



Brusi za livarsko industrijo

Foundry grinding wheels

- Izredna vzdržljivost
z dodatkom cirkon korundnih zrn
- Za vse vrste odlitkov

- Exceptional durability
due to addition of zirconium oxide
- For all types of casts



Smolno vezani brusi s SiC in korundnimi zrnji

F15, F17, F18, F18R, F19 Brusni čepi / Cone and plug wheels



Oblika Form	Kvaliteta Quality	Dimenzije D x T x M Dimensions D x T x M	Obodna hitrost Peripheral speed
F15	12A20R5B /47A16R5B	$D = 32 - 60 \text{ mm}$ $\times$ $T = 50 - 100 \text{ mm}$ $\times$ $M = M10, M12, M14, M16,$ $3/8", 1/2", 5/8"-11$	 50 m/s
F17			
F18			
F18R			
F19			

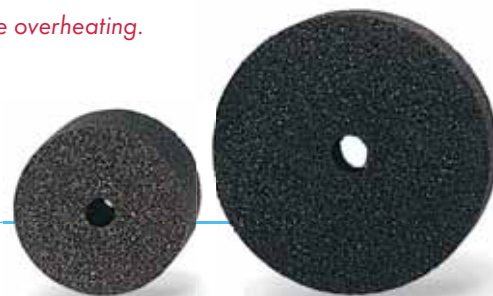
NAMEN UPORABE / APPLICATIONS

- Brušenje, čiščenje odlitkov vseh kvalit
- Brusni se uporabljajo pri maksimalni obodni hitrosti 50 m/s
- Grinding and cleaning of casts of all qualities
- Grinding wheels are used at the maximum peripheral speed of 50 m/s.

PREDNOSTI / ADVANTAGES

- Visoka vzdržnost čepov in veliki odvzemi materiala na časovno enoto
- Specialna kvaliteta 47A16 se odlikuje po velikem odvzemu materiala na časovno enoto, brez pregrevanja obdelovanca
- High durability of cone and plug wheels with high material removal rates
- Special quality 47A16 is distinguished by high material removal rates without workpiece overheating.

F1, F1-AF Brusne plošče / Grinding wheels



Oblika Form	Kvaliteta Quality	Dimenzije D x T x H Dimensions D x T x H	Obodna hitrost Peripheral speed
F1	15A30P4BF/47A24RBF	$D = 50 - 100 \text{ mm}$ $\times$	50 m/s
F1-AF		$T = 4 - 15 \text{ mm}$ $\times$	63 m/s
		$H = 6, 8, 10, 12, 13 \text{ mm}$	80 m/s

NAMEN UPORABE / APPLICATIONS

- Čiščenje odlitkov, odkovkov, razrezanih in varjenih materialov
- Uporabljajo se na ročnih brusilnih strojih
- Cleaning of casts, forged pieces and cut and welded materials
- For use on manual grinding machines.

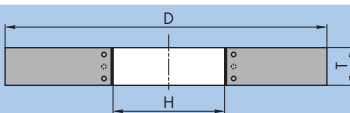
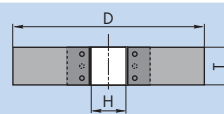
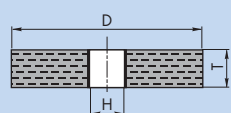
PREDNOSTI / ADVANTAGES

- Kvalitetno brušenje na različnih materialih
- Specialna kvaliteta se odlikuje po velikem odvzemu materiala na časovno enoto, brez pregrevanja obdelovanca
- High-quality grinding of various materials
- Special quality is distinguished by high material removal rates without workpiece overheating.



F1-AO, F1-AFG, F1-AF

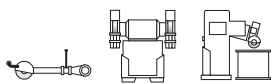
Brusne plošče / Grinding wheels

Oblika Form	Dimenzije D x T x H Dimensions D x T x H	Obodna hitrost Peripheral speed
 F1-AO	D = 300 - 600 mm x T = 25 - 125 mm x H = 40, 50, 60, 76.2, 127, 150, 152.4, 200, 200.3, 305 mm	50 m/s
 F1-AFG		63 m/s
 F1-AF		80 m/s

Kvaliteta Quality	Jeklo Steel	Nerjaveče jeklo Stainless steel	Siva litina Cast iron	Nodularna litina Nodular alloys	Alu. litina Alu. cast	Liv. pesek Casting sand
A14-24O-S4B	●			○		
12A14-24O-R5B	●	●				
47A14-24R5B	●	●	●	○	○	
52C14-24R5B			●		○	○
128A14-24R5B			●	○		
417A14-24R5B			●	●		
ZA14-24S4BF	●	●	●	●		
58C14-24S4BF			●			●
54A24-16R5BF			○		●	
90C24-16S4BF			○			●

● Primerna kvaliteta / Main application ○ Pogojno uporabna kvaliteta / Possible application

NAMEN UPORABE / APPLICATIONS



- Čiščenje in grobo brušenje vseh kvalitete odlitkov in odkovkov na stabilnih strojih (ročno dodajanje lažjih obdelovancev). Delovne obodne hitrosti so 50; 63 ; 80 m/s.
- Čiščenje in grobo brušenje vseh kvalitete težjih obdelovancev, s pomočjo visečih, ročno vodenih strojev; delovna obodna hitrost je 63 m/s.
- Čiščenje in grobo brušenje vseh kvalitete težjih obdelovancev, z avtomatskimi stroji-Andromat. Delovna obodna hitrost je 80 m/s
- Cleaning and coarse grinding of cast and forged pieces of all qualities, use on stationary grinding machines (manual feeding of light workpieces). Peripheral operating speeds: 50, 63 and 80 m/s
- Cleaning and coarse grinding of heavy workpieces of all qualities using suspended, manually controlled machines. Peripheral operating speed: 63 m/s
- Cleaning and coarse grinding of heavy workpieces of all qualities using Andromat automatic machines. Peripheral operating speed: 80 m/s.

PREDNOSTI / ADVANTAGES

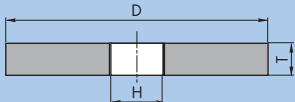
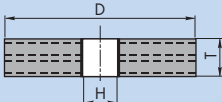
- Visok učinek brušenja na časovno enoto in visoka vzdržnost brusnih plošč
- Specialne kvalitete 417A, 47A in ZA16 se odlikujejo po velikem odvzemu materiala, veliko vzdržnostjo in brušenju brez pregrevanja obdelovanca
- High grinding efficacy and high durability of grinding wheels
- Special qualities 417A, 47A and ZA16 are distinguished by high material removal rates, high durability and absence of workpiece overheating during grinding.

Resin bonded grinding wheels with SiC and Al oxide



F1, F1-AF

Brusne plošče / Grinding wheels

Oblika Form	Dimenzije D x T x H Dimensions D x T x H	Obodna hitrost Peripheral speed
F1 	D = 75 - 250 mm x T = 20 - 50 mm x H = 16, 20, 25, 30, 32 mm	50 m/s
F1-AF 		63 m/s
		80 m/s

Kvaliteta Quality	Jeklo Steel	Nerjaveče jeklo Stainless steel	Siva litina Cast iron	Nodularna litina Nodular alloys	Alu. litina Alu. cast
A14-30Q4B	●			○	
12A24P6B	●	●			
91C24R5B			●		○
47A24R5B	●	●	●	○	○
ZA14-30Q4B	●	●	●	●	
54A24R5B			○		●

● Primerna kvaliteta / Main application ○ Pogojno uporabna kvaliteta / Possible application

NAMEN UPORABE / APPLICATIONS

- Čiščenje odlitkov, odkovkov, razrezanih in varjenih materialov
- Uporablja se na ročnih in stabilnih brusilnih strojih
- Cleaning of casts, forged pieces and cut and welded materials
- For use on manual and stationary grinding machines.

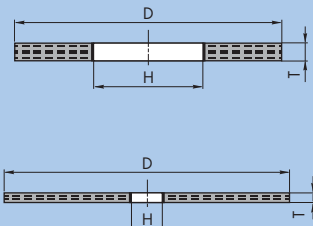
PREDNOSTI / ADVANTAGES

- Visok učinek brušenja na časovno enoto in visoka vzdržnost brusnih plošč
- Specialne kvalitete 47A in ZA se odlikujejo po velikem odvzemu materiala na časovno enoto, veliko vzdržnostjo in pri brušenju ne pregrevajo obdelovancev
- High grinding efficacy and high durability of grinding wheels
- Special qualities 47A and ZA are distinguished by high material removal rates, high durability and absence of workpiece overheating during grinding.



F1-AF

Brusne plošče za čiščenje utorov / Grinding wheels for cleaning grooves

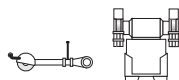
Oblika Form	Dimenzije D x T x H Dimensions D x T x H	Obodna hitrost Peripheral speed
 F1-AF	D = 300 - 600 mm x T = 6, 8, 10, 12, 16, 20 mm x H = 20, 22, 25.4, 30, 32, 127, 150 mm	63 m/s 80 m/s

Kvaliteta Quality	Jeklo Steel	Nerjaveče jeklo Stainless steel	Siva litina Cast iron	Nodularna litina Nodular alloys	Alu. litina Alu. cast	Livarski pesek Casting sand
A30-20P-S4BF	●			○		
12A30-20R5BF	●	●				
19A24S4BF			●		○	○
52C24R5BF			●		○	○
128A24-16R5B			●	○		
417A24-16R5BF			●	●		
47A24R5BF			●	○	○	
ZA24-16S4BF			●	●		
54A24R5BF			○		●	
C24S4BF						●

● Primerna kvaliteta / Main application

○ Pogojno uporabna kvaliteta / Possible application

NAMEN UPORABE / APPLICATIONS



- Ročno čiščenje utorov različnih kvalitete
- Uporablja se na stabilnih strojih
- Manual cleaning of grooves of various qualities
- For use on stationary grinding machines.

PREDNOSTI / ADVANTAGES

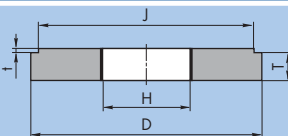
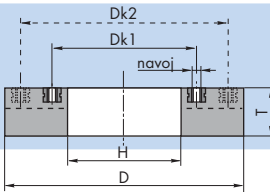
- Visok učinek brušenja na časovno enoto in visoka vzdržnost brusnih plošč
- Specialne kvalitete 47A, ZA20 in 417A se odlikujejo po velikem odvzemu materiala na časovno enoto, veliko vzdržnostjo in pri brušenju ne pregrevajo obdelovancev
- High grinding efficacy and high durability of grinding wheels
- Special qualities 47A, ZA20 and 417A are distinguished by high material removal rates, high durability and absence of workpiece overheating during grinding.



F35-U, F36

Brusne plošče z vgrajenimi maticami
Grinding wheels with integrated nuts



Oblika Form	Dimenzije D x T x H Dimensions D x T x H	Obodna hitrost Peripheral speed
 F35-U	D = 300 - 600 mm x T = 40 - 110 mm x H = po naročilu / to order	50 m/s
 F36		63 m/s

Navoj matice je lahko levo ali desno sučni / Nut with left or right thread

Kvaliteta Quality	D x T x H (mm)	J (mm)	T (mm)	Dk1/št. matic mm/kom piece No. of knots	Dk2/št. matic mm/kom piece No. of knots	Navoj Thread
F35-U	450 x 60 x 200	428	11			
F35-U	450 x 60 x 0	428	11			
F36	350 x 100 x 255			300/8		M12
F36	450 x 90 x 255			375/10		M10
F36	508 x 100 x 350			456/24		M10
F36	508 x 100 x 406			456/24		M10
F36	508 x 110 x 406			456/24		M10
F36	602 x 100 x 325			530/12	370/6	M16
F36	602 x 125 x 325			530/12	370/6	M16
F36	602 x 75 x 325			530/12	370/6	M16

Kvaliteta Quality	Jeklo Steel	Nerjaveče jeklo Stainless steel	Siva litina Cast iron	Nodularna litina Nodular alloys	Alu. litina Alu. cast	Magneti Magnets
947C60G8B						●
147A46H5B	●	●				
417A14-24R5B			●	●		
ZA14-24S4BF	●	●	●	●		
54A24-16R5BF			○		●	

● Primerna kvaliteta / Main application ○ Pogojno uporabna kvaliteta / Possible application

NAMEN UPORABE / APPLICATIONS

- Za eno ali dvokolutno ploskovno avtomatsko brušenje odlitkov
- Uporablja se v proizvodnji magnetov, vzmeti ter brušenje odlitkov za avtomobilsko industrijo
- For single and bi-wheel automatic flat grinding of casts
- Manufacture of magnets and springs and grinding of casts for the automotive industry

PREDNOSTI / ADVANTAGES

- Visok učinek brušenja na časovno enoto in visoka vzdržnost brusnih plošč
- Specialne kvalitete 417A, 47A in ZA16 se odlikujejo po velike odvzemu materiala na časovno enoto, veliko vzdržnostjo in brušenju brez pregrevanja obdelovancev
- High grinding efficacy and high durability of grinding wheels
- Special qualities 417A, 47A and ZA16 are distinguished by high material removal rates, high durability and absence of workpiece overheating during grinding.