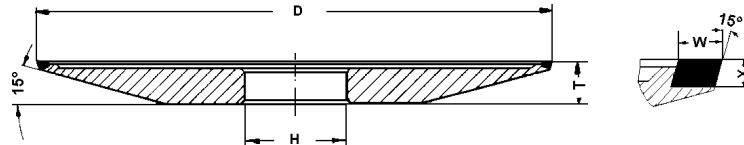


WINTER

Diamond grinding wheels
for automatic circular sawblade
grinding machines >akemat<
Vollmer Werke GmbH, Biberach/Riß



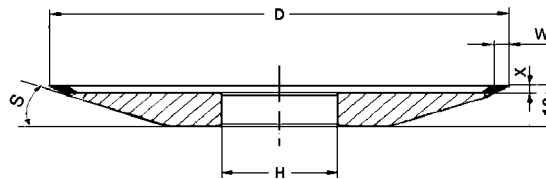
Creep feed grinding



Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 222	- 150 - 3 - 1.5 - 32	D64	K-PLUS 920	C100A	80140197	T = 11.5 1)
5K 222	- 150 - 3 - 2 - 32	D91	K-PLUS 888 TY	C150A	80109360	T = 12 1)

For grinding tooth faces of sawblades with very close pitch.
Machine type: akemat B

1) End of line, replaced by 82179160



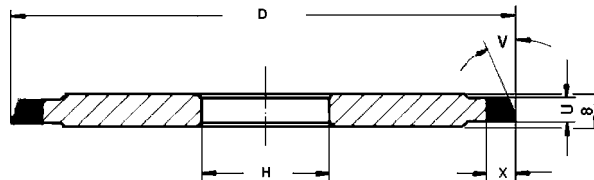
Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
6K 12V2	- 150 - 4 - 2 - 32	D46	K-PLUS 888RY	C125A	82103568	S = 15° 1)
		D46	K-PLUS 921	C125A	82144625	S = 15° *)
		D64	K-PLUS 921	C125A	82137687	S = 15° *)
1K 12V9	- 150 - 2.3 - 4 - 32	-	TIGER	-	82179160	2)
1K 12V9	- 200 - 2.3 - 4 - 32	-	TIGER	-	82176477	2)

For grinding tooth faces of swabblades.
Machine type: akemat B

*) Also suitable for application with oil as cutting fluid

1) End of line, replaced by 82179160

2) For very narrow chip space



Shape	- D - U - X - V° - H	Grit size	Bond	Concentration	ORDER No.	Remarks
2K 14B1	- 127 - 5 - 7 - 15 - 32	D54	K-PLUS 921	C125 A	82105738	*)

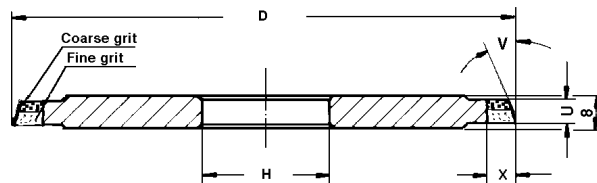
For grinding tooth tops with normal pitch. Allowance > 0,2 mm.
Machine type: akemat B

*) Also suitable for application with oil as cutting fluid

WINTER

Diamond grinding wheels
for automatic circular sawblade
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Creep feed grinding

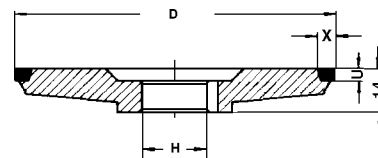


Shape	- D - U - X - V° - - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 14B1	- 127 - 5 - 7 - 5 -2B- 32	D107 D46	K-PLUS 4821	C100 C75H	80149853	1)
1K 14B1	- 127 - 5 - 7 - 15 -2B- 32	D107 D46	K-PLUS 4821	C100 C75A	80126087	2)
		D126 D54	K-PLUS 1313RY	C125 C100A	82141712	3)

For grinding tooth tops with normal pitch. Allowance > 0.2 mm.
Machine type: akemat U

2) End of line, replaced by 80149853
3) Also suitable for carbide/steel combination.

1) WINTER recommendation



Shape	- D - U - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 700	- 76 - 4 - 4.5 - 20	D91	K-PLUS 730-42	C50A	80124742	1)
		D126	K-PLUS 888NY	C75A	80108080	2)
1K 700	- 100 - 4 - 4.5 - 20	D91	K-PLUS 730-42	C50A	80112105	1)
		D126	K-PLUS 888NY	C75A	80106177	3)
2K 700	- 100 - 4 - 6.5 - 20	D126	K-PLUS 888NY	C75A	80102394	4)

1) For grinding tooth flanks (cutting width) For multi-tooth blades with weak core.
Also suitable for application with strong core
2) For multi-tooth sawblades with oil as cutting fluid.
3) For sawblades with strong core.
4) For grinding tooth flanks (cutting width).
All types machine type: akemat F

1) WINTER recommendation