

Electroplated Grinding Wheels, C02



Characteristics

Electroplated grinding wheels use high-grade diamond and CBN (borazon) as the abrasive material. They are manufactured on steel bodies, where the profile of the working surface of the grinding wheel precisely reflects the shape of the machined component. The wheel profile contains a single layer of abrasive grain with a selected grit size; therefore, the wheel operates exclusively until this layer is worn and does not require dressing. These grinding wheels can be regenerated, and their bodies can be reused for the application of a new abrasive grain layer. Within this product category, discs with any profile can be manufactured according to user requirements.

Application

These grinding wheels are used for sharpening band saws of the WM, Fenes Standard, Lenox, and Roma types, as well as for machining amber, glass, plastics, concrete, medical prosthetic components, brake pads, and in laminated boat production, as well as in many other industries.

The most important advantages of electroplated grinding wheels are as follows:

- long service life
- the ability to machine components with complex shapes using a single tool
- high machining accuracy
- low temperature of the machined workpiece
- no need for dressing
- grinding wheels can be regenerated



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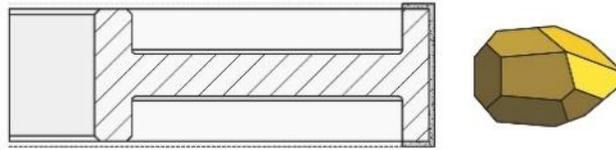
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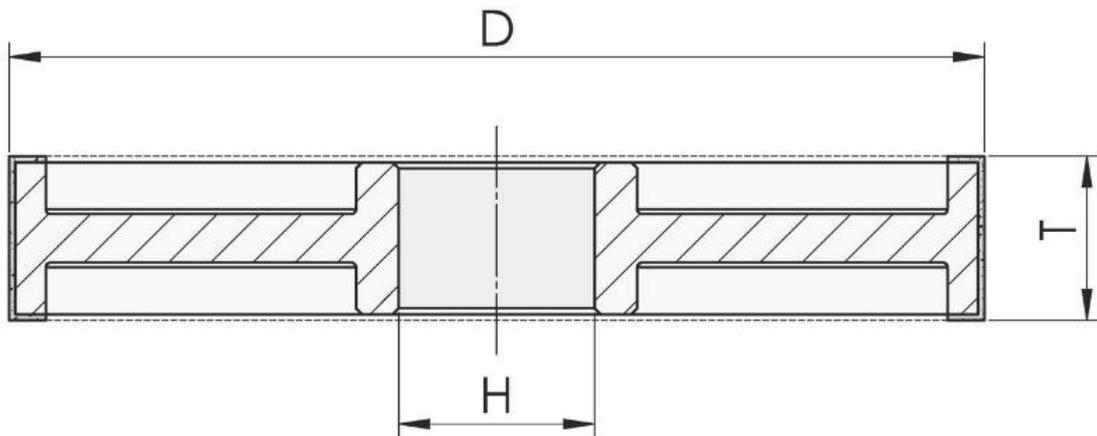
Grinding Wheels – Type 1A1

Application

The electroplated diamond grinding wheel type **1A1** is intended for machining amber on LUX-type grinding machines.



Dimensions



D	T	H
150	20 25	as per order

Order Example

Wheel type	D T H	Body	Grain	Binder	Assortment
1A1	150x20x20	KS	D107	G	1A1-150x20x20 KS D107 G
1A1	150x25x32	KS	D126	G	1A1-150x25x32 KS D126 G



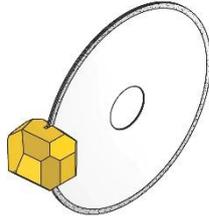
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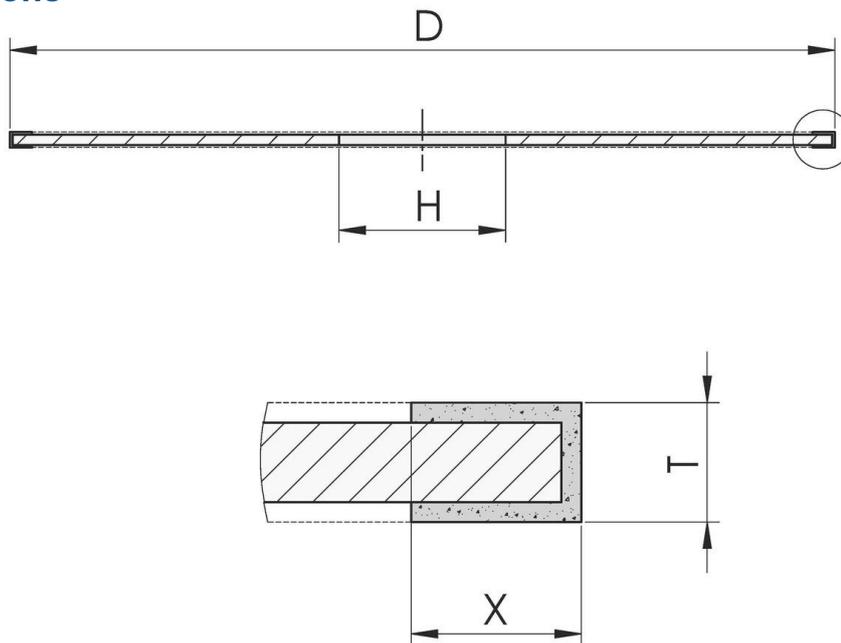
Grinding Wheels – Type 1A1R

Application

The electroplated grinding wheel type **1A1R** is intended for cutting plastics, laminates, amber, graphite, silicon, and other difficult-to-machine materials.



Dimensions



D	T	X	H
75	0,6 0,8	5	≤ 32
100	0,6 0,8	5	as per order
125	0,8 1 1,2	5	as per order
150	0,8 1 1,2	5	as per order
175	1 1,2 1,6	5	as per order
200	1 1,2 1,6 2	6	as per order
250	1 1,2 1,6 2 2,5	7	as per order
300	2 2,5 3 3,5	8	as per order
350	3 3,5 4	8	as per order
400	3 3,5 4	10	as per order

Order Example

Wheel type	D T X H	Body	Grain	Binder	Assortment
1A1R	150x0,8x5x20	KS	D126	G	1A1R-150x0,8x5x20 KS D126 G
1A1R	200x1,6x6x32	KS	D151	G	1A1R-200x1,6x6x32 KS D151 G



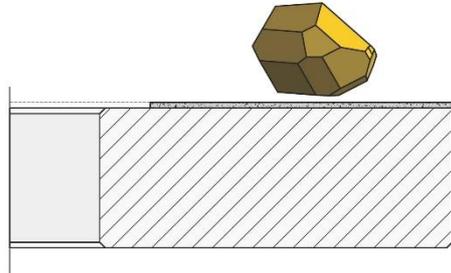
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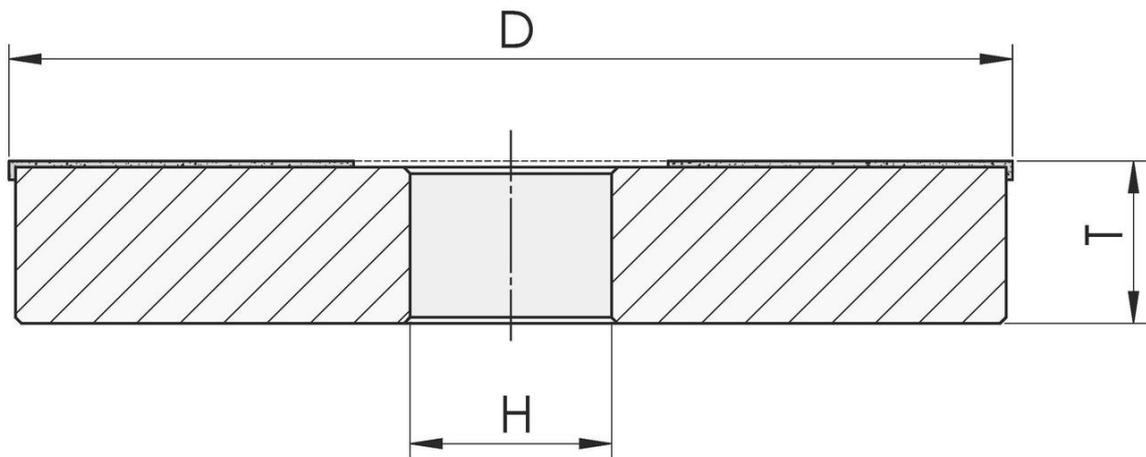
Grinding Wheels – Type 1A2

Application

The electroplated diamond grinding wheel type **1A2** is intended for rough machining (debarking) of amber.



Dimensions



D	T	H
150	10	as per order
175	10	as per order
200	15	as per order
250	15	as per order
300	15	as per order

Order Example

Wheel type	D T H	Body	Grain	Binder	Assortment
1A2	150x10x20	KS	D107	G	1A2-150x10x20 KS D107 G
1A2	250x15x32	KS	D126	G	1A2-250x15x32 KS D126 G



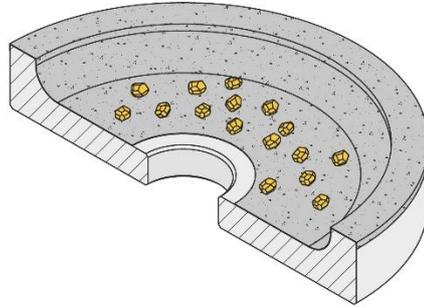
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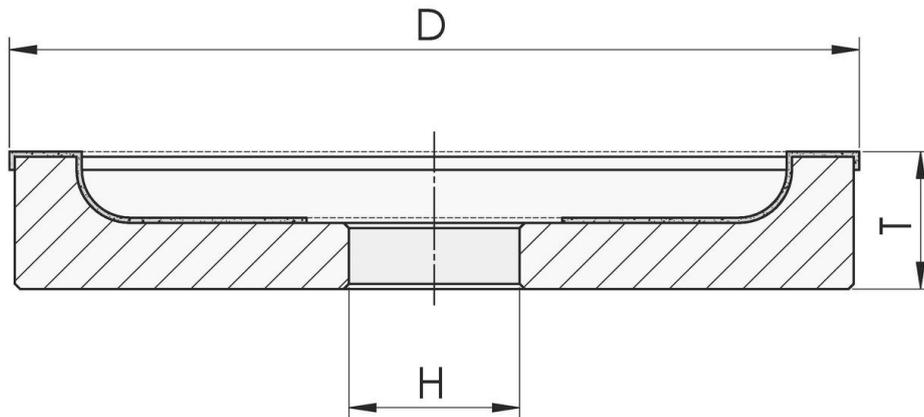
Grinding Wheels – Type 1AG2

Application

The electroplated diamond grinding wheel type **1AG2** is intended for rough machining (debarking) of amber.



Dimensions



D	T	H
150	10	as per order
175	10	as per order
200	15	as per order
250	15	as per order
300	15	as per order

Order Example

Wheel type	D T H	Body	Grain	Binder	Assortment
1AG2	150x10x20	KS	D107	G	1AG2-150x10x20 KS D107 G
1AG2	250x15x32	KS	D126	G	1AG2-250x15x32 KS D126 G



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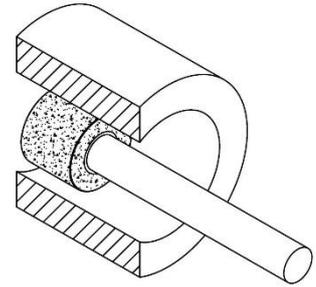
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Grinding Wheels – Type 1A1W

Application

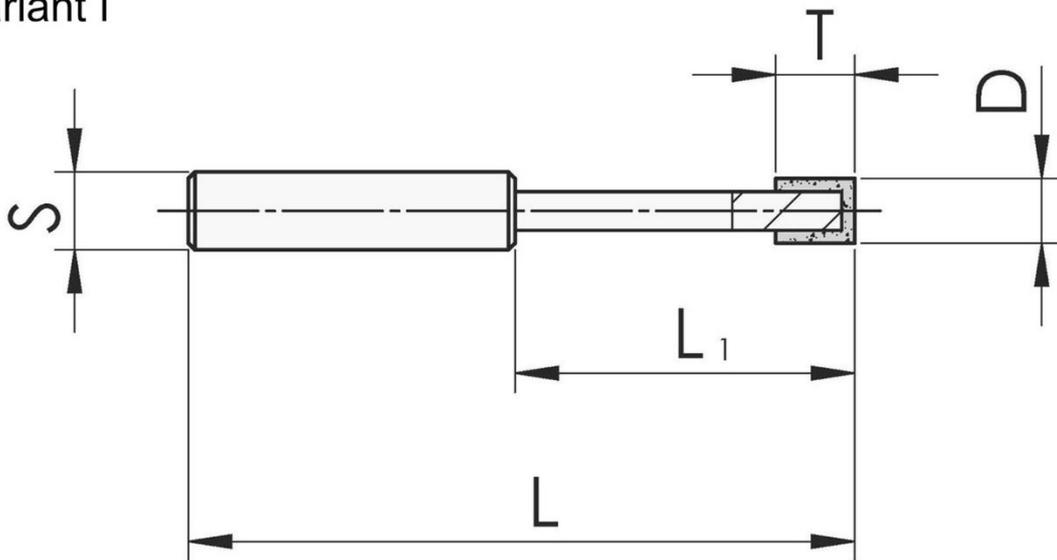
The electroplated grinding wheel type **1A1W** with diamond grain (grain symbol D) is intended for grinding holes in cemented carbides, glass, ceramics, silicon, graphite, etc.

In contrast, the grinding wheel with CBN grain (grain symbol B) is intended for grinding holes in tool steels, hardened steels, high-speed steels, bearing steels, stainless steels, etc.

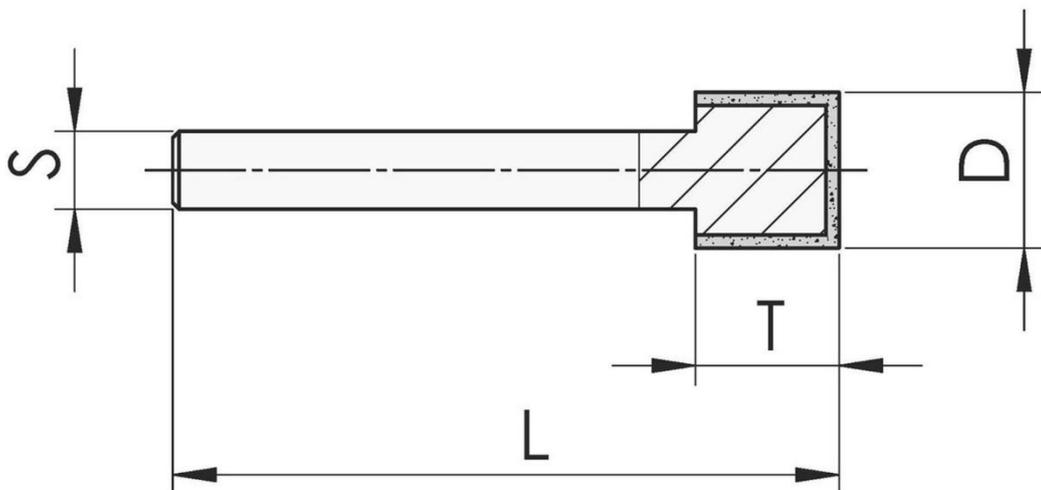


Dimensions

Variant I



Variant II



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D	T	S	L	L1	Grain	Variant
0,5	2	3	40	7	D54 – D64	I
0,6	2	3	40	7	D54 – D64	I
0,8	2	3	40	7	D54 – D107 B107	I
1	3	3	40	9	D54 – D107 B107	I
1,2	3	3	40	12	D54 – D107 B107	I
1,5	4	3	40	12	D54 – D107 B107	I
2	4	3	40	14	D54 – D107 B107	I
2,5	4	3	40	19	D54 – D107 B107 – B126	I
3	5	3	40	23	D54 – D107 B107 – B126	I
3,5	5	3	50	–	D107 – D151 B126 – B151	II
4	5	3	50	–	D107 – D151 B126 – B151	II
4,5	6	4	60	–	D107 – D151 B126 – B151	II
5	6	5	80	–	D107 – D151 B126 – B151	II
5,5	8	5	70	–	D107 – D151 B126 – B151	II
6	8	5	75	–	D126 – D151 B126 – B151	II
6,5	8	5	75	–	D126 – D151 B126 – B151	II
7	8	6	75	–	D126 – D151 B126 – B151	II
8	10	6	75 100	–	D126 – D151 B126 – B151	II
9	10	8	75 100	–	D126 – D151 B126 – B151	II
10	10	8	75 100	–	D126 – D151 B126 – B151	II
11	10	10	75 100	–	D126 – D151 B126 – B151	II
12	10	10	75 100	–	D126 – D151 B126 – B151	II
13	10	10	75 100	–	D126 – D151 B126 – B151	II
14	10	10	75 100	–	D126 – D151 B126 – B151	II
15	10	10	75 100	–	D126 – D151 B126 – B151	II
16	10	10	75 100	–	D126 – D151 B126 – B151	II

Order Example

Wheel type	D T S/L	Body	Grain	Binder	Assortment
1A1W	0,8x2x3/40	KS	D126	G	1A1W-0,8x2x3/40 KS D126 G
1A1W	5,5x8x5/70	KS	D151	G	1A1W-5,5x8x5/70 KS D151 G



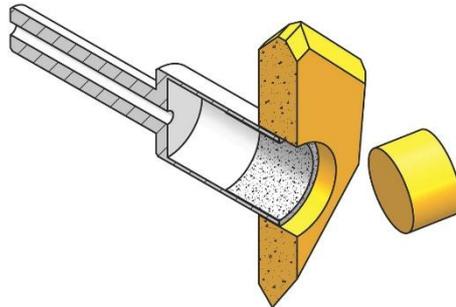
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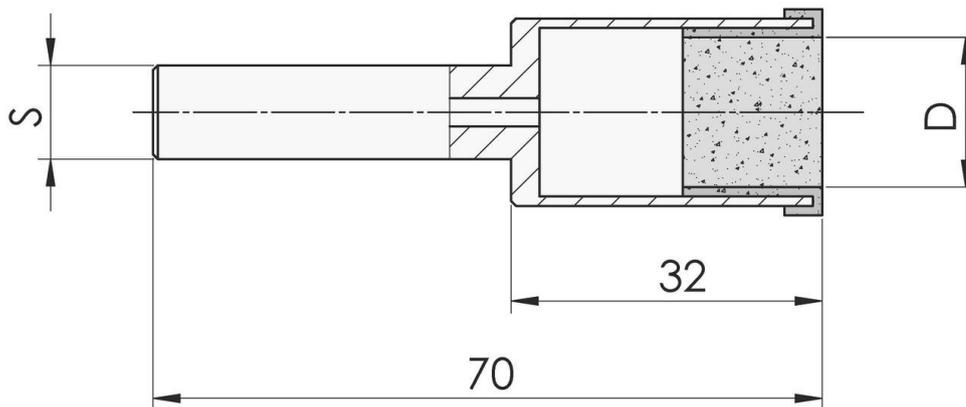
Grinding Wheels – Type 2A2W

Application

The electroplated diamond drill type **2A2W** is intended for cutting amber discs.



Dimensions



D	S
6	6
8	6
10	6 / 8
12	6 / 8
14	6 / 8 / 10
16	6 / 8 / 10
18	6 / 8 / 10
20	6 / 8 / 10

Order Example

Wheel type	D S	Body	Grain	Binder	Assortment
2A2W	12x6	KS	D107	G	2A2W-12x6 KS D107 G
2A2W	18x8	KS	D126	G	2A2W-18x8 KS D126 G



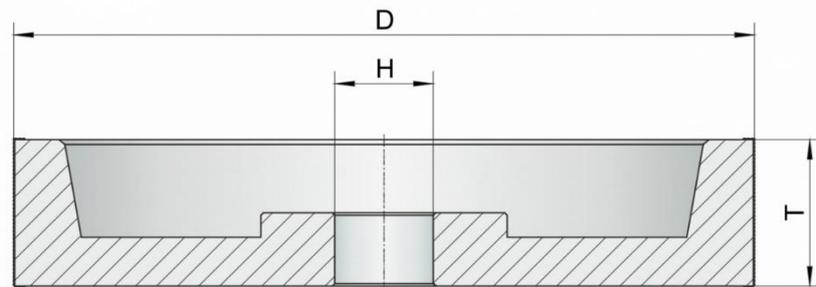
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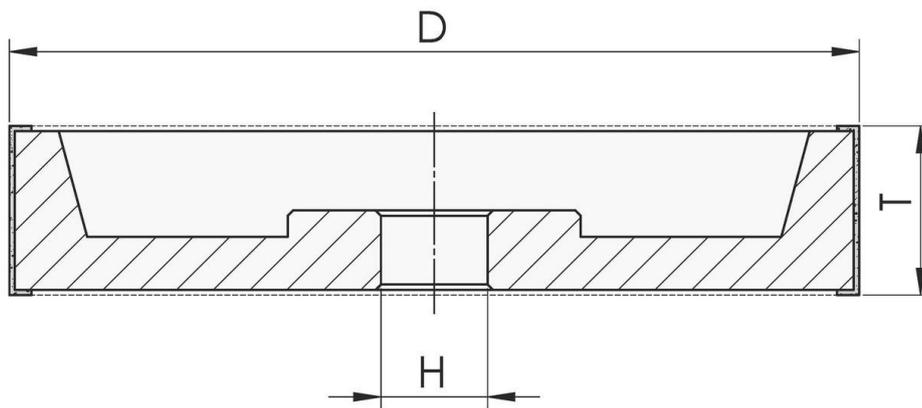
Grinding Wheels – Type 6A1

Application

The electroplated diamond grinding wheel type **6A1** is intended for machining amber on LUX-type grinding machines.



Dimensions



D	T	H
150	30 / 40 / 50	as per order

Order Example

Wheel type	D T H	Body	Grain	Binder	Assortment
6A1	150x40x20	KS	D107	G	6A1-150x40x20 KS D107 G
6A1	150x50x32	KS	D126	G	6A1-150x50x32 KS D126 G



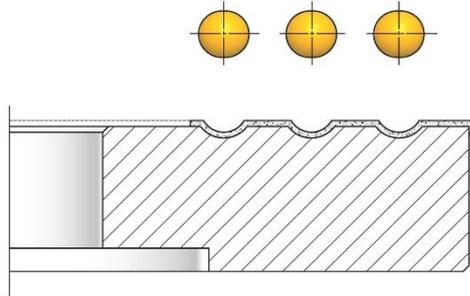
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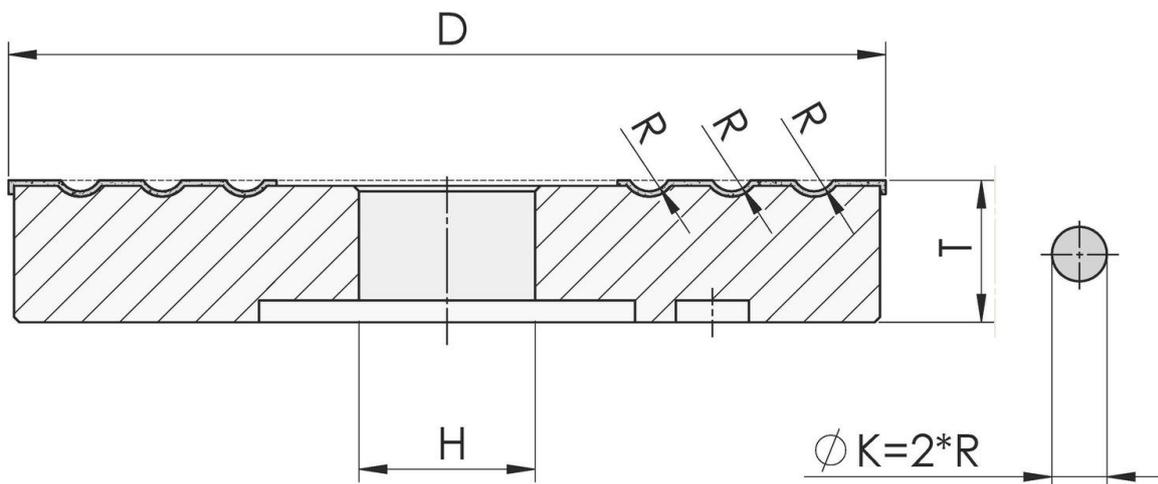
Grinding Wheels – Type S1041

Application

The electroplated diamond grinding wheel type **S1041** is intended for forming amber beads.



Dimensions



D	ØK	T	H
250	4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28	24	as per order

Order Example

Wheel type	D ØK T H	Body	Grain	Binder	Assortment
S1041	250x16x24x20	KS	D107	G	S1041-250x16x24x20 KS D107 G
S1041	250x22x24x32	KS	D107	G	S1041-250x22x24x32 KS D107 G



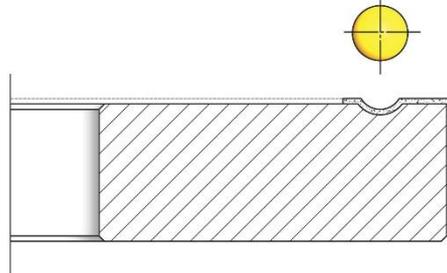
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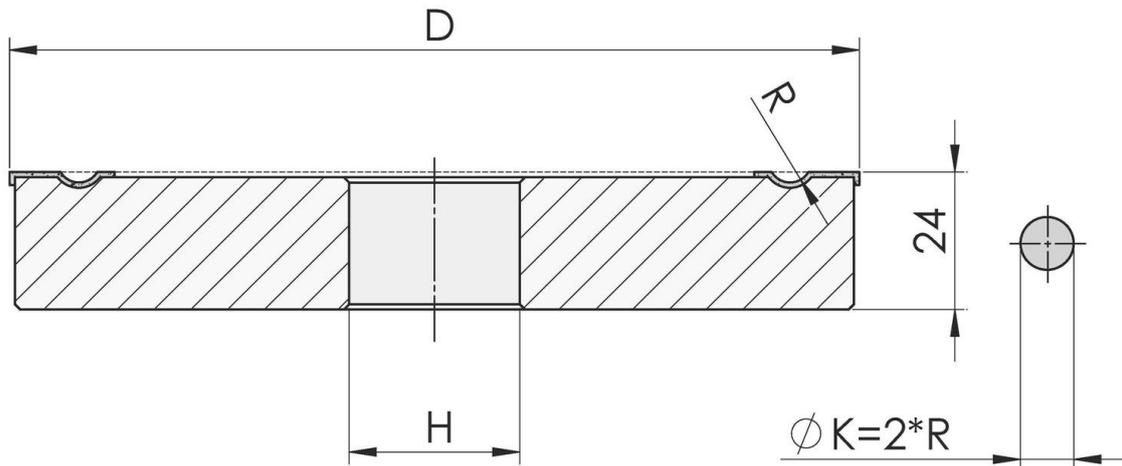
Grinding Wheels – Type S1042

Application

The electroplated diamond grinding wheel type **S1042** is intended for forming amber beads.



Dimensions



D	ØK	T	H
250	4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28	24	as per order
300	4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28	24	as per order
350	4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28	24	as per order

Order Example

Wheel type	D ØK T H	Body	Grain	Binder	Assortment
S1042	250x11x24x32	KS	D107	G	S1042-250x11x24x32 KS D107 G
S1042	350x22x24x76	KS	D107	G	S1042-350x22x24x76 KS D107 G



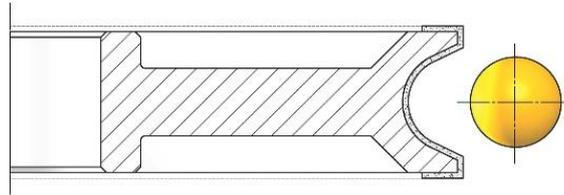
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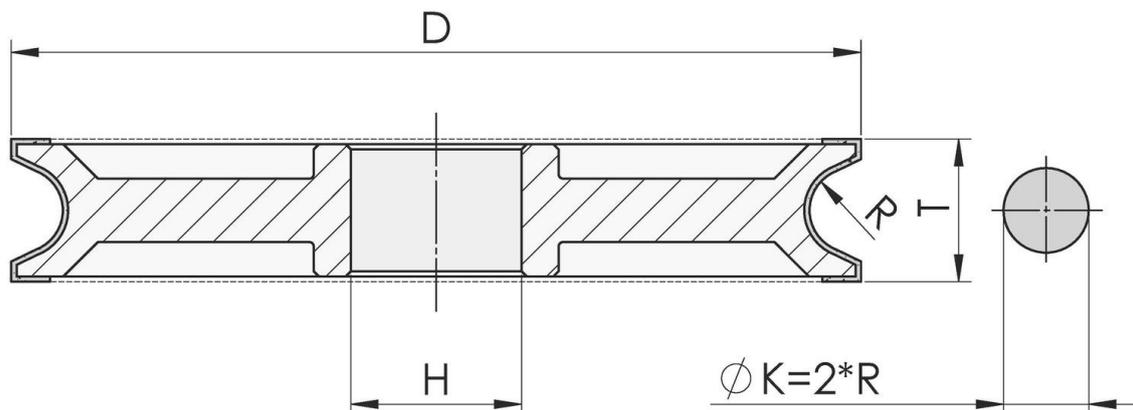
Grinding Wheels – Type S1210

Application

The electroplated diamond grinding wheel type **S1210** is intended for forming amber beads.



Dimensions



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D	ØK	T	H
150	4	7	as per order
150	5	8	as per order
150	6	9	as per order
150	7	10	as per order
150	8	11	as per order
150	9	12	as per order
150	10	13	as per order
150	11	14	as per order
150	12	15	as per order
150	13	16	as per order
150	14	17	as per order
150	15	18	as per order
150	16	19	as per order
150	17	20	as per order
150	18	21	as per order
150	19	22	as per order
150	20	23	as per order
150	21	24	as per order
150	22	25	as per order
150	23	26	as per order
150	24	27	as per order
150	25	28	as per order
150	26	29	as per order
150	27	30	as per order
150	28	31	as per order
150	29	32	as per order
150	30	33	as per order
150	31	34	as per order
150	32	35	as per order
150	33	36	as per order
150	34	37	as per order
150	35	38	as per order
150	36	39	as per order
150	37	40	as per order
150	38	41	as per order
150	39	42	as per order
150	40	43	as per order
150	41	44	as per order
150	42	45	as per order
150	43	46	as per order

Order Example

Wheel type	D ØK T H	Body	Grain	Binder	Assortment
S1210	150x28x32x20	KS	D107	G	S1210-150x28x32x20 KS D107 G
S1210	150x36x39x32	KS	D126	G	S1210-150x36x39x32 KS D126 G



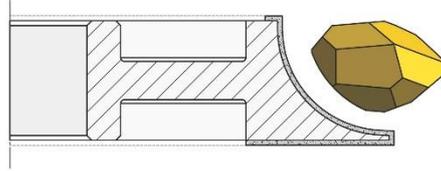
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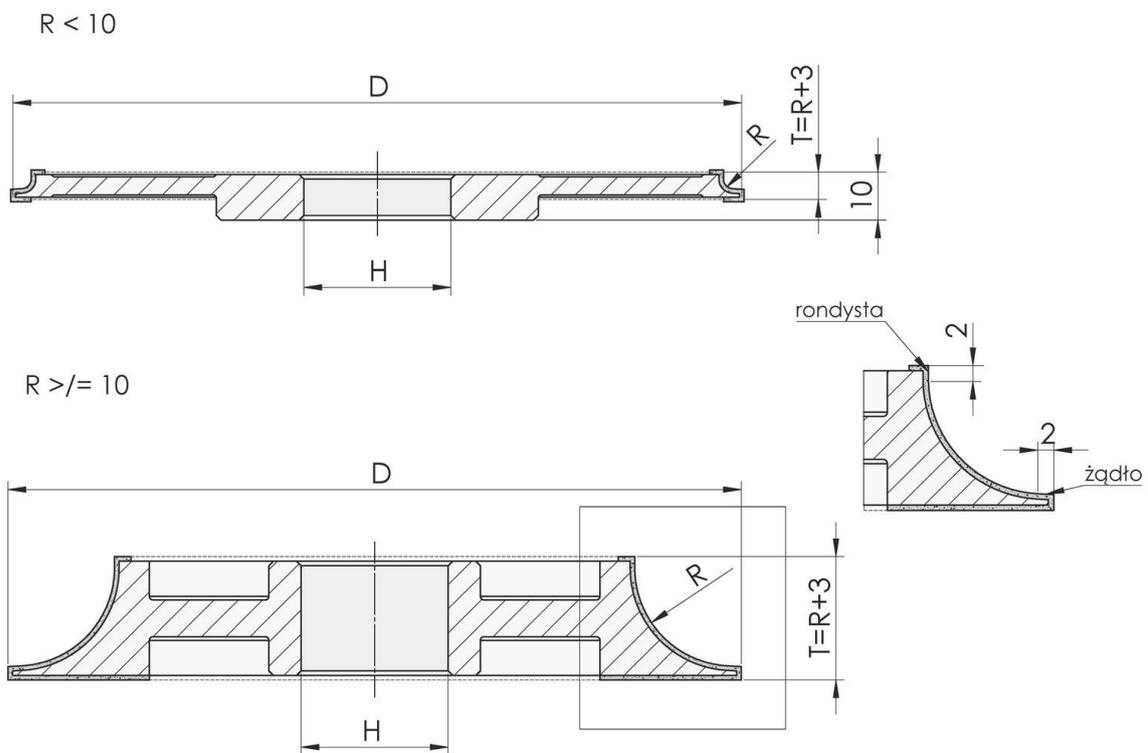
Grinding Wheels – Type S1211

Application

The electroplated diamond grinding wheel type **S1211** is intended for forming amber cabochons.



Dimensions



D	R	H
150	2 2,5 3 3,5 4 4,5 5 5,5 6 6,5 7 7,5 8 8,5 9 9,5 10 10,5 11 11,5 12 12,5 13 13,5 14 14,5 15 15,5 16 16,5 17 17,5 18 18,5 19 19,5 20	as per order

Order Example

Wheel type	D R H	Body	Grain	Binder	Assortment
S1211	150x13,5x16	KS	D107	G	S1211-150x13,5x16 KS D107 G
S1211	150x18,5x25	KS	D126	G	S1211-150x18,5x25 KS D126 G



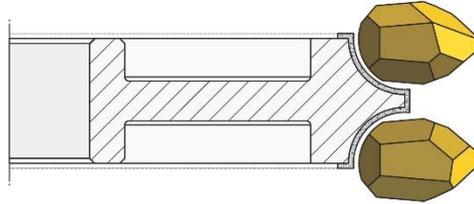
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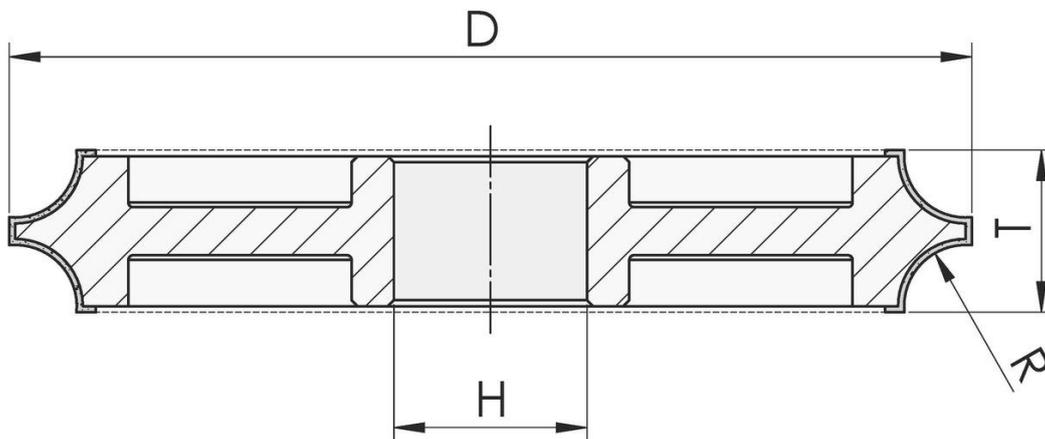
Grinding Wheels – Type S1212

Application

The electroplated diamond grinding wheel type **S1212** is intended for simultaneous forming of two amber cabochons on a “KOREANKA” type grinding machine.



Dimensions



D	R	T	H
150	6	18	as per order
150	9	25	as per order
150	10	25	as per order
150	12,5	27	as per order
150	15	32	as per order

Order Example

Wheel type	D R H	Body	Grain	Binder	Assortment
S1212	150x10x20	KS	D107	G	S1212-150x10x20 KS D107 G
S1212	150x15x32	KS	D126	G	S1212-150x15x32 KS D126 G



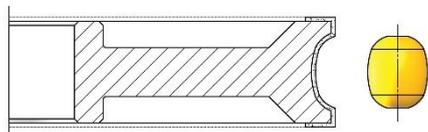
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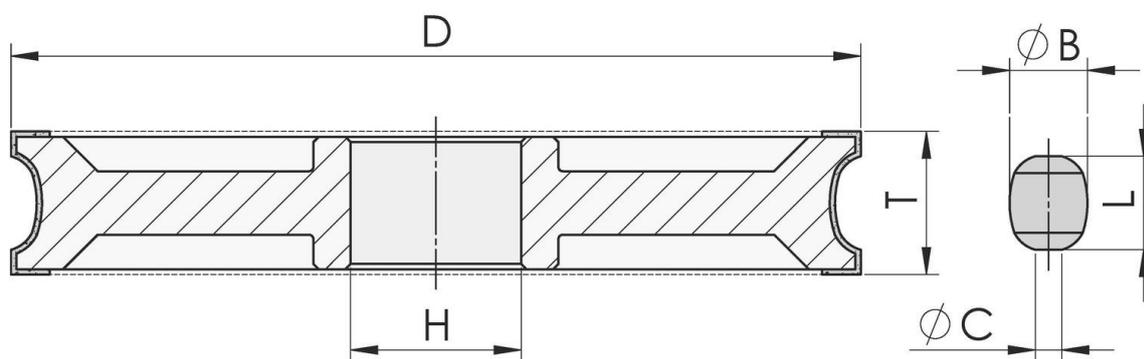
Grinding Wheels – Type S1213

Application

The electroplated diamond grinding wheel type **S1213** is intended for forming amber barrel-shaped beads.



Dimensions



D	L	ØB	ØC	T	H
150	10	8	3	18	as per order
150	11	9,9	5,3	18	as per order
150	12	10,8	5,6	18	as per order
150	13	11,7	5,9	18	as per order
150	14	12,6	6,2	19	as per order
150	15	13,5	6,5	20	as per order
150	16	14,4	6,6	21	as per order
150	17	15,3	6,7	22	as per order
150	18	16,2	7	23	as per order
150	19	17,1	7,1	24	as per order
150	20	18	7,7	25	as per order
150	21	18,9	7,5	26	as per order
150	26	21	6,8	30	as per order
150	28	22	6,4	32	as per order

Order Example

Wheel type	D L ØB ØC T H	Body	Grain	Binder	Assortment
S-1213	150x12x10,8x5,6x20	KS	D107	G	S-1213 150x12x10,8x5,6x20 KS D107 G
S-1213	150x21x18,9x7,5x32	KS	D126	G	S-1213 150x21x18,9x7,5x32 KS D126 G



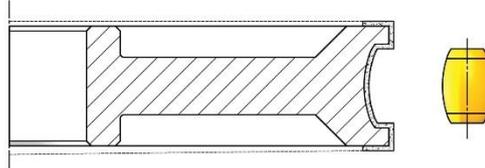
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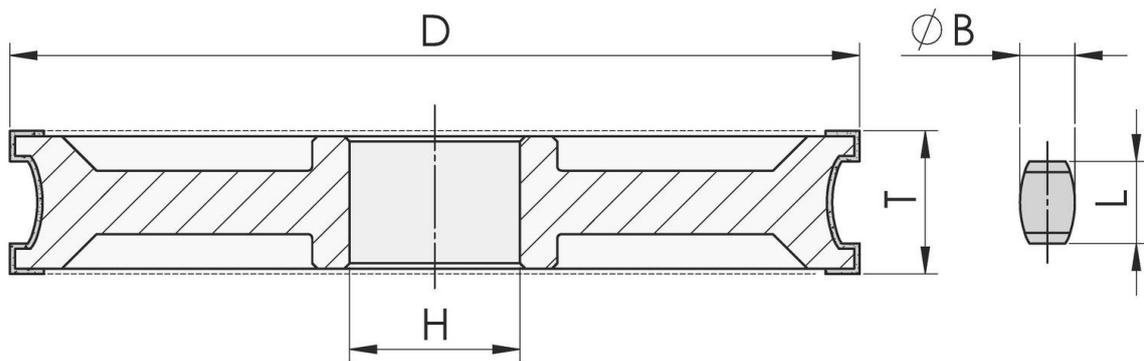
Grinding Wheels – Type S1214

Application

The electroplated diamond grinding wheel type **S1214** is intended for forming amber barrels.



Dimensions



D	L	ØB	T	H
150	11,2	7,8	16	as per order
150	12,2	8,8	17	as per order
150	13,2	9,4	18	as per order
150	14,2	10,4	19	as per order

Order Example

Wheel type	D L ØB T H	Body	Grain	Binder	Assortment
S1214	150x12,2x8,8x20	KS	D107	G	S1214-150x12,2x8,8x20 KS D107 G
S1214	150x13,2x9,4x25	KS	D126	G	S1214-150x13,2x9,4x25 KS D126 G



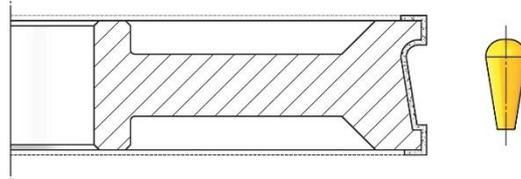
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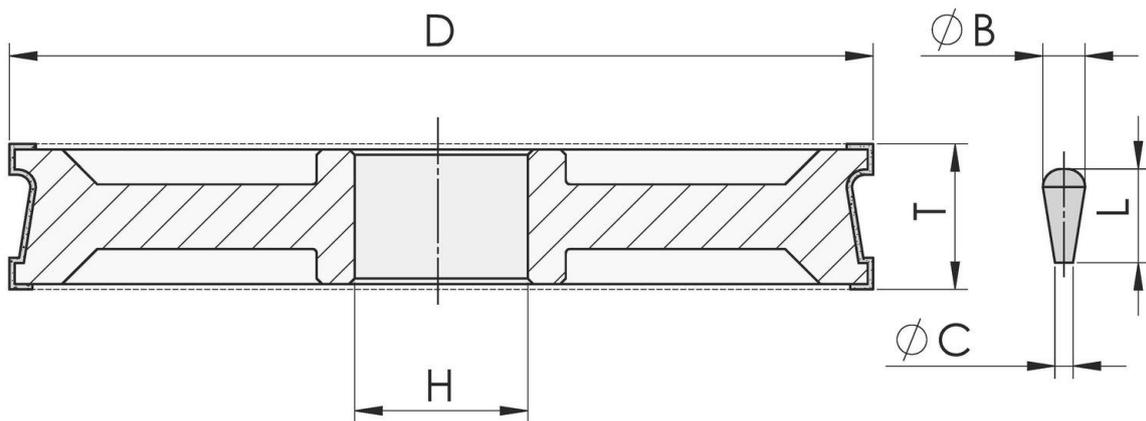
Grinding Wheels – Type S1215

Application

The electroplated diamond grinding wheel type **S1215** is intended for forming amber teardrops.



Dimensions



D	L	ØB	ØC	T	H
150	25	10	3,3	30	as per order
150	30	12	4	35	as per order
150	37,5	15	5	42	as per order

Order Example

Wheel type	D L ØB ØC T H	Body	Grain	Binder	Assortment
S1215	150x20x10,3x3,3x20	KS	D107	G	S1215-150x20x10,3x3,3x20 KS D107 G
S1215	150x30x12x4x32	KS	D126	G	S1215-150x30x12x4x32 KS D126 G



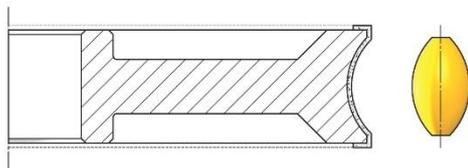
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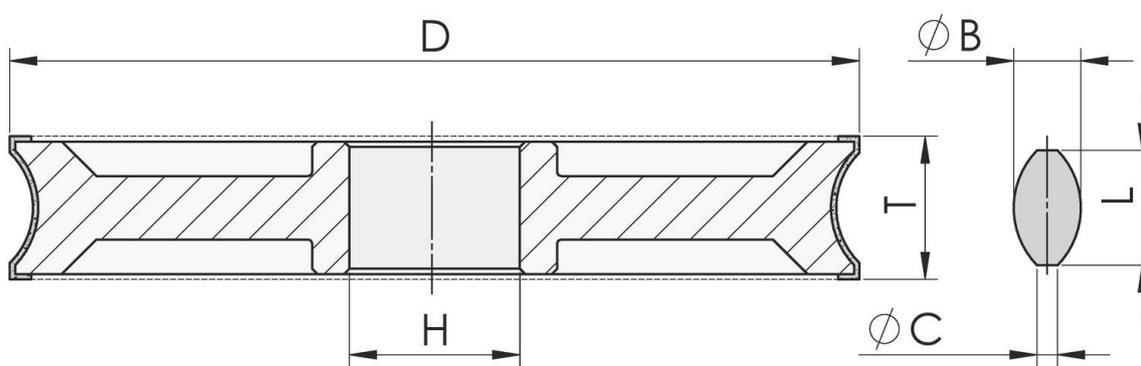
Grinding Wheels – Type S1216

Application

The electroplated diamond grinding wheel type **S1216** is intended for machining amber.



Dimensions



D	L	ØB	ØC	H
150	9	7	2	as per order
150	11	8	2	as per order
150	13	9	2	as per order
150	14	10	2	as per order
150	15	11	2	as per order
150	16	12	3	as per order
150	17	13	3	as per order
150	18	14	3	as per order
150	19	15	3	as per order
150	20	16	3	as per order
150	21	17	3	as per order
150	23	16 17	3	as per order

Order Example

Wheel type	D L ØB ØC H	Body	Grain	Binder	Assortment
S1216	150x15x11x2x20	KS	D107	G	S1216-150x15x11x2x20 KS D107 G
S1216	150x20x16x3x25	KS	D126	G	S1216-150x20x16x3x25 KS D126 G



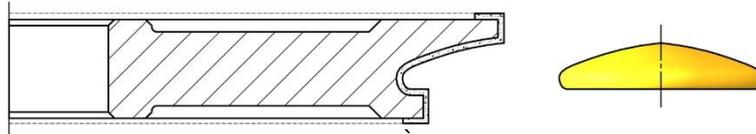
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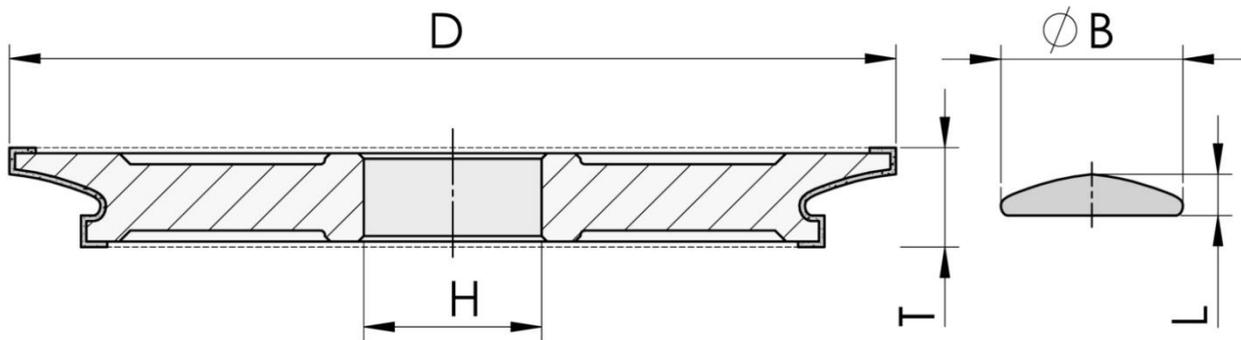
Grinding Wheels – Type S1217

Application

The electroplated diamond grinding wheel type **S1217** is intended for forming buttons.



Dimensions



D	L	ØB	T	H
150	26	6,7	17	as per order
150	40	9,7	20	as per order

Order Example

Wheel type	D L ØB H	Body	Grain	Binder	Assortment
S1217	150x26x6,7x20	KS	D107	G	S1217-150x26x6,7x20 KS D107 G
S1217	150x40x9,7x25	KS	D126	G	S1217-150x40x9,7x25 KS D126 G



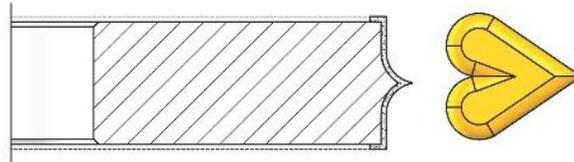
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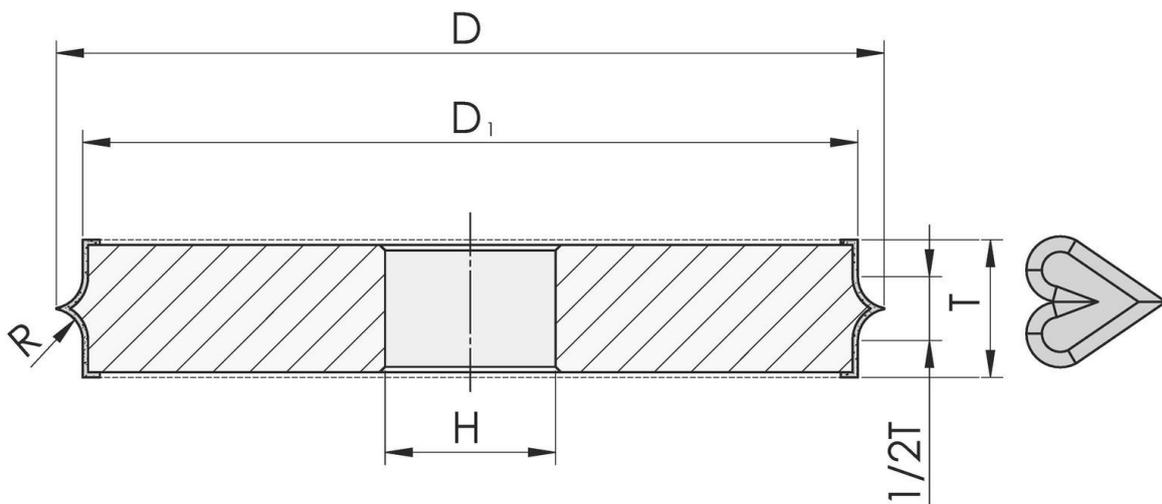
Grinding Wheels – Type **S1218**

Application

The electroplated diamond grinding wheel type **S1218** is intended for forming a heart profile.



Dimensions



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D	R	T	D1	H
60	3	10	57,3	as per order
60	3,5	11	57,3	as per order
60	4	12	57,3	as per order
60	4,5	13	57,2	as per order
60	5	14	57,1	as per order
60	5,5	15	57	as per order
60	6	16	56,9	as per order
60	6,5	17	56,8	as per order
60	7	18	56,7	as per order
60	7,5	19	56,6	as per order
60	8	20	56,5	as per order
60	8,5	21	56,4	as per order
60	9	22	56,2	as per order
60	9,5	23	56,1	as per order
60	10	24	56	as per order
60	10,5	25	55,9	as per order
60	11	26	55,7	as per order
60	11,5	27	55,6	as per order
60	12	28	55,5	as per order
60	12,5	29	55,4	as per order
60	13	30	55,2	as per order
60	13,5	31	55,1	as per order
60	14	32	55	as per order
60	14,5	33	54,8	as per order
60	15	34	54,7	as per order
60	16	36	54,5	as per order
60	17	38	54,2	as per order
60	18	40	53,9	as per order
60	19	42	53,7	as per order
60	20	44	53,4	as per order

Order Example

Wheel type	D R T H	Body	Grain	Binder	Assortment
S1218	60x3,5x11x10	KS	D107	G	S1218-60x3,5x11x10 KS D107 G
S1218	60x8,5x21x10	KS	D126	G	S1218-60x8,5x21x10 KS D126 G



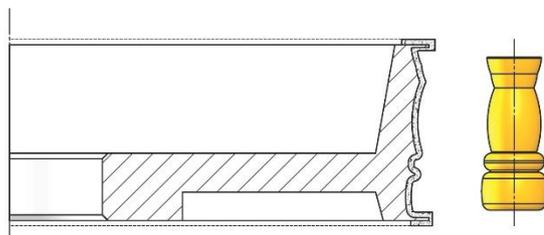
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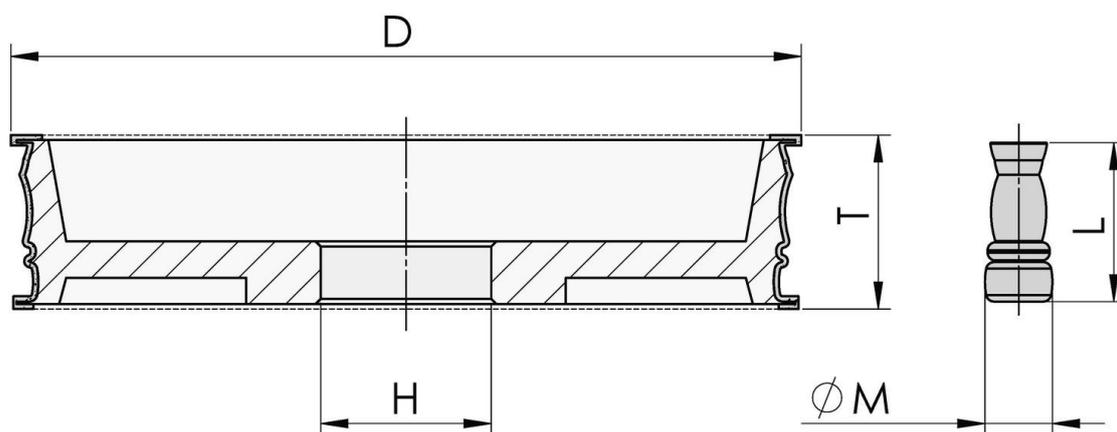
Grinding Wheels – Type S1219M/1

Application

The electroplated diamond grinding wheel type **S1219M/1** is intended for forming amber minarets.



Dimensions



D	ØM	L	T	H
150	12	30	31	as per order

Order Example

Wheel type	D ØM L H	Body	Grain	Binder	Assortment
S1219M/1	150x12x30x20	KS	D107	G	S1219M/1-150x12x30x20 KS D107 G
S1219M/1	150x12x30x32	KS	D126	G	S1219M/1-150x12x30x32 KS D126 G



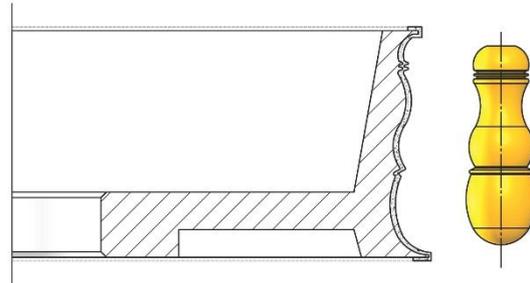
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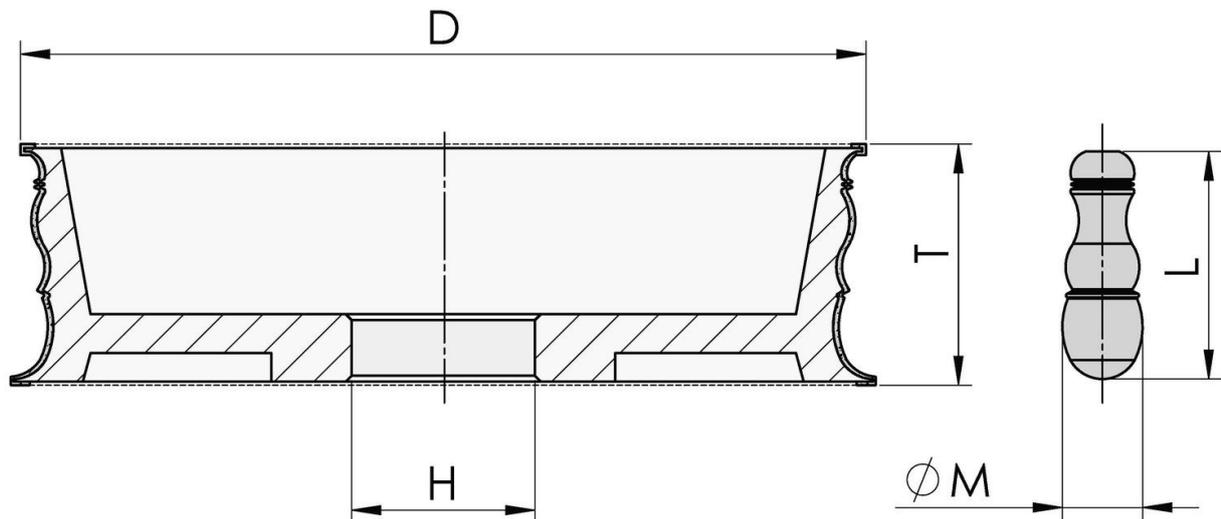
Grinding Wheels – Type S1219M/2

Application

The electroplated diamond grinding wheel type **S1219M/2** is intended for forming amber minarets.



Dimensions



D	ØM	L	T	H
150	14	40	41	as per order

Order Example

Wheel type	D ØM L H	Body	Grain	Binder	Assortment
S1219M/2	150x14x40x20	KS	D107	G	S1219M/2-150x14x40x20 KS D107 G
S1219M/2	150x14x40x32	KS	D126	G	S1219M/2-150x14x40x32 KS D126 G



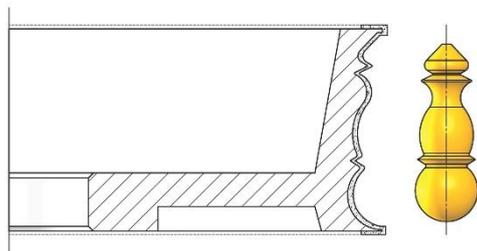
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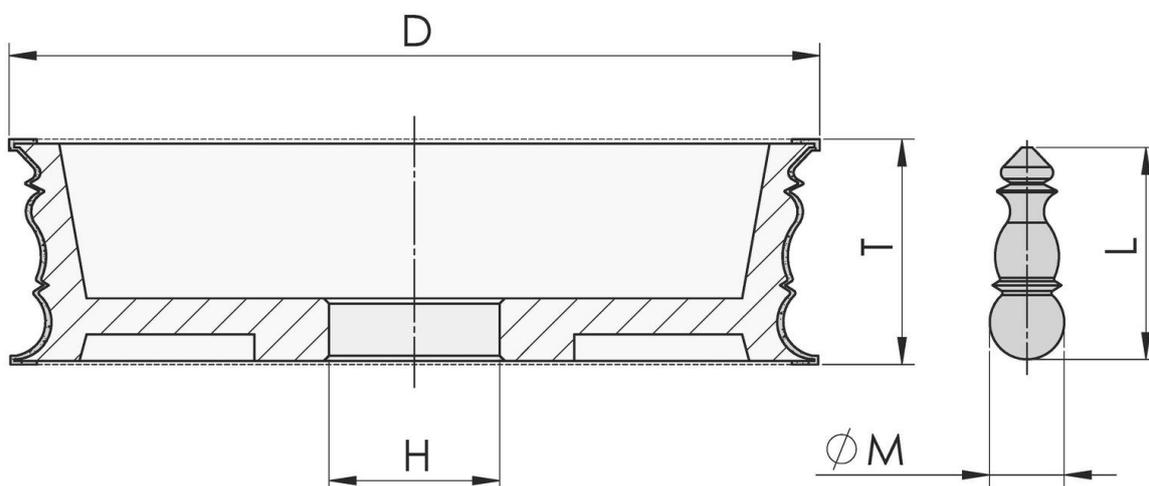
Grinding Wheels – Type S1219M/3

Application

The electroplated diamond grinding wheel type **S1219M/3** is intended for forming amber minarets.



Dimensions



D	ØM	L	T	H
150	14	40	41	as per order

Order Example

Wheel type	D ØM L H	Body	Grain	Binder	Assortment
S1219M/3	150x14x40x20	KS	D107	G	S1219M/3-150x14x40x20 KS D107 G
S1219M/3	150x14x40x32	KS	D126	G	S1219M/3-150x14x40x32 KS D126 G



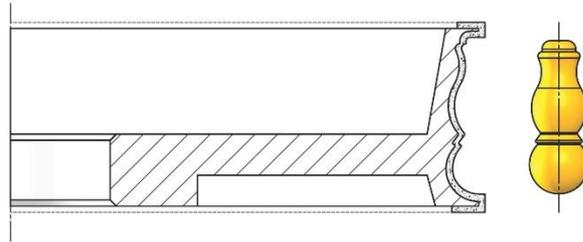
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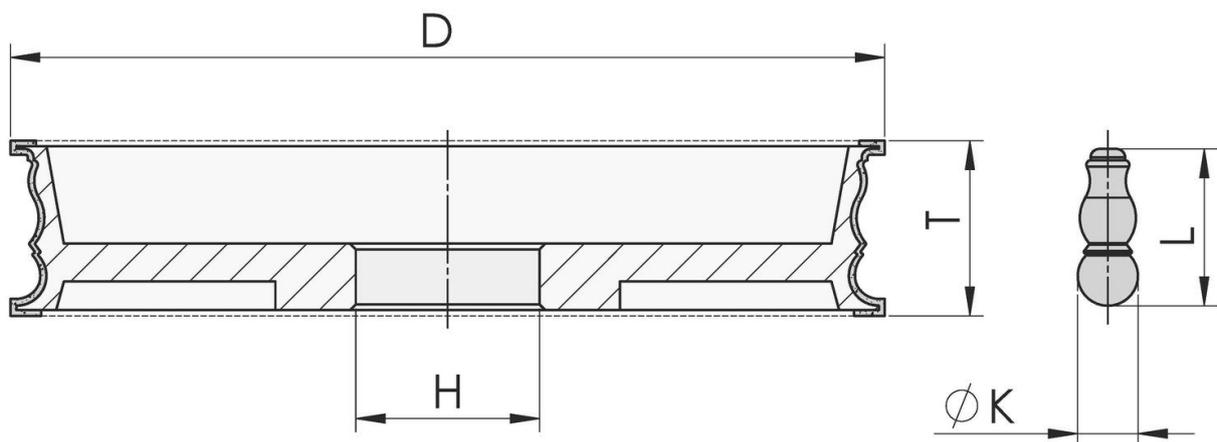
Grinding Wheels – Type S1219M/4

Application

The electroplated diamond grinding wheel type **S1219M/4** is intended for forming amber minarets.



Dimensions



D	ØM	L	T	H
150	10,5	27,5	29	as per order

Order Example

Wheel type	D ØM L H	Body	Grain	Binder	Assortment
S1219M/4	150x10,5x27,5x20	KS	D107	G	S1219M/4-150x10,5x27,5x20 KS D107 G
S1219M/4	150x10,5x27,5x32	KS	D126	G	S1219M/4-150x10,5x27,5x32 KS D126 G



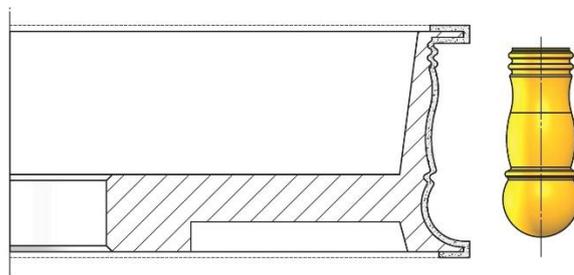
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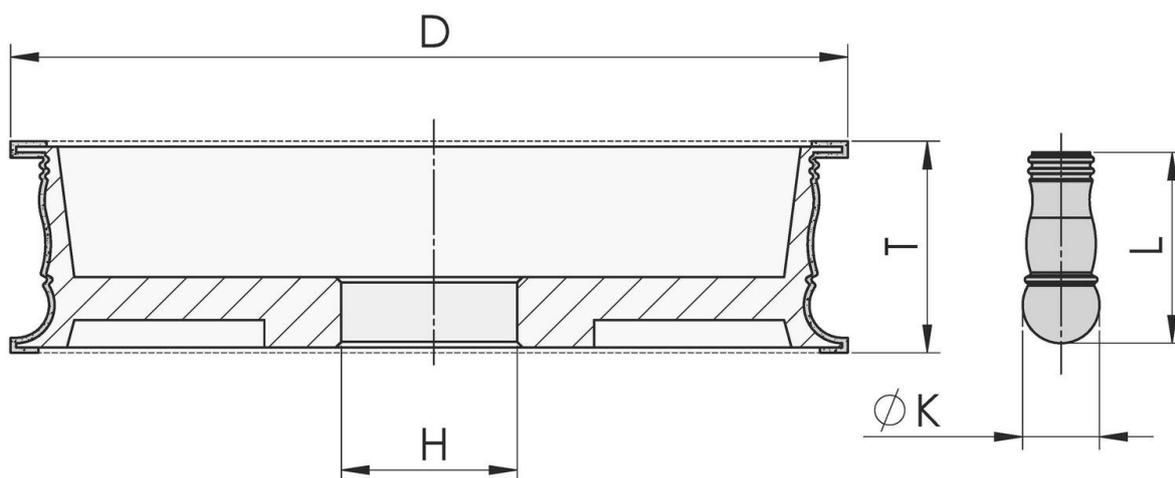
Grinding Wheels – Type S1219M/5

Application

The electroplated diamond grinding wheel type **S1219M/5** is intended for forming amber minarets.



Dimensions



D	ØM	L	T	H
150	14	35	36	as per order

Order Example

Wheel type	D ØM L H	Body	Grain	Binder	Assortment
S1219M/5	150x14x35x20	KS	D107	G	S1219M/5-150x14x35x20 KS D107 G
S1219M/5	150x14x35x32	KS	D126	G	S1219M/5-150x14x35x32 KS D126 G



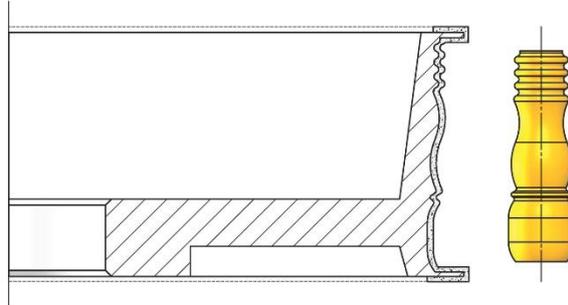
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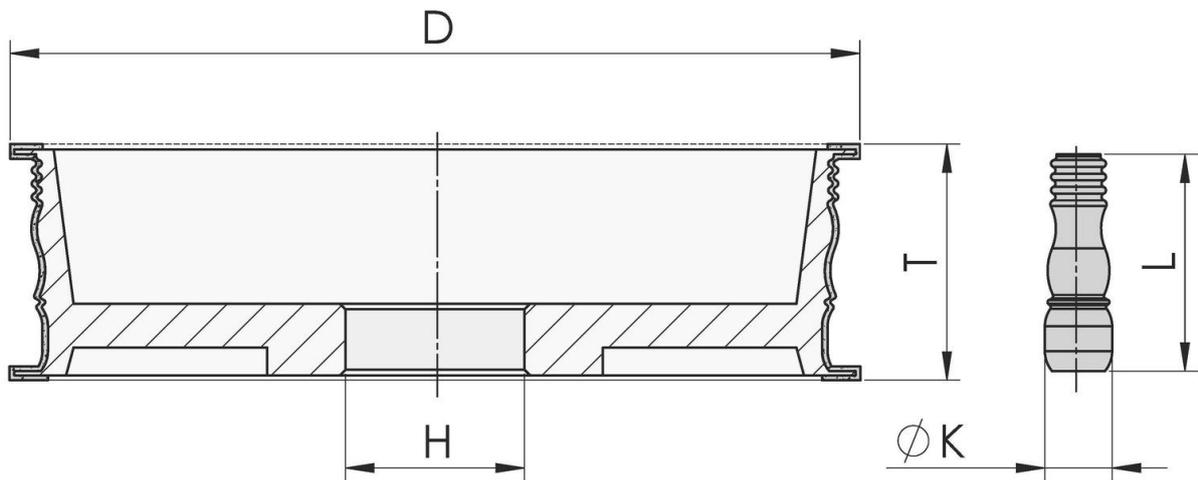
Grinding Wheels – Type S1219M/6

Application

The electroplated diamond grinding wheel type **S1219M/6** is intended for forming amber minarets.



Dimensions



D	ØM	L	T	H
150	12	39	40	as per order

Order Example

Wheel type	D ØM L H	Body	Grain	Binder	Assortment
S1219M/6	150x12x39x20	KS	D107	G	S1219M/6-150x12x39x20 KS D107 G
S1219M/6	150x12x39x32	KS	D126	G	S1219M/6-150x12x39x32 KS D126 G



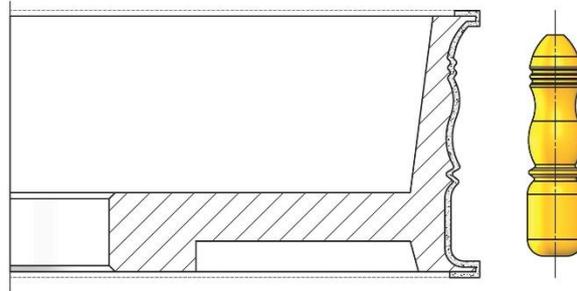
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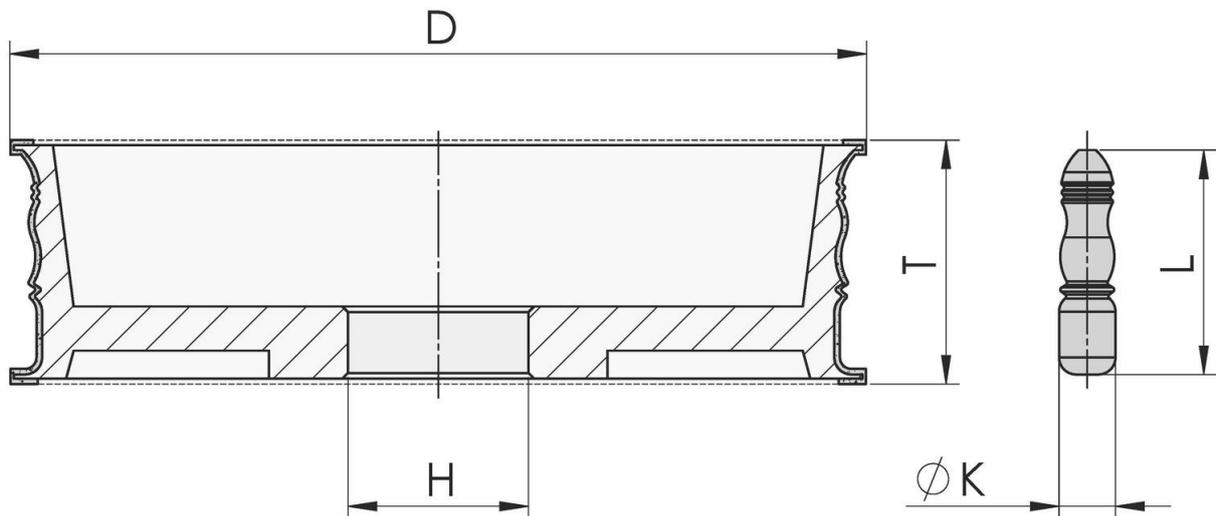
Grinding Wheels – Type S1219M/7

Application

The electroplated diamond grinding wheel type **S1219M/7** is intended for forming amber minarets.



Dimensions



D	ØM	L	T	H
150	10	40	41	as per order

Order Example

Wheel type	D ØM L H	Body	Grain	Binder	Assortment
S1219M/7	150x10x40x20	KS	D107	G	S1219M/7-150x10x40x20 KS D107 G
S1219M/7	150x10x40x32	KS	D126	G	S1219M/7-150x10x40x32 KS D126 G



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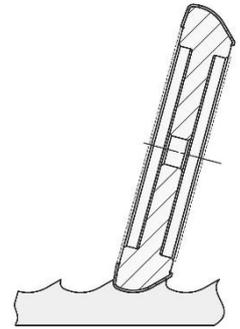
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Grinding Wheels – Type PS

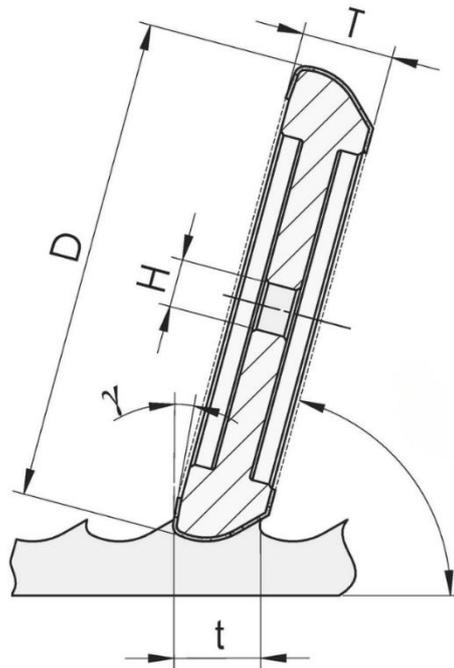
Application

Electroplated CBN (borazon) profile grinding wheels **PS** are intended for sharpening band saws used in the woodworking, sawmill, and food industries. By precisely matching the wheel profile to the tooth contour, high repeatability of tooth geometry after sharpening is achieved, ensuring long saw blade life.

The use of electroplated CBN (borazon) grinding wheels for sharpening band saws allows for high efficiency without the risk of burning.



Dimensions



Symbol	γ	t	Remarks	Saw Profile	D	T	H
Fenes	10°	22,2		Fenes Standard	127	23,2	12,7
Fenes	10°	22,2		Fenes Standard	127	23,2	20
Fenes	10°	22,2		Fenes Standard	150	23,2	20
Fenes	10°	22,2		Fenes Standard	203	23,2	25,4
Fenes	10°	22,2		Fenes Standard	203	23,2	32
WM	10°	22,2	Winter Version	WM 9/29	127	22,2	12,7
WM	10°	22,2	Winter Version	WM 9/29	127	22,2	20
WM	10°	22,2	Winter Version	WM 9/29	150	22,2	20
WM	10°	22,2	Winter Version	WM 9/29	203	22,2	25,4
WM	10°	22,2	Winter Version	WM 9/29	203	22,2	32
Sword Lenox	10°	22,2		Lenox	127	22,2	12,7
Sword Lenox	10°	22,2		Lenox	127	22,2	20
Sword Lenox	10°	22,2		Lenox	150	22,2	20
Sword Lenox	10°	22,2		Lenox	203	22,2	25,4
Sword Lenox	10°	22,2		Lenox	203	22,2	32



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Grain Grit

Band saw sharpening wheels produced by INTER-DIAMENT® are manufactured in various dimensional versions with different working profiles, adapted for sharpening saws with different tooth shapes. The working surface of the wheel is coated with high-grade CBN (borazon) grain with very high durability, providing excellent wheel performance.

The following CBN grain grit sizes are used:

- B126, B151 – saw sharpening
- B181, B252 – tooth profile correction, optionally reshaping

Thanks to the latest technologies, the wheels we produce feature a very long service life, leading to significant cost savings for the customer.

Operating Instructions

The optimal peripheral speed of the above-mentioned grinding wheels, 20–30 m/s, is critical for sharpening efficiency and wheel service life.

Recommended types of cooling oil:

- ACP-2-E non-emulsifying – ORLEN
- WECO EP-10 (or EP-15) – PROMASZ

Remarks

The use of oil emulsions is not recommended due to the sensitivity of CBN (borazon) grain to water. In low ambient temperatures, it is advisable to heat the machine oil to reduce its viscosity.

During the sharpening process, the stream of cooling oil should be directed directly onto the grinding wheel (not onto the saw tooth) to continuously remove metal chips and prevent clogging of the wheel's working surface. The flow of cooling oil must be continuous. Periodically, it is recommended to clean the wheel with diesel oil. Before starting the sharpening process, check the wheel's alignment relative to the saw. The wheel should contact the saw along the entire circumference of its working surface, only after reaching the bottom of the tooth gullet. The sharpening process should be monitored by the operator, with particular attention to the effectiveness of cooling provided by the oil stream.

Order Example

Wheel type	D T H	Body	Grain	Binder	Assortment
ROMA8	128x22,2x12,7	KS	B151	G	ROMA8-128x22,2x12,7 KS B151 G
WM9/29	150x22,2x20	KS	B181	G	WM9/29-150x22,2x20 KS B181 G



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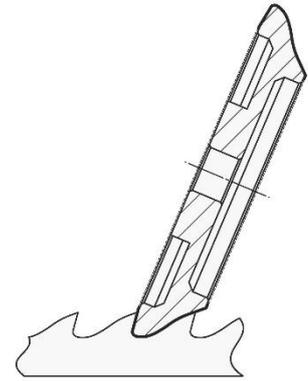
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Grinding Wheels – Type **PT**

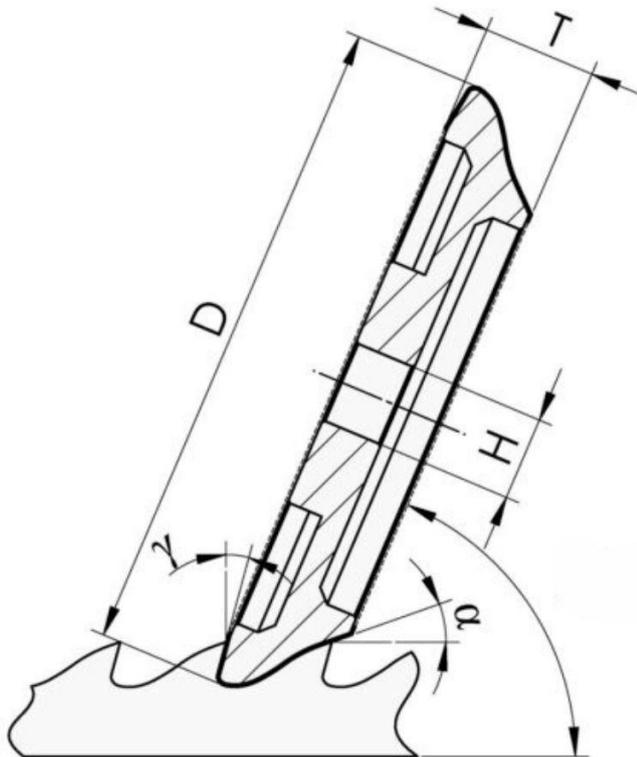
Application

Electroplated CBN (borazon) profile grinding wheels **PT** are intended for sharpening bandsaws used in the woodworking and sawmill industries. These wheels are primarily manufactured in diameters of $\varnothing 200 - \varnothing 250$ mm.

By precisely matching the wheel profile to the tooth contour, high repeatability of tooth geometry after sharpening is achieved, ensuring long saw blade life.



Dimensions



Symbol	γ	t	Remarks	Saw Type	D	T	H
Jabłoński	8°	35	—	ASPI 40 AGRW	246	35	32
Jabłoński	8°	36	—	PRETA 40 MJD	246	36	32



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Recommended grain sizes

- B126, B151 – for sharpening
- B181, B252 – for tooth profile correction or, if necessary, profiling

Advantages of Using Electroplated CBN (Borazon) Grinding Wheels

- Very long service life and high sharpening efficiency
- No need for wheel dressing, unlike ceramic wheels
- No tooth deformation during sharpening
- Reduced sharpening costs

Operating Instructions

The optimal peripheral speed of the above-mentioned grinding wheels (20–30 m/s) is critical for sharpening efficiency and wheel service life.

Recommended types of cooling oil:

- ACP-2-E non-emulsifying – ORLEN
- WECO EP-10 (or EP-15) – PROMASZ

Remarks

The use of water-oil emulsions is not recommended due to the sensitivity of CBN (borazon) grain to water. In low ambient temperatures, it is advisable to heat the machine oil to reduce its viscosity.

During the sharpening process, the stream of cooling oil should be directed directly onto the grinding wheel (not onto the saw tooth) to continuously remove metal chips and prevent clogging of the wheel's working surface. The flow of cooling oil must be continuous. Periodically, it is recommended to clean the wheel with diesel oil.

Before starting the sharpening process, check the wheel's alignment relative to the saw. The wheel profile should contact the saw's working part (tooth) along its entire length, only after reaching the bottom of the tooth gullet. The wheel profile must be matched to the profile of the saw tooth being sharpened. Tooth shapes may vary depending on the manufacturer and the type of wood being processed.

Order Example

Wheel type	DTH	Body	Grain	Binder	Assortment
PT	246x35x32	KS	B151	G	PT-246x35x32 B151 G
PT	246x36x32	KS	B181	G	PT-246x36x32 B181 G



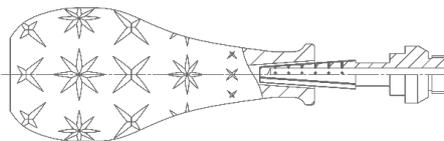
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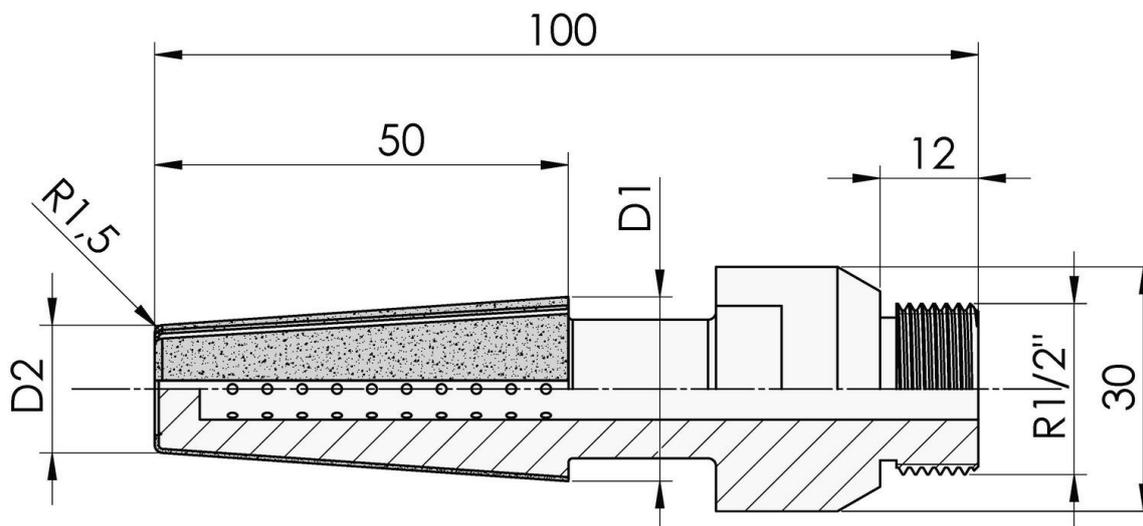
Grinding Wheels – Type S8200

Application

The electroplated diamond cutter type **S8200** is used for rough and finish machining of holes in decanter necks.



Dimensions



Designation	D1	D2
18 / 11	18,0	11,0
18,5 / 11,5	18,5	11,5
19 / 12	19,0	12,0
20 / 13	20,0	13,0
20,5 / 13,5	20,5	13,5
22 / 15	22,0	15,0
22,5 / 15,5	22,5	15,5
23 / 16	23,0	16,0
23,5 / 16,5	23,5	16,5
25,5 / 18,5	25,5	18,5
26 / 19	26,0	19,0
26,5 / 19,5	26,5	19,5
27,5 / 20,5	27,5	20,5
29 / 22	29,0	22,0
29,5 / 22,5	29,5 / 22,5	22,5
30,5 / 23,5	30,5	23,5
31 / 24	31,0	24,0
31,5 / 24,5	31,5	24,5
34,5 / 27,5	34,5	27,5
35 / 28	35,0	28,0

Order Example

Wheel type	D1/D2	Body	Grain	Binder	Assortment
S8200	22/15	KS	D64	G	S8200-22/15 D64 G
S8200	31/24	KS	D126	G	S8200-31/24 D126 G



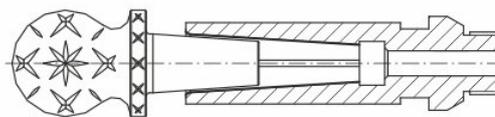
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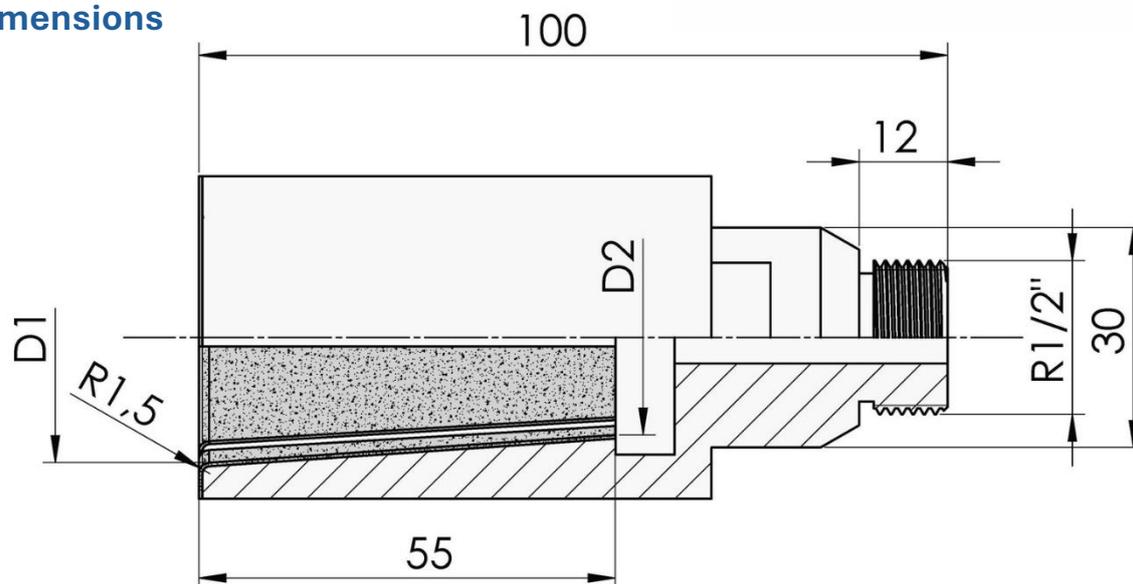
Grinding Wheels – Type S8210

Application

The electroplated diamond cutter type **S8210** is used for rough and finish machining of decanter stoppers.



Dimensions



Designation	D1	D2
18 / 11	18,4	11,0
18,5 / 11,5	18,9	11,5
19 / 12	19,4	12,0
20 / 13	20,2	13,0
20,5 / 13,5	20,9	13,5
22 / 15	22,4	15,0
22,5 / 15,5	22,9	15,5
23 / 16	23,4	16,0
23,5 / 16,5	23,9	16,5
25,5 / 18,5	25,9	18,5
26 / 19	26,4	19,0
26,5 / 19,5	26,9	19,5
27,5 / 20,5	27,9	20,5
29 / 22	29,4	22,0
29,5 / 22,5	29,9	22,5
30,5 / 23,5	30,9	23,5
31 / 24	31,4	24,0
31,5 / 24,5	31,9	24,5
34,5 / 27,5	34,9	27,5
35 / 28	35,4	28,0

Order Example

Wheel type	D1/D2	Body	Grain	Binder	Assortment
S8200	22/15	KS	D64	G	S8200-22/15 D64 G
S8200	31/24	KS	D126	G	S8200-31/24 D126 G



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Grinding Wheel Selection Guide

Description of Product Symbolism

Electroplated grinding wheels are designated according to the table found in the “ORDER EXAMPLE” section. This table is included in the description of each product. For electroplated tools, a steel body (/KS/) is always used.

Note

We do not coat bodies made of stainless steel or those coated with other materials.

Bond Designation

The electroplated bond is designated by the symbol /G/.

Grain Grit

The grain grit is specified in the table according to the FEPA designation.

Proper selection of grain size ensures correct wheel performance and achieves the intended surface finish. In general, the smaller the grain size, the smoother the machined surface. However, one should not always aim for the smoothest possible surface, but rather for achieving the desired results in the shortest possible time. This means using the coarsest grain that allows reaching an acceptable surface finish.

Grain Concentration

For electroplated diamond grinding wheels, a grain concentration of K50 has been adopted, corresponding to 2.2 grains per 1 cm² of the abrasive layer. For CBN (borazon) grinding wheels, a concentration of V120 has been adopted, corresponding to 2.09 grains per 1 cm² of the wheel's working layer.

Cooling During Machining

Wet grinding (with cooling) is superior to dry grinding (without cooling) in terms of both wheel life and cutting efficiency. Cooling improves grinding conditions by enhancing chip removal and reducing temperature in the grinding zone. Therefore, wherever possible, wet grinding should be used.

For diamond grinding wheels, it is recommended to use low-percentage oil-water emulsions as the coolant, while for CBN (borazon) grinding wheels, mineral oils with additives that enhance cooling efficiency are recommended.



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Recommended Machining Parameters

When machining holes with electroplated mounted (shaft) grinding wheels, it is recommended to use the machining parameters listed below:

PARAMETR	DIAMOND	CBN (Borazon)
Peripheral Grinding Speed	20 – 30 m/s	20 – 30 m/s
Wheel Rotational Speed	Dependent on Wheel Diameter	Dependent on Wheel Diameter
Feed Rate	1 – 5 mm	1 – 5 mm
Table Feed	0,5 – 5 m/min	0,5 – 5 m/min
Max. Allowance per Double Pass	20% Grain Size	20% Grain Size

Excessive allowances should not be used when grinding with fine-grain wheels, as this increases abrasive layer wear and worsens the surface quality of the workpiece. For rough machining, the coarsest possible grain should always be selected to achieve maximum grinding efficiency.

It is recommended to use a grinding depth not exceeding 20% of the nominal grain size per double pass of the wheel. For example, for D126 (B126) grain, the grinding allowance should not exceed 0.025 mm.

Ordering

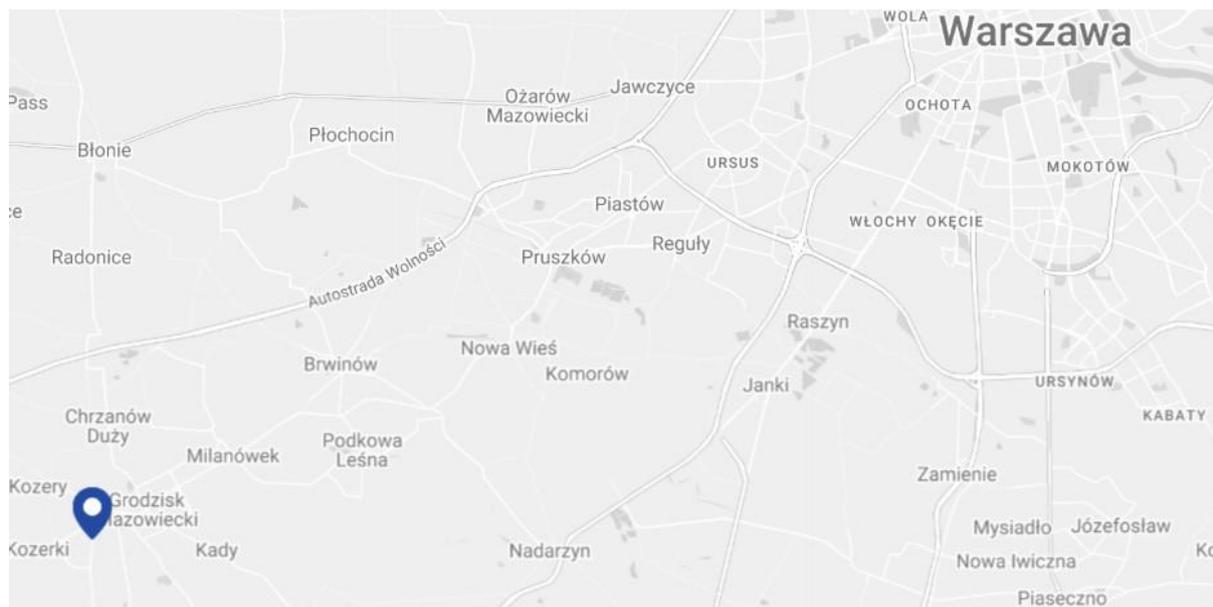
Whenever possible, please specify in the order the type of material being machined and the machining operation (roughing or finishing), its conditions, and the type of machine for which the grinding wheels are intended, as well as a drawing. This will allow the wheel to be tailored to your needs as precisely as possible.

If the desired grinding wheel is not listed on our website, we can manufacture it to **your special order**. The website presents examples of the most popular products from our offer.



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