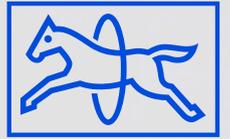


PFERD



TOOLS



Mounted points

Mounted points

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Mounted points

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Mounted points

Highlights from the PFERD TOOLS range



TOUGH mounted points

TOUGH type mounted points have a state-of-the-art vitrified bond comprising an aluminium oxide mixture of ceramic oxide grain and white aluminium oxide, which impresses as it is easy to break down. The mounted points have a long tool life and high stock removal performance with excellent removal rates thanks to the self-sharpening qualities of the ceramic oxide grain.

The TOUGH type is specifically designed for general use on titanium materials, nickel-based and cobalt-based alloys, hardened steel components and built-up weld deposits. TOUGH type mounted points can easily machine hardened, heat-treated steels over 1,200 N/mm² (> 38 HRC).

Its applications include weld dressing on repair welds and reworking on turbine blades during aircraft maintenance, as well as regrinding of repair welds in tool and mould-making.

Scan the QR code to find out more about the PFERD TOOLS grinding/mounted points.



Bench grinding wheels

PFERD TOOLS offers a very wide range of high-quality bench grinding wheels for work on a large variety of materials. Bench grinding wheels are very well-suited to deburring, work on edges and sharpening tools. The bench grinding wheels are available with different dimensions, grains and abrasives. The PFERD TOOLS range has been adapted to the standard bench grinders on the market.

The bench grinding wheels impress with their long tool life, high dimensional stability and high abrasive performance. Thanks to the integrated adapter sleeves, the bench grinding wheels can be mounted on almost any bench grinder spindle. Dressing the wheel on a regular basis exposes sharp grain and maintains an even grinding area.

Scan the QR code to find out more about the PFERD TOOLS bench grinding wheels.



Grinding and polishing stones

Grindstones and polishing stones are versatile tools for finish machining on moulds in tool and mould-making. They are used for step-by-step fine grinding after machining or after electrical discharge machining (EDM) to grind in a brushed finish/polish in the demoulding direction or to prepare for high-gloss polishing with diamond pastes. They are also used for rounding and finishing.

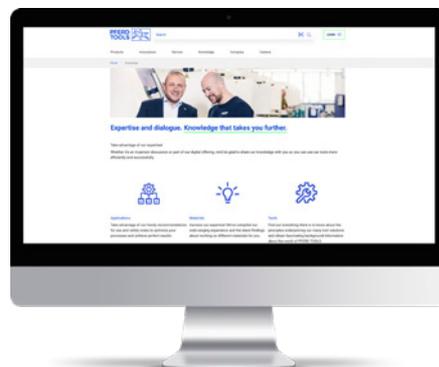
A quick-mounting handle is recommended in manual applications to make work more ergonomic. Grinding oil should be used to achieve a better surface finish. Polishing stones should be sorted by type to avoid grain being carried over.

Scan the QR code to find out more about grinding and polishing stones.



More expert information online

Scan the QR code to find out a wide range of tool and application knowledge relating to PFERD TOOLS' high-quality tools and their huge variety of materials.



The quick way to find the perfect tool

① Material group

Select the material to be machined.

② Application

Select the application.

③ Mounted point type

After determining the application (see column ②), the type is selected in the horizontal row.

① Material group			Bond ▶		Vitrified bond									
			③ Mounted point type ▶		INOX	INOX EDGE	RUBBER	ALU	TOUGH	CAST	CAST STEEL	STEEL	STEEL EDGE	CAST EDGE
Abrasive ▶			ADW	AN	AH	CN	AWCO	ARN	ADR	ADW	AR	CU		
Rec. cutting speed ▶			35-50 m/s	35-50 m/s	5-20 m/s	20-40 m/s	30-50 m/s	30-50 m/s	25-40 m/s	30-50 m/s	25-40 m/s	30-50 m/s		
② Application ▼														
Steel, cast steel	Steels up to 1,200 N/mm ² (< 38 HRC)	Construction steels, carbon steels, tool steels, non-alloyed steels, case-hardened steels, tempering steels	Universal								●			
			Surface	○								●	○	
			Edges		○							○	●	
	Hardened, heat-treated steels over 1,200 N/mm ² (> 38 HRC)	Tool steels, tempering steels, alloyed steels	Universal									●		
			Surface					●				○		
			Edges					●						○
	Cast steel	Non-alloyed cast steel, low-alloyed cast steel	Universal								●			
			Surface	○						○	○	●	○	
			Edges		○						○	○	●	
Stainless steel (INOX)	Rust and acid-resistant steels	Austenitic and ferritic stainless steels	Surface	●	○							○		
			Edges	○	●								○	
Non-ferrous metals	Soft non-ferrous metals, non-ferrous metals	Aluminium alloys, brass, copper, zinc	Universal	○			●							
	Hard non-ferrous metals	Bronze, titanium, titanium alloys, hard aluminium alloys		●			○	●			○			
	High-temperature-resistant materials	Nickel-based and cobalt-based alloys (engine and turbine construction)		○				●						
Cast iron	Grey cast iron, white cast iron	Cast iron with flake graphite EN-GJL (GG), with nodular graphite/nodular cast iron EN-GJS (GGG), white annealed cast iron EN-GJMW (GTW), black annealed cast iron EN-GJMB (GTS)	Surface	○	○					●	○		○	
			Edges	○	○					○	○		○	●
Plastics, other materials	Fibre-reinforced plastics, thermoplastics, rubber, wood		Universal			●	○							

● = highly suitable ○ = suitable

Applications of mounted points



General use

For general use on surfaces and edges, the emphasis is on the balance between abrasive performance and tool life.



Surface grinding

In surface grinding, the mounted points are subject to lower loads. The mounted point bond is therefore comparatively soft and has been designed to give high stock removal rates.

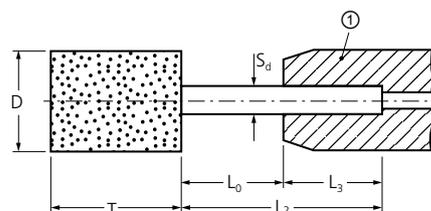


Edge grinding

In edge grinding, the mounted points must be dimensionally stable. The mounted point bond is therefore comparatively hard and designed for a long service life.

Explanation of the code system according to EN 12413

D = Mounted point outer dia.
T = Mounted point width
 S_d = Shank dia.
 L_0 = Unsupported shank length
 L_2 = Shank length
 L_3 = Clamping length of shank (⊙ collet)



Safety notes

All PFERD TOOLS mounted points are approved for a maximum operating speed of 50 m/s. The maximum permitted rotational speeds for the various shank lengths and shank diameters are defined in DIN 69170 based on EN 12413. These must be adhered to in order to avoid buckling of the shank during use. Regardless of the shank length, the clamping length (L_3) of the shank must be at least 10 mm.

The maximum permitted rotational speed calculated according to EN 12413 is determined by the following factors:

- Shape and dimensions of the mounted point
- Diameter of the steel shank S_d
- Unsupported shank length L_0



Wear eye protection!



Wear hearing protection!



Wear a dust mask!



Wear gloves!



Observe the safety notes!

Custom-made products

If you cannot find the solution for your particular application in our extensive catalogue range, we can produce grinding and mounted points in premium PFERD TOOLS quality specifically for your application on request.

We can take into account your specifications and needs, drawings, information on dimensions and shapes, grit sizes and grain types, grain mixtures, shank diameters and shank lengths. Please speak to our sales representatives. We will be happy to advise you.

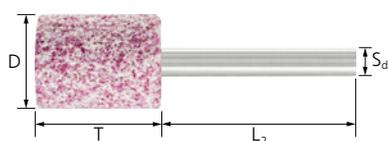


Extensions for drive spindles

Mounted points with a shank diameter of 3, 6 and 8 mm can be extended with drive spindle extensions. They allow access to hard-to-reach areas. The drive spindle extension is mounted in the collet of the tool drive (air grinder or electric grinder), or in the handpiece of the flexible shaft. In some applications, spindle extensions are an economical alternative to customized mounted points with long shanks. Further information on our drive spindle extensions can be found in catalogue section 9 "Tool drives".


3

For universal use on steel and cast steel



STEEL cylindrical mounted points

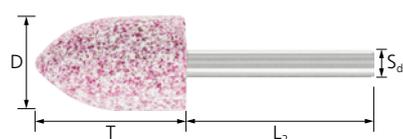
These mounted points are exceptionally well suited for grinding high-speed steel (HSS) moulded parts and weld dressing of weld seams on steel constructions. The cylindrical shape ZY is ideal for grinding bores, radii and contours.



Special features:

- High grinding performance and stock removal rate in general use on steel materials.
- Shortened grinding times and thus cost savings due to the high stock removal rate.
- Particularly suitable for work on surfaces.

S_d [mm]	L_2 [mm]	D [mm]	T [mm]	Grit size	USA type	Opt. RPM	Max. RPM		Item no.	Designation
6	40	13	25	46	W 187	65,000	66,000	10	31125254	ZY 1325 6 ADW 46 M5V STEEL
6.35	40	50	25	46	W 242	17,200	19,100	5	39101318	W 242 6.3 ADW 46 M 5V STEEL



Pointed tree type STEEL

These mounted points are exceptionally well suited for grinding high-speed steel (HSS) moulded parts and weld dressing of weld seams on steel constructions. The pointed tree shape SP is suitable for machining small holes and bores.

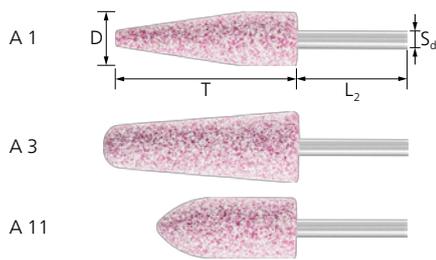
Special features:

- High grinding performance and stock removal rate in general use on steel materials.
- Shortened grinding times and thus cost savings due to the high stock removal rate.
- Particularly suitable for work on surfaces.

S_d [mm]	L_2 [mm]	D [mm]	T [mm]	Grit size	Opt. RPM	Max. RPM		Item no.	Designation
6	40	20	50	30	30,500	30,500	10	32111253	SP 2050 6 ADW 30 M5V STEEL
		25	40	30	35,000	35,000	10	32114253	SP 2540 6 ADW 30 M5V STEEL

Mounted points

For universal use on steel and cast steel



Series A STEEL

These mounted points are exceptionally well suited for grinding high-speed steel (HSS) moulded parts and weld dressing of weld seams on a wide range of different contours on steel constructions.

Special features:

- High grinding performance and stock removal rate in general use on steel materials.
- Shortened grinding times and thus cost savings due to the high stock removal rate.
- Particularly suitable for work on surfaces.

S _d [mm]	L ₂ [mm]	USA type	D [mm]	T [mm]	Grit size	Opt. RPM	Max. RPM		Item no.	Designation
6.35	40	A 1	19	64	30	33,500	33,500	10	35001253	A 1 6,3 ADW 30 M5V STEEL
		A 3	25	70	30	13,080	16,100	10	39101950	A 3 6,3 ADW 30 M 5V STEEL
6.3	40	A 11	22	50	30	15,100	19,860	10	39101693	A 11 6,3 ADW 30 M5V 330 STEEL



Mounted point set SSO 5300 STEEL

This set is exceptionally well suited for grinding high-speed steel (HSS) moulded parts and weld dressing of weld seams on steel constructions. It contains 100 mounted points with 6 mm shank diameter in the most common shapes and dimensions.

Contents:

Contains ten each of the following mounted points: 16 x 20 mm, 20 x 25 mm, 25 x 6 mm, 25 x 32 mm, 32 x 16 mm, 32 x 32 mm, 40 x 20 mm in cylindrical shape, 20 x 32 mm in pointed tree shape and 25 x 70 mm in conical shape.

Special features:

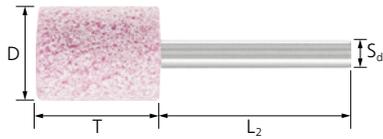
- High grinding performance and stock removal rate in general use on steel materials.
- Shortened grinding times and thus cost savings due to the high stock removal rate.
- Particularly suitable for work on surfaces.

S _d [mm]	Grit size		Item no.	Designation
6	coarse	1	33930001	SSO 5300 STEEL



Mounted points

For edge grinding on steel and cast steel



STEEL EDGE cylindrical mounted points

These mounted points are particularly suitable for edge grinding and for deburring work, as well as for grinding chamfers for weld seam preparation and weld dressing on contours. The cylindrical shape ZY is ideal for grinding bores, radii and contours.



Special features:

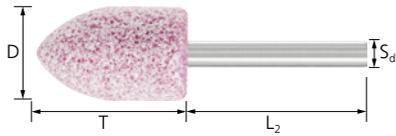
- Long tool life and low tool wear due to hard, dimensionally stable bond.
- Economical to use due to the high edge stability even on low-speed tool drives.
- Particularly well suited to work on edges.

3

S_d [mm]	L_2 [mm]	D [mm]	T [mm]	Grit size	USA type	Opt. RPM	Max. RPM		Item no.	Designation		
3	30	3	6	100	W 144	150,000	206,100	10	31103270	ZY 0306 3 AR 100 O5V STEEL EDGE		
			10	100	W 145	131,400	131,400	10	35805270	ZY 0310 3 AR 100 O5V STEEL EDGE		
			13	100	W 146	95,400	95,400	10	35806270	ZY 0313 3 AR 100 O5V STEEL EDGE		
		6	40	4	8	60	-	150,000	175,100	10	31105276	ZY 0408 3 AR 60 O5V STEEL EDGE
					10	100	W 153	130,000	130,700	10	31107270	ZY 0510 3 AR 100 O5V STEEL EDGE
				5	13	100	W 154	114,800	114,800	10	35814270	ZY 0513 3 AR 100 O5V STEEL EDGE
					19	100	W 162	100,000	110,500	10	35822270	ZY 0610 3 AR 100 O5V STEEL EDGE
				6	19	100	W 164	64,500	64,500	10	35824270	ZY 0619 3 AR 100 O5V STEEL EDGE
					8	13	46	W 170	74,400	74,400	10	35830274
				10	10	80	W 175	65,000	77,500	10	35835278	ZY 1010 3 AR 80 O5V STEEL EDGE
					13	80	W 176	58,400	58,400	10	31116278	ZY 1013 3 AR 80 O5V STEEL EDGE
				13	13	80	W 185	45,300	45,300	10	31122278	ZY 1313 3 AR 80 O5V STEEL EDGE
				16	3	60	W 191	42,000	60,000	10	35851276	ZY 1603 3 AR 60 O5V STEEL EDGE
				19	3	60	W 200	35,000	49,900	10	35860276	ZY 1903 3 AR 60 O5V STEEL EDGE
				6	40	10	13	80	W 176	65,000	95,400	10
13	80	W 185	50,000				73,400	10	31121278	ZY 1313 6 AR 80 O5V STEEL EDGE		
40	46	W 188	42,400				42,400	10	31146274	ZY 1340 6 AR 46 O5V STEEL EDGE		
20	6	80	W 201			33,000	47,700	10	31317278	ZY 2006 6 AR 80 O5V STEEL EDGE		
	25	60	W 205			33,000	47,700	10	31131276	ZY 2025 6 AR 60 O5V STEEL EDGE		
25	6	80	W 214			26,000	38,100	10	31321278	ZY 2506 6 AR 80 O5V STEEL EDGE		
	13	30	W 218			26,000	38,100	10	31323273	ZY 2513 6 AR 30 O5V STEEL EDGE		
	25	30	W 220			26,000	38,100	10	31134273	ZY 2525 6 AR 30 O5V STEEL EDGE		
60	60	W 220	26,000			38,100	10	31134276	ZY 2525 6 AR 60 O5V STEEL EDGE			
6.35	40	25	25	30	W 220	19,120	25,500	10	39105059	ZY 2525 6.3 AR30 O5V STEEL EDGE		
6	40	40	10	46	W 236	16,000	23,800	5	39101225	W 236 6,3 AR 46 O5V STEEL EDGE		
6.35	40	40	25	30	W 237	17,620	22,500	5	39100968	W 237 6.3 AR30 O5V STEEL EDGE		

Mounted points

For edge grinding on steel and cast steel



Pointed tree type STEEL EDGE

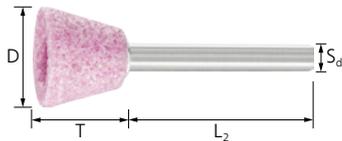
These mounted points are particularly suitable for edge grinding and for deburring work, as well as for grinding chamfers for weld seam preparation and weld dressing on contours. The pointed tree shape SP is exceptionally well-suited for machining small holes and bores.



Special features:

- Long tool life and low tool wear due to hard, dimensionally stable bond.
- Economical to use due to the high edge stability even on low-speed tool drives.
- Particularly well suited to work on edges.

S_d [mm]	L_2 [mm]	D [mm]	T [mm]	Grit size	Opt. RPM	Max. RPM		Item no.	Designation
6	40	13	20	80	50,000	73,400	10	32107278	SP 1320 6 AR 80 05V STEEL EDGE



STEEL EDGE cups

These mounted points are particularly suitable for edge grinding and for deburring work, as well as for grinding chamfers for weld seam preparation and weld dressing on contours. The cup shape TO is ideal for work on profiles, planar surfaces and ledges, without the cylindrical surface being damaged.

Special features:

- Long tool life and low tool wear due to hard, dimensionally stable bond.
- Economical to use due to the high edge stability even on low-speed tool drives.
- Particularly well suited to work on edges.

S_d [mm]	L_2 [mm]	D [mm]	T [mm]	Grit size	Opt. RPM	Max. RPM		Item no.	Designation
6	40	25	20	30	26,000	38,100	10	32902273	TO 2520 6 AR 30 05V STEEL EDGE
		32	25	46	21,000	29,800	5	32903274	TO 3225 6 AR 46 05V STEEL EDGE



Mounted points

For edge grinding on steel and cast steel



Series A STEEL EDGE

These mounted points are particularly suitable for edge grinding and for deburring work, as well as for grinding chamfers for weld seam preparation and weld dressing on a wide range of different contours.

Special features:

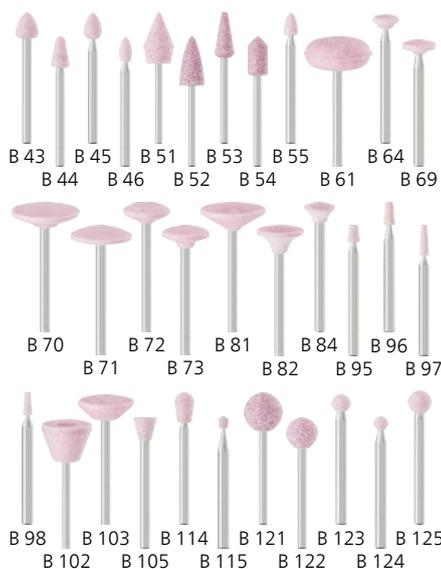
- Long tool life and low tool wear due to hard, dimensionally stable bond.
- Economical to use due to the high edge stability even on low-speed tool drives.
- Particularly well suited to work on edges.



S_d [mm]	L_2 [mm]	USA type	D [mm]	T [mm]	Grit size	Opt. RPM	Max. RPM		Item no.	Designation
6	40	A 11	22	50	30	27,600	27,600	10	35511273	A 11 6 AR 30 05V STEEL EDGE
		A 12	17	32	30	40,000	54,500	10	35512273	A 12 6 AR 30 05V STEEL EDGE
		A 15	6	27	60	100,000	112,900	10	35515296	A 15 6 AR 60 05V STEEL EDGE
		A 25	25	25	30	26,000	37,500	10	35525273	A 25 6 AR 30 05V STEEL EDGE
		A 26	16	16	30	42,000	60,000	10	35526273	A 26 6 AR 30 05V STEEL EDGE
		A 34	38	10	30	18,000	25,000	5	35534273	A 34 6 AR 30 05V STEEL EDGE
6.35	40	A 1	19	64	30	33,500	33,500	10	35001273	A 1 6,3 AR 30 05V STEEL EDGE
		A 2	25	32	30	26,000	37,500	10	35002273	A 2 6,3 AR 30 05V STEEL EDGE
		A 3	25	70	30	18,600	18,600	10	35003273	A 3 6,3 AR 30 05V STEEL EDGE
		A 4	32	32	30	21,000	30,000	5	35004273	A 4 6,3 AR 30 05V STEEL EDGE
		A 5	19	29	30	35,000	49,900	10	35005273	A 5 6,3 AR 30 05V STEEL EDGE
		A 11	22	50	30	30,400	30,400	10	35011273	A 11 6,3 AR 30 05V STEEL EDGE
		A 12	17	32	30	40,000	54,500	10	35012273	A 12 6,3 AR 30 05V STEEL EDGE
		A 15	6	27	60	100,000	112,900	10	35015296	A 15 6,3 AR 60 05V STEEL EDGE
		A 24	6	19	60	100,000	117,400	10	35024276	A 24 6,3 AR 60 05V STEEL EDGE
		A 25	25	25	30	26,000	37,500	10	35025273	A 25 6,3 AR 30 05V STEEL EDGE
		A 36	41	10	60	16,000	23,100	5	35036276	A 36 6,3 AR 60 05V STEEL EDGE
		A 37	32	6	60	21,000	30,000	5	35037276	A 37 6,3 AR 60 05V STEEL EDGE
		A 39	19.1	19.1	60	36,090	44,030	10	39101061	A 39 6,3 AR 60 05V STEEL EDGE
6.3	60	A 26	16	16	30	34,600	44,900	10	39100962	A 26 6,3-60 AR 30 05V STEEL EDGE

Mounted points

For edge grinding on steel and cast steel



Series B STEEL EDGE

These mounted points are particularly suitable for edge grinding and for deburring work, as well as for grinding chamfers for weld seam preparation and weld dressing on a wide range of different contours on smaller or more delicate components.

Special features:

- Long tool life and low tool wear due to hard, dimensionally stable bond.
- Economical to use due to the high edge stability even on low-speed tool drives.
- Particularly well suited to work on edges.

S_d [mm]	L_2 [mm]	USA type	D [mm]	T [mm]	Grit size	Opt. RPM	Max. RPM		Item no.	Designation
3	30	B 52	10	19	46	65,000	66,200	10	35612274	B 52 3 AR 46 05V STEEL EDGE
		B 53	6	16	100	100,000	149,200	10	35613270	B 53 3 AR 100 05V STEEL EDGE
		B 54	6	13	100	100,000	101,500	10	35614270	B 54 3 AR 100 05V STEEL EDGE
		B 61	19	8	80	35,000	45,000	10	35621278	B 61 3 AR 80 05V STEEL EDGE
		B 72	13	3	100	50,000	75,100	10	35632270	B 72 3 AR 100 05V STEEL EDGE
		B 73	13	3	100	50,000	75,100	10	35633270	B 73 3 AR 100 05V STEEL EDGE
		B 81	19	8	100	35,000	49,900	10	35641270	B 81 3 AR 100 05V STEEL EDGE
		B 97	2	10	100	107,300	107,300	10	35657270	B 97 3 AR 100 05V STEEL EDGE
		B 103	16	5	80	42,000	60,000	10	35663278	B 103 3 AR 80 05V STEEL EDGE
		B 121	13	13	46	50,000	56,200	10	35681274	B 121 3 AR 46 05V STEEL EDGE
		B 122	10	10	80	65,000	90,200	10	35682278	B 122 3 AR 80 05V STEEL EDGE
		B 123	5	5	100	130,000	198,900	10	35683270	B 123 3 AR 100 05V STEEL EDGE



Mounted point set 2002 STEEL EDGE

This set is particularly suitable for edge grinding and for deburring work, as well as for grinding chamfers for weld seam preparation and weld dressing on contours. It contains 15 small mounted points in the most common shapes and dimensions for finishing work.

Contents:

Contains two each of the following mounted points: 5 x 10 mm, 8 x 10 mm, 16 x 4 mm in cylindrical shape; and one each of the following mounted points: 4 x 8 mm, 6 x 13 mm, 8 x 2 mm, 10 x 13 mm, 13 x 3 mm in cylindrical shape, 5 x 10 mm in cylindrical shape with radius end, in ball shape with dia. 5 mm,

3 x 6 mm and 8 x 16 mm in pointed tree shape.

Special features:

- Long tool life and low tool wear due to hard, dimensionally stable bond.
- Economical to use due to the high edge stability even on low-speed tool drives.
- Particularly well suited to work on edges.

S_d [mm]	Grit size		Item no.	Designation
3	fine	1	33920231	2002 O F STEEL EDGE

Mounted points

For edge grinding on steel and cast steel



Mounted point set 2001 STEEL EDGE

This set is particularly suitable for edge grinding and for deburring work, as well as for grinding chamfers for weld seam preparation and weld dressing on contours. It contains 10 mounted points in the most common shapes and dimensions.

Contents:

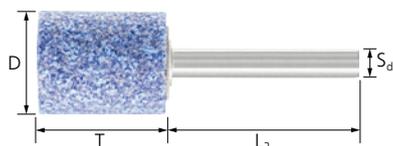
Contains one each of the following mounted points: in cylindrical shape 10 x 13 mm, 13 x 20 mm, 20 x 6 mm, 20 x 13 mm, 20 x 25 mm, in ball shape dia. 16 mm, in cylindrical shape with radius end 20 x 25 mm, in conical shape 20 x 20 mm, 20 x 32 mm and in pointed tree shape 13 x 20 mm.

Special features:

- Long tool life and low tool wear due to hard, dimensionally stable bond.
- Economical to use due to the high edge stability even on low-speed tool drives.
- Particularly well suited to work on edges.

S_d [mm]	Grit size		Item no.	Designation
6	coarse	1	33920131	2001 O G STEEL EDGE

For universal use on materials that are difficult to machine



TOUGH, cylindrical type

These mounted points are particularly suitable for weld dressing on repair welds, reworking on turbine blades during aircraft maintenance, and regrinding of repair welds in tool and mould-making. The cylindrical shape ZY is ideal for grinding bores, radii and contours.



Special features:

- Cool grinding as the grain mix is easy to break down.
- High stock removal rates and very good tool life.
- Constant stock removal rates thanks to the self-sharpening qualities of the ceramic oxide grain.

S_d [mm]	L_2 [mm]	D [mm]	T [mm]	Grit size	USA type	Opt. RPM	Max. RPM		Item no.	Designation
3.17	32	5	13	80	W 154	45,600	70,500	10	35314281	W 154 3,1AW CO80 J5V TOUGH
		6	13	80	W 163	38,020	60,000	10	35323281	W 163 3,1 AW CO 80 J5V TOUGH
			19	80	W 164	30,000	45,900	10	35324281	W 164 3,1 AW CO 80 J5V TOUGH
		8	13	80	W 170	33,000	52,500	10	35330281	W 170 3,1 AW CO 80 J5V TOUGH
6.35	40	13	50	46	W 189	18,750	24,000	10	35449281	W 189 6,3AW CO46 J5V TOUGH
		25	25	46	W 220	19,120	25,500	10	35480281	W 220 6,3 AW CO 46 J5V TOUGH
			50	46	W 222	12,370	15,900	10	35482281	W 222 6,3 AW CO 46 J5V TOUGH
		40	50	46	W 239	9,900	12,750	5	35492281	W 239 6,3 AW CO 46 J5V TOUGH
		50	25	46	W 242	17,200	19,100	5	35493281	W 242 6,3 AW CO 46 J5V TOUGH

Mounted points

For universal use on materials that are difficult to machine



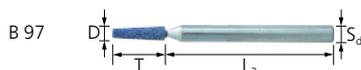
Series A TOUGH

Series A mounted points are particularly well suited to use on larger components. Due to the special shapes of series A mounted points, it is possible to grind in a variety of contours.

Special features:

- Constant stock removal rates thanks to the self-sharpening qualities of the ceramic oxide grain.
- High stock removal rates and very good tool life.

S_d [mm]	L_2 [mm]	USA type	D [mm]	T [mm]	Grit size		Item no.	Designation
6.35	40	A 1	19	63	46	10	35001281	A 1 6,3 AWCO 46 J 5V TOUGH
		A 3	25	70	46	10	35003281	A 3 6,3 AWCO 46 J 5V TOUGH
		A 11	22	50	46	10	35011281	A 11 6,3 AWCO 46 J5V TOUGH
		A 21	25	25	46	10	35021281	A 21 6,3 AWCO 46 J5V TOUGH
		A 26	16	16	46	10	35026281	A 26 6,3 AWCO 46 J5V TOUGH
		A 39	19	19	46	10	35038281	A 39 6,3 AWCO 46 J5V TOUGH



Series B TOUGH

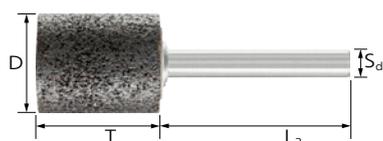
Series B mounted points are suitable for use on smaller or more delicate components, such as in tool and mould construction. Due to the special shapes of series B mounted points, it is possible to grind in a variety of contours.

Special features:

- Cool grinding as the grain mix is easy to break down.
- High stock removal rates and very good tool life.
- Constant stock removal rates thanks to the self-sharpening qualities of the ceramic oxide grain.

S_d [mm]	L_2 [mm]	USA type	D [mm]	T [mm]	Grit size		Item no.	Designation
3.17	32	B 97	3	10	80	10	35157281	B 97 3,1 AWCO 80 J5V TOUGH

For universal use on stainless steel (INOX)



INOX cylindrical type

These mounted points are used for rough grinding of stainless steel (INOX) castings and grinding of moulded parts made of high-temperature-resistant alloys. The cylindrical shape ZY is ideal for grinding bores, radii and contours.



Special features:

- Due to cool grinding, particularly suitable for use on temperature-sensitive materials.
- High level of grinding comfort due to low-vibration grinding.

S_d [mm]	L_2 [mm]	D [mm]	T [mm]	Grit size	USA type	Opt. RPM	Max. RPM		Item no.	Designation	
6	40	6	19	60	W 164	88,900	88,900	100	39101418	W 164 6 ADW 60 L6B INOX	
			20	40	60	W 207	26,600	35,800	100	39101474	W 207 6 ADW 60 L6B INOX
				50	60	W 208	19,600	25,800	10	39101475	W 208 6 ADW 60 L6B INOX
		25	25	60	W 220	37,000	38,100	10	39101399	W 220 6 ADW 60 L6B INOX	
			40	60	60	W 235	23,000	23,800	5	39101949	W 235 6 ADW 60 L6B INOX
				25	60	W 237	15,750	15,750	5	39101428	W 237 6 ADW 60 L6B INOX

Continued on next page

Mounted points

For universal use on stainless steel (INOX)



S_d [mm]	L_2 [mm]	D [mm]	T [mm]	Grit size	USA type	Opt. RPM	Max. RPM		Item no.	Designation
6	40	16	32	30	-	51,200	51,200	10	31127743	ZY 1632 6 ADW 30 L6B INOX
				30	W 205	45,000	47,700	10	31131743	ZY 2025 6 ADW 30 L6B INOX
		20	25	60	W 205	45,000	47,700	10	31131746	ZY 2025 6 ADW 60 L6B INOX
				40	W 207	32,400	32,400	10	31133743	ZY 2040 6 ADW 30 L6B INOX
				30	W 218	37,000	38,100	10	31323743	ZY 2513 6 ADW 30 L6B INOX
		25	13	30	W 220	37,000	38,100	10	31134743	ZY 2525 6 ADW 30 L6B INOX
				30	-	32,900	32,900	10	31135743	ZY 2532 6 ADW 30 L6B INOX
				30	-	29,000	29,800	5	31326742	ZY 3216 6 ADW 24 L6B INOX
		32	16	24	W 231	20,300	20,300	5	31137742	ZY 3240 6 ADW 24 L6B INOX
				24	-	23,000	23,800	5	31328743	ZY 4010 6 ADW 30 L6B INOX
		40	10	30	-	23,000	23,800	5	31330742	ZY 4020 6 ADW 24 L6B INOX
				24	-	19,000	19,000	5	31331743	ZY 5013 6 ADW 30 L6B INOX
		50	13	30	-	19,000	19,000	5	31332742	ZY 5025 6 ADW 24 L6B INOX
				24	W 242	19,000	19,000	5		



INOX, cylindrical with radius end type

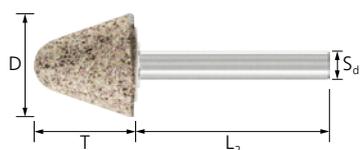
These mounted points are used for rough grinding of stainless steel (INOX) castings and grinding of moulded parts made of high-temperature-resistant alloys. The cylindrical shape with radius end WR is perfect for a variety of deburring and grinding jobs.



Special features:

- Due to cool grinding, particularly suitable for use on temperature-sensitive materials.
- High level of grinding comfort due to low-vibration grinding.

S_d [mm]	L_2 [mm]	D [mm]	T [mm]	Grit size	Opt. RPM	Max. RPM		Item no.	Designation
6	40	25	32	30	37,000	37,300	10	31408253	WR 2532 6 ADW 30 L6B INOX



INOX, tapered type

These mounted points are used for rough grinding of stainless steel (INOX) castings and grinding of moulded parts made of high-temperature-resistant alloys. The conical shape KE is designed for a comfortable working position during surface grinding and grinding of chamfers.

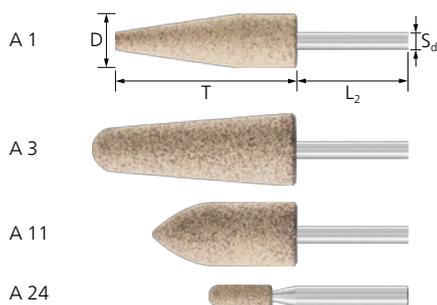
Special features:

- Due to cool grinding, particularly suitable for use on temperature-sensitive materials.
- High level of grinding comfort due to low-vibration grinding.

S_d [mm]	L_2 [mm]	D [mm]	T [mm]	Grit size	Opt. RPM	Max. RPM		Item no.	Designation
6	40	20	20	30	45,000	47,700	10	32205743	KE 2020 6 ADW 30 L6B INOX
		25	45	30	34,000	34,000	10	32211743	KE 2545 6 ADW 30 L6B INOX

Mounted points

For universal use on stainless steel (INOX)



Series A INOX

These mounted points are used for rough grinding of a wide range of different contours on stainless steel (INOX) castings and grinding of moulded parts made of high-temperature-resistant alloys.

Special features:

- Due to cool grinding, particularly suitable for use on temperature-sensitive materials.
- High level of grinding comfort due to low-vibration grinding.

S_d [mm]	L_2 [mm]	USA type	D [mm]	T [mm]	Grit size	Opt. RPM	Max. RPM		Item no.	Designation
6	40	A 1	19	64	60	30,400	30,400	10	35501746	A 1 6 ADW 60 L6B INOX
		A 3	25	70	60	18,600	18,600	10	35503746	A 3 6 ADW 60 L6B INOX
		A 11	22	50	60	27,600	27,600	10	35511746	A 11 6 ADW 60 L6B INOX
		A 24	6	19	60	117,400	117,400	10	39101427	A 24 6 ADW 60 L6B INOX

For edge grinding on stainless steel (INOX)



INOX EDGE, cylindrical type

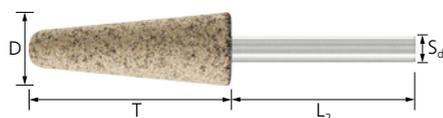
Applications include weld dressing on fillet welds, removing burrs and grinding chamfers on high-temperature-resistant alloys and stainless steel components. The cylindrical shape ZY is ideal for grinding bores, radii and contours.



Special features:

- Due to cool grinding, particularly suitable for use on temperature-sensitive materials.
- High grinding comfort due to low-vibration grinding and high dimensional stability on edges.
- Economical to use due to the high edge stability even on low-speed tool drives.

S_d [mm]	L_2 [mm]	D [mm]	T [mm]	Grit size	Opt. RPM	Max. RPM		Item no.	Designation
6	40	50	8	30	19,000	19,000	5	31378613	ZY 5008 6 AN 30 N5B INOX EDGE



INOX EDGE, tapered type

Applications include weld dressing on fillet welds, removing burrs and grinding chamfers on high-temperature-resistant alloys and stainless steel components. The conical shape KE is designed for a comfortable working position during surface grinding and grinding of chamfers.



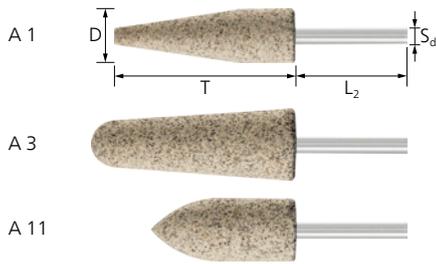
Special features:

- Due to cool grinding, particularly suitable for use on temperature-sensitive materials.
- High grinding comfort due to low-vibration grinding and high dimensional stability on edges.
- Economical to use due to the high edge stability even on low-speed tool drives.

S_d [mm]	L_2 [mm]	D [mm]	T [mm]	Grit size	Opt. RPM	Max. RPM		Item no.	Designation
6	40	32	32	24	29,000	29,800	5	32207612	KE 3232 6 AN 24 N5B INOX EDGE

Mounted points

For edge grinding on stainless steel (INOX)



Series A INOX EDGE

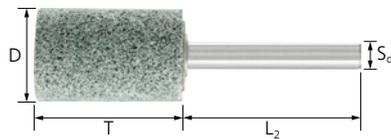
Applications include weld dressing on fillet welds, removing burrs and grinding chamfers with different contours on high-temperature resistant alloys and stainless steel components.

Special features:

- Due to cool grinding, particularly suitable for use on temperature-sensitive materials.
- High grinding comfort due to low-vibration grinding and high dimensional stability on edges.
- Economical to use due to the high edge stability even on low-speed tool drives.

S_d [mm]	L_2 [mm]	USA type	D [mm]	T [mm]	Grit size	Opt. RPM	Max. RPM		Item no.	Designation
6.35	40	A 11	22	50	30	30,400	30,400	10	35011613	A 11 6,3 AN 30 N5B INOX EDGE

For universal use on soft non-ferrous metals



ALU cylindrical mounted points

These mounted points are used to remove burrs on cast aluminium parts and for chamfering on aluminium profiles for weld-seam preparation. The cylindrical shape ZY is ideal for grinding bores, radii and contours.



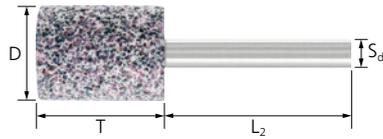
Special features:

- The special impregnation means there is no clogging when working on soft, lubricating or tough materials.
- High grinding performance and stock removal rate.

S_d [mm]	L_2 [mm]	D [mm]	T [mm]	Grit size	USA type	Opt. RPM	Max. RPM		Item no.	Designation
6	40	16	20	80	W 195	30,000	59,600	10	31126408	ZY 1620 6 CN 80 F10V ALU
		32	32	80	W 230	15,000	25,700	5	31136408	ZY 3232 6 CN 80 F10V ALU

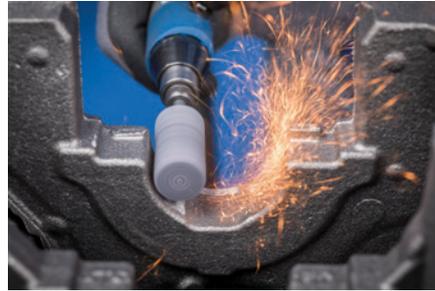
Mounted points

For surface grinding on grey and nodular cast iron



CAST cylindrical type

These mounted points are exceptionally well suited for cleaning workpieces and for grinding out shrinkage holes. The cylindrical shape ZY is ideal for grinding bores, radii and contours.



Special features:

- Suitable for use on surfaces and edges.
- Combined with high peripheral speeds, very well suited for surface use.
- High grinding performance and good tool life. High stock removal rates thanks to coarse grit size.

S_d [mm]	L_2 [mm]	D [mm]	T [mm]	Grit size	USA type	Opt. RPM	Max. RPM		Item no.	Designation
6.3	40	40	10	60	W 236	22,000	25,000	5	39101671	W 236 6,3 CN 60 KV CAST

For edge grinding on grey and nodular cast iron



CAST EDGE cylindrical type

These mounted points are particularly good for edge grinding, for deburring and grinding out sand inclusions and metal contamination on grey and nodular cast iron. The cylindrical shape ZY is ideal for grinding bores, radii and contours.



Special features:

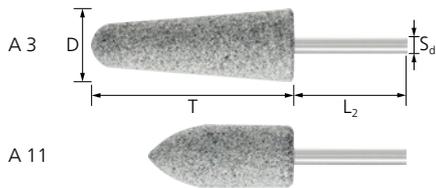
- Highly dimensionally stable due to the high bond content.
- Economical to use due to the high edge stability even on low-speed tool drives.

S_d [mm]	L_2 [mm]	D [mm]	T [mm]	Grit size	Opt. RPM	Max. RPM		Item no.	Designation
6	40	40	20	24	19,000	23,800	5	31330502	ZY 4020 6 CU 24 R5V CAST EDGE



Mounted points

For edge grinding on grey and nodular cast iron



Series A CAST EDGE

These mounted points are particularly good for edge grinding, for deburring and grinding out sand inclusions and metal contamination on a wide range of different contours on grey and nodular cast iron.

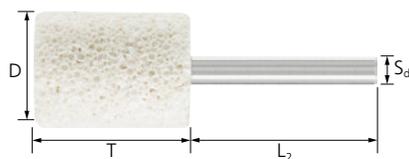


Special features:

- Highly dimensionally stable due to the high bond content.
- Economical to use due to the high edge stability even on low-speed tool drives.

S_d [mm]	L_2 [mm]	USA type	D [mm]	T [mm]	Grit size	Opt. RPM	Max. RPM		Item no.	Designation
6	40	A 3	25	70	30	18,600	18,600	10	35503503	A 3 6 CU 30 R5V CAST EDGE
		A 11	22	50	30	27,600	27,600	10	35511503	A 11 6 CU 30 R5V CAST EDGE

For universal use on plastic



RUBBER, cylindrical type

These mounted points are exceptionally well suited to removing burrs, trimming, weld dressing and roughening of soft plastics and rubber. The cylindrical shape ZY is ideal for grinding radii and contours, and for deburring work.



Special features:

- Open structure and large chip channels due to bubble grain aluminium oxide.
- Machining of temperature-sensitive materials without the addition of coolant thanks to large chip channels.
- High grinding performance.

S_d [mm]	L_2 [mm]	D [mm]	T [mm]	Grit size	Opt. RPM	Max. RPM		Item no.	Designation
6	40	25	32	1	8,000	32,900	10	31135901	ZY 2532 6 AH 1 D12V RUBBER

Grinding discs

General information

Safety notes

- The maximum permitted peripheral speed is 35 m/s.
- For safety reasons, the maximum permitted rotational speed indicated must never be exceeded.
- Before clamping, the grinding tool must be ring tested to make sure that it does not have any cracks (undamaged grinding tools give a clear tone).



Wear eye protection!



Wear hearing protection!



Wear a dust mask!



Wear gloves!



Observe the safety notes!



Do not use if damaged!

The quick way to find the perfect tool

Material group ▼			Design ►	UNIVERSAL	CARBIDE	HSS
Steel	Steels up to 1,200 N/mm ² (< 38 HRC)	Construction steels, carbon steels, tool steels, non-alloyed steels, case-hardened steels, tempering steels		●		○
	Hardened, heat-treated steels over 1,200 N/mm ² (> 38 HRC)	Tool steels, tempering steels, alloyed steels		○	●	●
Stainless steel (INOX)	Rust and acid-resistant steels	Austenitic and ferritic stainless steels		●		
Tungsten carbide	–	–			●	
Non-ferrous metals	Soft non-ferrous metals, non-ferrous metals	Aluminium alloys, brass, copper, zinc		●	○	
	Hard non-ferrous metals	Bronze, titanium, titanium alloys, hard aluminium alloys		○	○	
Other materials	Glass				●	

● = highly suitable ○ = suitable



Grinding discs

Bench grinding wheels



UNIVERSAL version

These bench grinding wheels are ideal for universal use in the workshop. They are suitable for working on steel, cast steel, stainless steel (INOX) and cast iron.

Special features:

- Long tool life, high dimensional stability and high abrasive performance.
- Integrated adapter sleeves for mounting on almost any bench grinder spindle.

D [mm]	Reductions [mm]	T [mm]	H [mm]	Grit size	Max. RPM		Item no.	Designation
Regular aluminium oxide (AN)								
150	1", 3/4", 5/8", 1/2", 25, 20, 16, 13	20	32	24	4,500	1	39008422	BW 15020-32 AN 24 UNIVERSAL
				36	4,500	1	39009708	BW 15020-32 AN 36 UNIVERSAL
				60	4,500	1	39008423	BW 15020-32 AN 60 UNIVERSAL
200	1-1/4", 1", 3/4", 5/8", 1/2", 32, 25, 20, 16	25	51	24	3,350	1	39008440	BW 20025-51 AN 24 UNIVERSAL
				36	3,350	1	39009711	BW 20025-32 AN 36 UNIVERSAL
				60	3,350	1	39008441	BW 20025-51 AN 60 UNIVERSAL



HSS design

These bench grinding wheels are exceptionally well suited for sharpening HSS pilot drills or for working on other high-alloy steels. They are suitable for working on tool steels, case-hardened steels, hardened and coated steels.



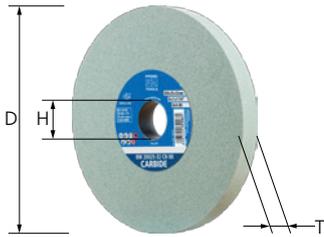
Special features:

- Long tool life, high dimensional stability and high abrasive performance.
- Integrated adapter sleeves for mounting on almost any bench grinder spindle.

D [mm]	Reductions [mm]	T [mm]	H [mm]	Grit size	Max. RPM		Item no.	Designation		
White aluminium oxide (AW)										
150	1", 3/4", 5/8", 1/2", 25, 20, 16, 13	20	32	60	4,500	1	39008424	BW 15020-32 AW 60 HSS		
				80	4,500	1	39009699	BW 15020-32 AW 80 HSS		
200	25, 20, 16	25	32	80	3,350	1	39009702	BW 20025-32 AW 80 HSS		
				1-1/4", 1", 3/4", 5/8", 1/2", 32, 25, 20, 16	51	60	3,350	1	39008442	BW 20025-51 AW 60 HSS
						80	3,350	1	39009703	BW 20025-51 AW 80 HSS

Grinding discs

Bench grinding wheels



CARBIDE design

These bench grinding wheels are used on hard materials, e.g. for sharpening tungsten carbide tools and hardened steels.



Special features:

- Long tool life, high dimensional stability and high abrasive performance.
- Integrated adapter sleeves for mounting on almost any bench grinder spindle.

D [mm]	Reductions [mm]	T [mm]	H [mm]	Grit size	Max. RPM		Item no.	Designation
Silicon carbide (CN)								
150	1", 3/4", 5/8", 1/2", 25, 20, 16, 13	20	32	60	4,500	1	39008570	BW 15020-32 CN 60 CARBIDE
				80	4,500	1	39009724	BW 15020-32 CN 80 CARBIDE
				120	4,500	1	39008425	BW 15020-32 CN 120 CARBIDE
200	25, 20, 16	25	32	80	3,350	1	39008490	BW 20025-32 CN 80 CARBIDE
				51	120	3,350	1	39008443



Grinding tool with threaded insert

Grinding tool with threaded insert



Grinding tool with threaded insert, silicon carbide SiC

Grinding tools with a threaded insert are manufactured from silicon carbide SiC with a high-quality resinoid bond. Due to the easy-to-break-down silicon carbide, the products have a high stock removal rate and good tool life.



Special features:

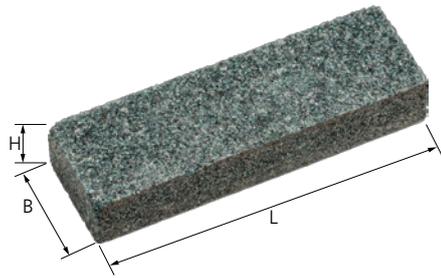
- High stock removal rate.
- High level of edge and dimensional stability.
- Thanks to the cool grinding, the thermal load on the workpiece is reduced.

3

D [mm]	T [mm]	Grit size	Thread	Opt. RPM	Max. RPM		Item no.	Designation
40	63	16	M12	24,000	24,100	25	39008004	ZY 4063 M12 CU 16 QB INOX EDGE

Accessories for mounted points and grinding discs

Hand dressers



Dressing stone for profiling and dressing work

The dressing stones are suitable for profiling grinding points and Poliflex mounted points.

Special features:

- For profiling and dressing smaller mounted points.

L [mm]	B [mm]	H [mm]		Item no.	Designation
70	12	22	5	33899045	SE 702212 CU 46 M 5 V

3

