

MOLE DIAMANTATE e CBN



TECNOLOGIA

QUALITA'

SERVIZIO



DIAWA ABRASIVI



Mole diamantate (colore giallo) e Cbn (colore rosso) in agglomerante resinoidi sviluppate per fabbricanti e affilatori di utensili in metallo duro e acciai impiegati nel mercato del legno e suoi derivati.

Asportazione per passata e Rugosità

| OPERAZIONE | asportazione | DIAMANTE | | CBN | |
|--------------------|--------------|--------------|------------|--------------|-------------|
| | | asportazione | rugosità | asportazione | rugosità |
| Sgrossatura (DB) | Alta | 0,10 | 0,5 a 1,0 | 0,15 | 0,8 a 1,2 |
| Semi-finitura (SA) | Média | 0,05 | 0,3 a 0,6 | 0,075 | 0,6 a 0,9 |
| Finitura (AC) | Baixa / Baja | 0,025 | 0,15 a 0,4 | 0,035 | 0,35 a 0,75 |

✓ L'asportazione per passata (mm) è quella suggerita per ottenere una maggior durata della mola.

✓ La rugosità è in scala Ra

Velocità d'uso

| diametro della mola (mm) | Velocità periferica della mola (m/s) | | | | | | |
|--------------------------|--------------------------------------|----------|------------------|----------|-------------|----------|------|
| | 18 (m/s) | 23 (m/s) | 25 (m/s) | 33 (m/s) | 36 (m/s) | 46 (m/s) | 50 |
| | Diamante/Cbn a secco | | Diamante a umido | | Cbn a umido | | Max |
| 75 | 4,6 | 5,8 | 6,4 | 8,4 | 9,1 | 11,7 | 12,7 |
| 100 | 3,4 | 4,4 | 4,8 | 6,3 | 6,8 | 8,8 | 9,5 |
| 125 | 2,8 | 3,5 | 3,8 | 5,0 | 5,5 | 7,0 | 7,6 |
| 150 | 2,3 | 2,9 | 3,2 | 4,2 | 4,6 | 5,8 | 6,3 |
| 175 | 1,9 | 2,5 | 2,7 | 3,6 | 3,9 | 5,0 | 5,5 |
| 200 | 1,7 | 2,2 | 2,4 | 3,1 | 3,4 | 4,4 | 4,7 |

Rotazione della mola in g/min (x 1000)

✓ Si raccomanda di lavorare sempre a umido per evitare l'eccessivo riscaldamento delle mole.

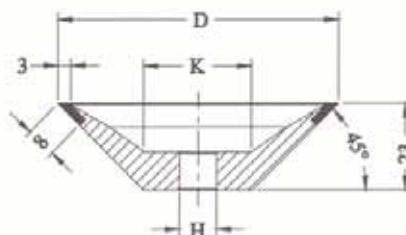
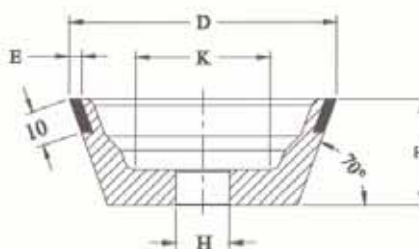
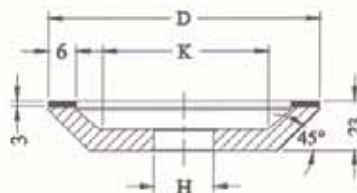
✓ La velocità periferica massima consentita è di 50 m/s

MOLE A TAZZA CONICA

| Tipo 12A2 45° | | | |
|---------------|---|---|----|
| D | B | E | K |
| 75 | | | 35 |
| 100 | 6 | 3 | 60 |
| 125 | | | 85 |

| Tipo 11V9 70° | | | | |
|---------------|----|-----|----|----|
| D | B | E | T | K |
| 100 (95) | | 2-3 | 35 | 50 |
| 125 | 10 | 3 | 40 | 70 |

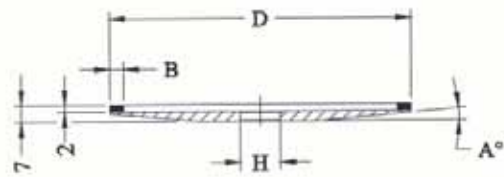
| Tipo 12V9 45° | | | |
|---------------|---|---|----|
| D | B | E | K |
| 100 | | | 53 |
| 125 | 8 | 3 | 78 |



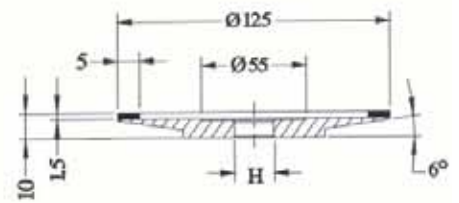
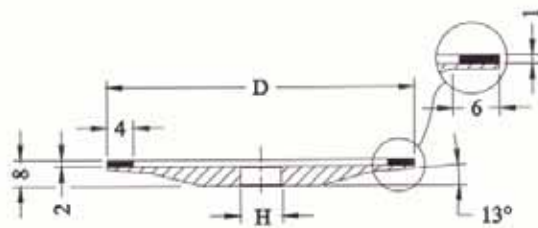
MOLE SERIE 500/550

Particolarmente indicate su seghe circolari ad alto numero di denti, ove il passo e l'angolo d'entrata sono piccoli.

| Tipo 4A2P S500 | | | |
|----------------|-------|---|----|
| D | B | E | A° |
| 100 | 3 - 4 | 2 | 8 |
| 125 | 4 | | 7 |
| 150 | | | 6 |

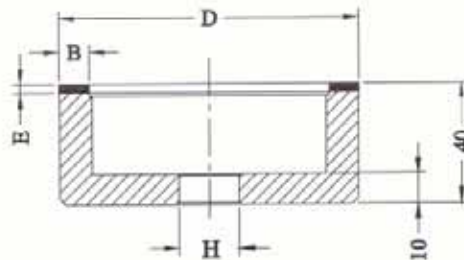


| Tipo 4A2P S550 | | | |
|----------------|---|-------|----|
| D | B | E | T |
| 125 | 4 | 2 - 1 | 8 |
| 150 | 5 | 1,5 | 10 |
| 125 | | | |



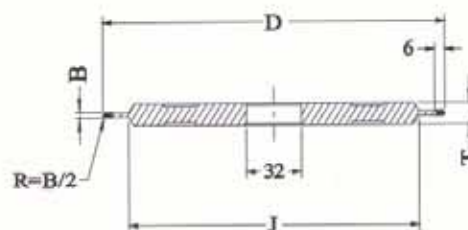
MOLE PER COLTELLI LINEARI

| Tipo 6A2 Facas | | | |
|----------------|--------|-------|----|
| D | B | E | T |
| 100 | 6 | 3 | 40 |
| 125 | 6 - 10 | 3 - 5 | |
| 150 | 10 | | |
| 200 | | | |

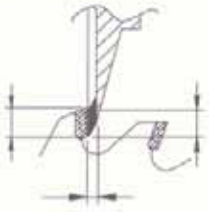


MOLE PER SEGHE CIRCOLARI HSS

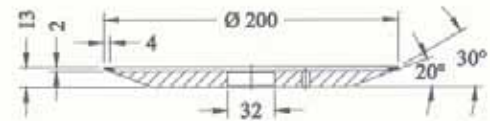
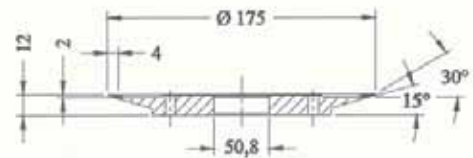
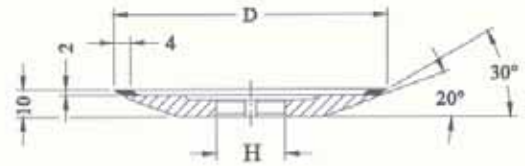
| Tipo 14F1 S700 | | | | |
|----------------|---------|---|-----|---|
| D | B | E | J | T |
| 200 | 2 - 2,5 | 6 | 170 | 8 |



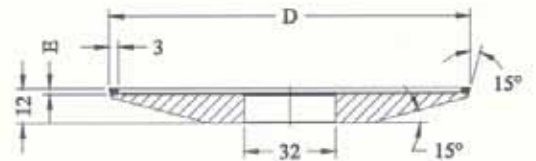
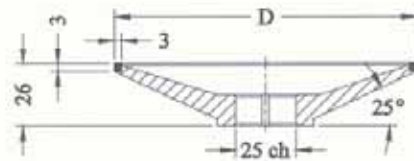
Affilatura del petto



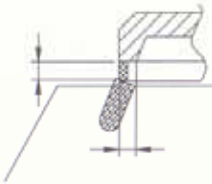
| Tipo 12V2 S700 | | | |
|----------------|---|---|----|
| D | B | E | T |
| 100 | 4 | 2 | 10 |
| 125 | | | 12 |
| 175 | | | 12 |
| 200 | | | 13 |



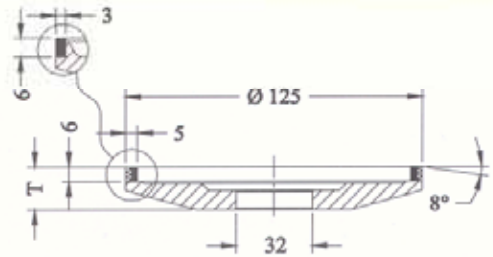
| Tipo 4B9 S700 | | | |
|---------------|---|-----|----|
| D | B | E | T |
| 125 | 3 | 3 | 26 |
| | | 2-4 | 12 |



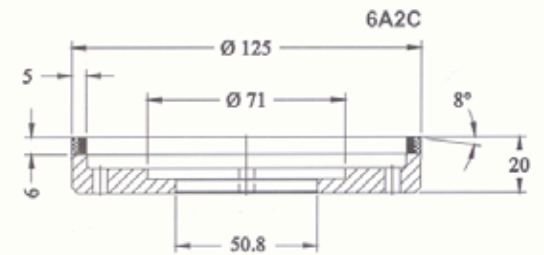
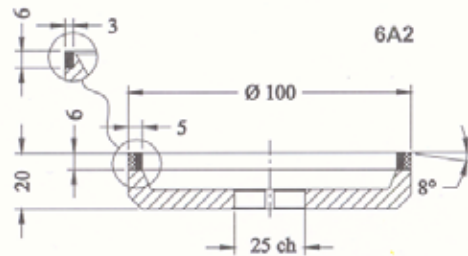
Affilatura del dorso



| Tipo 4A2 S700 | | | |
|---------------|-------|---|----|
| D | B | E | T |
| 125 | 3 - 5 | 6 | 18 |



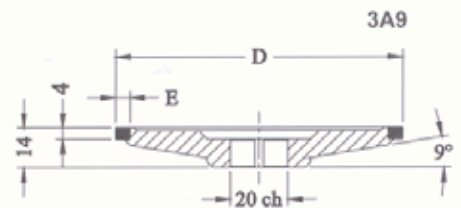
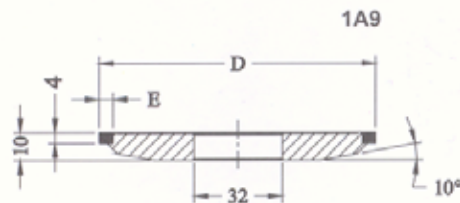
| Tipo 6A2 / 6A2C S700 | | | |
|----------------------|-------|---|----|
| D | B | E | T |
| 100 | 3 - 5 | 6 | 20 |
| 125 | | | |



Affilatura dei fianchi



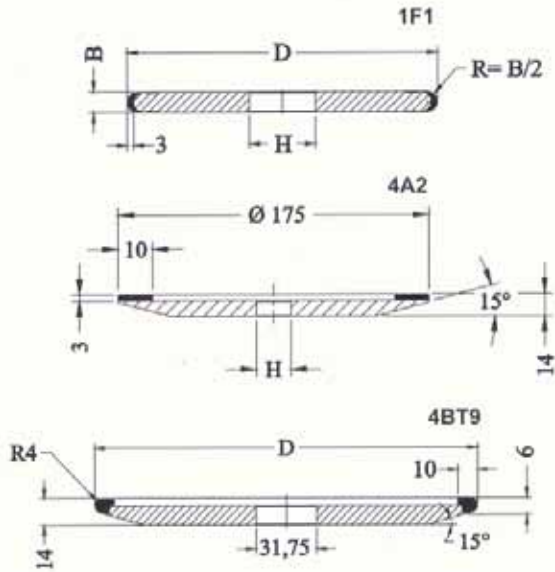
| Tipo 1A9 / 3A9 S700 | | |
|---------------------|-------|---|
| D | E | B |
| 80 | 5 | 4 |
| 100 | 5 - 7 | |



MOLE SERIE 900

Indicate per l'affilatura di "fingers"

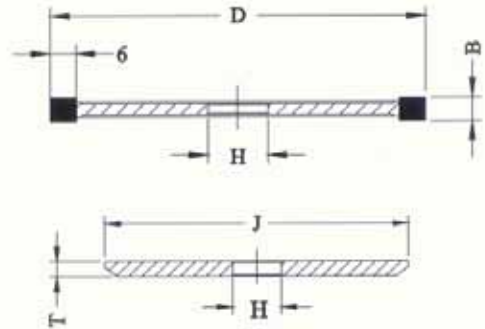
| FINGERS - S900 | | | |
|----------------|-----|----|---|
| TIPO | D | B | E |
| 1F1 | 150 | 10 | 3 |
| | 200 | 12 | |
| 4A2 (15°) | 175 | 10 | 3 |
| 4BT9 | 175 | 10 | 6 |
| | 200 | | |



DISCHI DA TAGLIO PER METALLO DURO e HSS



| DISCHI DA TAGLIO - 1A1R | | | | |
|-------------------------|-----|---|--------|---|
| D | B | E | Flange | |
| | | | J | T |
| 100 | 1,2 | 6 | 85 | 4 |
| 125 | | | | |
| 150 | 1,4 | | | |
| 200 | 2,0 | | | |



Utensili diamantati per la ravnatura di mole AL203 e SiC.



Sistema de Gestão da Qualidade
ISO 9001



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