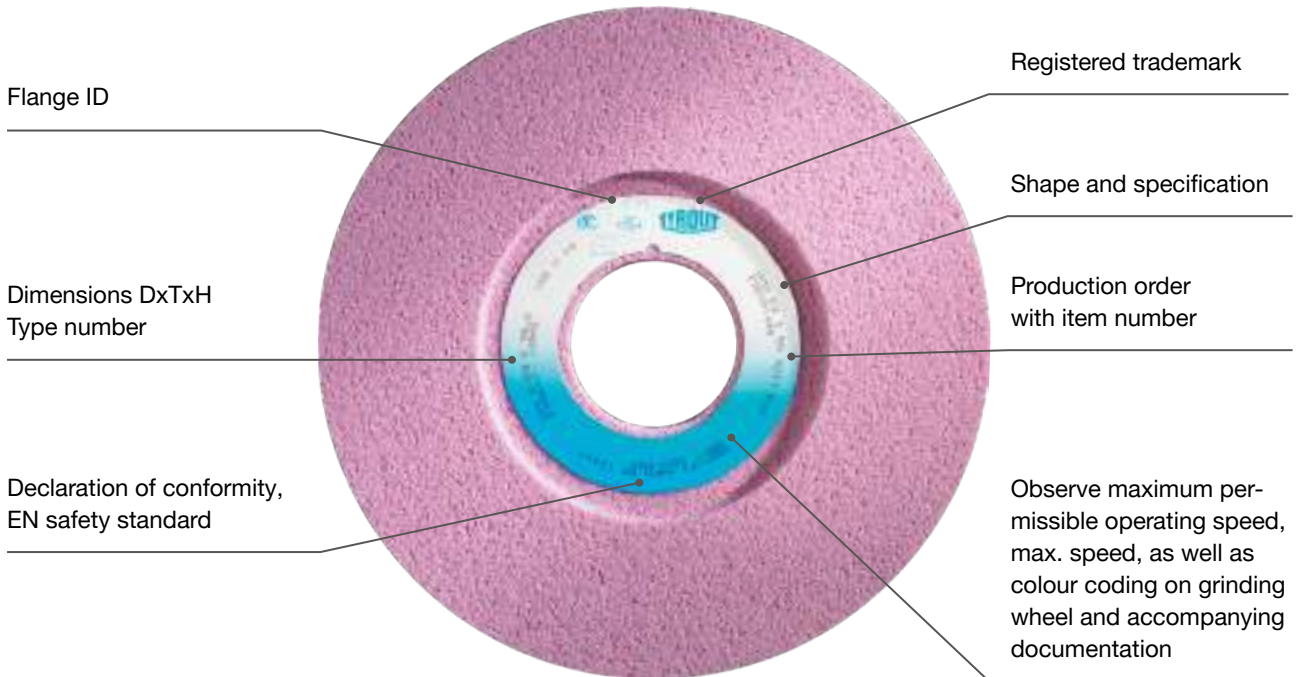


Precision tool specific Information

Product label



Precision grinding

Precision tool specification

Conventional ceramic

89A 60 M 5 V 217

	Bond designation	Internal code, which defines bond type
	Bond	
	V	vitrified bonded
	B	resin bonded
	E	elastic bonded
	G	galvanic bonded
	Structure	The higher the number, the more open the wheel
	Hardness	Hardness ascends alphabetically e.g.
	G	Soft
	R	Hard
	Grit size description	Grit size indication in mesh (sieve size per inch)
	14 – 36	COARSE
	46 – 60	MEDIUM
	80 – 220	FINE
	800 – 1 200	VERY FINE

Abrasive description	
10A	Regular aluminium oxide
50A	Mixture of 89A and 10A
52A	Semi-friable aluminium oxide
80A	Mixture of 88A and special aluminium oxide
87A	Mixture of 89A and 88A
88A	Pink aluminium oxide
89A	White aluminium oxide
91A	Red aluminium oxide
92A	Mixture of 89A and special aluminium oxide
93A	Mixture of 89A and 91A
97A	Special aluminium oxide
454A	Mixture of sintered aluminium oxide and 89A
455A	Mixture of sintered aluminium oxide and 89A
C	Green silicon carbide
1C	Black silicon carbide
50C	Silicon carbide mixture Green/black

Precision tool specification

CBN resin / Diamant

B 126 C50 B 54

			Bond designation	Internal code, which defines bond type
			Bond	
			B	Resin bonded
			M	Metal bonded
			Concentration	The grain concentration shows the grain volume in carat per unit volume of the grinding layer
			Grit size description	Grit size indication in μm (average grit diameter according to FEPA))
			35 – 181 μm	
			Abrasive description	
			B	CBN
			D	Diamond

Pictograms



External-cylindrical grinding



Internal-cylindrical grinding



Surface grinding



Floorstand grinder



Hand-guided grinding



Tool grinding



Saw sharpening



Dressing and sharpening

Precision grinding

Delivery time

EXPLANATION OF TERMS	DELIVERY TIMES
<p>Stock type</p> <p>All products in the chapter "Precision grinding" that are listed with type numbers are in stock.</p>	
<p>Recommended stock type</p> <p>A standard range created by a collaboration between our application engineers and marketing managers, which guarantees optimum grinding results for various grinding applications and the materials to be processed.</p>	<p>Delivery 7 to 10 working days.</p>
<p>Alternative stock type</p> <p>Existing stock products, which – based on our global market and product experience – also guarantee good grinding results, but which are replaced in the short to MEDIUM term by recommended stock types.</p>	
<p>Breadth of product range</p> <p>Precision is our business! However, if the specifications available in stock do not provide you with the perfect solution, modifications to the recommended product range (dimensions) can also be made, i.e. grit size, hardness and structure.</p>	<p>The corresponding delivery times can be found in the relevant chapters, or in our quote or order confirmation documentation.</p>

Precision grinding

Example for breadth of product range

C	60	H	5	Stock type	→	Recommended standard specification
C	46-180	F-I	5-8	5-6 weeks DT	→	Possible range of modifications for grit sizes, hardness and structure
C	80	F	8		→	Example of a possible modification

Modification on request

To ensure quicker delivery times in urgent cases, existing stock types (recommended stock types) can be modified to suit customer requirements. The current delivery time and price will be provided according to the enquiry.



Precision data sheet			Recorded by: on:	
Customer	ATDB no.:		Country:	
	Target group:		Product family:	
	Item requirements:			
	Customer: *		Classification:	
	Department:		Customer no.:	
	Contact:		Tel. / Fax:	
Customer	Shape: *		1 set = item.:	
	Dimensions (mm): *			
	Dimensions (mm):		Tolerance:	
	Specifications:			
	Manufacturer:		Current price:	
	Vs max. (m/s)*		Order quantity:	
Customer	Grinding process:			
	Machine manufacturer:			
	Vs (m/s):			
	Coolant / lubricant:			
	Dressing tool:			
	Dressing cycle:		Dressing amount:	
Workpiece	Workpiece: *		Dimensions (mm):*	
	Material group:*		Stock (mm):	
	Condition: *		Hardness: *	
Aim	Surface roughness:		Contact time:	
	Lifetime:			
	Addition:			
Probe	Specification:			
	Specification:			
	Specification:			
Info			Drawing:	
Distributor:				

* COMPULSORY fields are marked in grey

Precision grinding