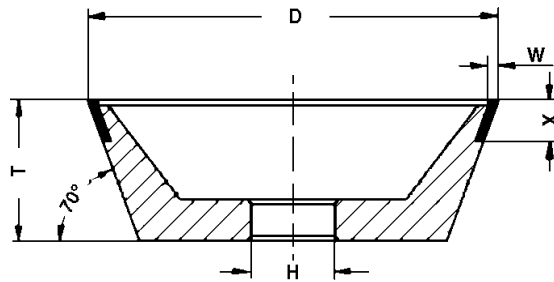


Grinding wheel shape according to FEPA
11V9 - Diamond grinding wheels



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 *)

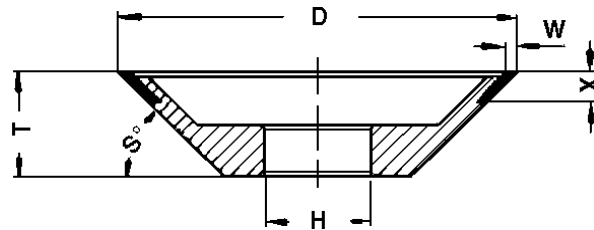
Application

For grinding single- and multi-edge solid carbide and carbide-tipped tools, for example 1st and 2nd 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
12V9 - Diamond grinding wheels



Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
2K 12V9	- 75 - 2 - 10 - 20	D15C	K-plus 777N	C75 H	82121943	T=25 S°=45°
		D46	K-plus 888R	C75 D	82043662	
		D64	K-plus 888R	C75 D	80123357	
		D91	K-plus 888R	C75 D	82152926	
		D126	K-plus 888R	C75 D	80123365	
5K 12V9	- 100 - 2 - 10 - 20	D46	K-plus 888R	C75 D	82131121	T=25 S°=45°
		D64	K-plus 888R	C75 D	80123381	
		D91	K-plus 888R	C75 D	82152927	
		D126	K-plus 888R	C75 D	80123398	
3K 12V9	- 100 - 3 - 6 - 20	D91	K-plus 888R	C75 A	82003450	T=20 *) S°=30°

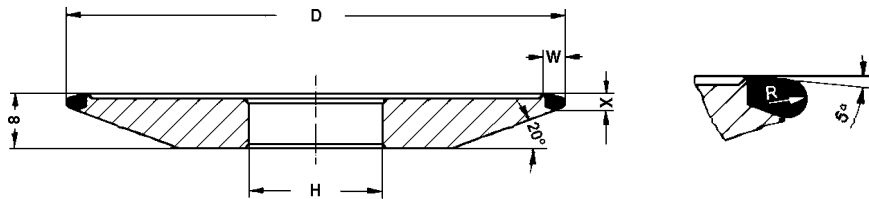
Application

For grinding single- and multi-edge solid carbide and carbide-tipped tools, e.g. relief, and for thinning (straight and helical).

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

*) Suitable for close-pitch tools.

Grinding wheel shape
700 - Diamond grinding wheels
(not FEPA Standard)



Shape	- D - U - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 700	- 75 - 2.2 - 3 - 20	D126	K-plus 888R	C100 A	80122725	R=1
1K 700	- 100 - 2.2 - 3 - 20	D151	K-plus 1414R	C100 A	80116278	R=1
1K 700	- 100 - 4.4 - 5 - 20	D126	K-plus 888R	C100 A	80116091	R=2

Application
For grinding helical-fluted carbide tools, e.g. on NC controlled tool and cutter grinding machines. Reciprocating and creep-feed grinding. See also page 8 (12V9 wheels).

Grinding wheel shape
700 - CBN grinding wheels
(not FEPA Standard)

Shape	- D - U - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 700	- 75 - 2.2 - 3 - 20	B126 B151	KSS 10N KSS RY	V180 A V240 A	80142035 82002054	R=1 R=1
1K 700	- 100 - 2.2 - 3 - 20	B126	KSS 10N	V180 A	80142043	R=1
1K 700	- 100 - 3.5 - 4 - 20	B151 B151	KSS 10N KSS RY	V240 A V240 A	82014785 82001256	R=2 R=2
1K 700	- 100 - 4.4 - 5 - 20	B126 B181	KSS 920 KSS 007N	V180 A V180 D	80146548 80108778	R=2 R=2
1K 700	- 125 - 4.4 - 5 - 20	B126 B181	KSS 920 KSS 007N	V180 A V180 D	80146556 80108948	R=2 R=2

Application

For grinding helical-fluted HSS tools, e.g. on NC controlled tool and cutter grinding machines. Reciprocating and creep-feed grinding. Very suitable for relief grinding. See also page 8 (12V9 wheels).