

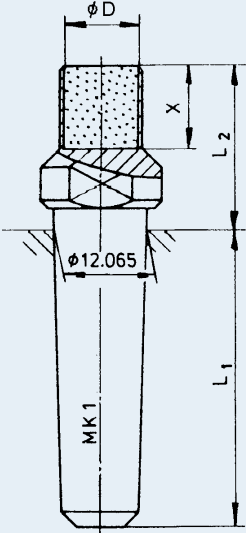
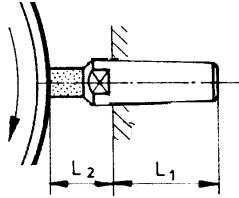
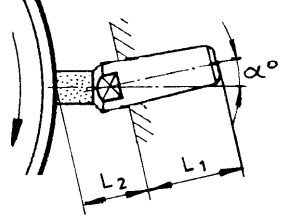
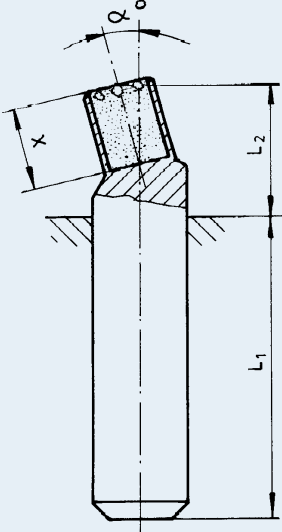
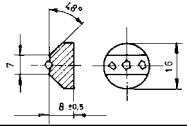
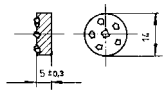
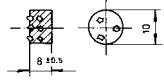
WINTER diamond Igel

Tool specification in four steps

Step 1	Select appropriate Igel size for wheel size																			
IG 2.5-	<p>The graph plots Grinding wheel width [mm] on the y-axis (100 to 500) against Grinding wheel diameter [mm] on the x-axis (100 to 800). Four regions are defined by diagonal lines:</p> <ul style="list-style-type: none"> IG 1: Bottom-left region (width < 100 mm, diameter < 100 mm). IG 2.5: Region between width 100-250 mm and diameter 100-400 mm. IG 3.5: Region between width 250-450 mm and diameter 100-600 mm. IG 5: Top-right region (width > 450 mm, diameter > 600 mm). 				<p>IG 1 = Igel® with diamond content 1ct and active diameter 8mm</p> <p>IG 2.5 = Igel® with diamond content 2.5ct and active diameter 8 mm</p> <p>IG 3.5 = Igel® with diamond content 3.5ct and active diameter 8mm</p> <p>IG 5 = Igel® with diamond content 5ct and active diameter 11mm</p> <p>IG 3 = Igel® set with to specially large diamonds,</p> <p>IG 15 = e.g. for face dressing.</p>															
Step 2	Selection of diamond grit for wheel abrasive																			
D1001-	<table border="1" data-bbox="280 1227 770 1408"> <thead> <tr> <th>Wheel abrasive</th> <th>Diamond grit</th> <th>Old Winter designation</th> </tr> </thead> <tbody> <tr> <td>60 - 80</td> <td>D 711</td> <td>80</td> </tr> <tr> <td>46 - 60</td> <td>D 1001</td> <td>60</td> </tr> <tr> <td>36 - 46</td> <td>D 2240</td> <td>50</td> </tr> <tr> <td>36 - 54</td> <td>D 711</td> <td>70</td> </tr> </tbody> </table>					Wheel abrasive	Diamond grit	Old Winter designation	60 - 80	D 711	80	46 - 60	D 1001	60	36 - 46	D 2240	50	36 - 54	D 711	70
Wheel abrasive	Diamond grit	Old Winter designation																		
60 - 80	D 711	80																		
46 - 60	D 1001	60																		
36 - 46	D 2240	50																		
36 - 54	D 711	70																		
Step 3	Selection of bond for grit type																			
H 710-	<p>Bond: H 710 For fused alumina (Al₂O₃). (old designation N)</p> <p>Bond: H 770 For silicon carbide (SiC). (old designation H)</p>																			
Step 4	Selection of mount “always required”.																			
MK1	<p>Specify depending on machine type, e.g. MK1 or MK0. Straight version or inclined version. For further mounts, see pages 9 and 22.</p>																			
Example	<p>IG 2.5 - 8 - 11 - D1001 - H 710 - MK1-15°</p> <table border="1" data-bbox="248 2033 1441 2101"> <tr> <td>Step 1</td> <td>Dimension see page 13</td> <td>Step 2</td> <td>Step 3</td> <td>Step 4</td> </tr> </table>					Step 1	Dimension see page 13	Step 2	Step 3	Step 4										
Step 1	Dimension see page 13	Step 2	Step 3	Step 4																

WINTER diamond Igel
Full diamond and set version

Order data

Examples:	WINTER diamond Igel, full-diamond version						Holder selection: see page 9
	Shape	D	X	Grit size	Bond & core	Old designation	Holder required
	IG 1	8	4	D2240 D1001 D 711	H710 H770	50/1 60/1 80/1	 $L_2 = X + (6 \dots 11 \text{mm})$  Please state inclination angle α when ordering.
	IG 2.5	8	11	D2240 D1001 D 711	H710 H770	50/2.5 60/2.5 80/2.5	
	IG 3.5 highly concentrated	8	11	D 711	H710	70/3.5	
	IG 5	11	11	D2240 D1001 D 711	H710 H770	50/5 60/5 80/5	
	WINTER diamond Igel, set version						Setting pattern
	IG 3	16	8	D3700	T625	3 (single-layer)	
	IG 6	14	5	D2600	T625	6 (single-layer)	
	IG 6A	10	8	D2600	T625	6A (double-layer)	
Other dimensions and specifications on request. Drawing needed for special versions. Order example: IG 1-8-4 / MK1-40-G / D1001 / H710 IG 3-16-8 / Z11-50-15° / D3700 / T625							