BONDFLEX RENMIN

Solutions for Gear Grinding

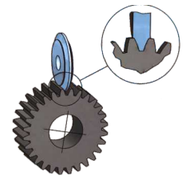
Gear grinding has become increasingly important as the tolerance on the precision of gears has tightened. It is a key working procedure in the production of both automobile gearbox and wind turbine gearbox. Bondflex Sumeng grinding wheels can be used to generate the profile of the gear teeth in a wide range of gear types.

Main Gear Grinding Methods

1. Form Gear Grinding:

The form grinding by the single wheel to process individual gear teeth is now commonly used. Bondflex Sumeng adopts the highly porous structure with ceramic grains, which makes the grinding more efficient and avoid the burn.

Figure 1

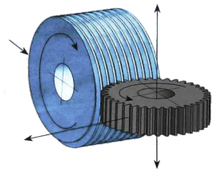


Product Example

2. Worm Gear grinding:

The worm grinding wheel can be applied to a variety of gears to form the desired gear geometry. The wheels have superior form holding ability, precision grinding, low heat generation and high efficiency. Bondflex Sumeng cooperate with machine manu-facturer to provide a tailored solution to shorten the adjusting time and save the cost.

Figure 2

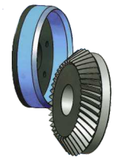


Product Example

3. Bevel Gear Grinding:

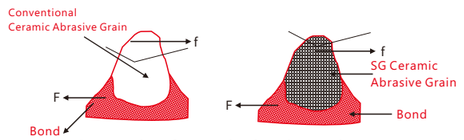
Spiral bevel gear grinding wheels are mainly used for sprial bevel gears. While the contact areas are large during the grinding process, Bondflex Sumeng adopts sharp ceramic grains for cool cutting to avoid the burn.

Figure 3

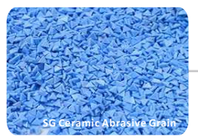


Product Example

Advantages of SG Ceramic Abrasive Grain



Conventional ceramic abrasive grains vs. SG ceramic abrasive grains

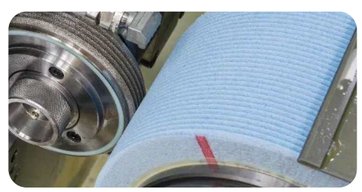


- Trimming time reduced
- Mitigation of burn
- Self-sharpening
- Cost effective

Example of Gear Grinding Solution

Bondflex Sumeng is able to provide SG, NQ, TG ceramic abrasive grains for continuous gear generation, which can mitigate the burn while maintain the grinding force.

Main Grinding Parameters of Continuous Gear Generation:	
Workpiece material:	20CrMnTi
Hardness of workpiece:	HRC48-55
Machining allowance:	0.5 for rough grinding, 0.1 for fine grinding
Finish:	Ra0.4-0.6
Processing requirements:	no burns and in good tooth shape.



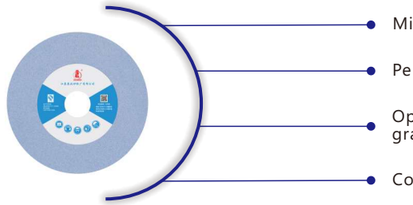
Note: The choice of specifications, such as the adjustment of process parameters, can be optimised by Bondflex Sumeng application engineers to suit customer requirements. Please contact our Sales Department for details.

BONDFLEX RENMIN

Solutions for Electronics Industry

Electronics industry is playing a vital role in the 21st century. The sector produces electronic equipment and consumer electronics, and manufactures electrical components for a variety of products, which majority of them need to be produced by mold. Bondflex Sumeng offers a portfolio of grinding solutions for the industry.

Tool Grinding/Surface Grinding/Cylindrical Grinding



- Minimum risk of burning
- Perfect slot grinding with sharp corner
- Optimal surface finish with tailored grade and structure specifications
- Complete solutions for the electronics industry

Figure 1

Product Examples






Shape	DxTxH (mm)	Specification	Comments
38	180*3/6*31.75	SG/WA/F60-120KL7VG	Grit size F150 - F320, Ra approx. 0.10 – 0.05mm
1	180*3/6.4*31.75	SG/WA/F60-120JK7VG	
1	180*8-19*31.75	SG/WA/F46-120JK7VG PA/F46-120KL7VG SA/F46-120KL7VG	WA grains for grinding of tool steel (SKD11, XW-10, XW-4)
5	180*25*31.75-100*12	SG/WA/F46-120JK7VG PA/F46-120JK7VG SA/F46-120JK7VG	PA grains for grinding of plastic mould steel (P-20M, 718, 738, S136)
1	205*6.4-19*31.75	SG/WA/F46-120KL7VG PS/F46-120KL7VG SA/F46-120KL7VG	SA grains for grinding of plastic mould steel and high speed steel (4CrMoSiV1, SKD-61, 8402, 8407ASP23, ASP30, ASP60)
5	205*25*31.75-110*12	SG/WA/F46-120JK7VG PA/F46-120JK7VG SA/F46-120JK7VG	SG grains for grinding of all types of tool steel

Centerless Grinding

The centerless grinding wheel contains double-layered abrasives, which can ensure that the different parts of the workpiece can be processed simultaneously.

Product Example


General Dimensions

Diameter (mm)	Thickness (mm)	Bore Diameter (mm)
350	150/10	120
350	80/10	120

Note: The choice of specifications, such as the adjustment of process parameters, can be optimised by Bondflex Sumeng application engineers to suit customer requirements. Please contact our Sales Department for details.

Crankshaft Grinding Wheel

The crankshaft grinding wheel is used in the grinding of crankshafts for automobile, motorcycle and marine diesel engines. The crankshafts are made by a variety of materials, including high-strength wear-resistant alloy steel, forged steel, cast steel and nodular iron. Bondflex Sumeng can design and develop group products for crankshaft grinding according to customer needs.

Advantages of Crankshaft Grinding Wheels

Excellent heat dissipation in grinding

The shape of the product is single or double-sided concave. Slotted wheels can be designed upon request. These enable the wheels to transfer the heat and to grind without burns.

High grinding efficiency and Self-sharpening

Using PA, PA/WA, FA and SG abrasive grains, the product is self-sharpening with high grinding efficiency.

Well-balanced

The company adopts fully automatic presser and diamond grinding machine, to ensure the uniformity and flatness of the products. This, in particular, is suitable for grouped crankshaft grinding.

Sandwich multi-layered abrasives design

The sandwich multi-layered grinding wheel can ensure the precision and roughness requirements of the crankshaft journal and the R-angle simultaneously. The grinding process is completed at one time to prevent problems such as the radius shoulder and side burns.

Industry Solutions

Examples of commonly used specifications for diesel engine crankshaft	
*1067*47*304.8 19A60MV	Mixed abrasive grains; used for standard crankshaft grinding
*1067*47*304.8 PA/WA/PA/F54/70/L/K/7V	"Sandwich grinding wheel" - used to improve the shape retention of the bottom R-angle and maintain the roughness of the journal.
*1067*47*304.8 SG54LV	SG abrasive grain - stable grinding performance; mitigate the burns
Examples of commonly used specifications for gasoline engine crankshaft	
*1065*25*304.8 PA60L~PA60MV	
*1065*25*304.8 SG60L~SG60MV	

Note: The choice of specifications, such as the adjustment of process parameters, can be optimised by Bondflex Sumeng application engineers to suit customer requirements. Please contact our Sales Department for details.

Roll Grinding Wheel

Roll grinding wheels are used in the regrinding and production of rolls in the steel, aluminum, and other industries. While rolls degrade during the rolling process, the rolls need to be constantly reground due to cracks, wear, and dimensional change.

≫ **Excellent surface finishes**

Adopts Type B2 – B24 resin bonds to improve each grain's grinding behaviour and to avoid early-releasing of grains which would cause the surface scratch.

≫ **Enhanced grinding efficiency**

Uses GC, 23AC, PA, PA/WA, FA and SG abrasive grains. Tailored solutions designed for different roll materials, to achieve the best results.

≫ **Optimised grinding cost**

Shortens grinding time and improves the wheel lifetime by unique formulas.

Industry solutions

Recommendations for the Selection of Grinding Wheels

Application		Steel Types	Product Specifications
Hot rolling mill	Work roll	Infinitely chilled ductile cast iron	GC/F36/F46IJ7B or GC/F36/F46LM6B
		High chromium cast iron	GC/F46JK7B or 3RA/F46JK7B
		High chromium cast steel	SA/WA/F36/F46IJ7B
		Above-mentioned mixed material	N3A/F46I7B or 3RA/F46JK7B
		High speed steel (HSS)	SG/NQ/F36/F46/K7B24
	Back-up roll	Cast Steel	WA/F36/F46I7B
Cold rolling mill	Work roll	Cast steel	SA/F80HI7B
		High chromium cast steel	SA/WA/F80HI7B
		Alloy steel	WA/F80HI7B
	Back-up roll	Cast Steel	WA/F46/F60IJ7B

Solutions for Steel Industry

Bondflex Sumeng has extensive expertise and experience in offering cutting and grinding solutions in the steel industry. The company offers a wide product portfolio of roll grinding wheels, heavy-duty grinding wheels, and extra-large cut-off wheels, which are highly competitive in the market.

Heavy-duty Grinding Wheel

The heavy-duty grinding wheel is used to remove the defects of the billet i.e. crack, scale, hard spots, before conveying to the rolling mill. The grinding wheels, with excellent grinding power and high production output, are widely adopted by major domestic steel factories.

Rapid stock removal and high production output

Adopts zirconia alumina and sintered alumina abrasive grains, which have additional strength, toughness, hardness and wear resistance. Zirconia alumina is suitable for use on low and middle-alloy steel, high-speed steel, and titanium alloy, while sintered alumina is commonly used for stainless steel which has higher requirement on surface finish.

Additional strength and maximum safety

The grinding wheel is more balanced and closely compacted due to special formula, self-developed microwave heating system and fully automated production line. This ensures the safety use under high pressure.

Longer lifetime and high cost efficiency

Bondflex Sumeng is constantly focusing on the formula upgrade, while maximizing the grinding power, stock removal capability, as well as optimising the grinding cost.

Main Product Specifications

Diameter (mm)	Thickness (mm)	Bore Diameter(mm)	Grit size (mesh)
610	76/102	203.2/304.8	8, 10, 12, 16, 20, 24
760	76/102/125	203.2/304.8	
915	102/125/150	304.8	

Zirconia Alumina

Sintered Alumina

Large Diameter Cut-off Wheel

The large diameter cut-off wheel is specially designed for the steel industry, which requires high performance reinforced wheels to ensure good profile retention, clean cut, no burrs and no burns.

Superior cutting performance

Adopt zirconium corundum and new type abrasive grains with high toughness, high heat resistance and high wear resistance.

Good surface finish

The cut surface is smooth, without surface hardening, and less burrs.

High stability, safe operation and low noise

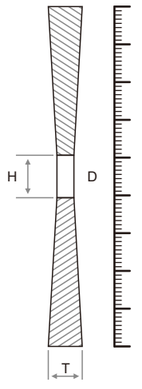
Adopt advanced formula, the speed can reach 100m/s. No oblique cutting and no scrap.

Long lifetime and economic efficiency

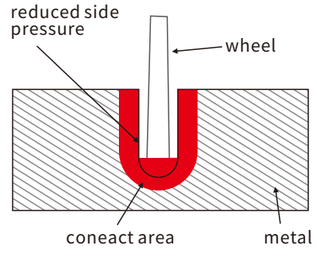
Use more durable abrasive blend with longer lifetime and therefore cost-effective.

Tapered shape wheel

Decrease heat generation and avoid clogging.



Diameter (mm)	Thickness (mm)	Bore Diameter (mm)
2000	17/16	152.4/203/230
1800	17/16	152.4/203/230
1600	16/15	100/127/152.4/203.2/230
1500	15/14	100/127/152.4/203.2/230
1380	14/13	100/127/152.4/203.2/230
1250	13/12	100/127/152.4/203.2/230
1220	12/11	100/127/152.4/203.2/230
1000	11/10	100/127/152.4
800	8/7	80/100/127/152.4
750	8/7	80/100/127/152.4



Note: Special specifications can be produced upon client request

Main Applications

The extra-large cut-off wheel is designed to cut large workpieces in materials with high internal stresses.

Cold cutting-off 20-100C	Warm cutting-off 100-600C	Hot cutting-off 600 -1100C
mainly used in steel processing companies and finishing workshops	mainly used in steel rolling mills to cut steel materials off from the cooling bed	mainly used in steel rolling mills and casting factories

Note: The choice of specifications, such as the adjustment of process parameters, can be optimised by Bondflex Sumeng application engineers to suit customer requirements. Please contact our Sales Department for details.

BONDFLEX RENMIN

Solutions for Bearing Industry

Bearings are vital mechanical devices used to enable movements in modern industries. Regardless of the shapes, sizes, and types of bearings, surface quality and dimensional accuracy are the key requirements, which illustrates the importance of having top quality abrasive products. Bondflex Sumeng offers complete range of solutions for bearing industry.

BONDFLEX RENMIN

Requirements for Bearing Grinding

· The rolling part include rings and rollers require high dimensional accuracy, excellent surface finish, and coefficient of friction

· Automated bearing production line needs grinding wheel with improved economic efficiency and process stability

Requirements for Grinding Tools

· Long life, high production, and no burning

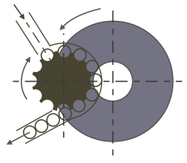
· Trend of high speed grinding which leads to better surface finish and economic efficiency

· High precision of grinding wheels for better dimensional accuracy

· Customised products for high quality requirements

· Process stability for industrial automated applications

Applications of Bear Grinding

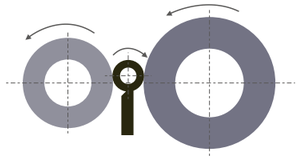


① Inner and outer rings face grinding

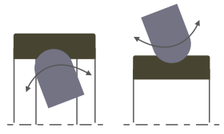
② Inner ring raceway grinding

③ Outer ring raceway grinding

④ Inner ring bore grinding



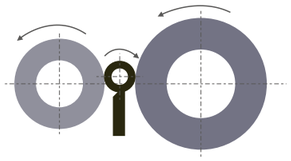
⑤ Centreless grinding of outer ring



⑥ Superfinishing of inner and outer raceways

Centerless Grinding

All types of bearing rings, rollers, and needles can be ground by centerless grinding. The centreless grinding wheel can also be applied to the grinding of outside diameter of piston pin, drill, and round bar.



≫ **Uniform Quality**
Double-sided pressing from automated production equipment ensures the grinding wheel in uniform quality

≫ **High productivity and long lifetime**
The advanced kiln installation ensures the bond completely holds the abrasive grains within the wheel structure, providing bulk strength

≫ **High consistency**
The grinding wheels are produced from automated CNC grinding machine, which ensures the coxiality and flatness. A perfect solution for centreless grinding in volume production

Reference Table for Grinding Machine and Centerless Grinding Wheel

Grinding Machine Model	Grinding Wheel Specifications	Regulating wheel Specifications
M1040	7-350*125*127	7-250*125*75
M1080	1-500*150*305	7-300*150*127
M10100	1-500*200*305	7-350*200*127
JHC-12S	7-305*150*120	7-205*150*90
JHC-18AS	7-455*255*228.6	7-255*255*111.2

Grinding Machine Model	Grinding Wheel Specifications	Regulating wheel Specifications
M1050	1-400*150*203	7-300*150*127
M1083	1-600*200*305	7-350*200*127
M10200	1-600*400*306	1-350*400*203
JHC-18S	7-455*205*228.6	7-255*205*111.2
JHC-20S	7-510*205*254	7-305*205*127

Complete Solution for Centerless Grinding

Bondflex Sumeng also offers rubber grinding wheel and regulating wheel, which provides customers with a one-stop solution service in centreless grinding.

Product Example

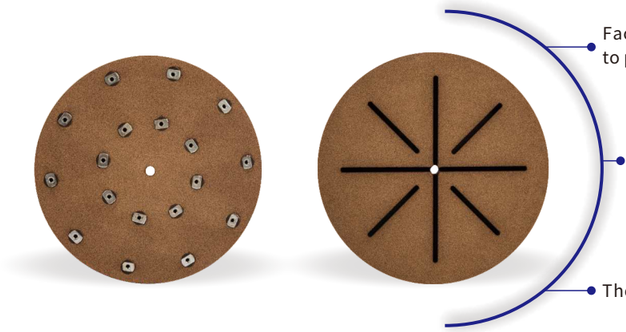
Example of Centerless Grinding Solutions

Workpiece	Gudgeon pin	Bearing outer ring
Material	Low carbon alloy steel	Alloy steel
Hardness	HRC55	HRC62
Grinding requirement	Fine grinding	Fine Grinding
Product Specification	38A80L7V	FA100L7V

Solutions for Bearing Industry

Disc Grinding

Bondflex Sumeng offers a portfolio of conventional resin-bonded grinding wheels for disc grinding. The product has been widely adopted by the bearing industry due to its high grinding precision, long service time, and economic efficiency. It also ensures the plane parallelism and flatness of the face. The wheels can also be used for the production of vehicle cylinder head, piston ring, spring and compressor parts etc.



- Face designed in slotting and honeycomb type to prevent wheel loading
- Advanced bond formula to allow wheels to become more elastic, cool grinding and no burning
- The bolts are firmly fastened to ensure safety use

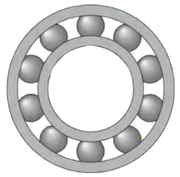
General specifications

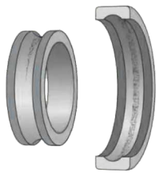
Recommendations for the Selection of Bolted Grinding Wheels

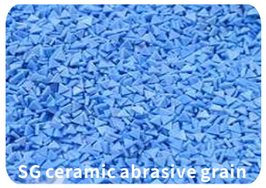
Grinding Object	Grinding Wheel Specifications
Bearing ring and roller end face, Sealing valve plate, Automobile friction plate	37-540*100*60-C/F30/F36LK7B-35m/s
Bearing ring	36-750*75*20-A/F80KLM7B-35m/s
	36-350*60*16-A/F60PQ4B-35m/s
Engine cylinder block double-side face grinding and four-side face grinding etc.	36-609.6*120*355.6-C/F16PQ6B-45m/s
	37-773*75*93-C/F24PQ6B-40m/s

Inner Ring and Outer Ring Race Grinding

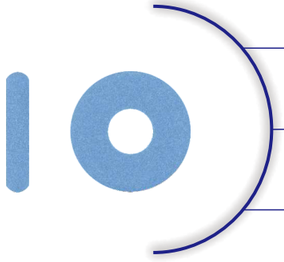
Bondflex Sumeng has developed a high-strength bond for bearing ring race grinding, which is suitable for high-speed grinding. It concentrates on the advantages of various grinding solutions, and uses mixed abrasive grains to enhance the grinding precision and efficiency, minimise the dressing times, extend lifetime, with a leading position in China.







Main Techniques



- Development of vitrified bonds for high-speed grinding (60 – 80m/s)
- Exclusive bond structure to avoid workpiece burn
- Application of new SG ceramic abrasive grain

General Specifications

Recommendation for Bearing Ring Raceway Grinding

Grinding Object	Grinding Wheel Specifications
External raceway of bearing inner ring	Diameter 500 – 600mm A/WA/F120JK7VG-63m/s SG/WA/PA/F120JK7VG-63m/s
Internal raceway of bearing inner ring	Diameter 25 – 75mm A/WA/F120KL7VG-63m/s SG/PA/F100/F120KL7VG-63m/s WA/F120M6R-60m/s

Solutions for Bearing Industry

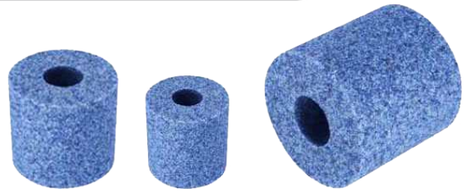
Internal Grinding

The internal grinding process is used for most types of bearings.

Key Technology I: Production of Internal Grinding Wheel with SG Abrasive Grains

Advantages

- **High Quality** (cool grinding and excellent metallographic structure)
- **High Adaptability** (no special requirement for grinding such as dressing tool and coolant)
- **High Efficiency** (excellent cutting edge with microcrystalline structure)
- **Long life** (reduced dressing times)
- **High precision** (good profile retention)



Product example: P 65*20*20 3SG100L8V 60m/s
Grit size and hardness can be tailored according to surface roughness requirement and grinding allowance.

Key Technology II: Production of Vitrified CBN Internal Cylindrical Grinding Wheel

Advantages

- Sharp grinding with high production efficiency
- No burning
- Good profile retention
- Reduced adjustment and replacement times

It is the trend that CBN grinding wheel will replace conventional grinding wheel in the long run. However, CBN grinding wheel has higher requirements for grinding machines, with special criteria on spindle rigidity, coolant pressure and nozzles, on top of high rotation speed. Therefore, the market still uses conventional grinding wheels, and will upgrade to SG vitrified grinding wheels.

Bondflex Sumeng has accumulated vast experience in both conventional and SG vitrified grinding wheels, which can provide complete solutions for customers.

Note: The choice of specifications, such as the adjustment of process parameters, can be optimised by Bondflex Sumeng application engineers to suit customer requirements. Please contact our Sales Department for details.

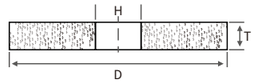
Solutions for General Industry

Bondflex Sumeng offer a portfolio of products, including vitrified, resin and rubber bonded grinding wheels, as well as grinding segments, mounted points, and oil stones, in a variety of shapes and specifications for general industrial applications. The products are widely used in different types of grinding requirement.

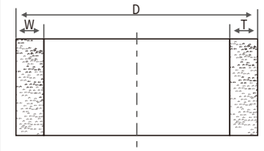
Cylindrical Grinding, Internal Grinding and Surface Grinding

These are most commonly used grinding methods, which covers almost all industry sectors.

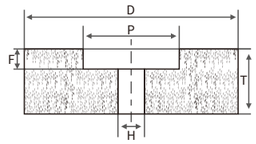
Straight Grinding Wheel (Type 1)



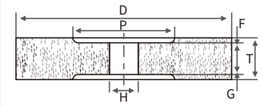
Cylinder Grinding Wheel (Type 2)



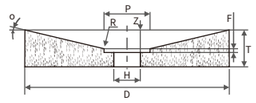
One Side Recessed Grinding Wheel (Type 5)



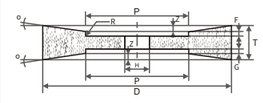
Two Sides Recessed Grinding Wheel (Type 7)



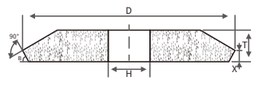
One Side Recessed and Tapered Grinding Wheel (Type 23)



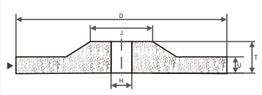
Two Side Recessed and Tapered Grinding Wheel (Type 26)



Type 1-N Straight Wheel (Type 1-N)



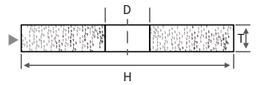
One Side Convex Grinding Wheel (Type 38)



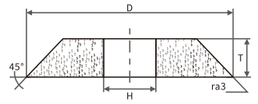
Tool Grinding

With the characteristics of reasonable structure,homogeneous organization,high stock removal rate cool grinding,these are commonly used for mold processing,all kinds of cutting tolls,drills and sawtooth,etc.

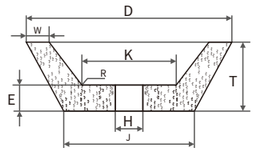
Straight Grinding Wheel (Type 1)



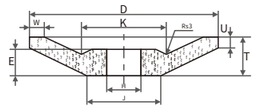
One Side Tapered Grinding Wheel (Type 1-C)



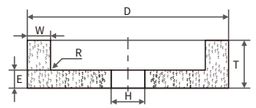
Flaring Cup Grinding Wheel (Type 11)



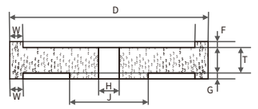
Dish Grinding Wheel (Type 12a)



Straight Cup Grinding Wheel (Type 6)

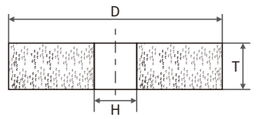


Type 8 Grinding Wheel (Type 8)



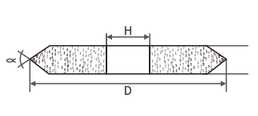
Guideway Grinding Wheel

The grinding wheel is produced by newly developed formula for high grinding efficiency due to the high porosity and more even structure.



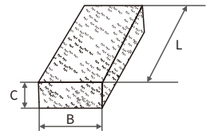
Thread Grinding Wheel

The grinding wheel is mainly used for grinding of diff erent types of screw rods and taps. It has well-balanc ed structure,with high profile retention,high precisi on and will not burn the workpiece.



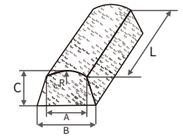
Grinding Segments

Segments are used for surface grinding and could achieve more stock removal, better dimensional accuracy, and surface finishing etc.



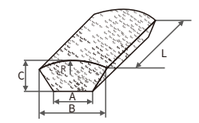
Flat segments
Type:3101
Marking of the shape and size
3101-B*C*L

B(mm)	C(mm)	L(mm)
50/80	25	150
90	35	150
80	50	200



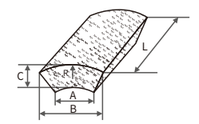
Flat-convex segments
Type:3102
Marking of the shape and size
3102-B/A*C*L

B(mm)	A(mm)	C(mm)	R(mm)	L(mm)
100	85	38	230	150



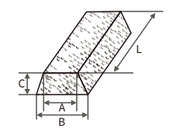
Convex-flat segments
Type:3103
Marking of the shape and size
3103-B/A*C*L

B(mm)	A(mm)	C(mm)	R(mm)	L(mm)
115	80	45	250	150



Convex-concave segments
Type:3104
Marking of the shape and size
3104-B/A*C*L

B(mm)	A(mm)	C(mm)	R(mm)	L(mm)
60	40	85	60	75
125	85	225	190	125



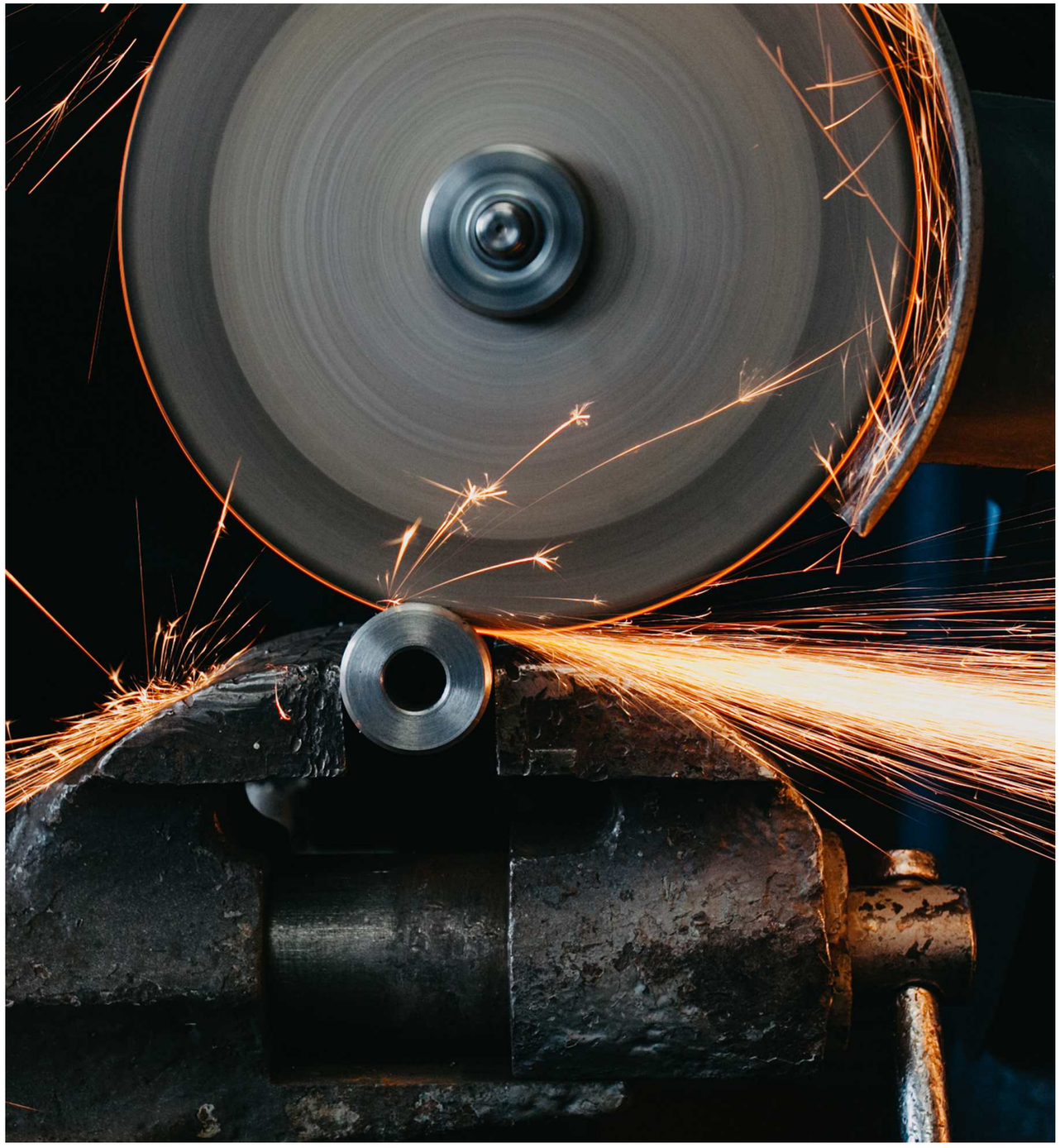
Trapezoidal segments
Type:3109
Marking of the shape and size
3109-B/A*C*L

B(mm)	A(mm)	C(mm)	L(mm)
60	50	15	125
100	85	35	150

Mounted Point Grinding Wheel

Mounted wheels are offered primarily in three groups (A,B,and W)

- Group A is mainly used in foundries, steel mill, metal processing and stone industries.
- Group B is normally used in the tool and mould industries.
- Group W is suitable for precision grinding.



DISC LABEL

PICTOGRAMS: MATERIALS

Steel | Stainless steel | Non-ferrous metals | Stone, universal building materials | Rails | Plastics,lacquers, paints | Concrete | Asphalt

SAFETY INFORMATION

Pay attention to the safety recommendations | Personal safety | Use dust mask | Use eye protection | Use ear protection | Use gloves

Not permitted for side grinding | No freehand work | Dry grinding | Wet grinding | Do not use damaged wheels

BONDFLEX RENMIN

Cutting Disc and Grinding Disc Product Range	
Cutting disc	D≤400mm, T≤3.0mm, H≤32.0mm, V≤100m/s
Grinding disc	D≤230mm, T≤8.0mm, H≤25.4mm, V≤80m/s
Grit size	F24-F60
Hardness	S, Q, T

SHAPE

Designation	Shape	Description
	T41	Cut-off wheel (staight design)
	T42	Cut-off wheel (depressed-centre design)
	T27	Rough grinding wheel

Steel Cutting (incl. chop saw and petrol saw)

Material
- Structural steels
- Tool steels
- Hardened steels
- High tensile/High-alloyed steels

Application
- Solid materials
- Thin metal sheets
- Pipes&profile
- Welding grinding
- Forge grinding

Advantage
- High speed
- Long lifetime
- Lower odor
- High flexibility

Art No.	Specification	Dimension (DxTxH mm)	Type	Speed(m/s)	Max.rpm	P.Qty.
MEF401052	A46T5BF	100X1.0X16.00	T41	80	15300	400
MEF402552	A36S5BF	100X2.5X16.00	T41	80	15300	400
MEF451072	A46T5BF	115X1.0X22.23	T41	80	13300	400
MEF501072	A46T5BF	125X1.0X22.23	T41	80	12250	400
MEF501672	A36T5BF	125X1.6X22.23	T41	80	12250	400
MEF701672	A36T5BF	180X1.6X22.23	T41	80	8500	200
MEF702572	A30S5BF	180X2.5X22.23	T41	80	8500	100
MED702572	A30S5BF	180X2.5X22.23	T42	80	8500	100
MEF901972	A36T5BF	230X1.9X22.23	T41	80	6650	100
MEF902572	A30S5BF	230X2.5X22.23	T41	80	6650	100
MED902572	A30S5BF	230X2.5X22.23	T42	80	6650	100
MEF123082	A30R5BF	300X3.0X25.40	T41	100	6400	25
MEF144063	A24T5BF	350X3.5X20.00	T41	100	5500	25
MEF164083	A30R5BF	400X4.0X25.4	T41	100	4800	25

Steel Grinding

Material
- Hardened steels
- High-alloyed steels
- Tool steels
- Structural steels

Application
- Welding seam preparation
- Edge grinding
- Surface grinding
- Burr grinding

Advantage
- Long lifetime
- High efficient
- High stock removal
- High flexibility

Art No.	Specification	Dimension (DxTxH mm)	Type	Speed(m/s)	Max.rpm	P.Qty.
MEC407053	A30S5BF	100X7.0X16.00	T27	80	15300	160
MEC457073	A30S5BF	115X7.0X22.23	T27	80	13300	160
MEC507073	A30S5BF	125X7.0X22.23	T27	80	12250	160
MEC707073	A24S5BF	180X7.0X22.23	T27	80	8500	40
MEC907073	A24S5BF	230X7.0X22.23	T27	80	6650	40

Common Disc Sizes

Stainless Steel Cutting (incl. chop saw and petrol saw)

Material
- Rust and acid proofed steels
- Hardened steels
- Tool steels
- High-alloyed steels

Application
- Cutting
- Beveling
- Burr removing
- Dressing

Advantage
- Low development of burrs
- High cutting speed
- Very long lifetime

Art No.	Specification	Dimension (DxTxH mm)	Type	Speed(m/s)	Max.rpm	P.Qty.
SSF401052	WA46T5BF	100X1.0X16.00	T41	80	15300	400
SSF401252	WA46T5BF	100X1.2X16.00	T41	80	15300	400
SSF451072	WA46T5BF	115X1.0X22.23	T41	80	13300	400
SSF451672	WA36T5BF	115X1.6X22.23	T41	80	13300	400
SSF501072	WA46T5BF	125X1.0X22.23	T41	80	12250	400
SSF501672	WA36T5BF	125X1.6X22.23	T41	80	12250	400
SSF701672	WA36T5BF	180X1.6X22.23	T41	80	8500	200
SSF301972	WA36T5BF	230X1.9X22.23	T41	80	6650	100
SSF122483	WA30S5BF	300X2.4X25.4	T41	80	5100	25
SSF142683	WA30S5BF	350X2.6X25.4	T41	80	4400	25
SSF143082	WA30S5BF	350X3.0X25.4	T41	80	4400	25
SSF163082	WA30S5BF	400X3.0X25.4	T41	80	3850	25

Stainless Steel Grinding

Material
- Rust and acid proofed steels
- Hardened steels
- High-alloyed steels
- Tools steels

Application
- Welding seam preparation
- Edge grinding
- Surface grinding
- Burr grinding

Advantage
- Long lifetime
- Minimum development of burrs
- High efficient
- High stock

Art No.	Specification	Dimension (DxTxH mm)	Type	Speed(m/s)	Max.rpm	P.Qty.
SSC407053	WA30Q5BF	100X7.0X16.00	T27	80	15300	160
SSC457073	WA30Q5BF	115X7.0X22.23	T27	80	13300	160
SSC507073	WA30Q5BF	125X7.0X22.23	T27	80	12250	160
SSC707073	WA24Q5BF	180X7.0X22.23	T27	80	8500	40
SSC907073	WA24Q5BF	230X7.0X22.23	T27	80	6650	40

Aluminum Cutting

Material
- Non-ferrous metals
- Brass
- Bearing metal
- Al-alloy

Application
- Rain guttering
- Corrugated sheets
- Thin-walled tubes
- Surface grinding
- Burrgrinding

Advantage
- Low development of burrs
- Long lifetime
- Cool cut
- Cool grinding performance

Art No.	Specification	Dimension (DxTxH mm)	Type	Speed(m/s)	Max.rpm	P.Qty.
ALF401652	A36P5BF	100X1.6X16.00	T41	80	15300	400
ALD402552	A36P5BF	100X2.5X16.00	T42	80	15300	200
ALF451672	A36P5BF	115X1.6X22.23	T41	80	13300	400
ALD452572	A36P5BF	115X2.0X22.23	T42	80	13300	200
ALF501672	A36P5BF	125X1.6X22.23	T41	80	12250	400
ALF502072	A36P5BF	125X2.0X22.23	T41	80	12250	400
ALD502072	A36P5BF	125X2.0X22.23	T42	80	12250	200
ALF701672	A36P5BF	180X1.6X22.23	T41	80	8500	200
ALF901672	A36P5BF	230X1.9X22.23	T41	80	6650	100
ALF902572	A36P5BF	230X2.5X22.23	T41	80	6650	100
ALD902572	A36P5BF	230X2.5X22.23	T42	80	6650	100

Aluminum Grinding

Material
- Non-ferrous metals
- Brass
- Bearing metal
- Al-alloy

Application
- Welding seam preparation
- Edge grinding
- Surface grinding
- Burr grinding

Advantage
- No clogging
- High flexibility
- Cool grinding performance
- High efficient

Art No.	Specification	Dimension (DxTxH mm)	Type	Speed(m/s)	Max.rpm	P.Qty.
ALC407053	A30N5BF	100X7.0X16.00	T27	80	15300	160
ALC457073	A30N5BF	115X7.0X22.23	T27	80	13300	160
ALC507073	A30N5BF	125X7.0X22.23	T27	80	12250	160
ALC707073	A24N5BF	180X7.0X22.23	T27	80	8500	40
ALC907073	A24N5BF	230X7.0X22.23	T27	80	6650	40

Stone Cutting

Material
- Mardle
- Natural stone
- Limestone
- Artificial stone
- Asphalt

Application
- Tiles
- Seamless tubes
- Rain guttering
- Floor slabs
- Roofing tiles

Advantage
- High cutting speed
- Long lifetime
- Cool cut
- High stock removal

Art No.	Specification	Dimension (DxTxH mm)	Type	Speed(m/s)	Max.rpm	P.Qty.
STF401652	C36T5BF	100X1.6X16.00	T41	80	15300	400
STD402552	C36T5BF	100X2.0X16.00	T42	80	15300	200
STF402552	C36T5BF	100X2.5X16.00	T41	80	15300	400
STF451672	C36T5BF	115X1.6X22.23	T41	80	13300	400
STF453072	C36T5BF	115X3.0X22.23	T41	80	13300	400
STD453072	C36T5BF	115X3.0X22.23	T42	80	13300	200
STD503072	C36T5BF	125X3.0X22.23	T42	80	12250	200
STF701972	C36T5BF	180X1.9X22.23	T41	80	8500	200
XTF703072	C36T5BF	180X3.0X22.23	T41	80	8500	100
STD903072	C36T5BF	230X3.0X22.23	T42	80	6650	100

Stone Grinding

Material
- Concrete products
- Natural stones
- Lime stones
- Artificial stones
- Tile

Application
- Corner and edge grinding
- Surface grinding
- Cleaning
- Edge grinding

Advantage
- High stock removal
- No clogging
- High efficient
- High flexibility
- Cool grinding performance

Art No.	Specification	Dimension (DxTxH mm)	Type	Speed(m/s)	Max.rpm	P.Qty.
STC407053	C30S5BF	100X7.0X16.00	T27	80	15300	160
STC457073	C30S5BF	115X7.0X22.23	T27	80	13300	160
STC507073	C30S5BF	125X7.0X22.23	T27	80	12250	160
STC707073	C24S5BF	180X7.0X22.23	T27	80	8500	40
STC907073	C24S5BF	230X7.0X22.23	T27	80	6650	40