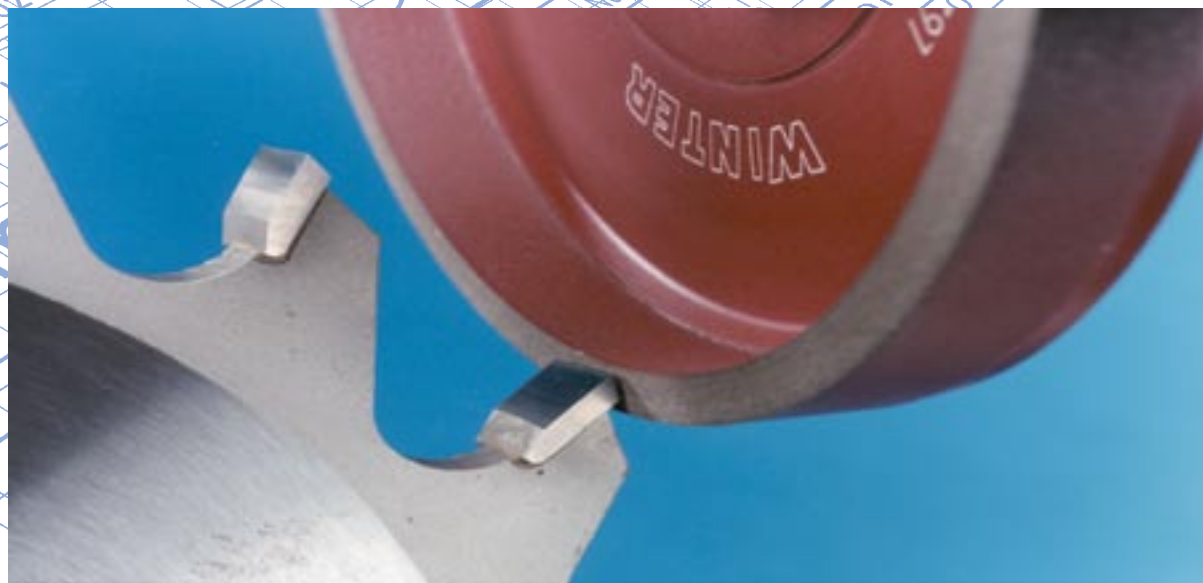
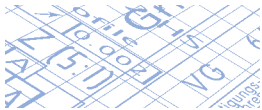


Precision Grinding Solutions

Precision Grinding Solutions

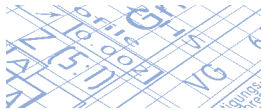




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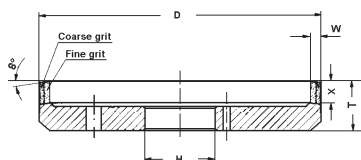




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Grinding wheel shape 222



WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Biberach<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
3K 222	- 125 - 5 - 6 - 2B - 32	D126	K-plus 888RY	C100	66260136530	T = 18
		D46		C75		
		D126	K-plus 888RY	C125	66260112775	T = 18
		D46		C75		
52K 222	- 125 - 5 - 6 - 2B - 32	D126	K-plus 434	C100	66260136498	T = 18
		D46		C75		1)
		D126	K-plus 1313 RY	C75	66260352075	T = 18
		D20B	K-plus 1313 RY-42	C75		

For grinding tooth tops with normal pitch > 0.2 mm.

Machine type: CC, CB, CE, CHC, CHP, CEP, CEN, CHM, CHT, CHTS, CHHT, CHD, CX

1) WINTER recommendation

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Biberach<

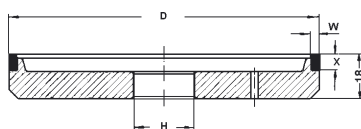
Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
5K 222	- 125 - 5 - 10 - 2B - 32	D126	K-plus 434	C100	60157642597	T = 22
		D46		C75		
		D126	K-plus 1066	C125	66260134470	T = 22
		D46		C100		1) 2)
		D91	K-plus 888RY	C75	66260115711	T = 22
		D15C		C50		
D76	D25	K-plus 888RY	C125	C100	60157643637	T = 22

For grinding tooth tops with normal pitch > 0.2 mm.

Machine type: CC, CHC, CHP, CEP, CEN, CHT, CHTS, CHHT, CHD, CX

2) Particularly suitable where core is included in grinding.

1) WINTER recommendation



WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Biberach<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 222	- 125 - 3 - 6,5 - 32	D54	K-plus 888RY	C100A	60157642641	

For grinding tooth tops with normal pitch. Allowance < 0.3 mm.

Machine type: CC, CB, CE, CHC, CHP, CEP, CEN, CHM, CHT, CHTS, CHHT, CHD, CX

WINTER

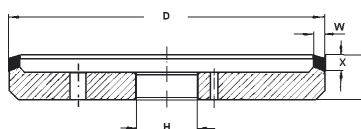
Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Biberach<

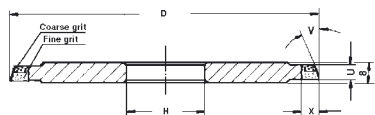
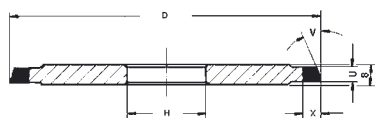
Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
27K 222	- 125 - 5 - 6 - 32	D91	K-plus 4821	C100A	60157643295	Winkel 8°

For grinding tooth tops and faces of sawblades for metal working.

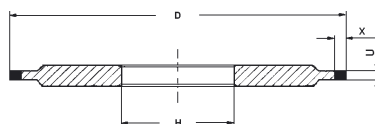
Machine type: CC, CHC, CHP, CEP, CEN, CHT, CHTS, CHHT, CHD



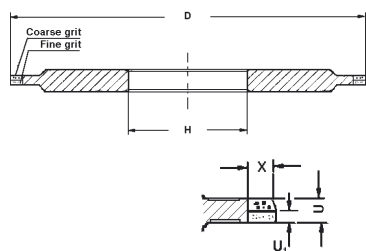
Grinding wheel shape 14B1



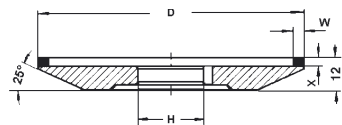
Grinding wheel shape 14A1



Grinding wheel shape 14M1



Grinding wheel shape 4A2



WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >AKEMAT<

Shape	- D - U - X - V° - H	Grit size	Bond	Concentration	ORDER No.	Remarks
2K 14B1	- 127 - 5 - 7 - 15 - 32	D54	K-plus 921	C125 A	66260114938	*)

For grinding tooth tops with normal pitch. Allowance > 0,2 mm.
Machine type: akemat U

*) Also suitable for application with oil as cutting fluid

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >AKEMAT<

Shape	- D - U - X - V° - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 14B1	- 127 - 5 - 7 - 5 - 2B - 32	D107 D46	K-plus 4821	C100 C75H	66260134416	1)
1K 14B1	- 127 - 5 - 7 - 15 - 2B - 32	D107 D46	K-plus 4821	C100 C75A	60157643587	2)
		D126 D54	K-plus 1313RY	C125 C100A	66260117412	3)

For grinding tooth tops with normal pitch. Allowance > 0.2 mm.
Machine type: akemat U

1) WINTER recommendation

2) End of line, replaced by 66260134416

3) Also suitable for carbide/steel combination.

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >AKEMAT<

Shape	- D - U - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
4K 14A1	- 150 - 5 - 8 - 32	D64	K-plus 1421R	C100A	66260350218	*) 1)

For grinding tooth tops.
Machine type: akemat

*) Also suitable for application with oil as cutting fluid.

1) Delivery within four weeks.

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >AKEMAT<

Shape	- D - U - X - U ₁ - V° - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 14M1-150	- 5 - 8 - 2,5 - 5° - 2B - 32	D107 D46	K-plus 1421R	C100 C75A	66260346277	1) 2)
1K 14M1-150	- 5 - 8 - 2,5 - 8° - 2B - 32	D107 D46	K-plus 921	C100 C75A	66260130887	1)
1K 14M1-200	- 5 - 8 - 2,0 - 8° - 2B - 32	D91 D20B	K-plus 1066	C100 C75A	66260379464	
1K 14M1-200	- 5 - 8 - 2,5 - 8° - 2B - 32	D107 D46	K-plus 921	C100 C75A	66260375347	1)

For grinding tooth tops.
Machine type: akemat U6 and U10

1) Also suitable for application with oil as cutting fluid.

2) End of line, replaced by 66260130887

WINTER

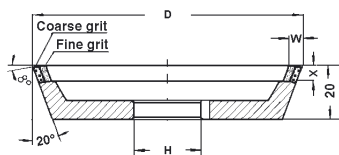
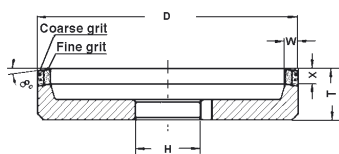
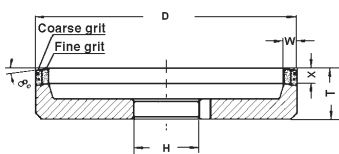
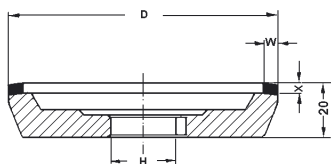
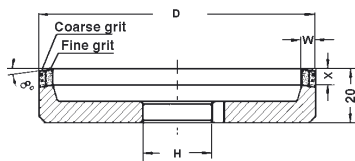
Reciprocating grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >VOLLMER-Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 4A2	- 100 - 4 - 3 - 25	D46	K-plus 888RY	C75	66260137095	

For grinding tooth tops and faces with normal pitch.
This wheel type should be used whenever pitch allows. Machine type: Finimat

Grinding wheel shape **222**



WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >WIDMA<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
6K 222	- 100 - 5 - 6 - 2B - 25	D126 D46	K-plus 888RY	C100 C75	66260135827	

For grinding tooth tops.

Machine type: HKS 700 / HKS 700/H-I / HKS 700/H-III / HKS 750 / HKS 800

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
9K 222	- 125 - 5 - 6 - 2B - 25	D126 D46	K-plus 888RY	C100 C75	60157643868	

For grinding tooth tops.

Machine type: HKS 700 / HKS 700/H-I / HKS 700/H-III / HKS 750 / HKS 800 / grinding centre / Optimat / Supermat

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >WIDMA<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
5K 222	- 100 - 5 - 4 - 25	D76	K-plus 888RY	C75	60157643743	

For grinding tooth tops in sharpening service.

Machine type: UNIMAT

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
6K 222	- 100 - 5 - 6 - 2B - 25	D126 D46	K-plus 888RY	C100 C75	66260135827	T = 20

For grinding tooth with normal pitch. Allowance > 0.2 mm.

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 222	- 100 - 5 - 10 - 2B - 25	D126 D46	K-plus 434	C100 C75	66260135783	T = 24
2K 222	- 100 - 5 - 10 - 2B - 25	D126 D46	K-plus 888RY	C125 C100	60157643263	T = 24 ³⁾

For grinding tooth tops with normal pitch > 0.2 mm. In continuous operation wheels with greater layer depth are more economical - especially in production grinding.

³⁾ WINTER recommendation

WINTER

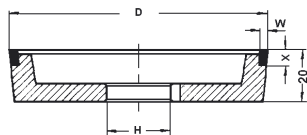
Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Dornhan<

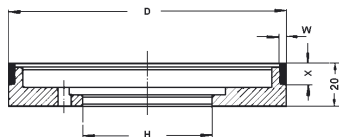
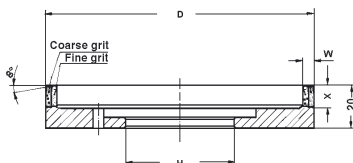
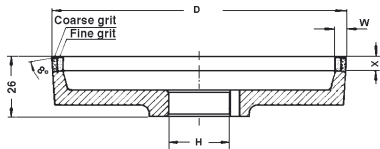
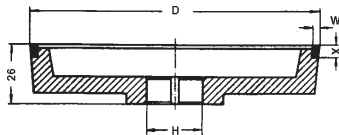
Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
4K 222	- 100 - 5 - 6 - 2B - 25	D126 D46	K-plus 888RY	C100 C75	60157642914	

For grinding tooth tops with narrow pitch. Allowance > 0.2 mm.

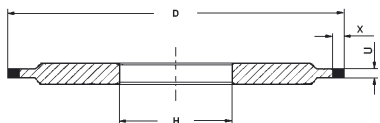
Grinding wheel shape 11V9



Grinding wheel shape 222



Grinding wheel shape 14A1



WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 11V9	- 100 - 3 - 6 - 25	D54	K-plus 888RY	C100A	60157643081	

For grinding tooth tops with narrow pitch and / or allowance > 0,2 mm.

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 222	- 125 - 3 - 5 - 25	D54	K-plus 888RY	C100A	60157642941	

For grinding tooth tops with close pitch and/or allowance ≤ 0.2 mm

Machine type: Uniläpp

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Dornhan<

Shape	- D - W - X - - H	Grit size	Bond	Concentration	ORDER No.	Remarks
4K 222	- 125 - 5 - 6 - 2B - 25	D126 D46	K-plus 888RY	C100 C75	60157643430	

For grinding tooth tops. Allowance > 0.2 mm.

Machine type: Uniläpp

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Dornhan<

Shape	- D - W - X - - H	Grit size	Bond	Concentration	ORDER No.	Remarks
31K 222	- 125 - 5 - 6 - 2B - 50,8	D126 D46	K-plus 888RY	C100 C75	66260135844	
8K 222	- 125 - 5 - 10 - 2B - 50,8	D126 D46	K-plus 888RY	C100 C75	66260135843 ¹⁾	
		D126 D20B	K-plus 1313RY K-plus 1313RY-42	C100 C75	60157642975	

For grinding tooth tops.

Machine type: Finimat Gamma, Beta, Alpha

¹⁾ WINTER recommendation

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
7K 222	- 125 - 3 - 6 - 50,8	D64	K-plus 888RY	C100A	60157643056	

For grinding tooth tops.

Machine type: Finimat Gamma, Beta, Alpha

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >WALTER AG<

Shape	- D - U - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
4K 14A1	- 150 - 5 - 8 - 32	D64	K-plus 1421R	C100A	66260350218 ¹⁾ ²⁾	

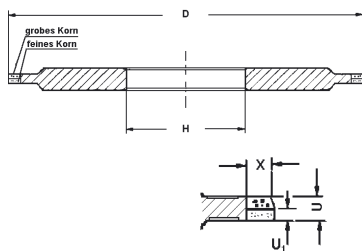
For grinding tooth tops.

Machine type: akemat

²⁾ Also suitable for application with oil as cutting fluid.

¹⁾ Delivery within four weeks.

Grinding wheel shape **14M1**



WINTER

Creep feed grinding

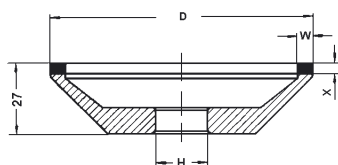
Diamond grinding wheels for automatic circular sawblade grinding machines >WALTER AG<

Shape	D	U	X	U ₁	V	H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 14M1-150-	5	- 8	- 2,5	- 5°	- 2B	- 32	D107	K-plus 1421R	C100	66260346277	1) 2)
							D46		C75A		
1K 14M1-150-	5	- 8	- 2,5	- 8°	- 2B	- 32	D107	K-plus 921	C100	66260130887	1)
							D46		C75A		
1K 14M1-175-	5	- 8	- 2,5	- 8°	- 2B	- 32	D107	K-plus 921	C100	66260133092	1)
							D46		C75A		
1K 14M1-200-	5	- 8	- 2,0	- 8°	- 2B	- 32	D91	K-plus 1066	C100	66260379464	
							D20B		C75A		
1K 14M1-200-	5	- 8	- 2,5	- 8°	- 2B	- 32	D107	K-plus 921	C100	66260375347	1)
							D46		C75A		

For grinding tooth tops.
Machine type: akemat U6 and U10

1) Also suitable for application with oil as cutting fluid.
2) End of line, replaced by 66260130887

Grinding wheel shape **12A2**



WINTER

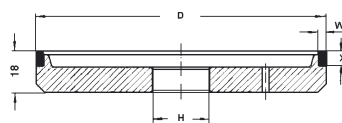
Diamond grinding wheels for universal tool and cutter grinding machines

Shape	D	W	X	S°	H	Grit size	Bond	Concentration	ORDER No.	Remarks
K 12A2	- 100	- 6	- 4	- 45°	- 20	D64	K-plus 888 R	C50	60157642582	Trockenschliff
						D126	K-plus 888 R	C75	60157642588	Trockenschliff
						D126	K-plus 888RY	C75	60157644168	Nassschliff 1)

For grinding flanks of milling cutters and sawblades.

1) Delivery within four weeks.

Grinding wheel shape **222**



WINTER

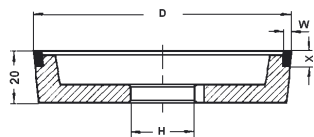
>Creep feed grinding< For HSS tools only

CBN grinding wheels for automatic circular sawblade grinding machines >VOLLMER Biberach<

Shape	D	W	X	H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 222	- 125	- 3	- 6,5	- 32	B107	KSS RY	V240A	60157643394	

For grinding tooth tops of HSS sawblades.
Machine type: CHT, CHTS, CHIHT, CHD

Grinding wheel shape **11V9**



WINTER

>Creep feed grinding< For HSS tools only

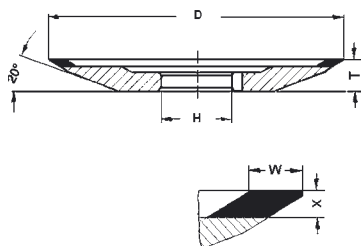
CBN grinding wheels for automatic circular sawblade grinding machines >VOLLMER Dornhan<

Shape	D	W	X	H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 11V9	- 100	- 3	- 6	- 25	B107	KSS RY	V120A	60157643533	1)

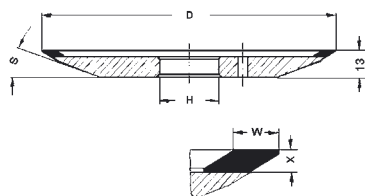
For grinding tooth tops and corner chamfers of roughing teeth on HSS sawblades.
Machine type: Finimat

1) Delivery within four weeks.

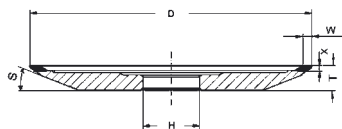
Grinding wheel shape **12V2**



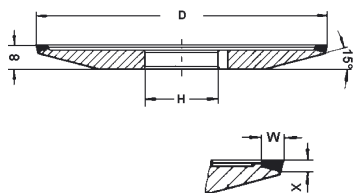
Grinding wheel shape **12V2 / 12V9**



Grinding wheel shape **12V2**



Grinding wheel shape **222**



WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >WIDMA<

Form	- D - W - X - H	Körnungsgröße	Bindung	Konzentration	BESTELL-NUMMER	Be-merkung
2K 12V2	- 100 - 4 - 2 - 25	D46 D76	K-plus 921 K-plus 4821	C125A C125A	66260128232 66260333648	T = 10 *) T = 10

For grinding tooth faces.

Machine type: BS 700 / HKS 700 / HKS 700/H-I / HKS 800 / UNIMAT

*) Also suitable for application with oil as cutting fluid.

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >WIDMA<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
5K 12V2	- 150 - 4 - 2 - 25	D76	K-plus 888RY	C125A	60157642656	T = 13

For grinding tooth faces.

Machine type: BS 700 / HKS 700 / HKS 700/H-I / HKS 800 / UNIMAT

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Biberach<

Shape	- D - W - X - S° - H	Grit size	Bond	Concentration	ORDER No.	Remarks
2K 12V2	- 200 - 4 - 2 - 20 - 32	D25 D46 D76	K-plus 921 K-plus 921 K-plus 888RY	C100A C125A C125A	66260130483 66260117017 66260115113	**) *) *) *)
1K 12V2	- 200 - 2,5 - 5,5 - 25 - 32	-	TIGER II	-	66260382131	*) *)
	- 200 - 2,9 - 5,5 - 20 - 32	-	TIGER II	-	60157680758	*) *) *)
1K 12V9	- 200 - 2,3 - 4 - - 32	-	TIGER	-	66260383180	*) *)

For grinding tooth faces. *) Also suitable for application with oil as cutting fluid. **) Finish grinding

Machine type: CHD *) WINTER recommendation *) For very narrow chip space *) Delivery within four weeks.

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Biberach<

Shape	- D - W - X - S° - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 12V2	- 200 - 2 - 2 - 20 - 32	D46	K-plus 921	C125A	66260133948	T=13
2K 12V2	- 200 - 4 - 2 - 20 - 32	D25	K-plus 921	C100A	66260130483	T=13 *)
2K 12V2	- 200 - 4 - 2 - 20 - 32	D46	K-plus 921	C125A	66260117017	T=13

For grinding tooth faces; all types are also suitable for application with oil as cutting fluid.

Machine type: Vollmer CHD

*) Superfinishing

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >WIDMA<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 222	- 100 - 2 - 1,6 - 25	D76	K-plus 888RY	C125A	60157643361	

For grinding tooth faces.

Machine type: BS 700 / HKS 700 / HKS 700 H-I / HKS 800 / UNIMAT

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >WIDMA<

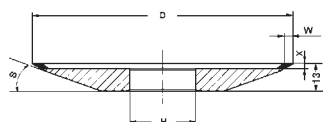
Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
4K 222	- 125 - 3 - 1,8 - 25	D76	K-plus 888RY	C125A	60157643303	*)

For grinding tooth faces.

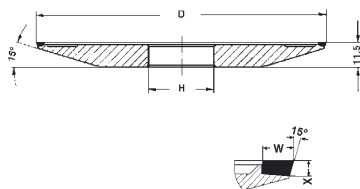
Machine type: HKS 700/H-III / HKS 750 / grinding centre/ Optimat

*) Delivery within four weeks.

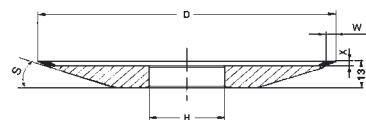
Grinding wheel shape **12V2 / 12V9**



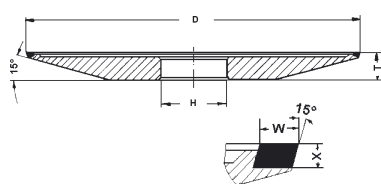
Grinding wheel shape **222**



Grinding wheel shape **12V2 / 12V9**



Grinding wheel shape **222**



WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >VOLLMER Biberach<

Shape	- D - W - X - S° - H	Grit size	Bond	Concentration	ORDER No.	Remarks
5K 12V2	- 125 - 4 - 2 - 20 - 32	D46	K-plus 4821	C125A	66260134429	*)
		D46	K-plus 921	C125A	66260115804	*)
		D76	K-plus 888RY	C125A	66260135735	**)
		D76	K-plus 4821	C125A	66260134487	**) 3)
1K 12V2	- 125 - 2,5 - 5,5 - 25 - 32	-	TIGER II	-	66260375783	*) 3)
1K12V9	- 125 - 2.3 - 4 - - - 32	-	TIGER	-	66260383182	3) 3)

For grinding tooth faces.

Machine type: CHC, CHCB, CHP, CE, CEP, CEN, CHM, CB, CC, CHHT, CHT, CHTS, CNHB, CX

1) Also suitable for application with oil as cutting fluid

*) End of line, replaced by 66260383182

**) End of line, replaced by 66260134487 or 66260383182

3) WINTER recommendation

3) For very narrow chip space

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >VOLLMER Biberach<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 222	- 125 - 2,5 - 1,2 - 32	D54	K-plus 888RY	C75A	60157642666	1) *)
		D76	K-plus 888RY	C125A	66260135745	1) *)
1K 222	- 125 - 3 - 3,8 - 32	D54	K-plus 888RY	C75A	60157642674	3)

For grinding tooth faces 1) with very close pitch, 2) with wide pitch.

Machine type: CHC, CHCB, CHP, CE, CEP, CEN, CHM, CB, CC, CHHT, CHT, CHTS, CNHB

*) End of line

Replaced by 66260383182

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >akemat<

Shape	- D - W - X - S° - H	Grit size	Bond	Concentration	ORDER No.	Remarks
6K 12V2	- 150 - 4 - 2 - 15 - 32	D46	K-plus 888RY	C125A	66260113968	1)
		D46	K-plus 921	C125A	66260127225	*)
		D64	K-plus 921	C125A	66260118587	*)
1K 12V2	- 155 - 2,5 - 5,5 - 25 - 32	-	TIGER II	-	69014168642	3)
1K 12V2	- 200 - 2,5 - 5,5 - 25 - 32	-	TIGER II	-	66260382131	3)
1K 12V2	- 200 - 2,9 - 5,5 - 20 - 32	-	TIGER II	-	60157680758	3) 3)
1K 12V9	- 150 - 2.3 - 4 - - - 32	-	TIGER	-	66260385221	1) 3)
1K 12V9	- 155 - 2.3 - 4 - - - 32	-	TIGER	-	66260378555	3) 3)
1K 12V9	- 155 - 2.3 - 4 - - - 32	-	TIGER F	-	66260378280	3) 3)
1K 12V9	- 155 - 2.3 - 4 - - - 32	-	TIGER G	-	66260354959	3)
1K 12V9	- 200 - 2.3 - 4 - - - 32	-	TIGER	-	66260383180	3)

For grinding tooth faces of sawblades. *) Also suitable for application with oil as cutting fluid

Machine type: akemat B 1) End of line, replaced by 66260378555 3) For very narrow chip space

F = fine

G = rough

3) Delivery within four weeks.

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >akemat<

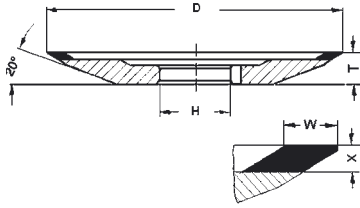
Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 222	- 150 - 3 - 1,5 - 32	D64	K-plus 920	C100A	66260135724	T = 11,5 1)
5K 222	- 150 - 3 - 2 - 32	D91	K-plus 888 TY	C150A	60157643360	T = 12 1)

For grinding tooth faces of sawblades with very close pitch.

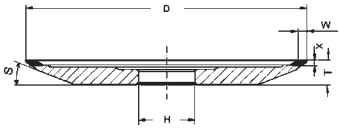
Machine type: akemat B

1) End of line, replaced by 66260385221

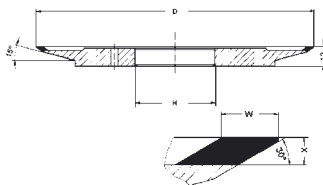
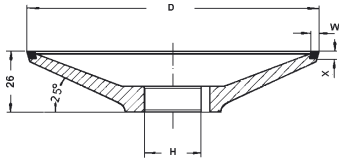
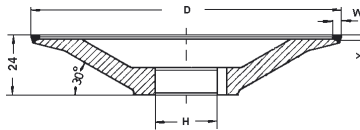
Grinding wheel shape **12V2**



Grinding wheel shape **12V9 / 12V2 / 222**



Grinding wheel shape **222**



WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >VOLLMER Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
2K 12V2	- 125 - 4 - 2 - 25	D46 D76	K-plus 921 K-plus 4821	C125A C125A	66260127431 66260112238	T=11 *) T=11

For grinding tooth faces.

Machine type: HKS 700/H-I / HKS 750 / grinding centre / Optimat

*) Also suitable for application with oil as cutting fluid.

WINTER

Creep feed grinding

CBN grinding wheels for automatic circular sawblade grinding machines >akemat<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 12V9	- 150 - 2,3 - 4 - 32	-	TIGER	-	66260385221	1) 2)
1K 12V9	- 200 - 2,3 - 4 - 32	-	TIGER	-	66260383180	1) 2)
6K 12V2	- 150 - 4 - 2 - 32	D46 D64	K-plus 921 K-plus 921	C125A C125A	66260127225 66260118587	T=13 T=13
1K 12V2	- 200 - 2 - 2 - 32	D46	K-plus 921	C125A	66260133948	T=13, S=20° 2)
2K 12V2	- 200 - 4 - 2 - 32	D25	K-plus 921	C100A	66260130483	T=13 2)
2K 12V2	- 200 - 4 - 2 - 32	D46	K-plus 921	C125A	66260117017	T=13

For grinding tooth faces; all types are also suitable for application with oil as cutting fluid.

Machine type: akemat B, U6, U10

2) Superfinishing

1) WINTER recommendation

2) For very narrow chip spaces

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
2K 222	- 125 - 3 - 1,8 - 25	D54	K-plus 888RY	C75A	60157642853	1)

For grinding tooth face with narrow pitch.

Machine type: Uniläpp

1) Delivery within four weeks.

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 222	- 125 - 3 - 3,3 - 25	D54	K-plus 888RY	C75A	60157642734	

For grinding tooth face with normal pitch.

This wheel type should be used whenever pitch allows.

Machine type: Uniläpp

WINTER

Creep feed grinding

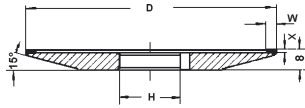
Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 222	- 175 - 4 - 2 - 50,8	D76	K-plus 888RY	C125A	66260136435	

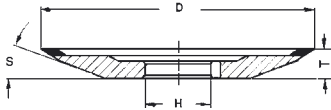
For grinding tooth face.

Machine type: Finimat Gamma, Beta, Alpha

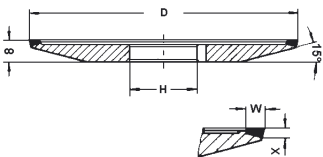
Grinding wheel shape **4A2**



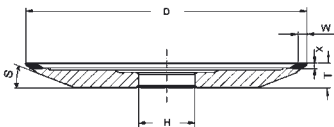
Grinding wheel shape **12V2 / 12V9**



Grinding wheel shape **222**



Grinding wheel shape **12V9 / 12V2**



WINTER

Reciprocating grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 4A2	- 100 - 4 - 1 - 25	D64	K-plus 888RY	C100	66260137093	

For grinding tooth tops and faces with narrow pitch.

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
2K 12V2	- 100 - 4 - 2 - 25	D46	K-plus 921	C125A	66260128232	T=10,*)**) T=10
2K 12V2	- 125 - 4 - 2 - 25	D46	K-plus 921	C125A	66260127431	T=11,*)**) T=11
3K 12V9	- 125 - 2,3 - 4 - 25	D76	K-plus 4821	C125A	66260112238	T=11
		-	TIGER	-	66260135761	1) 2)

For grinding tooth faces. *) Also suitable for application with oil as cutting fluid. **) S = 30°
Machine type: Finimat

1) WINTER recommendation

2) For very narrow chip spaces

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
2K 222	- 100 - 3 - 1,8 - 25	D54	K-plus 888RY	C75A	60157642713	
		D64	K-plus 888RY	C75A	66260135818	

For grinding tooth faces with narrow pitch.

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 222	- 100 - 3 - 3,3 - 25	D54	K-plus 888RY	C75A	60157642681	
		D76	K-plus 888RY	C75A	66260137081	

For grinding tooth faces.
Machine type: Finimat

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >WALTER AG<

Shape	- D - W - X - S° - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 12V9	- 150 - 2,3 - 4 - - 32	-	TIGER	-	66260385221	1) 2)
1K 12V9	- 160 - 2,3 - 4 - - 32	-	TIGER	-	66260380257	1) 2)
1K 12V9	- 200 - 2,3 - 4 - - 32	-	TIGER	-	66260383180	1) 2)
6K 12V2	- 150 - 4 - 2 - - 32	D46	K-plus 921	C125A	66260127225	T=13
		D64	K-plus 921	C125A	66260118587	T=13
1K 222	- 160 - 3 - 2 - - 32	D46	K-plus 921	C125A	66260133171	T=12 3) *)
		D64	K-plus 921	C125A	66260128437	T=12 3)
1K 12V2	- 160 - 2,5 - 5,5 - 25 - 32	-	TIGER ii	-	60157672258	1) 2) *)
1K 12V2	- 160 - 4 - 2 - - 32	D46	K-plus 921	C125A	66260131774	T=13 *)
		D64	K-plus 921	C125A	66260131075	T=13 *)
1K 12V2	- 200 - 2 - 2 - 20 - 32	D46	K-plus 921	C125A	66260133948	T=13 *)
2K 12V2	- 200 - 4 - 2 - - 32	D25	K-plus 921	C100A	66260130483	T=13 3)
2K 12V2	- 200 - 4 - 2 - - 32	D46	K-plus 921	C125A	66260117017	T=13 3)

For grinding tooth faces; all types are also suitable for application with oil as cutting fluid.

Machine type: Woodtronic NC 2 / NC 3, 3) / NC 4, 4) / NC 5

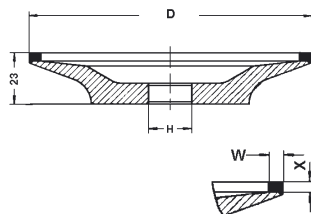
3) Superfinishing

1) WINTER recommendation

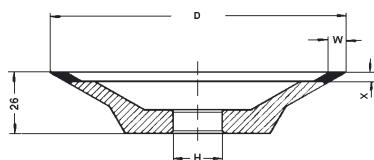
2) For very narrow chip spaces

*) Delivery within four weeks.

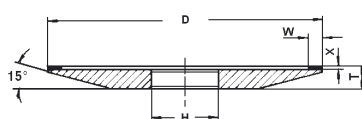
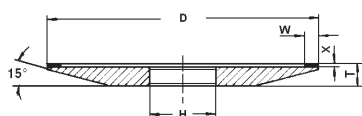
Grinding wheel shape **222**



Grinding wheel shape **12V2**



Grinding wheel shape **4A2**



WINTER

Diamond grinding wheels for universal tool and cutter grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
20K 222	- 125 - 5 - 4 - 20	D46	K-plus 888 J	C50	66260349438	
		D46	K-plus 1410	C75	66260111759	
		D64	K-plus 888 R	C50	66260117305	
		D64	K-plus 1410	C75	66260335191	
		D91	K-plus 888 R	C50	66260117906	
		D126	K-plus 888 R	C50	66260118608	
		D151	K-plus 888 R	C75	66260130346	
16K 222	- 125 - 5 - 4 - 20	D181	K-plus 1410	C100	66260115578	
		D151	K-plus 888 R	C75	66260100321	*)
		D181	K-plus 888 R	C100	60157643406	*)

For grinding faces and tops of milling cutters and tooth faces of sawblades with wide spacing.

*) Reinforced core

WINTER

Diamond grinding wheels for universal tool and cutter grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 12V2	- 125 - 5 - 3 - 20	D46	K-plus 888 N	C50	60157643110	*) Auslaufftyp
		D64	K-plus 888 N	C50	60157642736	*)
1K 12V2	- 125 - 5 - 4 - 20	D46	K-plus 888 N	C50	66260129020	

For grinding faces of sawblades with normal tooth spacing and little tooth height; off-hand grinding.

*) Delivery within four weeks.

*) Replaced by 66260129020

WINTER

Diamond grinding wheels for universal tool and cutter grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 12V2	- 125 - 8 - 4 - 20	D46	K-plus 888 N	C50	60157642744	
		D64	K-plus 888 N	C75	66260136367	

For grinding faces of sawblades with normal tooth spacing; off-hand grinding. If tooth gaps allow, the wheel with 8 mm rim width should always be used, as it permits greater control.

WINTER

Diamond grinding wheels for universal tool and cutter grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
K 4A2	- 100 - 6 - 2 - 20	D64	K-plus 888 N	C50	66260137071	T = 8 *)
		D91	K-plus 888 N	C50	66260136265	T = 8 *)
6K 4A2	- 125 - 5 - 2 - 20	D46	K-plus 888 J	C50	60157643448	T = 10
		D64	K-plus 888 R	C50	60157643256	T = 10
K 4A2	- 125 - 5 - 2 - 20	D91	K-plus 888 R	C50	66260133740	T = 9
1K 4A2	- 125 - 6 - 2 - 20	D46	K-plus 1410	C75	66260115833	T = 10
		D64	K-plus 1410	C100	66260128030	T = 10

For grinding faces of milling cutters and sawblades.

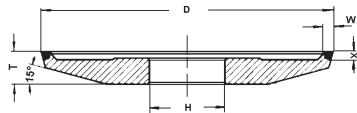
*) See also Superstandard programme

Diamond grinding wheels for universal tool and cutter grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
K 4A2	- 150 - 5 - 4 - 20	D64	K-plus 888 N	C50	60157643184	T = 13
K 4A2	- 175 - 5 - 4 - 20	D64	K-plus 888 N	C50	60157643327	T = 13

For grinding faces of milling cutters and sawblades with deep, narrow chip spaces (e.g. BG test tools).

Grinding wheel shape **222**



WINTER

>Creep feed grinding< For HSS tools only

CBN grinding wheels for automatic circular sawblade grinding machines >VOLLMER Biberach<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 222	- 125 - 3 - 1,8 - 32	B107	KSS RY	V180A	60157643500	T = 12 ¹⁾

For grinding tooth faces of medium pitch HSS sawblades.
Machine type: CHT / CHTS / CHHT

¹⁾ Delivery within four weeks.

WINTER

>Creep feed grinding< For HSS tools only

CBN grinding wheels for automatic circular sawblade grinding machines >VOLLMER Biberach<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 222	- 125 - 3 - 3,8 - 32	B107	KSS RY	V180A	60157643417	T = 14

For grinding tooth faces of wide pitch HSS sawblades.
Machine type: CHT / CHTS / CHHT

WINTER

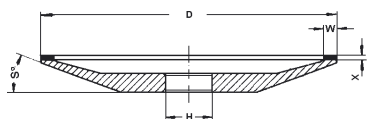
For HSS tools only

CBN grinding wheels for universal tool and cutter grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
20K 222	- 125 - 5 - 4 - 20	B64 B107 B126 B151	KSS 007 N-63 KSS 10 J KSS 10 J KSS 007 N-63	V120 V120 V120 V120	66260115588 66260133018 66260350216 66260135854	

For grinding tooth faces and tooth tops of milling cutters and tooth faces of wide pitch sawblades.

Grinding wheel shape **12A2**



WINTER

For HSS tools only

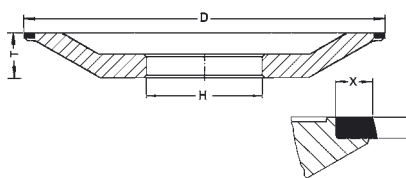
CBN grinding wheels for universal tool and cutter grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
K 12A2	- 100 - 5 - 2 - 20 - 20	B126	KSS 10 J	V120	66260136215	T = 12 ^{*)}
K 12A2	- 125 - 5 - 2 - 20 - 20	B126	KSS 10 J	V120	66260136538	T = 16

For grinding tooth faces and tops of milling cutters and tooth faces of wide pitch sawblades.

^{*)} See also Superstandard programme

Grinding wheel shape **700** (not FEPAStandard)



WINTER

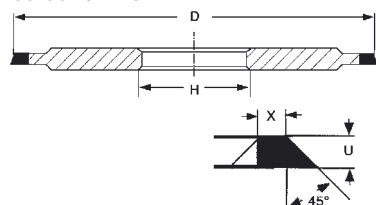
For HSS tools -Metal bond-

Shape	- D - U - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1BZ700	- 200 - 1.5 - 5 - 32	B126	MSS560	V240	66260111706	¹⁾

Application depending on software of machine manufacturer:
For chamfering HSS sawblades on Lorch AK.

¹⁾ Delivery within four weeks.

Grinding wheel shape according to FEPA **1K14B1**



WINTER

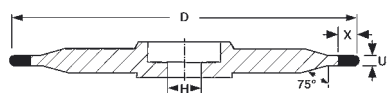
For HSS tools

Shape	- D - U - X - V - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K14B1	- 200 - 1.5 - 5 - 45 - 32	B126	KSS RY	V240	66260113015	¹⁾

Application depending on software of machine manufacturer:
For chamfering HSS sawblades on Schmidt.

¹⁾ Delivery within four weeks.

Grinding wheel shape 700 (not FEPA standard)



WINTER

profile S for HSS tools

Shape	-	D	-	U	-	X	-	R	-	H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K700	-	150	-	1.3	-	8	-	0.65*	-	20	-	profile S	-	66260349334	*)
3K700	-	150	-	2	-	8	-	1*	-	20	-	profile S	-	66260354690	*)
1K700	-	150	-	2.5	-	8	-	1.25*	-	20	-	profile S	-	66260354889	*)
3K700	-	150	-	3	-	8	-	1.5*	-	20	-	profile S	-	66260351109	*)

Application depending on software of machine manufacturer:
For CNC grinding tooth shape of HSS sawblades on Schmidt ECE.

*) Other radii possible
*) Delivery within four weeks.

WINTER

profile S 50 for HSS tools

The specification profile S 50 was developed particularly for the use with emulsion and works very well with lower cutting velocities (50 m/s).

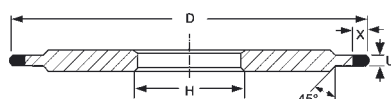
Shape	-	D	-	U	-	X	-	R	-	H	Grit size	Bond	Concentration	ORDER No.	Remarks
2K700	-	150	-	1.3	-	8	-	0.65*	-	20	-	profile S 50	-	60157685427	
6K700	-	150	-	2	-	8	-	1*	-	20	-	profile S 50	-	60157685429	
2K700	-	150	-	2.5	-	8	-	1.25*	-	20	-	profile S 50	-	60157685430	
3K700	-	150	-	3	-	8	-	1.5*	-	20	-	profile S 50	-	60157685431	

Application depending on software of machine manufacturer:
For CNC grinding tooth shape of HSS sawblades on Schmidt ECE.

*) Other radii possible

WINTER

profile S for HSS tools



Shape	-	D	-	U	-	X	-	R	-	H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K700	-	200	-	1.3	-	6.5	-	0.65*	-	32	-	profile S	-	66260395757	
2K700	-	200	-	1.6	-	7	-	0.8*	-	32	-	profile S	-	66260391758	
3K700	-	200	-	2	-	8	-	1	-	32	-	profile S	-	66260395659	
2K700	-	200	-	2.5	-	8	-	1.25*	-	32	-	profile S	-	69014169272	
5K700	-	200	-	3	-	10	-	1.5*	-	32	-	profile S	-	66260399460	
3K700	-	200	-	3.5	-	10	-	1.75*	-	32	-	profile S	-	66260394362	
1K700	-	200	-	4	-	12.5	-	2*	-	32	-	profile S	-	66260399763	
1K700	-	200	-	5	-	15	-	2.5*	-	32	-	profile S	-	66260398364	
2K700	-	200	-	6	-	15	-	3*	-	32	-	profile S	-	66260394265	

Application depending on software of machine manufacturer:
For grinding tooth shape of HSS sawblades Loroch, Rekord and Schmidt.

*) Other radii possible

WINTER

profile S 50 for HSS tools

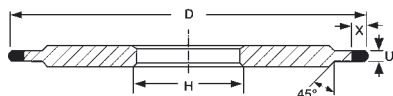
The specification profile S 50 was developed particularly for the use with emulsion and works very well with lower cutting velocities (50 m/s).

Shape	-	D	-	U	-	X	-	R	-	H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K700	-	200	-	1.3	-	6.5	-	0.65*	-	32	-	profile S 50	-	60157688121	*)
2K700	-	200	-	1.6	-	7	-	0.8*	-	32	-	profile S 50	-	60157688122	*)
3K700	-	200	-	2	-	8	-	1*	-	32	-	profile S 50	-	60157688123	*)
2K700	-	200	-	2.5	-	8	-	1.25*	-	32	-	profile S 50	-	60157688124	*)
5K700	-	200	-	3	-	10	-	1.5*	-	32	-	profile S 50	-	60157688125	*)
3K700	-	200	-	3.5	-	10	-	1.75*	-	32	-	profile S 50	-	60157688126	*)
1K700	-	200	-	4	-	12.5	-	2*	-	32	-	profile S 50	-	60157688128	*)
1K700	-	200	-	5	-	15	-	2.5*	-	32	-	profile S 50	-	60157688130	*)
2K700	-	200	-	6	-	15	-	3*	-	32	-	profile S 50	-	60157688131	*)

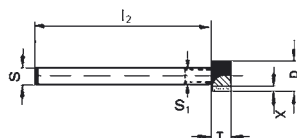
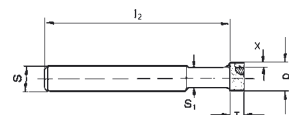
Application depending on software of machine manufacturer:
For grinding tooth shape of HSS sawblades Loroch, Rekord and Schmidt.

*) Other radii possible
*) Delivery within four weeks.

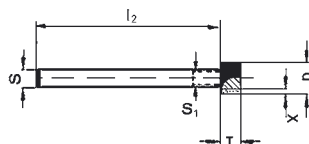
Grinding wheel shape 700 (not FEPASstandard)



Grinding pins 1A1W



Hinweis zur Auswahl des Schleifstift-durchmessers „D“ in Abhängigkeit von der Schnittbreite „B“ der Kreissäge/ des Nutfräasers: $D = 2 \cdot B + 1$ [mm]



Hinweis zur Auswahl des Schleifstift-durchmessers „D“ in Abhängigkeit von der Schnittbreite „B“ der Kreissäge/ des Nutfräasers: $D = 2 \cdot B + 1$ [mm]

WINTER

Diamond grinding wheels for tungsten carbide

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
3K 700	- 200 - 2 - 8 - 32	D91	K-plus 975-42	C100E	60157685432	

Application depending on software of machine manufacturer:
For CNC grinding tooth shape of tungsten carbide sawblades on Schmidt ECE.

WINTER

Creep feed grinding for hollow-tooth sawblades

Diamond grinding pins for all automatic circular sawblade grinding machines

Shape	- D - T - X - S - l ₂	Grit size	Bond	Concentration	ORDER No.	Remarks
3K 1A1W	- 6 - 3 - 1,5 - 6 - 42	D76	K-plus 921	C125	66260111416	S ₁ = 5,1
1K 1A1W	- 6,5 - 3 - 1,75 - 6 - 42	D76	K-plus 921	C125	66260133964	S ₁ = 5,1
8K 1A1W	- 6,5 - 3 - 1,75 - 6 - 33	D76	K-plus 921	C125	66260134445	S ₁ = 4,1
2K 1A1W	- 7 - 3 - 2 - 6 - 42	D76	K-plus 921	C125	66260133966	S ₁ = 5,1
		D91	K-plus 921	C125	60157643351	S ₁ = 5,1
		D91	K-plus 888 TY	C150	60157643957	S ₁ = 5,1

For grinding faces of hollow-tooth sawblades (creep-feed).

WINTER

Diamond grinding pins for universal tool and cutter grinding machines

Shape	- D - T - X - S - l ₂	Grit size	Bond	Concentration	ORDER No.	Remarks
K 1A1W	- 6 - 6 - 1,5 - 6 - 60	D64	K-plus 888RY	C125	66260134006	S ₁ = 3,1
		D126	K-plus 888RY	C100	66260134009	S ₁ = 3,1
K 1A1W	- 7 - 6 - 2 - 6 - 60	D64	K-plus 888RY	C125	60157644032	S ₁ = 3,1
K 1A1W	- 8 - 6 - 2 - 6 - 60	D64	K-plus 888RY	C125	66260134020	S ₁ = 4,1
		D126	K-plus 888RY	C100	66260134023	S ₁ = 4,1
K 1A1W	- 10 - 6 - 2 - 6 - 60	D64	K-plus 888RY	C125	60157643973	
		D126	K-plus 888RY	C100	66260134036	
K 1A1W	- 12 - 6 - 2 - 6 - 60	D64	K-plus 888RY	C125	66260134081	
		D126	K-plus 888RY	C100	66260134045	
K 1A1W	- 16 - 6 - 2 - 6 - 60	D64	K-plus 888RY	C100	60157643934	
		D126	K-plus 888RY	C100	66260134059	
K 1A1W	- 20 - 6 - 2 - 6 - 60	D64	K-plus 888RY	C100	60157644006	*)
		D126	K-plus 888RY	C100	60157644107	

For grinding faces of hollow-tooth sawblades and groove milling cutters.

*) Delivery within four weeks.

WINTER

for HSS

CBN grinding pins for universal tool and cutter grinding machines

Shape	- D - T - X - S - l ₂	Grit size	Bond	Concentration	ORDER No.	Remarks
K 1A1W	- 6 - 6 - 1,5 - 6 - 60	B126	KSS RY	V240	66260133969	S ₁ = 3,1
K 1A1W	- 8 - 6 - 2 - 6 - 60	B126	KSS RY	V240	66260133918	S ₁ = 4,1
K 1A1W	- 10 - 6 - 2 - 6 - 60	B126	KSS RY	V240	66260133971	
K 1A1W	- 12 - 6 - 2 - 6 - 60	B126	KSS RY	V240	60157643978	

For grinding tooth faces of hollow-tooth sawblades and groove milling cutters.



NEW!

TIGER II from WINTER!!!

The new generation for face grinding.

The very high break resistance is a great benefit of this new TIGER-Generation from WINTER.

Low grinding forces, short cycle times and the ability to grind very low tooth gaps are additional advantages.

Use the convenience of the TIGER II diamond grinding wheel for face grinding of carbide tipped saw blades.



From WINTER!!!

The "Tiger grinding wheel".

The diamond wheel for face grinding.

The K-plus wheel for all automated saw grinding machines for grinding tooth face

Requirements:

Grinding carbide sawblades on tooth face, for blades with very narrow tooth gaps.

Sufficient straightness of face, even where tooth gap is very narrow.

Straightness of faces sufficient even where blades are frequently reground (no "vulture beak").

Good resistance to breakage, due to good support of layer [both for plunging into core (1) and in the event of contact with the blade by next tooth (2), see sketch].

Layer support used up by the grinding operation itself.

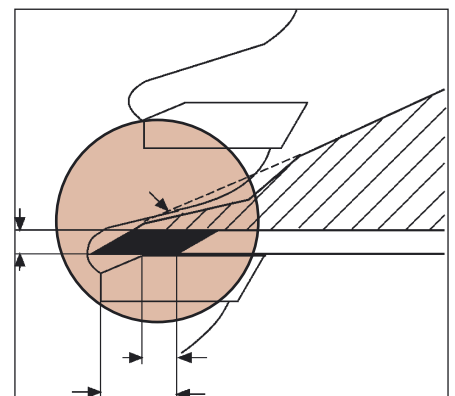
No Al-buildup on carbide tooth, because layer support is metal-free.

Shorter grinding times possible (due to shorter grinding distance; see sketch). Layer support is removed by the grinding operation itself.

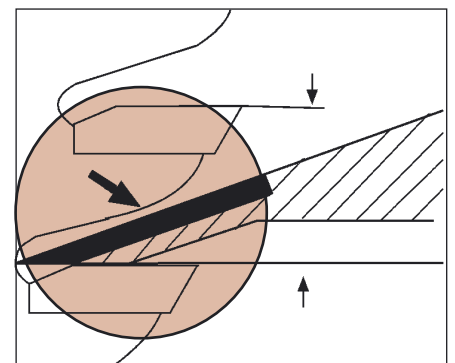
Good life of grinding wheel.

K-plus grinding wheel for all automated grinding machines with self-dressing core, high resistance to fracture.

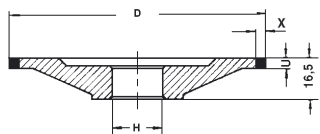
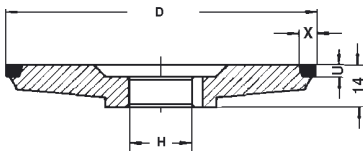
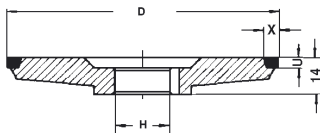
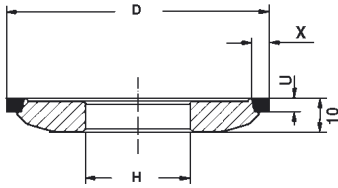
Previous:



NOW:



Grinding wheel shape 700



WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Biberach<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 700	- 80 - 4 - 5 - 32	D91	K-plus 730-42	C50A	66260135826	1) *)

For grinding tooth flanks (cutting width) with narrow pitches. 1) Also suitable for application with oil as cutting fluid.
Machine type: CC, CEF, CHAFT, CHAFTE, CHTF

*) Delivery within four weeks.

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >Vollmer Biberach<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 700	- 100 - 4 - 5 - 32	D54	K-plus 921	C75A	66260131923	2)
		D91	K-plus 730-42	C50A	60157642622	1)
		D107	K-plus 888NY	C75A	66260136539	3)

For grinding tooth flanks (cutting width).

1) Also suitable for application with oil as cutting fluid.

Machine type: CC, CEF, CFL, CHAFT, CHAFTE, CHHF, CHTF, CHF

2) Production grinding

*) WINTER recommendation

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >akemat<

Shape	- D - U - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 700	- 76 - 4 - 4,5 - 20	D91	K-plus 730-42	C50A	60157643342	1)
		D126	K-plus 888NY	C75A	66260136474	2)
1K 700	- 100 - 4 - 4,5 - 20	D91	K-plus 730-42	C50A	66260136591	1)
		D126	K-plus 888NY	C75A	66260136408	3)
2K 700	- 100 - 4 - 6,5 - 20	D126	K-plus 888NY	C75A	66260137143	4)

1) For grinding tooth flanks (cutting width) For multi-tooth blades with weak core.

Also suitable for application with strong core

2) For multi-tooth sawblades with oil as cutting fluid.

3) For sawblades with strong core.

4) For grinding tooth flanks (cutting width).

All types machine type: akemat F

*) WINTER recommendation

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >VOLLMER-Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 700	- 76 - 4 - 4,5 - 20	D126	K-plus 888NY	C75A	66260136474	

For multi-blades with strong core.

Machine type: DUO TS / Uniläpp II-450 TS / MF 600

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >VOLLMER-Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 700	- 76 - 4 - 4,5 - 20	D91	K-plus 730-42	C50A	60157643342	*)

For grinding tooth flanks (cutting width). For multi-tooth blades with weak core.

*) Also suitable for application with oil as cutting fluid.

Machine type: DUO TS / Uniläpp II-450 TS / MF 600

WINTER

Reciprocating grinding

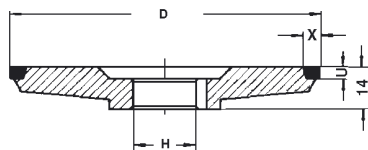
Diamantschleifscheiben für Kreissägen-Schleifautomat >VOLLMER-Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 700	- 100 - 4 - 4 - 20	D126	K-plus 888NY	C75	60157642956	

For grinding tooth flanks (cutting width).

Machine type: DUO S

Grinding wheel shape **700**



WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >VOLLMER-Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 700	- 100 - 4 - 4,5 - 20	D91	K-plus 730-42	C50A	66260136591	

For grinding tooth flanks (cutting width). For multi-tooth blades with weak core.
Machine type: DUO TS / MF 600

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >VOLLMER-Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 700	- 100 - 4 - 4,5 - 20	D126	K-plus 888NY	C75A	66260136408	

For blades with strong core.
Machine type: DUO TS / MF 600

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >VOLLMER-Dornhan and akemat<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
2K 700	- 100 - 4 - 6,5 - 20	D126	K-plus 888NY	C75A	66260137143	

For grinding tooth flanks (cutting width).
Machine type: HKS 400 / FS 600 / FS 1000/H / FS 1001/H / grinding centre

WINTER

Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >VOLLMER-Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 700	- 100 - 4 - 4,5 - 20	D91 D126	K-plus 730-42 K-plus 888NY	C50A C75A	66260136591 66260136408	*)

For grinding tooth flanks (cutting width).
Machine type: HKS 400 / FS 600 / FS 1000/H / FS 1001 / grinding centre

*) Also suitable for application with oil as cutting fluid.

WINTER

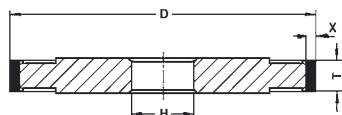
Creep feed grinding

Diamond grinding wheels for automatic circular sawblade grinding machines >VOLLMER-Dornhan<

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
2K 700	- 100 - 4 - 6,5 - 20	D126	K-plus 888NY	C75A	66260137143	

For grinding tooth flanks (cutting width).
Machine type: HKS 400 / FS 600 / FS 1000/H / FS 1001/H / grinding centre

Grinding wheel shape **1A1**



WINTER

Creep feed grinding

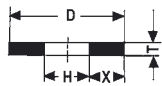
Diamond grinding wheels for all automatic circular sawblade grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
K 1A1	- 125 - 8 - 15 - 20	D64	K-plus 921	C100A	66260131843	*)

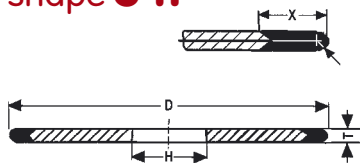
For grinding the saw tooth.
Machine type: for all grinding machines

*) Profile to be ground and bore to be modified acc. to customer's request.

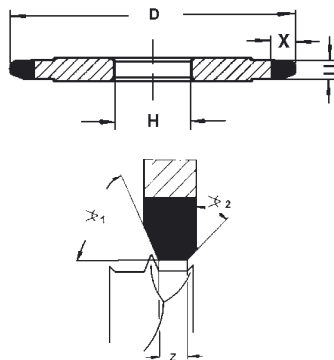
Grinding wheel shape **1A8**



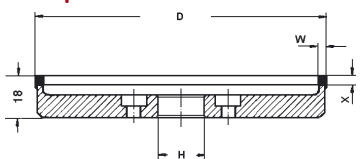
Grinding wheel shape **34P**



Grinding wheel shape **1D1**



Grinding wheel shape **6A2**



WINTER

Diamond grinding wheels for grinding of chip breaking flutes in carbide saws

Shape	- D - T - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1A8	- 30 - 0,3 - 11 - 8	D76	MR875	C125	66260337005	*)
1A8	- 30 - 0,4 - 11 - 8	D91	MR875	C125	66260340908	*)

Minimum order quantity 6 pieces each Type.

*) Delivery within seven weeks.

WINTER

Diamond grinding wheels for grinding of chip breaking flutes in carbide saws

Shape	- D - T - X - E - R - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1BZ 34P	- 125 - 0.5 - 5 - 0.4 - 0.25 - 32	D126	BZ457	C135	66260388921	
1K 34P	- 125 - 0.8 - 5 - 0.6 - 0.4 - 32	D151	K-plus 888RY	C75	66260383651	

WINTER

Diamond grinding wheels for universal tool and cutter grinding machines

Shape	- D - U - X - Z - $\angle 1$ - $\angle 2$ - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 1D1	- 75 - 4,5 - 6 - 0,9 - 67,5 - 45 - 20	D64	K-plus 888 R	C75	60157642996	Z = 0,9
for dowel drills $\varnothing 4$						
1K 1D1	- 75 - 4,5 - 6 - 1,4 - 67,5 - 45 - 20	D64	K-plus 888 R	C75	66260116659	Z = 1,4
for dowel drills $\varnothing 5$						
1K 1D1	- 75 - 4,5 - 6 - 1,9 - 67,5 - 45 - 20	D64	K-plus 888 R	C75	66260136519	Z = 1,9
for dowel drills $\varnothing 6$						
1K 1D1	- 75 - 5 - 6 - 2,8 - 67,5 - 45 - 20	D64	K-plus 888 R	C75	66260136520	Z = 2,8
for dowel drills $\varnothing 8$						
1K 1D1	- 75 - 6 - 6 - 3,7 - 67,5 - 45 - 20	D64	K-plus 888 R	C75	66260136522	Z = 3,7
for dowel drills $\varnothing 10$						

For form grinding of dowel drills (clearance) with simultaneous sharpening of centre point tips and rough cutting edges. Other dimensions can be supplied, but are not available from stock. When ordering, please state drill diameter or Z-dimension.

WINTER

For HSS dowel drills

CBN grinding wheels for universal tool and cutter grinding machines

Shape	- D - U - X - Z - $\angle 1$ - $\angle 2$ - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 1D1	- 75 - 4,5 - 6 - 0,9 - 67,5 - 45 - 20	B107	KSS 10 N	V180	60157642715	Z=0,9 *)
for dowel drills $\varnothing 4$						
1K 1D1	- 75 - 4,5 - 6 - 1,9 - 67,5 - 45 - 20	B107	KSS 10 N	V180	60157643017	Z=1,9 *)
for dowel drills $\varnothing 6$						
1K 1D1	- 75 - 5 - 6 - 2,8 - 67,5 - 45 - 20	B107	KSS 10 N	V180	60157642955	Z=2,8 *)
for dowel drills $\varnothing 8$						

For form grinding of dowel drills (clearance) with simultaneous sharpening of centre point and tips.

*) Delivery within four weeks.

Other dimensions can be supplied, when ordering, please state drill diameter or Z-dimension.

WINTER

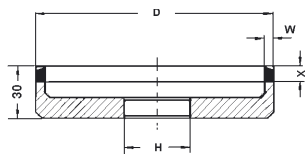
For HSS tools only >Reciprocating grinding<

CBN grinding wheels for planer-knife grinding machines

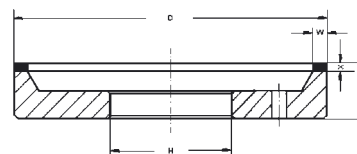
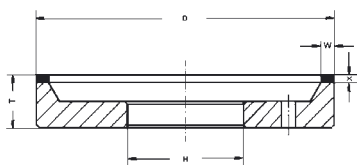
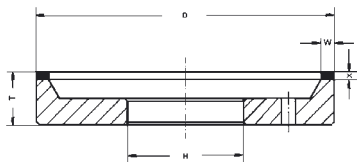
Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
2K 6A2	- 125 - 3 - 4 - 20	B107	KSS RY	V120	66260134792	

For grinding planer-knives in planer head.
Machine type: Weing Rondamat

Grinding wheel shape **222**



Grinding wheel shape **6A2**



WINTER

For HSS tools only >Reciprocating grinding<

CBN grinding wheels for planer-knife grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
3K 222	- 100 - 3 - 6 - 20	B126	KSS RY	V120A	60157643658	

For grinding planer-knives in planer head.
Machine type: Weinig Rondamat

WINTER

For HSS tools only >Reciprocating grinding<

CBN grinding wheels for planer-knife grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
5BZ 6A2	- 200 - 8 - 8 - 50	B126	MSS 587	V120	66260133248	T = 31

For regrinding clearance of HSS planer-knives.
Machine: GÖCKEL

WINTER

For HSS tools only >Reciprocating grinding<

CBN grinding wheels for planer-knife grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
3BZ 6A2	- 200 - 8 - 8 - 75	B126	MSS 587	V120	66260368698	T = 35

For regrinding clearance of HSS planer-knives.
Machine: REFORM (Rabenseifner)

WINTER

>GÖCKEL<

Diamond grinding wheels for planer-knife grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
14K 6A2	- 200 - 8 - 4 - 50	D126	K-plus 1313 RY	C100A	66260134453	

For sharpening (clearance) of carbide-tipped planer-knives. Also suitable for carbide/steel combination.
Machine: GÖCKEL

WINTER

>REFORM<

Diamond grinding wheels for planer-knife grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
26K 6A2	- 200 - 8 - 4 - 75	D126	K-plus 1313 RY	C100A	60157643892	

For sharpening (clearance) of carbide-tipped planer-knives. Also suitable for carbide/steel combination.
Machine: REFORM (Rabenseifner)

WINTER

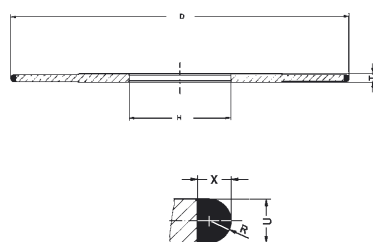
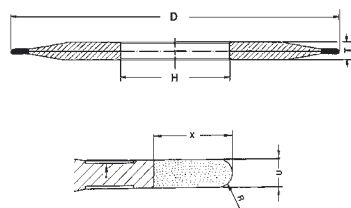
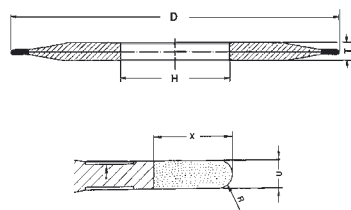
>REFORM<

Diamond grinding wheels for planer-knife grinding machines

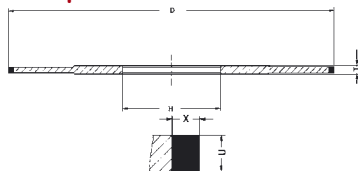
Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
3BZ 6A2	- 200 - 8 - 4 - 75	D64	BZ 587	C25	60157642913	

For sharpening (clearance) of carbide-tipped planer-knives.
Machine: REFORM (Rabenseifner)

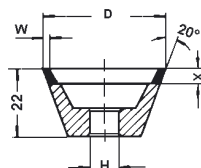
Grinding wheel shape **14F1**



Grinding wheel shape **14A1**



Grinding wheel shape **11V2**



WINTER

For HSS tools only

CBN grinding wheels for profile grinding

Shape	- D - U - X - R - H	Grit size	Bond	Concentration	ORDER No.	Remarks
9K 14F1	- 200 - 2 - 7 - 1 - 20	B126	KSS RY	V180A	66260119631	T = 10 *)
		30 B126	KSS RY	V180A	66260128533	T = 10 *)
		31,75 B126	KSS RY	V180A	66260127835	T = 10 *)
		32 B126	KSS RY	V180A	66260350545	T = 10 *)
		40 B126	KSS RY	V180A	66260127441	T = 10 *)
		50 B126	KSS RY	V180A	66260127044	T = 10 *)
13K 14F1	- 200 - 2 - 7 - 1 - 60	60 B126	KSS RY	V180A	66260131760	T = 10 *)
		B126	KSS RY	V180A	66260119546	T = 5 *)

For profile grinding of milling cutters and inserts of inserted-tooth milling cutters. *) Also for Weinig Rondamat

*) Delivery within four weeks.

WINTER

For HSS tools only

CBN grinding wheels for profile grinding

Shape	- D - U - X - R - H	Grit size	Bond	Concentration	ORDER No.	Remarks
7K 14F1	- 200 - 4 - 7 - 2 - 20	B181	KSS 007N-63	V180A	66260119950	T = 10 *)
		30 B181	KSS 007N-63	V180A	66260394252	T = 10 *)
		31,75 B181	KSS 007N-63	V180A	662601188%4	T = 10 *)
		32 B181	KSS 007N-63	V180A	66260118455	T = 10 *)
		40 B181	KSS 007N-63	V180A	66260122856	T = 10 *)
		50 B181	KSS 007N-63	V180A	66260393657	T = 10 *)
9K 14F1	- 200 - 4 - 7 - 2 - 60	B181	KSS 007N-63	V180A	66260119858	T = 5 *)

For profile grinding of milling cutters and inserts of inserted-tooth milling cutters. *) Also for Weinig Rondamat

*) Delivery within four weeks.

WINTER

For HSS tools only

CBN grinding wheels for grinding machine >Weinig Rondamat<

Shape	- D - U - X - R - H	Grit size	Bond	Concentration	ORDER No.	Remarks
K 14F1	- 200 - 3 - 5 - 1,5 - 60	B151	KSS RY	V180 A	66260130748	T = 10
1K 14F1	- 200 - 4 - 3 - 2 - 60	B151	KSS RY	V240	60157642904	T = 5

For profile grinding of milling cutters and inserts of inserted-tooth milling cutters.

Machine type: Rondamat 930 / 31

WINTER

For HSS tools only

CBN grinding wheels for grinding machine >Weinig Rondamat<

Shape	- D - U - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 14A1	- 200 - 4 - 3 - 60	B91	KSS RY	V240	60157643410	T = 5

For profile grinding of milling cutters and inserts of inserted-tooth milling cutters.

Machine type: Rondamat 930 / 31

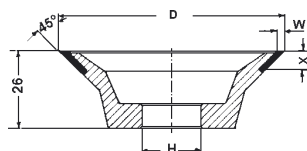
WINTER

Diamond grinding wheels for universal tool and cutter grinding machines

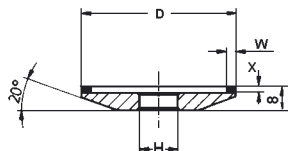
Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
K 11V2	- 40 - 2 - 5 - 10	D64	K-plus 888 R	C75	60157642670	

For grinding single- or multi-edge routers (first face).

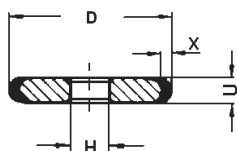
Grinding wheel shape **12V9**



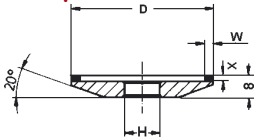
Grinding wheel shape **4A2**



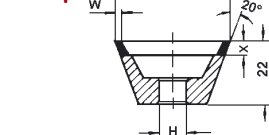
Grinding wheel shape **1FF1**



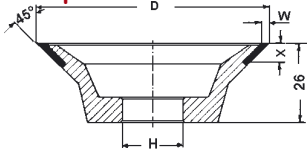
Grinding wheel shape **4A2**



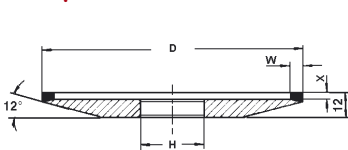
Grinding wheel shape **11V2**



Grinding wheel shape **12V9**



Grinding wheel shape **222**



WINTER

Diamond grinding wheels for universal tool and cutter grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 12V9	- 75 - 2,3 - 7,1 - 20	D46 D64	K-plus 888 R K-plus 888 R	C75 H C75	60157642595 60157642687	

For grinding single- or multi-edge routers (first face).

WINTER

Diamond grinding wheels for universal tool and cutter grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
K 4A2	- 50 - 3 - 2 - 10	D64	K-plus 888 N	C50	60157642922	

For grinding faces of small routers with chip thickness restriction.

WINTER

Diamond grinding wheels for universal tool and cutter grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 1FF1	- 40 - 6 - 2,5 - 3 - 10	D64	K-plus 888 R	C75	60157642702	1)

For grinding chip space of single-edge routers.

1) Delivery within four weeks.

WINTER

For HSS tools only

Diamond grinding wheels for universal tool and cutter grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
1K 4A2	- 50 - 3 - 2 - 10	B107	KSS 10J	V120	66260136536	1)

For grinding tooth faces of small routers with chip thickness restriction.

1) Delivery within four weeks.

WINTER

For HSS tools only

Diamond grinding wheels for universal tool and cutter grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
K 11V2	- 40 - 2 - 5 - 10	B126	KSS 10 N	V180	66260134764	*)

For grinding single or multi-edge routers (first flank)

*) See also Superstandard programme

WINTER

For HSS tools only

Diamond grinding wheels for universal tool and cutter grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
2K 12V9	- 75 - 2,3 - 7,1 - 20	B126	KSS 007N-63	V180	66260113221	

For grinding single- or multi-edged routers (first flank).

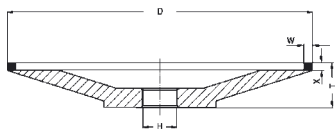
WINTER

Diamond grinding wheels for universal tool and cutter grinding machines

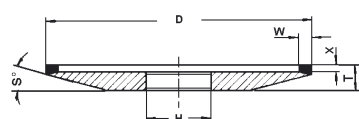
Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
2K 222	- 150 - 3 - 3,3 - 20	D64	K-plus 1410	C75A	66260345390	
5K 222	- 175 - 3 - 3,3 - 20	D64	K-plus 1410	C75A	66260347846	1)
2K 222	- 200 - 3 - 3,3 - 20	D64	K-plus 1410	C75A	66260340765	

For grinding faces of milling cutters with deep, narrow chip spaces (e.g. BG test tools). 1) Delivery within four weeks.

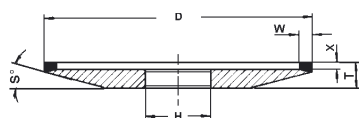
Grinding wheel shape **222**



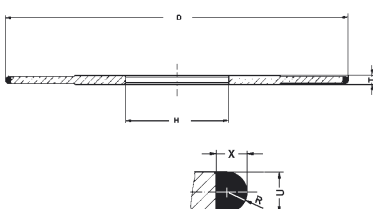
Grinding wheel shape **4A2**



Grinding wheel shape **222**



Grinding wheel shape **14F1**



WINTER

Diamond grinding wheels for universal tool and cutter grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
14K 222	- 150 - 5 - 4 - 20	D64 D151	K-plus 888 R K-plus 1414 N	C50 C75	66260135778 66260128468	T = 23
2K 222	- 175 - 5 - 4 - 20	D64	K-plus 888 R	C50	66260135779	T = 26
6K 222	- 200 - 5 - 4 - 20	D64	K-plus 888 R	C50	60157643208	T = 28

For grinding faces of milling cutters with deep, narrow chip spaces (e.g. BG test tools).

WINTER

For HSS tools only

CBN grinding wheels for universal tool and cutter grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
K 4A2	- 175 - 5 - 4 - 20	B126	KSS 10 J	V120	60157643668	T=13/S=15°
K 4A2	- 200 - 6 - 2 - 20	B107	KSS 10 J	V120	60157643223	T=11/S=15°

For grinding BG test tools.

WINTER

For HSS tools only

CBN grinding wheels for universal tool and cutter grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
2K 222	- 150 - 3 - 3,3 - 20	B64 B107	KSS 007N-63 KSS 007N-63	V120A V180A	66260119538 66260345388	T=12/S=12° T=12/S=12°
5K 222	- 175 - 3 - 3,3 - 20	B107	KSS 007N-63	V180A	66260347845	T=12/S=12°
2K 222	- 200 - 3 - 3,3 - 20	B107	KSS 007N-63	V180A	66260340761	T=12/S=12°

For grinding tooth faces of milling cutters with narrow, deep chip spaces (e.g. BG test tools).

WINTER

For HSS tools only

CBN grinding wheels for universal tool and cutter grinding machines

Shape	- D - W - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
14K 222	- 150 - 5 - 4 - 20	B107	KSS 10 J	V120	66260135777	T = 23
2K 222	- 175 - 5 - 4 - 20	B107	KSS 10 J	V120	66260135775	T = 26
6K 222	- 200 - 5 - 4 - 20	B107	KSS 10 J	V120	60157643768	T = 28

For grinding tooth faces of milling cutters with narrow, deep chip spaces (e.g. BG test tools).

WINTER

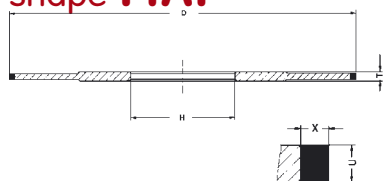
Diamond grinding wheels for grinding machines >Weinig Rondamat<

Shape	- D - U - X - R - H	Grit size	Bond	Concentration	ORDER No.	Remarks
K 14F1	- 200 - 3 - 5 - 1.5 - 60	D64	K-plus 920	C100 A	66260336122	T=10 ¹⁾
3K 14F1	- 200 - 4 - 6 - 2 - 60	D46 D151	K-plus 888 RY K-plus 1313 RY	C100 A C100A	66260111253 66260114210	T = 5 T = 5

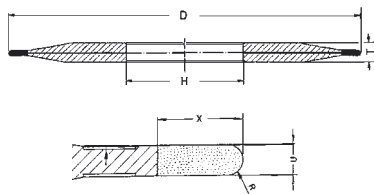
For profile grinding of milling cutters and inserts of inserted-tooth milling cutters.
Machine type: Rondamat 930 / 31

¹⁾ Delivery within four weeks.

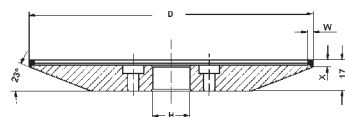
Grinding wheel shape **14A1**



Grinding wheel shape **14F1**



Grinding wheel shape **222**



WINTER

Diamond grinding wheels for grinding machines >Weinig Rondamat<

Shape	- D - U - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
2K 14A1	- 200 - 4 - 10 - 60	D46	K-plus 888 RY	C 100 A	66260112982	T = 6

For profile grinding of milling cutters and inserts of inserted-tooth milling cutters.
Machine type: Rondamat 930 / 31

WINTER

Diamond grinding wheels for profile grinding

Shape	- D - U - X - R - H	Grit size	Bond	Concentration	ORDER No.	Remarks
9K 14F1	- 200 - 2 - 7 - 1 - 20	D64	K-plus 4821	C100A	66260119930	T = 10 *)
		30 D64	K-plus 4821	C100A	66260127332	T = 10 *)
		31,75 D64	K-plus 4821	C100A	66260127734	T = 10 *)
		32 D64	K-plus 4821	C100A	66260350546	T = 10 *)
		40 D64	K-plus 4821	C100A	66260127638	T = 10 *)
		50 D64	K-plus 4821	C100A	66260118539	T = 10 *)
13K 14F1	- 200 - 2 - 7 - 1 - 60	60 D64	K-plus 4821	C100A	66260131361	T = 10 *)
		D64	K-plus 4821	C100A	66260119140	T = 5 *)

For profile grinding of milling cutters and inserts of inserted-tooth milling cutters. *) Also for Weinig Rondamat
*) Delivery within four weeks.

WINTER

Diamond grinding wheels for profile grinding

Shape	- D - U - X - R - H	Grit size	Bond	Concentration	ORDER No.	Remarks
7K 14F1	- 200 - 4 - 7 - 2 - 20	D151	K-plus 4821	C100A	66260119142	T = 10 *)
		30 D151	K-plus 4821	C100A	66260395343	T = 10 *)
		31,75 D151	K-plus 4821	C100A	66260127145	T = 10 *)
		32 D151	K-plus 4821	C100A	66260350535	T = 10 *)
		40 D151	K-plus 4821	C100A	66260117349	T = 10 *)
		50 D151	K-plus 4821	C100A	66260117251	T = 10 *)
9K 14F1	- 200 - 4 - 7 - 2 - 60	D151	K-plus 4821	C100A	66260127453	T = 5 *)

For profile grinding of milling cutters and inserts of inserted-tooth milling cutters. *) Also for Weinig Rondamat
*) Delivery within four weeks.

WINTER

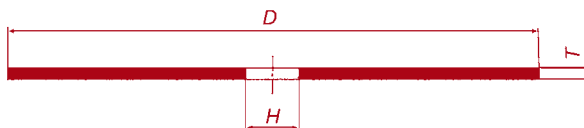
For HSS tools only

CBN grinding wheels for grinding machine >Weinig Rondamat<

Shape	- D - U - X - H	Grit size	Bond	Concentration	ORDER No.	Remarks
4K 222	- 150 - 2 - 3,3 - 20	B107	KSS JYA	V180A	60157642630	

For grinding faces of milling cutters.
Machine type: Rondamat 912

Conventional grinding wheels



NORTON

Grinding wheels for tooth sharpening of CV-sawblades

Material number	Dimension D - T - H	Specification	for machine	Remarks
66253088057	150 - 3 - 20	217AH806M8V451	Vollmer CNE, CANA, etc.	
66253088060	200 - 6 - 20.R3	27AA606M8V303	Vollmer CNE, CANA, etc.	
66253088061	250 - 8 - 20.R4	21A54K8V300	Vollmer CNE, CANA, etc.	

NORTON

Grinding wheels for relieve grinding the carbide tooth

Material number	Dimension D - T - H	Specification	for machine	Remarks
66253088062	175 - 3 - 51	21A80L7V300	Widma	
66243569396	120 - 2 - 51	57A60MB25	Vollmer Lilliput	

NORTON

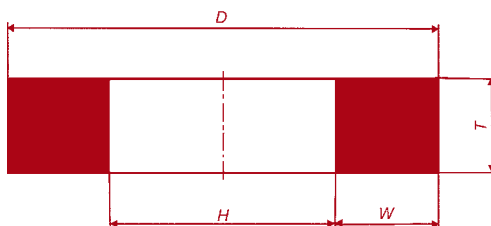
Grinding wheels for tooth sharpening of belt saws

Material number	Dimension D - T - H	Specification	for machine	Remarks
69210444548	175 - 3 - 51	21A80L7V300	Vollmer Lilliput	Nassschliff
69936659605	175 - 3 - 51	38A54KV5	Vollmer Lilliput	Trockenschliff

NORTON

Grinding wheels for profiling of HSS knives and inserts

Material number	Dimension D - T - H	Specification	for machine	Remarks
69936694778	225 - 5 - 60	3SG46JVS	Weinig / Schneeberger	

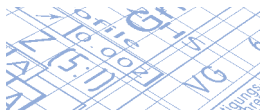


Contact address for conventional grinding wheels see backside

NORTON

Grinding wheels for HSS planer knives and chopper knives

Material number	Dimension D - T - H	Specification	for machine	Remarks
61463663860	200 - 100 - 160	22A467G8B165001	Göckel / Reform, etc.	
66253088065	225 - 90 - 185	22A467G8B165001	Göckel / Reform, etc.	
61463663030	250 - 100 - 200	22A467G8B165001.EVJ160	Göckel / Reform, etc.	



Dressing tools and WINTER cleaning and sharpening stones for diamond and CBN wheels

WINTER Dressing Device

with rotating SiC wheel (break-controlled)
for dressing diamond and CBN wheels.
Complete with 1 wheels 37 C602 N5V and 37 C802-15V.

Order No. 66260195821

Share wheels:

37 C46-N5V **Order No. 66260381805**

37 C602-N5V **Order No. 69936639791**

37 C802-15V **Order No. 66260390221**

For grit size:

≤ D/B181

≥ D/B46

D/B64 and metal bond

Accessories for WINTER Dressing Device:

1 Set Order No. 66260274670

Consisting of: 3 brake discs, clips and screws.

Handout about the dressing device on request.



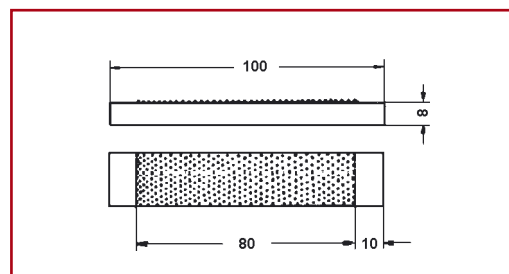
Use dry only, subsequent sharpening with WINTER Stone only if required.

1S 09 H-80-20-8

Order No. 66260134287

WINTER Diamond Dressing Stick

for dressing CBN wheels (KSS) on surface grinding machines.
Use with coolant, subsequent sharpening with WINTER-Stone necessary.

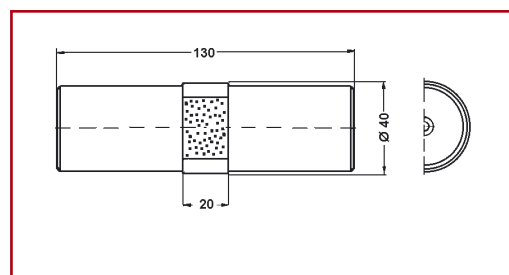


1S 44B-40-20 / D301 / S11

Order No. 60157642712

WINTER Dressing Cylinder

For dressing CBN wheels (KSS) on cylindrical grinding machines.
Use with coolant subsequent sharpening with WINTER-Stone necessary.



WINTER-Stone Nr. 1AW (100x20x20)

Cleaning for fine grit, < D46, K-plus bonds.

Order No. 66260395639

WINTER-Stone Nr. 2 (100x24x13)

Universal sharpening stone.

Order No. 66260195816

WINTER-Stone Nr. 3 (100x40x15)

Cleaning and sharpening vitrified-bond CBN wheels and pins.

Order No. 66260195817

WINTER-Stone Nr. 3a (80x15x10)

Cleaning and sharpening vitrified-bond CBN wheels and pins.

Order No. 66260389357

WINTER-Stone Nr. 3b (100x50x25)

Cleaning and sharpening vitrified-bond CBN wheels and pins.

Order No. 66260386167

WINTER-Stone Nr. 4 (90x70x20)

For sharpening metal-bond diamond and CBN wheels
(BZ / MS). Grit > D/B251.

Order No. 60157642665

WINTER-Stone Nr. 5 (100x50x25)

Comments: see WINTER Stone No. 2

Order No. 66260389054

For your enquiries please contact:

WINTER

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