

Ceramic-Bond CBN Grinding Wheels, C03



Characteristics

These grinding wheels are manufactured from a superhard abrasive material—cubic boron nitride (CBN)—bonded with a ceramic binder. High-performance wheels are used for machining superhard materials that require high dimensional accuracy and superior surface finish grades. Compared to conventional tools, ceramic-bond CBN grinding wheels demonstrate a significant advantage in high-efficiency grinding processes. The physical properties of CBN (hardness, wear resistance, and high-temperature resistance), combined with the characteristics of the ceramic bond (hardness, brittleness, and porous tool structure), enable more efficient material removal and ensure high-quality grinding performance.

Borazon – cubic boron nitride (CBN) – is classified as a superhard material due to its significantly higher hardness compared to conventional abrasives such as aluminum oxide (Al_2O_3) and silicon carbide (SiC). CBN is used in grinding processes where achieving excellent surface quality combined with high machining efficiency is a priority.

The main advantages of abrasive tools made of cubic boron nitride (CBN) are as follows:

- long service life combined with excellent profile retention
- short machining time
- reduced auxiliary times due to less frequent tool changes
- elimination of thermal damage to machined surfaces due to lower grinding temperatures
- lower grinding temperatures
- maintained working profile accuracy



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Applications

- high-speed steels (HSS)
- tool steels
- case-hardening steels
- bearing steels
- stainless and high-alloy steels with a hardness of at least 55 HRC

These grinding wheels can be manufactured with either a ceramic core or a metal core. A metal core should be used for diameters above Ø300 mm, as it offers greater structural uniformity and allows operation at higher rotational speeds.

Ceramic cutting tools, such as milling cutters and turning inserts, are gaining increasing popularity in industry due to their unique properties and advantages. Manufactured from materials such as silicon carbide, aluminum oxide, and boron nitride, these tools are characterized by high hardness, excellent wear resistance, and outstanding thermal stability.

Ceramic cutting tools are used across various industrial sectors, including the automotive, aerospace, energy, and medical industries. They are particularly suitable for machining high-hardness materials, where conventional tools may wear rapidly or fail to deliver satisfactory results.



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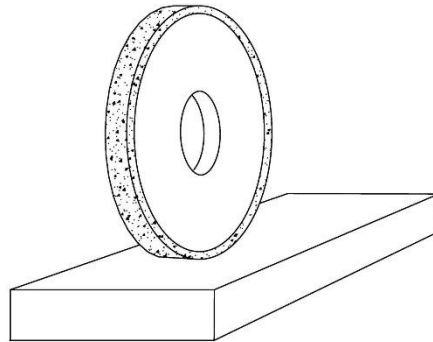
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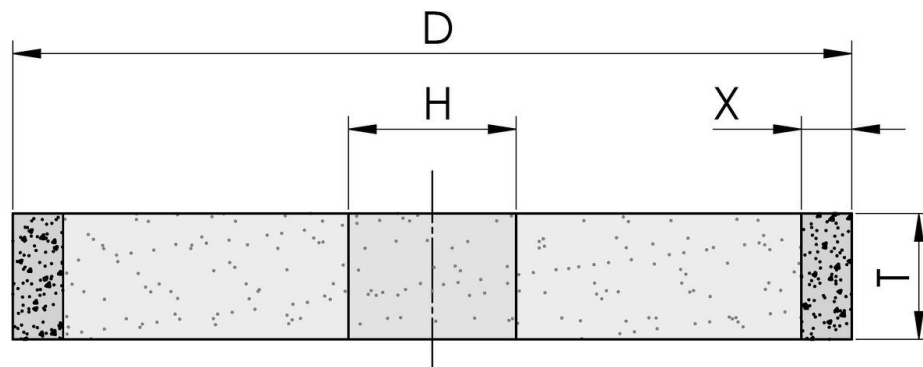
Grinding Wheels – Type 1A1

Application

The Type **1A1** cylindrical grinding wheel is intended for external cylindrical (“round”) grinding, surface grinding, and gear grinding. It can also be successfully used for internal grinding.



Dimensions



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Producent narzędzi ściernych
supertwardych i konwencjonalnych

D	T	X	H
25	20 25	5	6 8
28	20 25	5	10
30	20 25 30	5	8 10 13
32	15 20 25 32	5	8 10 13
35	20 25 33	5	10 13 16
40	10 20 25	5	8 10 13 16
40	40	5	10 13 16
45	15 25	5	13 16
50	3 5	5	10 13
50	10 13 16	5	8 10 13 16 20
50	20 25	5	10 13 16 20
50	32 40 50	5	13 16 20
63	6 10 20 32 50	5	16 20
70	10 32	5	20
80	6 10 20 32 45	5	20
90	5 15	5	20
100	6 10 20 32	5	20
125	8 10 20 25 30 40 60	5	20 32
150	10 15 20 25	5	20 32
160	10 13 16	5	20 32
160	20	5 10	20 32
160	25 30 32	5	20 32
160	60	5	32
200	10 15 20 25	5 10	32 51
225	10 15 20 25	5 10	51
250	10 15 20 25 40	5	51 76
300	15 20 25	5	76 127
320	15 20 25	5	127
350	20 25	5 10	76 127
360	15 20 25	5	127
400	15 20 25	5	127
400	32 40	10	127

Order Example

Wheel type	DTX H	Body	Grain	Concentration	Weight Parameters	Assortment
1A1	125x10x5x32	KC	B107	V240	MV	1A1-125x10x5x32 KC B107 V240 MV
1A1	400x20x5x127	KA	B126	V240	TV	1A1-400x20x5x127 KA B126 V240 TV



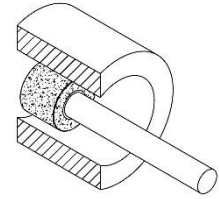
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Producent narzędzi ściernych
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Grinding Wheels – Type 1A1W

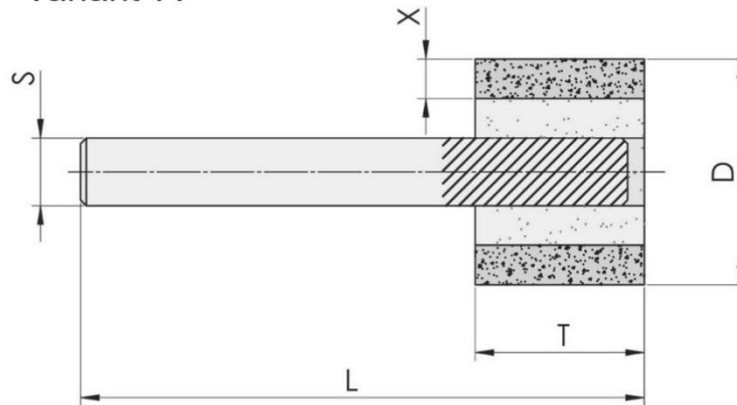
Application

The Type **1A1W** mounted grinding wheel is intended for internal grinding of rolling bearing rings, locating bores, and high-precision cutting tools (such as milling cutters and reamers). It is also used for coordinate grinding of components with complex geometries.

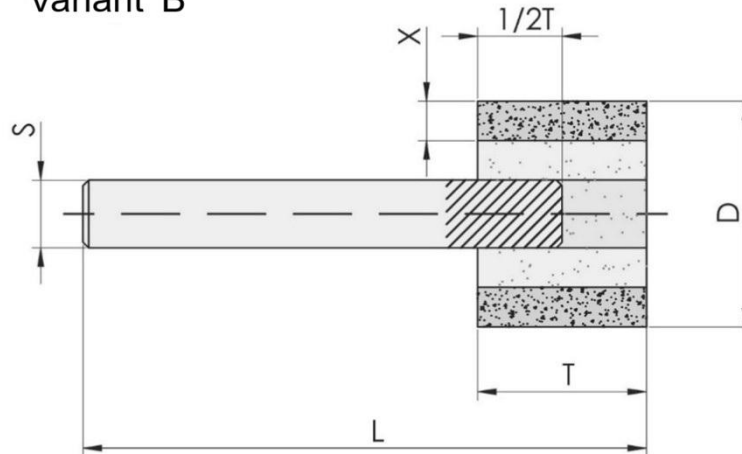


Dimensions

Variant 'A'



Variant 'B'



D	T	X	S	L	Variant
25	20 25	5	8 10	50 60 80 100 120	A B
28	20 25	5	8 10	50 60 80 100 120	A B
30	20 25 30	5	8 10	60 80 100 120	A B

Order Example

Wheel type	D T X S/L	Body	Grain	Concent ration	Weight Parameters	Assortment
1A1W/A	28x20x5x8/100	KS	B107	V240	MV	1A1W/A-28x20x5x8/100 KS B107 V240 MV
1A1W/B	30x30x5x10/40	KS	B151	V240	TV	1A1W/B-30x30x5x10/40 KS B151 V240 TV



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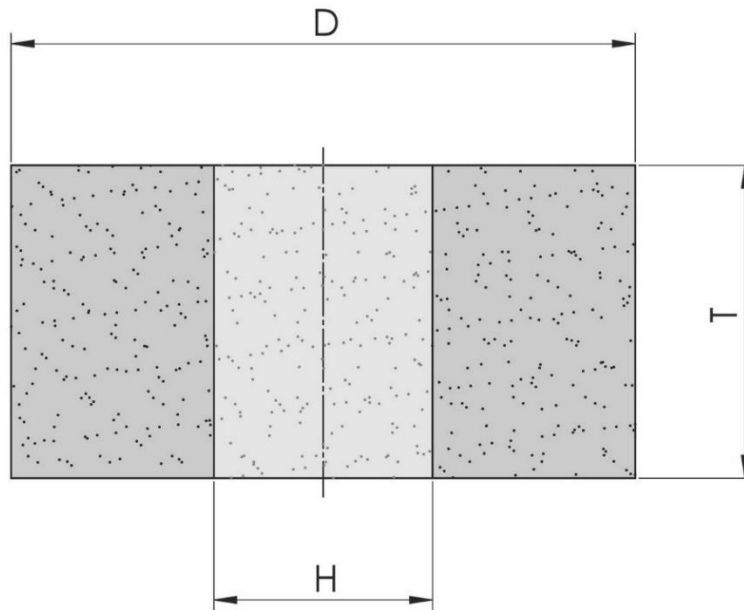
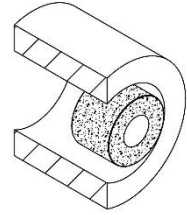
Producent narzędzi ściernych
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Grinding Wheels – Type 1A8

Application

The Type **1A8** grinding wheel is intended for internal grinding of rolling bearing rings, locating bores, and high-precision cutting tools (such as milling cutters and reamers).

The grinding wheel is also used for coordinate grinding of components with complex geometries.



D	T	H
3	6 10	0,9
4	8 10	1,6
5	8 10	2
6	6 8 10	2,6 3
8	8 10 12	3
10	10 13 16 20	3 4
12	10 13 16 20	3 6
13	10 13 16 20	3 4 6
14	10 13 16	5
15	10 13 16 20	5 6
16	10 13 16 20 25	4 5 6
17	10 13 16 20 25	6
20	10 15 20 25	5 6

Order Example

Wheel type	DTH	Body	Grain	Concentration	Weight Parameters	Assortment
1A8	15x16x6	KC	B107	V240	MV	1A8-15x16x6 KC B107 V240 MV
1A8	17x25x6	KC	B126	V240	TV	1A8-17x25x6 KC B126 V240 TV



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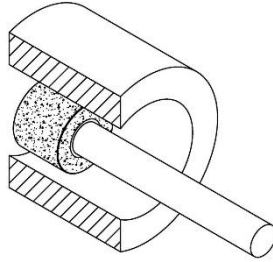
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Grinding Wheels – Type 1A8W

Application

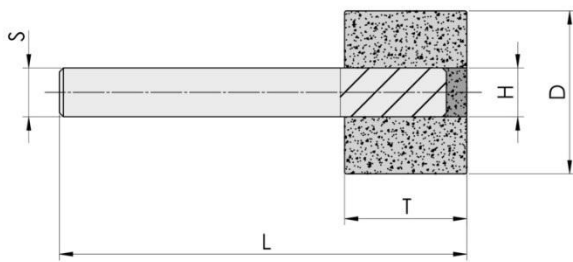
The Type **1A8W** mounted grinding wheel is intended for internal grinding of rolling bearing rings, locating bores, and high-precision cutting tools (such as milling cutters and reamers).

The grinding wheel is also used for coordinate grinding of components with complex geometries.

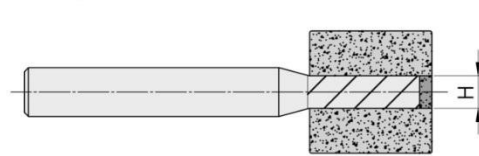


Dimensions

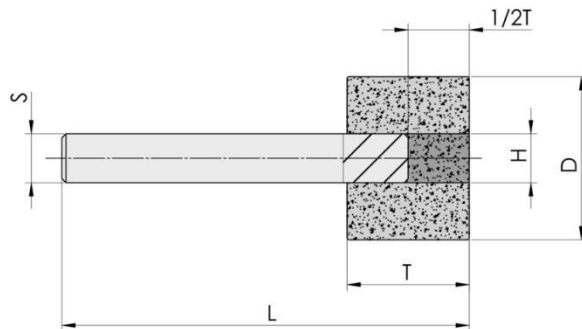
Variant 'A'



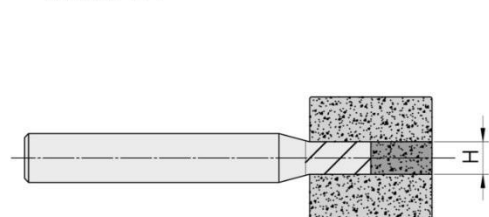
Variant 'A1'



Variant 'B'



Variant 'B1'



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Producent narzędzi ściernych
supertwardych i konwencjonalnych

D	T	H	S	L	Variant
3	6	0,9	3	40 50 60	A1 B1
4	8 10	1,6	3 4	40 50 60	A1 B1
5	8 10	2	3 4 5	40 50 60	A1 B1
6	6 8 10	2,6	3 4 5 6	40 50 60	A1 B1
6	6 8 10	3	3	40 50 60	A B
8	8 10 12	3	3	40 50 60	A B
8	8 10 12	3	4 5 6	40 50 60	A1 B1
10	10 13 16 20	3	3	40 50 60	A B
10	10 13 16 20	3	4 5 6	40 50 60	A1 B1
10	10 13 16 20	4	4	40 50 60	A B
10	10 13 16 20	4	5 6	40 50 60	A1 B1
10	10 13 16 20	4	5 6	40 50 60	A1 B1
12	10 13 16 20	3	6	40 50 60 80 100 120	A1 B1
12	10 13 16 20	6	6	40 50 60 80 100 120	A B
12	10 13 16 20	6	8 10	40 50 60 80 100 120	A1 B1
13	10 13 16 20	3 4	6 8 10	40 50 60 80 100 120	A1 B1
13	10 13 16 20	6	6	40 50 60 80 100 120	A B
13	10 13 16 20	6	8 10	40 50 60 80 100 120	A1 B1
14	10 13 16	5	6 8 10	40 50 60 80 100 120	A1 B1
14	10 13 16	6	6	40 50 60 80 100 120	A B
14	10 13 16	6	8 10	40 50 60 80 100 120	A1 B1
15	10 13 16 20	5	6 8 10	40 50 60 80 100 120	A1 B1
15	10 13 16 20	6	6	40 50 60 80 100 120	A B
15	10 13 16 20	6	8 10	40 50 60 80 100 120	A1 B1
16	10 13 16 20 25	4 5	6 8 10	40 50 60 80 100 120	A1 B1
16	10 13 16 20 25	6	6	40 50 60 80 100 120	A B
16	10 13 16 20 25	6	8 10	40 50 60 80 100 120	A1 B1
17	10 13 16 20 25	6	6	40 50 60 80 100 120	A B
17	10 13 16 20 25	6	8 10	40 50 60 80 100 120	A1 B1
20	10 15 20 25	5 6	8 10	40 50 60 80 100 120	A1 B1
20	10 15 20 25	6	6	40 50 60 80 100 120	A B

Order Example

Wheel type	D T H S/L	Body	Grain	Concentration	Weight Parameters	Assortment
1A8W/A1	10x20x4x5/50	KS	B107	V240	MV	1A8W/A1-10x20x4x5/50 KS B107 V240 MV
1A8W/B1	20x15x6x8/80	KS	B151	V240	TV	1A8W/B1-20x15x6x8/80 KS B151 V240 TV



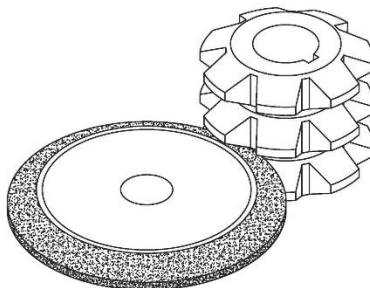
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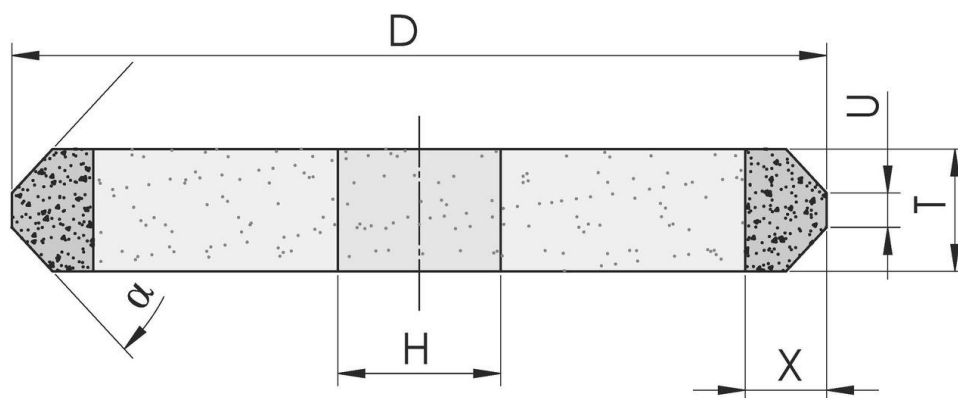
Grinding Wheels – Type 1D1

Application

The Type **1D1** profile grinding wheel is intended for grinding the teeth of hob cutters, as well as for grinding involute broaches and lead screw threads.



Dimensions



D	T	X	U	α	H
50	8	15	1	50°	20
80	13	15	2	40° 60°	20
125	8 10	12	2	40° 60°	32
125	13	15	2	40° 60°	32
150	10	12	2	40° 60°	32
150	16	15	3	60°	32

Order Example

Wheel type	DTXUH/ α	Body	Grain	Concentration	Weight Parameters	Assortment
1D1	125x10x12x2x32/40°	KC	B107	V240	MV	1D1-125x10x12x2x32/40° KC B107 V240 MV
1D1	150x10x12x2x32/60°	KC	B126	V240	TV	1D1-150x10x12x2x32/60° KC B126 V240 TV



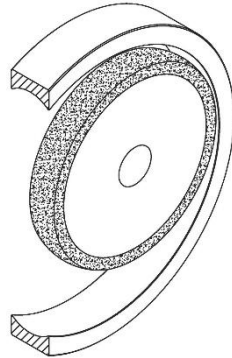
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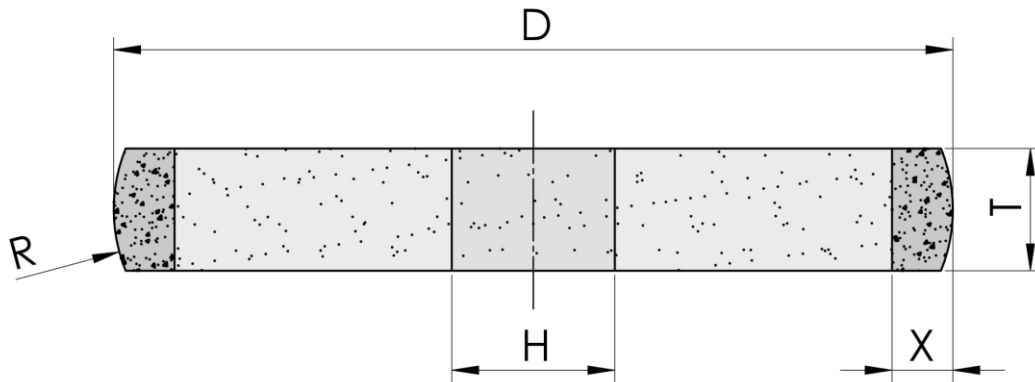
Grinding Wheels – Type 1F1

Application

The Type **1F1** profile grinding wheel is intended for grinding the raceways of rolling bearings.



Dimensions



D	T	X	R	H
50	10	10	20	16
75	10	10	20	20
90	10	10	20	20
90	16	10	20	20
100	10	10	20	20
105	15	10	20	20
125	21 26	10	22,5	20 32
150	14	10	20	20 32
150	16	10	22,5	20 32
160	20	10	25	32
150	10	12	2	32
150	16	15	3	32

Order Example

Wheel type	D T X H	Body	Grain	Concentration	Weight Parameters	Assortment
1F1	125x26x10x32	KC	B107	V240	MV	1F1-125x26x10x32 KC B107 V240 MV
1F1	160x20x10x32	KC	B126	V240	TV	1F1-160x20x10x32 KC B126 V240 TV



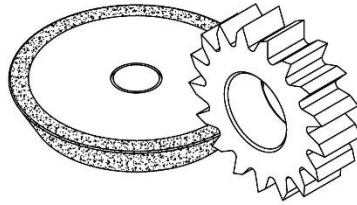
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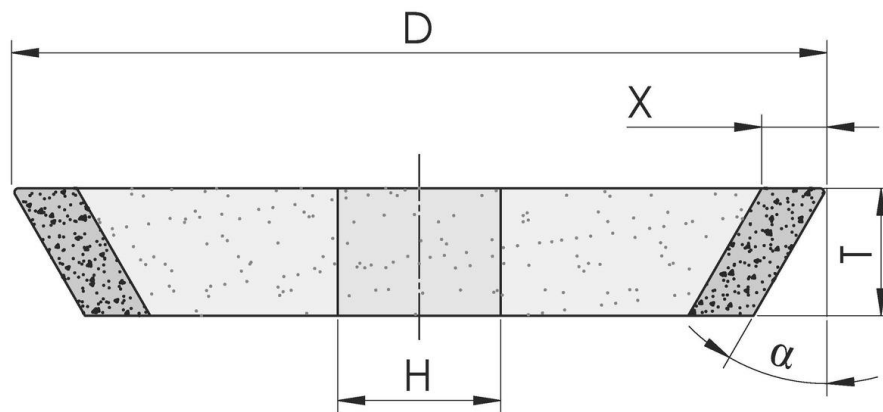
Grinding Wheels – Type 1V1

Application

The Type **1V1** profile grinding wheel is intended for grinding and sharpening cutting tools made of tool steels and high-speed steels (HSS).



Dimensions



D	T	X	α	H
60	10	3	45° 60°	10
60	10	4	30°	20
70	10	5	45° 60°	20
80	10	5	45° 60°	20
100	10 12	5	30° 45° 60°	20
125	10 12	5	30° 45° 60°	20
125	15	5	10°	20

Order Example

Wheel type	D T X H / α	Body	Grain	Concentration	Weight Parameters	Assortment
1V1	60x10x4x10/60°	KC	B107	V240	MV	1V1-60x10x4x10/60° KC B107 V240 MV
1V1	70x8x5x20/46°	KC	B126	V240	TV	1V1-70x8x5x20/46° KC B126 V240 TV



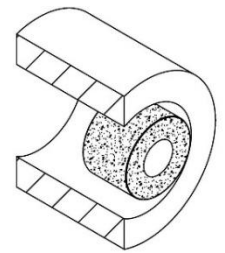
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Grinding Wheels – Type 5A1

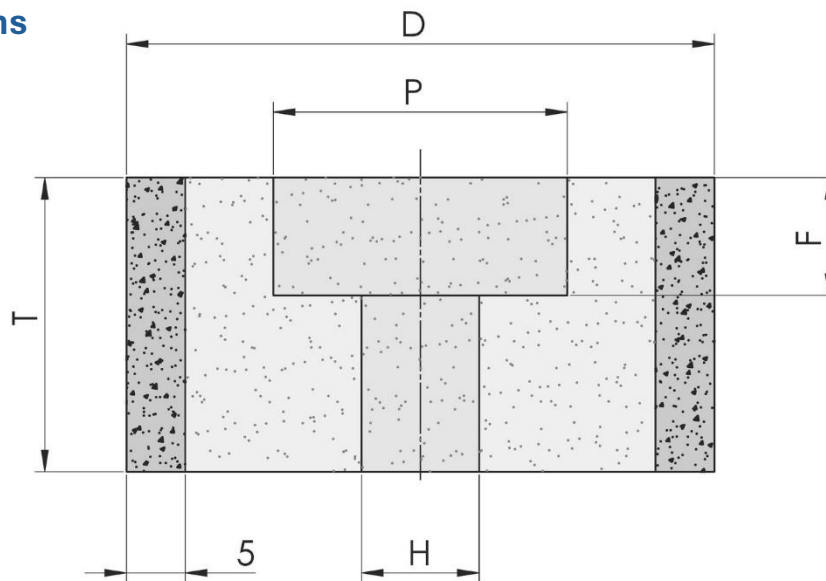
Application

The Type **5A1** grinding wheel is intended for internal grinding of rolling bearing rings, locating bores, and high-precision cutting tools (such as milling cutters and reamers), as well as for coordinate grinding of components with complex geometries. It is used on centerless grinding machines, tool grinding machines, crankshaft grinding machines, and universal grinding machines.



The cylindrical recess reduces the weight of the grinding wheel and improves the position of its center of gravity, thereby increasing the rigidity of the grinding machine–wheel–workpiece system.

Dimensions



D	T	H	Pmax	Fmax
25	20	6 8	12	14
25	25	6 8	12	19
30	20	8 10 13	17	12
30	25	8 10	17	17
30	25	13	17	15
30	30	8 10	17	20
30	30	13	17	18
32	20	8 10 13	19	12
32	25	8 10	19	17
32	25	13	19	15
32	32	8 10	19	22
32	32	13	19	20
35	25	10 13	22	17
35	25	16	22	15
35	33	10 13	22	23
35	33	16	22	21
35	35	10 13	22	22
35	35	16	22	20
40	25	8 10	27	15



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Producent narzędzi ściernych
supertwardych i konwencjonalnych

40	25	13 16	27	13
40	32	8 10	27	19
40	32	13 16	27	17
40	40	8 10	27	27
40	40	13 16	27	25
45	25	13	32	12
50	25	8 10	37	15
50	25	13 16	37	12
50	25	20	37	10
50	32	8 10	37	22
50	32	13 16	37	17
50	32	20	37	12
50	40	8 10	37	27
50	40	13 16	37	24
50	40	20	37	20
50	50	8 10	37	35
50	50	13 16	37	32
50	50	20	37	30
63	25	13 16	50	12
63	25	20	50	10
63	32	13 16	50	16
63	32	20	50	12
63	50	13 16	50	33
63	50	20	50	30
70	25	20	57	10
70	32	20	57	12
70	50	20	57	30
75	25	20	59	10
75	32	20	59	12
75	50	20	59	28
80	32	20	65	12
80	40	20	65	18
90	32	20	72	18
100	25	20 32	85	10
100	32	20 32	85	16
125	25	20 32	110	10
125	40	20 32	110	18
125	50	20 32	110	26
125	60	20 32	110	35
150	25	20 32	130	10
160	25	20 32	140	10
160	32	20 32	140	12
160	60	20 32	140	35

The recess diameters apply to a working layer thickness of $x = 5$ mm.

Order Example

Wheel type	DTH/PF	Body	Grain	Concentration	Weight Parameters	Assortment
5A1	30x25x8/15x12	KC	B107	V240	MV	5A1-30x25x8/15x12 KC B107 V240 MV
5A1	80x45x20/60x10	KC	B126	V240	TV	5A1-80x45x20/60x10 KC B126 V240 TV



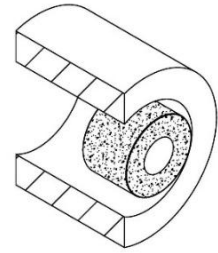
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Grinding Wheels – Type 5A8

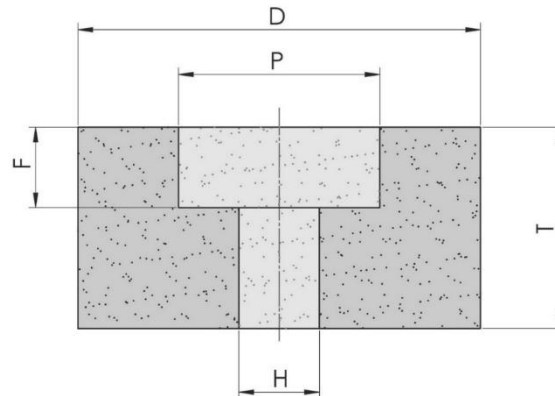
Application

The Type **5A8** grinding wheel is intended for internal grinding of rolling bearing rings, locating bores, and high-precision cutting tools (such as milling cutters and reamers), as well as for coordinate grinding of components with complex geometries. It is used on centerless grinding machines, tool grinding machines, crankshaft grinding machines, and universal grinding machines.



The cylindrical recess reduces the grinding wheel's weight and improves the position of its center of gravity, thereby increasing the rigidity of the grinding machine–wheel–workpiece system.

Dimensions



D	T	H	Pmax	Fmax
10	10	3 4	5	5
10	13	3 4	5	8
13	13	3 4 6	8	8
13	16	3 4 6	8	10
13	20	3 4 6	8	13
15	15 16	5	10	10
15	16	6	10	10
15	20	5	10	14
15	20	6	8	15
15	20	6	10	14
16	16	6	11	10
16	20	4 5 6	11	14
16	25	4 5 6	11	19
17	16	5 6	12	10
17	20	5 6	12	14
17	25	5 6	12	19
20	15	5 6	15	9
20	20	5 6	15	14
20	25	5 6	15	19

Order Example

Wheel type	D T H/P F	Body	Grain	Concentration	Weight Parameters	Assortment
5A8	20x25x6/14x12	KC	B107	V240	M V	5A8-20x25x6/14x12 KC B107 V240 MV
5A8	30x35x8/15x20	KC	B126	V240	T V	5A8-30x35x8/15x20 KC B126 V240 TV



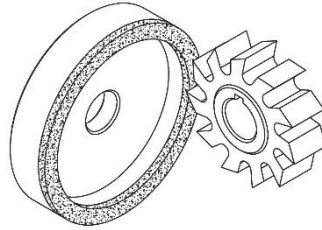
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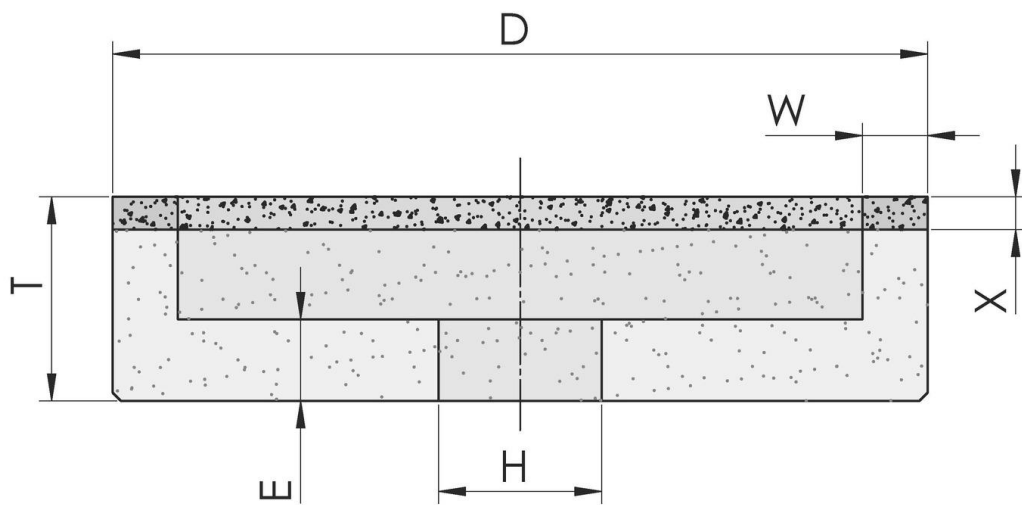
Grinding Wheels – Type 6A2

Application

The Type **6A2** grinding wheel is intended for grinding and sharpening cutting tools made of tool steels and high-speed steels (HSS).



Dimensions



D	W	X	T-X=	E	H
80	5 10	5	20	10	20
100	5 10	5	23	12	20
125	5 10	5	23	12	20
150	5 10	5	23	15	20

Order Example

Wheel type	D W X H	Body	Grain	Concentration	Weight Parameters	Assortment
6A2	100x10x5x20	KC	B107	V240	M V	6A2-100x10x5x20 KC B107 V240 MV
6A2	150x10x5x20	KC	B126	V240	T V	6A2-150x10x5x20 KC B126 V240 TV



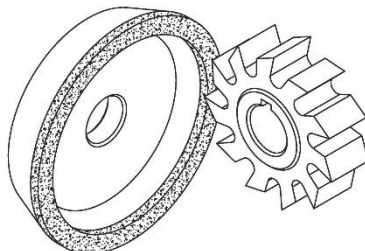
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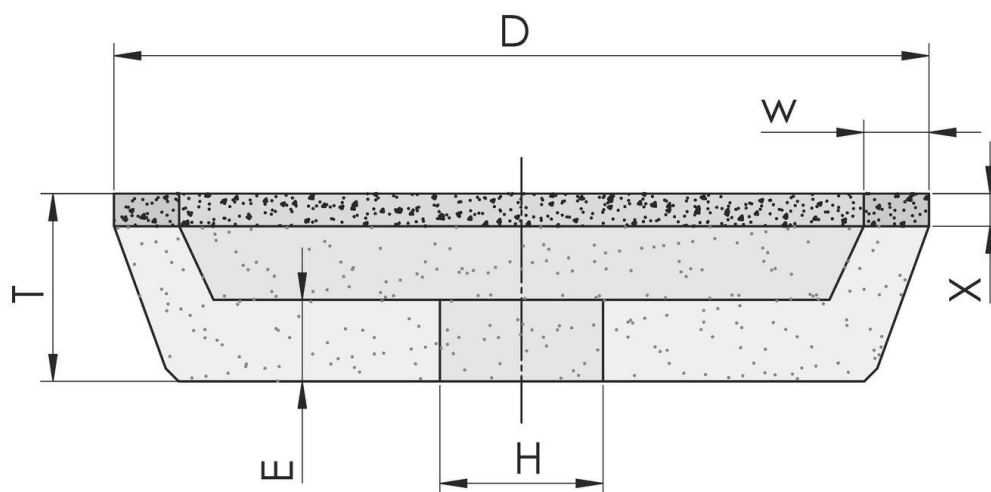
Grinding Wheels – Type 11A2

Application

The Type **11A2** grinding wheel is intended for grinding and sharpening cutting tools made of tool steels and high-speed steels (HSS).



Dimensions



D	W	X	T-X=	E	H
80	5 10	5	20	10	20
100	5 10	5	23	12	20
125	5 10	5	23	12	20
150	5 10	5 10	23	15	20 32

Order Example

Wheel type	D W X H	Body	Grain	Concentration	Weight Parameters	Assortment
11A2	100x10x5x20	KC	B107	V240	MV	11A2-100x10x5x20 KC B107 V240 MV
11A2	150x10x10x32	KC	B126	V240	TV	11A2-150x10x10x32 KC B126 V240 TV



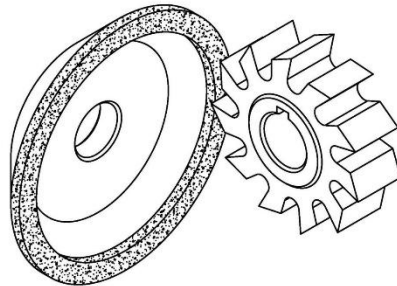
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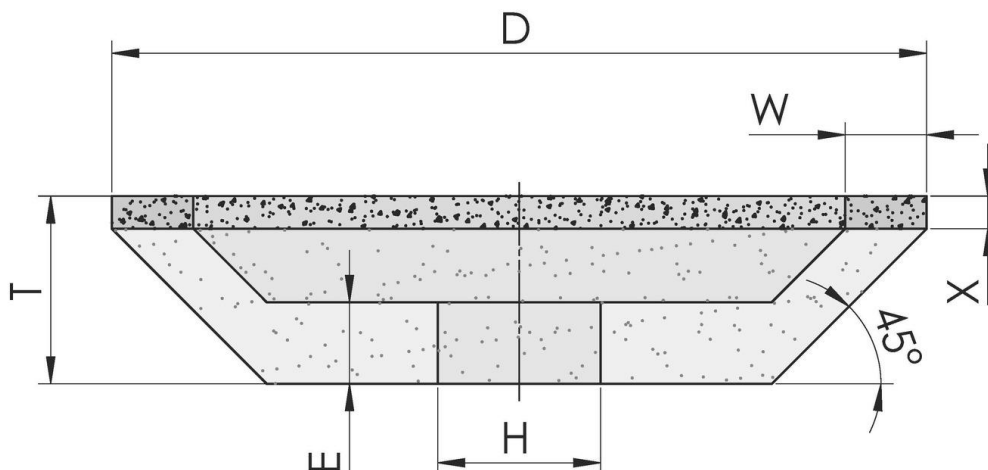
Grinding Wheels – Type 12A2/45°

Application

The Type **12A2/45°** grinding wheel is intended for grinding and sharpening cutting tools made of tool steels and high-speed steels (HSS).



Dimensions



D	W	X	T-X=	E	H
80	5 10	5	20	10	20
100	5 10	5	23	12	20
125	5 10	5	23	12	20 32
150	5 10	5 10	23	15	20 32

Order Example

Wheel type	D W X H	Body	Grain	Concent ration	Weight Parameters	Assortment
12A2/45°	100x5x5x20	KC	B107	V240	M V	12A2/45°-100x5x5x20 KC B107 V240 MV
12A2/45°	150x10x5x20	KC	B126	V240	T V	12A2/45°-150x10x5x20 KC B126 V240 TV



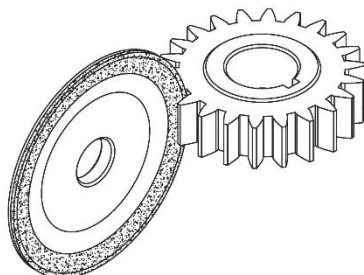
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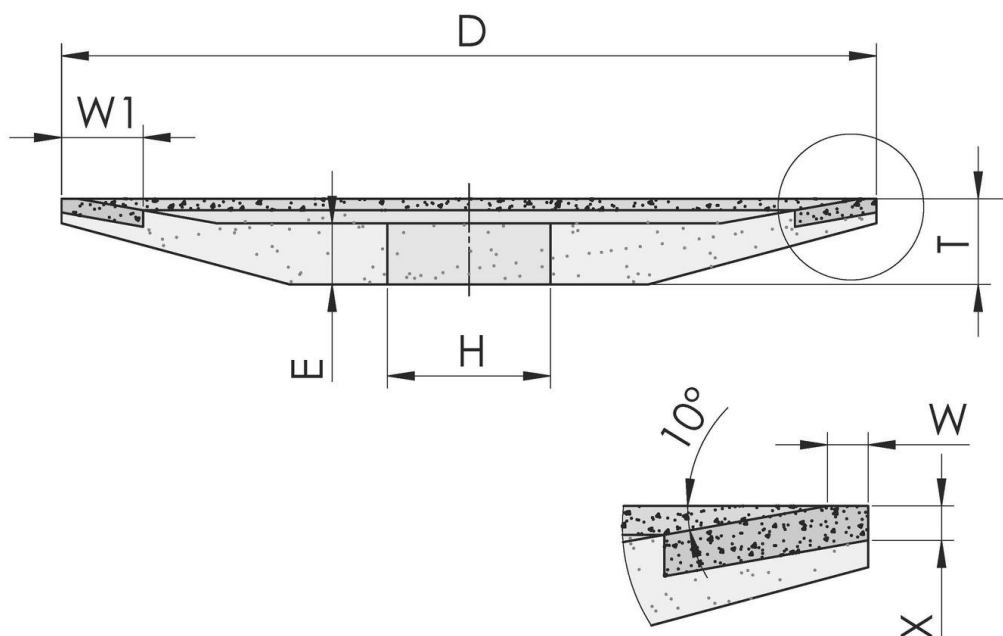
Grinding Wheels – Type 12R9

Application

The Type **12R9** profile grinding wheel is intended for gear grinding and for sharpening multi-edge cutting tools, such as reamers.



Dimensions



D	W	X	W1	T	E	H
100	2	2	10	10,5	7,5	20
125	2	2	10	13,5	9,5	20 32
135	2	2	10	16,5	11,5	20 32
150	4	2	10	16,5	11,5	32
150	4	5	15	16,5	11,5	32

Order Example

Wheel type	D W X H	Body	Grain	Concentration	Weight Parameters	Assortment
12R9	100x2x2x20	KC	B107	V240	MV	12R9-100x2x2x20 KC B107 V240 SV
12R9	125x2x2x32	KC	B126	V240	TV	12R9-125x2x2x32 KC B126 V240 TV



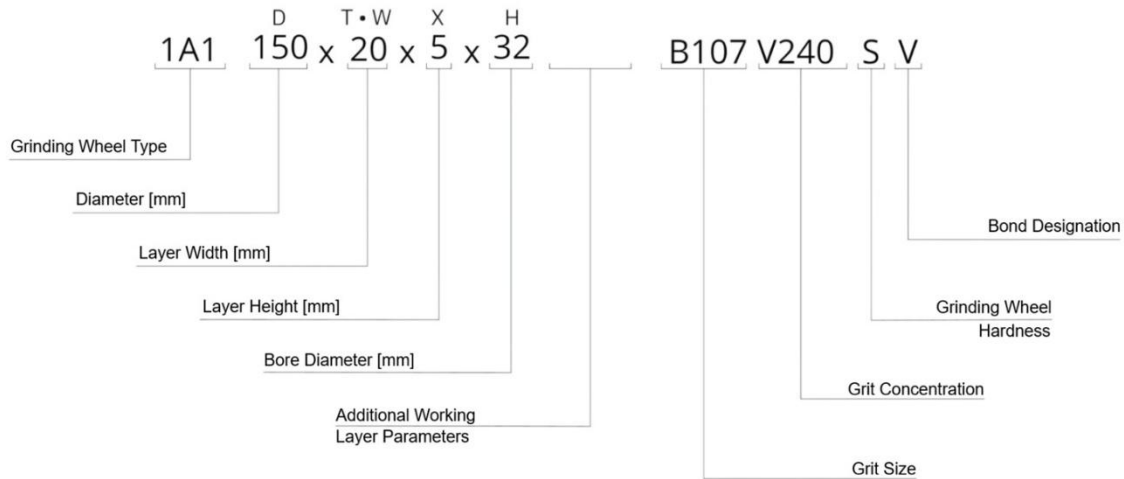
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Grinding Wheel Selection Guide

Product Coding Description

Ceramic-bond CBN grinding wheels are designated according to the following scheme:



Geometrical Parameters

Grinding Layer Parameters

Grit Size

The grit size is specified in the table in accordance with the FEPA designation.

Standard Grit Concentration Values

Concentration defines the amount of cubic boron nitride (CBN) grit per unit volume of the grinding wheel's working layer. The standard grit concentration for ceramic-bond grinding wheels is V240. Other available concentration values include V180 and V300.

Grinding Wheel Use

Storage

Proper storage of grinding wheels ensures they remain fully operational and is a prerequisite for safe use. Ceramic-bond grinding wheels should be stored at a temperature of at least 4°C, with a maximum relative humidity of 70%.

Mounting

Before mounting the grinding wheel on the machine spindle, it must be checked by performing a ring (sound) test. A clear, ringing sound indicates the absence of internal cracks, whereas a dull or short sound with changing frequency may indicate internal, often invisible microcracks. Mounting such a grinding wheel is strictly prohibited.



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Balancing

Before a new grinding wheel is put into operation, it must always be carefully balanced to correct manufacturing inaccuracies related to its geometry and structure. Due to the high rotational speeds involved, grinding wheels should be dynamically balanced to ensure safe operating conditions. Dynamic balancing enables significantly lower vibration amplitudes compared to static balancing. It is recommended to perform balancing directly on the grinding machine using specialized equipment, e.g., VibroDAQ-type systems.

Dressing

A prerequisite for proper grinding performance is adapting the shape of the grinding wheel's working surface to the specific application.

Dressing is used to impart the required geometry to the working layer of a new grinding wheel or to restore its original cutting properties during the grinding process.

Grinding Speed

In grinding operations, grinding speed - defined as the linear speed of the abrasive grains on the surface of the grinding layer - plays a crucial role. The proper selection of this speed, depending on the workpiece material and the type of operation, is a fundamental factor in achieving optimal grinding results.

An advantage of ceramic-bond CBN grinding wheels is the significantly lower heat generation compared to conventional grinding wheels, which makes it possible to apply particularly high grinding speeds without the risk of thermal damage to the workpiece surface. In light of the above, the use of high grinding speeds is highly beneficial; however, it requires careful balancing of the grinding wheels and the use of machines with sufficient power capacity.

Corrective Procedures

A properly selected ceramic grinding wheel requires only minimal corrective operations during use. These include profile correction and sharpening.

During prolonged operation, abrasive grains gradually wear down. In addition, part of the removed material accumulates in the natural pores of the grinding wheel, causing it to lose its cutting ability.

Dressing the grinding wheel restores its original cutting properties and operational efficiency.

Ordering

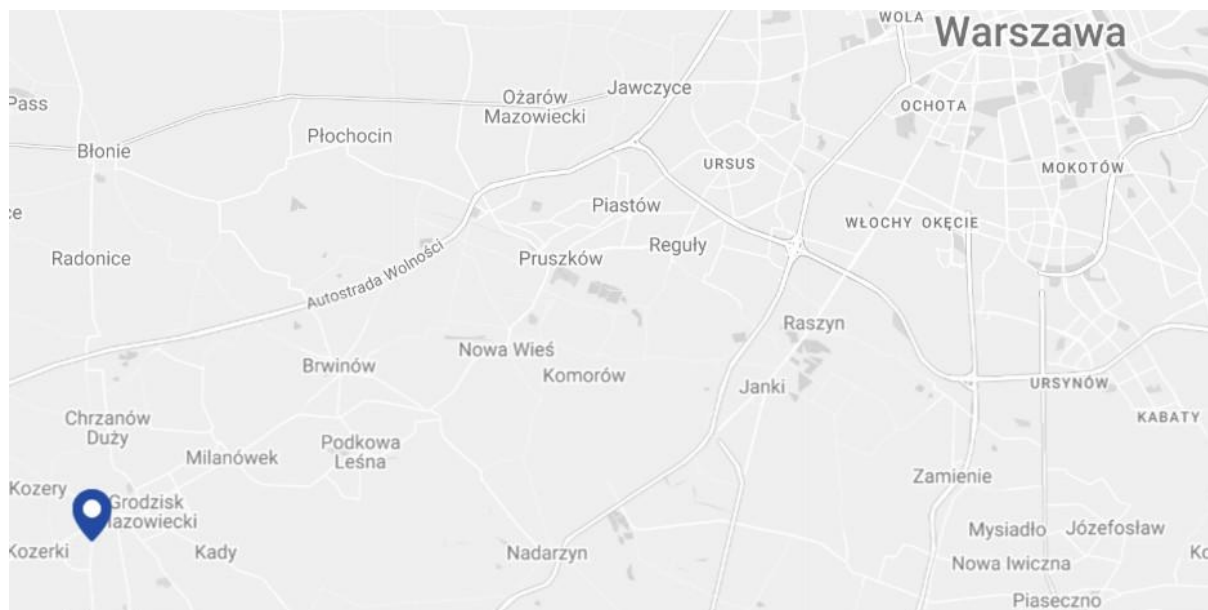
If possible, please specify in your order the type of material, the machining operation and its conditions, as well as the machine type for which the grinding wheels are being selected. This will allow the grinding wheel to be optimally tailored to your requirements.

If the grinding wheel you are looking for is not listed on our website, it can be manufactured to **your specific order**. The website presents examples of the most popular products from our range.



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