

IZBOR KONCENTRACIJE

Kvalitet tj. postojanost jedne brusne ploče jednim većim delom zavisi od koncentracije dijamanta - kubičnog bor nitrida u istoj. Određuje se prema volumenu brusne površine, što znači po 1 cm³ ide 100 % = 4,4 ct

Koncentracije	Karat ct/cm ³
25%	1,1
50	2,2
75	3,3
100	4,4
125	5,5
150	6,6

ŠTA SE BRUSI - SEČE SA DIJAMANTOM

Widija, keramika, spec. legure, poliester, kamen i ostali nemetali

VEZIVNO SREDSTVO

U takozvanoj vezi od veštačkih smola postoji u više kvaliteta.

J= mekano
N= srednje
R= tvrdo
S=vrlo tvrdo

KAKO SE NARUČUJE

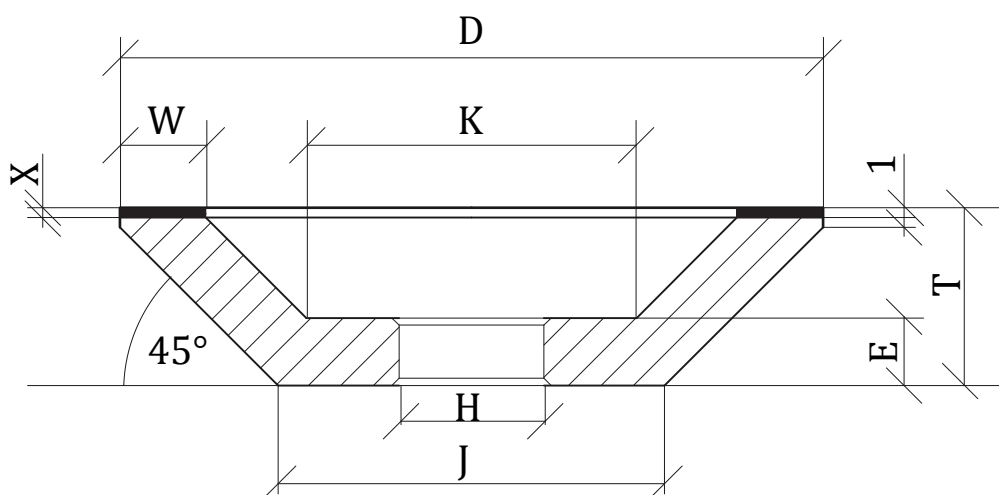
12A2/45*150x10x3x20D91 BR100W

W = mokro brušenje
D = suvo brušenje

ŠTA SE BRUSI - SEČE SA CBN-om

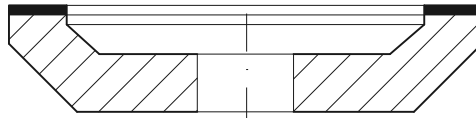
Sve vrste brzorezanih čelika, bakra i AL legura

NAPOMENA: PORED STANDARDIZOVANIH TIPOVA TOCILA IZ KATALOGA, PROIZVODIMO I ONA PO VAŠOJ NARUDŽBINI I SPECIFIKACIJAMA!

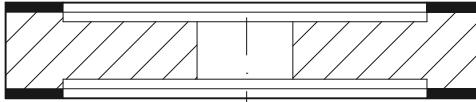


Precnik(mm)	10m/sec	12m/sec	16m/sec	18m/sec	20m/sec	22m/sec	25m/sec	30m/sec
5								
10	19108	22930	30950					
15	12740	15300	20390	22900	25500	28000		
20	9550	9200	15280	17200	19100	21000	23880	28600
25	7700	9200	12250	13800	15300	16850	19100	23000
50	3820	4580	6100	6870	7650	8400	9550	11450
75	2550	3060	4080	4580	5100	5600	6380	7650
100	1910	2290	3060	3440	3825	4200	4775	5730
125	1530	1830	2440	2750	3050	3355	3800	4600
150	1290	1530	2020	2290	2550	2800	3200	3800
200	955	1145	1530	1720	1910	2120	2390	2875
250	760	920	1225	1380	1525	1685	1910	2300
300	640	765	1020	1145	1275	1400	1590	1900
350	550	655	870	980	1090	1200	1360	1640
400	480	570	760	860	960	1050	1190	1450

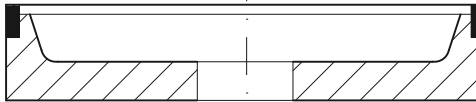
12 A 2
S = 45°



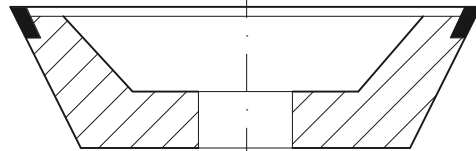
9 A 3



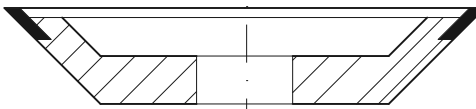
6 A 9



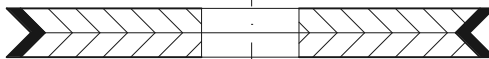
11 V 9



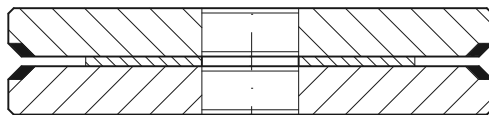
12 V 9



1 EE 1 V



1 V 9



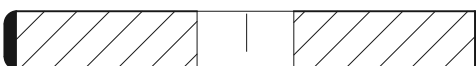
1 V 1



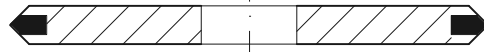
14 A 1



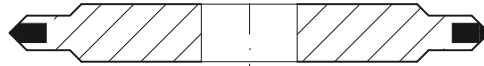
1 L 1



1 E 6 Q



14 E 6 Q



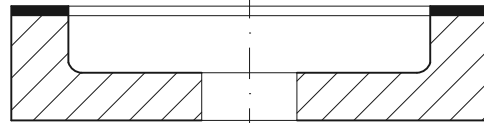
14 E E 1



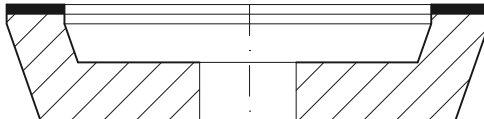
1 F F 1



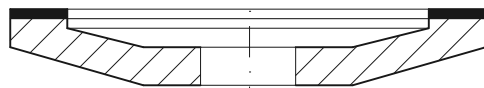
6 A 2



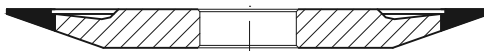
11 A 2



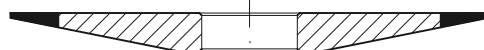
12 A 2
 $S = 20^\circ$

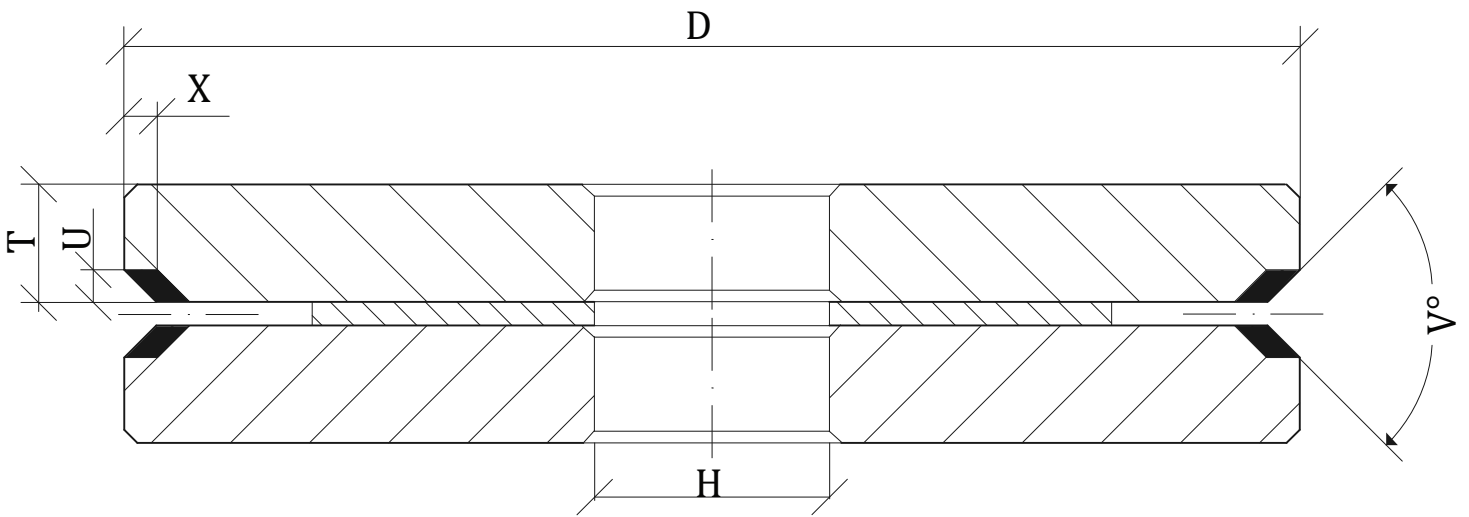


4 B T 9

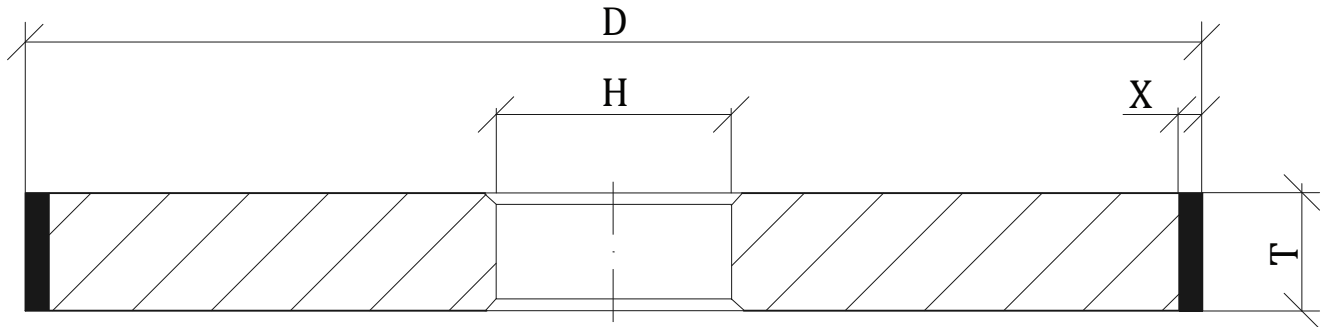


4 E T 9

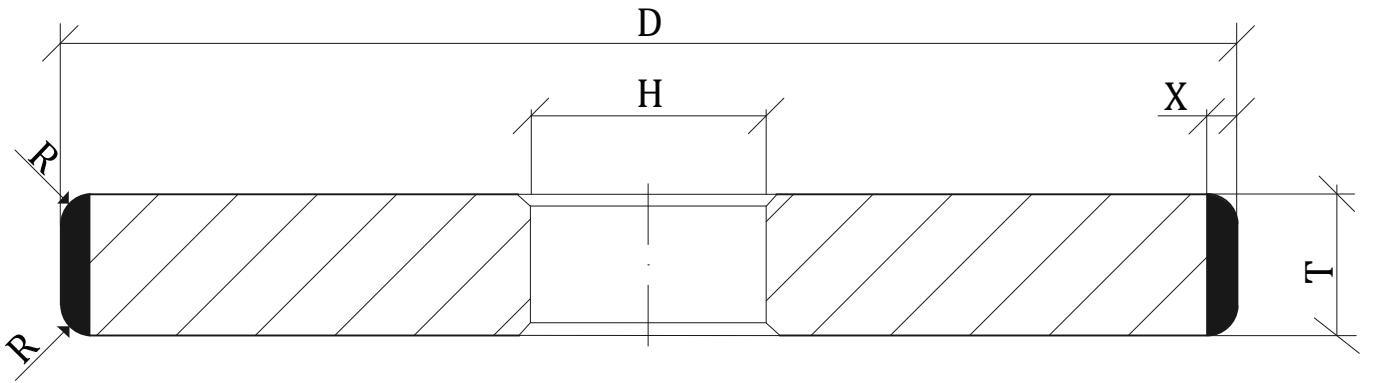




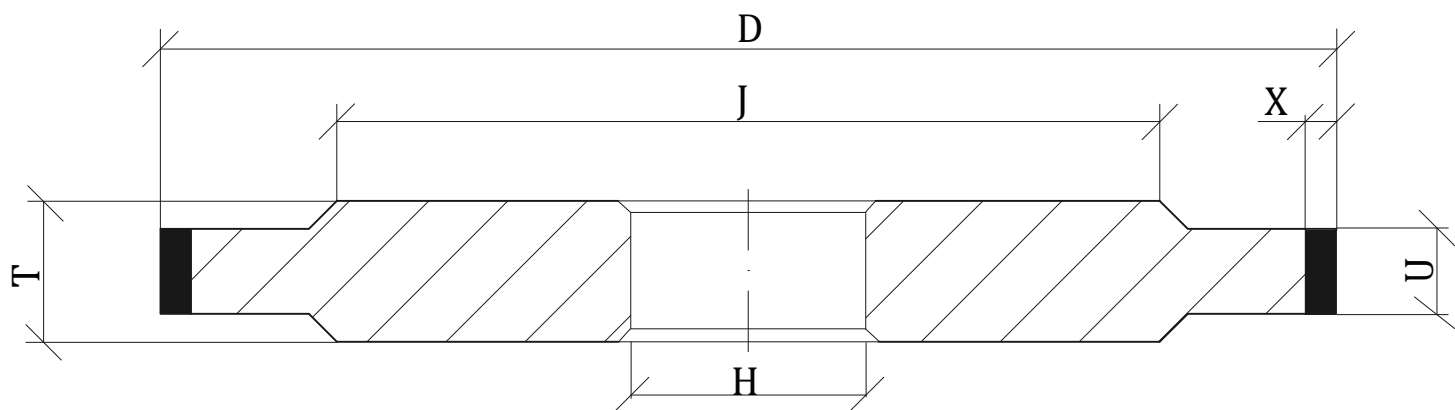
D	T	U	V°
150	10	2 3	90° 120°
175	10	2 3	90°
200	10	2 3	90°
250	10	2 3	90°



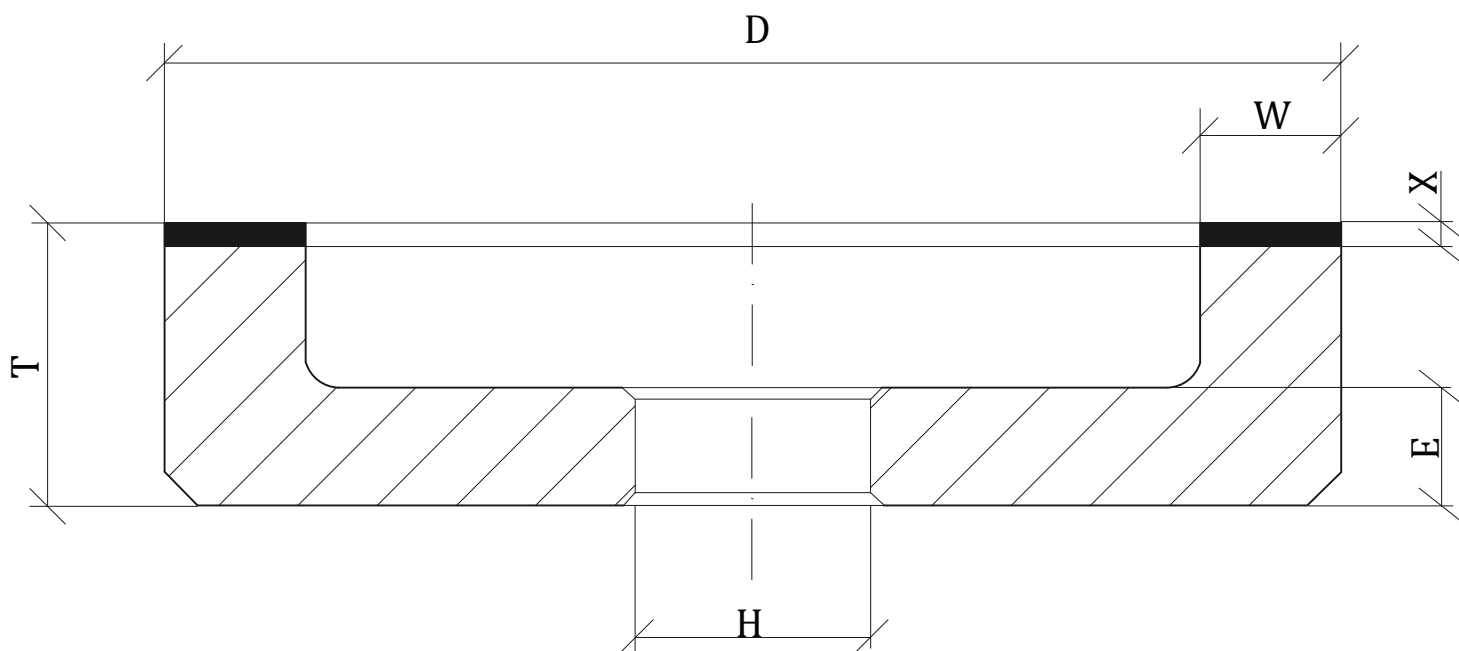
D	T						H	
20	4	8				10		
25	4	8				10		
40	4	8				10		
50	4	6	8	10				
75	3	4	5	6	10	12		
100	3	4	5	6	10	12		
125	3	4	5	6	10	12	15	
150	3	4	5	6	10	15	20	
175				6	10	15	20	
220				6	10	15	20	
245				6	10	15	20 40 60	
300					10	15	20 40 60	127 >
350					15	20 25 30 >		127 >
400					15	20 25 30 >		127 >



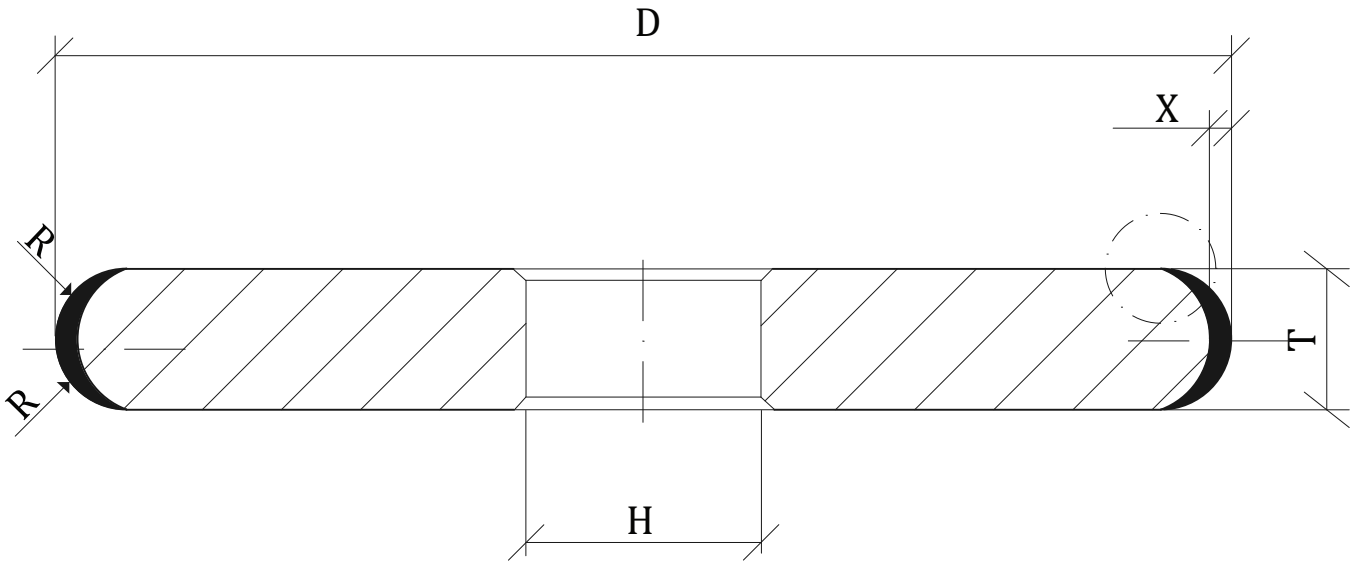
D	T				R
75	3	4	5		0.5
100	3	4	5		0.5
125	3	4	5	6	0.5
150	3	4	5	6	0.5



D	U		T	J	X
100	1	2	6	70	
125	1	2	6	100	
150	1	2	6	120	
175	1	3	5	8	140
200	2	3	5	10	160
300	5>				4
350	5>				
400	5>				

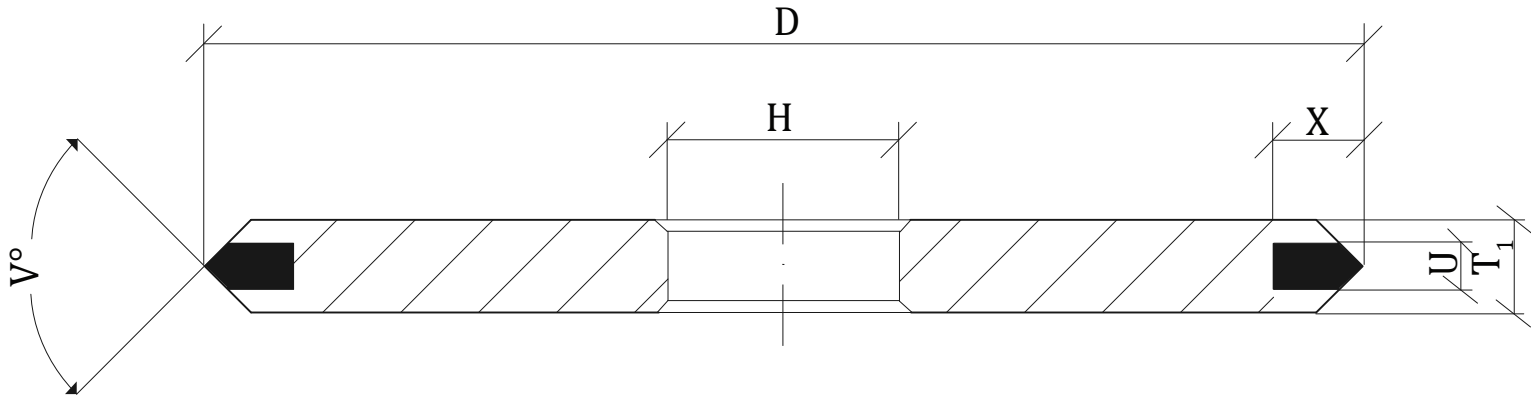


D	T-X	W				E	H			
50	22	3	5			10				
75	22	3	5	10		10				
100	22		5	10	15	10				
125	22			6	10	12.5	15	10		
150	22			6	10	12.5	15	20	25	10
175	25			6	10		15	20	25	13
200	25				10		15	20	25	13
250	25				10		15	20	25	13
300	35				10		15			250
350	90	6	8	10	12	15				250

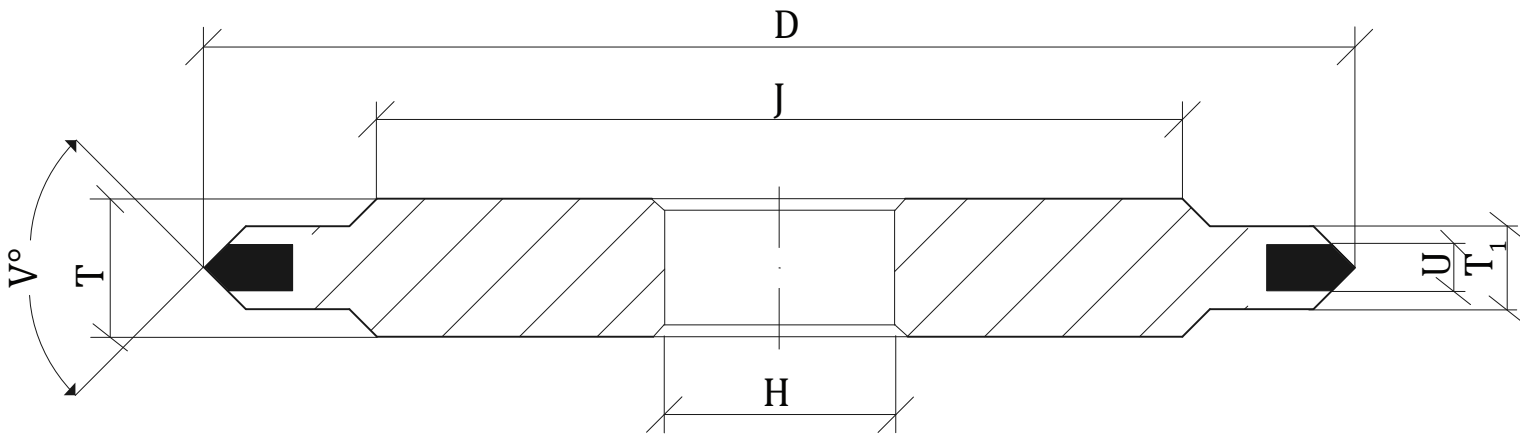


D	R	T
50		
75		
100	$2 \geq R \geq 10$	2 R
125		
150		

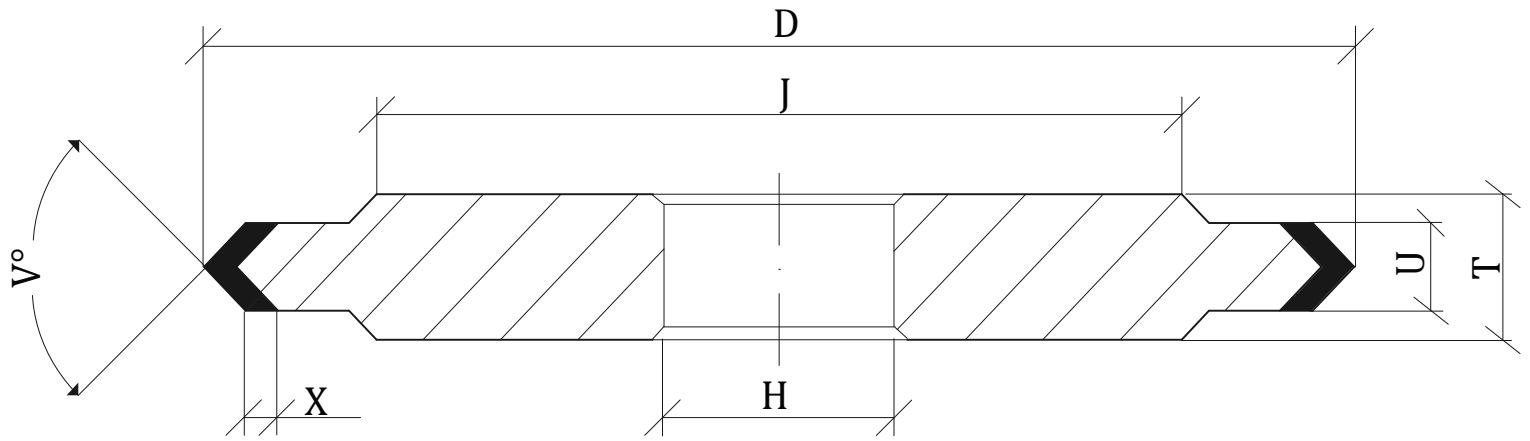
1 E 6 Q



14 E 6 Q

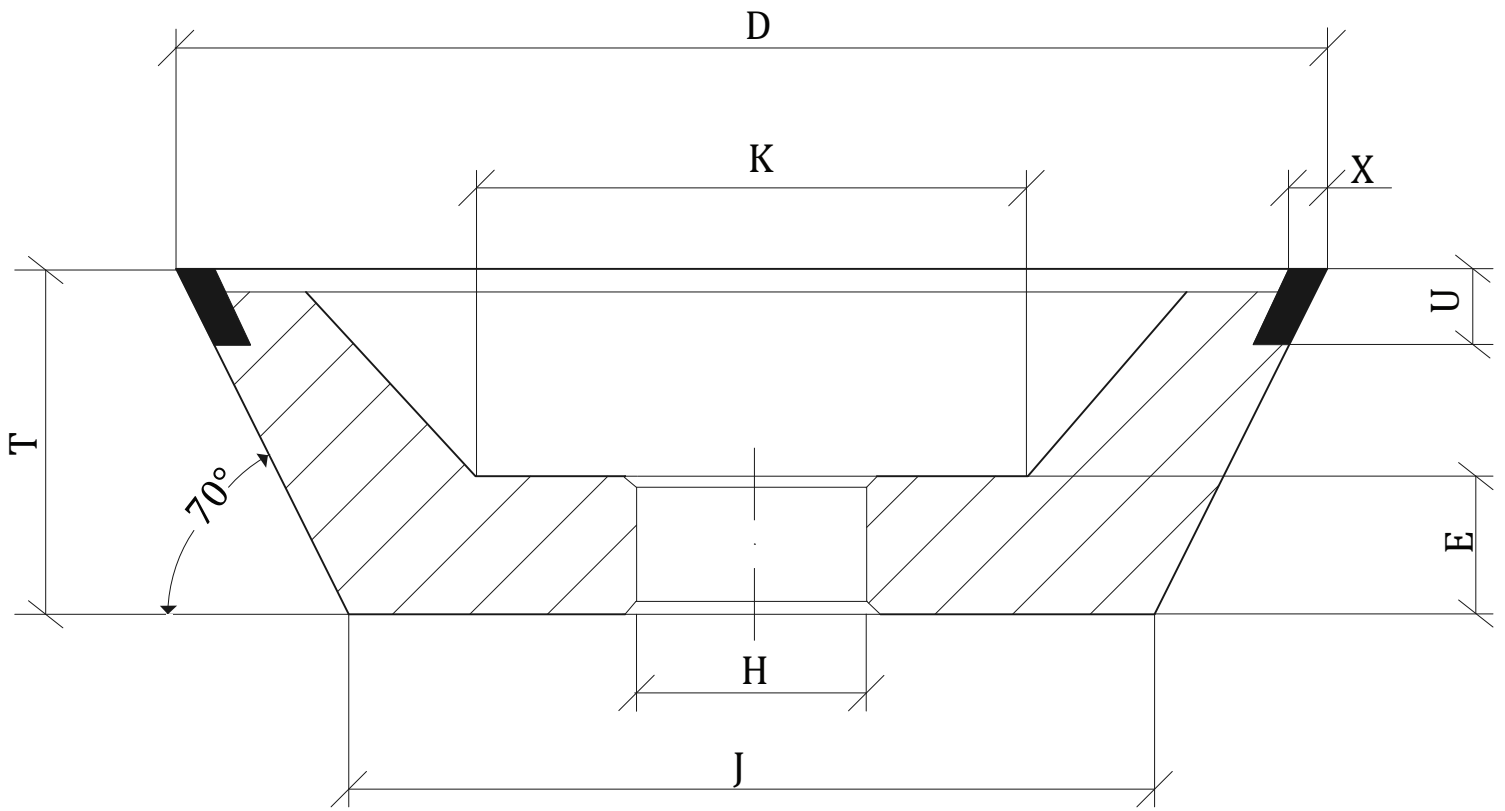


D	T ₁	U	X	T	J	V°
40	4	1	2	5		35° 45° 60° 90°
50	4	1	2	5		
75	4	1	2	5		
100	4	1	2	5		
125	5	1	2	5		
150	5	1	2	5		
220	5	1	2	5	12	

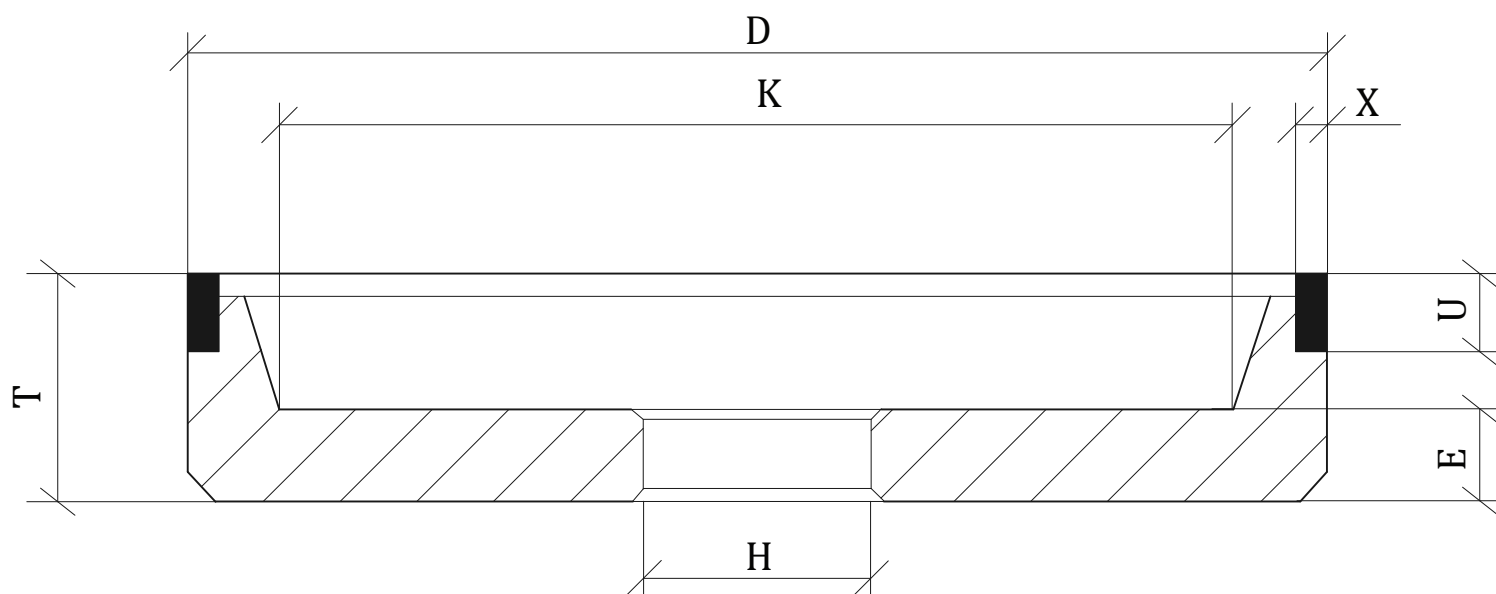


V°	35°	45°	60°	90°
X	3	2.5	2	1.5
	6	5	4	3

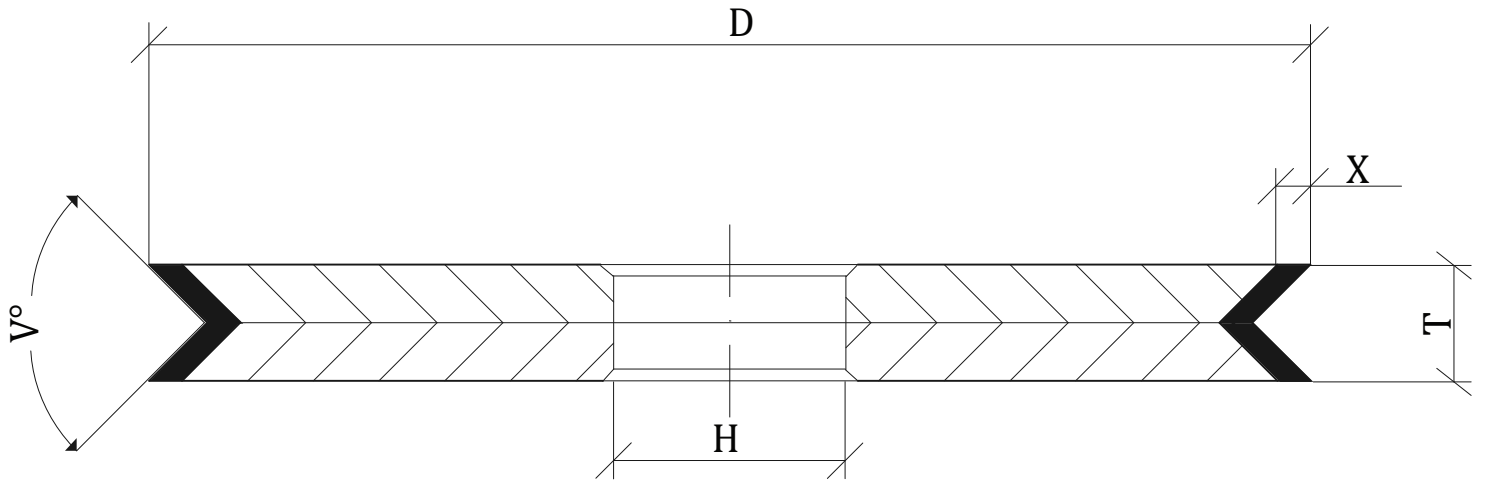
D	U	T	J	V°
100	3 4	6	70	
125	3 4	6	100	35°
150	3 4	6	120	45°
175	4 5	8	140	60°
200	4 5	10	160	90°
250	4 5	15	200	



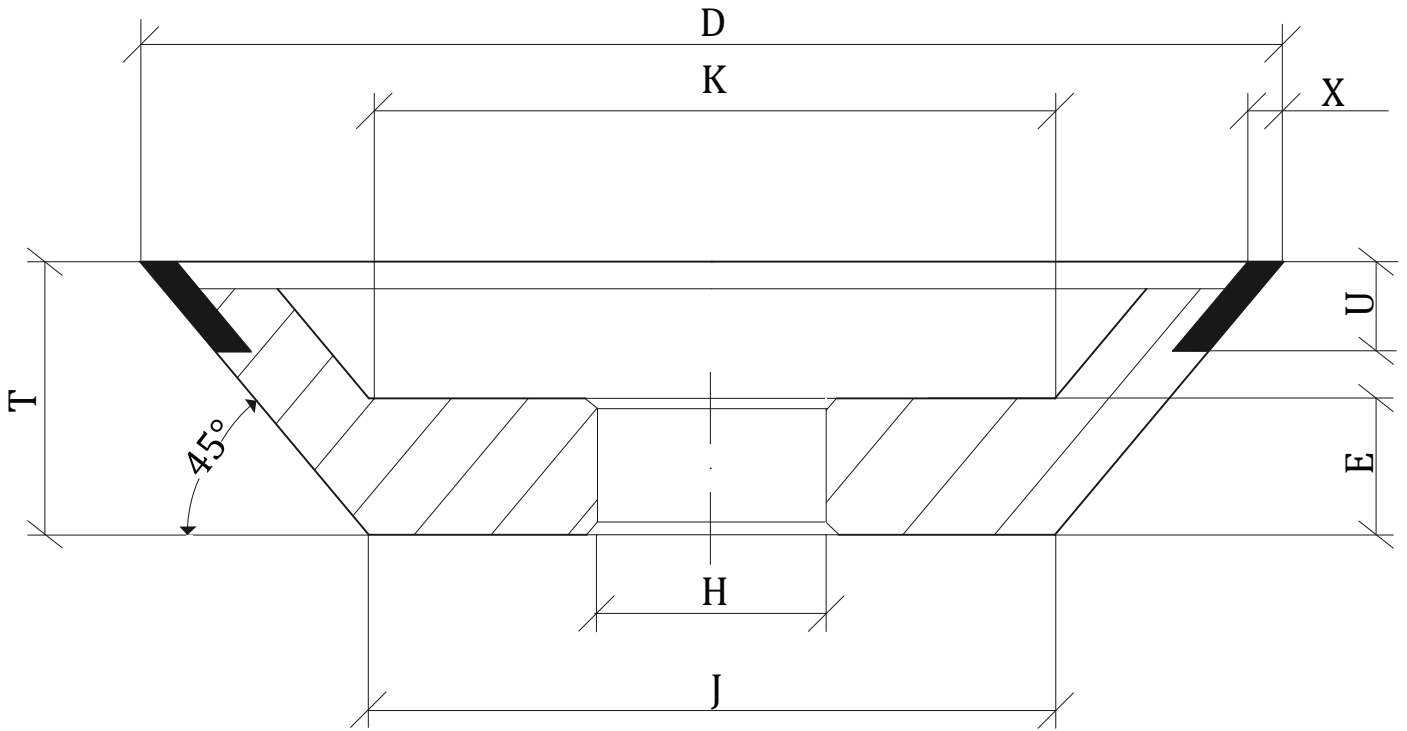
D	T	U	E	K	J
75	30	6	10	40	53
90	35	10	10	55	65
100	35	6	10	55	75
125	40	6	10	75	96
150	50	6	10	90	117



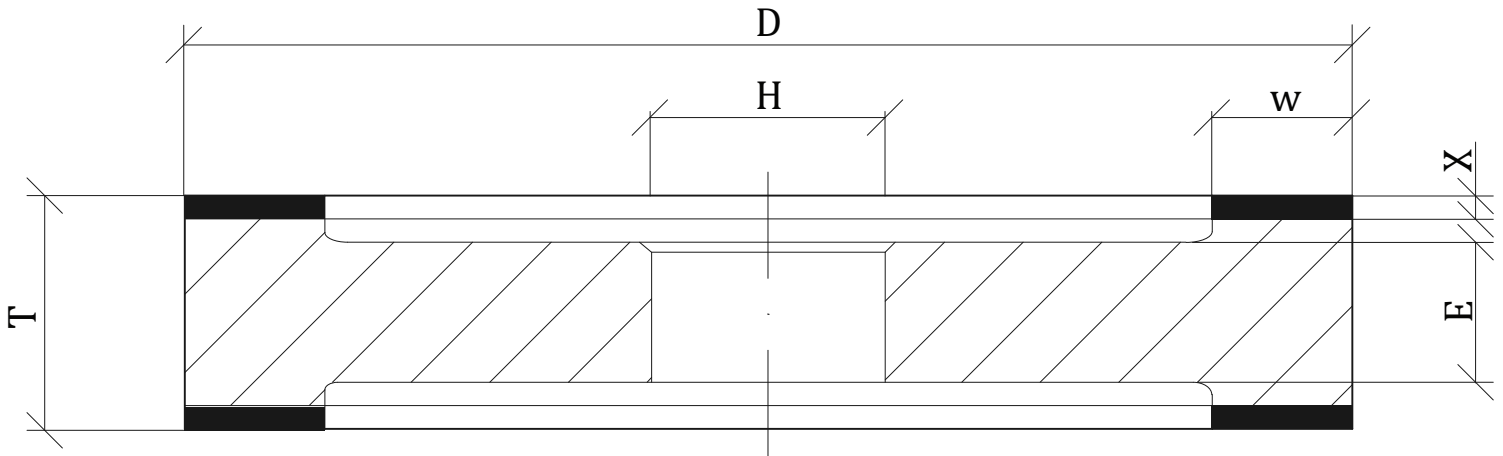
D	T	U	E	K	X			
75	25	6	10	10	60	1.5	2	3
100	30	6	10	10	80	1.5	2	3
125	30	6	10	10	110	1.5	2	3
150	35	6	10	10	135		2	3



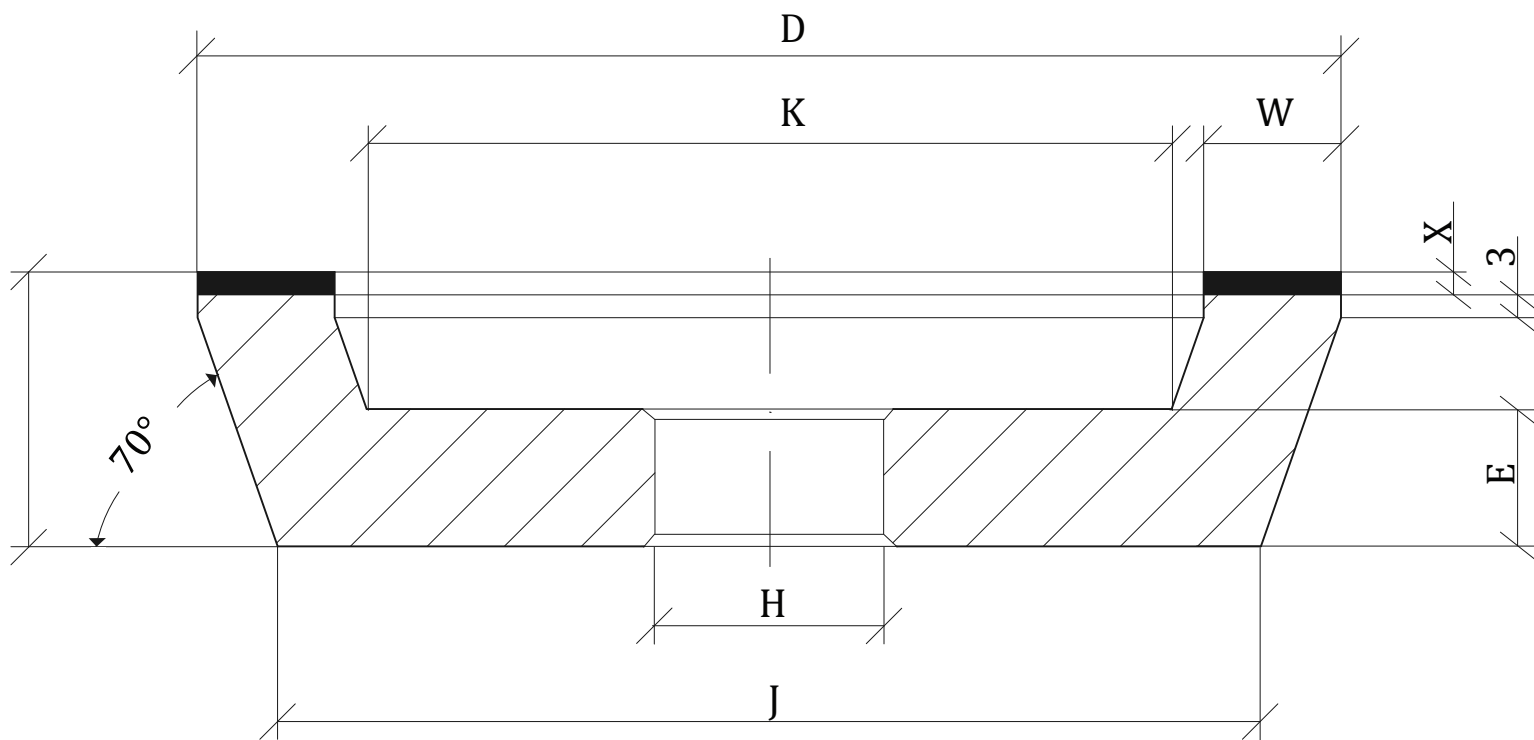
D	T	V°	
100	7	120°	
110	7	120°	
150	10	125°	135°
150	12	125°	135°
150	15	135°	



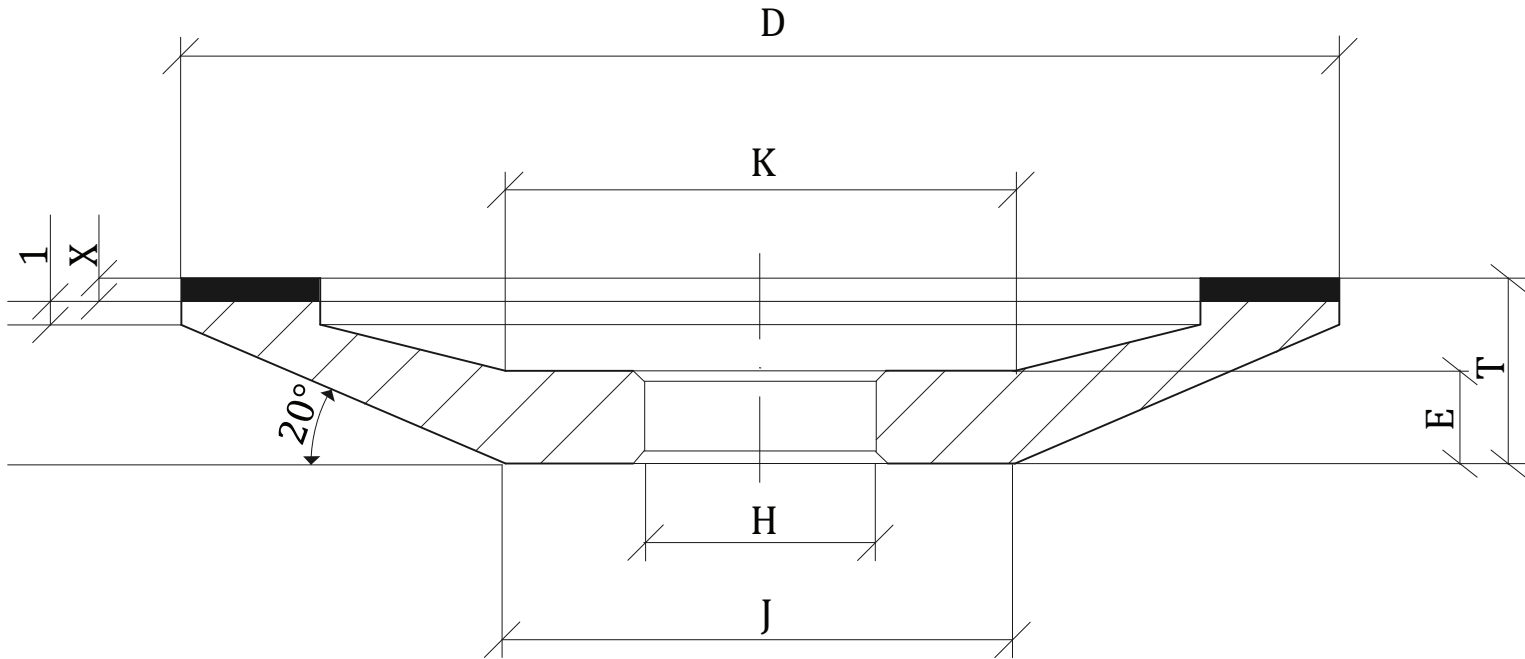
D	T	U	E	K	J
75	20	6	10	45	35
100	20	6	10	65	60
125	25	6 10	10	80	75



D		T		W			E
100	22	6	8	10		10	
125	22	6	8	10		10	
150	25	35	6	8	10	15	14
175	25	35	6	8	10	15	14
220	30		8	10	15		18



D	T-X		W		E	K	J
75	20	3	6	10	10	48	63
100	33		6	10	10	55	68
125	23		6	10	10	98	110
150	23	5	8	10	10		



D	T-X	W			E	K	J
75	8	3	6	10	5	33	37
100	10	3	6	10	6	50	51
125	14	3	6	10	8	54	54
150	16	3	6	10	9	68	68
175	18		6	10	10	82	82
200	20		6	10	11	96	96
250	23		6	10	13	130	130