
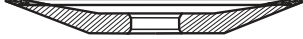
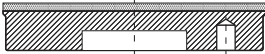

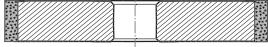
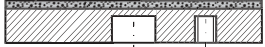
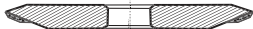
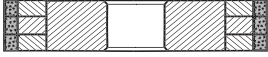

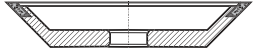
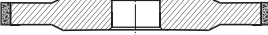
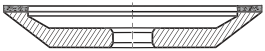
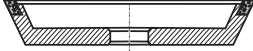
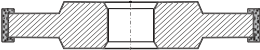
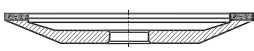
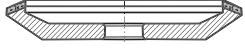
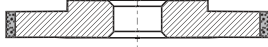
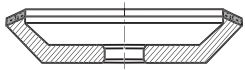
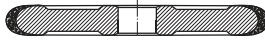
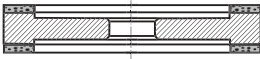

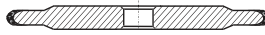
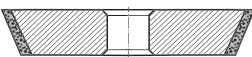

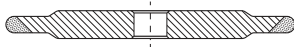


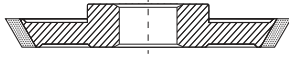


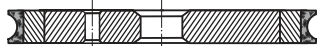
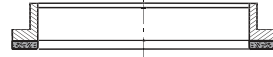

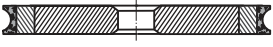
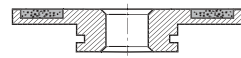
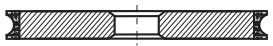
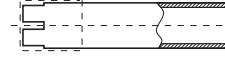

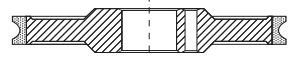
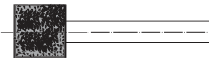
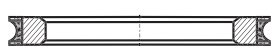
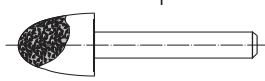
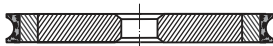
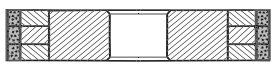

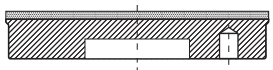

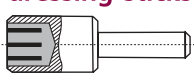
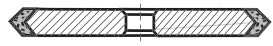
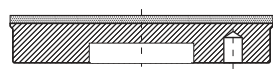
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**PRODUCT
CATALOG**

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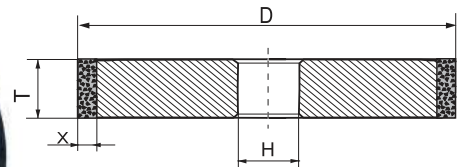
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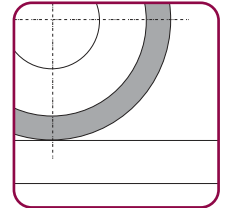


**METAL AND RESIN BONDED DIAMOND AND CBN
GRINDING WHEELS FOR MACHINE BUILDING,
ELECTRONICS, TOOL AND WOODWORKING INDUSTRIES**

1A1 STRAIGHT GRINDING WHEELS



1A1 D*T*X*H



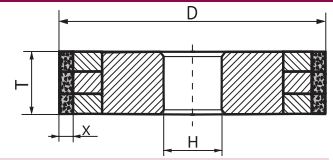
Flat surface grinding

- Used for machining of conical, cylindrical and flat surfaces, cylindrical and conical apertures.
- Machining of cylindrical surface parts and surface ends at one set-up.
- Machining of recesses and slots of carbide stamps.
- Sharpening and finishing of carbide tools.
- The diamond layer is made of diamond grinding powder with metal or resin bonds.
- For metal bonded tools, coolant is required

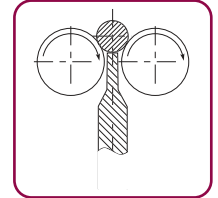
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0-0005	16	13	2	6
0-0010	20	10	2	6
0-0011	20	16	2	6
0-0016	25	10	3	6
0-0018	25	16	3	6
0-0022	32	10	3	10
0-0024	32	16	3	10
0-0031	40	16	3	16
0-0037	50	16	3	16
0-0044	63	16	3	20
0-0045	80	3	3	20
0-0048	80	6	3	20
0-0054	80	6	5	20
0-0050	80	10	3	20
0-0056	80	10	5	20
0-0053	80	20	3	20
0-0059	80	20	5	20
0-0060	100	3	3	20
0-0063	100	6	3	20
0-0065	100	10	3	20
0-0071	100	10	5	20
0-0068	100	20	3	20
0-0076	125	3	3	32
0-0078	125	5	3	32
0-0079	125	6	3	32
0-0080	125	10	3	32
0-0085	125	10	5	32
0-0083	125	20	3	32
0-0088	125	20	5	32
0-0089	125	32	5	32
0-0091	150	3	3	32
0-0093	150	5	3	32
0-0094	150	6	3	32
0-0100	150	6	5	32
0-0096	150	10	3	32
0-0102	150	10	5	32
0-0099	150	20	3	32
0-0105	150	20	5	32
0-0109	200	6	3	76
0-0111	200	10	3	76
0-0116	200	10	5	76
0-0114	200	20	3	76
0-0119	200	20	5	76
0-0120	200	40	5	76
0-0126	250	10	5	76
0-0128	250	15	5	76
0-0129	250	20	5	76
0-0130	250	40	5	76

1A1 STRAIGHT GRINDING compound WHEEL

- Used for machining cylindrical surfaces, centerless grinding.
- The diamond layer is made of diamond grinding powder with metal or resin bonds.
- For metal bonded tools coolant is required.



1A1 D*T*X*H



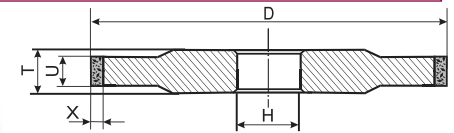
Centerless grinding

Catalog number	D, mm	T, mm	X, mm	H, mm
9-6993	300	100	5	127
0-2821	350	100	5	200
9-6997	350	100	5	127
9-6998	350	100	5	203
9-9606	400	150	5	203
9-6999	400	150	5	305
9-2034	500	200	3	304,8
9-2033	500	200	6	304,8

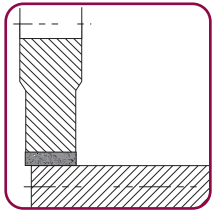
Customer-specific and other grinding tools can be produced on request.

14A1 STRAIGHT FLAT GRINDING WHEELS

- Used for machining of conical, cylindrical and flat surfaces, cylindrical and conical apertures, sharpening and finishing of carbide tools.
- The diamond layer is made of diamond grinding powder with metal or resin bonds.
- For metal bonded tools coolant is required.



14A1 D*T*U*X*H



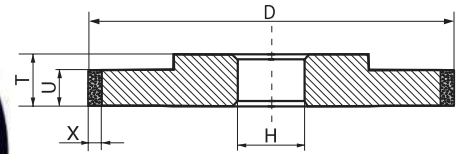
Cylindrical surface grinding

Catalog number	D, mm	T, mm	U, mm	X, mm	H, mm
0-0301	100	6	3	3	20
0-0302	100	6	5	3	20
0-0303	100	6	3	5	20
0-0304	100	6	5	5	20
0-0305	125	6	3	3	32
0-0306	125	6	5	3	32
0-0307	125	6	3	5	32
0-0308	125	6	5	5	32
0-0309	150	8	3	3	32
0-0310	150	8	5	3	32
0-0311	150	8	3	5	32
0-0312	150	8	5	5	32
0-0315	150	10	7	7	32
0-0316	150	10	9	7	32
0-0317	175	8	3	3	51
0-0318	175	8	5	3	51
0-0319	175	8	3	5	51
0-0320	175	8	5	5	51
0-0321	200	10	3	3	51
0-0322	200	10	5	3	51
0-0323	200	10	3	5	51
0-0324	200	10	5	5	51
0-0327	200	10	7	7	51
0-0328	200	10	9	7	51
0-0329	250	10	3	5	51
0-0330	250	10	5	5	51
0-0333	250	10	7	7	51
0-0334	250	10	3	5	76
0-0335	250	10	5	5	76
0-0338	250	10	7	7	76

Customer-specific and other grinding tools can be produced on request.

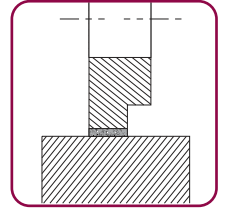
3A1 STRAIGHT GRINDING WHEELS

- Used for processing of cylindrical and flat surfaces on cylindrical and surface grinding machines.
- The diamond layer is made of diamond grinding powder with metal or resin bonds.
- For metal bonded tools coolant is required.



3A1 D*T*U*X*H

Flat surface grinding

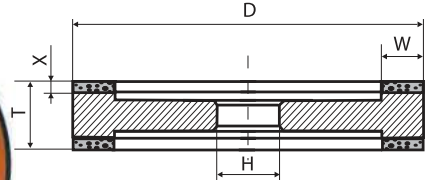


Catalog number	D, mm	T, mm	U, mm	X, mm	H, mm
9-5030	150	10	2	3	31,75
9-5031	150	10	3	3	31,75
9-5032	200	10	3	3	31,75
9-5021	300	14	5,5	3	127
9-5022	300	19	8	3	127
9-5023	300	14	10	3	127
9-5024	300	14	12	3	127
9-5020	350	22	10	5	127

Customer-specific and other grinding tools can be produced on request.

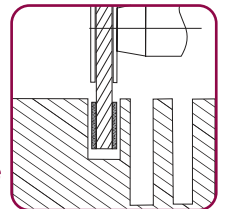
9A3 FLAT GRINDING WHEELS WITH DOUBLE-SIDED RECESS

- Used for sharpening and finishing of carbide tools, machining of glass, ceramics, quartz, semiconducting materials.
- The diamond layer is made of diamond grinding powder with metal or resin bonds.
- For metal bonded tools coolant is required.



9A3 D*W*X*T*H

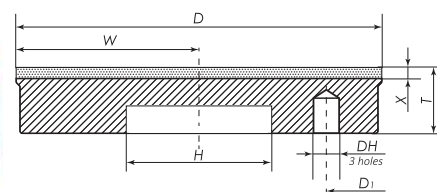
One-pass groove grinding



Catalog number	D, mm	W, mm	X, mm	T, mm	H, mm
3-0132	100	6	1,5	10	20
3-0135	125	10	2	20	32
3-0136	125	15	2	20	32
3-0137	150	6	3	16	32
3-0138	150	10	3	16	32
3-0139	150	20	3	16	32
3-0149	200	20	3	16	32
3-0160	250	10	3	21	76
3-0161	250	20	3	21	76

Customer-specific and other grinding tools can be produced on request.

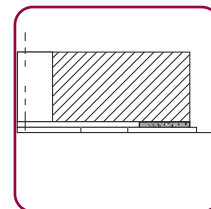
6A2 RECESSED FLAT GRINDING WHEELS



6A2 D*W*X*T*H

- Used for sharpening and finishing of carbide tools (cutters, drills and others)
- Machining of glass, ceramics, quartz, semiconductors and other non-metal materials.
- The diamond layer is made of diamond grinding powder with metal or resin bonds.
- For metal bonded tools coolant is required.

Face grinding



Catalog number	D, mm	W, mm	X, mm	T, mm	H, mm
3-0001	50	3	2	22	16
3-0002	50	5	2	22	16
3-0004	75	5	2	22	20
3-0005	75	10	2	22	20
3-0007	100	5	2	22	20
3-0008	100	10	2	22	20
3-0009	100	15	2	22	20
3-0011	100	5	4	24	20
3-0012	100	10	4	24	20
3-0013	100	15	4	24	20
3-0019	125	6	2	22	32
3-0020	125	10	2	22	32
3-0021	125	15	2	22	32
3-0023	125	6	4	24	32
3-0024	125	10	4	24	32
3-0025	125	15	4	24	32
3-0026	150	6	4	24	32
3-0027	150	10	4	24	32
3-0028	150	20	4	24	32
3-0035	150	6	6	26	51
3-0036	150	10	6	26	51
3-0037	150	20	6	26	51
3-0038	200	10	4	29	51
3-0039	200	20	4	29	51
3-0057	250	20	4	29	76
3-0058	250	40	4	29	76

Flat grinding wheels 6A2 special

Catalog number	D, mm	W, mm	X, mm	T, mm	H, mm
3-2111	50	4	2	10	16
3-0170	100	35	5	20	20
3-0171	150	30	5	20	20
3-1306	250	60	3	23	51
3-1401	500	50	8	34	325

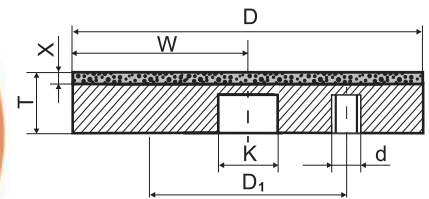
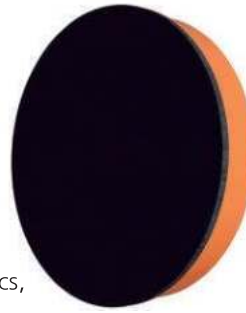
Flat grinding wheels 6A2 special, electroplated

Catalog number	D, mm	W, mm	T, mm	H, mm
6-1217	360	165	18	160
6-1218	400	185	18	160
6-1221	500	235	18	160
6-1219	600	285	18	160
6-1220	700	305	18	200

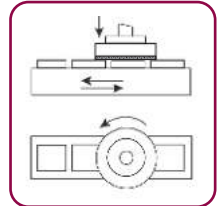
Customer-specific and other grinding tools can be produced on request.

6A2T FLAT GRINDING WHEELS

- Used for machining of flat and shaped surfaces of glass, ceramics, quartz, semiconductors, and decorative stones.
- The diamond layer is made of diamond grinding powder with metal bonds.
- Coolant is required.



6A2T D*W*X*T*D₁*d*H



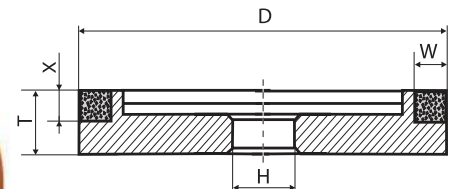
Surface grinding

Catalog number	D, mm	W, mm	X, mm	T, mm	D ₁ , mm	d, mm	H, mm
3-0201	100	50	3	18	70	M8	40
3-0202	150	75	3	18	70	M8	40
3-0203	200	100	3	18	150	M8	80
3-0204	250	125	3	18	150	M8	80
3-0205	300	150	3	20	260	M10	80
3-2807	400	200	2,4	20	260	M10	80

Customer-specific and other grinding tools can be produced on request.

6A9 RECESSED FLAT GRINDING WHEELS

- Used for sharpening and finishing of special tools.
- The diamond layer is made of diamond grinding powder with resin bonds.
- For metal bonded tools coolant is required.



6A9 D*W*X*T*H



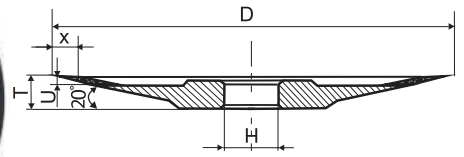
Saw end surface sharpening

Catalog number	D, mm	W, mm	X, mm	T, mm	H, mm
9-8150	100	3	6	30	20

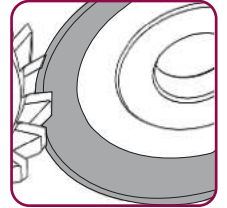
Customer-specific and other grinding tools can be produced on request.

12V9-20 DISH GRINDING WHEELS (PREMIUM LINE)

- Used for sharpening and finishing (face grinding) of circular saw teeth and other tungsten carbide tools.



12V9-20° D*T*X*U*H



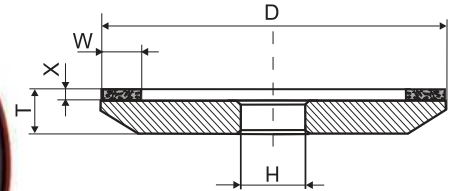
Face grinding

Catalog number	D, mm	T, mm	X, mm	U, mm	H, mm
3-3042	100	10	2,3	4	25
4-4026	120	13	2,5	4	32
3-3048	125	13	2,5	4	32
3D3048	125	13	2,5	4	20
3-3045	150	13	2,3	4	32
4-4026	160	13	2,3	4	32
3-3043	175	13	2,5	4	32
3-3049	200	13	2,3	4	32

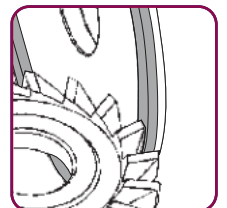
Customer-specific and other grinding tools can be produced on request.

4A2 DISH GRINDING WHEELS

- Used for sharpening and finishing (face and top grinding) of multiple-blade tools.
- The diamond layer is made of diamond grinding powder with metal or resin bonds.



4A2 D*T*X*W*H



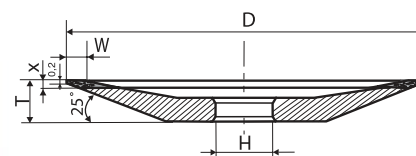
Top grinding

Catalog number	D, mm	T, mm	X, mm	W, mm	H, mm
9-8151	100	10	2	3	20
4-1140	100	10	1	6	22,20
4-1116	100	10	1,5	6	31,75
9-9161	125	10	3	6	31,75
9-9166	125	10	3	6	32
9-9165	125	10	2	8	20
9-3153	125	18	5	6	32
9-8158	150	12	3	5	20
9-9162	150	12	3	6	31,75
9-9167	150	12	3	6	32
4-1141	300	50	2	8	76

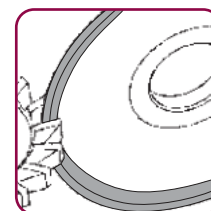
Customer-specific and other grinding tools can be produced on request.

12R4 DISH GRINDING WHEELS

- Used for sharpening and finishing of front surfaces of reamer teeth, cutters, circular saws, drawing dies and tools made of tungsten carbide.
- The diamond layer is made of diamond grinding powder with metal or resin bonds.
- For metal bonded tools coolant is required.



12R4 D*W*X*T*H



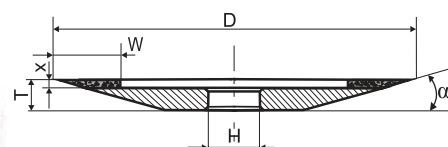
Face grinding

Catalog number	D, mm	W, mm	X, mm	T, mm	H, mm
5-0041	50	2	1,5	6	16
5-0042	75	3	2	10	20
5-0043	100	3	2	10	32
5-0045	150	5	3	16	32
5-1031	100	3	2	10	32
5-1041	125	3	2	13	32
5-1051	150	5	3	16	32
5-1052	150	5	3	16	51
3-3047	200	4	2	13	32

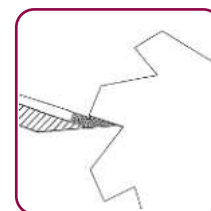
Customer-specific and other grinding tools can be produced on request.

4B2 DISH GRINDING WHEELS

- Used for sharpening and finishing of tool front surfaces.
- The diamond layer is made of diamond grinding powder with resin bonds.
- For metal bonded tools coolant is required.



4B2 D*T*X*W*α°*H



Face grinding

Catalog number	D, mm	T, mm	X, mm	W, mm	α°	H, mm
8-7002	100	10	1,5	6	20	31,75
8-7004	150	12	1,5	6	20	31,75
8-7008	125	10	2	6	20	32
8-7009	150	12	1,5	6	20	32
8-7010	100	10	1,5	6	20	32

Customer-specific and other grinding tools can be produced on request.

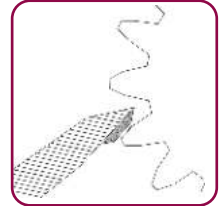
12D9 DISH GRINDING WHEELS

- Used for sharpening and finishing of front and back surfaces of carbide tools.
- The diamond layer is made of diamond grinding powder with metal or resin bonds.
- For metal bonded tools coolant is required.



12D9 D*W*X*T* α *H

Face grinding

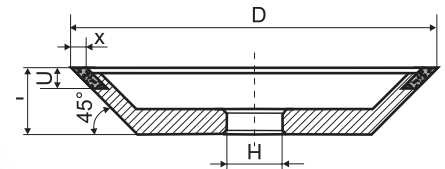


Catalog number	D, mm	W, mm	X, mm	T, mm	α°	H, mm
5-0102	125	4	2	11	20	32
5-0104	125	8	2	11	20	32
5-0106	150	8	3	13	20	32
5-0108	150	16	3	13	20	32
5-0113	200	25	3	16	15	32
5-0114	200	25	3	16	20	32
5-0126	250	16	3	20	20	76
5-0125	250	16	3	20	15	76

Customer-specific and other grinding tools can be produced on request.

12V9-45 DISH GRINDING WHEELS

- Used for sharpening and finishing of cutting tool back surfaces.
- The diamond layer is made of diamond grinding powder with metal or resin bonds.
- For metal bonded tools coolant is required.



12V9-45 D*U*X*T*H

Top grinding

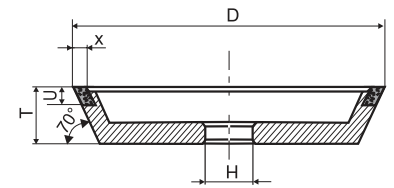


Catalog number	D, mm	U, mm	X, mm	T, mm	H, mm
4-2513	75	10	4	12	31,75
4-2503	75	6	1,5	18	31,75
4-1503	75	6	2	20	20
9-3154	75	6	3,5	20	10
4-2510	100	6	1,5	18	31,75
4-1510	100	10	2	20	20
4-2512	100	10	3	20	31,75
9-3108	125	10	3	25	20

Customer-specific and other grinding tools can be produced on request.

11V9-70 TAPERED CUP GRINDING WHEELS

- Used for sharpening and finishing of back and side surfaces of carbide tools.
- The diamond layer is made of diamond grinding powder with metal or resin bonds.
- For metal bonded tools coolant is required.



11V9-70 D*U*X*T*H



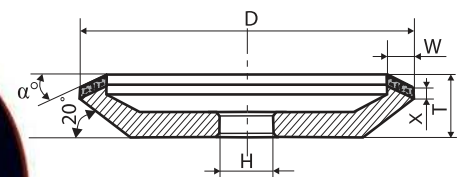
Sharpening of back and side surfaces

Catalog number	D, mm	U, mm	X, mm	T, mm	H, mm
4-0101	50	3	1,5	20	16
4-0102	75	6	2	32	20
4-0103	100	6	2	40	20
4-0104	100	10	2	40	20
4-0105	125	6	3	40	32
4-0106	125	8	3	40	32
4-0107	125	10	3	40	32
4-0108	150	6	3	40	32
4-0109	150	10	3	40	51

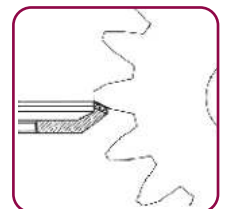
Customer-specific and other grinding tools can be produced on request.

12V5-20 DISH GRINDING WHEELS

- Used for sharpening and finishing of multiple-blade tools, cutter back surfaces (with straight and spiral teeth), drills and other tools made of tungsten carbide.
- Used for processing of semiconducting materials, ceramic materials, quartz and other materials.
- The diamond layer is made of diamond grinding powder with metal or resin bonds.
- For metal bonded tools coolant is required.



12V5-20 D*T*W*X* α° *H

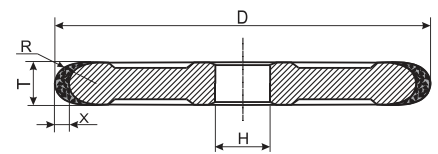


Ram sharpening

Catalog number	D, mm	T, mm	W, mm	X, mm	α°	H, mm
5-0078	75	10	5	2	25	20
5-0080	100	10	3	2	25	20
5-0086	125	13	5	2	25	32
5-0090	150	16	10	3	25	32

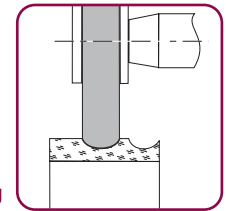
Customer-specific and other grinding tools can be produced on request.

1FF1 FLAT GRINDING WHEELS WITH SEMICIRCULAR-CONVEX PROFILE



1FF1 D*T*X*R*H

- Used for machining chip-breaking flutes in tools.
- Profile grinding.
- The diamond layer is made of diamond grinding powder with metal or resin bonds.
- For metal bonded tools coolant is required.



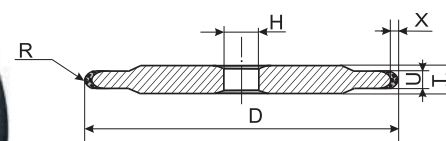
Profile grinding

Catalog number	D, mm	T, mm	X, mm	R, mm	H, mm
9-0001	50	2	2	1,0	16
9-0002	50	3	4	1,5	16
9-0003	50	4	4	2,0	16
9-0004	75	4	4	2,0	20
9-0005	75	5	4	2,5	20
9-0006	75	6	4	3,0	20
9-0007	75	8	4	4,0	20
9-0008	75	10	4	5,0	20
9-0009	100	4	4	2,0	20
9-0010	100	5	4	2,5	20
9-0011	100	6	4	3,0	20
9-0012	100	8	4	4,0	20
9-0013	100	10	4	5,0	20
9-0014	100	12	6	6,0	20
9-0015	100	16	6	8,0	20
9-0016	100	20	6	10,0	20
9-0017	125	4	4	2,0	32
9-0018	125	5	4	2,5	32
9-0019	125	6	4	3,0	32
9-0020	125	8	4	4,0	32
9-0021	125	10	4	5,0	32
9-0022	125	12	6	6,0	32
9-0023	125	16	6	8,0	32
9-0024	125	20	6	10	32
9-0025	150	10	4	5	32
9-0027	150	16	4	8	32
9-0028	150	20	6	10	32
9-0029	200	20	6	10	51
9-0030	200	30	6	15	51
9-0031	250	20	6	10	51
5-9156	80	40	5	26	32
5-9122	100	4	4	2	31,75
5-9123	100	6	4	3	31,75
5-9124	100	8	4	4	31,75
5-9125	100	10	4	5	31,75
5-9185	150	24	7	12	32
5-9188	150	32	7	16	32
9-2802	300	30	5	15	42

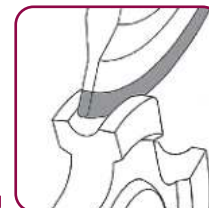
Customer-specific and other grinding tools can be produced on request.

14FF1 DIAMOND GRINDING WHEELS WITH SEMICIRCULAR-CONVEX PROFILE

- Used for machining chip-breaking flutes in tools.
- Profile grinding.
- The diamond layer is made of diamond grinding powder with metal or resin bonds.
- For metal bonded tools coolant is required.



14FF1 D*T*U*X*R*H



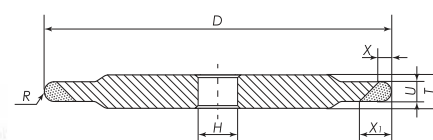
Profile grinding

Catalog number	D, mm	T, mm	U, mm	X, mm	R, mm	H, mm
9-2515	150	8,5	4	4	2	32
9-2639	200	10	3	4	1,5	51
9-2653	200	10	3	4	1,5	60
9-2640	200	10	4	4	2	60
9-2641	200	10	5	4	2,5	60
9-2655	200	10	6	4	3	60
9-0304	200	12	10	5	5	127

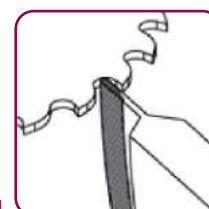
Customer-specific and other grinding tools can be produced on request.

14F1 DIAMOND GRINDING WHEELS WITH SEMICIRCULAR-CONVEX PROFILE

- Grinding wheels for production, re-sharpening and re-profiling of HSS circular blades.



14F1 D*T*U*X*X₁*R*H



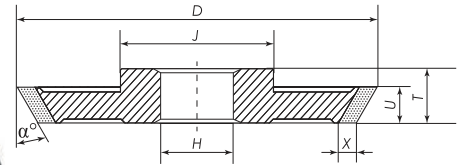
Profile grinding

Catalog number	D, mm	T, mm	U, mm	X, mm	X ₁ , mm	R, mm	H, mm
W-0100	150	8	1,2	4	7	0,60	32
W-0101	150	8	1,3	4	7	0,65	32
W-0102	150	8	1,5	4	7	0,75	32
W-0103	150	8	1,6	5	8	0,80	32
W-0104	150	8	1,8	5	8	0,90	32
W-0105	150	8	2,0	5	8	1,00	32
W-0106	150	8	2,5	8	12	1,25	32
W-0107	150	8	3,0	8	12	1,50	32
W-0108	150	8	3,5	8	12	1,75	32
W-0109	150	8	4,0	10	15	2,00	32
W-0110	150	8	5,0	10	15	2,50	32
W-0111	150	8	5,5	10	15	2,75	32
W-0112	150	8	6,0	10	15	3,00	32

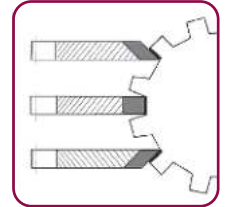
Customer-specific and other grinding tools can be produced on request.

3V1

- Grinding wheels are used for chip-breaker grinding, slotting and cutting surface profiling of shaft tools etc.



3V1 D* T *U*X* α *H



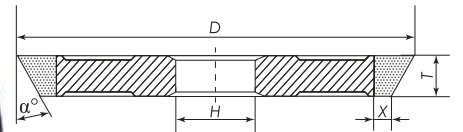
Machining of teeth

Code	D,mm	T,mm	U,mm	X,mm	α°	H,mm
9-5064	125	8	6	5	15	31.75
9-5065	100	8	5	10	45	31.75
9-5066	125	6	3	5	10	31.75
9U5063	100	6	3	10	15	31.75

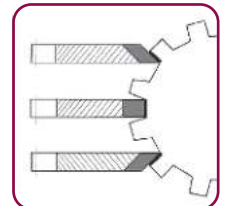
Customer-specific and other grinding tools can be produced on request.

1B1

- Grinding wheels are used for chip-breaker grinding, slotting and cutting surface profiling of shaft tools etc.



1B1 D* T *X* α *H



Machining of teeth

Code	D,mm	T,mm	X,mm	α°	H,mm
OE 0327	200	7	7	30	76
FM1B53	75	10	10	20	20

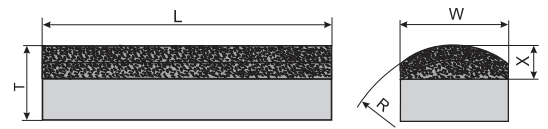
Customer-specific and other grinding tools can be produced on request.

DIAMOND HONING STICKS WITH THE CORPS

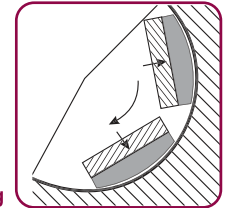
RECOMMENDATIONS FOR DIAMOND HONES

Diamond hones are used for high-precision apertures, processing cast iron, steel and other machine parts such as cylinder blocks, cylinder liners, hubs for car and tractor engines, hydro- and pneumatic units, compressor cylinders, hubs for ship diesel engines, brake units, gears, connecting-rods, fuel pump hubs.

The diamond layer is made of diamond grinding powder with metal or resin bonds.



L*T*X*W*R



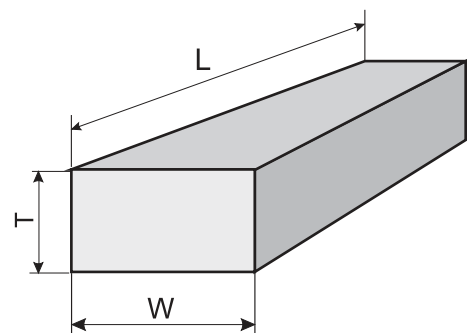
Honing

Catalog number	L, mm	T, mm	X, mm	W, mm	R, mm
2-0007	50	2	1	1	2
2-0004	80	5,2	2	5	37,5
2-0005	80	5	2	3	3
8-0023	100	6	3	5	30
8-0036	100	5	3	8	40
8-0063	150	6	3	16	100
8-0054	150	6	4	12	50

Customer-specific and other grinding tools can be produced on request.

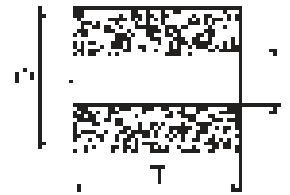
Diamond Honing Sticks (monolayer)

Code	L, mm	W, m	T, mm
125-84	125	8	4
100-84	100	8	4
100-85	100	8	5
80-3-5	80	3	5
80-5-5	80	5	5
75-6-4	75	6	4
75-6-5	75	6	5
60-3-3	60	3	3
50-4-3	50	4	3
50-4-4	50	4	4
50-6-4	50	6	4
50-2-2	50	2	2

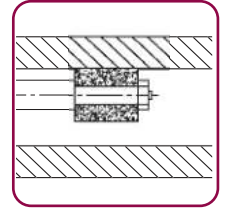


A8 STRAIGHT FLAT GRINDING DIAMOND WHEELS

- Circular internal grinding of cylindrical surfaces of carbide, ceramic, glass and other hard-to-machine materials.
- The diamond layer is made of diamond grinding powder and micropowders with metal or resin bonds.
- For metal bonded tools coolant is required.



A8 D*T*H



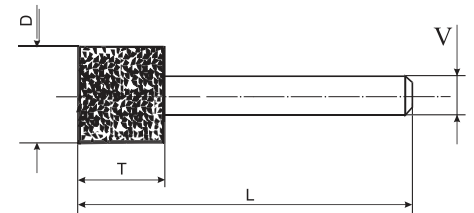
Internal grinding

Catalog number	D, mm	T, mm	H, mm
0-0181	6	6	2
0-0182	8	6	3
0-0183	8	10	3
0-0184	10	6	4
0-0185	10	10	4
0-0187	13	10	4
0-0196	25	20	6
0-0195	20	20	8
6-3024	30,5	11	8
OB0192	12	8	6
0-0192	12	10	4
0-0193	14	10	4

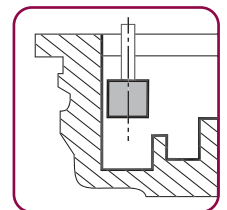
Customer-specific and other grinding tools can be produced on request.

AW CYLINDRICAL DIAMOND POINTS

- Grinding of cylindrical surfaces.
- The diamond layer is made of diamond grinding powder and micropowders with metal or resin bonds.
- For metal bonded tools coolant is required.
- Hollow teeth grinding.
- Inner diameter grinding of hard metal, HSS and nonmetal workpieces.



AW D*T*V*L



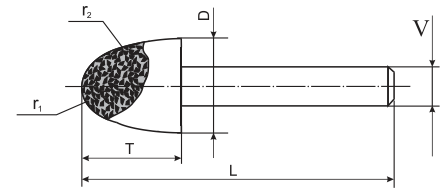
Internal grinding

Catalog number	D, mm	T, mm	V, mm	L, mm
8-1011	6	6	3	60
8-1024	8	8	3	60
8-1033	10	10	6	80
8-1042	12	12	6	80
8-1049	16	16	8	80
8-1058	20	20	8	80
8H1023	7	6	6	45
6D3051	6,5	6	6	40
6-3051	7	6	6	56,4

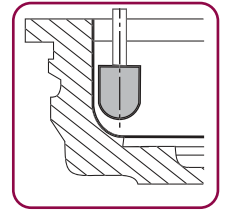
Customer-specific and other grinding tools can be produced on request.

F1W SEMICIRCULAR DIAMOND MOUNTED POINTS

- Internal grinding of complex surfaces.
- The diamond layer is made of diamond grinding powder and micropowders with metal or resin bonds.
- For metal bonded tools coolant is required.



F1W D*T*L*V*r₁*r₂



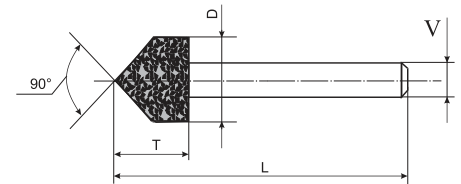
Internal profile grinding

Catalog number	D, mm	T, mm	L, mm	V, mm	r ₁ , MM	r ₂ , MM
9-3130	6	9	60	3	1,5	12
9-3132	8	12	60	3	1,5	15
9-3137	10	14	60	6	2	15
9-3144	12	16	80	6	2	22
9-3146	16	20	80	8	3	25
9-3148	20	24	80	8	3,5	29

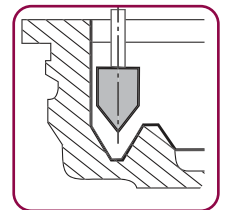
Customer-specific and other grinding tools can be produced on request.

EW TAPERED DIAMOND MOUNTED POINTS

- Internal grinding of complex surfaces.
- The diamond layer is made of diamond grinding powder and micropowders with metal or resin bonds.
- For metal bonded tools coolant is required.



EW D*T*V*L

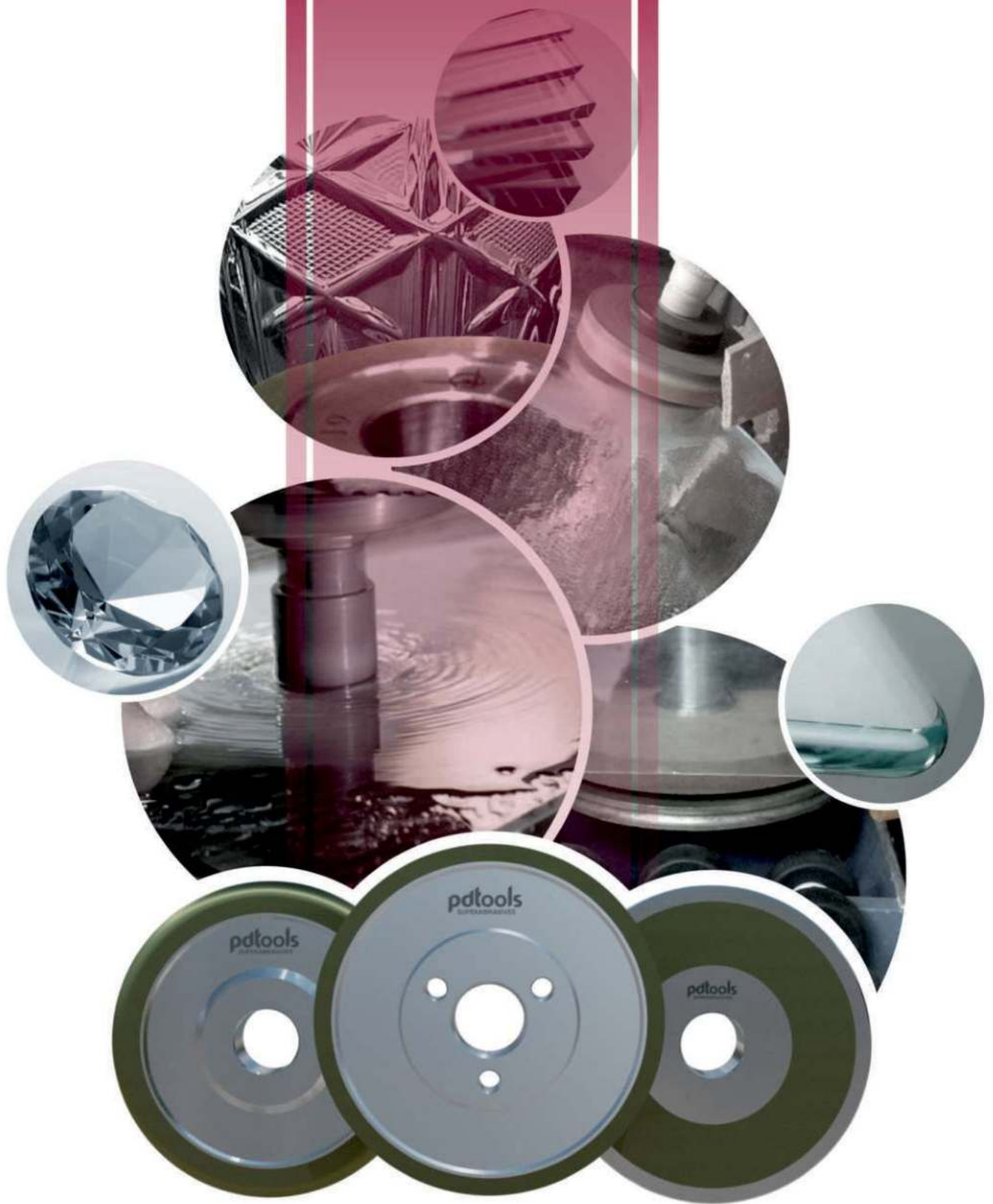


Internal grinding

Catalog number	D, mm	T, mm	V, mm	L, mm
9-3111	6	6	3	40
9-3112	6	6	4	40
9-3113	8	8	3	40
9-3114	8	8	6	40
9-3115	10	9	6	60
9-3117	12	10	6	60
9-3121	20	18	8	80

Customer-specific and other grinding tools can be produced on request.

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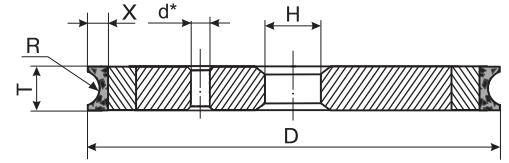
**DIAMOND GRINDING WHEELS
FOR MACHINING OF GLASS,
CRYSTAL, DIAMONDS, CERAMICS**

DIAMOND FLAT GRINDING WHEELS WITH SEMICIRCULAR-CONCAVE PROFILE FOR MACHINES BY:

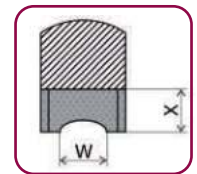
SULAK, INTERMAC, Z.BAVELLONI, SZILANK, etc.

DIAMOND WHEELS FOR GLASS PROCESSING (A-LINE EDGE) (PREMIUM LINE)

1F6V



1F6V D*T*X*W*R*H

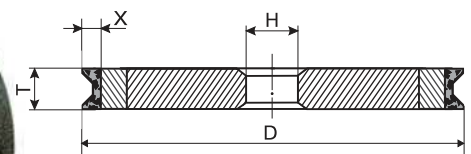


Glass thickness, mm	Code	D, mm	T, mm	X, mm	R, mm	W, mm	H, mm
2	FL-310	150	7	6	1,8	3,2	22
3	FL-311	150	8	6	2,25	4,2	22
4	FL-312	150	9	6	2,7	5,2	22
2	FS-310	150	7	6	1,8	3,2	22
3	FS-311	150	8	6	2,25	4,2	22
4	FS-312	150	9	6	2,7	5,2	22

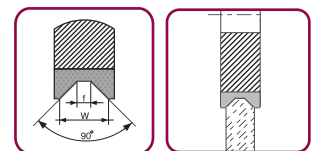
Customer-specific and other grinding tools can be produced on request.

DIAMOND WHEELS FOR GLASS PROCESSING (A-LINE EDGE) (PREMIUM LINE)

1DD6V



1DD6V D*T*X*f*W*H



Machining of technical glass edges

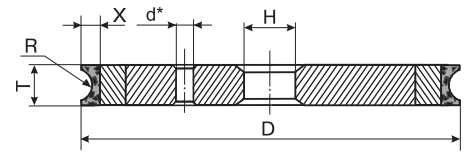
- Processing of technical glass edges and mirrors on machines by Sulak, Intermac, Z.Baveloni, Szilank, etc.
- Diamond layer is made of diamond grinding powders with metal bonds.
- Coolant is required.

Glass thickness, mm	Code	D, mm	T, mm	X, mm	f, mm	W, m	H, mm
4	DL-311	150	8	7	2,5	5	22
5	DL-312	150	9	7	3,3	6	22
6	DL-313	150	10	7	4	7	22
8	DL-314	150	12	7	5,3	9	22
10	DL-315	150	14	7	7,5	11	22
12	DL-316	150	16	7	9,5	13	22
4	DS-311	150	8	7	2,5	5	22
5	DS-312	150	9	7	3,3	6	22

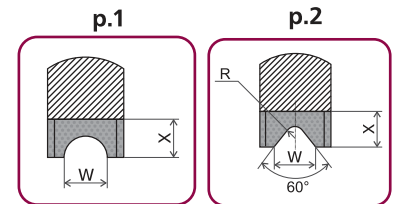
Customer-specific and other grinding tools can be produced on request.

1F6V

DIAMOND WHEELS
FOR GLASS PROCESSING
(A-LINE EDGE)
(STANDARD LINE)

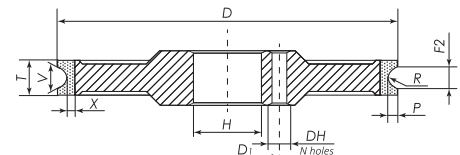


1F6V D*T*X*W*R*H

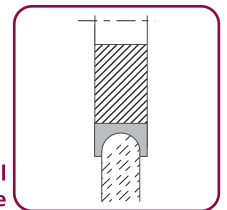


14F6V

(STANDARD LINE)



14F6V D*T*U*X*R*W*H



Machining of technical glass edge

d*- at D=150, 2 apertures \varnothing 7,0 x 180° by \varnothing 70
d*- at D=175, 3 apertures \varnothing 8,5 x 120° by \varnothing 76

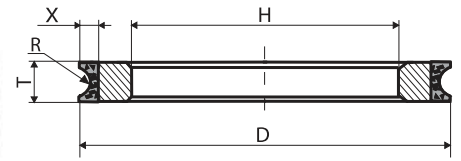
- Processing of technical glass and mirrors
- Diamond layer is made of diamond grinding powders and micro grinding powders with metal bonds.
- Coolant is required.

Glass thickness, mm	Wheel form	Pic.	Code	D, mm	T, mm	U, mm	X, mm	R, mm	W, mm	H, mm
2	1F6V	1	150-02	150	10	-	5	1,4	2,7	22
3	1F6V	2	150-03	150	12	-	8	1,6	4,2	22
4	1F6V	2	150-04	150	12	-	8	2,0	4,6	22
5	1F6V	2	150-05	150	12	-	8	2,5	5,8	22
6	1F6V	2	150-06	150	12	-	8	4,0	8,1	22
8	1F6V	1	150-08	150	18	-	9	5,5	11,0	22
10	1F6V	1	150-10	150	18	-	8	8,6	12,1	22
2	14F6V	1	175-02	175	12	11	7	1,4	2,7	63,4
3	1F6V	2	175-03	175	12	-	7	1,6	4,2	63,4
4	1F6V	1	175-04	175	12	-	8	2,5	5,0	63,4
5	1F6V	2	175-05	175	12	-	8	2,5	5,8	63,4
6	14F6V	2	175-06	175	14	12	8	4,0	7,5	63,4
8	14F6V	1	175-08	175	17	12	8	5,5	10,0	63,4

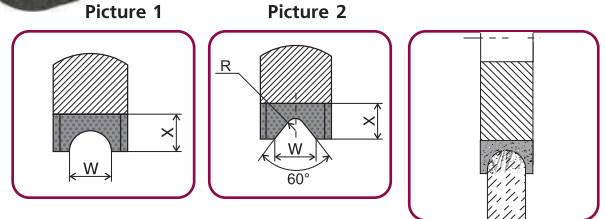
Customer-specific and other grinding tools can be produced on request.

2F6V (STANDARD LINE) FLAT DIAMOND GRINDING WHEELS WITH SEMICIRCULAR-CONCAVE PROFILE

- Machining of edges of industrial glass.
- The diamond layer is made of diamond grinding powder and micropowders with metal bonds.
- Usage of coolant is obligatory.



2F6V D*T*X*R*W*H



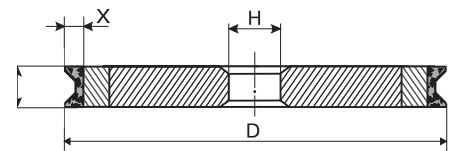
Machining of edges of industrial glass

Glass thickness, mm	Code	Pic.	D, mm	T, mm	X, mm	R, mm	W, mm	H, mm
3	9-0121	2	200	20	8,0	2,0	4,2	130
2	9-0112	1	250	9	7,0	1,6	3,2	200
3	9-0113	1	250	9	7,0	1,8	3,6	200
3	9-0114	1	250	9	7,0	2,0	4,0	200
3	9-0117	2	250	10	6,0	1,6	4,0	200
4	9-0115	1	250	12	7,0	2,5	5,0	200
5	9-0101	1	250	12	7,0	3,0	6,0	200
6	9-0116	1	250	17	7,0	4,0	8,0	200
8	9-0103	1	250	17	9,0	5,0	10,0	200

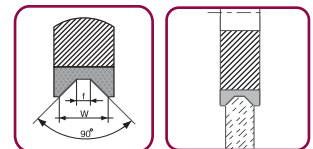
Customer-specific and other grinding tools can be produced on request.

1DD6V FOR GLASS PROCESSING (STANDARD LINE)

- Processing of technical glass edges and mirrors on machines by Sulak, Intermac, Z.Baveloni, Szilank, etc.
- Diamond layer is made of diamond grinding powders with metal bonds.
- Coolant is required.



1DD6V D*T*X*f*W*H



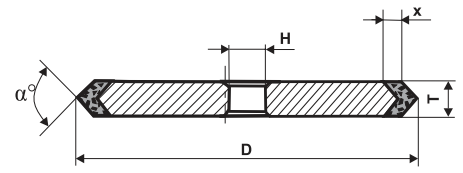
Machining of technical glass edges

Glass thickness, mm	Code	D, mm	T, mm	X, mm	f, mm	W, m	H, mm
4	150T04	150	14	4,5	2,5	6,5	22
5	150T05	150	14	4,5	3,0	7,0	22
6	150T06	150	14	4,5	3,5	7,5	22
8	150T08	150	16	4,5	5,0	9,0	22
10	150T10	150	16	4,5	7,0	11,0	22

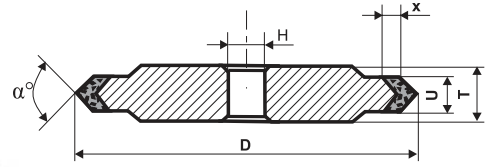
Customer-specific and other grinding tools can be produced on request.

1EE1 14EE1 FLAT GRINDING WHEELS WITH DOUBLE-SIDED CONICAL PROFILE

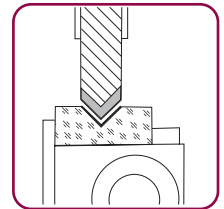
- Processing of industrial and decorative glass, crystal, external threading and grinding.
- Grinding of profiled workpieces made of carbide and other hard to process materials.
- The diamond layer is made of diamond grinding powder and micro-powders with metal or resin bonds.
- For metal bonded tools coolant is required.



1EE1 D*T*X* α° *H



14EE1 D*T*X* α° *H



Glass cutting

Type 1EE1

Catalog number	D, mm	T, mm	X, mm	α°	H, mm
9-0616	30	4	2,5	30	6
7-1175	50	10	5	90	16
9-0035	50	10	5	120	16
7-0186	75	16	5	110	32
9-0618	80	10	10	120	32
7-1240	100	10	10	90	42
7-1246	100	10	10	120	42
7-0190	150	8	5	90	32
7-0191	150	8	5	110	32
7-0274	150	10	5	120	42
9-0539	150	10	10	90	32
9-0531	150	10	10	120	42
7-0193	150	12	5	90	32
7-0197	150	12	10	110	32
7-0303	150	12	10	110	42
7-0196	150	12	10	90	32
7-0200	150	16	5	110	32
7-0203	150	16	10	110	32
9-0034	200	10	10	90	42
9-0540	200	10	10	120	42
7-0210	250	10	10	110	32
7-0215	250	12	10	110	32
7-0216	250	16	5	90	32
7-0217	250	16	5	110	32

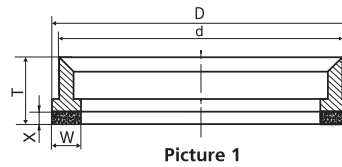
Type 14EE1

Catalog number	D, mm	T, mm	U, mm	X, mm	α°	H, mm
9-3229	125	6	3	3	90	32
9-3133	125	6	3	4	60	32
9-3204	125	6	3	5	45	32
9-3203	125	6	3	6	35	32
9-3201	150	6	3	4	50	32
9-3239	150	8	5	3	90	32
9-3171	200	10	6	3	90	60
7-0154	250	10	6	5	110	32
7-0158	250	10	8	5	110	32
9-3226	350	15	6	4	60	127

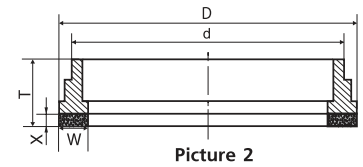
Customer-specific and other grinding tools can be produced on request.

2A2 DIAMOND RING WHEELS

- Grinding of spherical and flat surfaces made of non-metal hard materials (glass, silicon).
- Production of tube drills with diameters more than 20 mm.
- The diamond layer is made of diamond grinding powder and micropowders with metal bonds.
- Usage of coolant is obligatory.



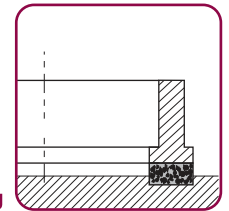
Picture 1



Picture 2



2A2 D*T*W*X*d



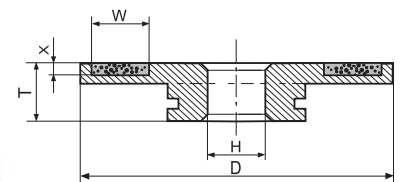
Hole drilling

Catalog number	Picture	D, mm	T, mm	W, mm	X, mm	d, mm
6-0100	1	30	32	5	10	30
6-0101	1	35	32	5	10	25
6-0102	1	40	32	5	10	30
6-0103	1	60	32	5	10	50
6-0104	1	50	32	5	10	40
6-0105	1	70	32	5	10	60
6-0106	1	80	32	5	10	70
6-0107	2	50	31	2,5	8	47
6-0108	2	60	31	2,5	8	57
6-0109	2	70	31	2,5	8	67
6-0110	2	80	31	2,5	8	77

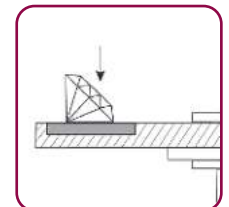
Customer-specific and other grinding tools can be produced on request.

1A2 FLAT DIAMOND GRINDING WHEELS

- Processing of diamonds, precious and semiprecious stones, decorative stones.
- Made with axis and without.
- The diamond layer is made of diamond grinding powder and micropowders with metal bonds.



1A2 D*T*W*X*H

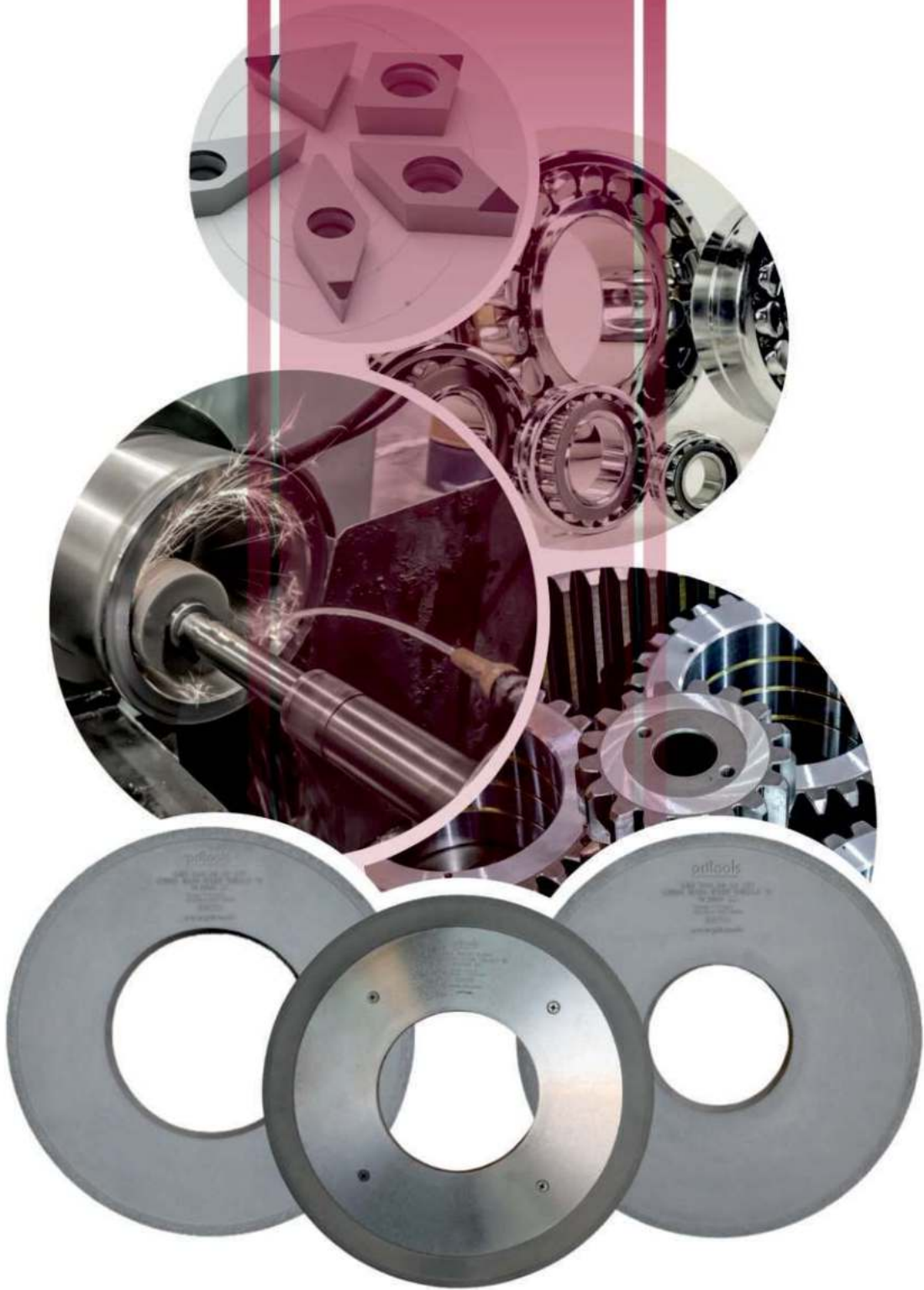


Diamond faceting

Catalog number	D, mm	T, mm	W, mm	X, mm	H, mm
9-3050	270	22	30	2	50
9-3033	320	16	30	1,5	114
9-3034	315	22	30	1,5	114
9-3038	315	16	30	2	114
9-3035	315	22	40	1,5	114
9-3036	315	10,5	60	1,5	114
9-3037	315	22	40	1,5	50,8
9-3045	315	22	60	1,5	50,8
9-3042	315	44	60	2	30

Customer-specific and other grinding tools can be produced on request.

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VITRIFIED BONDED CBN GRINDING WHEELS

Vitrified bonded CBN grinding wheels

The Application Area

- cylindrical grinding, flat grinding, internal grinding operations
- producing of details for bearing industry etc.
- sharpening of metal cutting tools
- gear-grinding operations
- thread-grinding operations
- producing parts for turbine etc.

Main Processed Materials

- instrument steel (P18, P6M5 etc.)
- bearing steel
- titanium alloy
- heat-resistant steel
- alloy-threaded steel



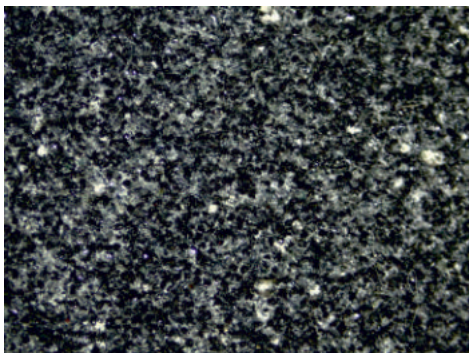
Recommendations for Wheel's Hardness Selection

Table 1. Types of hardness

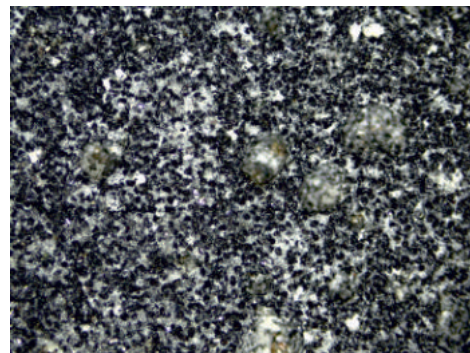
Group of Hardness	Designation in accordance with ISO Standards
Soft	J
	K
	L
Medium-soft	M
	N
	O
Hard	P
	Q
	R
	S

Main Rules for Vitrified Bonded Grinding Wheels Hardness Selection

1. Grinding of hard materials – soft bond.
The soft bond also could be used for grinding of soft and yielding materials, such as heatproof and nonferrous alloys.
2. For rough grinding should be used wheels with harder bond.
3. In case of speed rising client should decrease the hardness of the bond.
4. In case of large contact of grinding wheel with processed surface should be used softer bond.



VBA05 - normal porosity



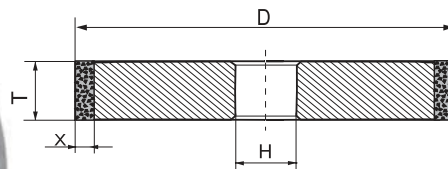
VBB05 - extended porosity

Grit and bond hardness recommendations for vitrified bonded wheels

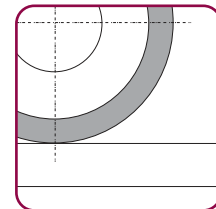
Grinding method	Grit size	Hardness
Surface grinding: Peripheral grinding, Ra 0,32 - 1,25 Face grinding, Ra 0,16 - 0,63	B91...B126 B54...B76	L-M K-L
Internal grinding:	B64...B126	O-R
Cylindrical grinding: In-feed grinding, Ra 0,32 - 1,25 Traverse grinding Ra 0,16- 0,63	B126...B151 B54...B107	N-O M-N
Gear grinding: Module < 3 mm Module > 3 mm	B76...B91 B107...B151	L-N K-M
Thread grinding: Pitch of thread 0,5-0,8 mm Pitch of thread 0,8-1 mm Pitch of thread 1-1,5 mm Pitch of thread > 1,5 mm	B16...B25 B25...B40 B40...B54 B54...B76	P-S O-P M-N L-N

1A1 STRAIGHT GRINDING WHEELS

- Grinding wheels are used for surface, cylindrical, ID and centerless grinding of forged, cemented, bearing, heat-resistant, tool, alloyed, high-speed steels etc.



1A1 D*T*X*H



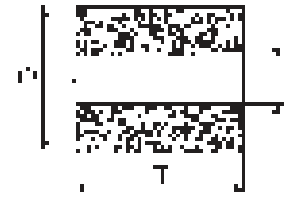
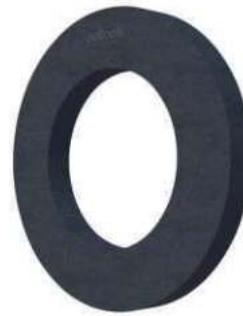
Flat surface grinding

Catalog number	D, mm	T, mm	X, mm	H, mm
K-0085	125	10	5	32
K-0124	20	30	5	10
K-0125	30	30	5	10
K-0126	32	20	5	10
K-0123	20	30	3	10
K-0127	35	32	5	10
K-0129	40	20	5	10
K-0130	40	32	5	20
K-0115	50	40	5	20
KD0119	60	50	5	32
K-0118	60	40	5	20
K-0117	60	32	5	20
K-0116	60	20	5	32
KB0085	125	4	5	32
KB0148	100	20	5	32
K-0120	70	20	5	20
K-0068	125	20	5	32
KG0055	150	20	5	32
K-0055	150	10	5	32
KD0004	200	8	5	32
K-0004	200	10	5	32
KB0036	200	10	10	32
K-0002	200	20	5	32
KL0036	200	20	10	32
KJ0011	250	20	10	76
KL0011	250	25	10	76
KD0011	250	16	10	76
K-0011	250	20	5	76
KB0003	300	13	5	127
K-0318	300	20	10	127
K-0320	300	40	10	127
K-0013	350	20	5	127
K-0319	350	20	10	127
K-0321	350	40	10	127
K-0199	400	20	10	203
K-0198	400	20	10	127
K-0200	400	40	10	203
K-0200	400	40	10	127
K-0203	450	40	5	127
K-0205	500	50	6	203

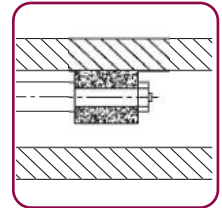
Customer-specific and other grinding tools can be produced on request.

A8 STRAIGHT FLAT GRINDING DIAMOND WHEELS

- Grinding wheels are used for internal (ID) grinding of forged, cemented, bearing, heat-resistant, tool, alloyed, high-speed steels etc.



A8 D*T*H



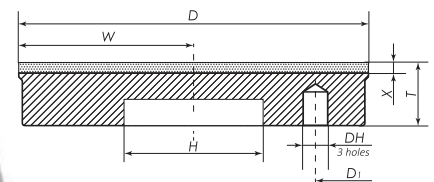
Internal grinding

Catalog number	D, mm	T, mm	H, mm
K-0185	10	10	4
KD0185	10	14	4
KB0192	12	18	4
KG1791	15	20	5
KB1791	15	25	5
KD0223	18	20	6
Kb0113	25	30	6
K-0121	12	20	5
KG0192	12	16	4
KB0038	10	18	3
KB0023	6	10	3
K-0255	4	10	1,6
K-0256	5	10	2,6
K-0257	6	10	2,6
KB0022	8	14	3
K-0038	10	10	3
K-0039	15	10	4
K-0122	15	18	4
K-0223	20	20	6
K-0195	20	20	8
K-0007	25	20	10
K-0132	30	30	10
K-0128	35	35	10
KB0025	40	40	10
K-0131	60	32	20

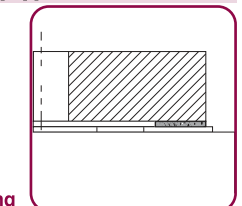
Customer-specific and other grinding tools can be produced on request.

6A2 FLAT RECESSED DIAMOND GRINDING WHEELS (PREMIUM LINE and STANDART)

- Grinding wheels are used for surface, cylindrical, face grinding of forged, cemented, bearing, heat-resistant, tool, alloyed, high-speed steels etc.



6A2 D*W*X*T*H



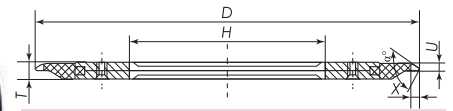
Face grinding

Code	D, mm	W,mm	X,mm	T,mm	H,mm
K-0062	100	15	10	40	20
K-0064	100	15	10	40	40
K-0067	125	5	10	40	40
K-0001	150	20	10	40	40
K-0033	150	20	10	40	40
K-0051	150	15	10	40	40

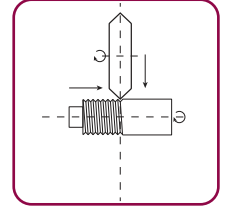
Customer-specific and other grinding tools can be produced on request.

1E6Q

- Grinding wheels are used for grinding of metric, pipe, trapezoidal (tapered), buttress threads of different hard steels etc.



1E6Q D*T*U*X*α°*H



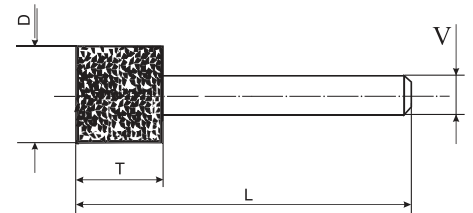
Thread grinding

Code	D,mm	T,mm	U,mm	X,mm	α°,mm	H,mm
K-0014	400	14	10	4	40	203
K-0015	400	14	10	4	60	203
K-0016	400	14	10	4	90	203
K-0017	400	14	10	6	40	203
K-0018	400	14	10	6	60	203
K-0019	400	14	10	6	90	203

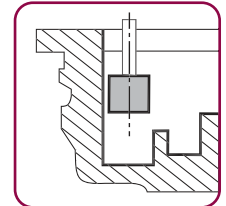
Customer-specific and other grinding tools can be produced on request.

AW CYLINDRICAL DIAMOND POINTS

- Grinding of cylindrical surfaces.
- The diamond layer is made of diamond grinding powder and micropowders with metal or resin bonds.
- For metal bonded tools coolant is required.
- Hollow teeth grinding.
- Inner diameter grinding of hard metal, HSS and nonmetal workpieces.



AW D*T*V*L



Internal grinding

Catalog number	D, mm	T, mm	V, mm	L, mm
K-0322	4	10	1,6	50
K-0323	5	10	2,6	50
K-0324	6	10	2,6	50

Customer-specific and other grinding tools can be produced on request.

pdtools
SUPERABRASIVES



DIAMOND PASTES

DIAMOND PASTES

Diamond pastes are used for the finishing and polishing of ferrous and nonferrous metals, steels and semiconductors, alloyed steels, cast irons, ceramics, metal ceramics, carbide, sapphire, glass, semiconductors, and drawing dies.

Paste made of synthetic diamond ACH micropowders, grit size M40, with normal diamond volume content and washable by water would be marked as follows: ACH M40 N W L.

Diamond pastes act on the workpiece surface chemically and mechanically. They form fine-dispersion emulsions that allow for a smoother distribution of diamonds over the workpiece surface. The paste also contains active surface agents, which make washing easier and help to remove slightly flammable liquids, chips and slag generated by the lapping process.

Pastes are produced with normal (N), higher (H) and extra-high concentration (E), depending on the volume content of diamonds and their grit size.

Volume content of diamond powder in diamond pastes.

Diamond powder grit size	Volume content of diamond in pastes. %			Color of paste and label
	N	H	E	
D126-D76	40	60	-	Lilac
D64-D54	20	40	-	
M63-M40	8	20	40	Red
M25-M16	6	15	30	Blue
M10-M4	4	10	20	Green
M2,5-M1	2	5	10	Yellow
1/0,5-0,1/0 mcm	2	5	10	Not colored

We can also produce pastes with other diamond volumes, without color and with non-standard diamond grit sizes. Pastes are delivered to consumers in syringes of 5, 10, and 20 grams, in containers of 50 and 100 grams, or in cans of 500 or 1000 grams. On request other packing is possible.

Depending on their ingredients, pastes are classified as follows:

(O) can be washed by organic solvents such as kerosene, petrol, alcohol, etc.

(W) can be dissolved and washed off by water.

(WO) can be washed off by water and by organic solvents, such as alcohol, industrial oils, petrol, kerosene.

Depending on grit size, pastes can be used for different finishes:

Diamond powder grit sizes	Surface roughness, Ra ,mcm		Operation
	Before	After	
D126-D54	-	-	Rough finishing
M63-M40	0,4 - 0,2	0,195 - 0,155	
M25-M16	0,16 - 0,1	0,12 - 0,075	Semi- finishing
M10-M4	0,08 - 0,05	0,06 - 0,038	Fine finishing
M2,5-M1	0,04 - 0,025	0,03 - 0,02	Preliminary polishing
1/0,5 - 0,1/0	-	-	Polishing

Abrasive capabilities of pastes

Diamond grit size	Abrasive paste quality, mg, not less than		
	N	High	Extra-high
M63	67	127	175
M40	62	123	163
M25	57	112	157
M20	52	102	153
M16	47	97	148
M10	42	93	143
M6.3	37	82	137
M4.0	32	65	108

Applications of diamond pastes

Type of paste	Rinseability	Application
Г (G)	O	Machining of ferrous and non-ferrous metals, alloys, non-metal materials, steels and semiconducting materials.
Л (L)	BO	Machining of alloyed steels, cast iron, ceramics, cermet, tungsten carbide, ferrite, sapphire
X (X)	B, BO	Machining of glass, semiconducting materials, carbide tools, dyes
Э (E)	BO	Machining of glass, semiconducting materials, carbide tools.

Attention! POLTAVA DIAMOND TOOLS produces paste with titanium carbide (TC).

TC abrasive pastes are used for the finishing and polishing of machine parts in the aviation industry, precision ball bearings, shut-off brake equipment, pneumatic equipment (plugs, valves, hydrocyclones), fuel equipment (seat plugs, valves), and tooling.

CUBIC BORON NITRIDE PASTES

Cubic Boron Nitride Pastes is produced for semi-finishing and finishing operations. It is used for finishing and polishing operations of carbon and alloy steel, chilled iron.

Past composition is next: cubic boron nitride powder, filler with organic oils, fatty acids, carbons of paraffin series and its derivate, polymer material. Cubic Boron Nitride Paste affects on processed surface with chemical and mechanical influence. The past composition consists of surface active materials, they help with washing workpieces, and output the slags from the processing surface.

It increases productivity and the roughness of the surface.

The paste divides:

"N" – normal consistency

"H" – higher consistency

"E" – extra-high consistency

We use the organic solvent: kerosene, engine oil, alcohol.

The data for grit correspondence and abrasive facilities and roughness are in the table.

Grit size of CBN powder	The color of the paste and label	Abrasive capacity of steel processing HRC			Surface roughness (Ra), mkm, not more	
		N	H	E	Before processing	After processing
B213; B151		-	-	-	-	-
B126 – B91		-	-	-	-	-
60/40 µm	Red	67	127	175	0,4	0,195
40/28 µm		62	123	163	0,2	0,155
28/20 µm	Blue	57	112	157	0,16	0,12
20/14 µm		52	102	153	0,125	0,095
14/10 µm		47	97	148	0,1	0,075
10/7 µm	Green	42	93	143	0,08	0,06
7/5 µm		37	82	137	0,063	0,045
5/3 µm		32	65	108	0,05	0,038
3/2 µm	Yellow	-	-	-	0,04	0,03
2/1 µm		-	-	-	0,32	0,23
1/0 µm		-	-	-	0,25	0,02

The paste is delivered to the customers in container of 40, 50 and 100 grams.

The other package for pastes is possible according to client's request.

Storage temperature 25±5°C.

CARBIDE TITANIUM PASTES

Abrasive Carbide Titanium Paste – consists of composition of classified according to carbide titanium powders grit sizes and surface-active materials.

The pastes are used for finishing and polishing of details for aerotechnics, high-precision bearing, blocking devices and pneumatic motor (cranes, faucets, hydraulic cyclones), fuel injection equipment (plunger pairs, valves), tool outfits and rough grinding of details and knots.

Abrasive pastes have grit sizes: micro grits D426 – D54; micro powders M63 – M4.0.

The paste concentration in accordance with part of carbide titanium powder are

“N” – normal consistency

“H” – higher consistency

“E” – extra-high consistency

In accordance with consistence carbide titanium paste divide into

“M” – salvelike

“T” – hard

THE SELECTION OF GRIT SIZE DEPENDS ON TYPE OF PROCESSING

Type of processing	Grit size of paste, μm	Expenditure of paste, gr/SM^2	Roughness of surface (Ra), μm	
			before processing	after processing
Rough processing	630/500-50/40	0,8-1,5		0,32
Semi-finishing processing	60/40-14/10	0,4-0,9		0,10
Finishing processing	14/10-3/2	0,2-0,6		0,032
Polishing	3/2-1/0	0,1-0,4		0,020

For diluting of pastes with oil base is recommended to use engine and aero oil, kerosene, gasoline;

paste with water-washable base – alcohol, water.

The lap should be made of cast iron, latten, glass, wood (birch, oak, beech), felt etc.

The Abrasive capacity of pastes and the roughness of processed surface are in the table.

Grit size of carbide titanium paste	Abrasive capacity of paste, mg, not less		Roughness of surface (Ra), μm	
	N	H	before processing	after processing
160/125	50	55	-	-
125/100	45	50	-	-
100/80	40	45	-	-
80/63	37	43	-	-
63/50	34	40	-	-
50/40	30	38	-	-
60/40	28	36	0,32	0,25
40/28	26	34	0,25	0,20
28/20	24	32	0,20	0,16
20/14	21	30	0,16	0,125
14/10	18	27	0,125	0,10
10/7	15	27	0,10	0,08
7/5	12	18	0,08	0,063
5/3	10	14	0,063	0,05
3/2	-	-	0,05	0,04
2/1	-	-	0,04	0,032