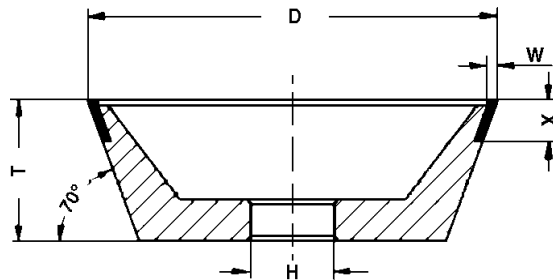


Grinding wheel shape according to FEPA 11V9 - CBN grinding wheels



Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
K 11V9	- 75 - 2 - 10 - 20	B126 B181	KSS 10N KSS 007N	V180 D V180 D	80129465 80111288	T=30 *)
K 11V9	- 75 - 3 - 10 - 20	B126	KSS 10N	V180 D	80129813	T=30
K 11V9	- 100 - 2 - 10 - 20	B91 B126 B126 B151 B181 B181	KSS 12N KSS 10N KSS 007N KSS 1065V-63 KSS 007N KSS 007N-63	V180 D V180 D V180 D V180 H V180 D V180 D	82039181 80114900 80138342 82153025 80141096 80102572	T=35 *)
K 11V9	- 100 - 3 - 10 - 20	B126	KSS 10N	V180 D	80110242	T=35
K 11V9	- 125 - 2 - 10 - 20	B181	KSS 007N D	V180 D	80142084	*) T=40

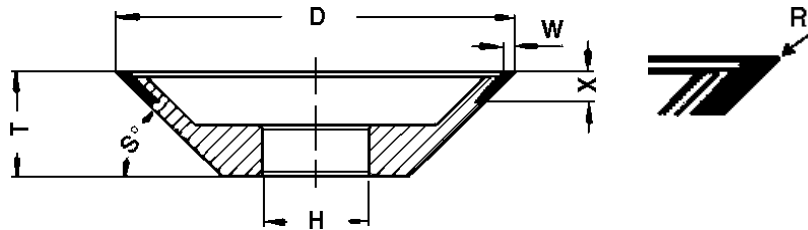
Application

For grinding single- and multi-edge HSS 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.

*) KSS 007N for high material removal rate at $v_c > 30$ m/s
Infeed $a_e = 0.05 \dots 0.15$ mm

Grinding wheel shape according to FEPA 12V9 - CBN grinding wheels



Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
7K 12V9	- 50 - 2 - 6 - 20	B126	KSS 10N	V180 D	80108631	T = 16 S = 45°
2K 12V9	- 75 - 2 - 10 - 20	B126	KSS 10N	V180 D	80123332	T = 25 S = 45°
3K 12V9	- 75 - 3 - 6 - 20	B181	KSS 007N	V180 D	80146523	T = 20 *) S = 45° R=1
6K 12V9	- 75 - 3 - 6 - 20	B181	KSS 007N	V180 H	80148095	T = 20 *) S = 35° R=1
K 12V9	- 100 - 2 - 6 - 20	B126	KSS 10N	V180 D	80137898	T = 35 S = 45°
5K 12V9	- 100 - 2 - 10 - 20	B126	KSS 10N	V180 D	80123340	T = 25 S = 45°
6K 12V9	- 100 - 3 - 6 - 20	B181	KSS 007N	V180 D	80144400	T = 20 *) S = 45° R=1
7K 12V9	- 100 - 3 - 6 - 20	B181	KSS 007N	V180 A	80123835	T = 20 *) S = 35° R=1
1K 12V9	- 100 - 3 - 15 - 20	B151	KSS 007N-63	V180 H	80113515	T = 22 *) S = 45°
3K 12V9	- 125 - 3 - 6 - 20	B181	KSS 007N	V180 D	80146531	T = 25 *) S = 45° R=1
K 12V9	- 125 - 3 - 10 - 20	B151	KSS 007N-63	V180 D	82094120	T = 40 *) S = 45°

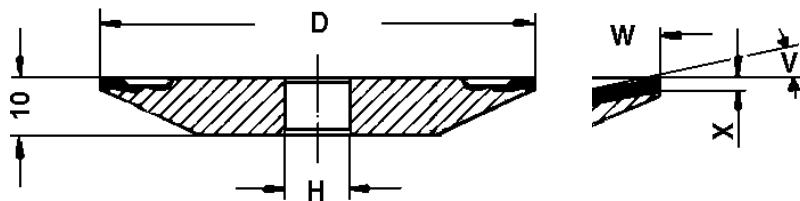
Application

For grinding single- and multi-edge HSS tools, for example relief, and for thinning (straight and helical).

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

*) KSS 007N for high material removal rate at $v_c > 30$ m/s
Infeed $a_e = 0.05 \dots 0.15$ mm

Grinding wheel shape according to FEPA
4V4 - Diamond grinding wheels



Shape - D - W - X - V° - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 4V4 - 100 - 6 - 1 - 10 - 20	D54	K-plus 888NY	C75 H	82100667	

Application
For grinding relief of straight, close-fluted solid carbide milling cutters.

Grinding wheel shape according to FEPA
4V4 - CBN grinding wheels

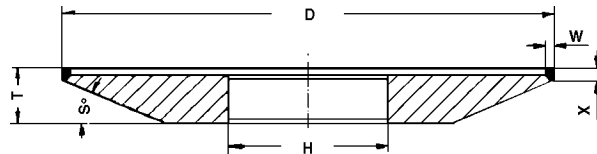
Shape - D - W - X - V° - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 4V4 - 100 - 6 - 1 - 10 - 20	B151	KSS TY	V180 A	80144425	

Application
For grinding relief of straight, close-fluted HSS milling cutters.

Grinding wheel shape

222 - CBN grinding wheels

(not FEPA Standard)



Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 222	- 150 - 2 - 3.3 - 50.8	B151	KSS RY	V300 A	80137321	bis Modul 6 T=17 S°=20°
1K 222	- 200 - 2 - 3.3 - 50.8	B151	KSS RY	V300 A	80137338	bis Modul 12 T=22 S°=23°

Application

For creep-feed and reciprocating grinding of relief of straight helical hobs.
Creep-feed grinding with intensive cooling.

Suitable for use on hob grinders, e.g. KAPP or KLINGELNBERG.