

Application recommendation



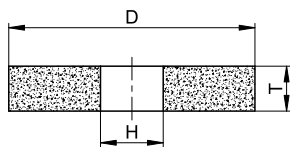
Specification	Aluminium	Non and low-alloyed steels		High-alloyed steels		HSS	INOX	Tungsten carbide	Industrial ceramics	Cast iron	Dry grinding	Wet grinding	Page
		Unhardened Hardened	Unhardened Hardened										
C		●	●	●	●	●	●	●			●		266
C	●	●	●	●	●	●	●	●	●	●	●		267

Application tips

- Polishing steel, nonferrous heavy metal, precious metal and sintered metal or plastic (C240-BE15)
- Fine grinding of various precision mechanical components, like watches, glasses, medical technology (C150-BE13)
- Effect grinding (C46-BE16 and C46-BE19F)
- Deburring (C80-BE15)
- Whetting of all kinds of kitchen and pocket knives (C400-BE15)

- Not suitable for sharp edges, large burrs or high stock removal
- For whetting, deburring and sharpening knives, splitting tools and axes (C400-BE15)
- Dressing stone (ceramic bond) for elastic grinding wheels (see chapter “Dressing and sharpening”)
- $V_s = 16\text{--}32$ m/s maximum operating speed for floor-stand grinding

Shapes



Shape 1

- Extremely suitable
- Limited suitability

Precision grinding

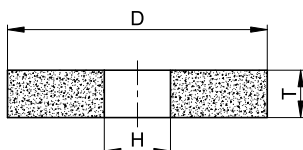
Sharpening wheel for cutting tool

For steel, HSS, stainless steel and tungsten carbide



Specification	Aluminum	Non and low-alloyed steels		High-alloyed steels		HSS	INOX	Tungsten carbide	Industrial ceramics	Cast iron	Dry grinding	Wet grinding
		Unhardened	Hardened	Unhardened	Hardened							
C		●	●	●	●	●	●	●			●	

Recommended stock type



Shape 1

This product was specially developed for sharpening whittlers. Its grit size and tailored bond system enable you to achieve particularly cool grinding. Its fine surface improves the cutting ability and lifetime of the cutting tools.

Ensure that you pay attention to the direction of rotation of the wheel when in use. **The sharpening wheel must always move away from the cutting edge. In addition, the wheel flange diameter must be at least two thirds of the wheel diameter.**

	Shape	Type no.	DxTxH	Specification	Vmax m/s	Degree of hardness	Comments
	1	10016	125x20x32	C 800-BE11	25	Medium	Sharpening of whittlers
		7133	125x25x20	C 800-BE11	25	Medium	
		2540	125x25x32	C 800-BE11	25	Medium	
		669110	150x20x20	C 800-BE11	25	Medium	
		7204	150x20x32	C 800-BE11	25	Medium	
		669109	175x20x32	C 800-BE11	25	Medium	

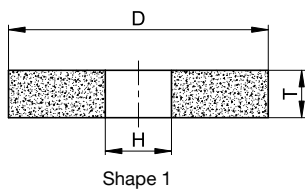
Fine grinding and polishing wheels

For steel, HSS, stainless steel, tungsten carbide and cast iron



Specification	Aluminium	Non and low-alloyed steels		High-alloyed steels		HSS	INOX	Tungsten carbide	Industrial ceramics	Cast iron	Dry grinding	Wet grinding
		Unhardened	Hardened	Unhardened	Hardened							
C	●	●	●	●	●	●	●	●	●	●	●	●

Recommended stock type



The soft elastic specification of this wheel means it perfectly follows the contours of the workpiece and does not alter the surface geometry. It can be used for polishing, fine grinding, effect grinding, deburring, matting and whetting. However, it is not suitable for large burrs or high stock removal rates.

	Shape	Type no.	DxTxH	Specification	Vmax m/s	Degree of hardness	PU	Comments	
	1	19435	125x20x20	C 400-BE15	20	Medium	1	Sharpening of kitchen knives	
		7203	150x20x32	C 400-BE15	20	Medium	1		
		22411	200x25x32	C 400-BE15	20	Medium	1		
		802276		150x10x25	C 150-BE13	16	Soft	5	Surface improvement on pre-ground workpieces (low stock removal)
		2661		150x20x20	C 150-BE15	20	Medium	1	
		71212		150x20x20	C 400-BE16	32	Hard	1	
		7186		150x20x20	C 80-BE15	20	Medium	1	
		22257		150x20x32	C 150-BE16	32	Soft	1	
		320369		200x25x20	C 240-BE15	20	Medium	1	
		7362		200x25x20	C 80-BE15	20	Medium	1	
		32765		200x25x32	C 150-BE15	20	Medium	1	

Precision grinding