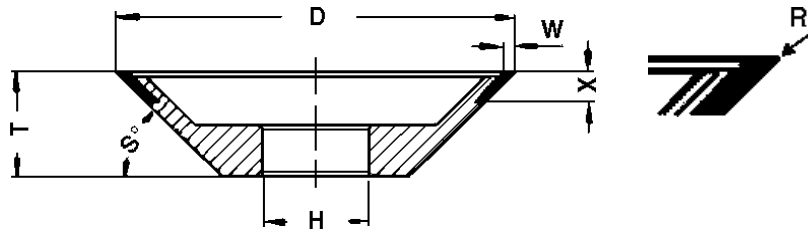


Grinding wheel shape according to FEPA 12V9 - CBN grinding wheels



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