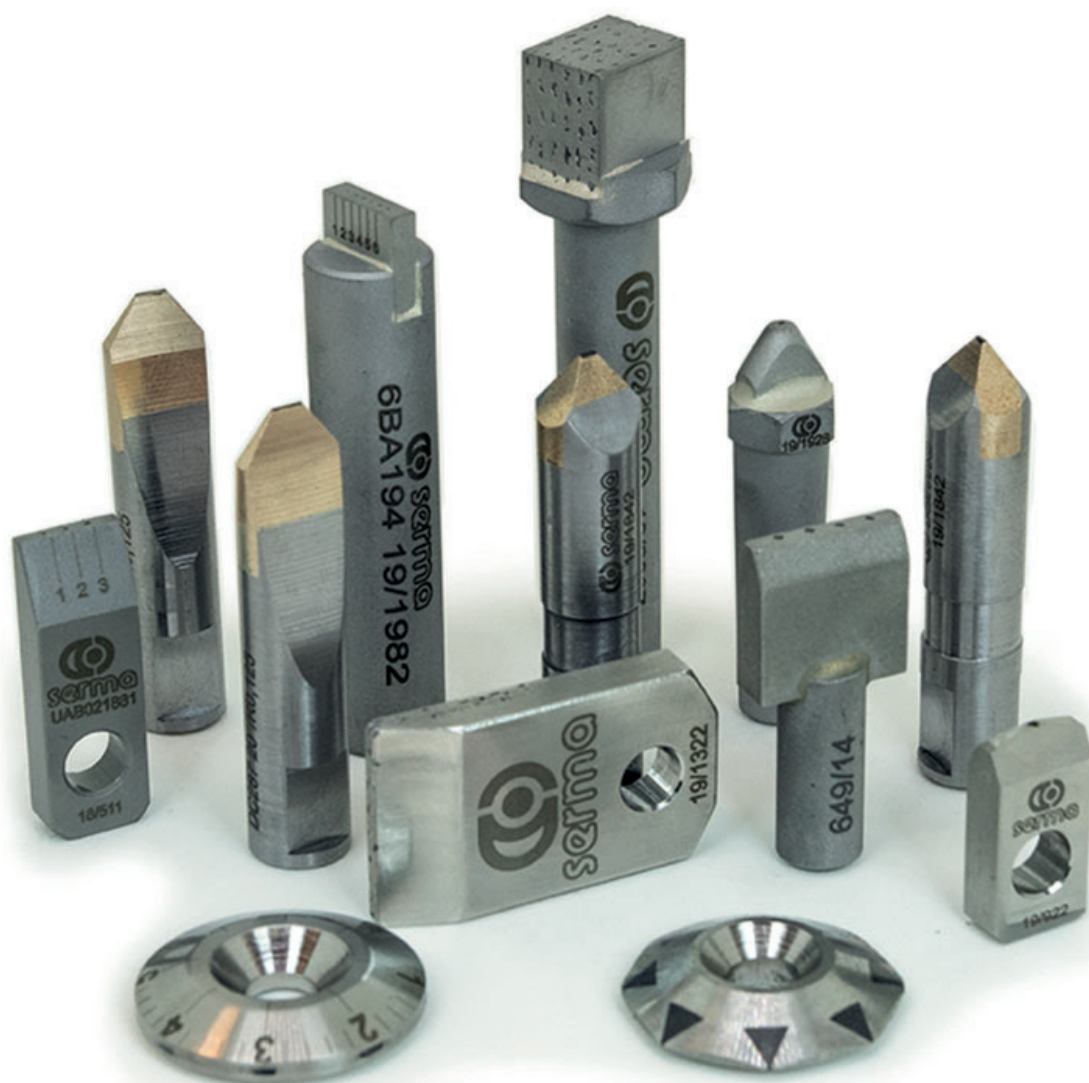
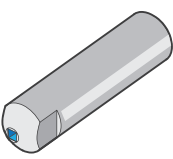
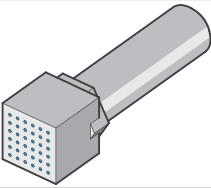
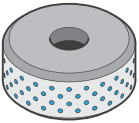
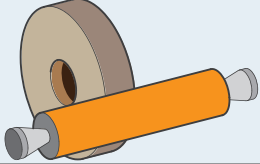
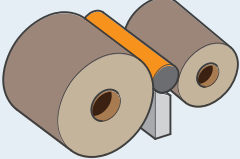
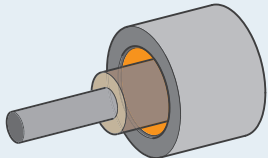
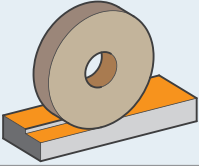
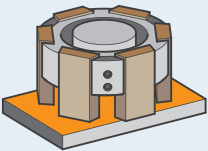
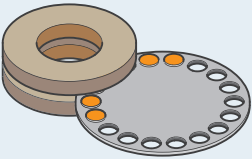
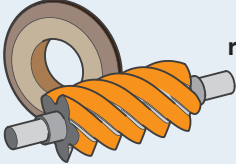
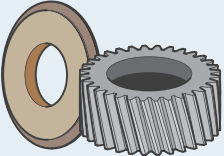
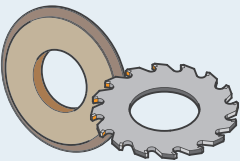
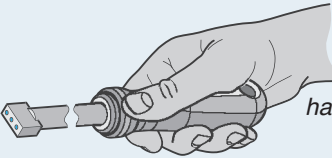


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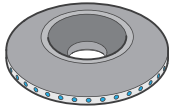
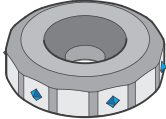
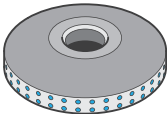
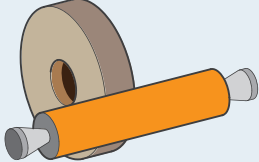
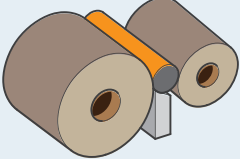
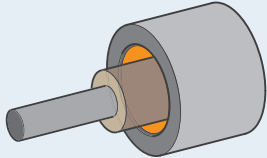
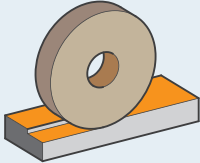
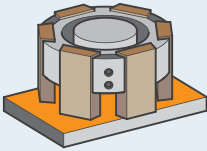
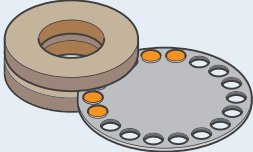
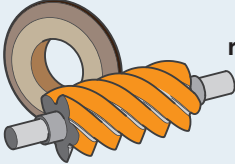
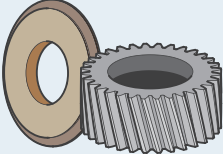
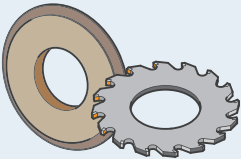
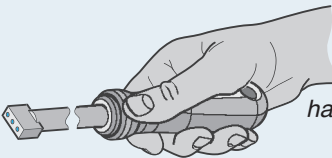


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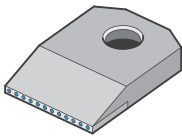
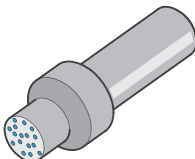
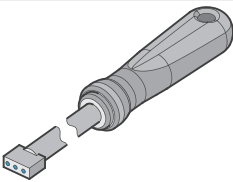
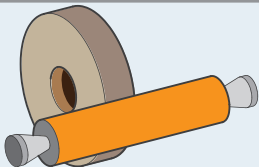
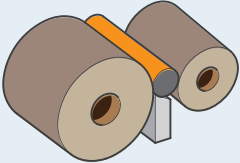
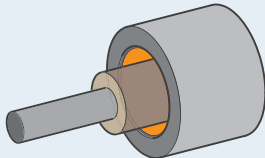
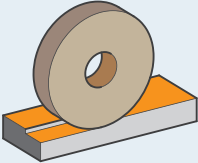
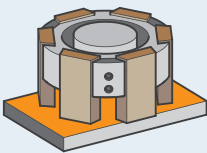
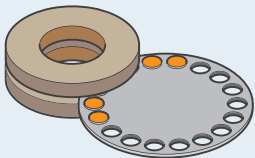
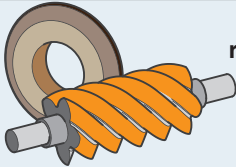
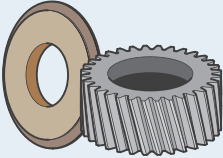
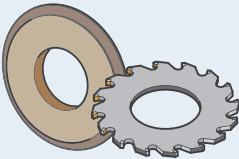
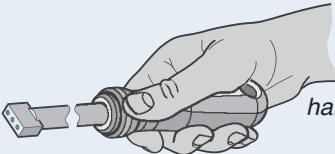
adeguato / fair	★ ★ ★ ☆ ☆ ☆
buono / good	★ ★ ★ ★ ☆ ☆
migliore / better	★ ★ ★ ★ ★ ☆
eccellente / best	★ ★ ★ ★ ★ ★

		tipo NS	tipo 1	tipo 2
				
		diamante singolo single point	multiplo frontale flat multiple diamond	multiplo periferico multiple diamond
	rettifica in tondo esterna o.d. grinding	diamantatura rettilinea straight dressing		
		★ ★ ★ ★ ★ ★	★ ★ ★ ★ ☆ ☆	★ ★ ★ ★ ☆ ☆
		☆ ☆ ☆ ☆ ☆ ☆	☆ ☆ ☆ ☆ ☆ ☆	☆ ☆ ☆ ☆ ☆ ☆
	rettifica senza centri centerless grinding	per mola operatrice for grinding wheel		
		★ ★ ★ ★ ★ ★	★ ★ ★ ★ ☆ ☆	★ ★ ★ ★ ★ ☆
		★ ★ ★ ★ ★ ☆	☆ ☆ ☆ ☆ ☆ ☆	★ ★ ★ ★ ★ ★
	rettifica interna i.d. grinding			
		★ ★ ★ ★ ★ ★	☆ ☆ ☆ ☆ ☆ ☆	★ ★ ★ ★ ★ ☆ solo agglomerato
	rettifica in piano tangenziale tangential surface grinding	diamantatura rettilinea straight dressing		
		★ ★ ★ ★ ★ ☆	★ ★ ☆ ☆ ☆ ☆	★ ★ ★ ★ ☆ ☆
		☆ ☆ ☆ ☆ ☆ ☆	☆ ☆ ☆ ☆ ☆ ☆	☆ ☆ ☆ ☆ ☆ ☆
	rettifica piana con tazze o settori vertical surface grinding			
		☆ ☆ ☆ ☆ ☆ ☆	★ ★ ★ ★ ★ ★	☆ ☆ ☆ ☆ ☆ ☆
	rettifica con mole contrapposte disc grinding			
		★ ★ ★ ★ ★ ☆	★ ★ ★ ★ ★ ★	☆ ☆ ☆ ☆ ☆ ☆
	rettifica viti e filetti worm and screw grinding	mola a profilo singolo single V profile		
		★ ★ ★ ★ ★ ☆	☆ ☆ ☆ ☆ ☆ ☆	☆ ☆ ☆ ☆ ☆ ☆
	rettifica ingranaggi gear grinding	mola a profilo singolo single V profile		
		★ ★ ★ ★ ★ ★	☆ ☆ ☆ ☆ ☆ ☆	☆ ☆ ☆ ☆ ☆ ☆
	affilatura sharpening	affilatrici universali per seghe, creatori, ecc. tool grinders, saw and hobs sharpening machine		
		★ ★ ★ ★ ★ ★	☆ ☆ ☆ ☆ ☆ ☆	☆ ☆ ☆ ☆ ☆ ☆
	uso manuale hand dressing			
		★ ★ ★ ★ ★ ★	☆ ☆ ☆ ☆ ☆ ☆	☆ ☆ ☆ ☆ ☆ ☆

adeguato / fair	★ ★ ★ ☆ ☆ ☆
buono / good	★ ★ ★ ★ ☆ ☆
migliore / better	★ ★ ★ ★ ★ ☆
eccellente / best	★ ★ ★ ★ ★ ★

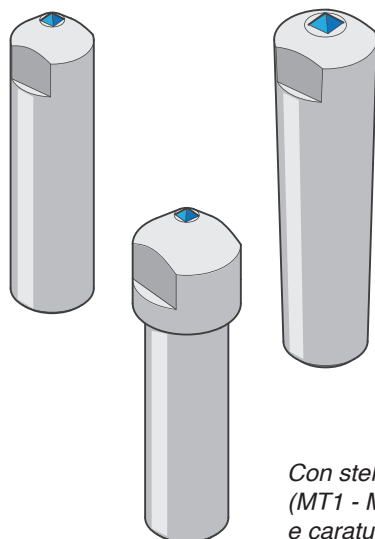
		tipo 3	tipo 4	tipo 5
				
		multiplo periferico multiple diamond	multiplo periferico multiple diamond	multiplo periferico multiple diamond
	rettifica in tondo esterna o.d. grinding	diamantatura rettilinea straight dressing	★ ★ ★ ★ ★ ★	☆☆☆☆☆☆
		profilatura profiling	★ ★ ★ ★ ★ ★	☆☆☆☆☆☆
	rettifica senza centri centerless grinding	per mola operatrice for grinding wheel	☆☆☆☆☆☆	☆☆☆☆☆☆
		per rullo conduttore for regulating wheel	☆☆☆☆☆☆	☆☆☆☆☆☆
	rettifica interna i.d. grinding		☆☆☆☆☆☆	★ ★ ★ ★ ★ ★
	rettifica in piano tangenziale tangential surface grinding	diamantatura rettilinea straight dressing	★ ★ ★ ★ ★ ☆	☆☆☆☆☆☆
		profilatura profiling	★ ★ ★ ★ ★ ★	☆☆☆☆☆☆
	rettifica piana con tazze o settori vertical surface grinding		☆☆☆☆☆☆	☆☆☆☆☆☆
	rettifica con mole contrapposte disc grinding		☆☆☆☆☆☆	☆☆☆☆☆☆
	rettifica viti e filetti worm and screw grinding	mola a profilo singolo single V profile	☆☆☆☆☆☆	☆☆☆☆☆☆
	rettifica ingranaggi gear grinding	mola a profilo singolo single V profile	☆☆☆☆☆☆	☆☆☆☆☆☆
	affilatura sharpening	affilatrici universali per seghe, creatori, ecc. tool grinders, saw and hobs sharpening machine	☆☆☆☆☆☆	☆☆☆☆☆☆
	uso manuale hand dressing		☆☆☆☆☆☆	☆☆☆☆☆☆

adeguato / fair	★★★★☆
buono / good	★★★★☆
migliore / better	★★★★★
eccellente / best	★★★★★

		tipo 6	tipo 7	tipo RM
				
		multiplo frontale multiple diamond	multiplo frontale multiple diamond	multiplo periferico multiple diamond
	rettifica in tondo esterna o.d. grinding	★★★★★★	★★★★★	☆☆☆☆☆
	profilatura profiling	★★★★★★	☆☆☆☆☆	☆☆☆☆☆
	rettifica senza centri centerless grinding	★★★★★	★★★★★	☆☆☆☆☆
	per mola operatrice for grinding wheel per rullo conduttore for regulating wheel	☆☆☆☆☆	☆☆☆☆☆	☆☆☆☆☆
	rettifica interna i.d. grinding	☆☆☆☆☆	☆☆☆☆☆	☆☆☆☆☆
	rettifica in piano tangenziale tangential surface grinding	★★★★★★	★★★★☆	☆☆☆☆☆
	profilatura profiling	★★★★★★	☆☆☆☆☆	☆☆☆☆☆
	rettifica piana con tazze o settori vertical surface grinding	☆☆☆☆☆	★★★★★	☆☆☆☆☆
	rettifica con mole contrapposte disc grinding	☆☆☆☆☆	★★★★★	☆☆☆☆☆
	rettifica viti e filetti worm and screw grinding	☆☆☆☆☆	★★★★★	☆☆☆☆☆
	rettifica ingranaggi gear grinding	☆☆☆☆☆	☆☆☆☆☆	☆☆☆☆☆
	affilatura sharpening	☆☆☆☆☆	★★★★★	★★★★★
	uso manuale hand dressing	☆☆☆☆☆	☆☆☆☆☆	★★★★★

TIPO NS - Singolo

Diamante naturale singolo



Qualità

				PEC - economica
				P10 - standard
				P20 - buona
				P30 - extra

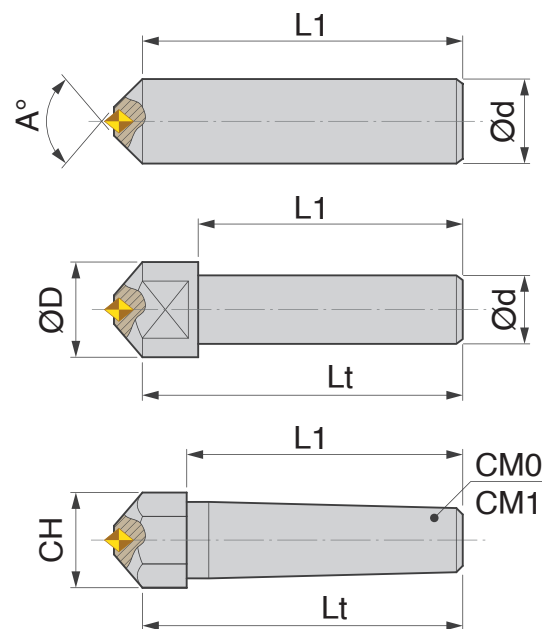
Caratura

	kt 0,25		kt 1,25
	kt 0,50		kt 1,50
	kt 0,75		kt 1,75
	kt 1,00		kt 2,00

Stelo

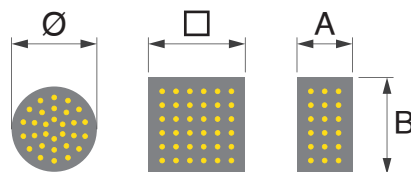
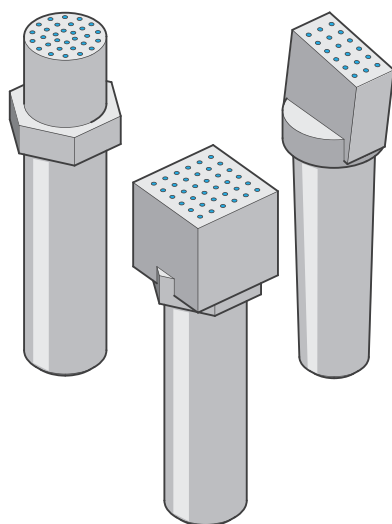
Ød	L1
8	10
10	15
12	20
15	30
20	40
25	50
30	60

Con stelo cilindrico oppure con morse (MT1 - MT0). Disponibili in diverse qualità e caratura.



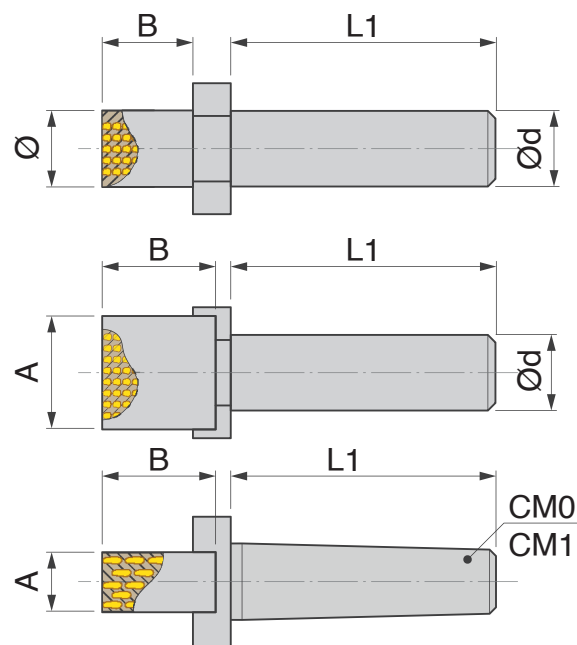
TIPO 1 - Quadro

Multiplo frontale a pietre disposte



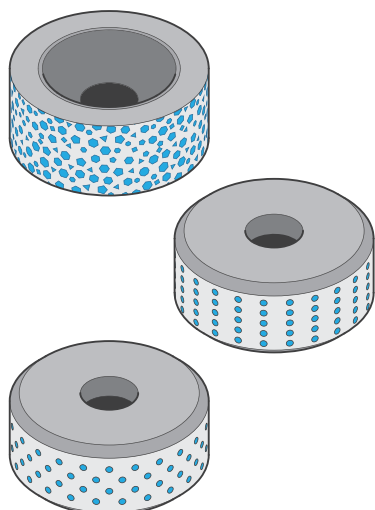
Ø	Ø	□	A x B
CM0	6	10	8 x 15
CM1	10	12	8,5 x 17,5
8	12	15	10 x 15
10	15	20	10 x 20
12	18	24	10 x 30
15	21	-	10 x 33
20	25	-	15 x 20
25	30	-	15 x 30
30	35	-	20 x 33

Steli speciali a richiesta

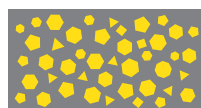


TIPO 2 - Rotella

Rotella a file multiple o granulato



Disposizione



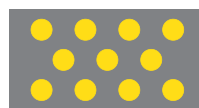
SK

granulato



AL

file allineate

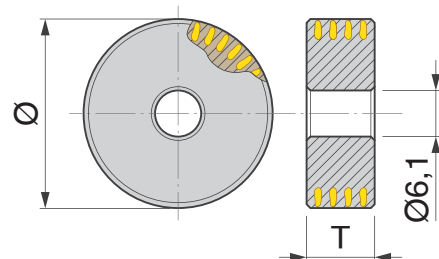
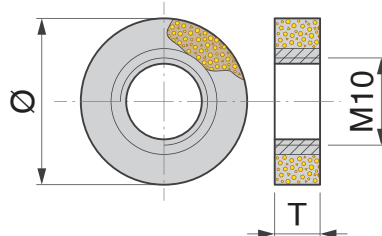


SF

file sfalsate

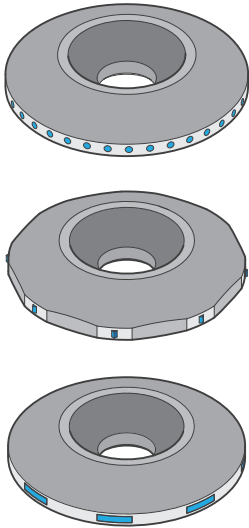
Ø
12
15
18
20
21
22
25
30

Dimensioni



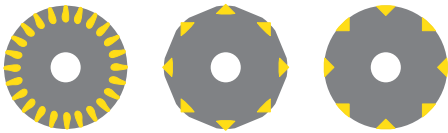
TIPO 3 - Rotella

Rotella a 1 fila di pietre



Dimensioni	Ø
	12
	15
	18
	21
	22
	25
	30
	35

Disposizione



S

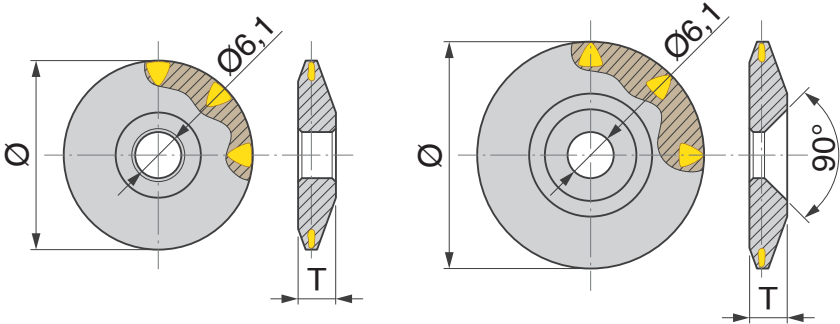
singole

P

a punta

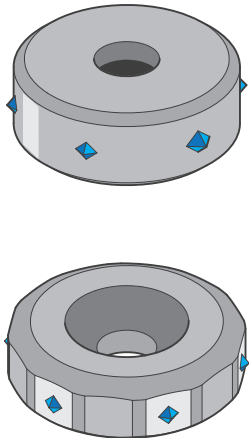
C

di costa



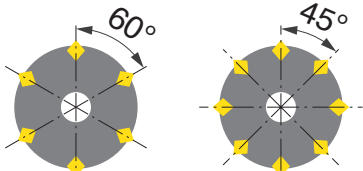
TIPO 4 - Rotella

Rotella a punte singole tipo dresser



Dimensioni	Ø
	12
	15
	18
	21
	22
	25
	30
	35

Disposizione

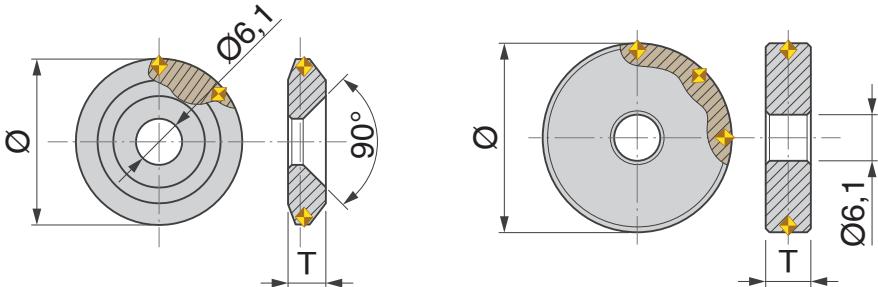


6

pietre

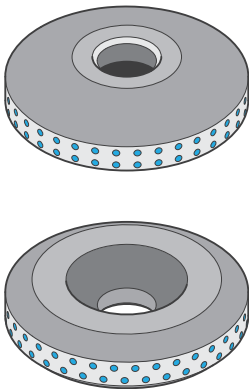
8

pietre



TIPO 5 - Rotella

Rotella a 2 file di pietre



Dimensioni	Ø
	12
	15
	18
	21
	22
	25
	30
	35

Disposizione

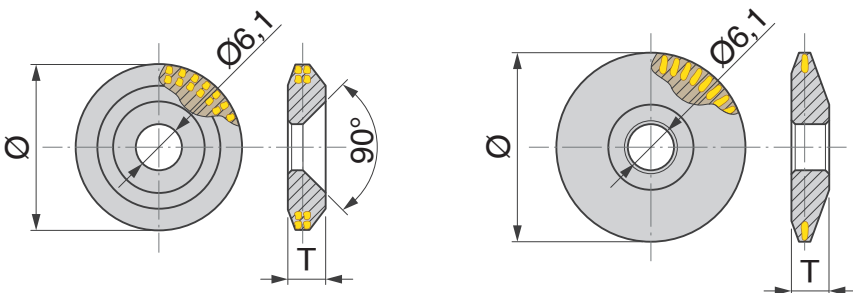


AL

file allineate

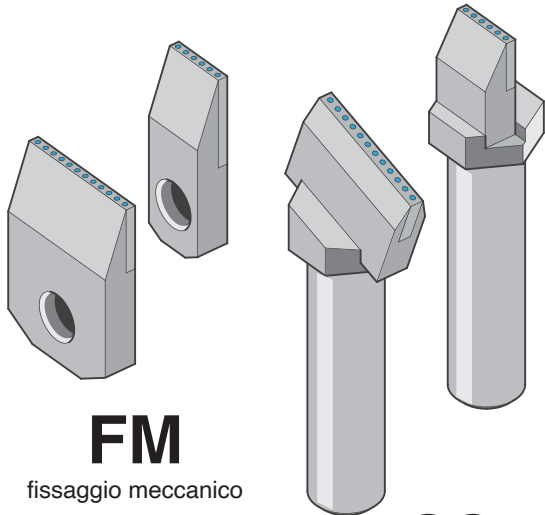
SF

file sfalsate



TIPO 6 - Placchetta / Scalpello

Multiplo frontale a pietre disposte



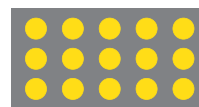
FM
fissaggio meccanico

SS
saldata su stelo

W	T
10	25
10	28
10	30
10	33
10	35
20	25
20	28
20	30
20	33
20	35

Dimensioni

Disposizione

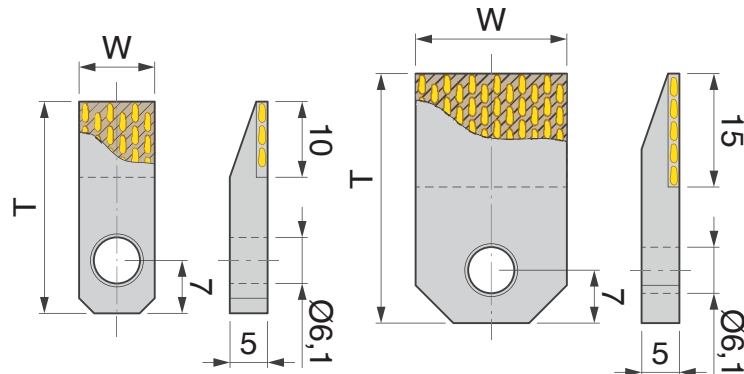


AL

file allineate

SF

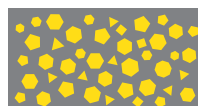
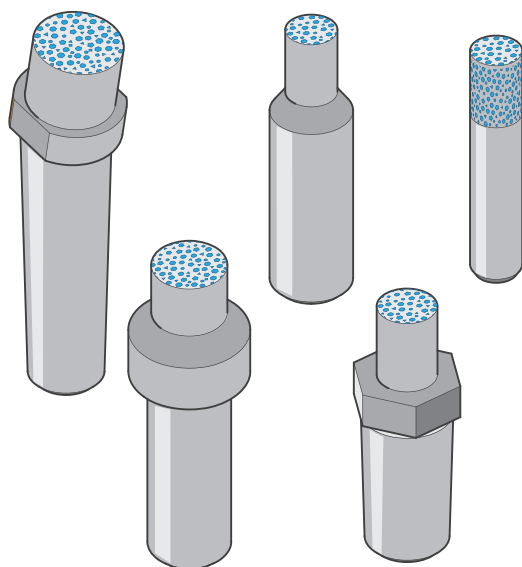
file sfalsate



Leganti disponibili: F16 - tenero; F17 - standard; FHM - duro

TIPO 7 - Granulato

Utensile in grana diamantata



SK

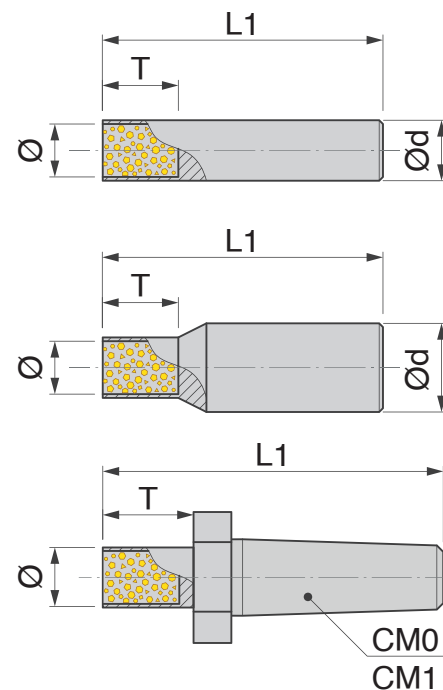
granulato

Ø
6
7
9
10
12
15

Dimensioni

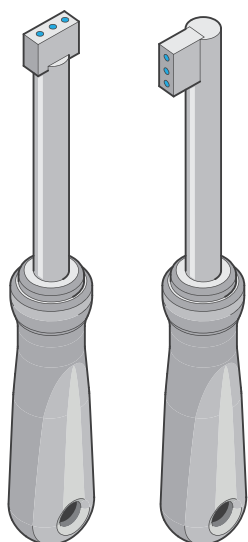
Grana

Sigla	FEPA
G01	D1181
G02	D1001
G2+	D711
G03	D601
G04	D501
G05	D426
G06	D301
G07	D251
G08	D181



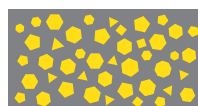
TIPO RM - Manuale

Utensile con manico per impiego manuale



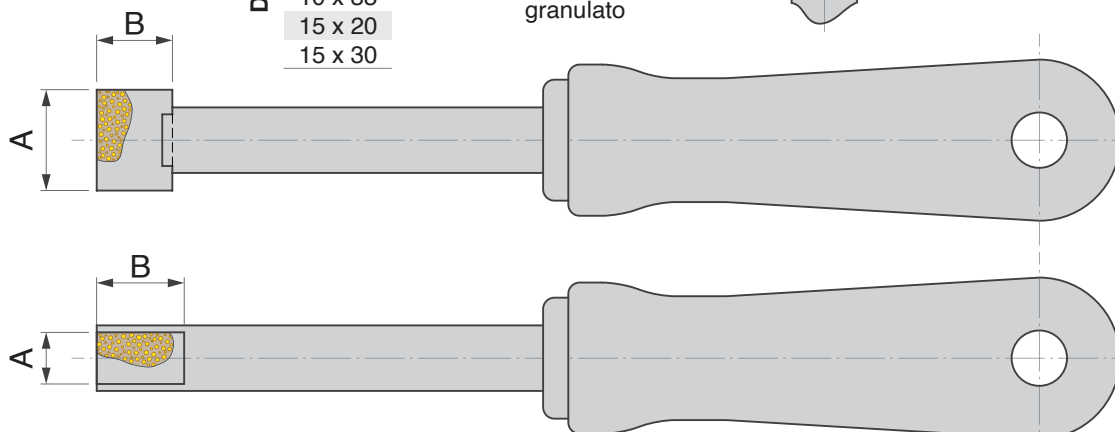
A x B
8 x 15
8,5 x 17,5
10 x 15
10 x 20
10 x 30
10 x 33
15 x 20
15 x 30

Dimensioni



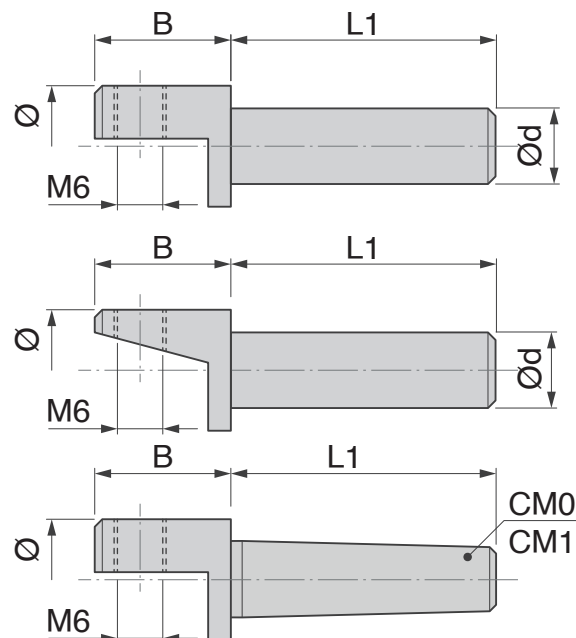
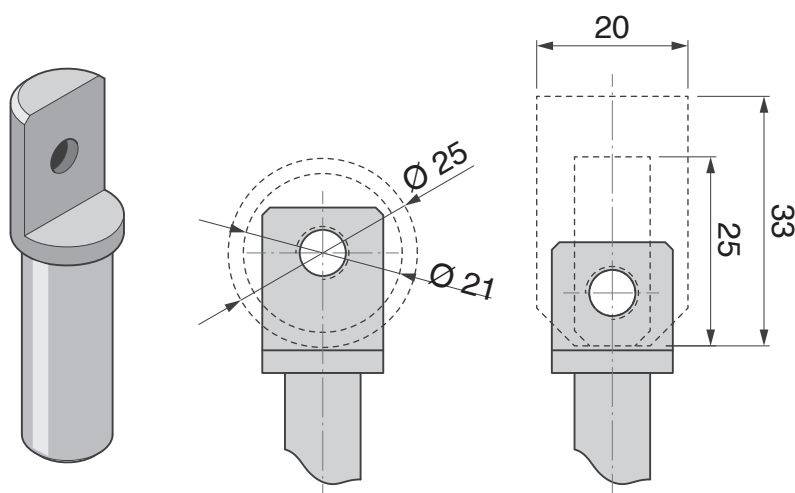
SK

granulato

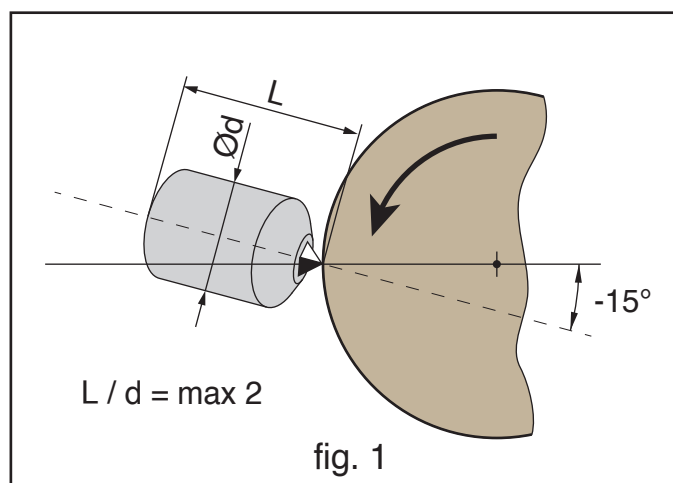


STELI

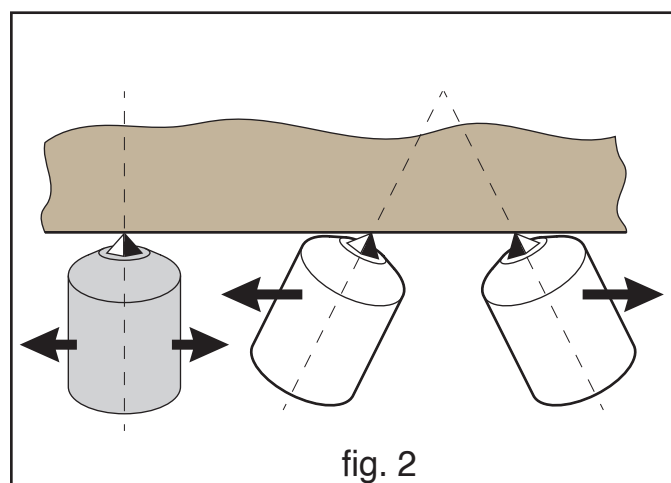
Per rotelle o placchette



Norme di impiego
per utensili in diamante
monocristallo naturale grezzo



Application guidelines for single
point diamond tools



bloccare fermamente l'utensile
nel dispositivo portadiamante

limitare lo sbalzo (fig. 1)

contatto sulla mola in corrispondenza
della linea centri mola pezzo (fig. 1)

la punta del diamante deve essere
rivolta nel senso di rotazione mola (fig. 1)

addurre il refrigerante prima del contatto
con la mola, al centro della sua fascia

incrementare radialmente il diamante
non più di 0,02 mm ogni passata

se il dispositivo di bloccaggio prevede una
inclinazione anche lateralmente effettuare gli
incrementi radiali solo nel senso in cui il diamante
non opera contro la punta (fig. 2)

1

steadily clamp the tool-shank
into the holder

2

shorten overhang (fig. 1)

3

contact the grinding wheel in correspondence
of wheel-workpiece centerline (fig. 1)

4

the point of diamond must be tilted to the direction
of grinding wheel revolution (fig. 1)

5

right before the start and throughout the dressing
operation, the tool should be flushed with an
abundant supply of coolant

6

depth of cut should be not higher
than 0,02 mm per pass

7

if the diamond tool is also tilted on right or left
side, avoid to feed it when the pass is to the same
direction of the tilted point (fig. 2)



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