

Tool and
die industry

SWATYCOMET CBN-V



CBN Vitrified bonded wheels
for grinding the most complex
tool parts



NEW GENERATION
PRODUCTS

SWATYCOMET

CBN-V



Advantages:

- Reduced machining costs.
- Effective grinding of the most difficult materials for tool production.
- Minimal number of dressing cycles.
- Shorter grinding times.
- Lower grinding forces.

Applications:

Grinding of high alloy tool parts (for machining plastic) with hardnesses of up to 70 HRC.

Steel grades:

- OCR12 VM
- Titanium alloys
- K340
- V2000
- V10
- M330
- INCONEL



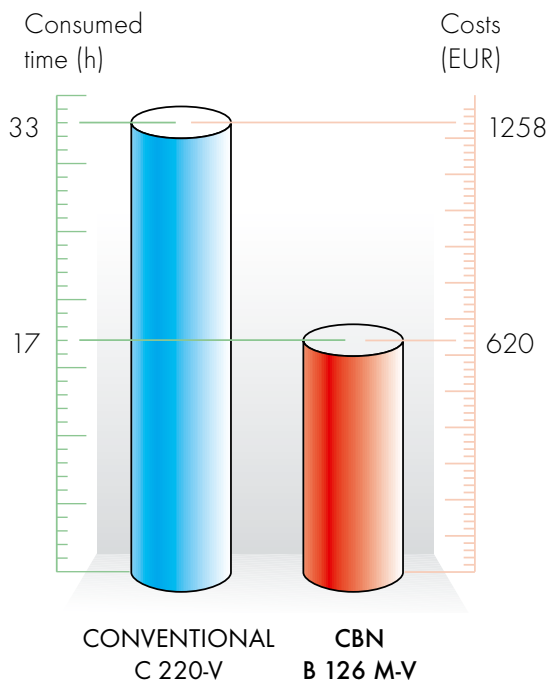
Example:

Grinding type: **External cylindrical**

Grinding wheel dimensions: **400 x 25 x 6 x 127**

Grinding wheel composition: **B126 M6V3 C100**

Machined material: **Vanadis 10 SC**



The comparative calculation was done for 100 units.

Recommendations:

- Internal grinding: **B126 J7V1 C100**
- External grinding: **B126 M6V3 C100**
- Flat grinding: **B126 M6V3 C100**
- Coordinate grinding: **B126 K6V1 C100**

Dimensions:

- Continuous rim type for diameters from 3mm to 400mm.
- Segmental rim type for diameters 450mm and 500mm.