



Ordering Example

Dimensions of the cut-off wheel: 250x1.5x32 mm
 Material to be cut: Tool steel workpiece Wst.nr. 1.2312 (40CrmmoS8-6)
 Hardness: 440 hV / 44.5 hRC
 Result: Type 167205

	Hardness		Recommended specification		
	Vickers hardness	Rockwell	Hard	Medium	Soft
	1 000 HV	72.3 HRC			
	700 HV	60.5 HRC			
	500 HV	49.1 HRC			
	350 HV	35.5 HRC			
	250 HV	22.0 HRC			
	150 HV				
	120 HV				
	80 HV				
	50 HV				
	30 HV				
	Dimension		Type No.	Type No.	Type No.
	432x3.0x32		167352	167351	167344
	400x3.0x32		167340	167339	167338
	350x2.5x32		169477	167334	167333
	300x2.0x32		169479	167226	167225
	250x1.5x32		167207	167205	165940
	230x1.5x32		167219	167215	167214
	Specification		A80-BH	A80-BM	A80-BS

★★★ PREMIUM **LAB**
 Laboratory for nonferrous metals, plastics and titanium

- Application guidelines
- Use sufficient coolant with 2-3% anti-corrosion additive
 - Avoid applying too much pressure to prevent any cut deviation
 - For larger workpiece dimensions, we recommend using the next softest specification

	Dimension	Type No.		
		NF metals	Plastics	Titanium
	432x3.0x32	167354	167351	
	400x3.0x32	167432	167354	
	350x2.5x32	167335	167335	167336
	300x2.0x32	167229	167229	
	250x1.5x32	167210	167210	167211
	230x1.5x32	167220	167220	167221
	Specification	C80-BN	C80-BN	C80-BT

vs < 50 m/sec (higher speed on request)



LAB

For steel and stainless steel





The PREMIUM*** laboratory cut-off wheel is a high-performance cut-off wheel for ferrous metals such as steel and stainless steel. It is used for cutting laboratory samples that have to be cut quickly and without structural alterations, workpiece deformations or cracks. Assembly is usually carried out on wet cutting systems with a manual or automatic feed, at a maximum operating speed of 50 m/s.

The workpiece must be fixed during machining and the wheel must not be

exposed to lateral load. Laboratory cut-off wheels are available in various specifications:

- soft for 60.5–72.3 HRC
- medium for 22.0–60.5 HRC
- hard up to 22.0 HRC

	Shape	Type no.	Dimension	Specification	Classification	PU	
		41N	167219	230x1.5x32	A80-BH50	Hard	10
		167215	230x1.5x32	A80-BM50	Medium	10	
		167214	230x1.5x32	A80-BS50	Soft	10	
		167207	250x1.5x32	A80-BH50	Hard	10	
		167205	250x1.5x32	A80-BM50	Medium	10	
		165940	250x1.5x32	A80-BS50	Soft	10	
		596848	250x1.8x32	89A60L5B17/50	Very easy cutting	10	
		169479	300x2.0x32	A80-BH50	Hard	10	
		167226	300x2.0x32	A80-BM50	Medium	10	
		167225	300x2.0x32	A80-BS50	Soft	10	
		597041	300x2.0x32	89A60L5B17/50	Very easy cutting	10	
		169477	350x2.5x32	A80-BH50	Hard	10	
		167334	350x2.5x32	A80-BM50	Medium	10	
		167333	350x2.5x32	A80-BS50	Soft	10	
		597383	350x2.5x32	89A60J5B17/50	Very easy cutting	10	
		167340	400x3.0x32	A80-BH50	Hard	10	
		167339	400x3.0x32	A80-BM50	Medium	10	
167338	400x3.0x32	A80-BS50	Soft	10			
167352	432x3.0x32	A80-BH50	Hard	10			
167351	432x3.0x32	A80-BM50	Medium	10			
167344	432x3.0x32	A80-BS50	Soft	10			





LAB

For titanium, nonferrous metals and plastic



The PREMIUM*** laboratory cut-off wheel is a high-performance cut-off wheel for nonferrous metals, titanium and plastic. It is used for cutting laboratory samples that have to be cut quickly and without structural alterations, workpiece deformations or cracks. Assembly is usually carried out on wet cutting systems with a manual or automatic feed, at a maximum operating speed of 50 m/s.

Sufficient coolant with 2–3 % anti-corrosive must be used for machining, and feed values must not be too high in order to prevent a cut deviation. The workpiece must be fixed during machining and the wheel must not be exposed to lateral load.

	Shape	Type no.	Dimension	Specification	Classification	PU	
		41N	167220	230x1.5x32	C80-BN50	Nonferrous / Plastique	10
		167221	230x1.5x32	C80-BT50	Titanium	10	
		167210	250x1.5x32	C80-BN50	Nonferrous / Plastique	10	
		167211	250x1.5x32	C80-BT50	Titanium	10	

**LAB**

For titanium, nonferrous metals and plastic



	Shape	Type no.	Dimension	Specification	Classification	PU	
		41N	167229	300x2.0x32	C80-BN50	Nonferrous / Plastique	10
		167335	350x2.5x32	C80-BN50	Nonferrous / Plastique	10	
		167336	350x2.5x32	C80-BT50 A2	Titanium	10	
		167342	400x3.0x32	C80-BN50	Nonferrous / Plastique	10	
		167354	432x3.0x32	C80-BN50	Nonferrous / Plastique	10	

**Cut-off wheels for cutting and saw sharpening**

For steel und HSS



This PREMIUM*** wheel is a non-reinforced high-performance cut-off wheel for stationary machines and automatic saw sharpening machines. As these cut-off wheels are manufactured without reinforcement, they are only suitable for wet cutting on stationary machines.


The workpiece must be fixed during machining and the wheel must not be exposed to lateral load.

	Shape	Type no.	Dimension	Specification	PU	
		1	591080*	150x3.0x20	A60O5B68	10
		655529*	200x2.0x25	89A60M5B0	10	
		41N	529392	100x1.0x20	A80N4B2	10
		202159	100x1.0x20	A80N4B68	10	
		46633	100x1.0x20	A80O4B43	10	
		722408	100x1.5x20	A80N4B2	10	
		6673	100x2.0x20	A80N4B2	10	
		88461**	120x2.0x51	A60N4B2	10	
		282077	120x2.0x51	A60N5B68	10	
		608409	120x2.0x51	A60P4B68	10	
		1197	120x2.0x51	A60O5B43	10	
		596269	125x1.0x16	A60O5B68	10	
		25590	125x1.0x20	A60O5B43	10	
		282079	125x1.0x20	A60N5B68	10	
		35917	125x1.0x20	A80O5B43	10	
		282080	125x1.0x20	A80N5B68	10	
	282078	125x1.5x20	A60N5B68	10		
	614686	150x1.0x16	A60P5B68	10		
	282110	150x1.0x20	A60N5B68	10		
	1211	150x1.0x20	A60O5B43	10		
	591103	150x1.0x20	A60O5B68	10		
	282111	150x1.0x20	A80N5B68	10		

* For saw sharpening only. ** Also suitable for saw sharpening.



Items with grey lettering are only available on request.

Shape	Type no.	Dimension	Specification	PU	
	41N	13695	150x1.0x20	A80O5B43	10
	594360	150x1.0x20	A80O5B68	10	
	75306	150x1.0x30	97A54P5B71	10	
	39110	150x1.0x32	A80O5B43	10	
	8833	150x1.5x20	A60O5B43	10	
	282085	150x1.5x20	A60N5B68	10	
	591104	150x1.5x20	A60O5B68	10	
	282105	150x1.5x20	A80N5B68	10	
	79957	150x1.5x20	A80O5B43	10	
	73385	150x1.5x20	97A54Q5B43	10	
	662430	150x1.5x32	A80N5B68	10	
	42808	150x1.6x20	A60P4B43	10	
	227165	150x1.6x32	A60O5B43	10	
	58158	150x1.6x32	A60P4B43	10	
	15685	150x2.0x20	A60O5B43	10	
	32023	150x2.0x20	A60N4B2	10	
	282112	150x2.0x20	A60N5B68	10	
	594362	150x2.0x20	A60O5B68	10	
	594356	150x2.0x30	A60O5B68	10	
	33436	150x2.0x30	A60N4B2	10	
	594357	150x2.0x30	A60Q5B68	10	
	39594	150x2.0x30	97A54P5B71	10	
	648577	150x2.0x32	A60O4B68	10	
	80143	150x2.0x32	A80N4B2	10	
	223516**	150x2.5x20	A60N4B2	10	
	598971	150x2.5x20	A60O5B68	10	
	591680	150x2.5x30	A60Q5B68	10	
	47636	175x1.7x16	A60Q5B43	10	
	596520	175x2.0x51	A60P4B68	10	
	607744	175x3.0x51	A60P4B68	10	
	675283	180x1.0x32	A60O5B43	10	
	493199	180x1.6x32	A60O5B68	10	
	282113	200x1.5x20	A60N5B68	10	
	1254	200x1.5x20	A60O5B43	10	
	282114	200x1.5x32	A60N5B68	10	
	6718	200x1.5x32	A60O4B43	10	
	42809	200x1.6x25.4	A60P4B43	10	
	230691	200x1.6x32	A60M4B43	10	

*For saw sharpening only. **Also suitable for saw sharpening.

Items with grey lettering are only available on request.