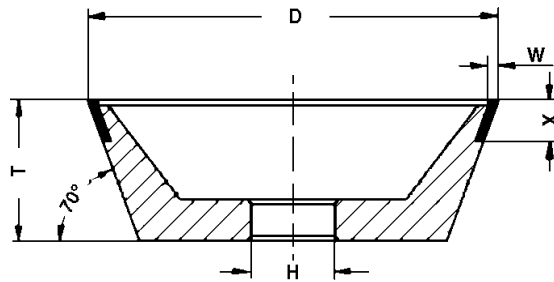


## Grinding wheel shape according to FEPA 11V9 - Diamond grinding wheels



Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
K 11V9	- 75 - 1.5 - 10 - 20	D64	K-plus 888RY	C75 D	82152921	T=30
K 11V9	- 75 - 2 - 10 - 20	D15C D46 D64 D91 D126	K-plus 888R K-plus 888R K-plus 888R K-plus 888R K-plus 888R	C50 H C75 D C75 D C75 D C75 D	82013375 82036507 82009328 80107927 80117160	T=30
K 11V9	- 100 - 2 - 10 - 20	D15A D46 D64 D91 D126 D126 D151	K-plus 777R K-plus 1414N K-plus 888R K-plus 888R K-plus 1414J K-plus 888R K-plus 1410	C75 H C75 D C75 D C75 D C75 D C75 D C75 D	82008521 82112679 80102564 80116983 82004763 80100036 82152923	T=35 *) *)
K 11V9	- 100 - 3 - 10 - 20	D46 D64 D91 D126 D126 D151	K-plus 1414N K-plus 888R K-plus 888R K-plus 1414N K-plus 888R K-plus 1410	C75 D C75 D C75 D C75 D C75 D C75 D	80116780 80116067 80135264 80137905 80105050 82152924	*) T=35 *)

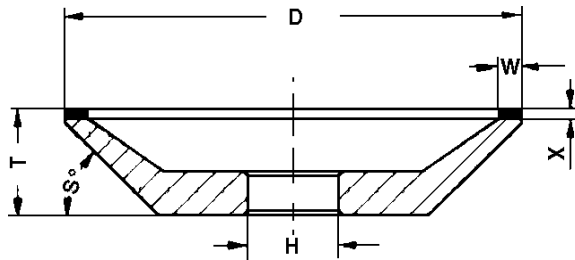
### Application

For grinding single- and multi-edge solid carbide and carbide-tipped tools, for example 1<sup>st</sup> and 2<sup>nd</sup> relief and faces (straight and helical)

Suitable for use on all universal tool and cutter grinding machines, in dry and wet grinding. Also for engraving tool grinding machines (see also page 24).

\*) K-plus 1414J and K-plus 1414N are especially suited if grinding also includes proportions of shank material and brazing material (cool grinding).

## Grinding wheel shape according to FEPA 12A2 - Diamond grinding wheels



Shape - D - W - X - S° - H	Grit size	Bond	Concentration	ORDER No.	Remarks
<b>1K 12A2 - 75 - 3 - 4 - 45 - 20</b>	D7	K-plus 730	C50 B	<b>80130160</b>	T=24
	D15B	K-plus 777J	C50 B	<b>80118846</b>	
	D46	K-plus 888J	C75 B	<b>80130152</b>	
	D64	K-plus 888J	C75 B	<b>80130177</b>	
	D126	K-plus 888R	C75 A	<b>80130200</b>	
<b>K 12A2 - 100 - 5 - 2 - 45 - 20</b>	D46	K-plus 888N	C50 H	<b>80124297</b>	T=25
	D91	K-plus 888R	C50 H	<b>80130185</b>	
<b>K 12A2 - 100 - 10 - 2 - 45 - 20</b>	D64	K-plus 888J	C50 H	<b>80103617</b>	T=25
	D126	K-plus 888J	C50 H	<b>80103666</b>	
<b>K 12A2 - 100 - 10 - 4 - 45 - 20</b>	D126	K-plus 888N	C75 H	<b>80120473</b>	T=27
<b>K 12A2 - 125 - 6 - 2 - 45 - 20</b>	D46	K-plus 888R	C50 H	<b>80103828</b>	T=25
	D91	K-plus 888R	C50 H	<b>80103836</b>	
	D126	K-plus 888R	C50 H	<b>82152925</b>	
<b>K 12A2 - 125 - 12,5 - 2 - 45 - 20</b>	D64	K-plus 888J	C38 H	<b>80104281</b>	T=25
	D64	K-plus 888J	C50 H	<b>80104135</b>	
	D91	K-plus 888J	C50 H	<b>80104184</b>	
	D126	K-plus 888J	C50 H	<b>80104192</b>	
<b>K 12A2 - 150 - 15 - 2 - 45 - 20</b>	D91	K-plus 777N	C50 H	<b>80107610</b>	T=25

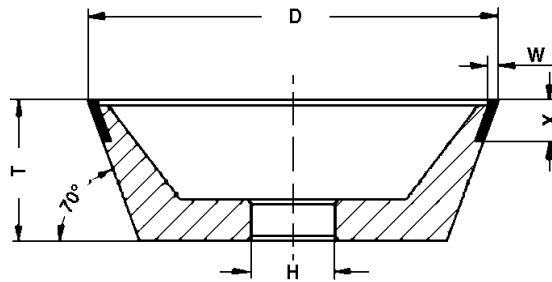
### Application

For grinding single- and multi-edge solid carbide and carbide-tipped tools, for example reamers, engraving tools, turning tools.

Suitable for use on all universal tool and cutter grinding machines, in dry and wet grinding.

## Grinding wheel shape according to FEPA

### 11V9 - Diamond grinding wheels



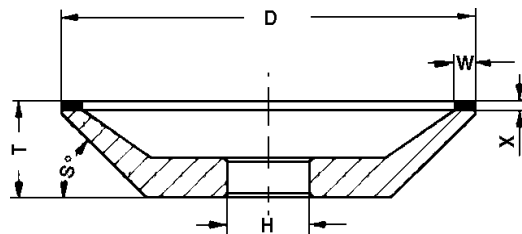
Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
<b>M 11V9</b>	<b>-95.3- 3.2 - 9.3 - 20</b>	<b>D91</b>	<b>M-plus 789</b>	<b>C50 D</b>	<b>80106096</b>	<b>T=35</b>
		<b>D126</b>	<b>M-plus 789</b>	<b>C50 D</b>	<b>80106103</b>	
		<b>D126</b>	<b>M-plus 789</b>	<b>C75 D</b>	<b>80106111</b>	
<b>M 11V9</b>	<b>-125- 3 - 10 - 20</b>	<b>D126</b>	<b>M-plus 789</b>	<b>C75 D</b>	<b>80147828</b>	<b>T=40</b>

**Application**

For grinding multi-edge carbide-tipped tools with up to 50% shank material.  
For use on all universal tool and cutter grinding machines and engraving tool grinding machines. For dry and wet grinding.  
Well suited for creep-feed grinding, e.g. for halving of engraving tools.

## Grinding wheel shape according to FEPA

### 12A2 - Diamond grinding wheels



Shape	- D - W - X - S° - H	Grit size	Bond	Concentration	ORDER No.	Remarks
<b>M 12A2</b>	<b>- 75 - 3 - 4 - 45 - 20</b>	<b>D91</b>	<b>M-plus 789</b>	<b>C50 A</b>	<b>80106030</b>	<b>T=24</b>
<b>M 12A2</b>	<b>- 100 - 6 - 4 - 45 - 20</b>	<b>D91</b>	<b>M-plus 789</b>	<b>C50</b>	<b>80106071</b>	<b>T=27</b>
		<b>D126</b>	<b>M-plus 789</b>	<b>C50</b>	<b>80106088</b>	

**Application**

For grinding multi-edge carbide-tipped tools with up to 50% shank material.  
For use on all universal tool and cutter grinding machines and engraving tool grinding machines. For dry and wet grinding.  
Well suited for creep-feed grinding, e.g. for halving of engraving tools.