

4 ŚCIERNICE OTWOROWE

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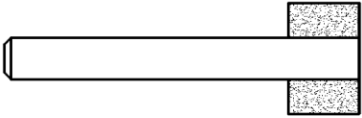
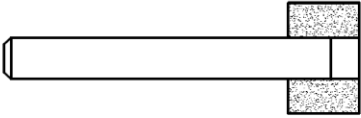
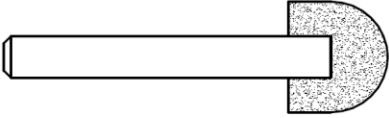
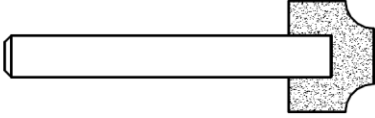
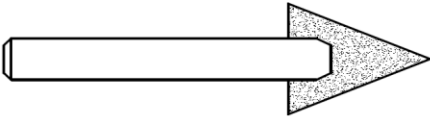
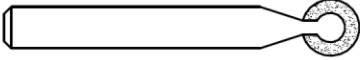
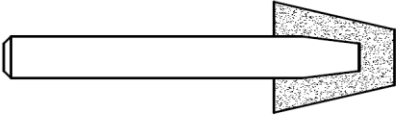
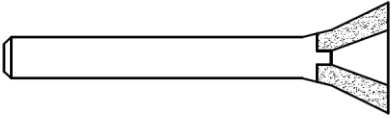
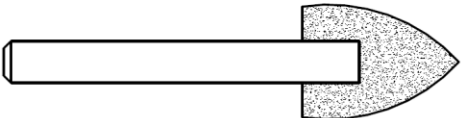
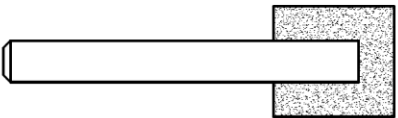
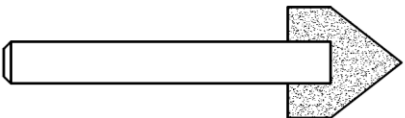
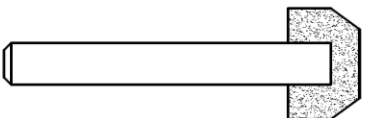
DIALEKS
GRUPA FIRM

KATALOG NR 1/2016

NARZĘDZIA DIAMENTOWE



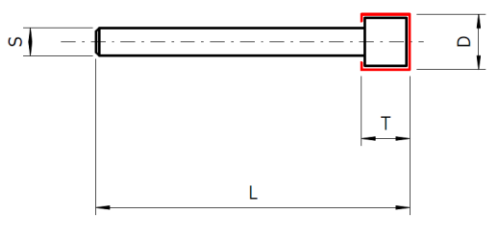
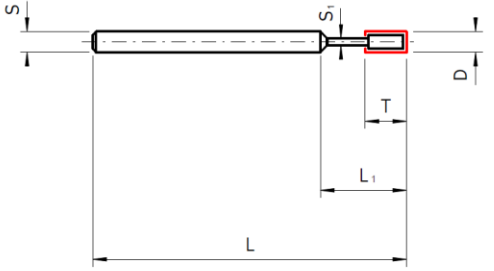
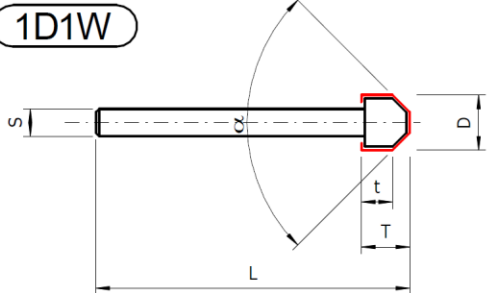
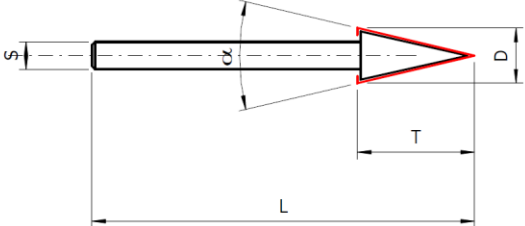
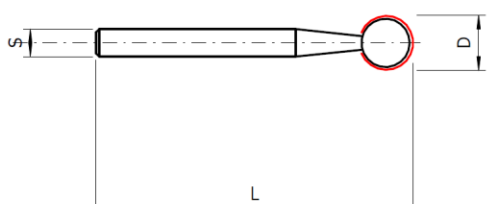
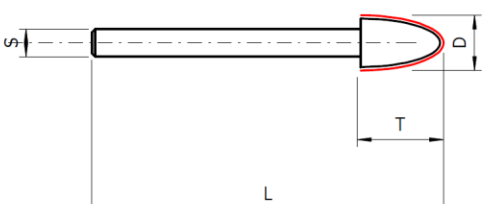
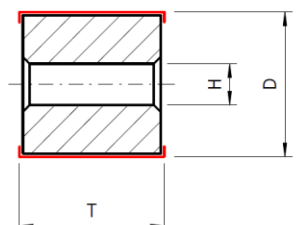
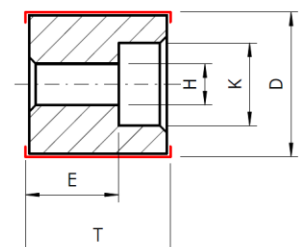
PRZYKŁADOWE KSZTAŁTY ŚCIERNIC WG FEPA

1A1W 	1A1PW 
1F1W 	1G1W 
1K1W 	1R1W 
1V1W 	11V2W 
1T1W 	1U1W 
1E1W 	1D1W 

NARZĘDZIA DIAMENTOWE



ŚCIERNICE DIAMENTOWE I CBN O SPOIWACH GALWANICZNYCH

<p>1A1W</p> 	<p>1A1W</p> 
<p>1D1W</p> 	<p>1E1W</p> 
<p>1R1W</p> 	<p>1T1W</p> 
<p>1A1</p> 	<p>6A1</p> 

NARZĘDZIA DIAMENTOWE



ŚCIERNICE DIAMENTOWE I CBN O SPOIWACH ŻYWICZNYCH

<p>1A1W</p> <p>Technical drawing of diamond tool 1A1W. It shows a cylindrical tool with a diameter D and a total length L. The diameter of the grinding wheel is X, and the thickness of the tool body is T. The distance from the end of the tool to the start of the grinding wheel is S.</p>	<p>1A1W</p> <p>Technical drawing of diamond tool 1A1W. It shows a cylindrical tool with a diameter D and a total length L. The diameter of the grinding wheel is S_1, and the thickness of the tool body is T. The distance from the end of the tool to the start of the grinding wheel is S. The length of the grinding wheel is L_1.</p>
<p>1A8W</p> <p>Technical drawing of diamond tool 1A8W. It shows a cylindrical tool with a diameter D and a total length L. The thickness of the tool body is T. The distance from the end of the tool to the start of the grinding wheel is S.</p>	<p>1A8W</p> <p>Technical drawing of diamond tool 1A8W. It shows a cylindrical tool with a diameter D and a total length L. The diameter of the grinding wheel is S_1, and the thickness of the tool body is T. The distance from the end of the tool to the start of the grinding wheel is S. The length of the grinding wheel is L_1.</p>
<p>1E8W</p> <p>Technical drawing of diamond tool 1E8W. It shows a cylindrical tool with a diameter D and a total length L. The thickness of the tool body is T. The distance from the end of the tool to the start of the grinding wheel is S. The grinding wheel has a chamfered edge with an angle α.</p>	<p>1D8W</p> <p>Technical drawing of diamond tool 1D8W. It shows a cylindrical tool with a diameter D and a total length L. The thickness of the tool body is T. The distance from the end of the tool to the start of the grinding wheel is S. The grinding wheel has a chamfered edge with an angle α and a thickness t.</p>
<p>1A1</p> <p>Technical drawing of diamond tool 1A1. It shows a cylindrical tool with a diameter D and a thickness T. The distance from the end of the tool to the start of the grinding wheel is H. The diameter of the grinding wheel is X.</p>	<p>6A1</p> <p>Technical drawing of diamond tool 6A1. It shows a cylindrical tool with a diameter D and a thickness T. The distance from the end of the tool to the start of the grinding wheel is E. The distance from the end of the tool to the start of the grinding wheel is H. The diameter of the grinding wheel is K.</p>

NARZĘDZIA DIAMENTOWE



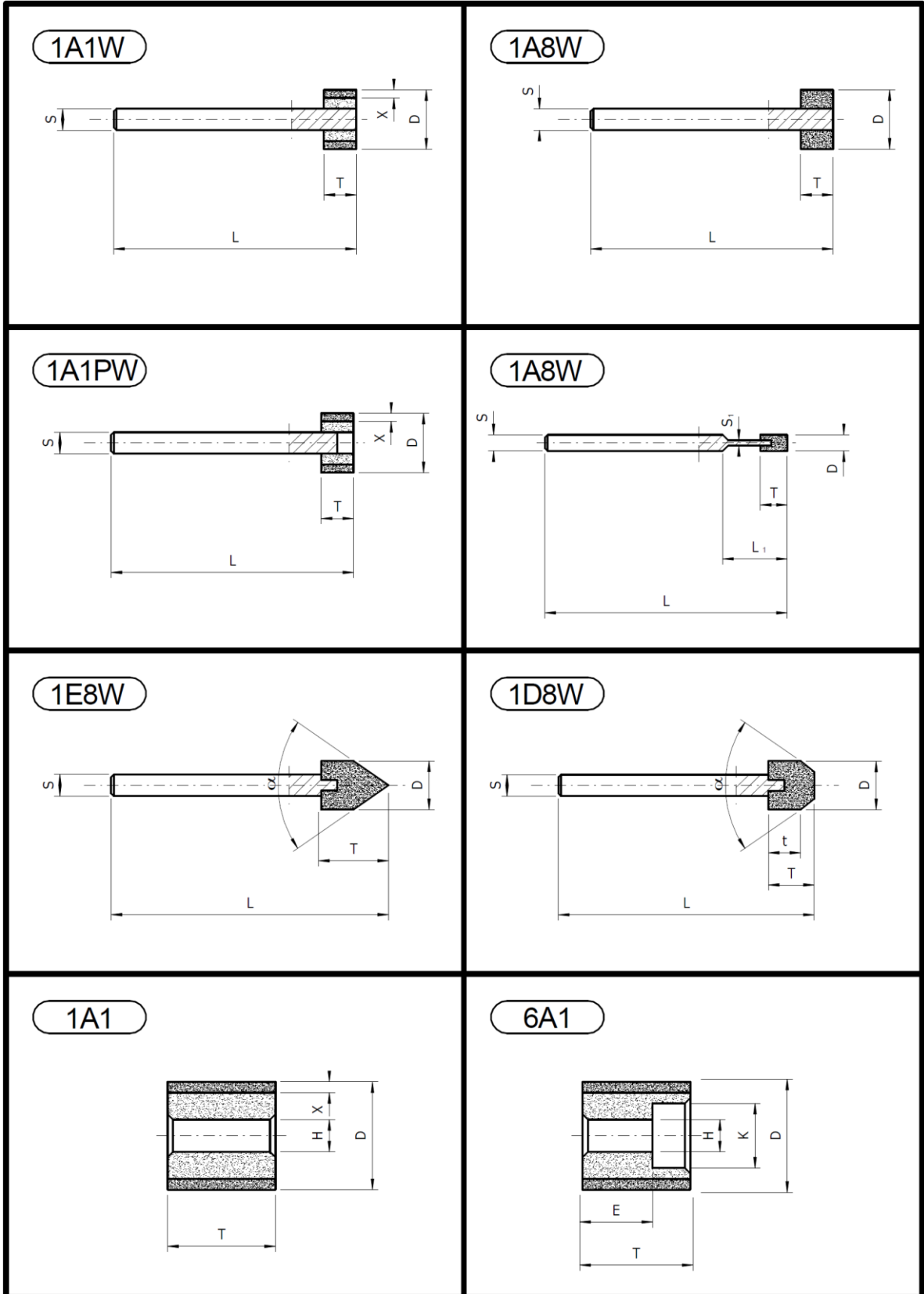
ŚCIERNICE DIAMENTOWE I CBN O SPOIWACH METALOWYCH

<p>1A1W</p>	<p>1A1W</p>
<p>1A8W</p>	<p>1A8W</p>
<p>1E8W</p>	<p>1D8W</p>
<p>1A1</p>	<p>6A1</p>

NARZĘDZIA DIAMENTOWE



ŚCIERNICE DIAMENTOWE I CBN O SPOIWACH CERAMICZNYCH







NARZĘDZIA DIAMENTOWE



Zalecane prędkości skrawania w m/sek.

Wielkości ziaren

SPOIWO	DIAMENT		CBN		FEPA		US-MESH	mic.
					DIA	CBN		
GALWANICZNE (GD)	15	20	20	30	D46	B46	325/400	45/38
METALOWE (SM)	15	18			D54	B54	270/325	53/45
ŻYWICZNE (SZ)	15	20	20	30	D64	B64	230/270	63/53
					D76	B76	200/230	75/63
CERAMICZNE (SC)				30	D91	B91	170/200	90/75
					D107	B107	140/170	106/90
					D126	B126	120/140	125/106
					D151	B151	100/120	150/125
					D181	B181	80/100	180/150
					D213	B213	70/80	212/180

D [mm]	Prędkość obrotowa m/sek							
	10	12	15	20	25	30	35	40
1								
2	95 500							
3	63 700	76 400	95 500					
4	47 700	57 300	71 600	95 500				
5	38 200	45 800	57 300	76 400	95 500			
6	31 800	38 200	47 700	63 700	79 600	95 500		
7	27 300	32 700	40 900	54 600	68 200	81 900	95 500	
8	23 900	28 600	35 800	47 700	59 700	71 600	83 600	95 500
9	21 200	25 500	31 800	42 400	53 100	63 700	74 300	84 900
10	19 100	22 900	28 600	38 200	47 700	57 300	66 800	76 400
11	17 400	20 800	26 000	34 700	43 400	52 100	60 800	69 500
12	15 900	19 100	23 900	31 800	39 800	47 700	55 700	63 700
13	14 700	17 600	22 000	29 400	36 700	44 100	51 400	58 800
14	13 600	16 400	20 500	27 300	34 100	40 900	47 700	54 600
15	12 700	15 300	19 100	25 500	31 800	38 200	44 600	50 900
16	11 900	14 300	17 900	23 900	29 800	35 800	41 800	47 700
17	11 200	13 500	16 900	22 500	28 100	33 700	39 300	44 900
18	10 600	12 700	15 900	21 200	26 500	31 800	37 100	42 400
19	10 100	12 100	15 100	20 100	25 100	30 200	35 200	40 200
20	9 500	11 500	14 300	19 100	23 900	28 600	33 400	38 200
21	9 100	10 900	13 600	18 200	22 700	27 300	31 800	36 400
22	8 700	10 400	13 000	17 400	21 700	26 000	30 400	34 700
23	8 300	10 000	12 500	16 600	20 800	24 900	29 100	33 200
24	8 000	9 500	11 900	15 900	19 900	23 900	27 900	31 800
25	7 600	9 200	11 500	15 300	19 100	22 900	26 700	30 600

KATALOGI NARZĘDZI DIAMENTOWYCH

1 ŚCIERNICE

O spoiwach żywicznych, metalowych, ceramicznych, galwanicznych

2 OBCIĄGACZE

Jedno i wieloziarniste, szlifowane, agregatowe, płytkowe, krążkowe, pyłowe

3 WGŁĘBNIKI

Rockwell, Vickers, Knoop

4 ŚCIERNICE DO OTWORÓW

O spoiwach żywicznych, metalowych, ceramicznych, galwanicznych

5 PILNIKI

Igłowe, ślusarskie

6 PASTY

Wodne i olejowe, zawiesiny, sprays, sztyfty

7 HONOWNIKI

Diamantowe i CBN o spoiwie metalowym, żywicznym

Dystrybutor :

