

RESIN BONDED WHEELS with SiC and Al-oxide

the art of sparks



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CORRECT STORAGE

Please store in dry and well-ventilated premises without major temperature changes (temperatures between 10° and 30° C and max. 70 % relative humidity).

This will help preserve the physical properties of reinforced resin bonded grinding wheels for up to three years, up to two years for non-reinforced ones.

The storage premises should be as close to the place of use as possible in order to avoid mechanical damage to the wheels during transport, as well as moisture condensation while in transit on colder days.



Please use appropriate stands, shelves, drawers and boxes for storing various types of grinding wheels.

- Store wide thin-section grinding wheels in a horizontal position on a flat surface or on a steel base.
- Place thinner resin bonded cutting-off wheels on a flat surface in order to prevent bending.
- Store small grinding wheels on upper shelves or in their original packaging.
- Store depressed-centre concave grinding wheels one on top of the other or in their original packaging, up to a stack height of 120 cm.
- Store grinding wheels and thick-section grinding rings of larger dimensions vertically on lower shelves, but transport them horizontally.

INCORRECT HANDLING

1. DON'T store wheels in a damp atmosphere or in extreme temperatures.
2. DON'T use non-reinforced cutting-off wheels on portable machines.
3. DON'T handle wheels roughly.
4. DON'T mount a damaged wheel.
5. DON'T EVER exceed the maximum operating speed marked on the wheel.
6. DON'T force a wheel onto a machine spindle.
7. DON'T use mounting flanges which are incorrect, damaged, dirty or worn out.
8. DON'T tighten the mounting nut or locking flange excessively. This can distort the flanges.
9. DON'T use blotters for soft mounting of depressed-centre concave wheels.
10. DON'T use a machine which is not in good mechanical condition.
11. DON'T use a machine without a wheel guard.
12. DON'T use wheels without proper ventilation or dust protection equipment.
13. DON'T apply side pressure to cutting-off wheels.
14. DON'T stop the wheel after use by applying pressure to the wheel edge or side.
Always switch the machine off and allow the wheel to stop revolving.
15. DON'T allow the wheel to be trapped or pinched in the cut.
16. DON'T apply excessive pressure onto the wheel so that the driving motor slows down.
17. DON'T grind on the side of cutting-off wheels .
18. DON'T drop portable machines or lower to the floor by the cable or air hose. A wheel can be easily cracked by the weight of the machine if it is put down hard. This is a common cause of wheel breakage.
19. DON'T grind with a depressed-centre concave grinding wheel at an angle lower than the prescribed angle.
20. DON'T use a machine in a position where you do not have full control of the machine and you are not well balanced.

CORRECT HANDLING

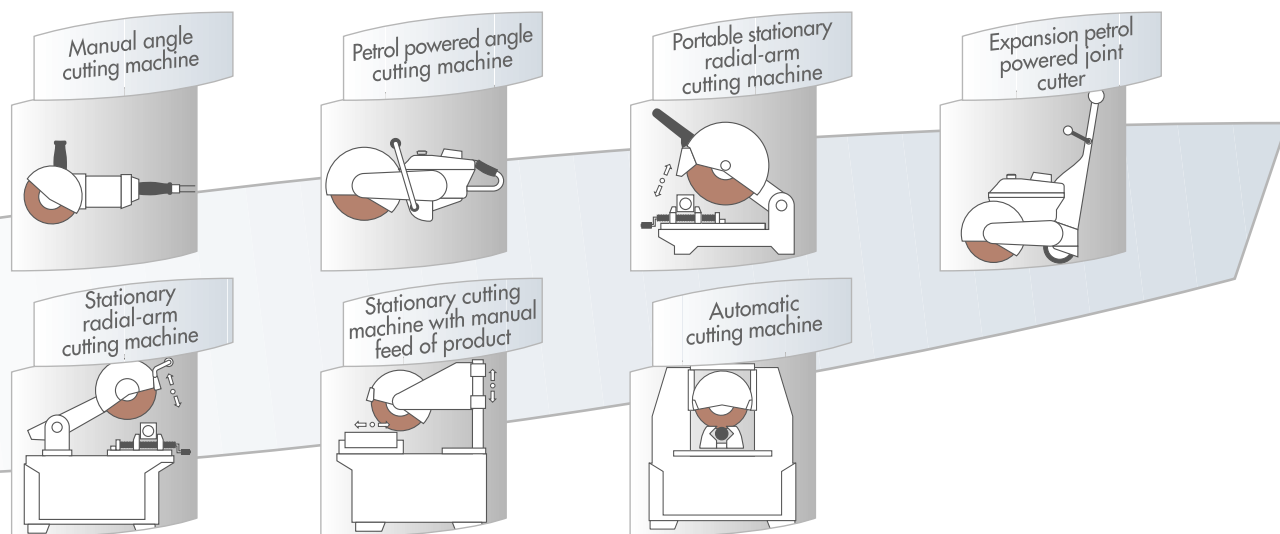
1. DO always follow instructions for correct storage.
2. DO always visually inspect grinding wheels before mounting for possible damage during transport and eliminate damaged ones.
3. DO always use a safety guard, which should cover nearly one half of the grinding wheel.
4. DO always use non-reinforced cutting-off wheels on fixed stationary machines.
5. DO always switch off the power at the supply and/or unplug the machine before changing the wheel.
6. DO always use the tools supplied by the machine manufacturer to change the wheel.
7. DO always ensure that the spindle speed of the machine is no higher than the operating speed marked on the wheel.
8. DO always use the correct wheel mounting flanges for grinding wheels and check that they are undamaged, clean and free of burrs.
9. DO always use blotters between the mounting flanges and the wheel sides for soft mounting of flat cutting-off wheels.
10. DO always allow newly mounted wheels to run at operating speed with the guard in place for at least one minute before cutting or grinding.
11. DO always wear protective gear: safety clothing, dust masks, eye protection (glasses or shield), gloves and ear protection.
12. DO have machine speeds checked regularly, especially after maintenance or repair.
13. DO always check the tension of the driving belt, where fitted, on a regular basis: belts must be kept tight in order to ensure optimum power transmission.
14. DO always secure the workpiece firmly before beginning cutting or grinding.
15. DO store portable machines appropriately when not being used, to avoid accidental physical damage to the wheel.
16. DO always use portable machines in a comfortable position, where the body is well balanced and the machine is well supported.
17. DO grind at the prescribed angle to the item with depressed-centre grinding wheels on an angle grinding machine.
18. DO always keep the work space around cutting and grinding operations clear.
It is very dangerous if an operator slips or falls during cutting or grinding operations.

SKORPIO

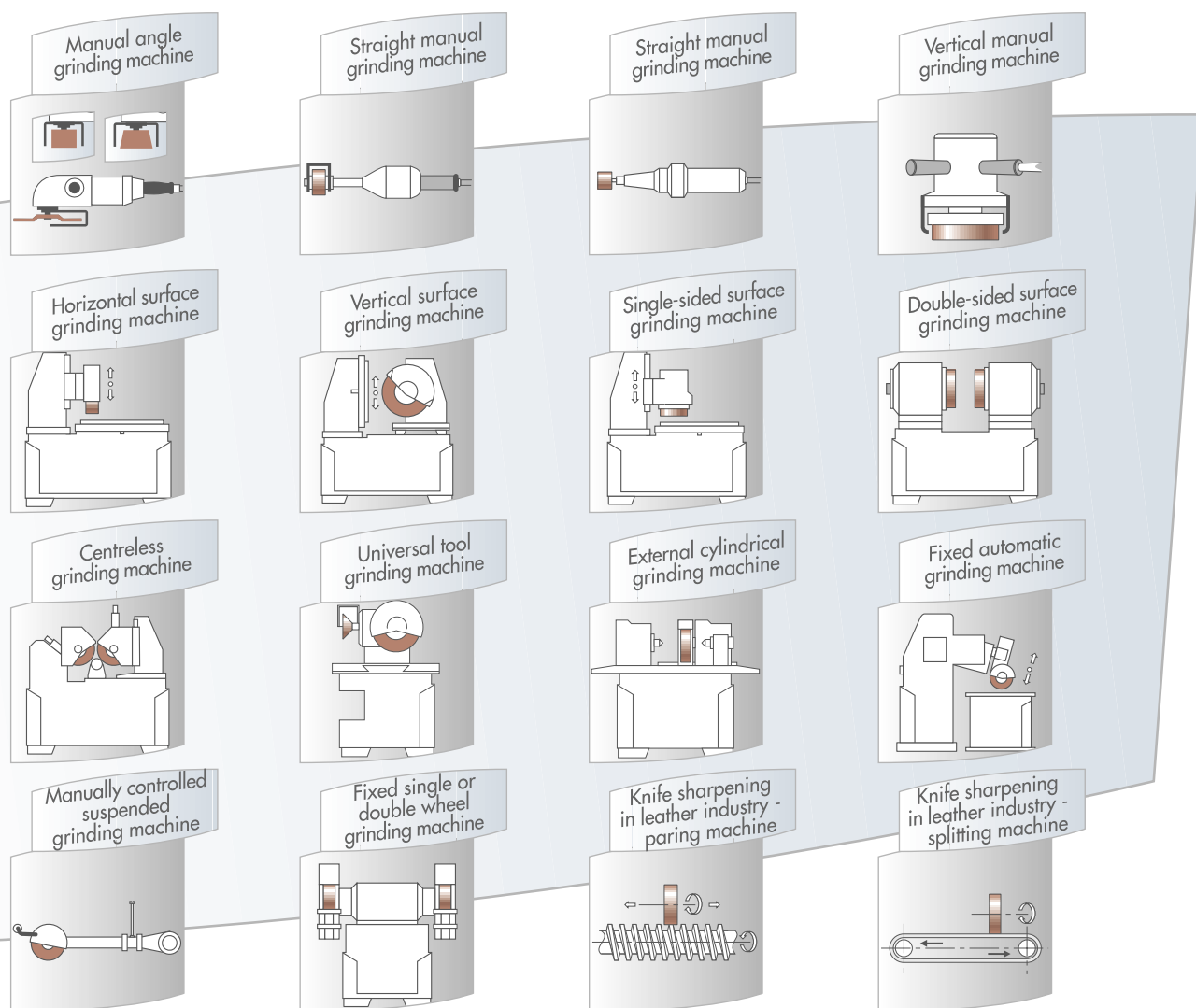
EXTRA high-quality level
for demanding industry applications!



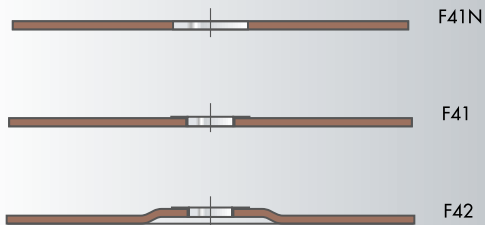
Cutting machines



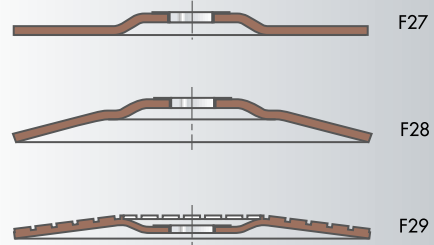
Grinding machines



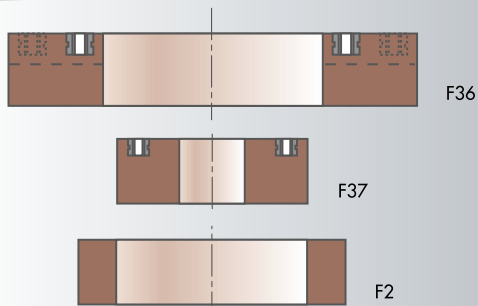
Flat and depressed-centre cutting-off wheels



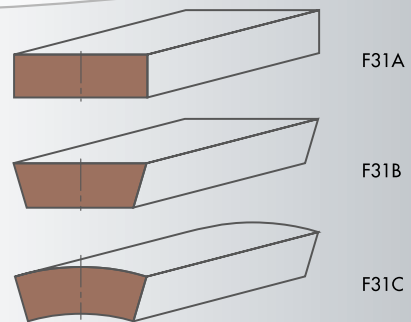
Flat and depressed-centre grinding wheels



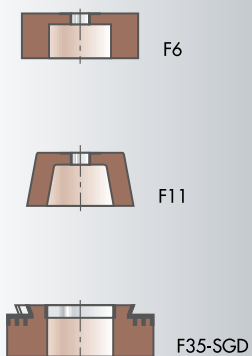
Grinding rings



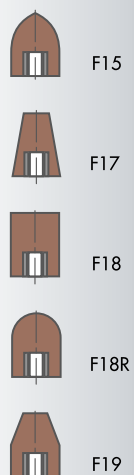
Grinding segments



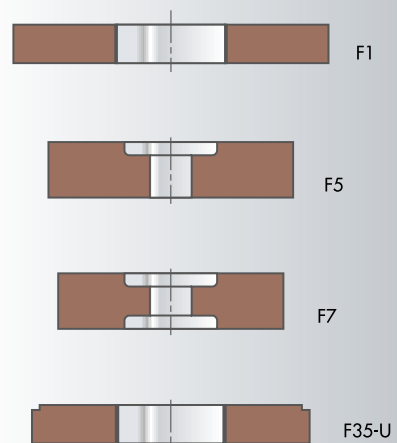
Grinding cup



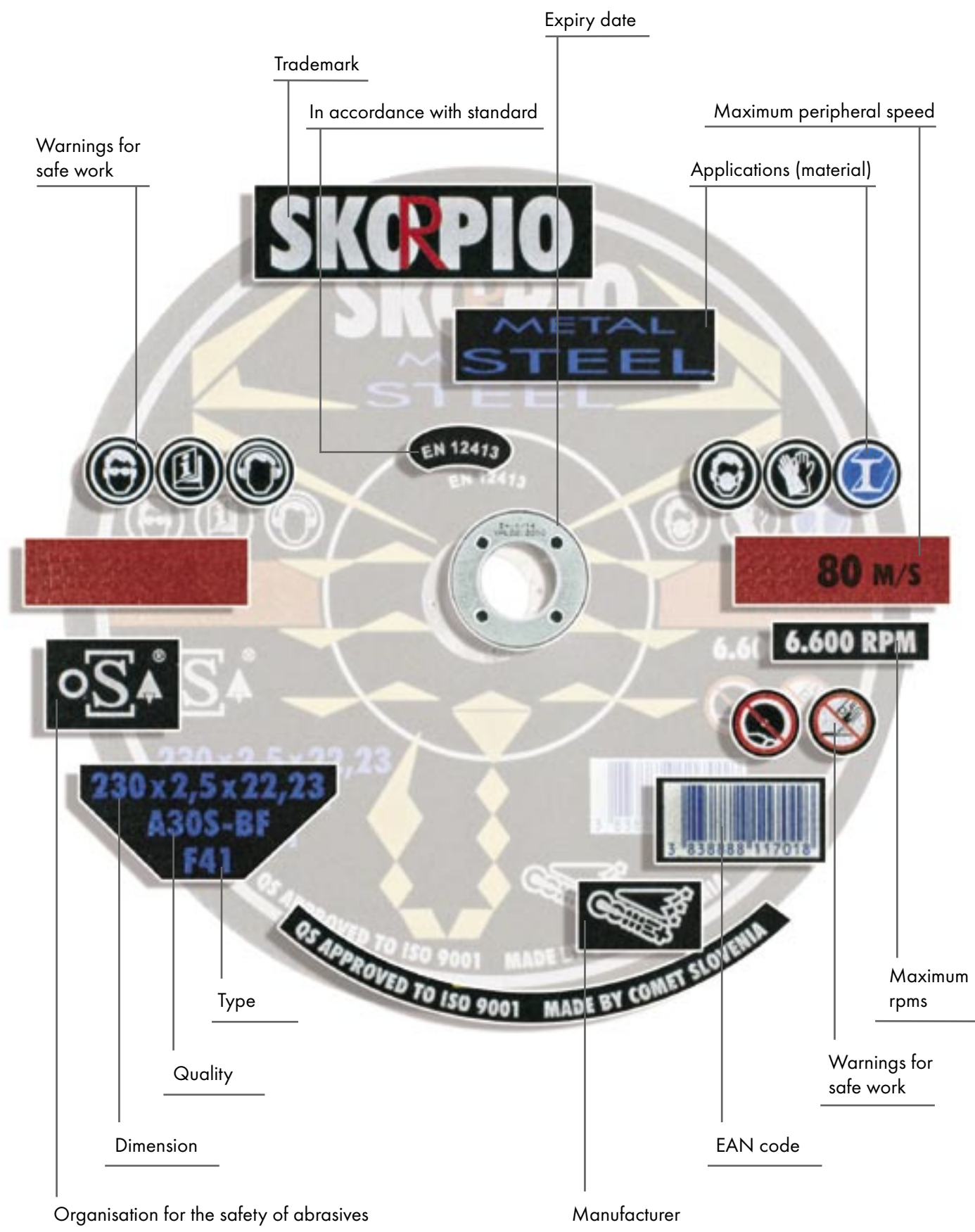
Mounted points



Grinding cup wheels



MOST FREQUENT MARKINGS ON WHEEL LABELS



MOST FREQUENT MARKINGS ON WHEEL LABELS

WARNINGS FOR SAFE USE

Please read the instructions
carefully



Use
a safety shield or
protective eyewear



Use
ear protection



Use
a dust mask



Use
protective gloves



Use an appropriate
safety shield when
grinding



Grinding
prohibited



Free-hand grinding
or cutting
prohibited



Wet cutting
prohibited



Use of damaged
products
prohibited



APPLICATIONS (MATERIALS)

Metals



Stainless steel



Aluminium



Railway tracks



Asphalt



Concrete



Nonmetals



Grey cast
and aluminium



I

Internally reinforced

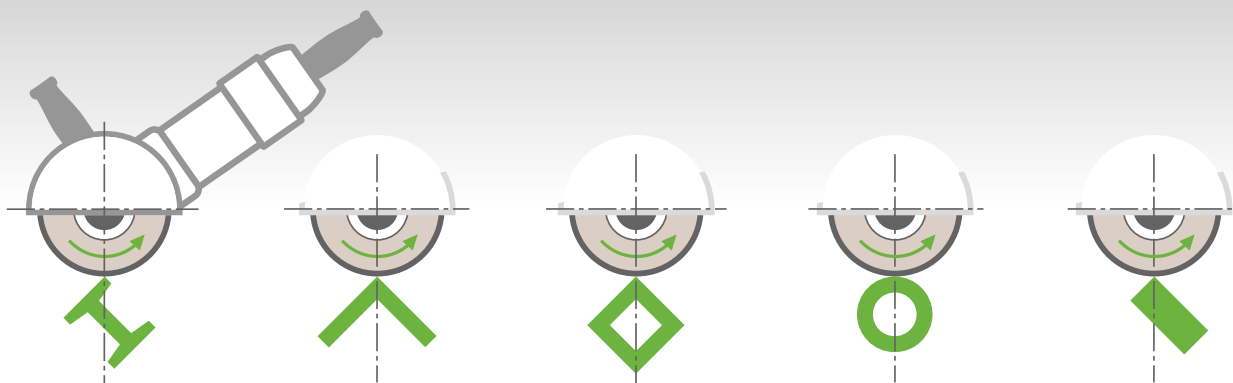
E

Externally reinforced

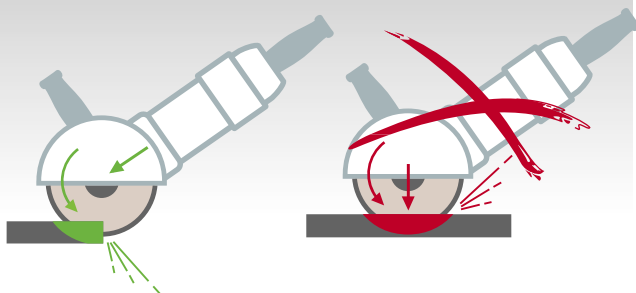


CORRECT CUTTING AND GRINDING

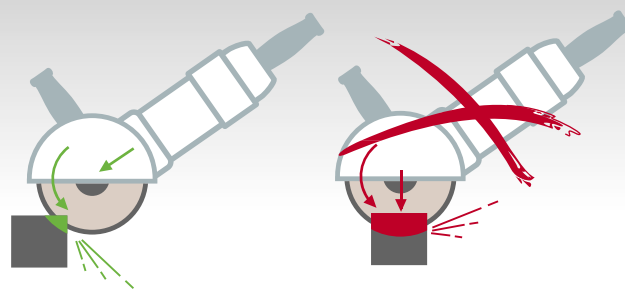
Correct cutting of pieces of various geometrical shapes



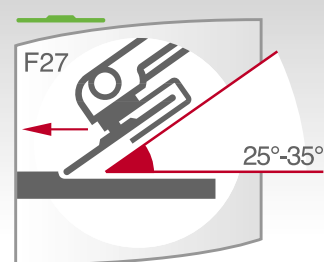
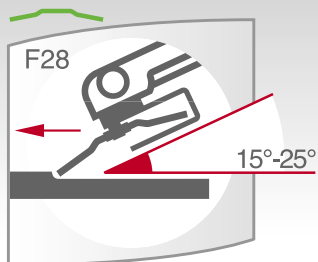
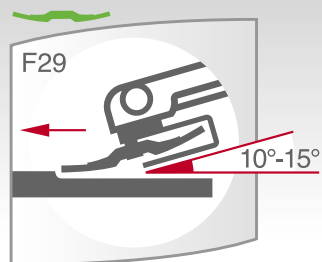
Cutting of sheet metals



Cutting of thicker pieces



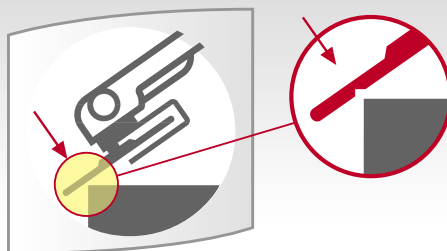
ALWAYS maintain the prescribed angle between the grinding wheel and the workpiece!



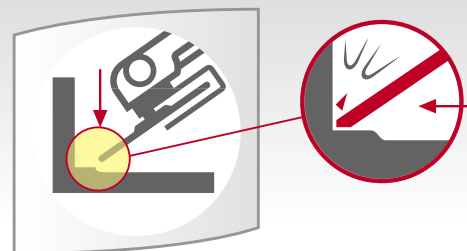
NEVER use cutting-off wheels for grinding!



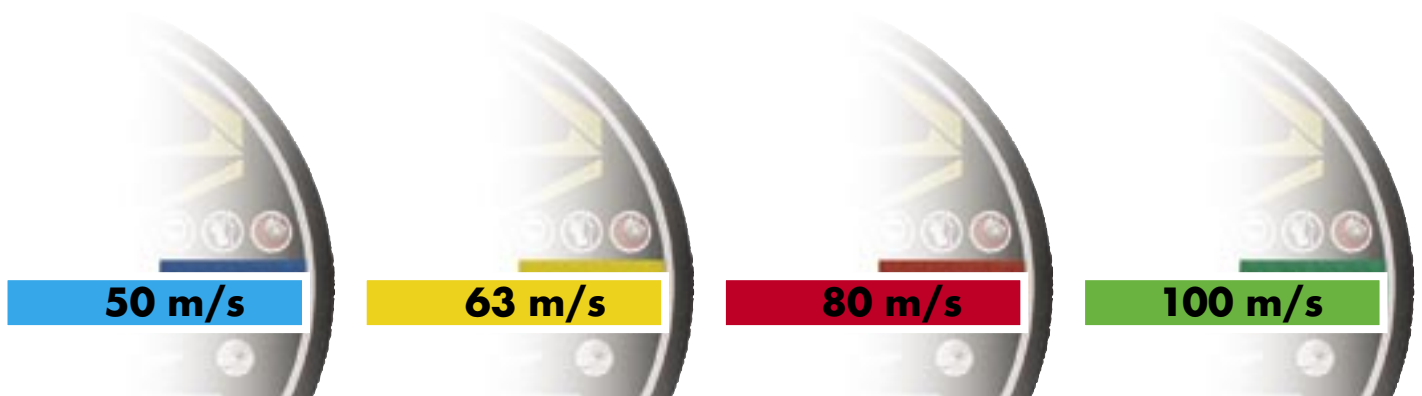
NEVER grind laterally or using the flat part of the grinding wheel!



During grinding, be careful not to contact any surfaces which you do not want grind with the grinding wheel!



The maximum operating speeds are marked with a colour line through the center, along the entire product diameter/label.



The grinding wheel operating speed is determined using the following equation:

$$v = \frac{D \times \pi \times n}{60000}$$

The necessary rpms are determined with equation:

$$n = \frac{60000 \times v}{D \times \pi}$$

v – operating speed (m/s)
D – wheel diameter (mm)
n – Rpm (1/min)
 π – 3.14159

RUN-OUT VALUES OF ABRASIVE PRODUCTS

Table (ISO 13942) states the diameter limit deviations for abrasive products of type F41, F42 and F27 (T_D), and the values of permissible axial (T_{PL}) and radial run-out tolerances (T_{RL}):

Diameter (mm)	T_D	T_{PL}	T_{RL}
$30 \leq D \leq 100$	± 2	0.5	0.5
$100 < D \leq 150$	± 2.5	0.6	0.6
$150 < D \leq 200$	± 3	0.8	0.8
$200 < D \leq 300$	+ 5 - 1	1	1
$300 < D \leq 400$	+6 0	1.2	1.2
$400 < D \leq 600$	+10 0	1.2	1.2
$600 < D \leq 1000$	+15 0	1.6	1.6
$1000 < D \leq 1800$	+20 0	2	2



MAXIMUM RPMS

The maximum rpms depend on the grinding wheel diameter and the maximum operating speed.

D mm	Maximum operating speed m/s											
	16	20	25	32	35	40	45	50	63	80	100	125
6	51000	64000	80000	102000	112000	128000	143240	160000	201000			
8	38200	48000	60000	76500	84000	95500	107430	120000	150500	191000		
10	30600	38200	48000	61200	67000	76500	86000	95500	120500	153000	191000	
13	23550	29500	35600	47100	51500	58800	66500	73500	92600	118000	147000	184000
16	19100	23900	29850	38200	41800	47800	54000	59700	75200	95500	120000	150000
20	15300	19100	23900	30600	33500	38200	43000	47800	60200	76500	95500	120000
25	12300	15300	19100	24500	26800	30600	34400	38200	48200	61200	76500	95500
32	9550	11950	14950	29100	20900	23900	26900	30000	37600	48000	60000	75000
40	7650	9550	11950	15300	16750	19100	21500	23900	30100	38200	47200	59700
50	6150	7650	9550	12250	13400	15300	17200	19100	24100	30600	38200	47750
63	4850	6100	7600	9750	10650	12150	13650	15200	19100	24300	30250	37900
80	3850	4800	6000	7650	8400	9550	10750	12000	15100	19100	23900	29850
100	3100	3850	4800	6150	6700	7650	8600	9550	12100	15300	19100	23900
115	2700	3350	4200	5350	5850	650	7500	8350	10500	13300	16650	20800
125	2450	3100	3850	4900	5350	6150	6900	7650	9650	12250	15300	19100
150	2050	2550	3200	4100	4500	5100	5750	6400	8050	10200	12700	16000
180	1700	2150	2700	3400	3750	4250	4800	5350	6700	8500	10650	13300
200	1550	1950	2400	3100	3350	3850	4300	4800	6050	7650	9550	11950
230	1350	1700	2100	2700	2950	3350	3750	4200	5250	6650	8350	10400
250	1250	1550	1950	2450	2700	3100	3450	3850	4850	6150	7650	9550
300	1050	1300	1600	2050	2250	2550	2870	3200	4050	5100	6400	8000
350/356	875	1100	1400	1750	1950	2200	2450	2750	3450	4400	5500	6850
400/406	765	960	1200	1550	1700	1950	2150	2400	3050	3850	4800	6000
450/457	680	850	1100	1400	1500	1700	1950	2150	2700	3400	4250	5350
500/508	615	765	960	1250	1350	1550	1750	1950	2450	3100	3850	4800
600/610	510	640	800	1050	1150	1300	1450	1600	2050	2550	3200	4000
650/660	460	580	720	930	1010	1160	1300	1450	1820	2320	2900	3620

UNBALANCE VALUES OF ABRASIVE PRODUCTS

Calculation of the permissible unbalance of abrasive products:

$$m_a = k \sqrt{m_1}$$

m_a – unbalance (g)

k – unbalance coefficient (see Table)

m_1 – abrasive product weight (g)

The coefficient k for the calculation of the permissible unbalance values should be taken from the following table and depends on the abrasive product's type, dimensions and application:

Method	Machine type	Product type	Dimensions		Coefficient for max. operating speed m/s		
			D	T			
			mm	mm	$16 < V_s \leq 40$	$40 < V_s \leq 63$	$63 < V_s \leq 100$
Grinding	Types Manual grinding machines	F1, F4, F27, F28, F35, F36	$115 < D \leq 150$	-	0.40	0.32	0.25
			$115 < D \leq 180$	-	0.40	0.32	0.20
			$D > 180$	$T \leq 6$	0.40	0.32	0.20
				$T > 6$	0.32	0.25	0.20
		F6, F11	All dimensions		0.40	0.32	-
Grinding	Stationary manual and other mach.	F1, F2, F35, F36	All dimensions		0.63	0.50	0.40
Grinding with high pressures	Stationary grinding machines	F1	All dimensions		0.8		
Grinding -precision gr. -external cylindrical gr. -surface gr. -sharpening	Stationary grinding machines	All types	$125 < D \leq 300$	All dimensions	0.25	0.20	0.16
			$300 < D \leq 610$		0.32	0.25	0.20
			$D > 600$		0.40	0.32	0.25
Cutting-off	Manual cutting-off mach.	F41, F42	$115 < D \leq 400$	-	0.40	0.32	0.20
	Stationary cutting-off mach.	F41, F42	$D \leq 300$	-	0.50	0.40	0.32
			$D > 300$	-	0.63	0.50	0.40



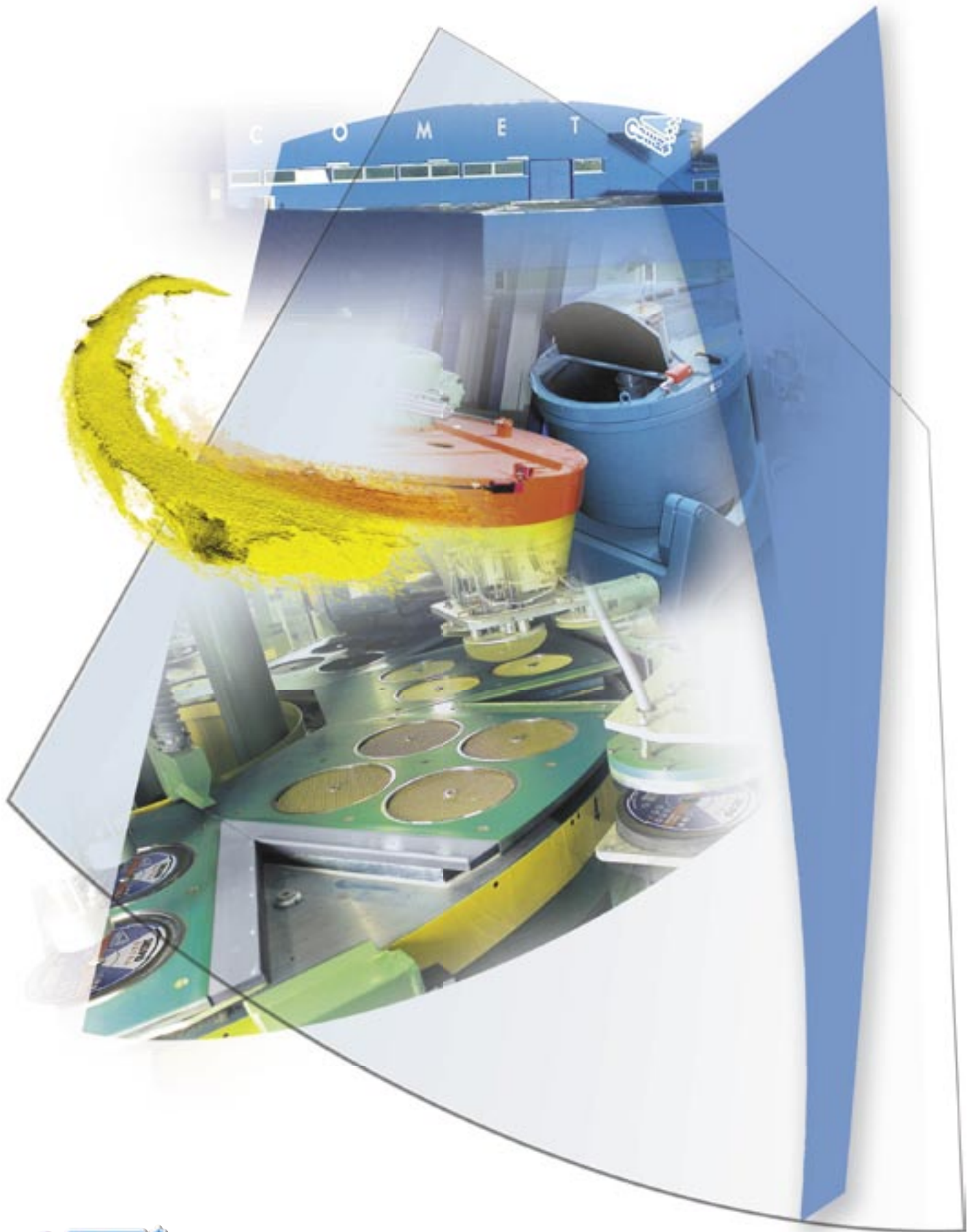
SIDE LOAD TESTING OF ABRASIVE PRODUCTS

In order to ensure a greater safety of abrasive products, all manufacturers are required to test abrasive products for their side-load capacity in accordance with the new requirements of standard EN 12413. The minimal side-load force that an abrasive product is required to sustain for types F41, F42, F27, F28 and F29 used on manual grinding machines is determined from the table below.

Abrasive product	Maximum operating speed V_s m/s	Outside diameter D mm	Side load testing		
			Single-point test	Three-point test	Impact test
			Single-point side loading F_{s1} , N	Three-point side loading F_{s3} , N	Impact resistance A, Nm
Depressed centre grinding wheels F27, F28, F29 ^a	≤ 80	≤ 125	290	-	-
		150	290	-	4.5
		180	290	-	5.4
		230	290	-	6.9
Flat and depressed centre grinding wheels F41, F42 ^a	≤ 80	≤ 125	40	-	-
		150	50	-	1.2
		180	50	-	1.5
		230	50	-	2.0
		300	125	150	5.4
		350/356	125	150	5.4
		400/406	125	150	5.4
	$80 < v_s \leq 100$	300	125	150	5.4
		350/356	125	150	5.4
		400/406	125	150	5.4

^a - in accordance with ISO 525





COLOUR CODED TRADEMARK SYSTEM

MATERIALS

BLUE

METALS/STEEL

METALLIC BLUE

STAINLESS STEEL

PURPLE

ALLOYS/ALUMINIUM

GREEN

STONE/CONCRETE

QUALITY CLASS

STANDARD

STANDARD resin bonded cutting-off and grinding wheels are intended for general-purpose cutting on various materials, taking into account the optimum ratio between cutting or grinding effect and grinding disc price.



EXTRA

The EXTRA product category is distinguished by high quality level, and therefore suitable for more demanding industrial uses. It provides excellent cutting and grinding properties: a quick and clear cut without overheating of the workpiece, as well as soft grinding with high material removal rates.



SPECIAL

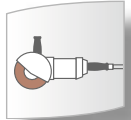
SPECIAL resin bonded grinding wheels with zirkonium are intended for use in industry and ensure minimisation off cutting costs, optimum stock removal, minimum influence on workpiece surface (no discoloration) and correspondingly higher durability.



[illegible]

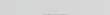
● - To be used primarily on these materials ◆ - Can also be used on...

THIN CUTTING-OFF WHEELS



Standard quality cutting-off wheels are intended for general applications in the cutting of various materials, taking into account the optimal ratio of cutting effect to product price.

QUALITY	MATERIAL	QUALITY CLASS
A60T-BF, A46T-BF	Steel, metals	Standard
20A60S-BF, 20A46S-BF	Stainless steel, steel, metals	Standard
C60S-BF, C46S-BF	Stone, concrete	Standard

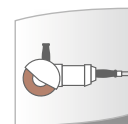
Type		Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Grit size	Packaging units
F41		100 x 1 x 16	80	15300	60	25
F41		115 x 1 x 22.23		13300	46	
F41		125 x 1 x 22.23		12250		
F41		100 x 1.2 x 16		15300		
F41		115 x 1.2 x 22.23		13300		
F41		125 x 1.2 x 22.23		12250		
F41		100 x 1.6 x 16		15300		
F41		115 x 1.6 x 22.23		13300		
F41		125 x 1.6 x 22.23		12250		
F41		150 x 1.6 x 22.23		10200		
F41		178 x 1.6 x 22.23		8500		
F41		230 x 1.6 x 22.23		6650		
F41		150 x 1.8 x 22.23		10200		
F41		178 x 1.8 x 22.23		8500		
F41		230 x 1.8 x 22.23		6650		
F41		250 x 1.8 x 22.23		6150		



F41 type cutting-off wheels are also available with the following bores:

D = 100 mm	H = 10 mm
D = 230, 250 mm	H = 16 mm





The EXTRA product category is distinguished by high quality level; therefore, it is suitable for more demanding industrial uses. It provides excellent cutting properties: high durability, very thin, quick and clear cuts without workpiece overheating and minimal dust formation. It is used on manual cutting machines. Cutting-off wheels with a thickness of 0.75 mm should be used with a flange for soft fastening.

QUALITY

MATERIAL

QUALITY CLASS

EA60T-BF, EA46T-BF	Steel, metals	Extra
E2060S-BF, E20A46S-BF	Stainless steel, steel, metals	Extra
E54A60S-BF, E54A46S-BF	Aluminium, colour metals, alloys	Extra

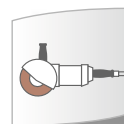
Type		Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Grit size	Packaging units
F42		115 x 0.75 x 22.23	80	13300	60	25
F42		125 x 0.75 x 22.23		12250		
F41		115 x 1 x 22.23		13300		
F41		125 x 1 x 22.23		12250		
F41		115 x 1.6 x 22.23		13300	46	
F41		125 x 1.6 x 22.23		12250		
F42		150 x 1.6 x 22.23		10200		
F42		178 x 1.6 x 22.23		8500		
F42		230 x 1.6 x 22.23		6650		
F41		150 x 1.9 x 22.23		10200		
F41		178 x 1.9 x 22.23		8500		
F41		230 x 1.9 x 22.23		6650		



On customer request, thin cutting-off wheels of all thicknesses may also be produced with a depressed centre (F42 type).



CUTTING-OFF WHEELS



Standard quality cutting-off wheels are intended for general applications in cutting of various materials, taking into account the optimal ratio of cutting effect to product price.

QUALITY	MATERIAL	QUALITY CLASS
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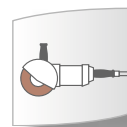
A30S-BF	Steel, metals	Standard
20A30P-BF	Stainless steel, steel	Standard
19A30S-BF	Grey cast, aluminium	Standard
C30S-BF	Stone, concrete	Standard

Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F41	100 x 2 x 16	80	15300	25
F41 F42	100 x 2.5 x 16		15300	
F41 F42	100 x 3 x 16		15300	
F41	115 x 2 x 22.23		13300	
F41 F42	115 x 2.5 x 22.23		13300	
F41 F42	115 x 3 x 22.23		13300	
F41	125 x 2 x 22.23		12250	
F41 F42	125 x 2.5 x 22.23		12250	
F41 F42	125 x 3 x 22.23		12250	
F41	150 x 2 x 22.23		10200	
F41 F42	150 x 2.5 x 22.23		10200	
F41 F42	150 x 3 x 22.23		10200	
F41	165 x 2 x 22.23		9250	
F41	165 x 2.5 x 22.23		9250	
F41	165 x 3 x 22.23		9250	
F41	178 x 2 x 22.23		8500	
F41 F42	178 x 2.5 x 22.23		8500	
F41 F42	178 x 3 x 22.23		8500	
F41	200 x 2 x 22.23		7650	
F41	200 x 2.5 x 22.23		7650	
F41	200 x 3 x 22.23		7650	
F41	230 x 2 x 22.23		6650	
F41 F42	230 x 2.5 x 22.23		6650	
F41 F42	230 x 3 x 22.23		6650	
F41	250 x 2 x 22.23		6150	
F41 F42	250 x 2.5 x 22.23		6150	
F41 F42	250 x 3 x 22.23		6150	



F41 type cutting-off wheels are also available with the following bores:

D = 100 mm	H = 10 mm
D = 115, 125 mm	H = 13 mm
D = 165, 178, 200 mm	H = $\diamond$
D = 150 - 230 mm	H = 13, 16, 20, 25.4, 32, 40 mm



The EXTRA product category is intended for professional industrial use where high quality products are required – quick cuts, high durability of cutting-off wheels.

QUALITY	MATERIAL	QUALITY CLASS
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EA30T-BF	Steel, metals	Extra
E20A30R-BF	Stainless steel, steel	Extra

Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F41	100 x 2 x 16	80	15300	25
F41 F42	100 x 2.5 x 16		15300	
F41	115 x 2 x 22.23		13300	
F41 F42	115 x 2.5 x 22.23		13300	
F41	125 x 2 x 22.23		12250	
F41 F42	125 x 2.5 x 22.23		12250	
F41	150 x 2 x 22.23		10200	
F41 F42	150 x 2.5 x 22.23		10200	
F41	178 x 2 x 22.23		8500	
F41 F42	178 x 2.5 x 22.23		8500	
F41	230 x 2 x 22.23		6650	
F41 F42	230 x 2.5 x 22.23		6650	
F41	250 x 2 x 22.23		6150	
F41 F42	250 x 2.5 x 22.23		6150	

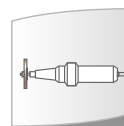
QUALITY	MATERIAL	QUALITY CLASS
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E54A30S-BF	Aluminium, grey cast	Extra
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Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F41 F42	100 x 3 x 16	80	15300	25
F41 F42	115 x 3 x 22.23		13300	
F41 F42	125 x 3 x 22.23		12250	
F41 F42	150 x 3 x 22.23		10200	
F41 F42	178 x 3 x 22.23		8500	
F41 F42	230 x 3 x 22.23		6650	



CUTTING-OFF WHEELS



Intended for cutting all types of steel and metal on flat, manual cutting machines.

QUALITY

MATERIAL

QUALITY CLASS

A60T-BF, A46T-BF

Steel, metals, grey cast

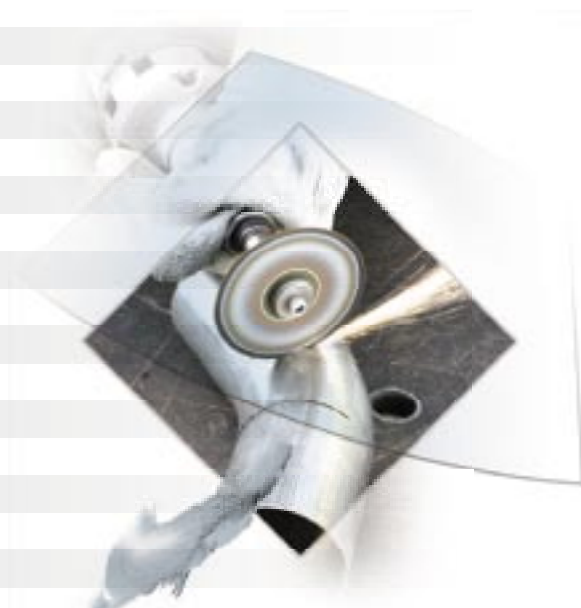
Standard

20A60R-BF, 20A46T-BF

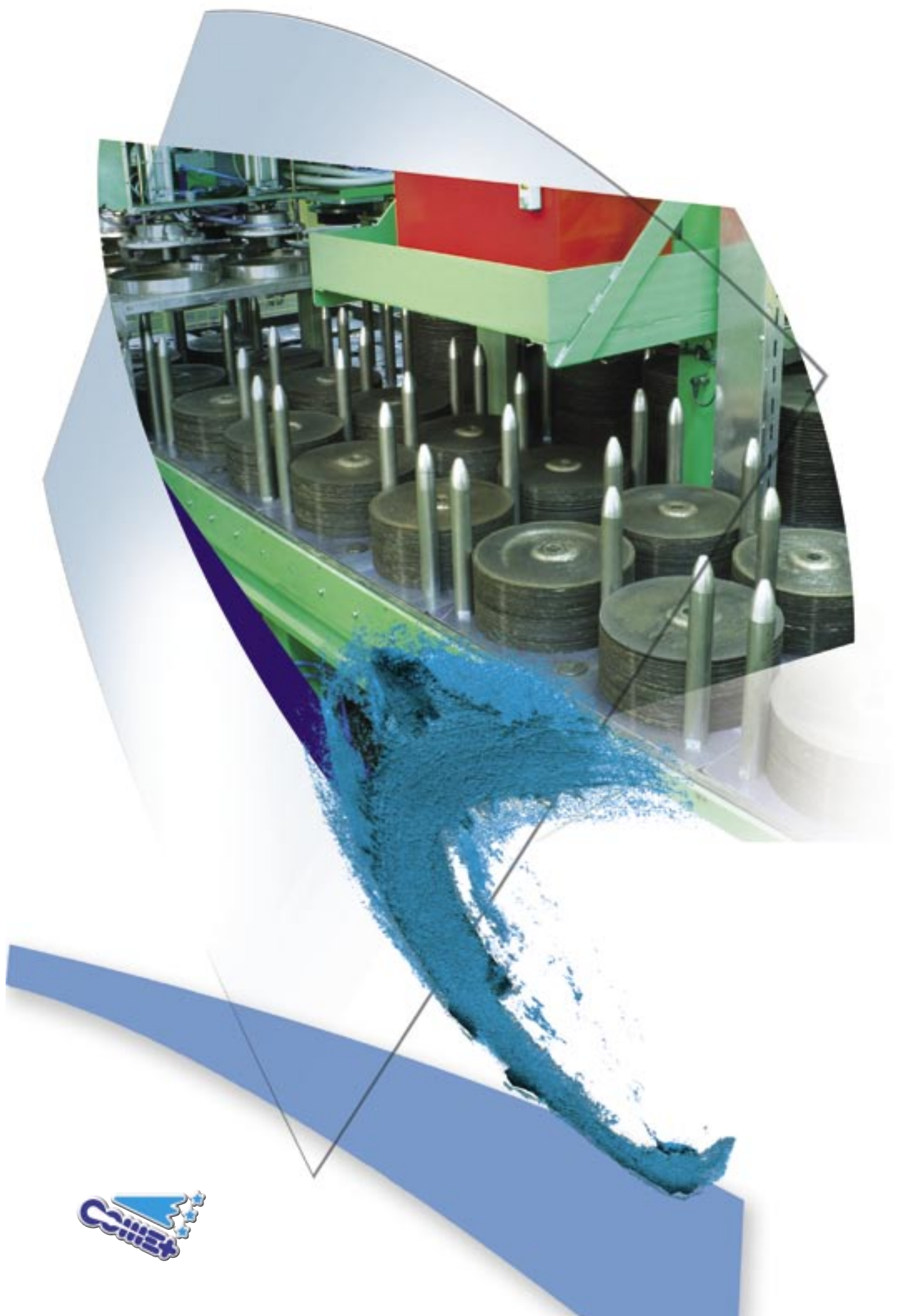
Stainless steel, steel, metals, grey cast

Standard

Type		Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Grit size	Packaging units
F41		50 x 1.0 x H	80	30600	60	100
F41		50 x 1.2 x H		30600		
F41		50 x 1.6 x H		30600		
F41		50 x 1.8 x H		30600		
F41		60 x 1.0 x H		25450		
F41		60 x 1.2 x H		25450		
F41		60 x 1.6 x H		25450		
F41		60 x 1.8 x H		25450		
F41		65 x 1.0 x H		23500		
F41		65 x 1.2 x H		23500		
F41		65 x 1.6 x H		23500		
F41		65 x 1.8 x H		23500		
F41		70 x 1.0 x H		21850		
F41		70 x 1.2 x H		21850		
F41		70 x 1.6 x H		21850		
F41		70 x 1.8 x H		21850		
F41		76 x 1.0 x H		20100		
F41		76 x 1.2 x H		20100		
F41		76 x 1.6 x H		20100		
F41		76 x 1.8 x H		20100		
F41		80 x 1.0 x H		19100		
F41		80 x 1.2 x H		19100		
F41		80 x 1.6 x H		19100		
F41		80 x 1.8 x H		19100		
F41		50 x 2 x H		30600	46	100
F41		60 x 2 x H		25450		
F41		65 x 2 x H		23500		
F41		70 x 2 x H		21850		
F41		76 x 2 x H		20100		
F41		80 x 2 x H		19100		



mm
H 6 10



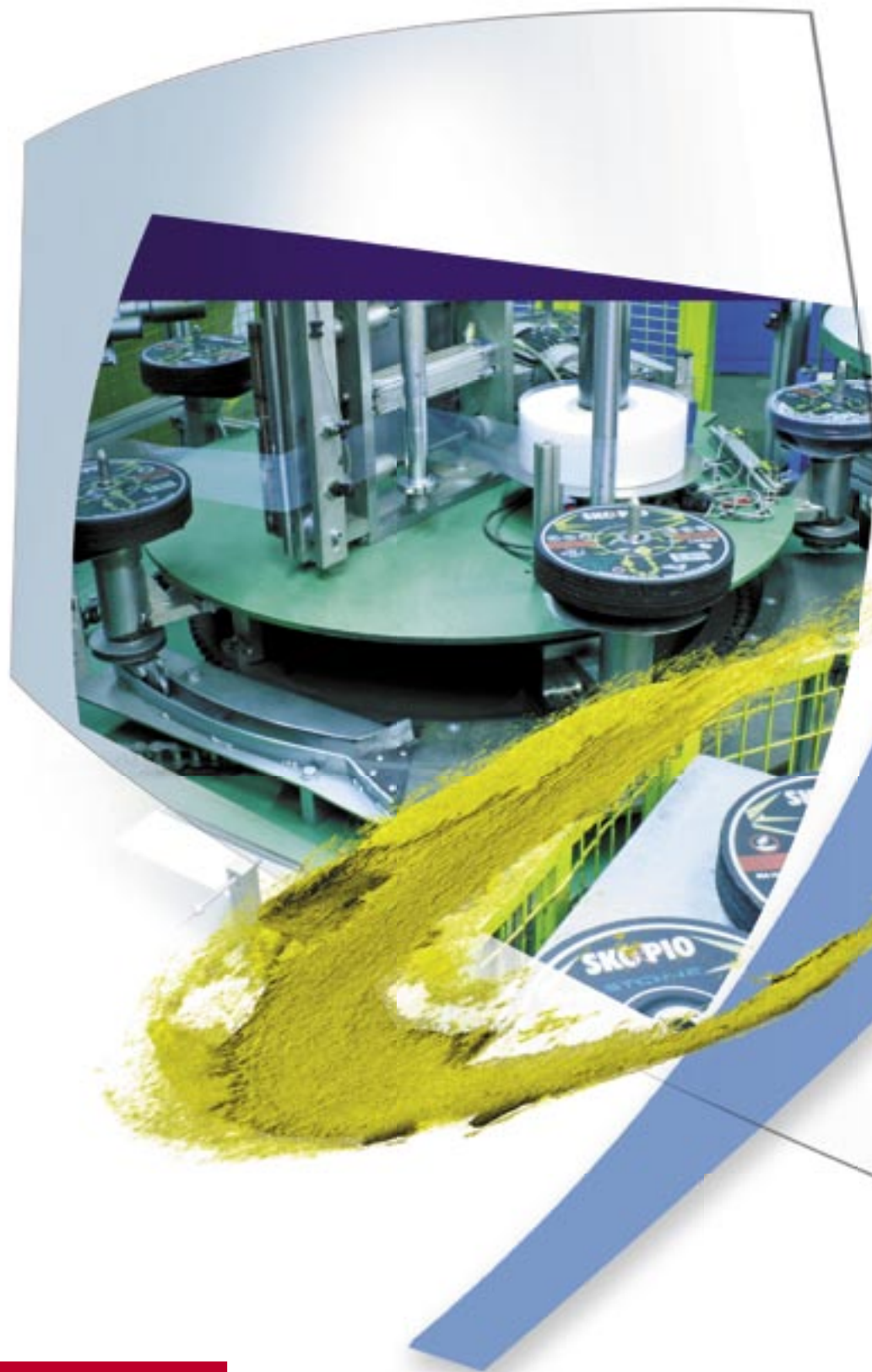
RESIN-BONDED GRINDING WHEELS

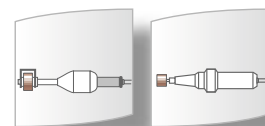
Grinding wheels are produced in three quality classes and in types F27, F27-GR and F28.

The EXTRA grinding wheels are intended for industry applications which require large material removal rates per time unit and a high grinding factor.

For the most demanding industry applications that involve machining of various materials, Comet produces grinding wheels for specific applications called SPECIAL, which also contain zirconium.

In order to achieve optimum grinding effects, ALWAYS observe the prescribed angle between the grinding wheel and the workpiece.

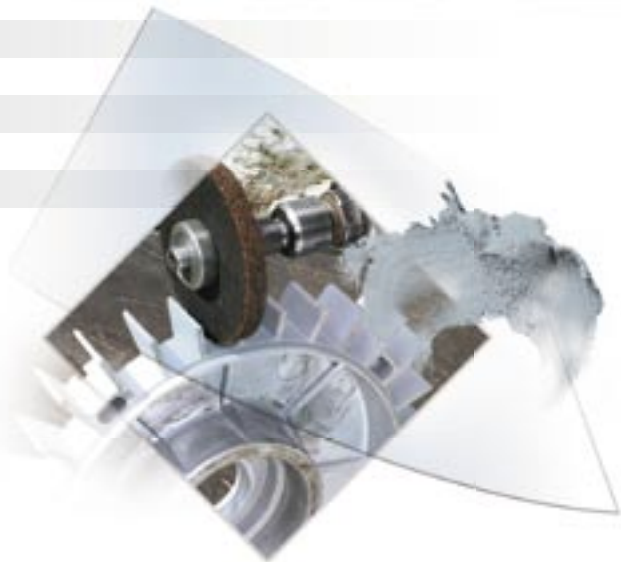


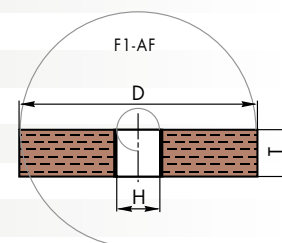


Grinding wheels F1-AF are intended for cleaning casts and forged pieces using flat, manual grinding machines. They are distinguished by optimal material removal rates and appropriate durability without workpiece overheating.

QUALITY	HARDNESS	MATERIAL	QUALITY CLASS
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10A24-30-B	R-S	Metals, steels	Standard
15A30-B	P-R	Metals, steels	Standard
47A30-B	Q-R	Stainless steel	Special
47A24-30-B	R-S	Alloys	Special

Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F1-AF	50 x 4 x H	80	30600	25
F1-AF	50 x 6 x H		30600	
F1-AF	50 x 10 x H		30600	
F1-AF	50 x 12 x H		30600	
F1-AF	60 x 4 x H		25500	
F1-AF	60 x 6 x H		25500	
F1-AF	60 x 10 x H		25500	
F1-AF	60 x 12 x H		25500	
F1-AF	65 x 6 x H1		23500	
F1-AF	65 x 10 x H1		23500	
F1-AF	65 x 12 x H1		23500	
F1-AF	70 x 6 x H1		21800	
F1-AF	70 x 10 x H1		21800	
F1-AF	70 x 12 x H1		21800	
F1-AF	76 x 6 x H1		20100	
F1-AF	76 x 10 x H1		20100	
F1-AF	76 x 12 x H1		20100	
F1-AF	80 x 4 x H1		19100	
F1-AF	80 x 6 x H1		19100	
F1-AF	80 x 10 x H1		19100	
F1-AF	80 x 12 x H1		19100	
F1-AF	100 x 6 x H2		15300	
F1-AF	100 x 10 x H2		15300	
F1-AF	100 x 12 x H2		15300	

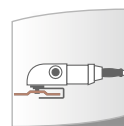


mm

H	6	10		
H1	6	10	12	
H2		10	12	20



GRINDING WHEELS



The STANDARD grinding wheels are intended for grinding and cleaning of welds, casts and forged pieces.

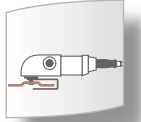
QUALITY	MATERIAL	QUALITY CLASS
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A24-S-BF	Steel, metals	Standard
20A24P-BF	Stainless steel, steel	Standard
19A24S-BF	Grey cast, aluminium	Standard
C24S-BF	Stone, concrete	Standard

Type		Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F27		100 x 4 x 16	80	15300	
F27		100 x 6 x 16		15300	
F27		100 x 7 x 16		15300	
F27		115 x 4 x 22.23		13300	
F27		115 x 6 x 22.23		13300	
F27		115 x 7 x 22.23		13300	
F27		115 x 8 x 22.23		13300	
F27		125 x 4 x 22.23		12250	
F27		125 x 6 x 22.23		12250	
F27		125 x 7 x 22.23		12250	
F27		125 x 8 x 22.23		12250	
F27		150 x 4 x 22.23		10200	
F27		150 x 6 x 22.23		10200	
F27		150 x 7 x 22.23		10200	
F27		150 x 8 x 22.23		10200	
F27		178 x 4 x 22.23		8500	
F27		178 x 6 x 22.23		8500	
F27		178 x 7 x 22.23		8500	
F27 F28		178 x 8 x 22.23		8500	
F27		178 x10 x 22.23		8500	
F27		230 x 4 x 22.23		6650	
F27		230 x 6 x 22.23		6650	
F27		230 x 7 x 22.23		6650	
F27 F28		230 x 8 x 22.23		6650	
F27		230 x10 x 22.23		6650	

On customer request, grinding wheels can also be produced as type F27-GR.





The EXTRA grinding wheels are intended for professional use in industry whenever large material removal rates per time unit and a high grinding factor are required.

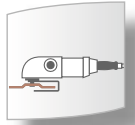
QUALITY	MATERIAL	QUALITY CLASS
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EA24R-BF	Steel, metals	Extra
E20A24R-BF	Stainless steel, steel	Extra
E54A30R-BF	Aluminium, alloys	Extra

Type		Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F27		100 x 4 x 16	80	15300	10
F27		100 x 7 x 16		15300	
F27		115 x 4 x 22.23		13300	
F27		115 x 7 x 22.23		13300	
F27		115 x 8 x 22.23		13300	
F27		125 x 4 x 22.23		12250	
F27		125 x 7 x 22.23		12250	
F27		125 x 8 x 22.23		12250	
F27		150 x 4 x 22.23		10200	
F27		150 x 7 x 22.23		10200	
F27		150 x 8 x 22.23		10200	
F27		178 x 4 x 22.23		8500	
F27		178 x 7 x 22.23		8500	
F27		178 x 8 x 22.23		8500	
F27		230 x 4 x 22.23		6650	
F27		230 x 7 x 22.23		6650	
F27		230 x 8 x 22.23		6650	



SEMI-FLEXIBLE GRINDING WHEELS



Semi-flexible grinding wheels are intended for general cleaning of large surface areas. They are produced in grit sizes between 24 and 100, to be used for coarse, medium or fine grinding.

QUALITY	MATERIAL	QUALITY CLASS
---------	----------	---------------

A24 - A100	Steel	Standard
20A24 - 20A100	Stainless steel	Standard
19A24 - 19A100	Grey cast	Standard
C24 - C100	Stone, concrete, marble	Standard

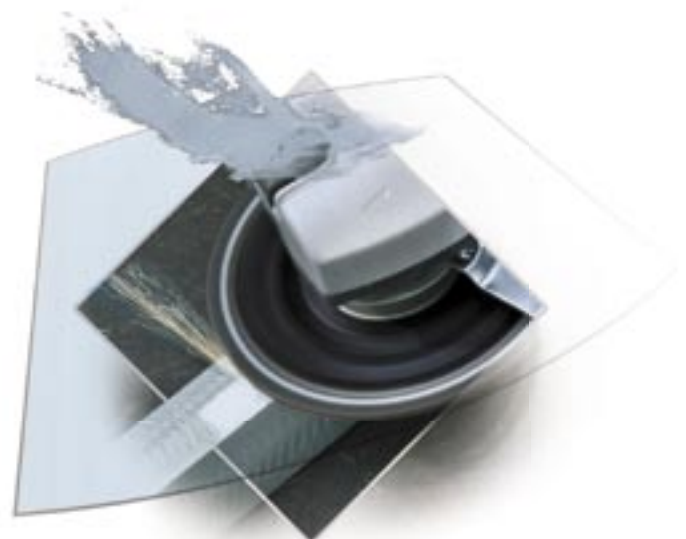
Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F29	100 x 3.5 x 22.23	80	15300	25
F29	115 x 3.5 x 22.23		13300	
F29	125 x 3.5 x 22.23		12200	
F29	150 x 3.5 x 22.23		10200	
F29	178 x 3.5 x 22.23		8600	



Backing pads for semi-flexible grinding wheels are enclosed in each basic package.

Always use backing pads with diameter 100 mm for semi-flexible grinding wheels with diameters 100 mm, 115 mm and 125 mm, and with diameter 130 mm for wheels with diameters 150 mm and 178 mm.

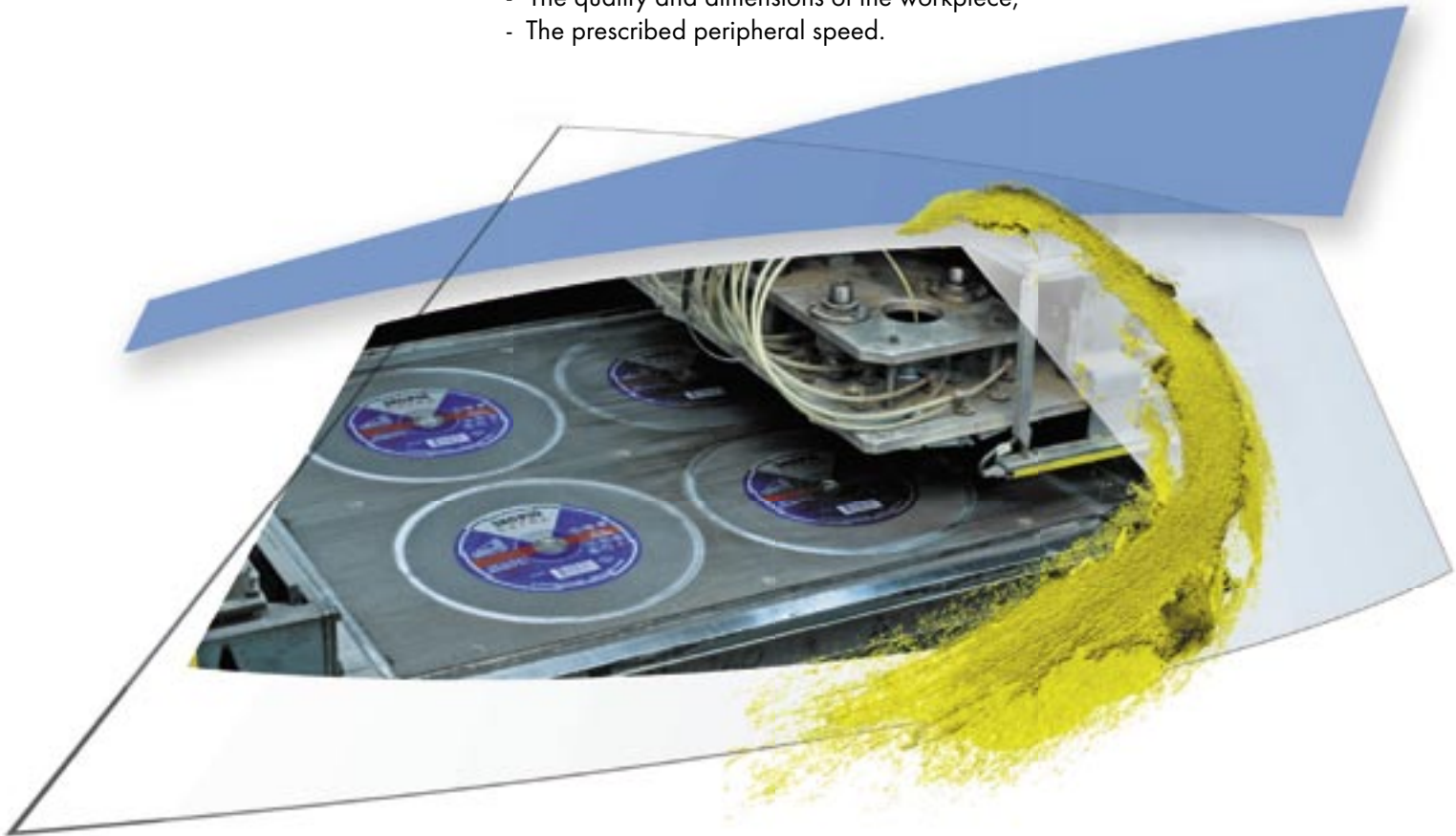
NEVER use semi-flexible grinding wheel without a backing pad!



Cutting-off wheels of larger dimensions are intended for machine cutting of various profiles.

When selecting the cutting-off wheel, you should always take into account the following:

- The machine type, which determines the type of cutting;
STATIONARY cutting on portable or stationary cutting machines,
FREE-HAND cutting on gas- or electrically-operated manual cutting machines;
- The quality and dimensions of the workpiece;
- The prescribed peripheral speed.



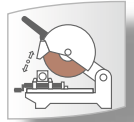
By observing the above requirements, you will be able to avoid the following problems:

- Excessive duration of cutting;
- Excessive wheel wear due to low machine power and low peripheral speed or insufficient rpms;
- Wobbly cuts, which may occur as a result of using a too thin cutting-off wheel, cutting machine malfunction, or an inappropriate diameter or damaged, dirty or worn out flange.

Inappropriate wheel selection may lead to:

- Cutting-off wheels can fly off due to cutting of large non-fixed workpieces;
- Use of extreme pressures during cutting as a result of too hard bond, insufficient peripheral speed or too low rpms;
- Surface damage to the cutting-off wheel due to inappropriate cutting machine or because the workpiece grips the cutting-off wheel during operation or due to too rough handling of the cutting-off wheel;
- The cutting-off wheel may also break due to forcible cutting, inappropriate flange or fastening method, damage to the cutting-off wheel bore or too high lead on the machine axle.

CUTTING-OFF WHEELS



These cutting-off wheels are intended for cutting smaller profiles.

QUALITY	MATERIAL	QUALITY CLASS
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A36P-BF	METALS, steel, general and high-strength construction steel, tool steel, low and high-alloy stainless steel.	Standard
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Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Reinf.	Packaging units
F41	300 x 2.8 x H	80	5100	E	25
F41	300 x 2.8 x H	63	4050	I	
F41	350 x 3.0 x H	80	4400	E	10
F41	350 x 3.0 x H	63	3450	I	
F41	400 x 3.0 x H1	80	3850	E	
F41	400 x 3.5 x H1	63	3050	I	

QUALITY	MATERIAL	QUALITY CLASS
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20A30P-BF	STAINLESS STEEL, low and high-alloy stainless steel sheet metal, steel, general and high-strength construction steel, tool steel.	Standard
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Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Reinf.	Packaging units
F41	300 x 2.8 x H	80	5100	E	25
F41	350 x 3.0 x H		4400	E	10

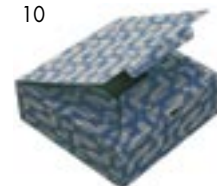
QUALITY	MATERIAL	QUALITY CLASS
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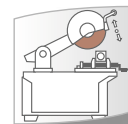
C46S-BF	STONE, fire-resistant brick, clinker, ceramics, granite, reinforced concrete, marble and ordinary types of concrete, concrete with paving stones.	Standard
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Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Reinf.	Packaging units
F41	300 x 2.8 x H	80	5100	E	25
F41	350 x 3.0 x H		4400	E	10

mm		
H	20	22.23 25.4
H1		25.4

Products with various bore sizes (H) are available on customer request.





These cutting-off wheels are intended for cutting smaller profiles.

QUALITY

MATERIAL

QUALITY CLASS

A30S-BF

METALS, steel, tool steel, general and high-strength construction steel.

Standard

Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Reinf.	Packaging units
F41	300 x 3 x H	80	5100	E	25
F41	300 x 3 x H	100	6400	I	
F41	350 x 3.5 x H	80	4400	E	10
F41	350 x 3.5 x H	100	5500	I	



QUALITY

MATERIAL

QUALITY CLASS

20A30P-BF

STAINLESS STEEL, low and high-alloy stainless steel sheet metal, steel, general and high-strength construction steel, tool steel.

Standard

Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Reinf.	Packaging units
F41	300 x 3 x H	80	5100	E	25
F41	350 x 3.5 x H		4400	E	10

QUALITY

MATERIAL

QUALITY CLASS

19A30S-BF

GREY CAST, steel, general and high-strength construction steel, nodular and tempered alloy, steel alloy, aluminium, other colour metals.

Standard

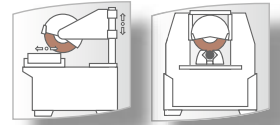
Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Reinf.	Packaging units
F41	300 x 3 x H	80	5100	E	25
F41	350 x 3.5 x H		4400	E	10

	mm				
H	20	22.23	25.4	30	32

Products with various bore sizes (H) are available on customer request.



CUTTING-OFF WHEELS



These cutting-off wheels are intended for cutting large profiles and casts in industry.

QUALITY

MATERIAL

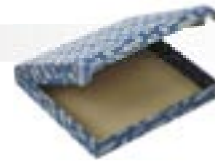
QUALITY CLASS

20A24P-BF

STAINLESS STEEL, steel, tool steel, general and high-strength construction steel, low and high-alloy stainless steel, stainless steel sheet metal.

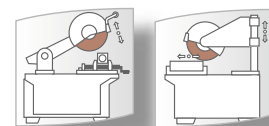
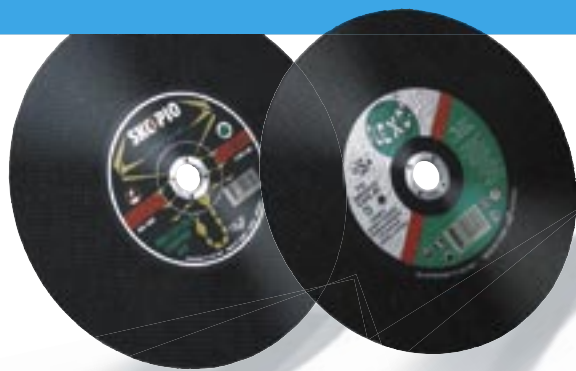
Standard

Type		Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Reinf.	Packaging units
F41		400 x 4 x H	80	3850	E	10
F41		400 x 4 x H	100	4800	E	
F41		450 x 4.5 x H		4250	E	
F41		500 x 5 x H		3850	E	



	mm					
H	25.4	32	40	60	76.2	80

Cutting-off wheels with various bore sizes (H) are available on customer request.



These cutting-off wheels are intended for cutting non-metal materials.

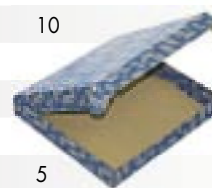
QUALITY

MATERIAL

QUALITY CLASS

C30S-BF	STONE, fire-resistant brick, ceramics, granite, reinf. concrete, marble	Standard
C24S-BF	and ordinary types of concrete, concrete with paving stones, asphalt.	Standard

Type		Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Reinf.	Packaging units
F41		300 x 3 x H	80	5100	E	25
F41		350 x 3.5 x H		4400	E	10
F41		400 x 4 x H1		3850	E	10
F41		400 x 4 x H1	100	4800	E	
F41		450 x 4.5 x H1		4250	E	
F41		500 x 5 x H1		3850	E	
F41		600 x 7 x H2		3200	I	5

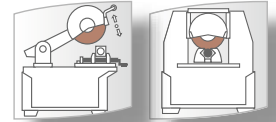


	mm								
H	20	22.23	25.4	30	32				
H1			25.4		32	40	60	76.2	80
H2							60	76.2	80

Cutting-off wheels with various bore sizes (H) are available on customer request.



CUTTING-OFF WHEELS



These cutting-off wheels are intended for cutting profiles and casts in industry.

QUALITY

MATERIAL

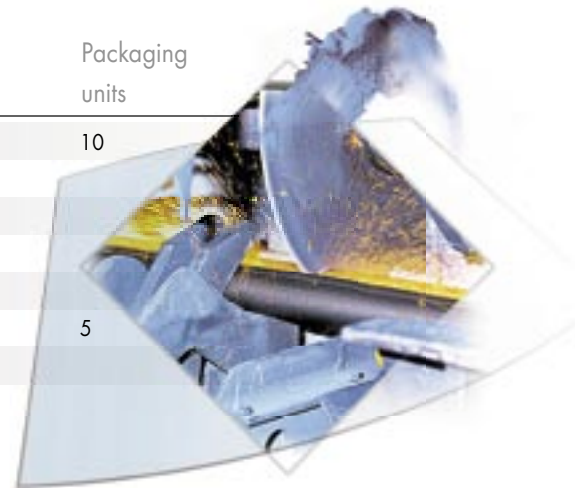
QUALITY CLASS

A24S-BF

METALS, steel, tool steel, general and high-strength construction steel.

Standard

Type		Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Reinf.	Packaging units
F41		400 x 4 x H	80	3850	E	10
F41		400 x 4 x H	100	4800	I	
F41		450 x 4.5 x H		4250	I	
F41		500 x 5 x H		3850	E	
F41		500 x 5 x H		3850	I	
F41		600 x 6 x H1		3200	I	5
F41		600 x 7 x H1		3200	I	
F41		610 x 7 x H1		3200	I	



QUALITY

MATERIAL

QUALITY CLASS

19A24S-BF

Grey cast, steel, general and high-strength construction steel, nodular and tempered alloy, steel alloy, aluminium, other colour metals.

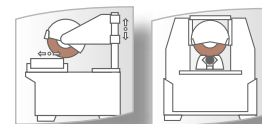
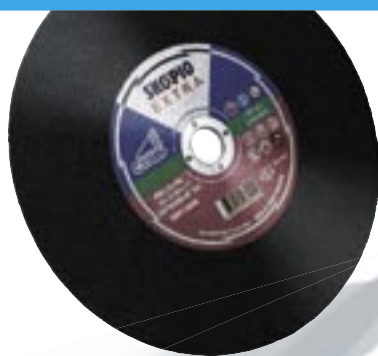
Standard

Type		Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Reinf.	Packaging units
F41		400 x 4 x H	80	3850	E	10
F41		400 x 4 x H	100	4800	E	
F41		450 x 4.5 x H		4250	E	
F41		500 x 5 x H		3850	E	



	mm					
H	25.4	32	40	60	76.2	80
H1				60	76.2	80

Cutting-off wheels with various bore sizes (H) are available on customer request.



These cutting-off wheels are intended for cutting various types of alloys in industry. They are distinguished by quick cuts and a high cutting factor.

QUALITY	MATERIAL	QUALITY CLASS
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E479A24R-BF	GREY CAST, nodular alloy, tempered alloy, steel alloy, steel, general and high-strength construction steel, tool steel, stainless steel, low and high-alloy stainless steel, stainless steel sheet metal.	Extra
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Type		Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Reinf.	Packaging units
F41		400 x 4 x H	100	4800	I	10
F41		500 x 5 x H		3850	I	
F41		600 x 7 x H1		3200	I	5
F41		610 x 7 x H1		3200	I	

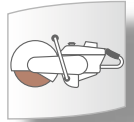
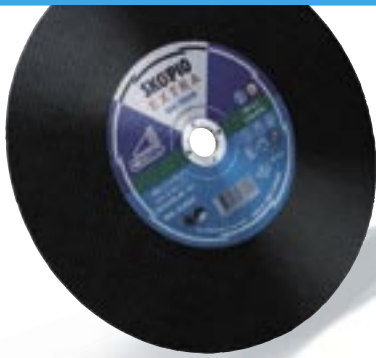


	mm			
H	40	60	76.2	80
H1		60	76.2	80

Cutting-off wheels with various bore sizes (H) are available on customer request.



CUTTING-OFF WHEELS



The EXTRA cutting-off wheels are intended for cutting railway tracks. Their advantages include high durability, along with high-quality and precise cuts without workpiece overheating. Greater cutting wheel efficiency can be achieved by turning the machine.

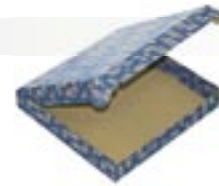
QUALITY

MATERIAL

QUALITY CLASS

E47A24Q-BF	RAILWAYS, steel, general and high-strength steel,	Extra
E74A20R-BF	tool steel, stainless steel, low and high-alloy	Extra
	stainless steel.	

Type		Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Reinf.	Packaging units
F41		300 x 3 x H	80	5100	E	25
F41		300 x 4 x H	100	6400	E	
F41		350 x 3 x H	80	4400	E	10
F41		350 x 4 x H	100	5500	E	
F41		400 x 3 x H	80	3850	E	
F41		400 x 4 x H	100	4800	E	



WARNING!

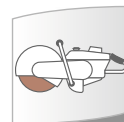
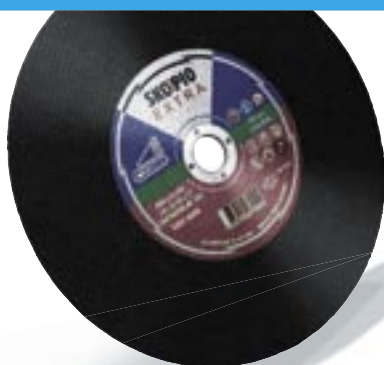
Gas-operated manual cutting machines achieve the best results when cutting at maximum speed and power (constantly). Do not press hard while cutting, as this may cause overheating and burning of the railway track, rapid wear on the wheel, lower efficiency and breakage.

Between individual cuts, breaks of at least 2 minutes are recommended.



	mm		
H	20	22.23	25.4

Cutting-off wheels with various bore sizes (H) are available on customer request.



Type E91C24S-BF cutting-off wheels are intended for cutting railway sleepers.

QUALITY

MATERIAL

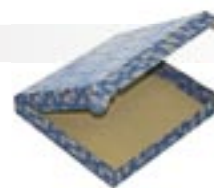
QUALITY CLASS

E91C24S-BF

RAILWAY SLEEPERS, marble and ordinary types of concrete, granite, ceramics, clinker, fire-resistant brick, stone.

Extra

Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Reinf.	Packaging units
F41	300 x 3 x H	80	5100	E	25
F41	300 x 4 x H	100	6400	E	
F41	350 x 3 x H	80	4400	E	10
F41	350 x 4 x H	100	5500	E	
F41	400 x 3 x H	80	3850	E	
F41	400 x 4 x H	100	4800	E	



	mm		
H	20	22.23	25.4

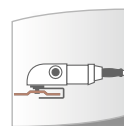
Cutting-off wheels with various bore sizes (H) are available on customer request.



RESIN-BONDED GRINDING WHEELS FOR SPECIAL APPLICATIONS

SPECIAL grinding wheels, with diameters from 100 to 230 mm	35
F41N non-reinforced cutting-off wheels	36
Grinding rings for surface grinding	38
Grinding segments for single and dual-wheel surface grinding	39
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Mounted points with nuts	43
Grinding wheels - Railway product range	44
Grinding wheels with diameters from 75 to 250 mm	46
Grinding wheels for cleaning grooves with diameters from 300 to 600 mm	48
Grinding wheels with diameters from 300 to 600 mm for coarse grinding	49
Grinding wheels with diameters from 300 to 600 mm for circular cylindrical grinding	50
Grinding wheels with diameters from 300 to 600 mm for centerless grinding	51
Grinding wheels with diameters from 200 to 350 mm for centerless grinding	52
Grinding wheels with diameters from 300 to 600 mm for surface cylindrical frontal grinding	53
Grinding wheels with diameters from 300 to 600 mm for single and dual-wheel surface grinding	54
Grinding wheels for sharpening applications in the leather industry	55





The SPECIAL grinding wheels are intended for specific industry applications.

QUALITY	HARDNESS	MATERIAL	QUALITY CLASS
ZA24R-BF	P-S	Stainless steel, steel, alloys,	Special
47A24R-BF	Q-T	Stainless steel, steel, alloys	Special
117A24R-BF	R	High-alloy steel	Special

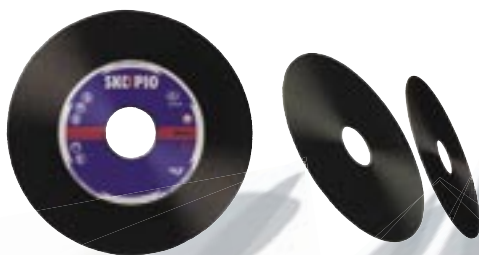
Type		Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F27		100 x 4 x 16	80	15300	10
F27		100 x 7 x 16		15300	
F27		115 x 4 x 22.23		13300	
F27		115 x 7 x 22.23		13300	
F27		125 x 4 x 22.23		12250	
F27		125 x 7 x 22.23		12250	
F27		150 x 4 x 22.23		10200	
F27		150 x 7 x 22.23		10200	
F27		178 x 4 x 22.23		8500	
F27		178 x 7 x 22.23		8500	
F27 (F28)		178 x 8 x 22.23		8500	
F27		178 x 10 x 22.23		8500	
F27		230 x 4 x 22.23		6650	
F27		230 x 7 x 22.23		6650	
F27 (F28)		230 x 8 x 22.23		6650	
F27		230 x 10 x 22.23		6650	



On customer request, grinding wheels can also be produced as type F27-GR and F1-AF.



NON-REINFORCED CUTTING-OFF WHEELS



These cutting-off wheels are intended for cutting metallographic specimens and grooves, as well as for sharpening of circular saws on automatic machines.

Please note that these cutting-off wheels are NOT REINFORCED and are produced exclusively for use on stationary machines for cutting at predefined peripheral speeds (50, 63 or 80 m/s).

ALWAYS use flanges for soft fastening.

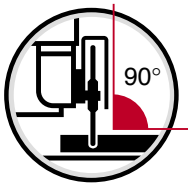
QUALITY	HARDNESS	MATERIAL	QUALITY CLASS
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10A60-B	N	Metals	Standard
15A46-60-B	L-N	Low-alloy steels	Standard
15A60-B	J-K	High-alloy steels	Standard
42A46-60-B	K-L	Stainless steel	Standard
95C80-B	P	Plastics	Standard
54A60-B	R	Aluminium	Standard

Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F41N	50 x 1.0 x H	50	19100	25
F41N	50 x 1.5 x H		19100	
F41N	50 x 2.0 x H		19100	
F41N	80 x 1.0 x H		12000	
F41N	80 x 1.5 x H		12000	
F41N	80 x 2.0 x H		12000	
F41N	100 x 1.0 x H		9550	
F41N	100 x 1.5 x H		9550	
F41N	100 x 2.0 x H		9550	
F41N	100 x 2.5 x H		9550	
F41N	115 x 1.0 x H		8350	
F41N	115 x 1.5 x H		8350	
F41N	115 x 2.0 x H		8350	
F41N	115 x 2.5 x H		8350	
F41N	125 x 1.0 x H		7650	
F41N	125 x 1.5 x H		7650	
F41N	125 x 2.0 x H		7650	
F41N	125 x 2.5 x H		7650	
F41N	125 x 3.0 x H		7650	
F41N	150 x 1.0 x H		6400	
F41N	150 x 1.5 x H		6400	
F41N	150 x 2.0 x H		6400	
F41N	150 x 2.5 x H		6400	
F41N	150 x 3.0 x H		6400	



NON-REINFORCED CUTTING-OFF WHEELS



Cutting should ALWAYS be done at an angle of 90 degrees.

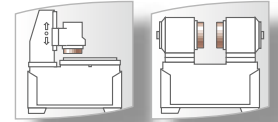


Type		Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F41N	—	178 x 1.5 x H	50	5350	25
F41N	—	178 x 2.0 x H		5350	
F41N	—	178 x 2.5 x H		5350	
F41N	—	178 x 3.0 x H		5350	
F41N	—	200 x 1.5 x H		4800	
F41N	—	200 x 2.0 x H		4800	
F41N	—	200 x 2.5 x H		4800	
F41N	—	200 x 3.0 x H		4800	
F41N	—	230 x 1.5 x H		4200	
F41N	—	230 x 2.0 x H		4200	
F41N	—	230 x 2.5 x H		4200	
F41N	—	230 x 3.0 x H		4200	
F41N	—	250 x 1.5 x H		3850	
F41N	—	250 x 2.0 x H		3850	
F41N	—	250 x 2.5 x H		3850	
F41N	—	250 x 3.0 x H		3850	
F41N	—	250 x 3.5 x H		3850	
F41N	—	300 x 2.0 x H		3200	
F41N	—	300 x 2.5 x H		3200	
F41N	—	300 x 3.0 x H		3200	

	mm						
H	6	10	16	20	22.23	25	32



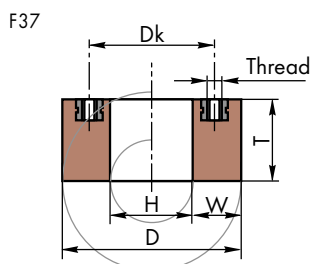
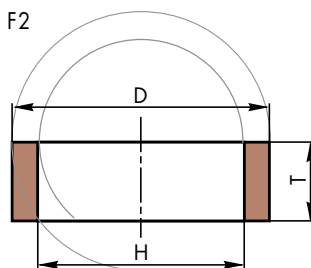
GRINDING RINGS

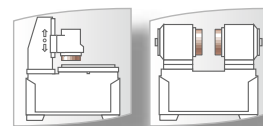


Grinding rings are intended for sharpening of blades for the lumber and paper industries on various purpose-built stable grinding machines. They are distinguished by high durability, optimal material removal rates, no material burning, no chips left on the workpiece and uniform wear.

QUALITY	HARDNESS	MATERIAL	QUALITY CLASS
42A46-60-B	J-L	Non-alloy and low-alloy steels	Standard
42A46-60-B	H-I	Steel alloys	Standard
42A46-60-B	E-G	High-alloy stainless steel	Standard
C20-24-B	G-I	Stone, porcelain, concrete	Standard

Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F2	200 x 65 W=25	40	3850	1
F2	200 x 90 W=20		3850	
F2	200 x 100 W=20		3850	
F2	250 x 80 W=25		3100	
F2	250 x 100 W=25		3100	
F2	250 x 125 W=25		3100	
F2	300 x 82 W=35		2550	
F37	250 x 125 W=25; 6 x M8 Dk=225	50	3850	

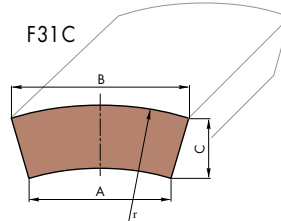
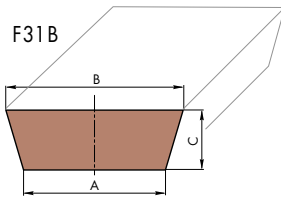
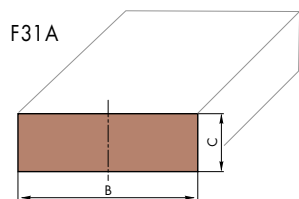




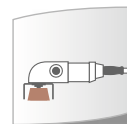
Grinding segments are intended for single or DUAL-WHEEL SURFACE grinding of blades for the lumber and paper industries on purpose-built stable grinding machines. They are distinguished by optimal material removal rates, high durability and appropriate workpiece surface.

QUALITY	HARDNESS	MATERIAL	QUALITY CLASS
17A24-60-B	L-N	Non-alloy and low-alloy steels	Standard
42A46-60-B	J-L	Alloy and fast-cutting steels	Standard
297C24-36-B	M-P	Grey and nodular alloys	Standard
54A36-46-B	L-M	Aluminium - colour metals	Standard
42A36-46-B	I-J	Blades of lower hardness for the lumber and paper industries	Standard
42A46-60-B	F-H	Blades of higher hardness for the lumber and paper industries	Standard
90C16-24-B	L-N	Lamellar and brake pads	Standard

Type	Dimensions/mm					Packaging units
	A	B	C	L	R	
F31A	50		32	130		10
F31A	80		25	150		
F31A	90		35	150		
F31A	85		50	185		
F31B	65	50	30	100		
F31B	70	64	25	150		
F31B	100	85	35	150		
F31B	100	85	40	150		
F31B	103	94	38	200		
F31B	120	106	41	200		
F31B	120	106	41	220		10
F31B	120	106	41	250		
F31C	95	72	25	120	150	
F31C	115	80	30	180	180	
F31C	143	103.5	40	200	250	



GRINDING CUPS



Grinding cups are intended for the grinding of large surface areas of materials with manual angle grinding machines. Please note that grinding cups are NON-REINFORCED and therefore highly sensitive to mechanical damage, which may result from impacts or equipment falling on the floor.



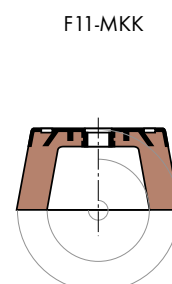
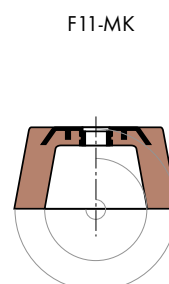
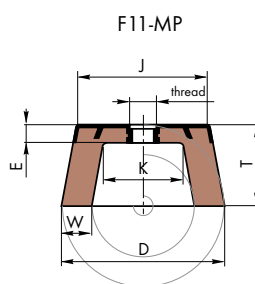
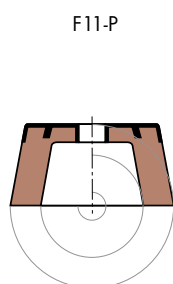
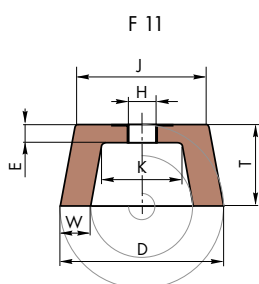
Grinding cups should ALWAYS be fastened on angle grinding machines using a special safety shield!

QUALITY	HARDNESS	MATERIAL	QUALITY CLASS
A14-A120-B	M-R	Metals, steel, construction steel	Standard
19A14-19A36-B	M-R	Grey cast	Standard
47A14-47A46-B	P-R	Stainless steel, steel, alloys	Special
ZA14-ZA4-B	P-R	Stainless steel, steel, alloys	Special
C14-C120-B	N-R	Concrete, stone, granite	Standard

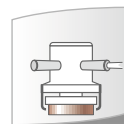
Type	Dimensions D x T x H mm	J mm	W mm	E mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F11-P	76/64 x 40 x 22.23	64	12	11	50	12570	10
F11-P	102/76 x 51 x 22.23	76	12	12		9370	
F11-P	110/90 x 55 x 22.23	90	20	12		8680	
F11-P	130/90 x 55 x 22.23	90	30	12		7350	5
F11-MP	76/64 x 40 x thread	64	12	11		12570	10
F11-MP	102/76 x 51 x thread	76	20	12/19		9370	
F11-MP	110/90 x 55 x thread	90	20	12/19		8680	
F11-MP	130/90 x 55 x thread	90	30	12/19		7350	5
F11-MK	130/90 x 55 x thread	90	30	12		7350	
F11-MK	130/100 x 51 x thread	100	30	19		7350	
F11-MK	150/120 x 51 x thread	120	30	19		6400	



Threads: M10, M14, 5/8"UNC



On customer request, F11 grinding cups can be made without flange.

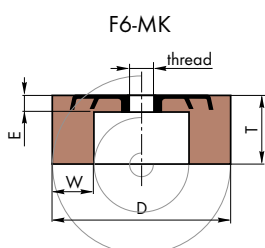
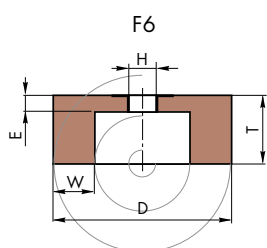


The F6 and F6-MK grinding cups are intended for grinding large surface areas with manual vertical grinding machine.

QUALITY	HARDNESS	MATERIAL	QUALITY CLASS
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A14-A120-B	M-R	Metals, steel, construction steel	Standard
19A14-19A36-B	M-R	Grey cast	Standard
47A14-47A46-B	P-R	Stainless steel, steel, alloys	Special
ZA14-ZA46-B	P-R	Stainless steel, steel, alloys	Special
54A14-54A46-B	P-R	Aluminium	Standard
C14-C120-B	N-R	Concrete, stone, granite	Standard

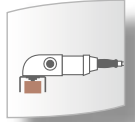
Type	Dimensions D x T x H mm	W mm	E mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F6	80 x 45 x 22.23	18	12	50	11940	10
F6	100 x 45 x 22.23	28	12		9550	
F6	130 x 50 x 22.23	32	12		7350	5
F6	130 x 110 x 22.23	35	20		6370	
F6	150 x 40 x 22.23	35	12		6370	1
F6	150 x 50 x 22.23	35	12		6370	
F6	150 x 110 x 22.23	35	20		6370	
F6-MK	80 x 45 x M14	20	12		11940	10
F6-MK	100 x 45 x M14	30	12		9550	
F6-MK	130 x 50 x M14	32	12		7350	5
F6-MK	130 x 65 x M14	35	15		7350	
F6-MK	150 x 40 x M14	50	19		6370	1
F6-MK	150 x 50 x M14	50	19		6370	
F6-MK	150 x 55 x M20	40	19		6370	
F6-MK	150 x 65 x 5/8"-11	40	19		6370	



On customer request, F6 grinding cups can be made without flange.



GRINDING CUPS



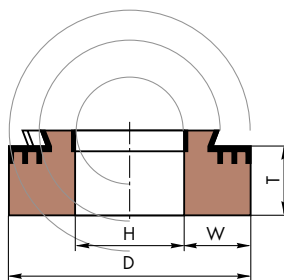
Grinding cups with spiral top for fastening are intended for the grinding of large surface areas. Please note that they are not reinforced and therefore highly sensitive to mechanical damage, which may result from impacts or equipment falling on the floor.

QUALITY	HARDNESS	MATERIAL	QUALITY CLASS
A14-A120-B	M-R	Metals, steel, construction steel	Standard
19A14-19A36-B	M-R	Grey cast	Standard
47A14-47A46-B	P-R	Stainless steel, alloys	Special
ZA14-ZA46-B	P-R	Stainless steel, steel, alloys	Special
54A14-54A46-B	P-R	Aluminium	Standard
C14-C120-B	N-R	Concrete, stone, granite	Standard

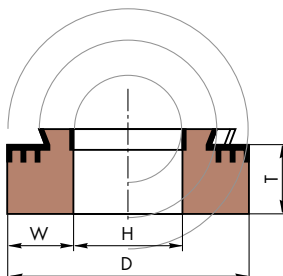
Type	Dimensions D x T x H mm	W mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F35-SGD	100 x 40 x 32	34	35	6690	10
F35-SGD	130 x 40 x 58	35		5140	
F35-SGD	150 x 40 x 58	33		4460	
F35-SGL	100 x 40 x 32	34		6690	
F35-SGL	130 x 40 x 58	35		5140	
F35-SGL	150 x 40 x 58	35		4460	



F35-SGD

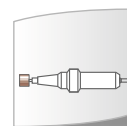


F35-SGL





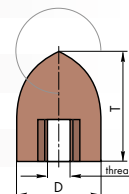
Intended for the CLEANING and GRINDING of various casts and metal parts. Quality 47A is distinguished by high material removal rates without workpiece overheating.



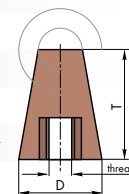
QUALITY	HARDNESS	MATERIAL	QUALITY CLASS
12A24-B	R	Metals, steel	Standard
47A16-24-B	R	Stainless steel, alloys	Special

Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F15	40 x 63 x thread	50	23900	25
F15	50 x 80 x thread		19100	
F15	63 x 80 x thread		15200	
F17	32 x 50 x thread		30000	
F17	32 x 63 x thread		30000	
F17	40 x 63 x thread		23900	
F17	50 x 80 x thread		19100	
F17	50 x 100 x thread		19100	
F18	32 x 40 x thread		30000	
F18	32 x 50 x thread		30000	
F18	32 x 63 x thread		30000	
F18	40 x 40 x thread		23900	
F18	40 x 50 x thread		23900	
F18	40 x 63 x thread		23900	
F18	50 x 80 x thread		19100	
F18R	50 x 50 x thread		19100	
F18R	50 x 80 x thread		19100	
F18R	50 x 100 x thread		19100	
F18R	63 x 80 x thread		15200	
F18R	80 x 80 x thread		12000	
F19	32 x 63 x thread		30000	
F19	40 x 63 x thread		23900	
F19	50 x 80 x thread		19100	
F19	50 x 100 x thread		19100	

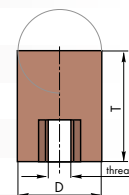
F15



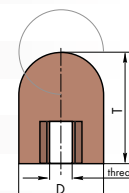
F17



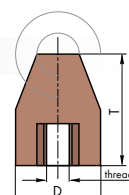
F18



F18R



F19



On customer request, mounted points can also be produced with the following threads:

M10, M12, M14 and M16

3/8", 1/2", 5/8" and 3/4" - 11UNC, UNF



GRINDING WHEELS – Railway product range

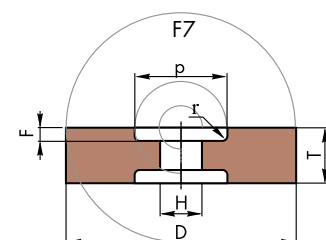
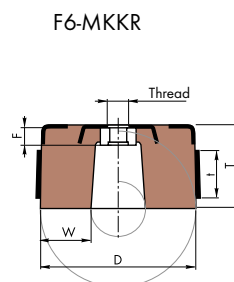
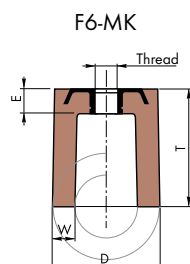
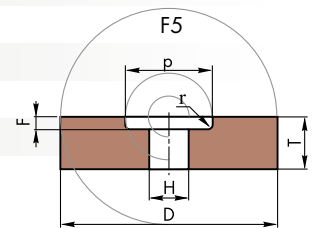
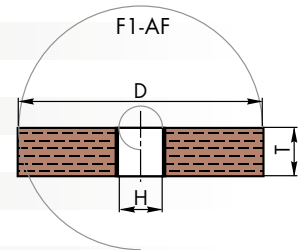
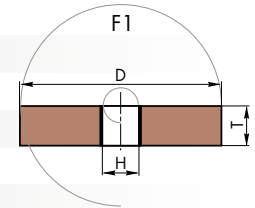


These grinding wheels are intended for the maintenance of railway tracks and for the grinding of welds and switches on special, purpose-built machines. They are distinguished by high durability and good grinding effects per time unit without workpiece overheating.

QUALITY	HARDNESS	PROPERTIES	QUALITY CLASS
---------	----------	------------	---------------

12A14-24-B	P-U	Good durability	Standard
ZA14-24-B	P-U	High durability	Special

Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F1	150 x 25 x 20 (16)	50	6400	2
F1-AF	230 x 15 x 25.4 (22.23)		4200	5
F1-AF	230 x 15 x 22.23 (25.4)	63	5250	
F1	230 x 20 x 25.4 (22.23)	50	4200	
F1-AF	230 x 20 x 22.23 (25.4)	63	5250	
F1-AF	254 x 15 x 25.4		4850	
F1	254 x 30 x 25.4	50	3850	2
F1-AF	260 x 15 x 120		3650	5
F1-AF	260 x 15 x 120	63	4650	
F1	260 x 25 x 120	50	3650	2
F1-AF	300 x 25 x 120	63	4050	
F5	254 x 32 x 25.4/152 x 13	50	3850	1
F5	254 x 38 x 25.4/127 x 12		3850	
F5	300 x 40 x 120/230 x 25		3200	
F6-MK	94 x 85 x M20 W21;E20	50	10150	10
F6-MK	100 x 100 x M20 W20;E23		9550	
F6-MK	100 x 110 x M20 W25;E23		9550	
F6-MKKR	152 x 80 x M20(5/8") W50;E18	63	8050	4
F7	135 x 95 x 25.4/2 x 55 x 32.6	50	7100	1
F7	254 x 32 x 25.4/2 x 152 x 13		3850	
F7	254 x 40 x 76/2 x 166 x 10		3850	



M20 nuts can be produced with left or right threads.

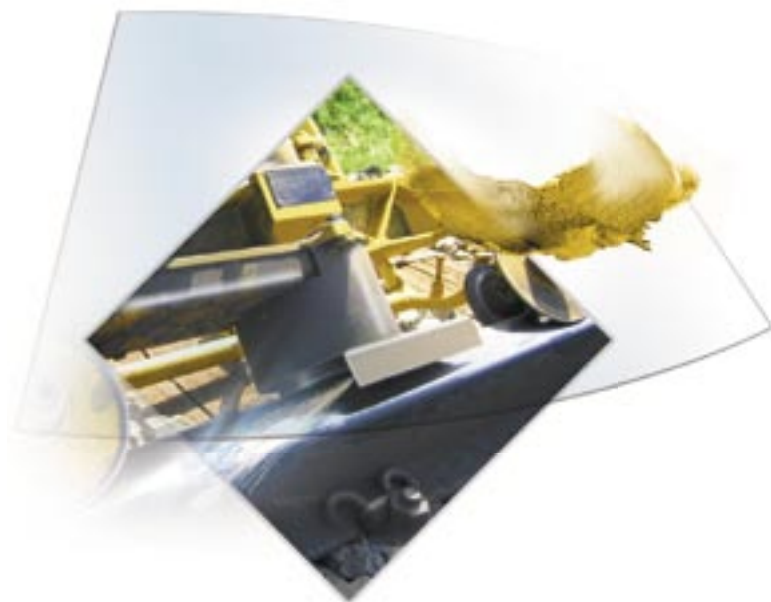
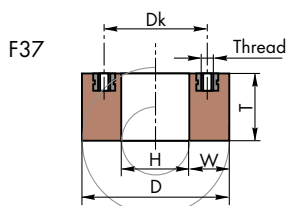
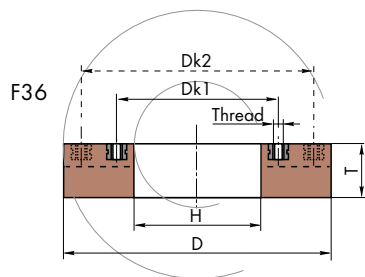
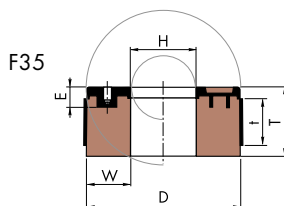


QUALITY HARDNESS PROPERTIES

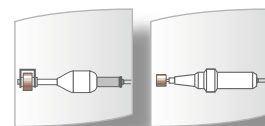
QUALITY CLASS

12A14-24-B	P-U	Good durability, good grinding efficiency and no overheating of workpiece surface	Standard
ZA14-24-B	P-U	Very high durability, high grinding efficiency and no overheating of workpiece surface	Special

Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F35	180 x 105 x 90	50	5350	1
F35	250 x 75 x 150		3850	
F36	250 x 76 x 150 Aluminium flange		3850	
F36	260 x 35 x 195 Aluminium flange		3700	
F37	130 x 60 x 57 (4 x M8/10) Dk=90		7350	
F37	150 x 75 x 57 (4 x M8/15) Dk=90		6400	
F37	152 x 79 x 80 (6 x M8/20) Dk=115			



GRINDING WHEELS



These grinding wheels are intended for use in various branches of industry for **CLEANING OF CASTS** and forged pieces with flat manual grinding machines. They are distinguished by optimal material removal rates and appropriate durability.

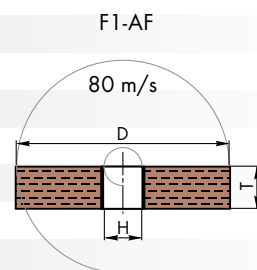
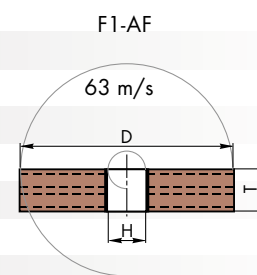
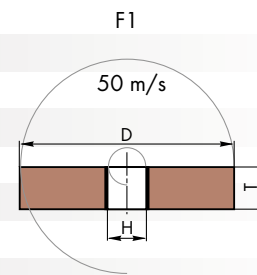
QUALITY	HARDNESS	MATERIAL	QUALITY CLASS
12A24-30-B	P-R	Steel	Standard
127A20-24-B	P-Q	Alloy steel	Standard
47A24-30-B	Q-R	Stainless steel	Special
91C16-24-B	Q-R	Grey cast	Standard

Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F1	75 x 20 x H	50	12750	25
F1-AF	75 x 20 x H	63	16100	
F1-AF	75 x 20 x H	80	20400	
F1	75 x 25 x H	50	12750	
F1-AF	75 x 25 x H	63	16100	
F1-AF	75 x 25 x H	80	20400	
F1	80 x 20 x H	50	12000	
F1-AF	80 x 20 x H	63	15100	
F1-AF	80 x 20 x H	80	19100	
F1	80 x 25 x H	50	12000	
F1-AF	80 x 25 x H	63	15100	
F1-AF	80 x 25 x H	80	19100	
F1	100 x 15 x H	50	9550	
F1-AF	100 x 15 x H	63	12100	
F1-AF	100 x 15 x H	80	15300	
F1	100 x 20 x H	50	9550	
F1-AF	100 x 20 x H	63	12100	
F1-AF	100 x 20 x H	80	15300	
F1	100 x 25 x H	50	9550	
F1-AF	100 x 25 x H	63	12100	
F1-AF	100 x 25 x H	80	15300	
F1	125 x 15 x H	50	7650	
F1-AF	125 x 15 x H	63	9650	
F1-AF	125 x 15 x H	80	12250	
F1	125 x 20 x H	50	7650	10
F1-AF	125 x 20 x H	63	9650	
F1-AF	125 x 20 x H	80	12250	
F1	125 x 25 x H	50	7650	
F1-AF	125 x 25 x H	63	9650	
F1-AF	125 x 25 x H	80	12250	





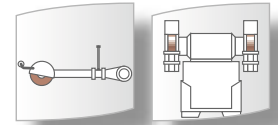
Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F1	150 x 20 x H	50	6400	10
F1-AF	150 x 20 x H	63	8050	
F1-AF	150 x 20 x H	80	10200	
F1	150 x 25 x H	50	6400	
F1-AF	150 x 25 x H	63	8050	
F1-AF	150 x 25 x H	80	10200	
F1	150 x 30 x H	50	6400	
F1-AF	150 x 30 x H	63	8050	
F1-AF	150 x 30 x H	80	10200	
F1	200 x 15 x H	50	4800	
F1-AF	200 x 15 x H	63	6050	
F1-AF	200 x 15 x H	80	7650	
F1	200 x 20 x H	50	4800	
F1-AF	200 x 20 x H	63	6050	
F1-AF	200 x 20 x H	80	7650	
F1	200 x 25 x H	50	4800	
F1-AF	200 x 25 x H	63	6050	
F1-AF	200 x 25 x H	80	7650	
F1	200 x 30 x H	50	4800	
F1-AF	200 x 30 x H	63	6050	
F1-AF	200 x 30 x H	80	7650	
F1	250 x 20 x H	50	3850	
F1-AF	250 x 20 x H	63	4850	
F1-AF	250 x 20 x H	80	6150	
F1	250 x 25 x H	50	3850	
F1-AF	250 x 25 x H	63	4850	
F1-AF	250 x 25 x H	80	6150	



mm
H 6 10 16 20 22.23 25 32



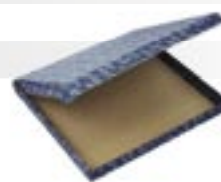
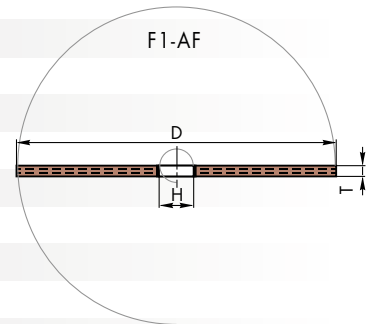
GRINDING WHEELS



These grinding wheels are intended for use in various branches of industry for manual CLEANING OF CASTS on stable grinding machines. They are distinguished by high grinding efficiency and less wear of the grinding wheel on various materials.

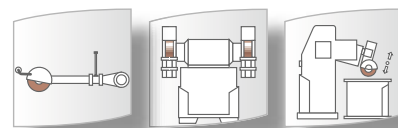
QUALITY	HARDNESS	MATERIAL	QUALITY CLASS
12A24-30-BF	Q-R	Steel	Standard
ZA20-24-BF	Q-R	Alloy steel	Special
47A20-24-BF	Q-R	Stainless steel	Special
128A16-24-BF	Q-R	Grey cast	Standard
417A16-24-BF	Q-R	Nodular alloy	Standard
54A16-24-BF	P-Q	Aluminium and other colour metals	Standard

Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F1-AF	300 x 6 x H	80	5100	2
F1-AF	300 x 8 x H		5100	
F1-AF	300 x 10 x H		5100	
F1-AF	350 x 6 x H		4400	
F1-AF	350 x 8 x H		4400	
F1-AF	350 x 10 x H		4400	
F1-AF	350 x 12 x H	63	3450	
F1-AF	350 x 16 x H		3450	
F1-AF	350 x 20 x H		3450	
F1-AF	400 x 6 x H	80	3850	
F1-AF	400 x 8 x H		3850	
F1-AF	400 x 10 x H		3850	
F1-AF	400 x 12 x H	63	3050	
F1-AF	400 x 16 x H		3050	
F1-AF	400 x 20 x H		3050	
F1-AF	450 x 12 x H		2700	
F1-AF	450 x 16 x H		2700	
F1-AF	450 x 20 x H		2700	
F1-AF	500 x 12 x H		2450	
F1-AF	500 x 16 x H		2450	
F1-AF	500 x 20 x H		2450	
F1-AF	600 x 12 x H		2050	
F1-AF	600 x 16 x H		2050	
F1-AF	600 x 20 x H		2050	



mm

H 22.23 25 32 40 127

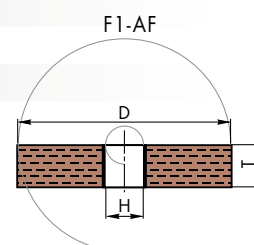
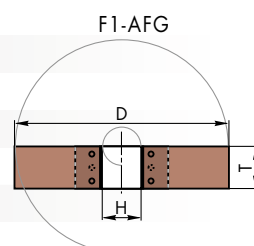
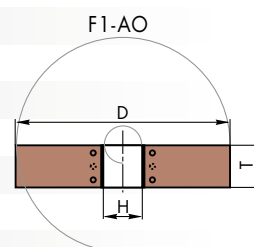


These grinding wheels are intended for use in various branches of industry for COARSE GRINDING on stable, manually operated suspended grinding machines and automatons. They are distinguished by a high grinding efficiency and appropriate durability.

QUALITY	HARDNESS	MATERIAL	QUALITY CLASS
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10A16-24-B	Q-S	Non-alloy and low-alloy steels	Standard
12A16-24-B	Q-R	High-alloy steels	Standard
47A16-24-B	O-R	Stainless steel, high-alloy steel	Special
128A16-24-B	Q-R	Grey and nodular alloy	Standard
417A16-24-B	Q-S	Tempered alloy	Standard
54A16-24-B	Q-R	Aluminium and other colour metals	Standard
ZA14-24-B	Q-S	Stainless steel, steel, alloys	Special

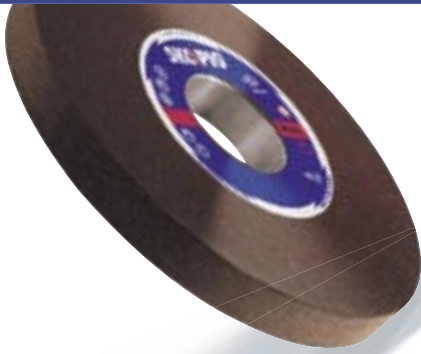
Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F1-AO	300 x 20-50 x H	50	3200	2
F1-AF	300 x 12-50 x H	63	4050	
F1-AF	300 x 12-50 x H	80	5100	
F1-AO	350 x 30-60 x H	50	2750	
F1-AFG	350 x 32-60 x H	63	3450	
F1-AF	350 x 30-60 x H	80	4400	
F1-AO	400 x 30-63 x H	50	2400	
F1-AFG	400 x 40-60 x H	63	3050	
F1-AF	400 x 20-60 x H	80	3850	
F1-AO	450 x 40-63 x H	50	2150	
F1-AFG	450 x 40-63 x H	63	2700	
F1-AF	450 x 40-63 x H	80	3400	
F1-AO	500 x 40-70 x H	50	1950	
F1-AFG	500 x 50-70 x H	63	2450	
F1-AF	500 x 40-60 x H	80	3100	
F1-AO	600 x 40-100 x H	50	1600	
F1-AFG	600 x 60-80 x H	63	2050	
F1-AF	600 x 40-80 x H	80	2550	



D mm							H mm						
300	25.4	30	32	40	50	60	76.2	127					
350			32	40	50	60	76.2	127					
400				40	50	60	76.2	127					
450				40	50	60	76.2	127	150	152.4	200	203	
500					50	60	76.2	127	150	152.4	200	203	250 305
600						60	76.2	127	150	152.4	200	203	250 305



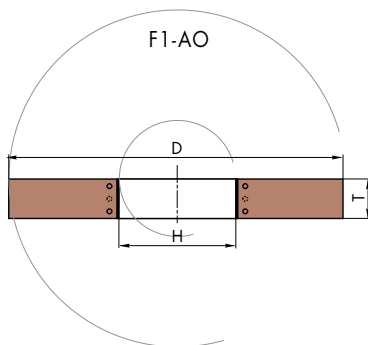
GRINDING WHEELS



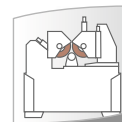
These grinding wheels are intended for CIRCULAR CYLINDRICAL GRINDING. They are distinguished by optimal material removal rates and appropriate surface quality of machined parts.

QUALITY	HARDNESS	MATERIAL	QUALITY CLASS
12A20-36-B	J-L	Hot rolled, hard alloys	Standard
22A24-46-B	J-L	Cold rolled, metal steels	Standard
47A24-60-B	L-O	High-alloy steels stainless steel	Special
C46-60-B	K-L	Cast iron	Standard
90C46-80-B	H-J	Copper	Standard
90C46-B	H	Rubber soft	Standard
22A46-B	J-K	Rubber hard	Standard

Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F1-AO	300 x 30-60 x H	50	3200	1
F1-AO	350 x 30-60 x H		2750	
F1-AO	400 x 30-70 x H		2400	
F1-AO	450 x 40-75 x H		2150	
F1-AO	500 x 40-80 x H		1950	
F1-AO	600 x 40-100 x H		1600	



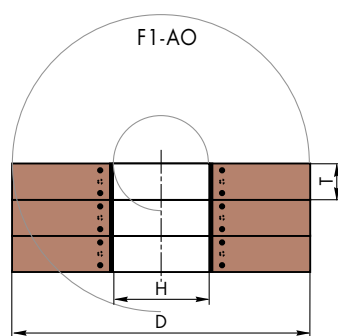
D mm							H mm						
300	32	40	50	60	76.2	80	127						
350	32	40	50	60	76.2	80	127						
400		40	50	60	76.2	80	127	150	152.4	200	203		
450			50	60	76.2	80	127	150	152.4	200	203	250	
500			50	60	76.2	80	127	150	152.4	200	203	250	305
600				60	76.2	80	127	150	152.4	200	203	250	305



These grinding wheels are intended for use in industry for CENTERLESS grinding. They are distinguished by optimal material removal rates and appropriate surface quality of machined parts.

QUALITY	HARDNESS	MATERIAL	QUALITY CLASS
15A46-60-B	O-P	Non-alloy and low-alloy steels	Standard
47A46-60-B	L-N	Inox, high-alloy fast-cutting steels	Special
947C80-100-B	H-J	Steel alloy, magnets	Standard
59C60-80-B	M-N	Stainless steel	Standard
417A46-60-B	M-O	Grey and nodular alloy	Standard
54A46-60-B	K-M	Aluminium and other colour metals	Standard
59C100-150-B	K-M	Ferrites	Standard

Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F1-AO	300 x 30-63 x H	50	3200	
F1-AO	350 x 30-75 x H		2750	
F1-AO	400 x 30-80 x H		2400	
F1-AO	450 x 40-100 x H		2150	
F1-AO	500 x 40-100 x H		1950	
F1-AO	600 x 40-125 x H		1600	



Grinding wheels of thicknesses (T) greater than the values given in the table are composed of several thinner grinding wheels.

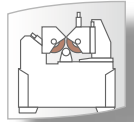
(2x50, 2x63, 2x75, 2x76, 2x80, 2x100, 2x125, 3x105, 3x127, 3x133)

Sample: $600 \times 400 \times 305 = 600 \times (3 \times 133.3) \times 305$

D mm	H mm
300	127
350	127 203
400	203
450	203
500	305
600	305



GRINDING WHEELS



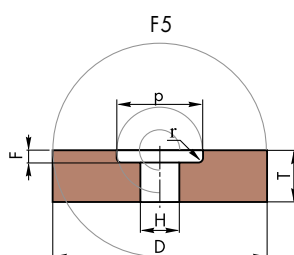
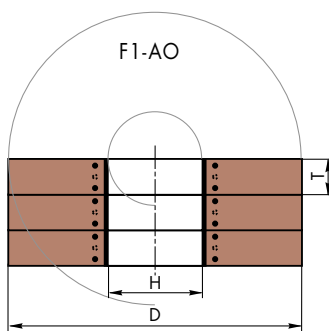
These grinding wheels are intended for use in industry for centerless grinding. They are distinguished by high durability and low wear rates.

QUALITY	HARDNESS	MATERIAL	QUALITY CLASS
11A80-B	T	Steels, alloys	Standard
15A100-B	R-S	Colour metals	Standard

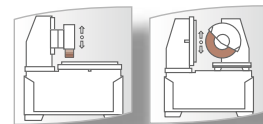
Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F1- AO	200 x 25 - 50 x 76	50	4800	1
F1- AO	250 x 30 - 100 x 76;127		3850	
F1- AO	300 x 40 - 75 x 127		3200	
F1- AO	350 x 40 - 100 x 127;203		2750	

	D	H	p	r	F
F5	200	76.2	114	3.2	*
F5	250	127	160	5.0	*
F5	300	127	190	5.0	*
F5	350	127	190	5.0	*

*as per agreement with customer



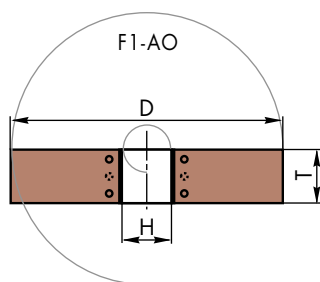
All grinding wheels are also available in F5 or F7 types (required diameter and recess depth must be specified for each order).



These grinding wheels are intended for use in various branches of industry for SURFACE circular cylindrical frontal grinding on various stable grinding machines. When used in manufacture of circular saws and blades for the paper industry, they are distinguished by optimal material removal rates and appropriate surface quality of machined parts.

QUALITY	HARDNESS	MATERIAL	QUALITY CLASS
114A46-60-B	L-M	Non-alloy and low-alloy steels	Standard
42A46-60-B	J-L	Alloy steel	Standard
47A46-60-B	H-J	Stainless high-alloy steel	Special
90C36-60-B	J-K	Grey and nodular alloy	Standard
54A46-60-B	L-O	Aluminium and other colour metals	Standard
95C46-60-B	H-J	Rubber soft	Standard
22A36-46-B	J-K	Rubber hard	Standard

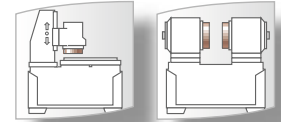
Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Packaging units
F1-AO	300 x 30-60 x H	50	3200	1
F1-AO	350 x 30-60 x H		2750	
F1-AO	400 x 40-70 x H		2400	
F1-AO	450 x 50-75 x H		2150	
F1-AO	500 x 50-80 x H		1950	
F1-AO	600 x 60-100 x H		1600	



D mm							H mm						
300	32	40	50	60	76.2	80	127						
350	32	40	50	60	76.2	80	127						
400		40	50	60	76.2	80	127						
450		40	50	60	76.2	80	127	150	152.4	200	203		
500			50	60	76.2	80	127	150	152.4	200	203	250	305
600				60	76.2	80	127	150	152.4	200	203	250	305



GRINDING WHEELS



Grinding wheels with installed nuts are intended for single or dual-wheel SURFACE grinding of casts in the manufacture of magnets and springs, and for the same type of grinding of casts for the automotive industry on purpose-built stable grinding machines. They are distinguished by optimal material removal rates, high durability and appropriate surface quality of machined parts.

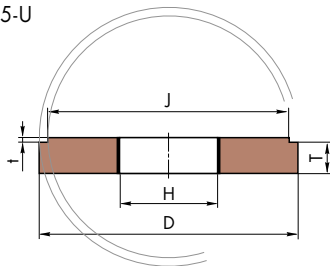
QUALITY	HARDNESS MATERIAL		QUALITY CLASS
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947C36-60-B	G-J	Non- and low-alloy steels, magnets	Standard
147A16-60-B	L-N	Alloy and fast-cutting steels	Standard
417A14-16-B	Q-R	Spring steel, low-alloy steels	Standard
ZA14-24-B	R-S	Stainless steel, steel, alloys	Special
417A16-24-B	P-Q	Grey and nodular alloy	Standard
90C36-60-B	K-L	Aluminium and other colour metals	Standard
90C16-24-B	M-O	Lamellar and brake pads	Standard

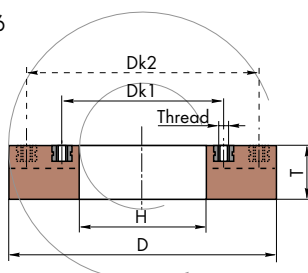
Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Dk1 (mm)/ No. of nuts	Dk2 (mm)/ No. of nuts	Thread	Packaging units
F35-U	450 x 60 x 200/428 x 11	50	2150				1
F36	350 x 90 x 200		2750	280/10	/	M10	
F36	350 x 100 x 255		2750	300/8	/	M12	
F36-AO	450 x 90 x 255	40	1700	375/10	/	M10	
F36-AO	500 x 100 x 350	40	1550	456/24	/	M10	
F36	508 x 102 x 406	50	1900	456/24	/	M10	
F36-AO	600 x 75 x 325	40	1300	530/12	380/6	M16	
F36	600 x 102 x 320	50	1600	530/12	380/6	M16	
F36	600 x 125 x 450		1600	588.8/12	508/6	M10	

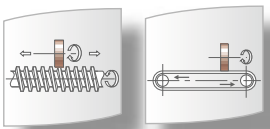


F35-U



F36

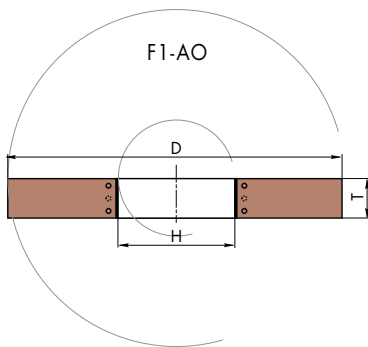
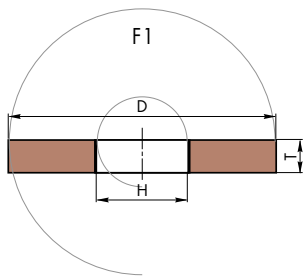




These grinding wheels are intended for SHARPENING blades on paring and splitting machines in the leather industry. They are distinguished by optimal material removal rates and their self-sharpening properties.

QUALITY	HARDNESS	MATERIAL	QUALITY CLASS		
14A46-B	G	Steel	Standard		
14A60-B	M	High-alloy steel	Standard		
38A46-B	E	Stainless high-alloy steel	Standard		

Type	Dimensions D x T x H mm	Peripheral speed m/s	Rpm 1/min	Machine	Packaging units
F1	230 x 38 x 100	50	4200	Paring	
F1	254 x 40 x 127		3850	Splitting	
F1-AO	300 x 40 x 127		3200	Splitting	
F1	350 x 40 x 127	40	2200	Splitting	
F1-AO	350 x 40 x 127	50	2750	Splitting	



ORDER FORM

1. CUSTOMER DATA:

Customer ID: _____

Customer: _____

Address: _____

Phone: _____ Fax: _____ E-mail: _____

Contact person: _____

2. WORKPIECE DATA:

Dimensions: _____

Material: _____ Hardness: _____

Surface quality: _____

Enclosures (design, workpiece): _____

Notes: _____

3. ABRASIVE TOOL DATA:

TOOL MANUFACTURER	SHAPE	DIMENSIONS mm	QUALITY	PER. SPEED m/s	INTERNAL DESIGNATION
_____	_____	_____	_____	_____	_____
_____	_____	_____	_____	_____	_____
_____	_____	_____	_____	_____	_____

The abrasive tool is appropriate: YES ☐ NO ☐ Why not: _____

Enclosures (sample, number of units): _____

Expected annual consumption: _____

Note: _____

4. ABRASIVE TOOL USE:

Machine type: _____ Engine power: _____

Peripheral speed: _____ m/s or _____ rpm

Workpiece speed: _____ Feed: _____

Cutting depth: _____ mm Grinding depth: _____ mm

Cooling: YES ☐ NO ☐ _____

Coolant type: _____

Note: _____

P R O D U C T R A N S A C T I O N E T



RESIN BONDED WHEELS with
silicon carbide and aluminium oxide

FLEXIBLE ABRASIVES from paper,
cloth and non woven materials

VITRIFIED BONDED GRINDING WHEELS
with SiC, Al-oxide and superabrasives

**DIAMOND
DRESSING TOOLS**

RESIN BONDED GRINDING TOOLS
with diamond and CBN grits

**METAL BONDED
diamond cutting-off tools**

**MAGNESITE AND SYNTHETIC BONDED
GRINDING WHEELS** with
silicon carbide and aluminium oxide

**INDUSTRIAL
CLOTH**

**REFRACTORY
PRODUCTS**





FACTORY STORE COMET
Zreče
Tel.: +386 3 7520 050



THE ART OF SPARKS



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