS: MDT (Resin bond), MDX (Metal bond), MDS (Electroplated bond)
COOLING: O (Oil), E (Emulsion)
DIN: 58742

ORDERING EXAMPLE

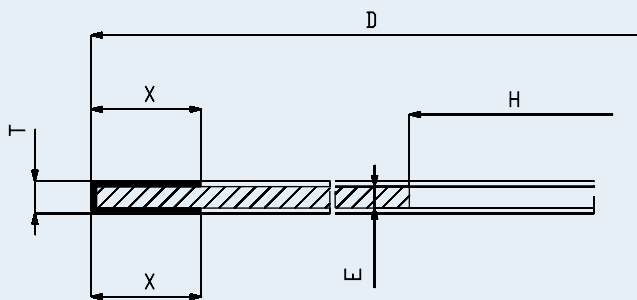
SHAPE	D	X	V	T	H	L	Y	LY	DY	BOND	GRIT	CONCENTRATION
F	100	2	45°	10	65	8	1	80	98	MDX	D64	C90

Individual tool configuration on request

D

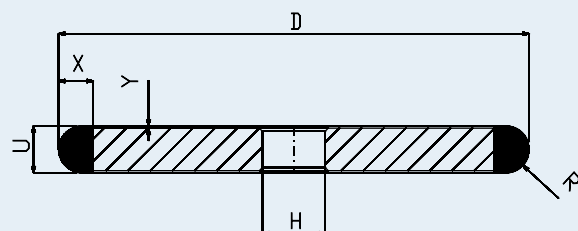
SPECIFICATIONS	DIMENSIONS: D 50-250mm; U 2-50mm; X 2-15mm												
	BONDS: MDT (Resin bond), MDX (Metal bond), MDS (Electroplated bond)												
ORDERING EXAMPLE	COOLING: O (Oil), E (Emulsion)												
	DIN: 58742												
SHAPE	D	U	X	T	H	E	J	Y	DY	BOND	GRIT	CONCENTRATION	
D	160	8	2	35	20	20	30	1	90	MDX	D64	C90	

Individual tool configuration on request

**1A1R(S)**

SPECIFICATIONS	DIMENSIONS: D 125-400mm; X 5-10mm								
	BONDS: MDS (Electroplated bond)								
ORDERING EXAMPLE	COOLING: D (Dry), O (Oil), E (Emulsion)								
	SHAPE	D	X	T	H	E	BOND	GRIT	
1A1R(S)	150	10	0,8	20	0,65	MDS	D126		

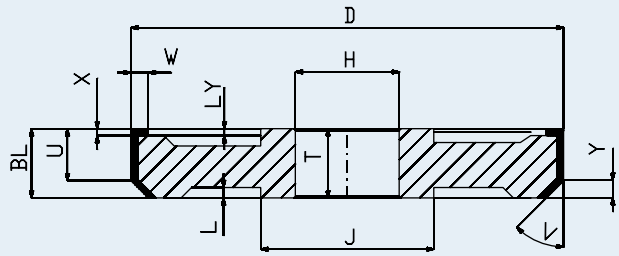
Individual tool configuration on request

**1F1**

SPECIFICATIONS	DIMENSIONS: D 25-200mm; U 6-12mm; X 4-6mm									
	BONDS: MDT (Resin bond), MDX (Metal bond), MDS (Electroplated bond)									
ORDERING EXAMPLE	COOLING: O (Oil), E (Emulsion)									
	SHAPE	D	U	X	R	H	Y	BOND	GRIT	CONCENTRATION
1F1	100	2	3	R1	10	0,2	MDT	D91	C100	

Individual tool configuration on request

EZ3

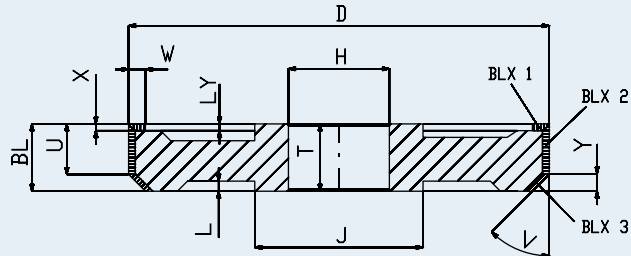


SPECIFICATIONS	DIMENSIONS:	D 48-200mm; W 1,5-22mm; U 3,5-45mm; X 1-6mm
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDS (Electroplated bond)
	COOLING:	O (Oil), E (Emulsion)

ORDERING EXAMPLE	SHAPE	D	W	U	X	V	T	H	J	L	Y	LY	BL	BOND	GRIT	CONCENTRATION
	EZ3	100	5	15	1	45°	20	20	50	2	5	1	20	MDX	D46	C125

Individual tool configuration on request

EZ3/A

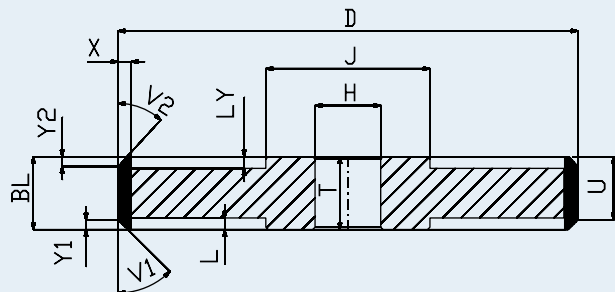


SPECIFICATIONS	DIMENSIONS:	D 48-200mm; W 1,5-22mm; U 3,5-45mm; X 1-6mm
	BONDS:	MDT (Resin bond), MDX (Metal bond)
	COOLING:	O (Oil), E (Emulsion)

ORDERING EXAMPLE	SHAPE	D	W	U	X	V	T	H	J	L	Y	LY	BL	BOND	GRIT			CONCENTRATION			
	EZ3/A	100	5	15	1	45°	20	20	50	2	5	1	20	MDX	LAYER			LAYER			
																BLX1	BLX2	BLX3	BLX1	BLX2	BLX3
																D25	D46	D35	C125	C90	C125

Individual tool configuration on request

EZ4

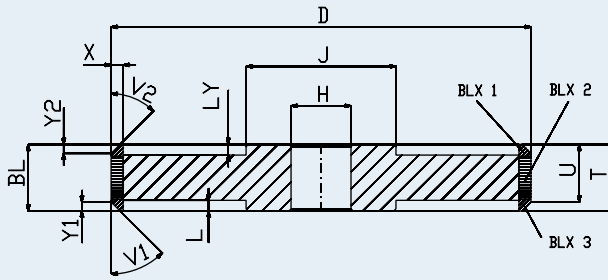


SPECIFICATIONS	DIMENSIONS:	D 48-200mm; W 1,5-22mm; U 3,5-45mm; X 2-6mm
	BONDS:	MDT (Resin bond), MDX (Metal bond)
	COOLING:	O (Oil), E (Emulsion)

ORDERING EXAMPLE	SHAPE	D	U	X	V	V1	T	H	J	L	Y	LY	BL	BOND	GRIT	CONCENTRATION
	EZ4	100	6	2,5	45°	0,5	20	20	50	2	1,8	2	15	MDX	D46	C125

Individual tool configuration on request

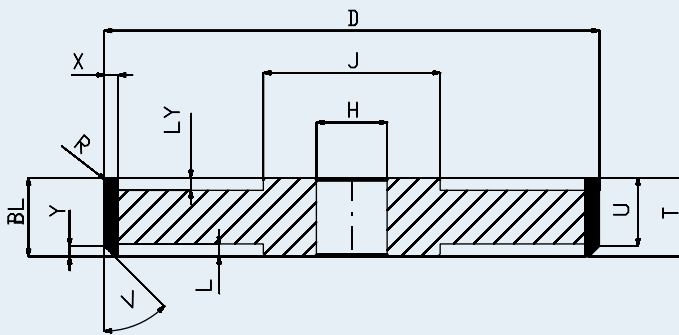
EZ4/A



SPECIFICATIONS	DIMENSIONS:		D 48-200mm; W 1,5-22mm; U 3,5-45mm; X 2-6mm																															
	BONDS:		MDT (Resin bond), MDX (Metal bond)																															
COOLING:		O (Oil), E (Emulsion)																																
ORDERING EXAMPLE	SHAPE	EZ4/A	D	100	U	6	X	2,5	V	45°	R	0,5	T	20	H	20	J	50	L	2	Y	1,8	LY	2	BL	15	BOND	MDX	GRIT			CONCENTRATION		
																LAYER																		
																BLX1	BLX2	BLX3	BLX1	BLX2	BLX3	D25	D46	D35	C125	C90	C125							

Individual tool configuration on request

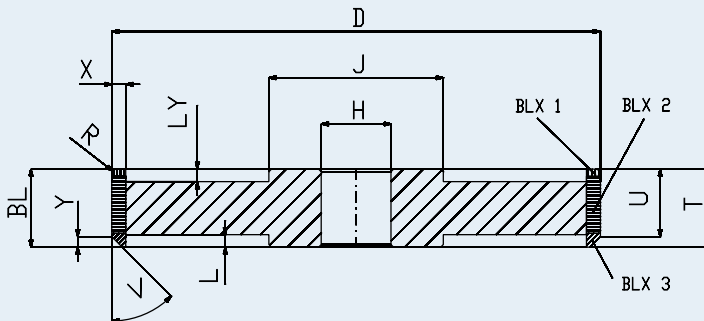
EZ5



SPECIFICATIONS	DIMENSIONS:		D 48-200mm; W 1,5-22mm; U 3,5-45mm; X 2-6mm																													
	BONDS:		MDT (Resin bond), MDX (Metal bond)																													
COOLING:		O (Oil), E (Emulsion)																														
ORDERING EXAMPLE	SHAPE	EZ5	D	100	U	6	X	2,5	V	45°	R	0,5	T	20	H	20	J	50	L	2	Y	1,8	LY	2	BL	15	BOND	MDX	GRIT	D46	CONCENTRATION	C125

Individual tool configuration on request

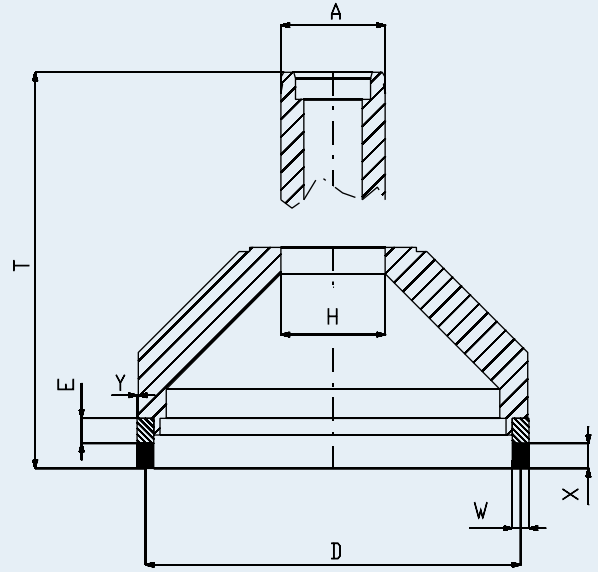
EZ5/A



SPECIFICATIONS	DIMENSIONS:		D 48-200mm; W 1,5-22mm; U 3,5-45mm; X 2-6mm																															
	BONDS:		MDT (Resin bond), MDX (Metal bond)																															
COOLING:		O (Oil), E (Emulsion)																																
ORDERING EXAMPLE	SHAPE	EZ5/A	D	100	U	6	X	2,5	V	45°	R	0,5	T	20	H	20	J	50	L	2	Y	1,8	LY	2	BL	15	BOND	MDX	GRIT			CONCENTRATION		
																LAYER																		
																BLX1	BLX2	BLX3	BLX1	BLX2	BLX3	D25	D46	D35	C125	C90	C125							

Individual tool configuration on request

PF

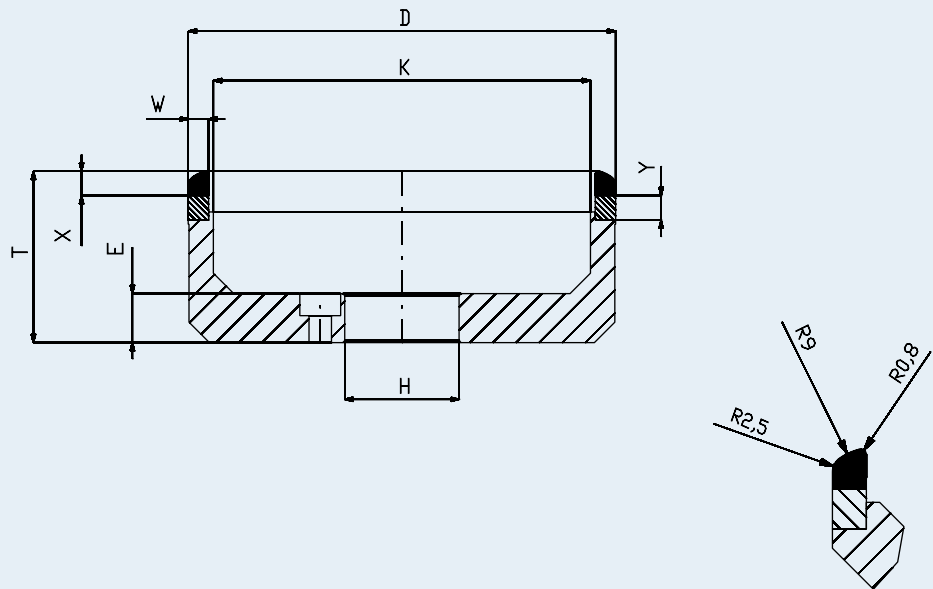


SPECIFICATIONS	DIMENSIONS:	D 3-450mm; W 1-30mm; X 4-25mm									
	BONDS:	MDT (Resin bond), MDX (Metal bond)									
	COOLING:	O (Oil), E (Emulsion)									
	DIN:	58741									

ORDERING EXAMPLE	SHAPE	D	W	X	T	H	E	Y	A	BOND	GRIT	CONCENTRATION
	PF	45	5	4	45	15	5	1	20	MDX	D76	C75

Individual tool configuration on request

PF/R

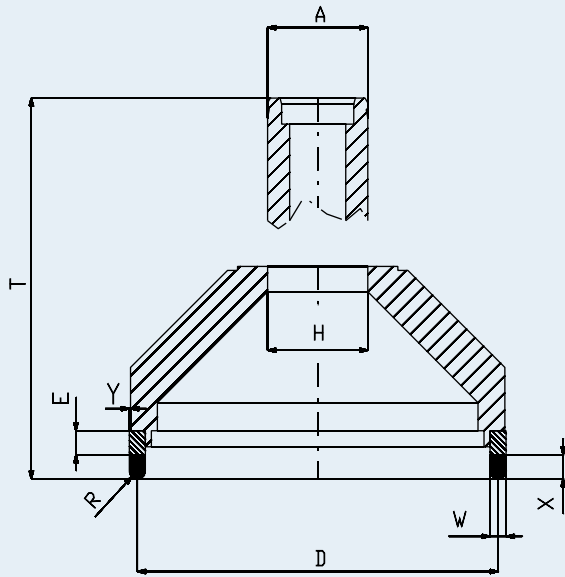


SPECIFICATIONS	DIMENSIONS:	D 3-350mm; W 1-15mm; X 4-10mm									
	BONDS:	MDT (Resin bond), MDX (Metal bond)									
	COOLING:	O (Oil), E (Emulsion)									
	DIN:	58741									

ORDERING EXAMPLE	SHAPE	D	W	X	T	H	E	K	Y	BOND	GRIT	CONCENTRATION
	PF/R	105	5	5	50	30	15	90	5	MDX	D76	C75

Individual tool configuration on request

RF



SPECIFICATIONS

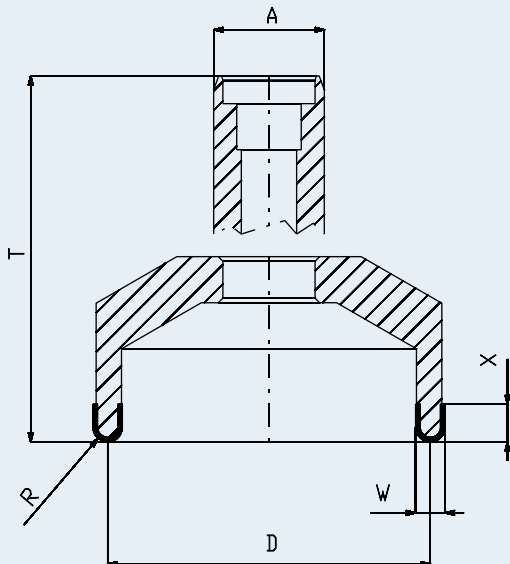
DIMENSIONS: D 3-350mm; W 1-10mm; X 4-10mm
BONDS: MDT (Resin bond), MDX (Metal bond)
COOLING: O (Oil), E (Emulsion)
DIN: 58741

ORDERING EXAMPLE

SHAPE	D	W	X	R	T	H	E	Y	A	BOND	GRIT	CONCENTRATION
RF	20	5	6	2,5	30	10	5	1	15	MDX	D64	C50

Individual tool configuration on request

RF(S)



SPECIFICATIONS

DIMENSIONS: D 3-300mm; W 1-10mm; X 2-4mm
BONDS: MDS (Electroplated bond)
COOLING: O (Oil), E (Emulsion)

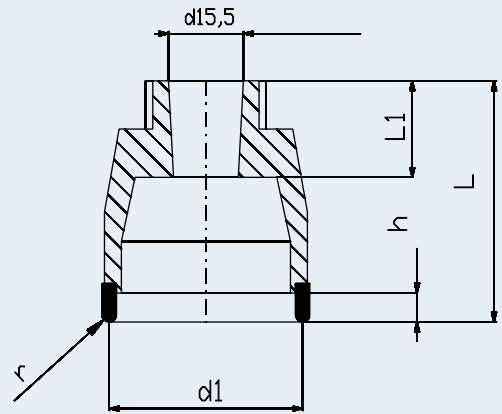
ORDERING EXAMPLE

SHAPE	D	W	X	R	T	A	BOND	GRIT
RF(S)	20	5	4	2,5	30	10	MDS	D64

Individual tool configuration on request

Mounting for RF

Ø	L1
15,5	22
20	27
27,67	37

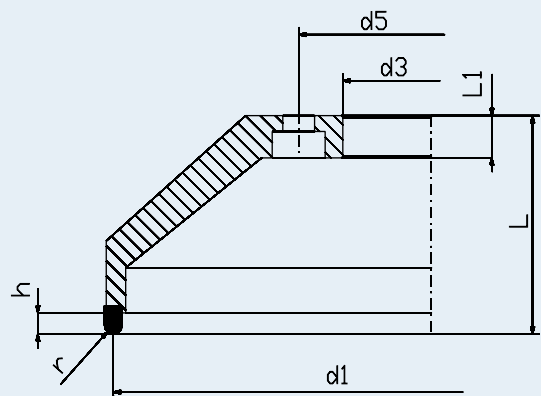


SPECIFICATIONS

MACHINE TYPE: CMV, FS3, FSK 200, FSK 300
DIN: 58741

Individual tool configuration on request

Mounting for RF

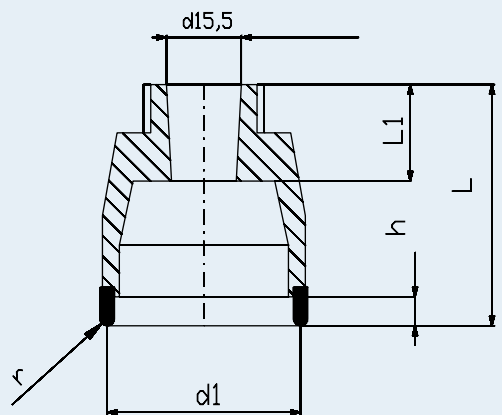


SPECIFICATIONS

MACHINE TYPE: Satisloh RF2, Satisloh RF2 (von Ø60 – Ø300), SPM 200
DIN: 58741

Individual tool configuration on request

Mounting for RF



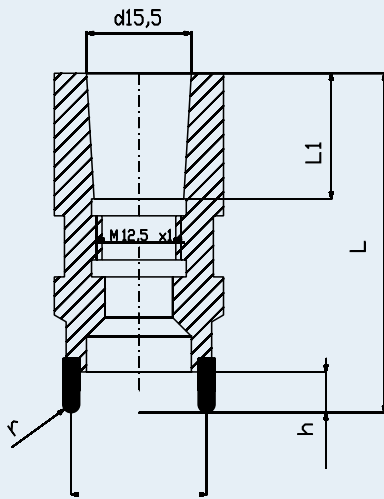
SPECIFICATIONS

MACHINE TYPE: Satisloh RF1, Satisloh RF1 <= d1 Ø60, Form B
DIN: 58741

Individual tool configuration on request

Mounting

for RF



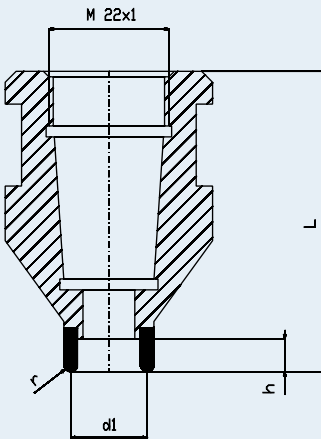
SPECIFICATIONS

MACHINE TYPE: Satisloh RF1, Satisloh RF1 $\leq \varnothing 25$, Form C
DIN: 58741

Individual tool configuration on request

Mounting

for RF



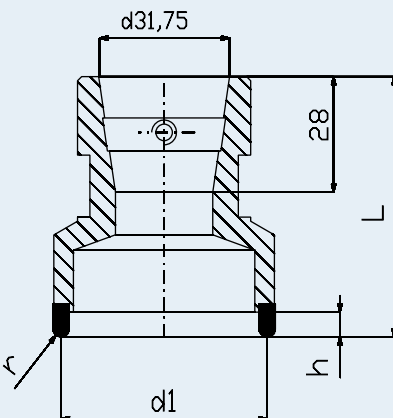
SPECIFICATIONS

MACHINE TYPE: Satisloh RF1S, RX-SPH
DIN: 58741

Individual tool configuration on request

Mounting

for RF (with bayonet-type fitting)

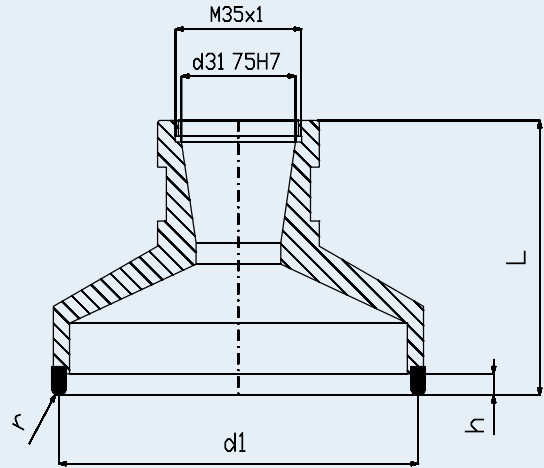


SPECIFICATIONS

MACHINE TYPE: Satisloh RF 3A (Bajonett), Satisloh RXT, Satisloh SPM 100
DIN: 58741

Individual tool configuration on request

Mounting for RF (steep cone)

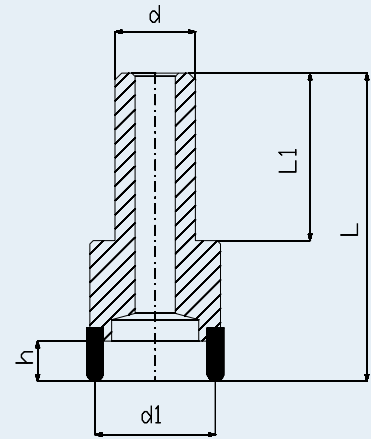


SPECIFICATIONS

MACHINE TYPE: —
DIN: 58741

Individual tool configuration on request

Mounting for RF

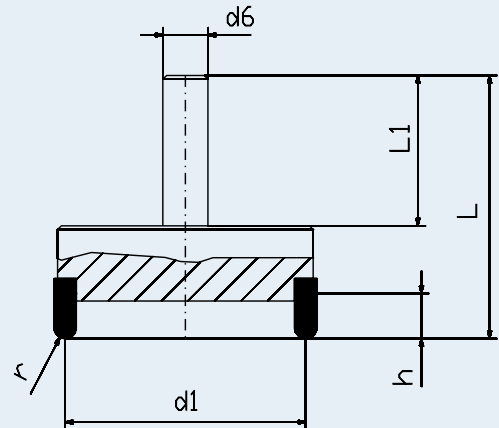


SPECIFICATIONS

MACHINE TYPE: Staisloh, OPTO-TECH, Schneider, Z12, Z25, Z40
DIN: 58741

Individual tool configuration on request

Mounting for RF

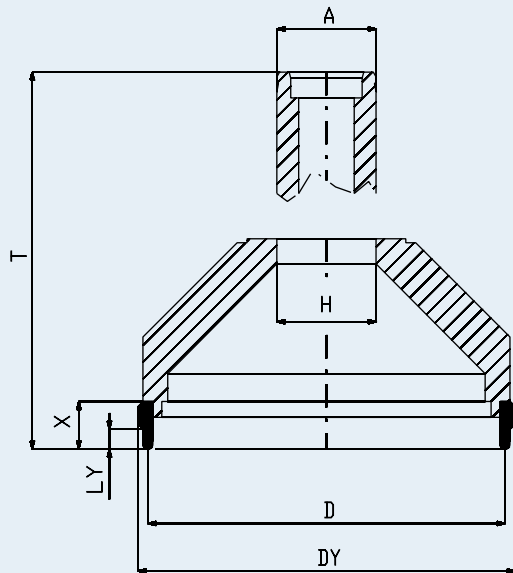


SPECIFICATIONS

MACHINE TYPE: Satisloh SPS20, OPTO-TECH, Schneider
DIN: 58741

Individual tool configuration on request

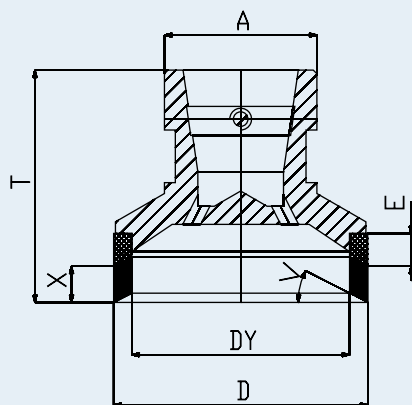
KW



ORDERING EXAMPLE	SHAPE	D	X	T	H	LY	DY	A	BOND	GRIT	CONCENTRATION
	KW	10	10	20	5	4	15	8	MDX	D46	C90

Individual tool configuration on request

TF

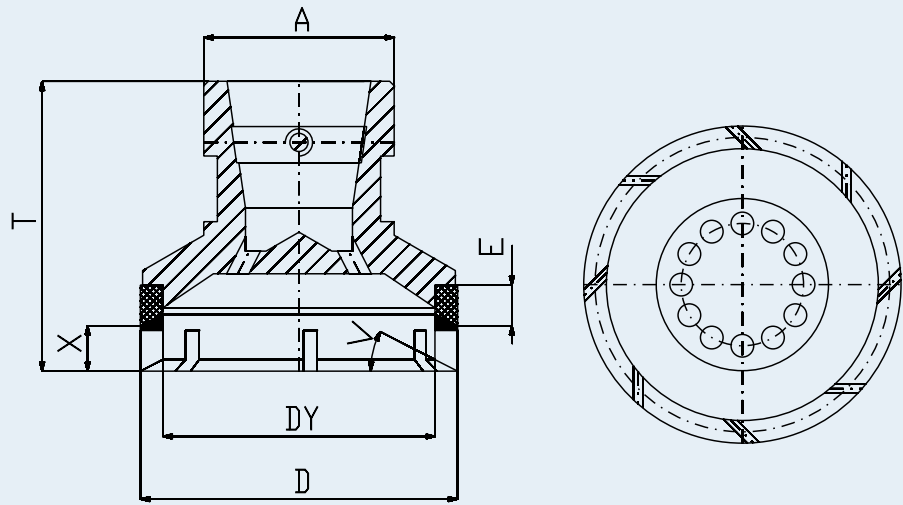


ORDERING EXAMPLE	SHAPE	D	X	V	T	E	DY	A	BOND	GRIT	CONCENTRATION
	TF	103	8	30°	100	8	90	80	MDX	D181	C35

Individual tool configuration on request

TF/S

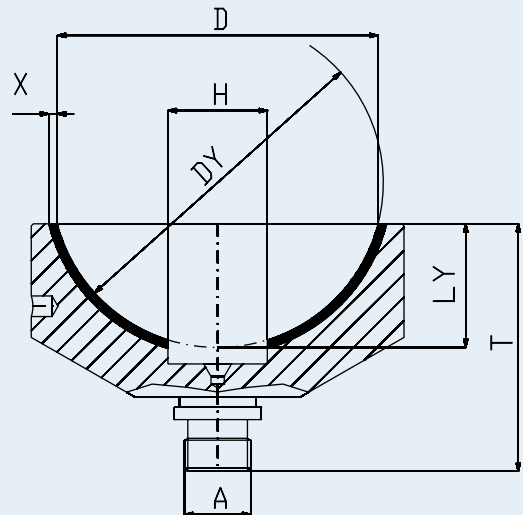
with flushing slots



SPECIFICATIONS	DIMENSIONS:	D 60-112mm; X 8-10mm									
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDS (Electroplated bond)									
	COOLING:	O (Oil), E (Emulsion)									
ORDERING EXAMPLE	SHAPE	D	X	V	T	E	DY	A	BOND	GRIT	CONCENTRATION
	TF/S	103	8	30°	100	8	90	80	MDX	D181	C35

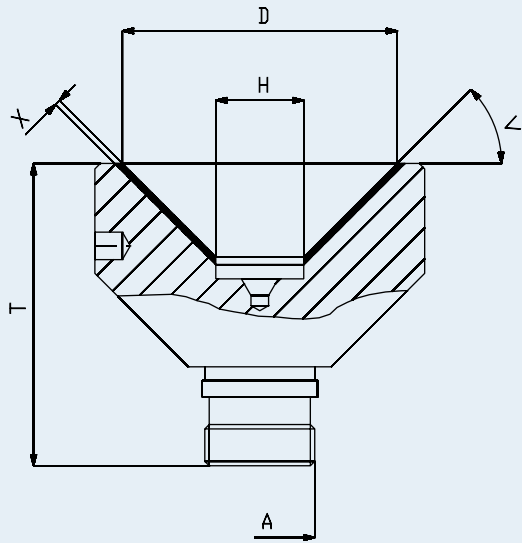
Individual tool configuration on request

A



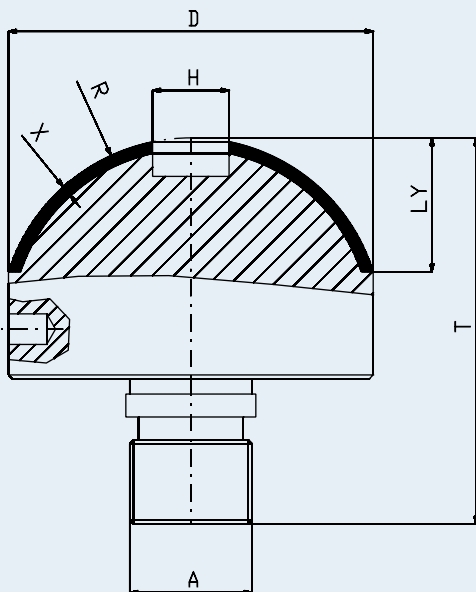
SPECIFICATIONS	DIMENSIONS:	D 3,6-235mm; X 1-15mm									
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDS (Electroplated bond)									
	COOLING:	O (Oil), E (Emulsion)									
	DIN:	58723									
	ATTENTION:	$LY = DY \times 0,35mm$									
ORDERING EXAMPLE	SHAPE	D	X	T	H	LY	DY	A	BOND	GRIT	CONCENTRATION
	A	121	1	100	37	47	125	30	MDX	D25	C50

Individual tool configuration on request

B

SPECIFICATIONS	DIMENSIONS: D 10-200mm; X 1-1,5mm									
	BONDS: MDT (Resin bond), MDX (Metal bond), MDS (Electroplated bond)									
COOLING: O (Oil), E (Emulsion)										
DIN: 58723										
ORDERING EXAMPLE	SHAPE	D	X	V	T	H	A	BOND	GRIT	CONCENTRATION
		B	25	1	45°	40	8	20	MDX	D15

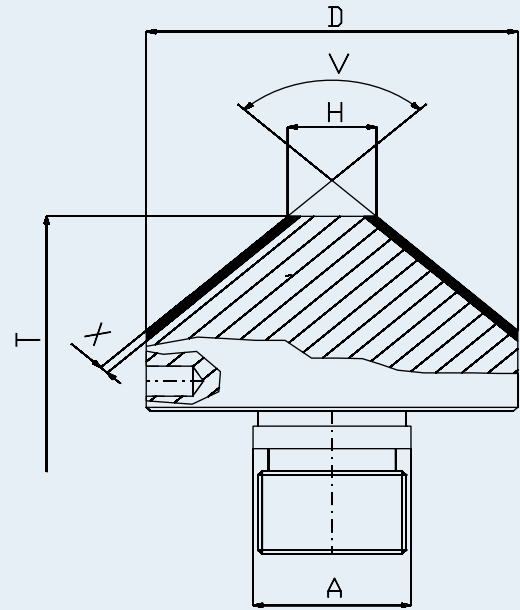
Individual tool configuration on request

FK

SPECIFICATIONS	DIMENSIONS: D 5,2-200mm; X 1-15mm										
	BONDS: MDT (Resin bond), MDX (Metal bond), MDS (Electroplated bond)										
COOLING: O (Oil), E (Emulsion)											
DIN: 58723											
ATTENTION: LY = DY x 0,35mm											
ORDERING EXAMPLE	SHAPE	D	X	R	T	H	LY	A	BOND	GRIT	CONCENTRATION
		FK	115	1	65	100	30	45	50	MDX	D25

Individual tool configuration on request

FKE

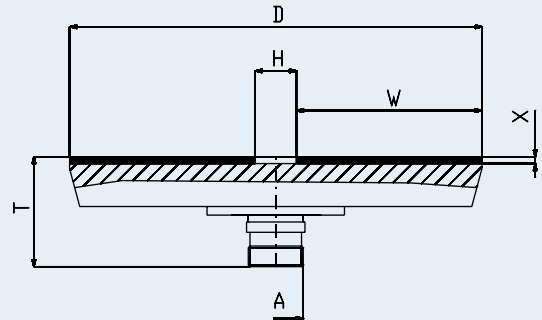


SPECIFICATIONS	DIMENSIONS:	D 3-200mm; X 1-6mm
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDS (Electroplated bond)
	COOLING:	O (Oil), E (Emulsion)
	DIN:	58723

ORDERING EXAMPLE	SHAPE	D	X	V	T	H	A	BOND	GRIT	CONCENTRATION
	FKE	70	1	90°	90	40	60	MDX	D15	C50

Individual tool configuration on request

C

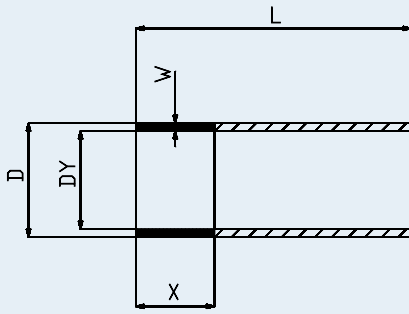


SPECIFICATIONS	DIMENSIONS:	D 35-410mm; W 28-185mm; X 2-5mm
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDS (Electroplated bond)
	COOLING:	D (trocken), O (Oil), E (Emulsion)
	DIN:	58723

ORDERING EXAMPLE	SHAPE	D	W	X	T	H	A	BOND	GRIT	CONCENTRATION
	C	75	27,5	2	40	20	30	MDX	D15	C50

Individual tool configuration on request

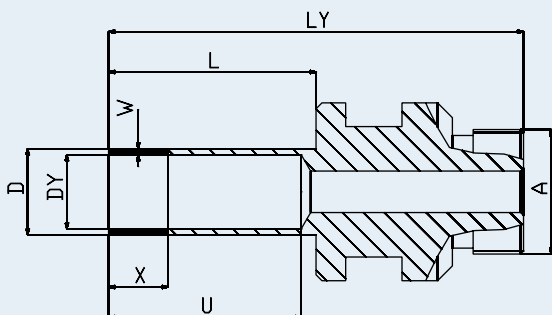
HB1



SPECIFICATIONS	DIMENSIONS: D 2,5-100mm; W 1-2mm; X 5-10mm BONDS: MDX (Metal bond), MDS (Electroplated bond) COOLING: O (Oil), E (Emulsion)									
ORDERING EXAMPLE	SHAPE	D	W	X	L	DY	BOND	GRIT	CONCENTRATION	
	HB1	20	1	10	40	18	MDX	D126	C50	

Individual tool configuration on request

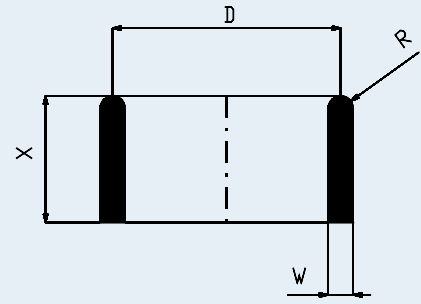
HB2



SPECIFICATIONS	DIMENSIONS: D 2,5-100; W 1-2mm; X 5-10mm BONDS: MDX (Metal bond), MDS (Electroplated bond) COOLING: O (Oil), E (Emulsion)										
ORDERING EXAMPLE	SHAPE	D	W	U	X	L	LY	DY	BOND	GRIT	CONCENTRATION
	HB2	30	1	30	10	25	50	28	MDX	D126	C50

Individual tool configuration on request

SR

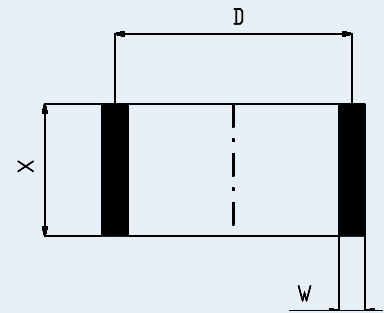


SPECIFICATIONS	DIMENSIONS:	D 3-200mm; W 1-20mm; X 6-15mm
	BONDS:	MDT (Resin bond), MDX (Metal bond)
	COOLING:	O (Oil), E (Emulsion)
	D AFTER DIN:	58741

ORDERING EXAMPLE	SHAPE	D	W	X	R	BOND	GRIT	CONCENTRATION
	SR	10	2	6	1	MDX	D46	C75

Individual tool configuration on request

SP

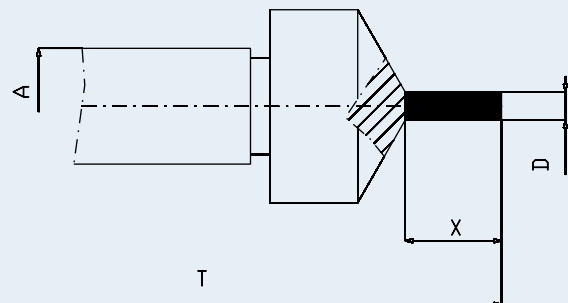


SPECIFICATIONS	DIMENSIONS:	D 3-200mm; W 1-20mm; X 6-15mm
	BONDS:	MDT (Resin bond), MDX (Metal bond)
	COOLING:	O (Oil), E (Emulsion)
	D AFTER DIN:	58741

ORDERING EXAMPLE	SHAPE	D	W	X	BOND	GRIT	CONCENTRATION
	SP	50	3	6	MDX	D46	C75

Individual tool configuration on request

FSN-MF

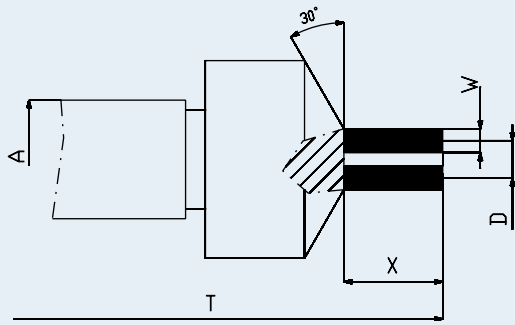


SPECIFICATIONS	DIMENSIONS:	D 0,5-4mm; X 4-6mm
	BONDS:	MDT (Resin bond), MDX (Metal bond)
	COOLING:	O (Oil), E (Emulsion)
	MINIMUM ORDER QUANTITY:	3 pieces

ORDERING EXAMPLE	SHAPE	D	X	T	A	BOND	GRIT	CONCENTRATION
	FSN-MF	2,25	6	30	10	MDX	D5	C35

Individual tool configuration on request

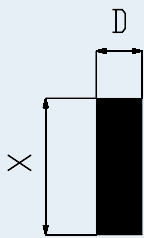
FSH-MF



SPECIFICATIONS	DIMENSIONS: D 1,5-6,3mm; W 0,5-2mm; X 5-6mm BONDS: MDX (Metal bond) COOLING: O (Oil), E (Emulsion) MINIMUM ORDER QUANTITY: 3 pieces								
	ORDERING EXAMPLE	SHAPE	D	W	X	T	A	BOND	GRIT
	FSH-MF	1,75	0,5	10	40	5	MDX	D5	C35

Individual tool configuration on request

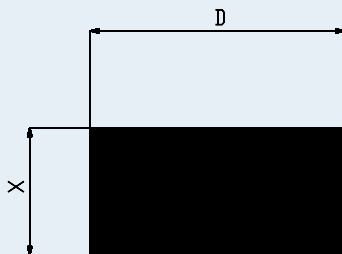
FSN-OK



SPECIFICATIONS	DIMENSIONS: D 1,5-4mm; X 6mm BONDS: MDT (Resin bond), MDX (Metal bond) COOLING: E (Emulsion) MINIMUM ORDER QUANTITY: 3 pieces					
	ORDERING EXAMPLE	SHAPE	D	X	BOND	GRIT
	FSN-OK	2,25	6	MDX	D5	C35

Individual tool configuration on request

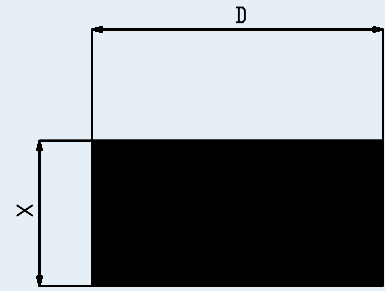
FSW-OK



SPECIFICATIONS	DIMENSIONS: D 4-125mm; X 2-35mm BONDS: MDT (Resin bond), MDX (Metal bond) COOLING: O (Oil), E (Emulsion) MINIMUM ORDER QUANTITY: 5 pieces					
	ORDERING EXAMPLE	SHAPE	D	X	BOND	GRIT
	FSW-OK	10	10	MDX	D5	C35

Individual tool configuration on request

PP

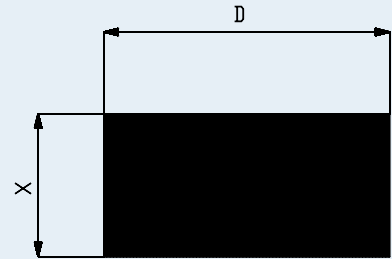


SPECIFICATIONS	DIMENSIONS:	D 2-15mm; X 2-6mm
	BONDS:	MDT (Resin bond), MDX (Metal bond), MDR (Ceramic bond)
	COOLING:	D (Dry), O (Oil), E (Emulsion)
	MINIMUM ORDER QUANTITY:	50 pieces
	DIN:	58745

ORDERING EXAMPLE	SHAPE	D	X	BOND	GRIT	CONCENTRATION
	PP	8	3	MDX	D10	C35

Individual tool configuration on request

PK-PP



SPECIFICATIONS	DIMENSIONS:	D 2-15mm; X 2-6mm
	BONDS:	MDX (Metal bond)
	COOLING:	O (Oil), E (Emulsion)
	MINIMUM ORDER QUANTITY:	50 pieces
	DIN:	58745

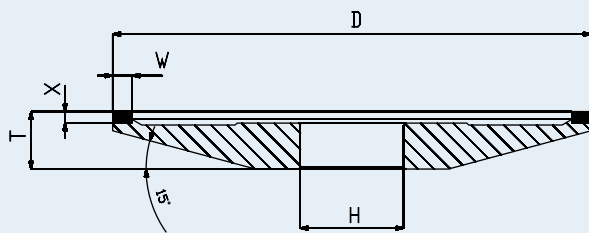
ORDERING EXAMPLE	SHAPE	D	X	BOND	GRIT	CONCENTRATION
	PP-PK	8	3	MDX	D10	C35

Individual tool configuration on request

TOOLS

For the woodworking and plastics industry

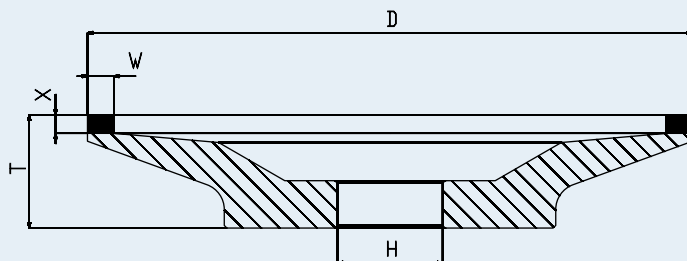
F100SG



ORDERING EXAMPLE	SHAPE	D	W	X	T	H	BOND	GRIT	CONCENTRATION
	F100SG	100	5	2	10	20	MDT	D46	C50

Individual tool configuration on request

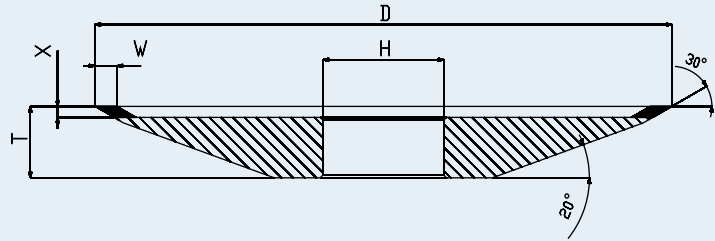
F105SG



ORDERING EXAMPLE	SHAPE	D	W	X	T	H	BOND	GRIT	CONCENTRATION
	F105SG	125	5	4	23	20	MDT	D64	C75

Individual tool configuration on request

F145SG

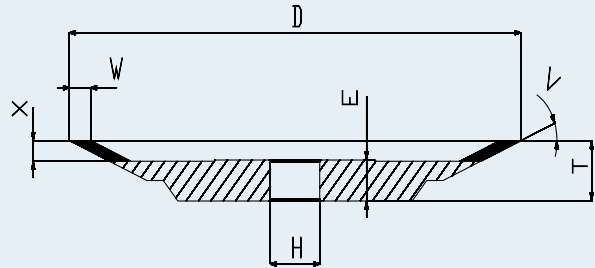


SPECIFICATIONS	DIMENSIONS:	D 75-200mm; W 2-8mm; X 2-4mm
	BONDS:	MDT (Resin bond)
	COOLING:	D (Dry), O (Oil), E (Emulsion)
	RECOMMENDATION MACHINE TYPE:	WIDMA, Akemat, Vollmer-Biberach, Vollmer-Dornhan, WIDMA

ORDERING EXAMPLE	SHAPE	D	W	X	T	H	BOND	GRIT	CONCENTRATION
	F145SG	125	8	4	26	20	MDT	D64	C75

Individual tool configuration on request

F160SG

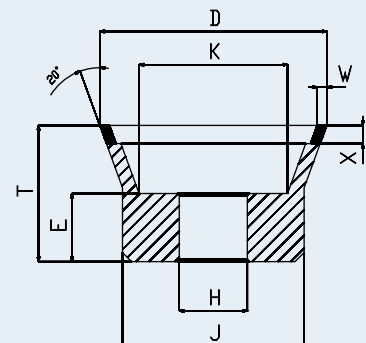


SPECIFICATIONS	DIMENSIONS:	D 75-200mm; X 4-16mm; W 2-10mm
	BONDS:	MDT (Resin bond)
	COOLING:	D (Dry), O (Oil), E (Emulsion)
	RECOMMENDATION MACHINE TYPE:	Walter AG, Akemat, Vollmer-Biberach, Vollmer-Dornhan, Universal-Werkzeugschleifmaschinen

ORDERING EXAMPLE	SHAPE	D	W	X	V	T	H	E	BOND	GRIT	CONCENTRATION
	F160SG	75	7,1	2,3	25°	26	20	19	MDT	D64	C75

Individual tool configuration on request

F170SG

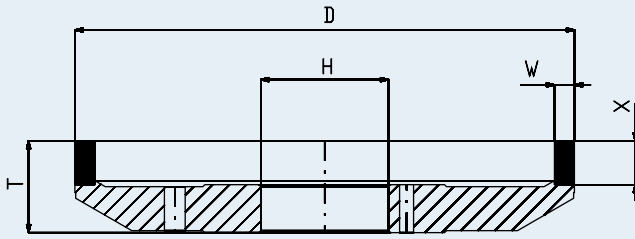


SPECIFICATIONS	DIMENSIONS:	D 40mm; W 2mm; X 5mm
	BONDS:	MDT (Resin bond)
	COOLING:	D (Dry), O (Oil), E (Emulsion)
	RECOMMENDATION MACHINE TYPE:	Universal-Werkzeugschleifmaschinen

ORDERING EXAMPLE	SHAPE	D	W	X	T	H	E	K	J	BOND	GRIT	CONCENTRATION
	F170SG	40	2	5	22	10	10	24	32	MDT	D64	C75

Individual tool configuration on request

F190SG

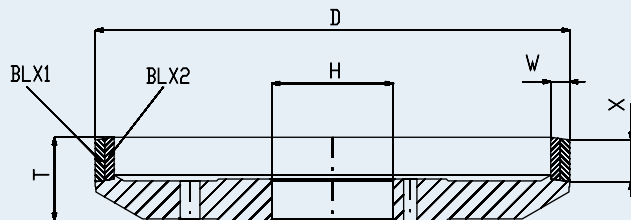


ORDERING EXAMPLE	SHAPE	D	U	X	T	H	BOND	GRIT	CONCENTRATION
	F190SG		125	6,5	3	18	32	MDT	D54

SPECIFICATIONS
DIMENSIONS: D 75-125mm; W 2-6mm; X 3-10mm
BONDS: MDT (Resin bond)
COOLING: D (Dry), O (Oil), E (Emulsion)
RECOMMENDATION MACHINE TYPE: Vollmar-Biberach, Vollmar-Dornhan, WIDMA

Individual tool configuration on request

F190SG/A

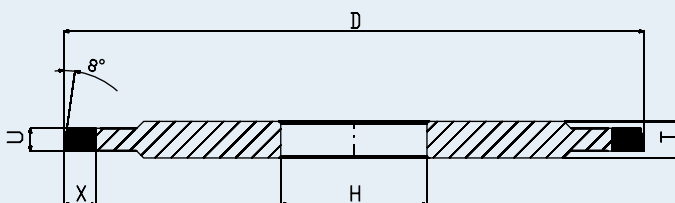


ORDERING EXAMPLE	SHAPE	D	U	X	T	H	BOND	GRIT		CONCENTRATION		
	F190SG/A		125	6	5	18	32	MDX	LAYER			
									BLX1	BLX2	BLX1	BLX2
								D46	D126	C75	C100	

SPECIFICATIONS
DIMENSIONS: D 75-125mm; W 2-6mm; X 3-10mm
BONDS: MDT (Resin bond)
COOLING: D (Dry), O (Oil), E (Emulsion)
RECOMMENDATION MACHINE TYPE: Vollmar-Biberach, Vollmar-Dornhan, WIDMA

Individual tool configuration on request

F240SG(1)

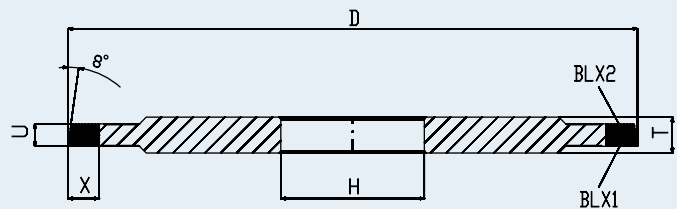


ORDERING EXAMPLE	SHAPE	D	U	X	T	H	BOND	GRIT	CONCENTRATION
	F240SG(1)		127	7	5	8	32	MDT	D54

SPECIFICATIONS
DIMENSIONS: D 50-200mm; U 2-6,5mm; X 4-8mm
BONDS: MDT (Resin bond)
COOLING: D (Dry), O (Oil), E (Emulsion)
RECOMMENDATION MACHINE TYPE: WEINIG RONDAMAT, Walter AG, Akemat, Vollmer-Biberach, Vollmar-Dornhan, WIDMA

Individual tool configuration on request

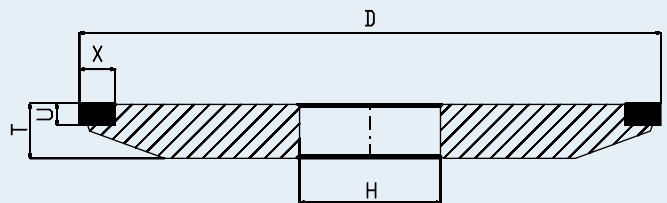
F240SG(1)/A



SPECIFICATIONS	DIMENSIONS: D 50-200mm; U 2-6,5mm; X 4-8mm									
	BONDS: MDT (Resin bond)									
COOLING: D (Dry), O (Oil), E (Emulsion)										
RECOMMENDATION MACHINE TYPE: WEINIG RONDAMAT, Walter AG, Akemat, Vollmer-Biberach, Vollmar-Dornhan, WIDMA										
ORDERING EXAMPLE	SHAPE	D	U	X	T	H	BOND	GRIT	CONCENTRATION	
	F240SG(1)/A	127	7	5	8	32	MDX	LAYER		
								BLX1 D46	BLX2 D107	BLX1 C75

Individual tool configuration on request

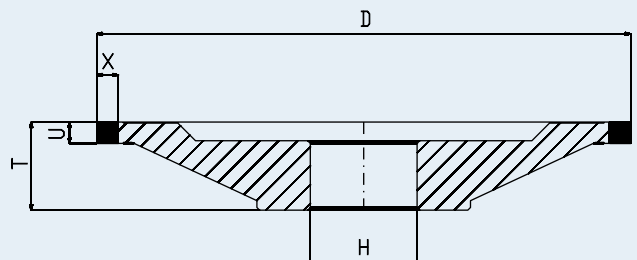
F240SG(2)



SPECIFICATIONS	DIMENSIONS: D 50-200mm; U 2-6,5mm; X 4-8mm								
	BONDS: MDT (Resin bond)								
COOLING: D (Dry), O (Oil), E (Emulsion)									
RECOMMENDATION MACHINE TYPE: WEINIG RONDAMAT, Walter AG, Akemat, Vollmer-Biberach, Vollmar-Dornhan, WIDMA									
ORDERING EXAMPLE	SHAPE	D	U	X	T	H	BOND	GRIT	CONCENTRATION
	F240SG(2)	100	6,5	4	14	20	MDT	D91	C50

Individual tool configuration on request

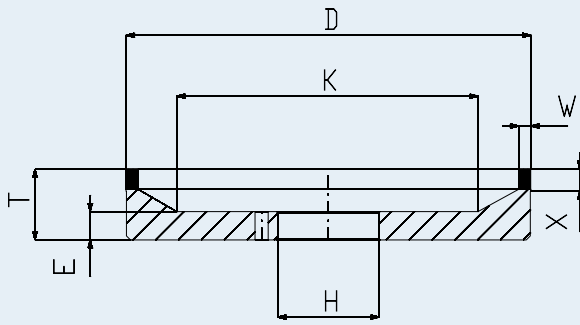
F240SG(3)



SPECIFICATIONS	DIMENSIONS: D 50-200mm; U 2-6,5mm; X 4-8mm								
	BONDS: MDT (Resin bond)								
COOLING: D (Dry), O (Oil), E (Emulsion)									
RECOMMENDATION MACHINE TYPE: WEINIG RONDAMAT, Walter AG, Akemat, Vollmer-Biberach, Vollmar-Dornhan, WIDMA									
ORDERING EXAMPLE	SHAPE	D	U	X	T	H	BOND	GRIT	CONCENTRATION
	F240SG(3)	100	4	4	16,5	20	MDT	D126	C75

Individual tool configuration on request

6A2G



SPECIFICATIONS

DIMENSIONS: D 150-250mm; W 4-10mm; X 2-10mm
BONDS: MDT (Resin bond), MDX (Metal bond)
COOLING: D (Dry), O (Oil), E (Emulsion)
RECOMMENDATION MACHINE TYPE: Göckel

ORDERING EXAMPLE

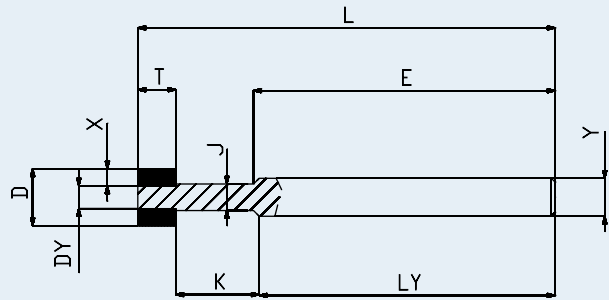
SHAPE	D	W	X	T	H	E	K	BOND	GRIT	CONCENTRATION
6A2G	200	6	4	30	50	15	180	MDT	B181	V180

Individual tool configuration on request

DIAMOND- AND CBN-TOOLS

For internal grinding

1A1W



SPECIFICATIONS

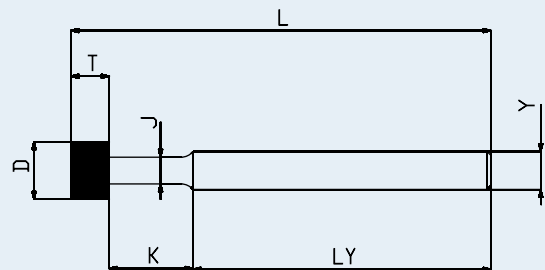
DIMENSIONS: D 0,5-55mm; X 0,5-10mm; T 0,6-200mm
BONDS: MDX (Metal bond), MDR (Ceramic bond)
COOLING: D (Dry), O (Oil), E (Emulsion)

ORDERING EXAMPLE

SHAPE	D	X	T	E	K	J	L	Y	LY	DY	BOND	GRIT	CONCENTRATION
1A1W	6,5	1,75	3	30	7	4	45	6	35	3	MDT	D76	C125

Individual tool configuration on request

1A1W-1(S)



SPECIFICATIONS

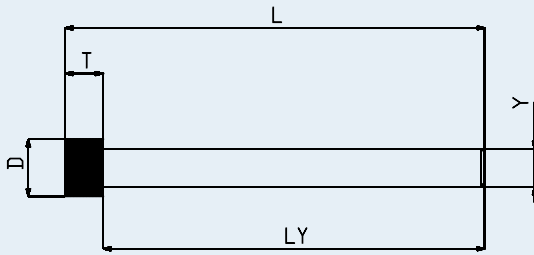
DIMENSIONS: D 0,5-6mm; T 2-29mm
BONDS: MDS (Electroplated bond)
COOLING: D (Dry), O (Oil), E (Emulsion)

ORDERING EXAMPLE

SHAPE	D	T	K	J	L	Y	LY	BOND	GRIT
1A1W-1(S)	8	5	10	4	45	6	30	MDS	D76

Individual tool configuration on request

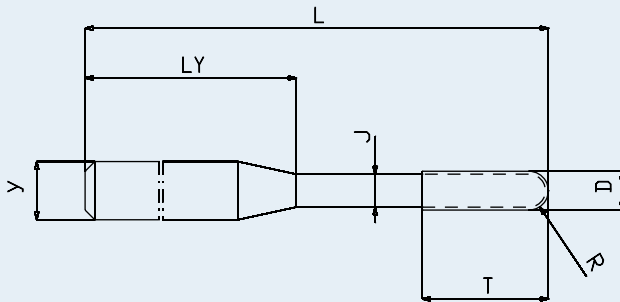
1A1W-2(S)



SPECIFICATIONS	DIMENSIONS:							BOND	GRIT
	D 3,5-60mm; T 5-55mm								
	BONDS:								
	MDS (Electroplated bond)								
	COOLING:								
	D (Dry), O (Oil), E (Emulsion)								
ORDERING EXAMPLE	SHAPE	D	T	L	Y	LY	BOND	GRIT	
	1A1W-2(S)	8	5	45	6	40	MDS	D76	

Individual tool configuration on request

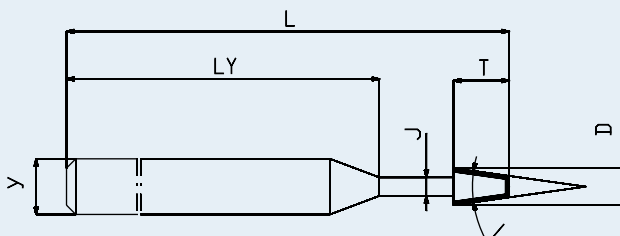
1A1W-ZR(S)



SPECIFICATIONS	DIMENSIONS:							BOND	GRIT	
	D 1-12,24mm; T 4-20mm									MDS
	BONDS:									
	MDS (Electroplated bond)									
	COOLING:									
	D (Dry), O (Oil), E (Emulsion)									
ORDERING EXAMPLE	SHAPE	D	R	T	J	L	Y	LY	BOND	GRIT
	1A1W-ZR(S)	4	2	20	3,5	60	6	30	MDS	D126

Individual tool configuration on request

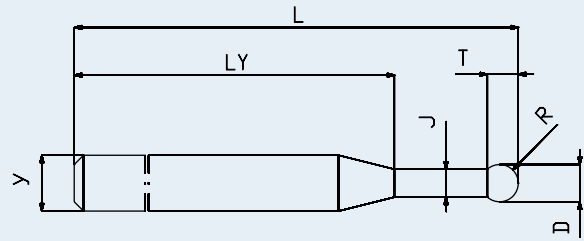
1A1W-PS(S)



SPECIFICATIONS	DIMENSIONS:							BOND	GRIT	
	D 2,8-38mm; T 3-16mm									MDS
	BONDS:									
	MDS (Electroplated bond)									
	COOLING:									
	D (Dry), O (Oil), E (Emulsion)									
ORDERING EXAMPLE	SHAPE	D	V	T	J	L	Y	LY	BOND	GRIT
	1A1W-PS(S)	4	10°	10	3	50	6	30	MDS	D126

Individual tool configuration on request

1A1W-R(S)

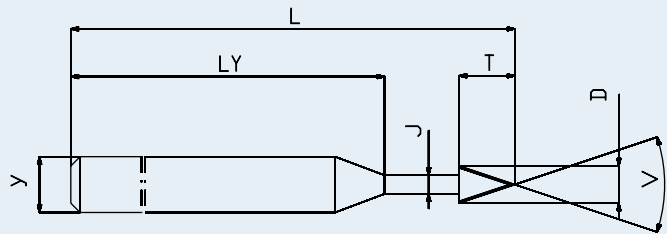


SPECIFICATIONS	DIMENSIONS:	D 1-25,3mm; T 6-80mm
	BONDS:	MDS (Electroplated bond)
	COOLING:	D (Dry), O (Oil), E (Emulsion)

ORDERING EXAMPLE	SHAPE	D	R	T	J	L	Y	LY	BOND	GRIT
	1A1W-R(S)	4	2	3,5	3	50	6	30	MDS	D126

Individual tool configuration on request

1A1W-S(S)

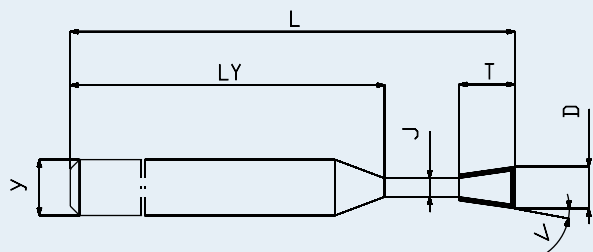


SPECIFICATIONS	DIMENSIONS:	D 3-20mm; T 1,75-100mm
	BONDS:	MDS (Electroplated bond)
	COOLING:	D (Dry), O (Oil), E (Emulsion)

ORDERING EXAMPLE	SHAPE	D	V	T	J	L	Y	LY	BOND	GRIT
	1A1W-S(S)	4	30°	8	3	50	6	30	MDS	D126

Individual tool configuration on request

1A1W-PSU(S)



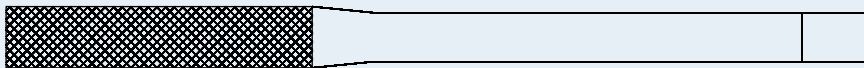
SPECIFICATIONS	DIMENSIONS:	D 4-50mm; T 6-20mm
	BONDS:	MDS (Electroplated bond)
	COOLING:	D (Dry), O (Oil), E (Emulsion)

ORDERING EXAMPLE	SHAPE	D	V	T	J	L	Y	LY	BOND	GRIT
	1A1W-PSU(S)	4	8°	8	3	50	6	35	MDS	D126

Individual tool configuration on request

DIAMOND FILES

DIAMOND NEEDLE FILES (S)



SPECIFICATIONS

GRITS: D91; D126; D151
PROFILE SHAPE: Flat, square, triangular, round, half round, oval, sword, beret, cutting edge, flat and rounded, flat/pointed

Individual tool configuration on request

DIAMOND MACHINE FILES (S)

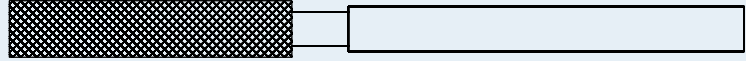


SPECIFICATIONS

GRITS: D91; D126; D151
PROFILE SHAPE: Flat, square, triangular, round, half round

Individual tool configuration on request

DIAMOND HAND FILES (S)



SPECIFICATIONS

GRITS: D91; D126; D151
PROFILE SHAPE: Flat one side, flat both sides, flat all sides, triangular, square, round, cutting edge

Individual tool configuration on request

DIAMOND RIFFLE FILES (S)



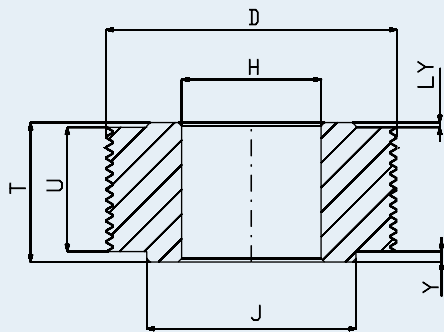
SPECIFICATIONS

GRITS: D91; D126; D151
PROFILE SHAPE: Flat blunt, triangular, square, oval / straight, oval / bent, round / straight, round / bent

Individual tool configuration on request

DIAMOND PROFILE ROLLS, DIAMOND SHAPE ROLLS

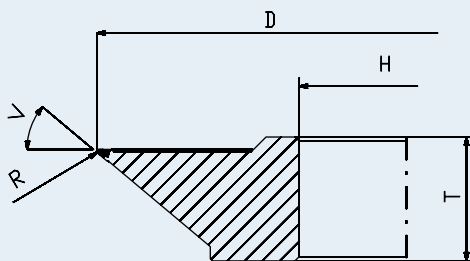
PROFILE ROLL – PRORO



SPECIFICATIONS	DIMENSIONS: D 15-240mm; U 2-150mm								
	BONDS: MDS (Electroplated bond)								
COOLING: D (Dry), O (Oil), E (Emulsion)									
ORDERING EXAMPLE	SHAPE	D	U	T	H	J	Y	LY	BOND
	PRORO	120	5	25	52	80	-	-	MDS

Individual tool configuration on request

SHAPE ROLL – FORO

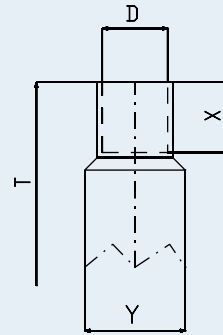


SPECIFICATIONS	DIMENSIONS: D 30-400mm						
	BONDS: MDS (Electroplated bond)						
COOLING: D (Dry), O (Oil), E (Emulsion)							
ORDERING EXAMPLE	SHAPE	D	V	R	T	H	BOND
	FORO	130	30	0,25	10	40	MDS

Individual tool configuration on request

DRESSING TOOLS AND DIAMOND ABRASIVES

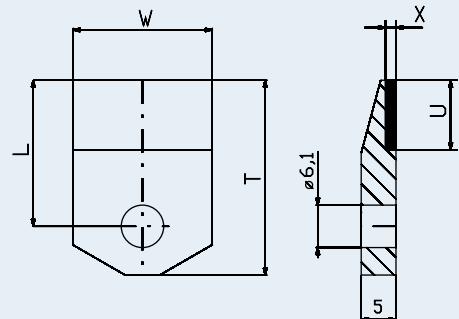
DRESSER – TK/VS



SPECIFICATIONS	DIMENSIONS:	D 4-16mm; X 4-14mm				
	BONDS:	MDX (Metal bond)				
	COOLING:	D (Dry), O (Oil), E (Emulsion)				
ORDERING EXAMPLE	SHAPE	D	X	T	Y	BOND
	TK/VS	8	8	200	12	MDX

Individual tool configuration on request

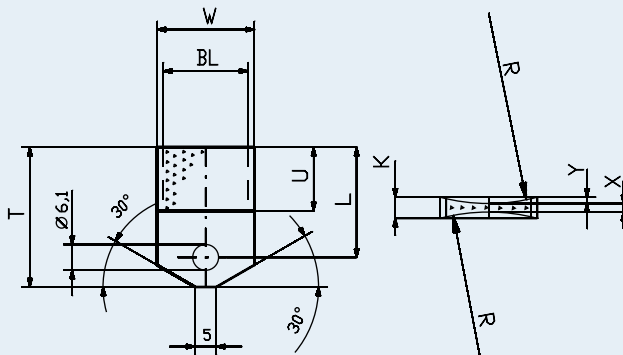
DRESSER – AP



SPECIFICATIONS	DIMENSIONS:	W 5-20mm; U 5-20mm; X 1-7mm					
	BONDS:	MDX (Metal bond)					
	COOLING:	D (Dry), O (Oil), E (Emulsion)					
ORDERING EXAMPLE	SHAPE	W	U	X	T	LB	BOND
	AP	20	10	1,5	28	21	MDX

Individual tool configuration on request

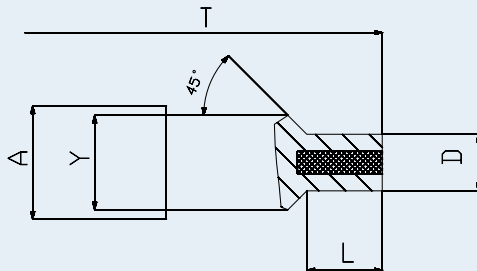
DRESSER – AP/Z



SPECIFICATIONS	DIMENSIONS: W 10-20mm; U 10-20mm; X 1-5mm										
	BONDS: MDX (Metal bond)										
COOLING: D (Dry), O (Oil), E (Emulsion)											
ORDERING EXAMPLE	SHAPE	W	U	X	R	T	K	L	Y	BL	BOND
	AP/Z	23	10	1,8	42	28	5	21	1,6	20	MDX

Individual tool configuration on request

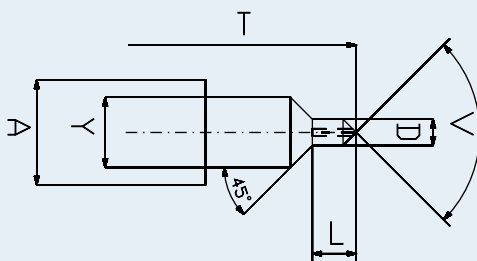
DRESSER – AMKA



SPECIFICATIONS	DIMENSIONS: D 4-20mm; V 40°-160°; T 30-100mm; Y 6-20mm							
	BONDS: MDX (Metal bond)							
COOLING: D (Dry), O (Oil), E (Emulsion)								
ORDERING EXAMPLE	SHAPE	D	V	T	L	Y	A	BOND
	AMKA	4w	0°	50	5	8	10	MDX

Individual tool configuration on request

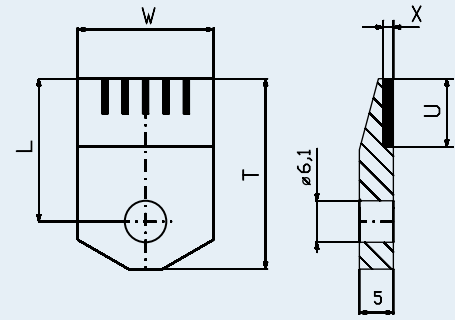
DRESSER – AMKB



SPECIFICATIONS	DIMENSIONS: D 4-20mm; V 40°-160°; T 30-100mm; Y 6-20mm							
	BONDS: MDX (Metal bond)							
COOLING: D (Dry), O (Oil), E (Emulsion)								
ORDERING EXAMPLE	SHAPE	D	V	T	L	Y	A	BOND
	AMKB	4w	90°	50	5	8	10	MDX

Individual tool configuration on request

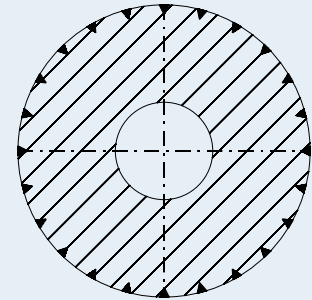
DRESSER – APMK



SPECIFICATIONS	DIMENSIONS:	W 10-20mm; U 10-15mm; X 1,5-5mm					
	BONDS:	MDX (Metal bond)					
	COOLING:	D (Dry), O (Oil), E (Emulsion)					
ORDERING EXAMPLE	SHAPE	W	U	X	T	L	BOND
	APMK	20	10	1	28	21	MDX

Individual tool configuration on request

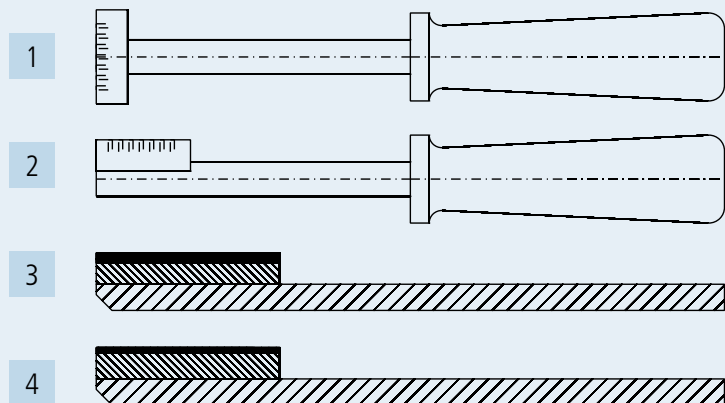
DRESSER – AR



SPECIFICATIONS	DIMENSIONS:	D 16,25mm; X 8mm			
	BONDS:	MDX (Metal bond)			
	COOLING:	D (Dry), O (Oil), E (Emulsion)			
ORDERING EXAMPLE	SHAPE	D	X	H	BOND
	AR	18	8	6,4	MDX

Individual tool configuration on request

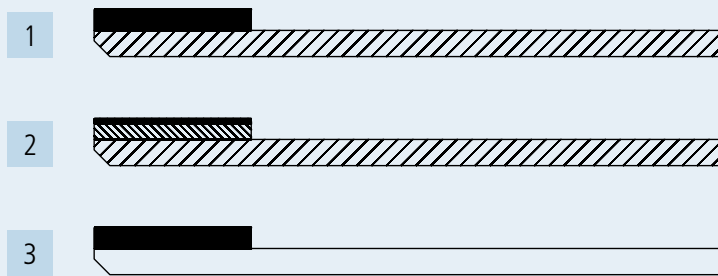
HAND DRESSER HT



SPECIFICATIONS	DIAMOND COAT DIMENSIONS:	(1+2) 30x10mm; (3) 40x6x1,5mm; (4) 40x6x1mm	
	BONDS:	MDX (Metal bond)	
	COOLING:	D (Dry), O (Oil), E (Emulsion)	

Individual tool configuration on request

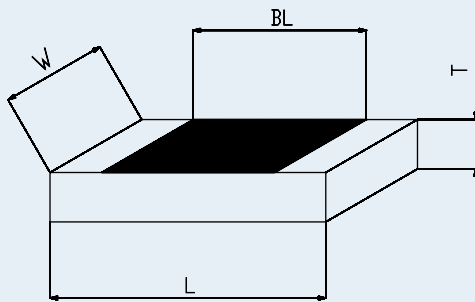
HAND LAPPING TOOL HL



SPECIFICATIONS	DIAMOND COAT DIMENSIONS:	(1) 30x10x2mm; (2) 30x10x1mm; (3) 30x10x2mm
	BONDS:	MDT (Resin bond), MDX (Metal bond)
	COOLING:	D (Dry), O (Oil), E (Emulsion)

Individual tool configuration on request

WHETPLATE – DAZL(S)

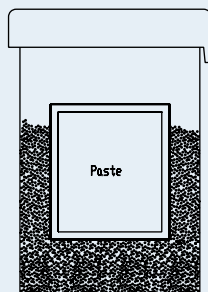


SPECIFICATIONS	DIMENSIONS:	W 20-134mm; T 5-100mm; L 100mm; BL 80mm
	BONDS:	MDS (Electroplated bond)
	COOLING:	D (Dry), O (Oil), E (Emulsion)

ORDERING EXAMPLE	SHAPE	W	T	L	BL	BOND	GRIT
	DAZL(S)	20	8	100	80	MDS	D301

Individual tool configuration on request

DIAMOND PASTES – DP

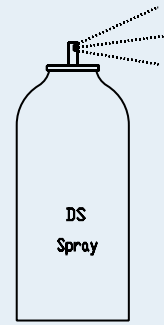


SPECIFICATIONS	AVAILABLE:	in 5, 10 and 20g plastic injectors, Grits D0,25-D50µm
	CONCENTRATIONS:	H (Highest), S (Strong), N (Normal), E (Simple)
	SOLUBILITIES:	A (Alcohol-/water soluble), O (Oil soluble), U (Universally soluble)

ORDERING EXAMPLE	SHAPE	AMOUNT	GRIT	CONCENTRATION	SOLUBILITY
	DP	10g	D30	N	O

Individual tool configuration on request

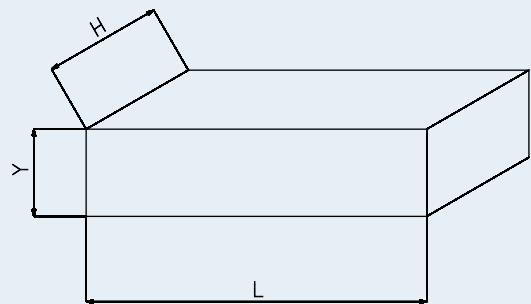
DIAMOND SPRAY – DS



SPECIFICATIONS	AVAILABLE:	in 165ml fingertip dispensers			
	GRIT SIZES:	D0,25-D15µm			
	SOLUBILITIES:	A (Alcohol-/water soluble); O (Oil-/Alcohol soluble)			
ORDERING EXAMPLE	SHAPE	AMOUNT	GRIT	SOLUBILITY	
	DS	165ml	D9	A	

Individual tool configuration on request

WHETSTONES



SPECIFICATIONS	DIMENSIONS:	H 13-50mm; L 100-200mm; Y 13-160mm			
	BONDS:	-			
	COOLING:	D (Dry), O (Oil), E (Emulsion)			
ORDERING EXAMPLE	SHAPE	H	L	Y	GRIT
	SST	50	100	25	180

Individual tool configuration on request

GENERAL INFORMATIONS

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CBN	66
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Diamond

Due to its hardness, diamond is an ideal abrasive for very hard materials. Almost 90% of the diamonds nowadays used in grinding tools are manufactured synthetically. The basic material is graphite which is transformed into the crystal lattice of the diamond with the aid of pressure and temperature in the presence of catalysts. On account of the controlled synthesis it is possible to produce diamonds with specific grinding properties for the most diverse bonding systems and grinding operations.

Whilst in metal bonds the diamonds are usually employed without a covering, with resin bonds, diamonds coated in nickel and copper are used in the majority of cases. Mainly the uneven surface of these coats reinforce the fixation of the diamonds in the bonds and quicken the heat dissipation.

Synthetic diamonds are produced in diverse qualities and grit sizes.

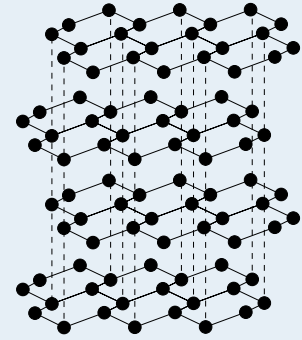
CBN

Cubic crystalline boron nitride presently is the second hardest material after diamonds.

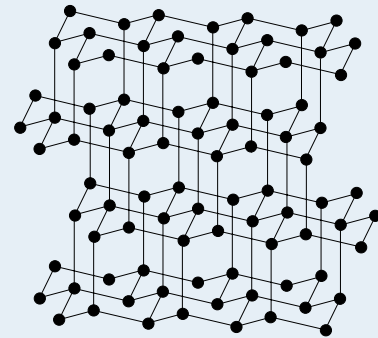
It is synthesized from the hexagonal boron nitride (a nitrogen boron compound) under pressure and temperature in the presence of catalysts, similar as diamond is synthesized.

Also cubic crystalline boron nitride is available in diverse qualities and grit sizes, and nickel-coated. The preferred application of CBN is grinding HSS qualities and of hardened steels.

CRYSTAL LATTICE
OF GRAPHITE

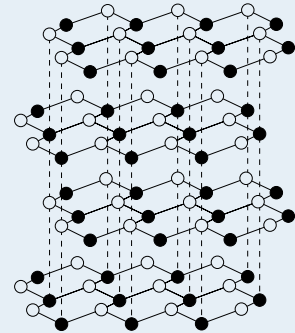


CRYSTAL LATTICE
OF DIAMOND

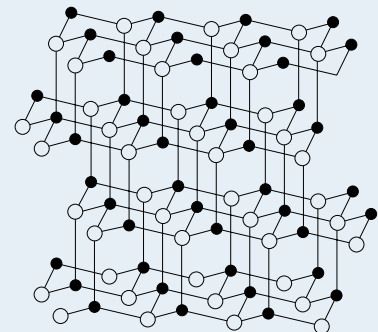


● = Carbon atoms

CRYSTAL LATTICE OF
HEXAGONAL BORON NITRIDE



CRYSTAL STRUCTURE OF
CUBIC BORON NITRIDE



● = Boron atoms ○ = Nitrogen atoms

Application ranges

for diamond- and CBN-wheels

DIAMOND WHEELS ARE EMPLOYED FOR GRINDING:

- ♦ hard metal
- ♦ cermet
- ♦ hard metal / steel combinations
- ♦ glass
- ♦ sapphire
- ♦ quartz
- ♦ ceramic materials of all kinds
- ♦ ferrotitanite
- ♦ carbide-based powder coatings
- ♦ graphite
- ♦ polycrystalline diamond and CBN blanks
- ♦ ceramic magnetic materials
- ♦ glass- and carbon-fibre reinforced synthetic materials
- ♦ tungsten carbide

CBN WHEELS ARE EMPLOYED FOR GRINDING:

- ♦ hardened high-speed steels (HSS)
- ♦ high-alloyed tool steels with at least 55 HRC
- ♦ case-hardened steels
- ♦ iron-based powder coatings
- ♦ chill castings
- ♦ soft steels in certain applications
- ♦ stellite
- ♦ surgeon steel
- ♦ PM-steels

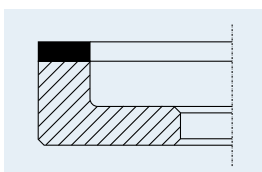
Selection criteria

for diamond and CBN wheels

Below, we have compiled the most important selection criteria for diamond and CBN wheels:

1. SHAPE

The shape of the various diamond/CBN wheels is expressed by a combination of figures and letters (e.g.: 6 A 2).



The basis for this designation system is the FEPA standard (Fédération Européenne des Fabricants de Produits Abrasifs / cf. also DIN standard 69800 and following). First choose the wheel shape suited for your grinding job. In the chart for wheel shapes on pages 10–17 the standard shapes are compiled; if you require different shapes, this can be done anytime. In that event, please let us have your sketch or drawing.

As a rule, the shape is determined by the workpiece, the machine and the grinding method. It is advisable to use a wheel shape as stable as possible to avoid oscillations during grinding. The carrier for the grinding wheels are made of different materials, depending on the bonds.

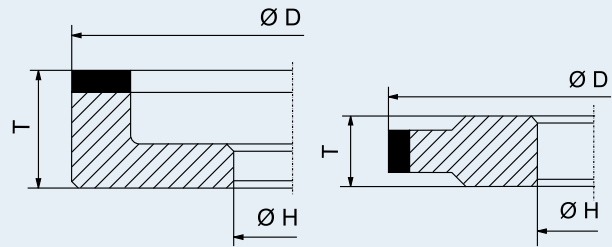
BOND	BODY MATERIAL
Resin bond (MDT)	Aluminium
	Aluminium/resin
	Graphite/resin
Metal bond (MDX)	Steel
	Bronze
Ceramic bond (MDR)	Aluminium
	Steel
S-bond (MDS)	Aluminium
	Steel

The selection of the suitable wheel carrier is done by us, corresponding to the wheel shape as well as to thermal stress and mechanical load.

2. DIMENSIONS

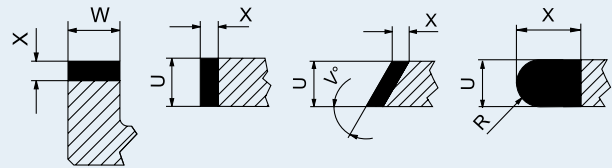
THE MOST RELEVANT DIMENSIONS FOR A DIAMOND/CBN WHEEL ARE:

- ♦ the diameter **D**
- ♦ the total height **T**
- ♦ the bore **H**



AND THE DIMENSIONS OF THE DIAMOND/CBN LAYER:

- ♦ the width of the layer **W** or **U**
- ♦ the layer depth **X**
- ♦ the profile angle **V°**
- ♦ the radius **R**



2A. DIAMETER D

Determine the diameter in accordance with the grinding operation you have to perform, with your machine, and with our cutting speed operations on page 70. The larger the wheel diameter, the more economically you will grind, thanks to the then more favourable thermal and kinematic conditions. You will find the possible dimensions among the individual shapes.

2B. TOTAL HEIGHT T

This dimension, in general, is determined in response to diameter and layer dimensions. Deviations are possible, however, for cases of limited space in the machine or of the workpiece. When placing your order, please point this out by providing exact space requirements.

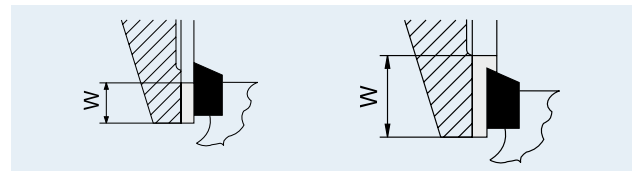
2C. BORE H

We manufacture the bores of our diamond- and CBN wheels conforming to quality H6. Against extra charge, we are also prepared to deliver our wheels with individual bore dimensions.

2D. LAYER WIDTHS W AND U

The layer widths *W* for front end layers and *U* for peripheral layers depend on the grinding operation to be performed. On principle, when grinding with diamond or CBN wheels, the contact surfaces should be as small as possible. Small layers allow faster and cooler grinding with cup wheels and plate-shaped wheels. The chip flow is better, and the wheel gives a feeling of improved performance. A broader layer is preferable in off-hand grinding, as a better guidance is provided.

The layer width should always be smaller than the workpiece to be ground.



If the layer width is larger than the workpiece to be ground, a shoulder is formed in the layer, which damages the cutting edges.

2E. LAYER DEPTHS X

Always choose a big *X*-dimension. The manufacturing costs are almost the same - whether the wheel has a layer depth of, e.g., $X = 2$ or 4 or 6 mm. The price difference then only results from the different diamond or CBN content. Bigger layer depths thus are considerably more economical.

2F. PROFILE ANGLE V°

Please consider the angle position with wheel type 1V1 respectively 14V1. The angle indication always relates to the angle formed – cf. drawing on page 29.

2G. RADIUS R

For the wheel shapes 1FF1 and 14F1 (p. 28) we have restricted ourselves to the most common radii. However, particularly with type 14F1 almost all wheel diameters and intermediate radius sizes can be manufactured.

3. DIAMOND AND CBN GRIT SIZES

In order to meet the various grinding requirements, there are available a great number of sizes. These sizes have been compiled in a standard by the FEPA (Fédération Européenne des Fabricants de Produits Abrasives).

For diamond and CBN the same grit sizes apply. Diamond grit is identified by a preceding D (e.g. D 126), CBN by a B (e.g. B 126).

The sizes shown in table are mesh sizes. For comparison, we have also included the American standard ASTM E11.

For finer grit sizes than D46/B46, the above range is continued by the fine grit sizes. Grading is essentially done by charging with water.

The grit size both determines the abrasive performance of diamond and CBN wheels as well as the surface quality achieved thereby on the workpiece. Higher abrasive performance is generally obtained with coarser grit sizes. With finer grit sizes the grinding quality is improved, but the abrading performance is reduced.

MESH GRIT SIZES*)

FEPA / DIN-STANDARD					U.S.-STANDARD ASTM E11 (mesh)		
DIAMOND		CBN		NOMINAL MESH WIDTH μm ISO R565 - 1990		DIAMOND AND CBN	
NARROW	WIDE	NARROW	WIDE	NARROW	WIDE	NARROW	WIDE
D1181	D1182			1180/1000	1180/850	16/18	16/20
D1001				1000/850		18/20	
D851	D852			850/710	850/600	20/25	20/30
D711	D711			710/600		25/30	
D601	D602			600/500	600/425	30/35	30/40
D501	500/425	35/40					
D426	D427	B426	B427	425/355	425/300	40/45	40/50
D356		B356		355/300		45/50	
D301		B301		300/250		50/60	
D251	D252	B251	B252	250/212	250/180	60/70	60/80
D213		B213		212/180		70/80	
D181		B181		180/150		80/100	
D151		B151		150/125		100/120	
D126		B126		125/106		120/140	
D107		B107		106/90		140/170	
D91		B91		90/75		170/200	
D76		B76		75/63		200/230	
D64		B64		63/53		230/270	
D54		B54		53/45		270/325	
D46		B46		45/38		325/400	

FINE GRIT SIZES*)

DIAMOND		CBN	
DR. MÜLLER DESIGNATION	AVERAGE GRIT SIZE RANGE μm	DR. MÜLLER DESIGNATION	AVERAGE GRIT SIZE RANGE μm
D35	30–40		
D20	15–25	B30	25–35
D15	10–20	B15	10–20
D9	6–12	B9	6–12
D6	4–8		
D5	4–6		
D3	2–4		

*) Sometimes there is a deviation between the grit size ordered and the grit size confirmed caused by our IT system, which automatically calculates the grit size for the technical definition of the tool. Since the fine grit sizes consist of different grit size classes, our IT system calculates and confirms the average value of the corresponding grit size class. As a result, our confirmed grit sizes will sometimes deviate from your order. However, we assure you with 100% certainty that we will produce and supply your product with the grit sizes you have requested. Please consider, that not every grit size is available. And also, not every grit goodness is available for all of our bonds.

4. BONDS

The grinding behaviour of diamond and CBN wheels essentially depends on the bond. The bond is to keep the grinding grit at an optimal condition at the grinding temperatures and forces occurring, whilst simultaneously providing enough space for the chips so as to permit an easy discharge of the abraded material. In view of the great number of grinding problems occurring a large spectrum of bonds is required.

4A. RESIN BONDS (MDT)

More than 50% of all grinding operations can be carried out by means of resin bonds, as these allow many bonding variants and high abrading performance on the workpiece.

4B. METAL BONDS (MDX)

Metal bonds excel by very high grit holding forces. For the continuous self-sharpening of diamond tips that have become blunt, high infeed forces are required, generating an increased heat amount. Therefore, metal bonds always have to be used in wet grinding. Only for small contact areas and light cuts, Dry grinding is possible.

4C. CERAMIC BONDS (MDR)

These bonds excel by porosity and profiling. At present, we are manufacturing only a choice of the shapes and dimensions contained in this catalogue and will therefore appreciate your inquiry in case of need.

4D. ELECTROPLATED BONDS (MDS)

In the nickel bond deposited by electro-plating usually only one grit layer of diamond or CBN is held firm (2 or 3 layers are contingently possible). The electroplated S-bond with diamond as abradant is particularly suited for machining less hard materials which are subject to wear, however, such as graphite, mineral or glass-fibre reinforced synthetic materials, and the like. A special field of application of the S-bond with CBN as abrasive is the grinding of profiles in the construction of turbines.

5. CONCENTRATION

According to international agreement, the basis for indicating concentration is the value C100, corresponding to 25% by volume of pure diamond or CBN within the abrasive layer.

Thus, the following formula applies to diamond and CBN:
 $C100 = 25\%vol = 4,4 \text{ carats/cm}^3 \text{ of layer; } 1 \text{ ct} = 0,2 \text{ g.}$

We manufacture diamond and CBN wheels to the following common concentrations:

CONCENTRATION	PROCESSED CARAT WEIGHT / cm ³ GRINDING WHEEL LAYER	VOLUME %
C200	8,8 kt.	50,0
C175	7,7 kt.	43,75
C165	7,3 kt.	41,25
C150	6,6 kt.	37,5
C135	5,9 kt.	33,75
C125	5,5 kt.	31,75
C115	5,1 kt.	28,75
C100	4,4 kt.	25,0
C90	4,0 kt.	22,5
C85	3,7 kt.	21,25
C80	3,5 kt.	20,0
C75	3,3 kt.	18,75
C68	3,0 kt.	17,0
C65	2,8 kt.	16,25
C60	2,6 kt.	15,0
C55	2,4 kt.	13,75
C50	2,2 kt.	12,5
C45	2,0 kt.	11,25
C38	1,7 kt.	9,5
C35	1,5 kt.	8,75
C25	1,1 kt.	6,25
C20	0,9 kt.	5,0
C15	0,7 kt.	3,75
C10	0,4 kt.	2,5

CBN wheels with the following concentrations are available upon request:

CONCENTRATION	PROCESSED CARAT WEIGHT / cm ³ GRINDING WHEEL LAYER	VOLUME %
V360	6,26 kt.	35,6
V300	5,22 kt.	29,7
V240	4,17 kt.	23,7
V210	3,65 kt.	20,8
V180	3,13 kt.	18,0
V150	2,61 kt.	14,8
V120	2,09 kt.	11,9
V90	1,57 kt.	8,9

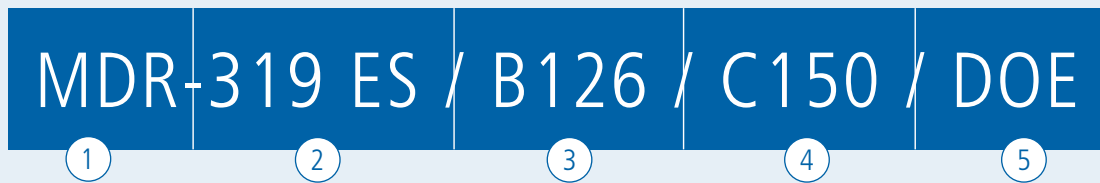
The concentration, on the one hand, definitely determines the price of the wheel, but on the other hand also the entire grinding behaviour thereof. Of decisive relevance is an optimal interaction between wheel dimension, grit size, bond and concentration. Higher concentrations (C100-C125-C150 / V240-V360) are suited if high profile stability is required, for narrow layer widths, for high bonding hardness, and in deep cutting. Average concentrations (C50-C75 / V120 - V180) are recommended with cup wheels and peripheral wheels having larger layer widths and finer grit sizes. Lower concentrations (C38-C50 / V120) primarily are used with very fine grit sizes.

6. ORDERING EXAMPLES

THE NEW LABEL FOR YOUR TOOL:

Since the introduction of our slogan, "We personalise your grinding tools!", on 1 August 2011, our focus has been on achieving improved safety, greater transparency and easier communication between you and Dr. Müller DIAMANTMETALL® AG. All of our tools now feature a new and unique label. The high level of quality of our grinding tools is not affected by this change.

- ◆ CLEAR TRANSPARENCY in the grinding wheel configuration
- ◆ CLEAR TRACEABILITY of technical improvements
- ◆ HIGH LEVEL OF SECURITY for your tool orders
- ◆ EASY COMMUNICATION through clear identification



- 1 "MD" stands for a genuine Dr. Müller DIAMANTMETALL® AG-grinding tool
- 2 The combination of numbers and letters stands for the type of bond and the mixture of grit goodness and grit quality
- 3 The combination of numbers and letters defines the cbn or diamond grit size*)
- 4 The combination of numbers and letters defines the concentration of the cbn or diamond grit*)
- 5 These letters defines the cooling for your grinding tool D (Dry), O (Oil), E (Emulsion)

The "Dr. Müller DIAMANTMETALL® AG CARD" provides an overview of the composition of the new label. Thanks to this practical card format, you always have the composition of the new label at hand!

YOU ARE WELCOME TO ORDER THE CARD FREE OF CHARGE!

Phone: +49 (0) 881 / 90 11 55-0

Fax: +49 (0) 881 / 90 11 55-100

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COMBINATION OF LETTERS DEFINES A MIXTURE OF GRIT GOODNESS AND GRIT QUALITY		
GRIT GOODNESS	GRIT QUALITY	COMBINATION
G (enius)	S(tandard) or P(rofessional)	GS or GP
C (uda)	S(tandard) or P(rofessional)	CS or CP
A (tlantis)	S(tandard) or P(rofessional)	AS or AP
T (esla)	S(tandard) or P(rofessional)	TS or TP
R (azor)	S(tandard) or P(rofessional)	RS or RP
E (dison)	S(tandard) or P(rofessional)	ES or EP

*) The new label, which is generated automatically and electronically, has also included the factors "grit goodness" and "grit quality" since 1 August 2011. Both of these factors can individually affect the grit size and concentration specified. This may result in a differing technical description of our tool, compared to your order or request. We can assure you with absolute certainty that you will receive your product with the desired configuration and our quality continues to be your success.



THE BIOMETRY OF YOUR ORDER IS YOUR X-NUMBER.

The huge benefit of an X-number order is that it saves you time!
Just how it saves you time is outlined below.

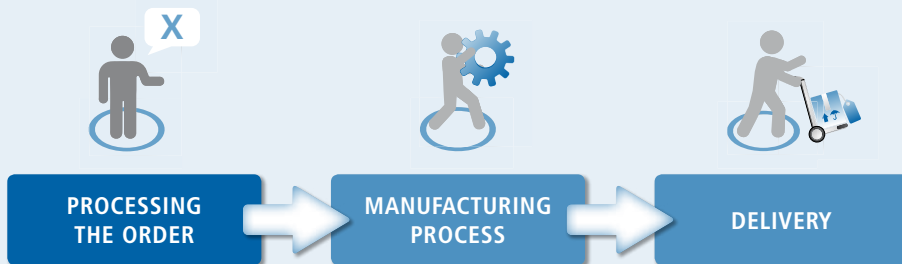
YOUR FIRST ORDER

On each of our grinding tools, we engrave your unique X-number in addition to the new label. All key technical details and manufacturing processes are stored behind this X-number. Our technicians have worked out these details when you order this tool for the first time.



YOUR SECOND ORDER WITH YOUR X-NUMBER

If you order the same grinding tool again with your X-number, your tool will be produced directly. The time-consuming processing procedure performed by our engineering department and the calculations done by our sales team are no longer required, thereby saving you time!



YOUR SIMULTANEOUS ORDER WITH AND WITHOUT YOUR X-NUMBER

And we have made improvements here too! Now when you place an order with and without X-number items, we will split this order with our new "Digital Splitting System" to enable the fastest way to process your order. Therefore, we are able to deliver your requested X-number grinding tools much faster than new grinding tools for which the technical details must be calculated afresh. Saving you time once again!



INFORMATION ABOUT THE ENGRAVING OF YOUR TOOL

- ① Technically defined labeling of the tool
- ② Brand name of a Dr. Müller DIAMANTMETALL® AG HighTec bond
- ③ Your X-number / serial number
- ④ Customer material number (on request)
- ⑤ Technical safety requirements

7. GENERAL INSTRUCTIONS FOR APPLICATION OF DIAMOND AND CBN WHEELS

7A. MACHINE

All grinding machines for diamond and CBN wheels should be of highly sturdy design, be equipped with properly running grinding spindles and wheel mounts, and be set up for vibration-free operation. Diamond and CBN wheels operated without a proper peripheral and transversal concentricity only achieve a low abrading performance and a poor surface finish since only a portion of the diamond or CBN layer is in contact and this portion is soon overloaded. The motor output must be adjusted in such a way that also higher cutting speeds can be used and that no substantial loss of speed occurs, even when infeed is high. All guides of the machine must operate jerk-free. During deep grinding, so at low feed speed but high surface pressure, the bench must operate without jolt. The design of coolant pumps, inlet nozzle and coolant capacity must assure a strong coolant flow especially for deep grinding.

7B. MOUNTING OF DIAMOND AND CBN WHEELS

Diamond and CBN wheels should possess a proper concentricity and axial run-out to ensure a superior abrading performance and good quality surface finish. The wheels that are ground to a concentricity and axial run-out of 0,01 - 0,02 mm are supplied in balanced form, and they should be attached to the wheel mount as follows:

- ♦ Check wheel mount on the spindle with a dial gauge for true running in peripheral and transversal direction. Correct any errors.
- ♦ Slide diamond or CBN wheel on the mount. Tighten mount lightly and check wheel running with dial gauge.
- ♦ Eliminate any radial runout due to bore clearance with light blows on a piece of wood deposited on the mount. Tighten the mount firmly and recheck with dial gauge.

In case of large diamond and CBN wheels, and especially of profile wheels, kindly send us the mount and the matching grinding or balancing mandrel so that we can grind the wheels directly on the mount, keeping true running deviations within the tightest limits. All diamond and CBN wheels should remain on their mounts until completely worn to avoid errors in concentricity due to change of mounts.

7C. COOLING

Wet grinding:

Wet grinding is to be preferred for almost all grinding operations using diamond and CBN wheels. A sufficient amount of coolant should be fed to the grinding point directly and under pressure, thereby assuring dissipation of the cutting heat generated during grinding, flushing the debris away and increasing the lifetime of the wheel.

For diamond wheels the best abrading performances and lifetimes are achieved with Emulsions at a mixing ratio of 1:50 to 1:100. CBN wheels, in contrast thereto, yield the best values with low viscosity Oils (viscosity ~ 4).

Often the necessity arises to use both the diamond and the CBN wheel on one machine. In this case, a low viscosity grinding Oil is recommended, but it has to be reckoned with slightly lower infeed rates and a short lifetime.

Special attention should be paid to optimal filtering of the coolant, which has quite an influence on the service life and the surface quality of the workpiece. Also, particularly with grinding Oils, attention should be paid to the temperature. If necessary, additional cooling should be provided, as the Oil not only is to have an lubricating effect, but also a cooling one.

It is worthwhile to pay sufficient attention to the choice of the coolant, as considerable costs for the grinding wheel can be saved by a good coolant. Diamond and CBN wheels whose bond is designed for wet grinding should be used for Dry grinding only in exceptional cases, end then with reduced rotational speed and infeed.

Dry grinding:

Due to their characteristics, their grit quality and their bond composition, diamond and CBN wheels engage well and keep their soft grinding capacity also in Dry grinding. However, lower contact pressures and infeeds than in wet grinding should be applied. Those diamond and CBN wheels with bonds designed for Dry grinding may also be used for wet grinding.

7D. DRESSING AND SHARPENING OF DIAMOND AND CBN WHEELS

By dressing, the restoration of the running accuracy of a diamond or CBN wheel is to be undertaken.

THERE ARE THE FOLLOWING POSSIBILITIES:

Dressing of cup wheels

Pulverized silicon carbide of 80-120 mesh is strewn onto a steel plate, and the diamond or CBN wheel is moved over it under slight pressure, thereby partially removing the bond and releasing the grinding grit.

Dressing of peripheral wheels

There are several methods to this end:

- ♦ Dressing by centrifugal force braking device
- ♦ ST37 workpieces
- ♦ electro-plated diamond stripping tools.

Following application of the last-mentioned dressing methods it is indispensable that the diamond or CBN wheel still be sharpened, i.e. that the bond be retracted so as to release the grinding grit.

The best way to do this in the case of resin-bonded wheels is:

- ♦ in the case of resin-bonded wheels is:
 - by means of our whetstone No. 2 or No. 5
- ♦ and in the case of metal-bonded wheels:
 - by means of our whetstone No. 6.
- ♦ For fine grit sizes
 - stone No. 8 is recommended.

The wheels have reached an optimal degree of sharpness if the finger nail catches on the grinding grit ("finger nail test").

7E. CUTTING SPEEDS FOR DIAMOND AND CBN WHEELS

The cutting speeds indicated in the table below are values from practical experience which should be observed as far as possible. Please ask our field staff as to which methods are suited best for you. With special materials or grinding methods different cutting speeds may give optimal results. Thus, a variable speed adjustment is of advantage for obtaining a high grinding performance and a superior grinding quality.

7E. METAL REMOVAL RATE

The specific metal removal rate, also known as Qw' , describes the removal capacity of a grinding wheel in cubic millimeters per millimeter of grinding rim width per second.

CUTTING SPEEDS

Ø MM	R.P.M. AT A CUTTING SPEED OF								
	10 M/SEC.	15 M/SEC.	20 M/SEC.	25 M/SEC.	30 M/SEC.	35 M/SEC.	40 M/SEC.	45 M/SEC.	50 M/SEC.
20	9550	14725	19100	23875	28650	33440	38215	42990	47770
25	7640	11460	15280	19100	22920	26750	30570	34390	38215
30	6365	9550	12730	15915	19100	22290	25475	28660	31845
50	3820	5730	7640	9550	11460	13375	15285	17195	19105
75	2545	3820	5095	6370	7640	8915	10190	11465	12735
100	1910	2865	3820	4775	5730	6685	7640	8600	9550
125	1530	2290	3055	3820	4580	5350	6115	6880	7640
150	1275	1910	2545	3180	3820	4460	5095	5730	6370
175	1090	1640	2185	2730	3280	3820	4367	4910	5460
200	955	1435	1910	2390	2865	3340	3820	4300	4780
250	765	1146	1530	1910	2290	2675	3055	3440	3820
300	635	905	1275	1590	1910	2230	2545	2865	3185
350	545	820	1090	1365	1640	1910	2180	2455	2730
400	480	715	955	1194	1435	1670	1910	2150	2390
450	425	635	850	1060	1275	1485	1700	1910	2120
500	382	573	764	955	1146	1337	1528	1719	1918
550	347	521	694	868	1042	1215	1389	1563	1737
600	318	477	636	796	955	1114	1273	1433	1592

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WE PERSONALIZE YOUR GRINDING TOOLS!

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THE NEW LABEL PROVIDES THE FOLLOWING BENEFITS FOR OUR CUSTOMERS:

- + **CLEAR TRANSPARENCY**
in the grinding wheel configuration
- + **CLEAR TRACEABILITY**
of technical improvements
- + **HIGH LEVEL OF SECURITY**
for your tool orders
- + **EASY COMMUNICATION**
through clear identification



THE BIOMETRY OF YOUR GRINDING TOOLS

JUST HOW IT SAVES YOU TIME IS OUTLINED BELOW

MDR-319 ES / B126 / C150 / DOE

1

2

3

4

5

1

"MD" stands for a genuine
Dr. Müller DIAMANTMETALL® AG-grinding tool

2

The combination of numbers and letters stands for the type of
bond and the mixture of grit goodness and grit quality

3

The combination of numbers and letters defines the CBN
or diamond grit size*)

4

The combination of numbers and letters defines the
concentration of the CBN or diamond grit *)

5

These letters defines the cooling for your grinding tool
D (Dry) • O (Oil) • E (Emulsion)

MDT (Resin bond) • MDX (Metal bond)
MDR (Ceramic bond) • MDS (Electroplated bond)



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