

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								
89A			●		●	●					●		289, 290
91A						●					●		290
454A					●	●					●		289
C								●			●		291
AMIGO, B			●		●	●					●		292, 293, 294
DIAGO, D								●			●		295, 296

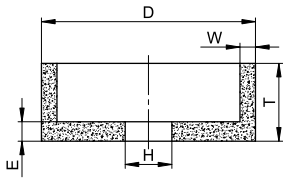
Application tips CBN

Recommended operating speed for cemented carbide:
16–22 m/s

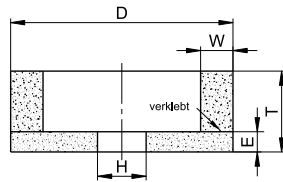
Recommended operating speed for HSS: 20–25 m/s

● Extremely suitable

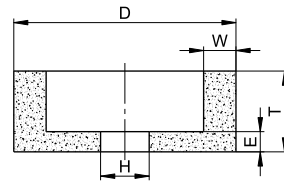
Shapes



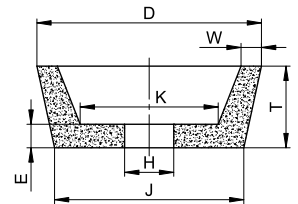
Shape 6



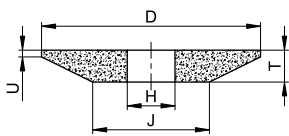
Shape 6BS



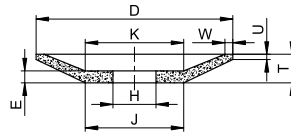
Shape 6BB



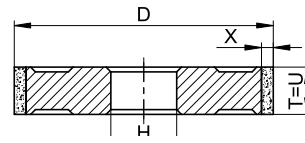
Shape 11



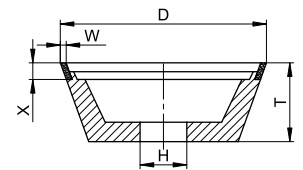
Shape 3



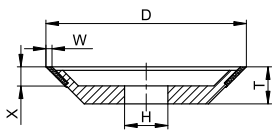
Shape 12



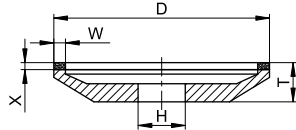
Shape 1A1



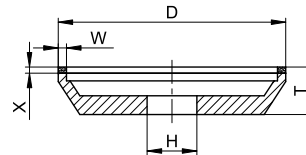
Shape 11V9



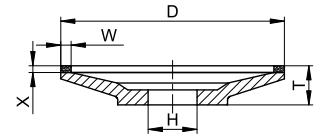
Shape 12V9



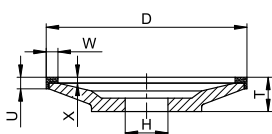
Shape 12A2



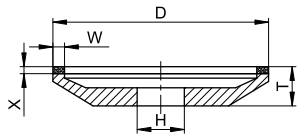
Shape 12A2D



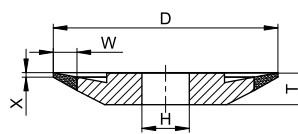
Shape 12A2F



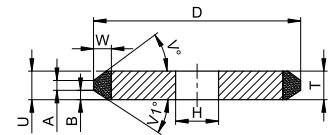
Shape 12C2F



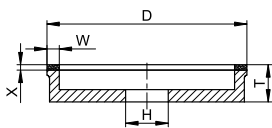
Shape 4C2



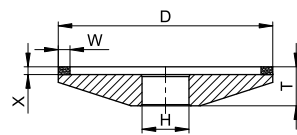
Shape 4BT9



Shape 1BM1



Shape 6A2



Shape 4A2

Precision grinding

Conventional ceramic for dry grinding

For non and low-alloyed steels, high-alloyed steels and HSS.



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							
89A			●		●	●					●	
91A						●					●	
454A					●	●					●	

Recommended stock type

Shape 6

Shape 6BS

Shape 11

Shape 3

Shape 12

With this tool you can grind all cutting tools for the wood and metal industry and a range of shear blades. These products are disc and cup wheels with fused white aluminium oxide or sintered aluminium oxide mixtures that are used in dry grinding.

The tailored specification of this tool prevents discolouration on the workpieces.

Precision grinding



	Shape	Type no.	DxTxH	W/E	Specification	Comments	
	6	34048152	80x40x20	W6/E10	454A 801 N5 V3 U5	With peripheral impregnation	
		455038	80x40x20	W6/E8	454A 901 M5 V3 U5		
		34048027	100x50x20	W10/E10	454A 801 K5 V3 U5		
	6	34924	100x50x20	W10/E10	89A 462 K5A V53		
		19040	100x50x20	W8/E10	89A 542 I5A V53		
		5886	100x50x20	W10/E10	89A 60 J5A V53		
		5887	100x50x20	W10/E10	89A 60 K5A V53		
		49273	100x50x20	W10/E10	89A 60 M5A V53		
		9627	100x50x20	W10/E10	89A 80 I7A V53		
		568265	100x50x20	W10/E10	89A 80 I7A V53 U5		With peripheral impregnation
		5889	100x50x20	W10/E10	89A 80 J5A V53		
		8641	100x50x20	W10/E10	89A 80 K5A V53		
		54820	100x50x20	W10/E10	89A 80 L5 V55		
		131991	125x50x32	W13/E13	89A 60 K5 V53		





	Shape	Type no.	DxTxH	W/E	Specification	Comments
	6	451151	125x63x20	W8/E13	89A 542 I5A V53	
		78847	150x50x32	W12/E15	89A 60 K5 V53	
		77824	150x60x50	W15/E15	89A 36 H7 V217	
		84809	150x70x28	W17/E16	89A 36 H8 V217	
		91350	150x76x28	W17.5/E16	89A 46 J8 V217	
		186445	150x80x32	W10/E16	89A 60 J5A V217	
		365824	150x80x50	W10/E16	89A 461 H7A V53	
		54119	175x75x76.2	W17.5/E17	89A 36 J8 V217	
		126245	175x75x78	W15/E18	89A 36 H7A V217	
		712490	175x75x78	W15/E18	89A 36 J10A V237 P22	
		91441	175x75x78	W15/E18	89A 46 H7 V217	
		587026	175x80x32	W13/E20	89A 46 G10A V217	
		210314	200x80x35	W20/E20	89A 46 J8A V53	
		70128	200x80x78	W20/E20	89A 36 H7 V217	
		798715	200x80x78	W20/E20	89A 36 J10A V237 P22	
5843	80x40x20	W6/E10	89A 60 K5A V53			
	6	122989	100x50x20	W10/E10	91A 80 L5A V217	
		438088	150x63x32	W15/E16	91A 46 G9A V217 P3	
		75803	165x60x32	W15/E15	91A 46 G9A V217 P3	
	6BS	70092	200x100x51	W25/E25	89A 36 I8A V217	
	11	334166	80/57x32x20	W6/E8/K46	89A 1002 H5A V53	
		338237	80/57x32x20	W6/E8/K46	89A 601 K5A V53	
		4917	100/71x40x20	W8/E10/K56	89A 462 J5A V53	
		4924	100/71x40x20	W8/E10/K56	89A 601 K5A V53	
		631057	100/71x40x32	W8/E10/K56	89A 601 J5A V53	
		63195	100/80x50x32	W9/E13/K67	89A 60 K5 V53	
		31675	125/96x40x20	W8/E10/K81	89A 462 K5A V53	
		331500	125/96x40x32	W8/E10/K81	89A 601 J5A V53	
		203176	150/114x50x32	W10/E13/K96	89A 462 I5A V53	
		498229	150/114x50x32	W10/E13/K96	89A 601 J5A V53	



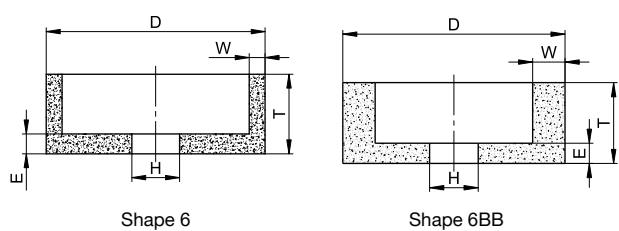
	Shape	Type no.	D/JxT/UxH	W/E/K	Specification
	3	31009	150/75x8/2x20		89A 601 J5A V53
	12	9398	150/75x16/3x20	W10/E10/K85	89A 601 J5A V53
		19659	100/50x13/3x20	W5/E7/K50	89A 601 K5A V53
		216789	125/63x13.3/3x20	W6/E7/K63	89A 461 J5A V53
		364685	125/63x13/3x20	W6/E7/K63	89A 601 I5A V53
		9833	175/85x18/3x20	W10/E10/K85	89A 601 I5A V53

Conventional ceramic for dry grinding For tungsten carbide





Specifica- tion	Alumin- ium	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



This silicon carbide wheel is a cost-effective variant for machining tungsten carbide for secondary applications. It is primarily used for working on castings and nonferrous metals.

It is ideally suited to grinding mining drills and re-sharpening tools in stone-masons' workshops.

	Shape	Type no.	DxTxH	W/E	Specification	Comments
	6	139155	100x50x20	W10/E10	C 80 I5 V15	For HM and coated tools
	6BB	24299	127x63x32	W22.5/E13	C 46 J5 V15	For mining drill grinding machines
		108479	200x100x32	W25.5/E20	C 46 J5 V15	

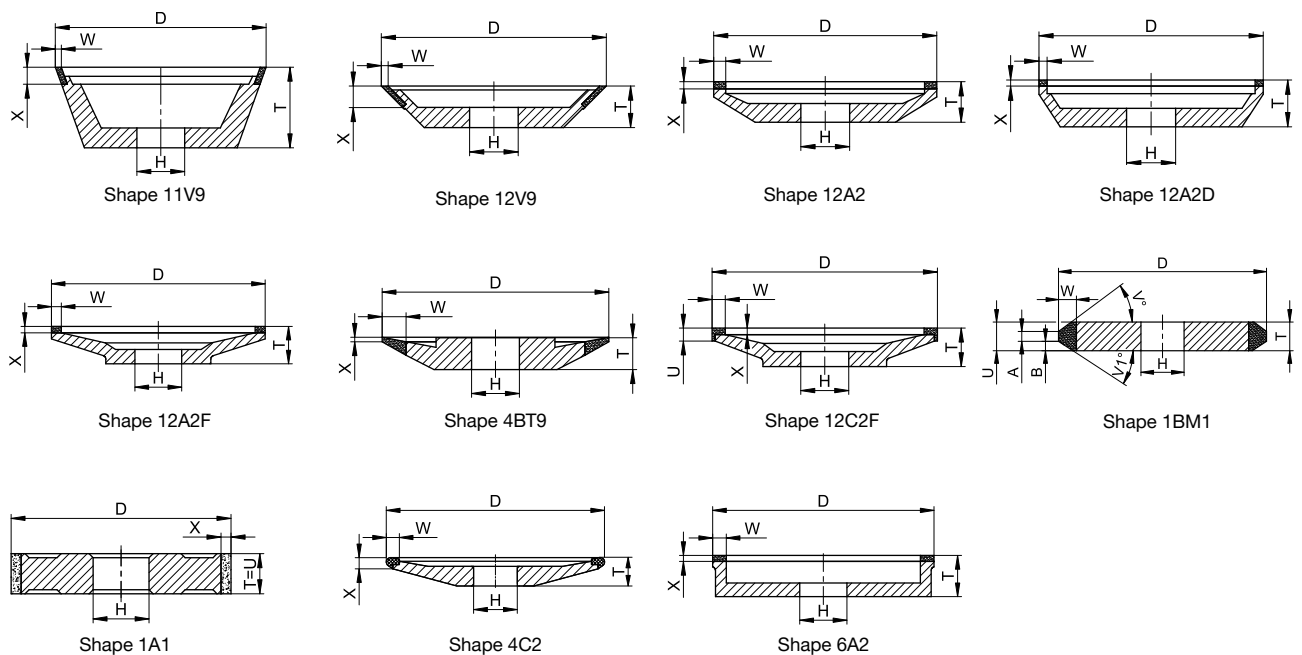
CBN resin-bonded for dry grinding

For non and low-alloyed steels, high-alloyed steels and HSS



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							
AMIGO, B			●			●					●	

Recommended stock type



With this tool you can grind all cutting tools for the wood and metal industry and a range of shear blades. These products are disc and cup wheels in the CBN grit size range B181 - B91.

Compared to conventional aluminium oxide wheels, CBN wheels exhibit significantly less wear and higher dimensional accuracy.

Shape	Type no.	DxTxH	W-X	Specification	Comments	
	11V9	640777	75x30x20	2-10	51B 126 C75 B AMIGO	
		644532	125x40x20	2-10	51B 91 C75 B AMIGO	
		641854	125x40x20	2-10	51B 126 C75 B AMIGO	
		649723	100x35x32	2-10	51B 126 C75 B AMIGO	
		666288	100x35x20	2-10	51B 181 C75 B AMIGO	
		644514	100x35x20	2-10	51B 91 C75 B AMIGO	
		617388	100x35x20	2-10	51B 126 C75 B AMIGO	
		636398	100x35x20	3-10	51B 126 C75 B AMIGO	
		561391	100x35x20	2-10	51B 151 C75 B 53 BG	Long-life B53



Precision grinding






Recommended stock type

	Shape	Type no.	DxTxH	W-X	Specification	Comments
	12V9	703242	75x20x20	2-6	51B 126 C75 B AMIGO	
		636658	100x20x20	2-10	51B 126 C75 B AMIGO	
		840506	125x25x20	2-10	51B 126 C75 B AMIGO	
	12A2	124644	150x18x20	5-3	51B 126 C50 B 75 AL	
		436484	150x18x20	5-2	51B 126 C50 B 75 AL	
		337051	150x18x20	4-3	51B 126 C75 B 54 AL	
		649692	175x20x20	6-2	51B 151 C75 B 45 AL	
	12A2D	217976	100x25x20	6-2	51B 126 C50 B 54 AL	
		666137	100x25x20	6-3	51B 126 C50 B 54 AL	
	12A2F	69502	125x23x20	5-4	51B 126 C50 B 75 AL	
	4BT9	119325	100x10x20	10-1	51B 126 C75 B 75 AL	
	Shape	Type no.	DxTxH	W/U-X	Specification	
	12C2F	646778	125x23x20	5/5-4	51B 91 C75 B AMIGO	
		641839	125x23x20	5/5-4	51B 151 C75 B AMIGO	
		641842	150x23x20	5/5-4	51B 151 C75 B AMIGO	
	Shape	Type no.	DxTxH	U-X	Specification	Comments
	1BM1	463068	75x4x20	4-8	51B 91 C75 B 54 AL	Drill bit diameter 4 mm

Precision grinding





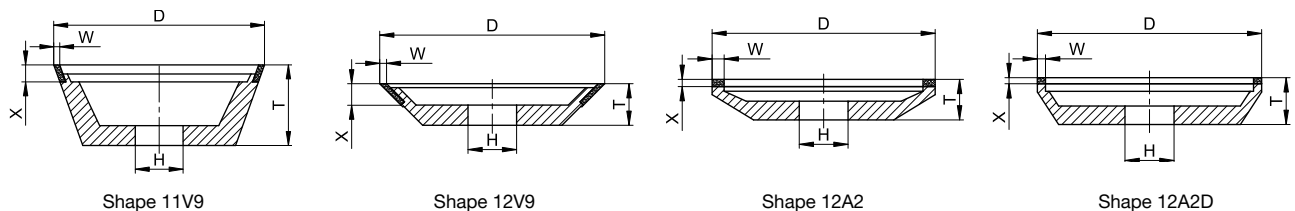
	Shape	Type no.	DxTxH	U-X	Specification	Comments
	1A1	620464	100x10x20	10-6	51B 126 C50 B 54 BA	
	Shape	Type no.	DxTxH	W/U R	Specification	
	4C2	83827	100x13x20	5.1/6 R2	51B 126 C75 B 75 AL	
	Shape	Type no.	DxTxExH	W-X	Specification	
	6A2	735896	100x30x12x20	3-6	51B 126 C75 B 74 AL	

Diamond resin-bonded for dry grinding
For tungsten carbide

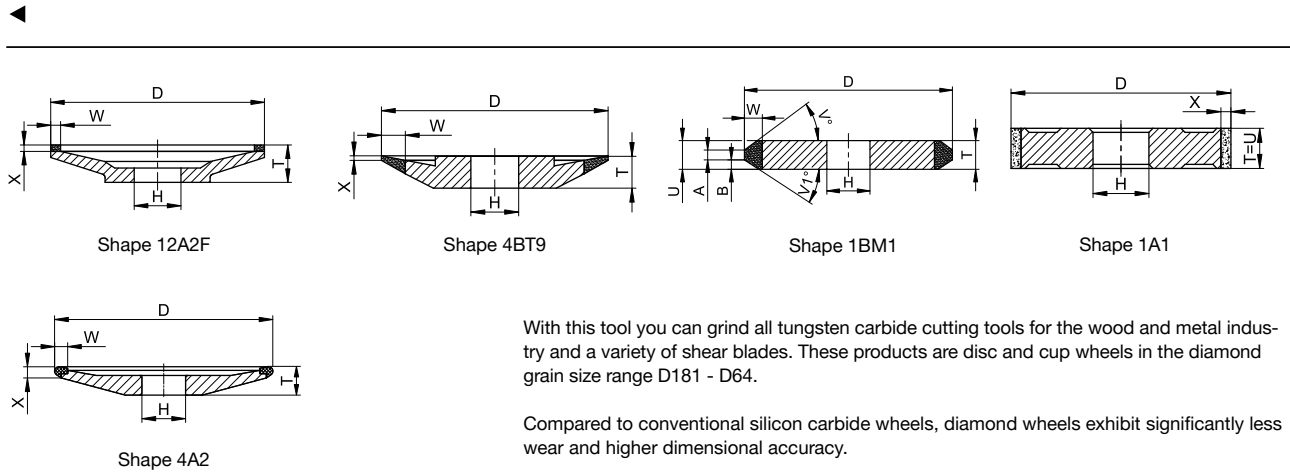


Specifica- tion	Alumin- ium	Non and low-alloyed steels		High-alloyed steels		HSS	INOX	Tungsten carbide	Industrial ceramics	Cast iron	Dry grinding	Wet grinding
		Unhardened Hardened	Unhardened Hardened									
DIAGO, D								●			●	

Recommended stock type






Precision grinding



	Shape	Type no.	DxTxH	W-X	Specification	Comments
	11V9	249717	75x30x20	2-6	11D 126 C75 B 52 BG	Long-life B52
		679634	75x30x20	2-10	11D 126 C75 B DIAGO	
		721301	75x30x20	2-10	11D 64 C50 B DIAGO	
		679946	125x40x20	3-10	11D 126 C75 B DIAGO	
		335803	100x35x31.75	2-10	D126B DIAGO	
		5028	100x35x20	3-10	11D 126 C75 B 52 BG	Long-life B52
		561390	100x35x20	3-10	11D 126 C75 B 53 BG	Long-life B53
		576021	100x35x20	2-10	11D 126 C75 B 74 BG	Long-life B74
		675309	100x35x20	2-10	11D 126 C75 B DIAGO	
		675318	100x35x20	3-10	11D 126 C75 B DIAGO	
		46198	100x35x20	3-10	11D 181 C75 B DIAGO	
		676589	100x35x20	2-10	11D 181 C75 B DIAGO	
		675272	100x35x20	2-10	11D 64 C50 B DIAGO	
		721303	100x35x20	3-10	11D 64 C50 B DIAGO	
681915	100x35x20	2-10	11D 91 C75 B DIAGO			
	12V9	696324	75x20x20	2-6	11D 126 C75 B DIAGO	
		721319	75x20x20	2-6	11D 64 C50 B DIAGO	
		311250	125x25x20	2-10	D126B DIAGO	Long-life B73
		90998	125x25x20	2-6	12D 54 C65 B 73 BA	
		689930	100x20x20	2-10	11D 126 C75 B DIAGO	
		194540	100x20x20	2-10	D91B DIAGO	
		43588	100x20x20	2-10	12D 91 C75 B 52 BG	
	12A2	19220	125x16x20	6-2	11D 126 C75 B 52 AL	
		291603	150x18x20	5-3	11D 91 C75 B 52 AL	

Precision grinding



	Shape	Type no.	DxTxH	W-X	Specification	Comments
	12A2D	28162	100x25x20	6-2	11D 126 C75 B 52 AL	
		38012	100x25x20	6-2	11D 64 C50 B 52 AL	
		104376	100x25x20	5-3	12D 91 C75 B 52 AL	
		779789	100x25x20	10-3	11D 91 C75 B 52 AL	
		462949	100x27x20	6-4	11D 64 C50 B 52 AL	
	12A2F	97868	125x23x20	5-4	D64B DIAGO	Long-life B73
		102902	125x23x20	5-4	D126B DIAGO	
		731387	125x23x20	5-4	11D 64 C50 B DIAGO	
		731399	125x23x20	5-4	11D 151 C75 B DIAGO	
		842923	125x23x20	5-4	11D 151 C75 B 53 AL	Long-life B53
		416671	150x22x20	4-3	11D 64 C50 B 52 AL	
		679671	150x23x20	5-4	11D 126 C75 B 60 AL	
	Shape	Type no.	DxTxH	U-X	Specification	Comments
	4BT9	255835	100x10x20	10-1	11D 91 C75 B 73 AL	
	1BM1	790783	75x4x20	4-8	11D 64 C75 B 52 AL	Drill bit diameter 4 mm
		848480	75x4.5x20	4.5-7	11D 64 C75 B 52 AL	Drill bit diameter 5 and 6 mm
		790784	75x5x20	5-6.5	11D 64 C75 B 52 AL	Drill bit diameter 8 mm
		867805	75x6x20	6-6	11D 64 C75 B 52 AL	Drill bit diameter 10 mm
	1A1	640978	100x10x20	10-6	11D 64 C50 B 52 BA	
	4A2	480500	125x10x20	5-2	11D 126 C75 B 52 AL	
		86734	125x10x20	5-2	11D 64 C50 B 73 AL	
		215813	150x12x20	5-2	11D 126 C50 B 73 AL	
		436472	150x12x20	5-2	11D 64 C50 B 73 AL	

Precision grinding