



Resin Tools

Basic Information for Resin Tools.

Used in the Toolmaking Industry : CNC Tool Grinding,
Woodworking and Insert Grinding.



Shinhan Diamond Industrial Co., Ltd. has produced a variety of diamond tools from products for construction and stone to those for precision industries and high-tech materials such as silicon wafers for semi-conductor and the flat panel display including LCD and OLED since its establishment in 1978.

Resin Tools

www.shinhandia.co.kr

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Basic Information

Mesh Size

US Mesh	FEPA (μm)
#60/80	D252
#80/100	D181
#100/120	D151
#120/140	D126
#140/170	D107
#170/200	D91
#200/230	D76
#230/270	D64
#270/325	D54
#325/400	D46
#400/500	D40
#500	D35
#600	D30
#800	D25
#1000	D20
#1200	D15
#1500	D11
#2000	D7
#3000	D6
#5000	D4
#8000	D3
#16000	D1

Concentration

DIA	Carat / cc	Vol %
C50	2.2	12.5
C75	3.3	18.75
C100	4.4	25
C125	5.5	31.25
C150	6.6	37.5

CBN	Carat / cc	Vol %
V120	2.09	12
V180	3.13	18
V240	4.18	24
V300	5.22	30
V360	6.37	36

Basic Information

Wheel Bodies

Body Material	Body Code	Vibration Absorption	Heat Transmisson	Mechanical Stiffness
Resin (phenol) with metal fillers	H	Medium	Sufficient	Good
Resin (epoxy) with metal fillers	P	Medium	Sufficient	Good
Resin with non-metallic fillers	B	Good	Bad	Satisfactory (not sufficient with thin walled bodies)
Aluminium	A	Bad	Good	Very good
Aluminium + Resin (phenol) with metal filler	AH	Medium	Sufficient	Good
Aluminium + Resin (epoxy) with metal filler	AP	Medium	Sufficient	Good
Aluminium + Copper	AC	Medium	Sufficient	Good
Aluminium + Steel cutter	AE	Bad	Satisfactory	Satisfactory (not sufficient with thin walled bodies)
Aluminium + Bakelite	ACF	Good	Bad	Satisfactory (not sufficient with thin walled bodies)
Steel	E	Bad	Satisfactory	Very Good
Copper	C	Bad	Very Good	Very Good
Composite Material (Bakelite)	CFK	Good	Bad	Good

CNC Tool Grinding

Selection Assistant for Shinhan Bond System

Bond	Material of Bond	Wear Resistance	Dry / Wet	Hardness	Diamond / CBN	Performance
RMD-R	Polyimide	HIGH	Wet	R	D	General purpose for Mini tool.
RMX1-J	Polyimide		Wet	J	D	High wear-resistant bond for mini tool.
XTG-V6	Hybrid		Wet	N	D	High-Grinding ability & Edge stability bond for flute grinding.
XTG-R	Hybrid		Wet	N	D	General purpose for High Polishing.
RMC-N	Polyimide		Wet	J	D	High wear-resistant bond for flute grinding.
RMX3-N	Polyimide		Wet	J	D	General purpose for peripheral grinding of tungsten carbide insert.
EK2-C	Polyimide		Wet	C	D	High wear-resistant bond for mini tool. (low hp CNC)
EK-P	Polyimide		Wet	P	D / B	Flute grinding. (low hp machine)
BT-N	Phenolic		Wet	N	D	For grinding of Tooth-Top face of saw blade.
EG3-N	Phenolic		Wet	N	D / B	General purpose for grinding. (low hp machine)
PG4-N	Phenolic		Wet	N	D	For grinding of Tooth-Top face of saw blade.
BA1-N	Phenolic		Wet	N	D	General purpose of cup type wheel.
BG2-N	Phenolic		Wet	N	D / B	General purpose for cutting tool.
PG2-N	Phenolic		Dry / Wet	N	D / B	General purpose for cutting tool. (dry & wet)
BC2-N	Phenolic		Dry / Wet	N	D	Profile grinding & Cut-off for W.C.
BA2-N	Phenolic		Wet	N	D	General purpose for surface grinding. (O.D > 300)
BA-N	Phenolic		Wet	N	D	General purpose for surface grinding. (O.D > 300)
BA5-N	Phenolic		Wet	N	D	Super polishing. (straight wheel)
JBA-N	Phenolic		Wet	N	D	Super polishing. (cup wheel)
BG1-N	Phenolic	Dry / Wet	N	D / B	General purpose for wet & dry grinding, High grinding ability for WC.	
RSC-N	Phenolic	Dry / Wet	N	D	General purpose for Die & Mold.	
PGX-N	Phenolic	Dry / Wet	N	D	General purpose for Die & Mold. (Standard design)	
BSH-N	Phenolic	Wet	N	D	Cut-off for Ceramic.	
EG6-N	Phenolic	Dry / Wet	N	D / B	Cutting Tool Regrinding.	
BG1-L	Phenolic	Dry / Wet	L	D / B	General purpose for wet & dry grinding.	
JBC-N	Phenolic	Dry	N	D	General purpose for Dry Polishing. (CUP & DISH wheel)	
BC-N	Phenolic	Dry	N	D	General purpose for Dry grinding.	
EG-R	Phenolic	Wet	R	B	General purpose for HSS flute grinding.	
PGD-N	Phenolic	LOW	Wet	N	D / B	General purpose for HSS Saw blade. (for Loroach, Schmidt-Tempo)

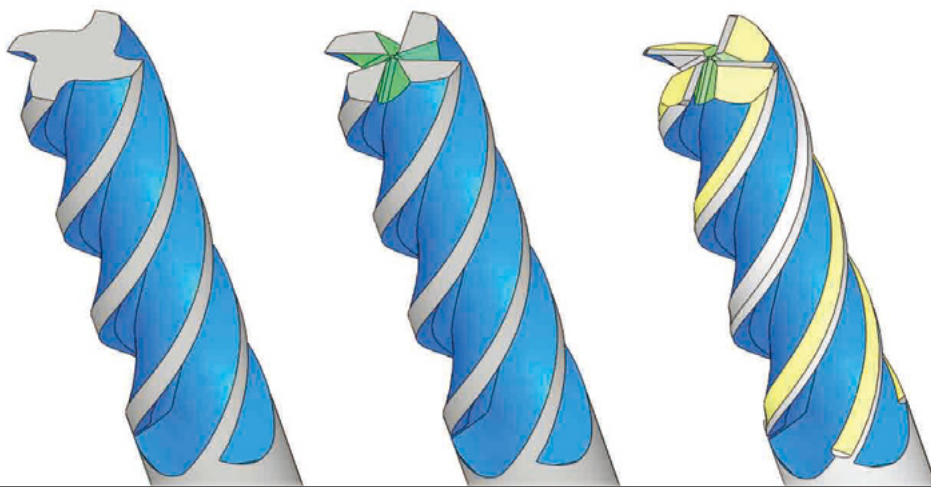
J - Softer L - Soft N - Normal P - Hard R - Harder

CNC Tool Grinding

⊙ Excellent ○ Good △ Normal

Bond	Shank tool					Mini Tool 4A9	Woodworing			Knife 6A2	Mold & Die		
	Flute	Gashing	Relief	Universal Grinding			Face	Top	Flank		Surface & OD	Profile	Cut-off
	1A1, 1V1	1V1, 12V9	11V9	ST Type	Cup, Dish		12A2	6VV9	1K700		1A1	14A1	1A1R
RMD-R						⊙							
RMX1-J						△							
XTG-V6	⊙												
XTG-R			○					△					
RMC-N	○												
RMX3-N							○						
EK2-C						○							
EK-P	⊙	⊙	○									○	
BT-N								⊙					
EG3-N	△	○							○			○	
PG4-N													
BA1-N					○		⊙						
BG2-N		⊙	⊙	△	○		△	○	○	○	△		
PG2-N		○	⊙		⊙								
BC2-N												⊙	⊙
BA2-N											⊙		
BA-N				⊙							⊙		
BA5-N											△		
JBA-N							○						
BG1-N					⊙		△		○	⊙			
RSC-N				⊙							○		
PGX-N				⊙							○		
BSH-N													○
EG6-N													
BG1-L													
JBC-N							○						
BC-N			△	○	○						○		
EG-R	⊙	○											
PGD-N	△								⊙			⊙	

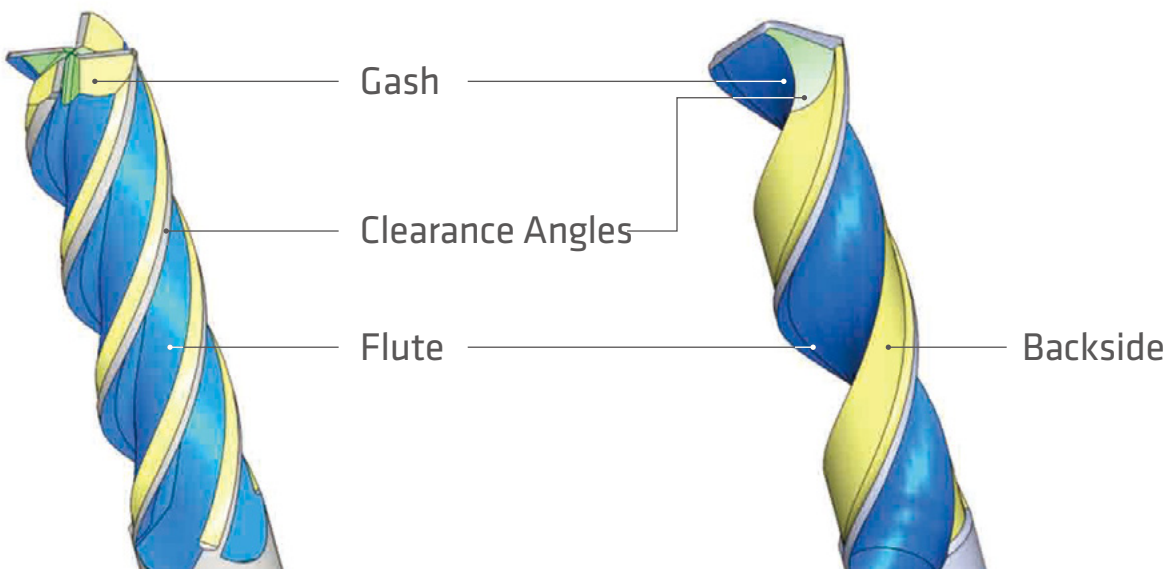
Application Guide _ General Information



Flute

Gash

Clearance Angles



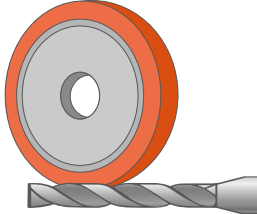


Gash

Clearance Angles

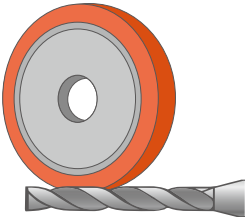
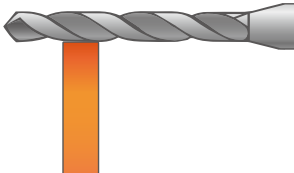
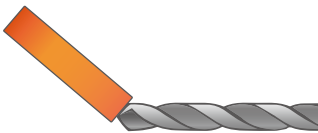
Flute

Backside

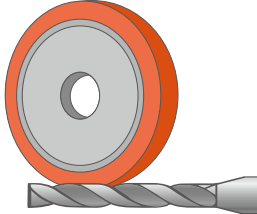


Application Guide _ Cemented Carbide Milling Cutter

Parameters	Product	Flute	Clearance Angles	Gashing
				
Cutting speed Vc	Polymide	20 ~ 24 m/s	20 ~ 24 m/s	20 ~ 24 m/s
	Hybrid	16 ~ 20 m/s	18 ~ 25 m/s	18 ~ 25 m/s
Infeed Ae	Polymide	Depth of flute	0.3 ~ 1.0 mm	Depends on Geometry
	Hybrid	Depth of flute	0.3 ~ 1.0 mm	Depends on Geometry
Feedrate Vf	Polymide	50 ~ 100 mm/min	100 ~ 200 mm/min	20 ~ 35 mm/min
	Hybrid	80 ~ 160 mm/min	200 ~ 400 mm/min	30 ~ 80 mm/min
Recommended Specification	Polymide	D54EK-P	D54EK-P	D54EK5-N
	Hybrid	D54XTG Series	D54XTG Series	D54XTG Series

Application Guide _ Cemented Carbide Drill

Parameters	Product	Flute	Backside	Point
				
Cutting speed Vc	Polymide	20 ~ 24 m/s	20 ~ 24 m/s	20 ~ 24 m/s
	Hybrid	16 ~ 20 m/s	16 ~ 18 m/s	16 ~ 20 m/s
Infeed Ae	Polymide	Depth of flute	0.3 ~ 1.5 mm	Depends on Geometry
	Hybrid	Depth of flute	0.5 ~ 1.5 mm	Depends on Geometry
Feedrate Vf	Polymide	Under 5 mm depth → 40 ~ 80 mm/min Above 5 mm depth → 20 ~ 60 mm/min	100 ~ 125 mm/min	10 ~ 15 mm/min
	Hybrid	Under 5 mm depth → 60 ~ 150 mm/min Above 5 mm depth → 30 ~ 120 mm/min	200 ~ 300 mm/min	15 ~ 55 mm/min
Recommended Specification	Polymide	D54EK-P	D54EK-P	D54EK-P
	Hybrid	D54XTG Series	D54XTG Series	D54XTG Series

Application Guide _ HSS Milling Cutter

Parameters	Product	Flute	Clearance Angles	Gashing
				
Cutting speed Vc	Polymide	22 ~ 24 m/s	20 ~ 40 m/s	22 ~ 40 m/s
	Hybrid	20 ~ 24 m/s	20 ~ 24 m/s	20 ~ 24m/s
Infeed Ae	Polymide	Depth of flute	0.3 ~ 1.5 mm	Depends on Geometry
	Hybrid	Depth of flute	0.3 ~ 1.5 mm	Depends on Geometry
Feedrate Vf	Polymide	80 ~ 150 mm/min	150 ~ 300 mm/min	30 ~ 70 mm/min
	Hybrid	100 ~ 200 mm/min	150 ~ 300 mm/min	40 ~ 70 mm/min
Recommended Specification	Polymide	B91EG-R	B91EG-R	B91EG-R
	Hybrid	B91XTG Series	B91XTG Series	B91XTG Series

Application Guide

According to recent researches, in order to improve productivity of company, it is better to increase work speed of diamond wheel than minimizing quantity of workpieces. It can help to increase potential capability and reduce production costs as well at the same time.

Shank tool's quality, which is also important as its cost, depends on chipping size of edge-cutting and residual stress, and solve this kind of problem, we need diamond tools which simultaneously have excellent precision and grinding performance along with precise mechanical conditions and improved coolant and lubrication system.

Shinhan's XTG Series is the best solution which can lead you to improve your productivity, cost reduction and better quality.

$$V_f = \frac{Q'w \cdot 60}{A_e}$$

Guideline

Recommended cutting speed with XTG Series
Vc = 16 - 20m/s

	30	40	50	60	70	80	90	100	120	140	160	180	200
2.6	1.3	1.7	2.2	2.6	3.0	3.5	3.9	4.3	5.2	6.1	6.9	7.8	8.7
2.8	1.4	1.9	2.3	2.8	3.3	3.7	4.2	4.7	5.6	6.5	7.5	8.4	9.3
3.0	1.5	2.0	2.5	3.0	3.5	4.0	4.5	5.0	6.0	7.0	8.0	9.0	10.0
3.2	1.6	2.1	2.7	3.2	3.7	4.3	4.8	5.3	6.4	7.5	8.5	9.6	10.7
3.4	1.7	2.3	2.8	3.4	4.0	4.5	5.1	5.7	6.8	7.9	9.1	10.2	11.3
3.6	1.8	2.4	3.0	3.6	4.2	4.8	5.4	6.0	7.2	8.4	9.6	10.8	12.0
3.8	1.9	2.5	3.2	3.8	4.4	5.1	5.7	6.3	7.6	8.9	10.1	11.4	12.7
4.0	2.0	2.7	3.3	4.0	4.7	5.3	6.0	6.7	8.0	9.3	10.7	12.0	13.3
4.2	2.1	2.8	3.5	4.2	4.9	5.6	6.3	7.0	8.4	9.8	11.2	12.6	14.0
4.4	2.2	2.9	3.7	4.4	5.1	5.9	6.6	7.3	8.8	10.3	11.7	13.2	14.7
4.6	2.3	3.1	3.8	4.6	5.4	6.1	6.9	7.7	9.2	10.7	12.3	13.8	15.3
4.8	2.4	3.2	4.0	4.8	5.6	6.4	7.2	8.0	9.6	11.2	12.8	14.4	16.0
5.0	2.5	3.3	4.2	5.0	5.8	6.7	7.5	8.3	10.0	11.7	13.3	15.0	16.7

Traverse speed Vf (mm/min)

Vf Start value Vf Optimization potential

➔ Reading Direction

XTG Series Application Example

XTG Example of use

Model 1 : D64 XTG-V6

Grinding Machine :
Walter Helitronic POWER

Coolant : Oil

Work Piece :
Cemented Carbide K20, Ø16 mm

Wheel : 1A1 D125 T12 H20

Grinding Parameters

Feed Rate : $V_f = 150$ mm/min

Infeed : $A_e = 4$ mm

Cutting Speed : $V_c = 20$ m/s

Specific Material Removal Rate :
 $Q'w = 10.0$ mm³/mm·s

Benefit

33% reduction of grinding time.

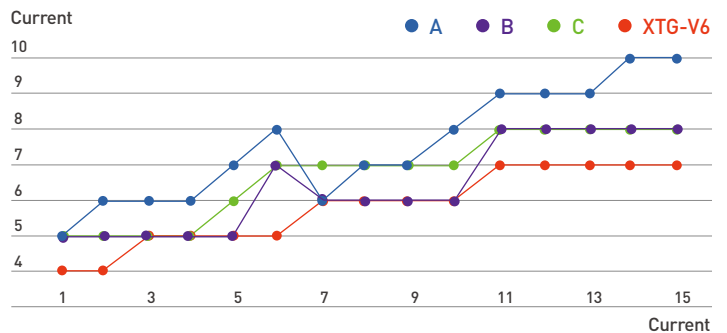
100% longer dressing interval.

Substantial increase in capacity
& Significant cost saving.

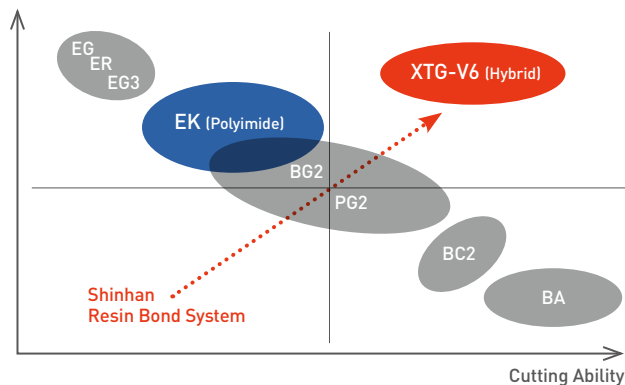
Test Result

Work Piece	Product	Load1	Load2	Load3	Grinding Number
		(avg.) 100 mm/min	(avg.) 120 mm/min	(avg.) 140 mm/min	
WC Rod (K20)	A	6	7.2	9.4	15
	B	5	6.2	8	15
	C	5.2	7	8	15
	SDC XTG-V6	4.6	5	7	15

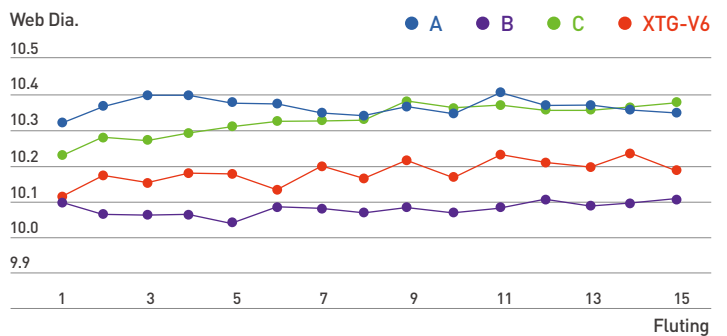
Grinding Current



Tool Life (Form Holding)



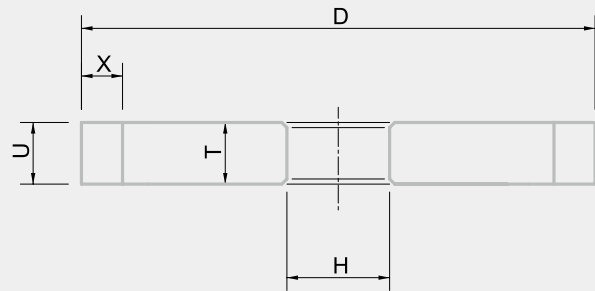
Web Diameter



CNC Tool Grinding

For Cemented Carbide _ Flute - 1

1A1

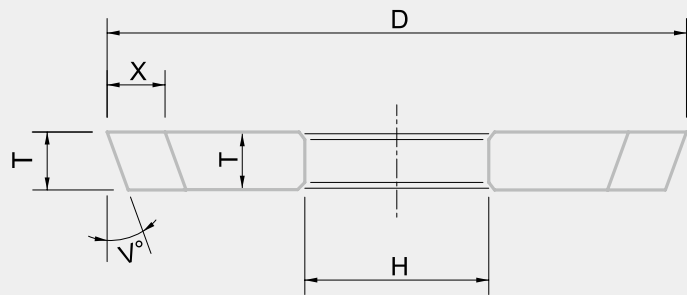


Type	D	T	U	X	H	Grit Size	Bond	Concentration	Body	Material Number
1A1	100	6	6	8	20	D64	EK-P	100	A	227987
1A1	100	8	8	8	20	D64	EK-P	100	A	227988
1A1	100	10	10	8	20	D64	EK-P	100	A	227989
1A1	100	12	12	8	20	D64	EK-P	100	A	227990
1A1	125	8	8	10	20	D64	EK-P	100	A	228003
1A1	125	10	10	10	20	D64	EK-P	100	A	228004
1A1	125	12	12	10	20	D64	EK-P	100	A	228005
1A1	100	6	6	8	20	D64	XTG	100	E	227991
1A1	100	8	8	8	20	D64	XTG	100	E	227992
1A1	100	10	10	8	20	D64	XTG	100	E	227993
1A1	100	12	12	8	20	D64	XTG	100	E	227994
1A1	125	8	8	10	20	D64	XTG	100	E	228006
1A1	125	10	10	10	20	D64	XTG	100	E	228007
1A1	125	12	12	10	20	D64	XTG	100	E	228008
1A1	100	6	6	8	31.75	D64	EK-P	100	A	227995
1A1	100	8	8	8	31.75	D64	EK-P	100	A	227996
1A1	100	10	10	8	31.75	D64	EK-P	100	A	227997
1A1	100	12	12	8	31.75	D64	EK-P	100	A	227998
1A1	125	8	8	10	31.75	D64	EK-P	100	A	228009
1A1	125	10	10	10	31.75	D64	EK-P	100	A	228009
1A1	125	12	12	10	31.75	D64	EK-P	100	A	228009
1A1	100	6	6	8	31.75	D64	XTG	100	E	227999
1A1	100	8	8	8	31.75	D64	XTG	100	E	228000
1A1	100	10	10	8	31.75	D64	XTG	100	E	228001
1A1	100	12	12	8	31.75	D64	XTG	100	E	228002
1A1	125	8	8	10	31.75	D64	XTG	100	E	228012
1A1	125	10	10	10	31.75	D64	XTG	100	E	228013
1A1	125	12	12	10	31.75	D64	XTG	100	E	228014

CNC Tool Grinding

For Cemented Carbide _ Flute - 2

1V1

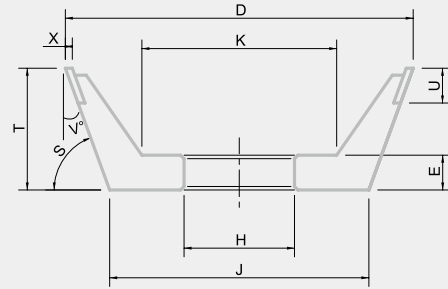


Type	D	T	X	V°	H	Grit Size	Bond	Concentration	Body	Matrial Number
1V1	100	10	5	10	20	D64	EK-P	100	A	228027
1V1	100	10	5	20	20	D64	EK-P	100	A	228028
1V1	100	10	8	10	20	D64	XTG	100	E	228030
1V1	100	10	8	20	20	D64	XTG	100	E	228031
1V1	125	10	5	10	20	D64	EK-P	100	A	228039
1V1	125	10	5	20	20	D64	EK-P	100	A	228040
1V1	125	10	8	10	20	D64	XTG	100	E	228042
1V1	125	10	8	20	20	D64	XTG	100	E	228043
1V1	100	10	5	10	31.75	D64	EK-P	100	A	228033
1V1	100	10	5	20	31.75	D64	EK-P	100	A	228034
1V1	100	10	8	10	31.75	D64	XTG	100	E	228036
1V1	100	10	8	20	31.75	D64	XTG	100	E	228037
1V1	125	10	5	10	31.75	D64	EK-P	100	A	228045
1V1	125	10	5	20	31.75	D64	EK-P	100	A	228046
1V1	125	10	8	10	31.75	D64	XTG	100	E	228048
1V1	125	10	8	20	31.75	D64	XTG	100	E	228049

CNC Tool Grinding

For Cemented Carbide _ Relief

11V9

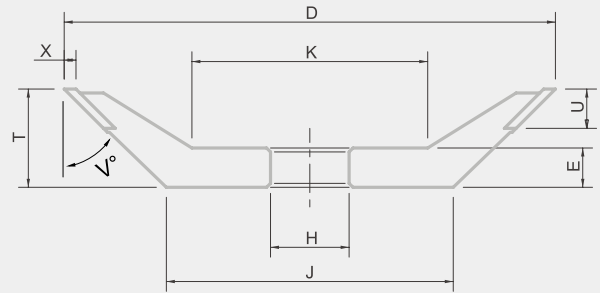


Type	D	T	U	X	H	Grit Size	Bond	Concentration	Body	Material Number	Comment
11V9	75	30	10	3	20	D64	BG2-L	75	AH	228015	V = 20°
11V9	100	35	10	2	20	D64	BG2-L	100	AH	228016	V = 20°
11V9	100	35	10	3	20	D64	BG2-L	100	AH	228017	V = 20°
11V9	125	40	10	3	20	D64	BG2-L	100	AH	228023	V = 20°
11V9	75	30	10	3	20	D64	EK-P	75	AH	228055	V = 20°
11V9	100	35	10	2	20	D64	EK-P	100	AH	228065	V = 20°
11V9	100	35	10	3	20	D64	EK-P	100	AH	228075	V = 20°
11V9	125	40	10	3	20	D64	EK-P	100	AH	228089	V = 20°
11V9	75	30	10	3	20	D64	XTG	75	AH	228056	V = 20°
11V9	100	35	10	2	20	D64	XTG	100	AH	228066	V = 20°
11V9	100	35	10	3	20	D64	XTG	100	AH	228076	V = 20°
11V9	125	40	10	3	20	D64	XTG	100	AH	228090	V = 20°
11V9	75	30	10	3	20	D46	BG2-L	75	AH	228057	V = 20°
11V9	100	35	10	2	20	D46	BG2-L	100	AH	228067	V = 20°
11V9	100	35	10	3	20	D46	BG2-L	100	AH	228077	V = 20°
11V9	125	40	10	3	20	D46	BG2-L	100	AH	228091	V = 20°
11V9	75	30	10	3	20	D46	EK-P	75	AH	228058	V = 20°
11V9	100	35	10	2	20	D46	EK-P	100	AH	228068	V = 20°
11V9	100	35	10	3	20	D46	EK-P	100	AH	228078	V = 20°
11V9	125	40	10	3	20	D46	EK-P	100	AH	228092	V = 20°
11V9	75	30	10	3	20	D46	XTG	75	AH	228059	V = 20°
11V9	100	35	10	2	20	D46	XTG	100	AH	228069	V = 20°
11V9	100	35	10	3	20	D46	XTG	100	AH	228079	V = 20°
11V9	125	40	10	3	20	D46	XTG	100	AH	228093	V = 20°
11V9	75	30	10	3	31.75	D64	BG2-L	75	AH	228018	V = 20°
11V9	100	35	10	2	31.75	D64	BG2-L	100	AH	228019	V = 20°
11V9	100	35	10	3	31.75	D64	BG2-L	100	AH	228020	V = 20°
11V9	125	40	10	3	31.75	D64	BG2-L	100	AH	228024	V = 20°
11V9	75	30	10	3	31.75	D64	EK-P	75	AH	228060	V = 20°
11V9	100	35	10	2	31.75	D64	EK-P	100	AH	228070	V = 20°
11V9	100	35	10	3	31.75	D64	EK-P	100	AH	228080	V = 20°
11V9	125	40	10	3	31.75	D64	EK-P	100	AH	228094	V = 20°
11V9	75	30	10	3	31.75	D64	XTG	75	AH	228061	V = 20°
11V9	100	35	10	2	31.75	D64	XTG	100	AH	228071	V = 20°
11V9	100	35	10	3	31.75	D64	XTG	100	AH	228081	V = 20°
11V9	125	40	10	3	31.75	D64	XTG	100	AH	228095	V = 20°
11V9	75	30	10	3	31.75	D46	BG2-L	75	AH	228062	V = 20°
11V9	100	35	10	2	31.75	D46	BG2-L	100	AH	228072	V = 20°
11V9	100	35	10	3	31.75	D46	BG2-L	100	AH	228082	V = 20°
11V9	125	40	10	3	31.75	D46	BG2-L	100	AH	228096	V = 20°
11V9	75	30	10	3	31.75	D46	EK-P	75	AH	228063	V = 20°
11V9	100	35	10	2	31.75	D46	EK-P	100	AH	228073	V = 20°
11V9	100	35	10	3	31.75	D46	EK-P	100	AH	228063	V = 20°
11V9	125	40	10	3	31.75	D46	EK-P	100	AH	228097	V = 20°
11V9	75	30	10	3	31.75	D46	XTG	75	AH	228064	V = 20°
11V9	100	35	10	2	31.75	D46	XTG	100	AH	228074	V = 20°
11V9	100	35	10	3	31.75	D46	XTG	100	AH	228084	V = 20°
11V9	125	40	10	3	31.75	D46	XTG	100	AH	228098	V = 20°

CNC Tool Grinding

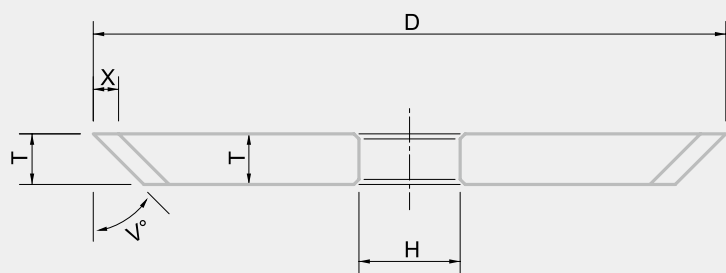
For Cemented Carbide _ Gash

12V9



Type	D	T	U	X	H	Grit Size	Bond	Concentration	Body	Material Number	Comment
12V9	100	20	10	3	20	D64	BG2-L	100	AH	228021	V = 45°
12V9	125	25	10	3	20	D64	BG2-L	100	AH	228025	V = 45°
12V9	100	20	10	3	20	D64	EK-O	100	AH	228085	V = 45°
12V9	125	25	10	3	20	D64	EK-O	100	AH	228099	V = 45°
12V9	100	20	10	3	20	D64	XTG-V	100	AH	228086	V = 45°
12V9	125	25	10	3	20	D64	XTG-V	100	AH	228100	V = 45°
12V9	100	20	10	3	31.75	D64	BG2-L	100	AH	228022	V = 45°
12V9	125	25	10	3	31.75	D64	BG2-L	100	AH	228026	V = 45°
12V9	100	20	10	3	31.75	D64	EK-O	100	AH	228087	V = 45°
12V9	125	25	10	3	31.75	D64	EK-O	100	AH	228101	V = 45°
12V9	100	20	10	3	31.75	D64	XYG-V	100	AH	228088	V = 45°
12V9	125	25	10	3	31.75	D64	XYG-V	100	AH	228102	V = 45°

1V1

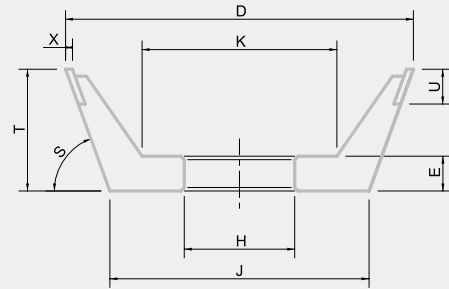


Type	D	T	X	V°	H	Grit Size	Bond	Concentration	Body	Material Number	Comment
1V1	100	10	5	45	20	D64	EK-O	100	A	228029	
1V1	100	10	5	45	20	D64	XTG-V	100	E	228032	
1V1	125	10	5	45	20	D64	EK-O	100	A	228041	
1V1	125	10	5	45	20	D64	XTG-V	100	E	228044	
1V1	150	12	5	45	20	D64	EK-O	100	A	228051	
1V1	150	12	5	45	20	D64	XTG-V	100	E	228052	
1V1	100	10	5	45	31.75	D64	EK-O	100	A	228035	
1V1	100	10	5	45	31.75	D64	XTG-V	100	E	228038	
1V1	125	10	5	45	31.75	D64	EK-O	100	A	228047	
1V1	125	10	5	45	31.75	D64	XTG-V	100	E	228050	
1V1	150	12	5	45	31.75	D64	EK-O	100	A	228053	
1V1	150	12	5	45	31.75	D64	XTG-V	100	E	228054	

CNC Tool Grinding

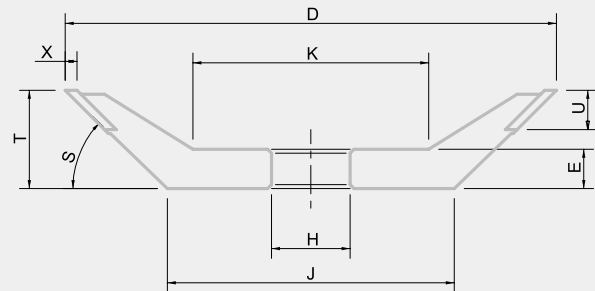
For Cemented Carbide _ Regrinding

11V9



Type	D	T	U	X	H	Grit Size	Bond	Concentration	Body	Material Number	Comment
11V9	75	30	10	3	20	D64	PG2-N	75	AH		
11V9	100	35	10	2	20	D64	PG2-N	100	AH		
11V9	100	35	10	3	20	D64	PG2-N	100	AH		
11V9	125	40	10	3	20	D64	PG2-N	100	AH		
11V9	75	30	10	3	31.75	D64	PG2-N	75	AH		
11V9	100	35	10	2	31.75	D64	PG2-N	100	AH		
11V9	100	35	10	3	31.75	D64	PG2-N	100	AH		
11V9	125	40	10	3	31.75	D64	PG2-N	100	AH		

12V9

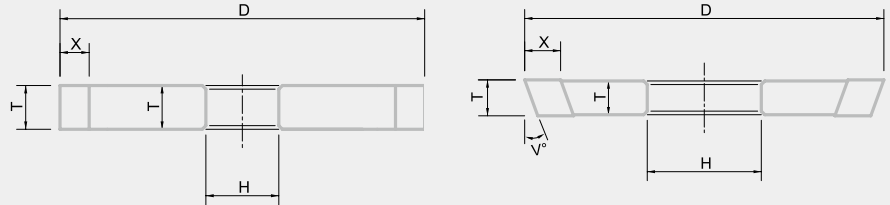


Type	D	T	U	X	H	Grit Size	Bond	Concentration	Body	Material Number	Comment
12V9	100	20	10	3	20	D64	BG2-N	100	AH		
12V9	125	25	10	3	20	D64	BG2-N	100	AH		
12V9	100	20	10	3	31.75	D64	BG2-N	100	AH		
12V9	125	25	10	3	31.75	D64	BG2-N	100	AH		

CNC Tool Grinding

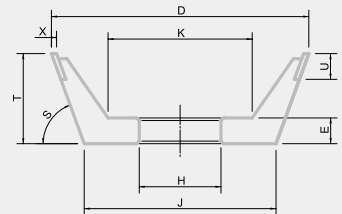
For HSS _ Flute, Relief, Gash

Flute



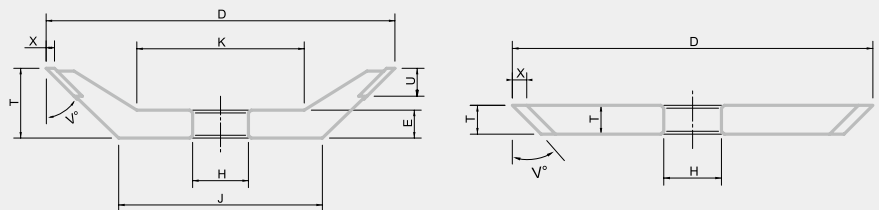
Type	D	T	X	V°	H	Grit Size	Bond	Concentration	Body	Material Number	Comment
1A1	100	10	8		20	B91	EG-R	100	A		
1A1	125	10	8		20	B91	EG-R	100	A		
1A1	100	10	8		20	B91	XTG	100	E		
1A1	125	10	8		20	B91	XTG	100	E		
1V1	100	10	5	10	20	B91	EG-R	100	A		
1V1	100	10	5	20	20	B91	EG-R	100	A		
1V1	125	10	5	10	20	B91	EG-R	100	A		
1V1	125	10	5	20	20	B91	XTG	100	C		
1V1	100	10	5	10	20	B91	XTG	100	C		
1V1	100	10	5	20	20	B91	XTG	100	C		
1V1	125	10	5	10	20	B91	XTG	100	C		
1V1	125	10	5	20	20	B91	XTG	100	C		

Relife



Type	D	T	U	X	H	Grit Size	Bond	Concentration	Body	Material Number	Comment
11V9	75	30	10	3	20	B64	BG2-N	75	AH		V = 20°
11V9	100	35	10	2	20	B64	BG2-N	100	AH		V = 20°
11V9	100	35	10	3	20	B64	BG2-N	100	AH		V = 20°
11V9	125	40	10	3	20	B64	BG2-N	100	AH		V = 20°

Gash

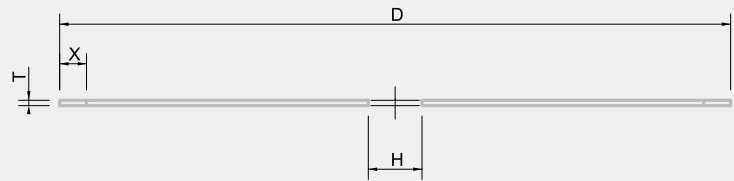


Type	D	T	U	X	H	Grit Size	Bond	Concentration	Body	Material Number	Comment
12V9	100	20	10	3	20	B64	EG-R	75	AH		V = 45°
12V9	125	25	10	3	20	B64	EG-R	100	AH		V = 45°
12V9	100	20	10	3	31.75	B64	EG-R	100	AH		V = 45°
12V9	125	25	10	3	31.75	B64	EG-R	100	AH		V = 45°
1V1	125	10	10	3	20	B64	EG-R	75	A		V = 45°
1V1	150	10	10	3	20	B64	EG-R	100	A		V = 45°
1V1	125	10	10	3	31.75	B64	EG-R	100	A		V = 45°
1V1	150	10	10	3	31.75	B64	EG-R	100	A		V = 45°

CNC Tool Grinding

For Cemented Carbide _ Cutting-Off

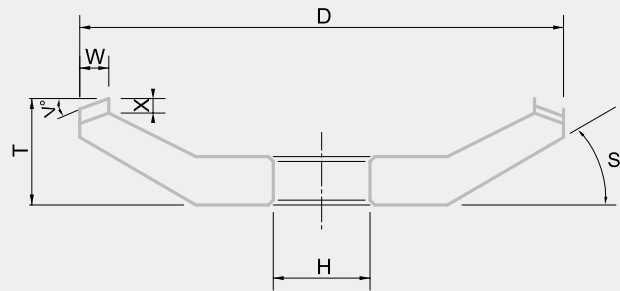
1A1R



Type	D	T	X	H	Grit Size	Bond	Concentration	Body	Material Number	Comment
1A1R	100	1	5	31.75	D64	BC2-N	100	E		RECESS 0.1mm
1A1R	125	1	5	31.75	D64	BC2-N	100	E		RECESS 0.1mm
1A1R	150	1	5	31.75	D64	BC2-N	100	E		RECESS 0.1mm
1A1R	200	1.2	5	31.75	D64	BC2-N	100	E		RECESS 0.1mm
1A1R	100	1	5	31.75	B64	BG2-N	100	E		RECESS 0.1mm
1A1R	125	1	5	31.75	B64	BG2-N	100	E		RECESS 0.1mm
1A1R	150	1	5	31.75	B64	BG2-N	100	E		RECESS 0.1mm
1A1R	200	1.2	5	31.75	B64	BG2-N	100	E		RECESS 0.1mm

For Ball Endmill _ Radial Clearance

11V5, 12V5



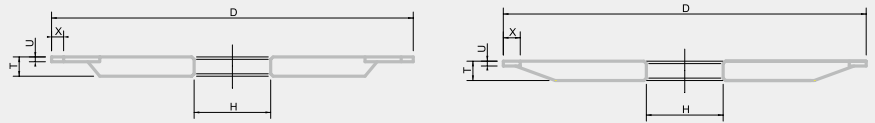
Type	D	T	W	X	H	Grit Size	Bond	Concentration	Body	Material Number	Comment
11V5	75	20	3	6	20	D46	EK5-P	100	A		V = 20°
11V5	100	28	5	6	20	D46	EK5-P	100	A		V = 20°
11V5	100	28	10	6	20	D46	EK5-P	100	A		V = 20°
11V5	125	28	5	6	20	D46	EK5-P	100	A		V = 20°
11V5	75	20	3	6	20	D64	XTG-V5	100	E		V = 20°
11V5	100	28	5	6	20	D64	XTG-V5	100	E		V = 20°
11V5	100	28	10	6	20	D64	XTG-V5	100	E		V = 20°
11V5	125	28	5	6	20	D64	XTG-V5	100	E		V = 20°
11V5	75	20	3	6	20	B91	EG-R	100	A		V = 20°
11V5	100	28	5	6	20	B91	EG-R	100	A		V = 20°
11V5	100	28	10	6	20	B91	EG-R	100	A		V = 20°
11V5	125	28	5	6	20	B91	EG-R	100	A		V = 20°

Depends on the Machine software. Possible to OD grinding, gashing, radial clearance grinding and radius sharpening.

CNC Tool Grinding

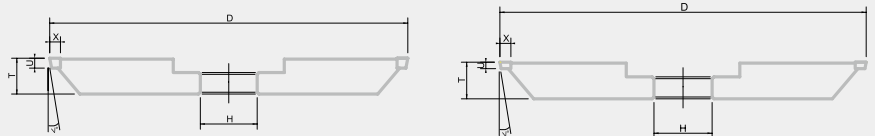
For Cemented Carbide _ Mini Tool

Flute, Relief



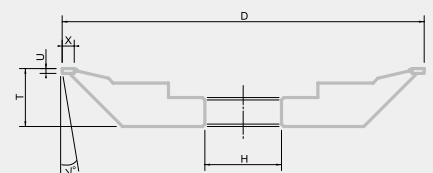
Type	D	T	U	X	H	Grit Size	Bond	Concentration	Body	Material Number	Comment
3A1	100	6	1	6	10	D20	RMD-R	C135	AC		
3A1	125	8	1.5	6	31.75	D20	RMD-R	C135	AC		
3A1	150	8	1.5	8	31.75	D20	RMD-R	C135	AC		
3A1	150	8	2	8	31.75	D20	RMD-R	C135	AC		

Pinch



Type	D	T	U	X	H	Grit Size	Bond	Concentration	Body	Material Number	Comment
4B1	200	20	3	6	31.75	D91	RMD-R	C125	A		V = 10°
4B1	200	20	6	6	31.75	D91	RMD-R	C125	A		V = 10°
4B1	250	20	6	8	31.75	D91	RMD-R	C125	A		V = 10°
4B1	250	20	8	8	31.75	D91	RMD-R	C125	A		V = 10°

Peel



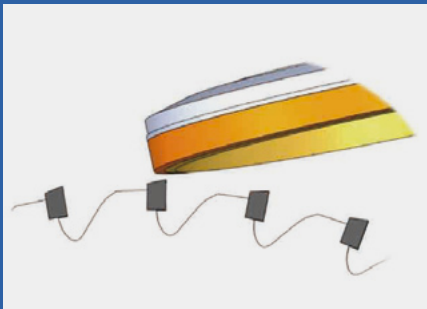
Type	D	T	U	X	H	Grit Size	Bond	Concentration	Body	Material Number	Comment
4B1	150	24	2	4	31.75	D20	V02	C150	A		V = 10°
4B1	150	24	3	4	31.75	D20	V02	C150	A		V = 10°
4B1	150	24	3	6	31.75	D20	V02	C150	A		V = 10°

M/C : Rollomatic, ANCA, STARTECH°

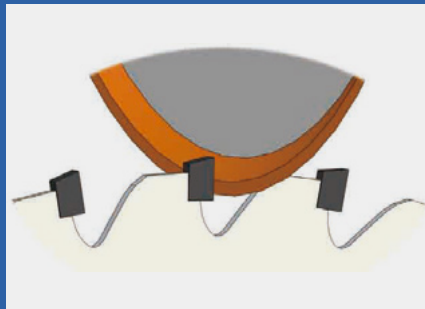
Woodworking

Application Guide

Carbide-Tipped Saw Blade



Tooth Top



Tooth Face



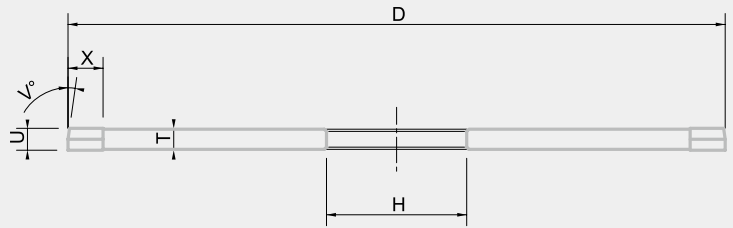
Flank

M/C Code

Machine	Machine Type	M/C
Vollmer Biberach	CB, CC, CE, CEN, CEP, CHC, CHM, CHP, CHT, CNHB, CX and others	VB1
	CHD	VB2
	CC, CEF, CFL, CHAFT, CHAFTE, CHHF, CHF and others	VB3
Vollmer Dornhan	Finimat600	VD1
	Finima800, Finimax	VD2
	FinimatBeta, Gamma	VD3
	Unilapp	VD4
	UnilappF2	VD5
Woodtronic	Duo TS	VD6
	NC2, NC3, C4, C5	W01
	CNC5	W02
Akemat	CNC6F	W03
	AkematB / B10	A1
	AkematU / U10	A2
Widma	AkematF / F10	A3
	Unimat	WD1
	HKS700/H111	WD2
	HKS400, FS1000	WD3

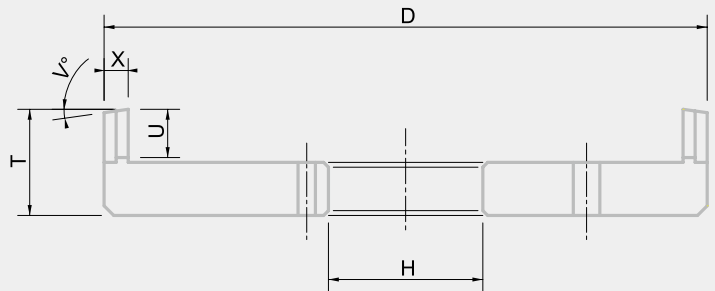
Carbide-Tipped Saw Blade _ Tooth Top - 1

14M1 Double Layer



Type	D	T	U	X	V°	H	Grit Size	Bond	Concentration	Body	M/C	Comment
14M1	127	8	5	6	8	32	D126	BT-N	C100	A	A2	Ufine=2.5
							D46	BT-N	C75			
14M1	150	10	5	8	8	32	D126	BT-N	C100	A	A2 / W01	Ufine=2.5
							D46	BT-N	C75			
14M1	200	10	5	8	8	32	D126	BT-N	C100	A	W02	Ufine=2.5
							D46	BT-N	C75			

6VV9 Double Layer

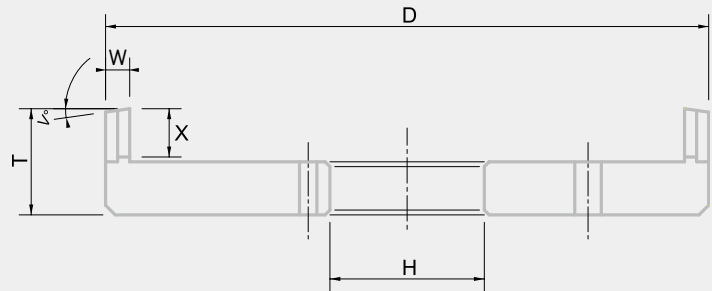


Type	D	T	U	X	V°	H	Grit Size	Bond	Concentration	Body	M/C	Comment
6VV9	125	18	5	6	8	32	D126	BG2-N	C100	A	VB1 / VB2	Wfine = 2.5
							D46	BG2-N	C75			
6VV9	125	18	5	6	8	32	D126	BT-N	C100	A	VB1 / VB2	Wfine = 2.5
							D46	BT-N	C75			
6VV9	125	18	5	6	8	32	D126	RMX3-N	C100	A	VB1 / VB2	Wfine = 2.5
							D46	RMX3-N	C75			
6VV9	125	22	5	10	8	32	D126	BG2-N	C100	A	VB1 / VB2	Wfine = 2.5
							D46	BG2-N	C75			
6VV9	125	22	5	10	8	32	D126	BT-N	C100	A	VB1 / VB2	Wfine = 2.5
							D46	BT-N	C75			
6VV9	125	22	5	10	8	32	D126	RMX3-N	C100	A	VB1 / VB2	Wfine = 2.5
							D46	RMX3-N	C75			

Carbide-Tipped Saw Blade _ Tooth Top - 2

6VV9

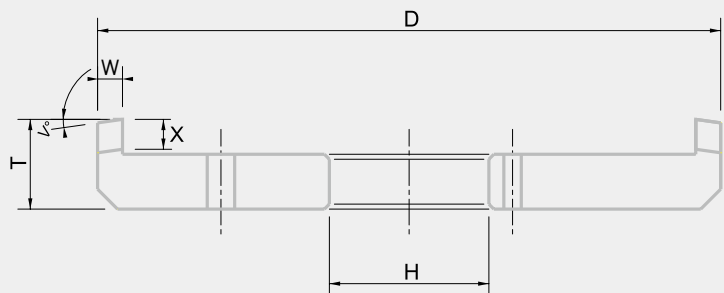
Double Layer



Type	D	T	W	X	V°	H	Grit Size	Bond	Concentration	Body	M / C	Comment
6VV9	100	20	5	6	8	25	D126	BT-N	C100	A	WD1 / WD2	Wfine = 2.5
							D46	BT-N	C75			
6VV9	100	20	5	6	8	25	D126	BT-N	C100	A	WD1 / WD2	Wfine = 2.5
							D46	BT-N	C75			
6VV9	100	24	5	10	8	25	D126	RMX3-N	C100	A	WD1 / WD2	Wfine = 2.5
							D46	RMX3-N	C75			
6VV9	125	20	5	6	8	25	D126	BT-N	C100	A	VD4 / WD1	Wfine = 2.5
							D46	BT-N	C75			
6VV9	125	20	5	6	8	25	D126	BT-N	C100	A	VD4 / WD1	Wfine = 2.5
							D46	BT-N	C75			
6VV9	125	24	5	10	8	25	D126	RMX3-N	C100	A	VD4 / WD1	Wfine = 2.5
							D46	RMX3-N	C75			

6V9

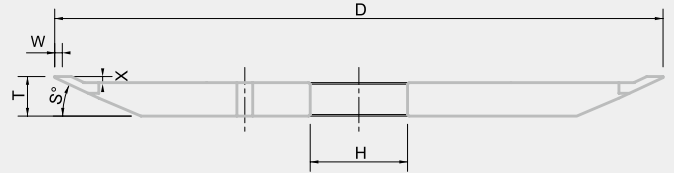
Single Layer



Type	D	T	W	X	V°	H	Grit Size	Bond	Concentration	Body	M / C	Comment
6V9	125	18	5	6	8	32	D64	BT-N	C100	A	VB1 / VB2	Wfine = 2.5
6V9	125	18	5	6	8	32	D64	RMX3-N	C100	A	VB1 / VB2	Wfine = 2.5
6V9	125	22	5	10	8	32	D64	BT-N	C100	A	VB1 / VB2	Wfine = 2.5
6V9	125	18	5	6	8	32	D64	BT-N	C100	A	VB1 / VB2	Wfine = 2.5
6V9	125	18	5	6	8	32	D64	RMX3-N	C100	A	VB1 / VB2	Wfine = 2.5
6V9	125	22	5	10	8	32	D64	BT-N	C100	A	VB1 / VB2	Wfine = 2.5

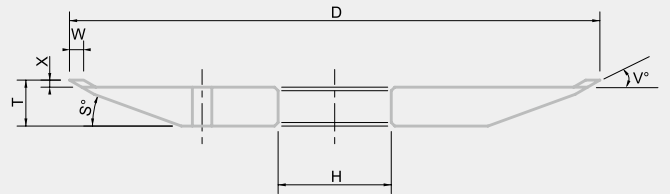
Carbide-Tipped Saw Blade _ Tooth Face

4V2 - SP



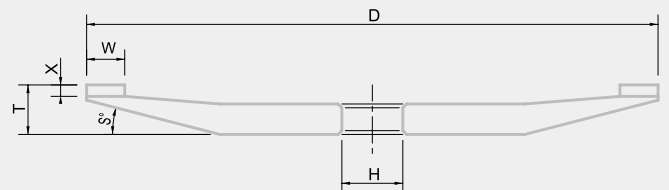
Type	D	T	W	X	S°	H	Grit Size	Bond	Concentration	Body	M / C	Comment
4V2-SP	125	11	2.5	5	25	32	D46	PG4-N	C125	A	VB1	
4V2-SP	150	11	2.5	5	25	32	D64	PG4-N	C125	A	W01 / A1	
4V2-SP	175	13	2.5	5	25	32	D46	PG4-N	C125	A	W01 / A1	
4V2-SP	200	13	2.5	5	25	32	D64	PG4-N	C125	A	VB2 / W02 / A2	
4V2-SP	200	13	2.5	5	25	32	D46	PG4-N	C125	A	VB2 / W02 / A2	

4V2



Type	D	T	W	X	V°	H	Grit Size	Bond	Concentration	Body	M / C	Comment
4V2	100	10	4	2	30	25	D46	BA1-N	C100	A	VD1/VD2/WD1	S = 20°
4V2	100	10	4	2	30	25	D76	PG4-N	C100	A	VD1/VD2/WD1	S = 20°
4V2	125	11	4	2	30	25	D46	BA1-N	C100	A	VD2/WD1/WD2	S = 20°
4V2	125	11	4	2	30	25	D76	PG4-N	C100	A	VD2/WD1/WD2	S = 20°
4V2	125	11	4	2	30	32	D46	BA1-N	C100	A	VB1	S = 20°
4V2	125	11	4	2	30	32	D76	PG4-N	C100	A	VB1	S = 20°
4V2	150	13	4	2	30	32	D46	BA1-N	C100	A	VB1/WD1	S = 20°
4V2	150	13	4	2	30	32	D76	PG4-N	C100	A	VB1/WD1	S = 20°
4V2	200	13	4	2	30	32	D46	PG4-N	C100	A	VB2/W02/A2	S = 20°
4V2	200	13	4	2	30	32	D76	PG4-N	C100	A	VB2/W02/A2	S = 20°

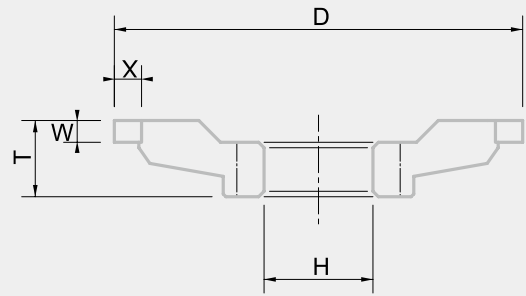
12A2 - 20°



Type	D	T	W	X	S°	H	Grit Size	Bond	Concentration	Body	M / C	Comment
12A2	150	13	6	2	20		D46	BA1-N	C100	ACF	Universal	
12A2	150	13	8	2	20		D76	BA1-N	C100	ACF	Universal	
12A2	150	13	6	2	20		D46	BA1-N	C100	ACF	Universal	
12A2	150	13	8	2	20		D76	BA1-N	C100	ACF	Universal	
12A2	150	13	6	2	20		D46	BA1-N	C100	A	Universal	
12A2	150	13	8	2	20		D76	BA1-N	C100	A	Universal	
12A2	150	13	6	2	20		D46	BA1-N	C100	A	Universal	
12A2	150	13	8	2	20		D76	BA1-N	C100	A	Universal	

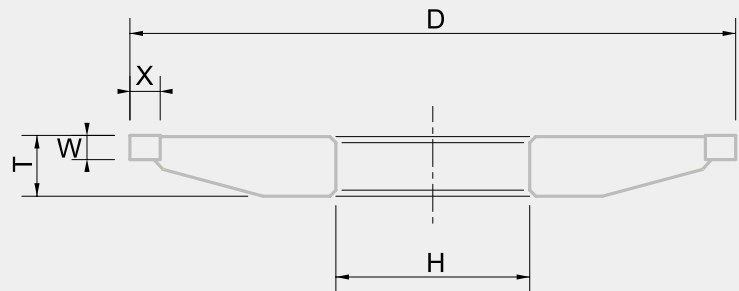
Carbide-Tipped Saw Blade _ Flank - 1

4A1 - SP



Type	D	T	W	X	H	Grit Size	Bond	Concentration	Body	M/C	Comment
4A1-SP	75	14	4	5	20	D54	PGD-N	C75	A	A3 / VD6	
4A1-SP	75	14	4	5	20	D91	BG2-N	C75	A	A3 / VD6	
4A1-SP	75	14	4	5	20	D126	BG2-N	C75	A	A3 / VD6	
4A1-SP	100	14	4	5	20	D54	PGD-N	C75	A	A3 / VD6 / WD3	
4A1-SP	100	14	4	5	20	D91	BG2-N	C75	A	A3 / VD6 / WD3	
4A1-SP	100	14	4	5	20	D126	BG2-N	C75	A	A3 / VD6 / WD3	

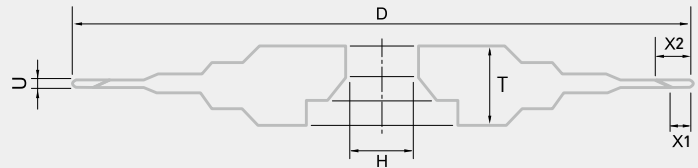
4A1



Type	D	T	W	X	H	Grit Size	Bond	Concentration	Body	M/C	Comment
4A1	80	10	4	5	32	D54	PGD-N	C75	A	VB3 / W03	
4A1	80	10	4	5	32	D91	BG2-N	C75	A	VB3 / W03	
4A1	80	10	4	5	32	D126	BG2-N	C75	A	VB3 / W03	
4A1	100	10	4	5	32	D54	PGD-N	C75	A	VB3 / W03	
4A1	100	10	4	5	32	D91	BG2-N	C75	A	VB3 / W03	
4A1	100	10	4	5	32	D126	BG2-N	C75	A	VB3 / W03	

Carbide-Tipped Saw Blade _ Flank - 2

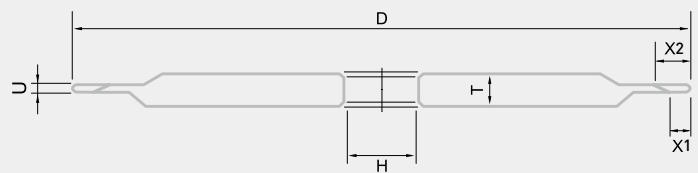
14F1



Type	D	T	U	X1	X2	H	Grit Size	Bond	Concentration	Body	Comment
14F1	150, 200	20	1.3	5	8	20	B151	PGD-N	V300	E	
14F1	150, 200	20	1.3	5	8	20	B126	PGD-N	V300	E	
14F1	150, 200	20	1.8	5	8	20	B151	PGD-N	V240	E	
14F1	150, 200	20	1.8	5	8	20	B126	PGD-N	V240	E	
14F1	150, 200	20	2.5	5	8	20	B151	PGD-N	V240	E	
14F1	150, 200	20	2.5	5	8	20	B126	PGD-N	V240	E	

Machine : SCHMIDT TEMPO ECE, SCHMIDT TEMPO

14F1



Type	D	T	U	X1	X2	H	Grit Size	Bond	Concentration	Body	Comment
14F1	200	8	1.3	5	8	32	B151	PGD-N	V300	E	
14F1	200	8	1.3	5	8	20	B126	PGD-N	V300	E	
14F1	200	8	1.8	5	8	20	B151	PGD-N	V240	E	
14F1	200	8	1.8	5	8	20	B126	PGD-N	V240	E	
14F1	200	8	2.5	5	8	20	B151	PGD-N	V240	E	
14F1	200	8	2.5	5	8	20	B126	PGD-N	V240	E	

Machine : LOROCH, REKORD, SCHMIDT TEMPO

Insert Grinding

Application Guide

Requirements of Different Inserts

	Standard WC Insert	Large WC Insert	Polished WC Insert	Cermet Insert	Ceramic Insert
Low Wheel Wear	○			○	○
High Feed Rates	○	○		○	
Cool Grinding Behavior		○	○	○	
Optimal Edge Qualities			○		○
SHINHAN Bond System	RMX3-N	RMX3-N	RMX35-J	RMX3-P RMX35-I	RMX35-J

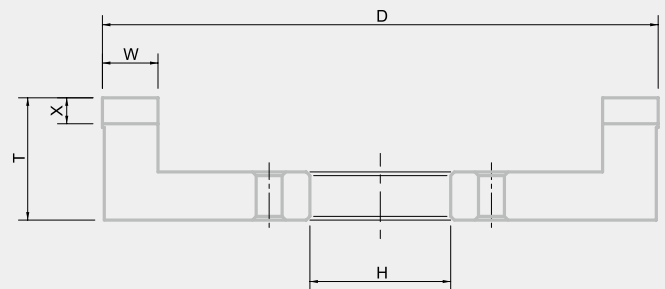
Development Trend in the Peripheral Grinding of Inserts

In the Past	Present			
Workpiece	Standard Tungsten Carbide Insert	Polished Tungsten Carbide Insert	Cermet Insert	Ceramic Insert
Bond	High-Performance Resin Bonds	Standard Resin or Ceramic Bonds	Standard or High-Performance Resin Bonds	High-Performance Resin Bonds or Ceramic Bonds
Grit Size	Medium Grit Size D35~D54	Small Grit Size D15~D35	Medium Grit Size D35~D54	Small Grit Size D15~D35
Concentration	Medium to High Concentration C100~C125	Low to Medium Concentration C75~C100	Medium to High Concentration C100~C125	Various Concentration C75~C125

Insert Grinding

Peripheral Grinding for Cemented Carbide - 1

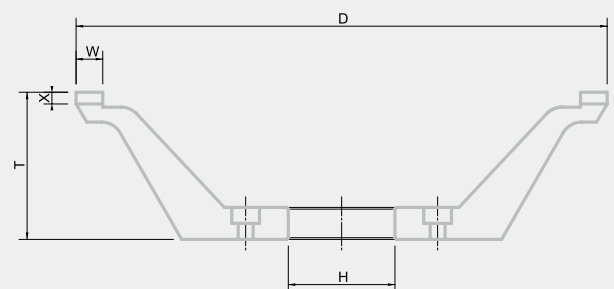
6A2H



Type	D	T	W	X	H	Grit Size	Bond	Concentration	Body	Comment
6A2H	150	40	6	6	40	D46	RMX3-N	C125	A	for WC
6A2H	150	40	10	6	40	D46	RMX3-N	C125	A	for WC
6A2H	150	40	15	6	40	D46	RMX3-N	C125	A	for WC
6A2H	150	40	20	6	40	D46	RMX3-N	C125	A	for WC
6A2H	150	40	6	6	40	D46	CP-N	C125	A	for PCD
6A2H	150	40	10	6	40	D46	CP-N	C125	A	for PCD
6A2H	150	40	15	6	40	D46	CP-N	C125	A	for PCD
6A2H	150	40	20	6	40	D46	CP-N	C125	A	for PCD

Machine : EWAG WS Series

11A2B



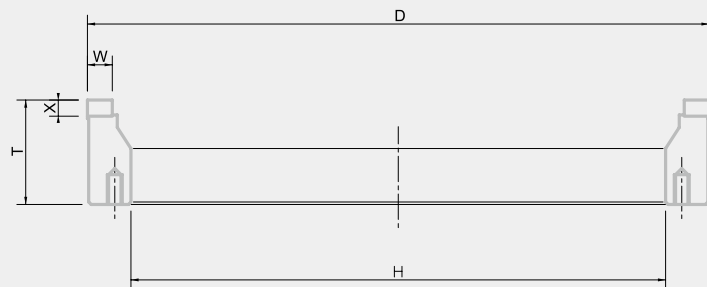
Type	D	T	W	X	H	Grit Size	Bond	Concentration	Body	Comment
11A2B	250	69	8	6	50	D46	RMX3-N	C125	A	
11A2B	250	69	12	6	50	D46	RMX3-N	C125	A	
11A2B	250	69	20	6	50	D46	RMX3-N	C125	A	

Machine : EWAG EWAMATIC

Insert Grinding

Peripheral Grinding for Cemented Carbide - 2

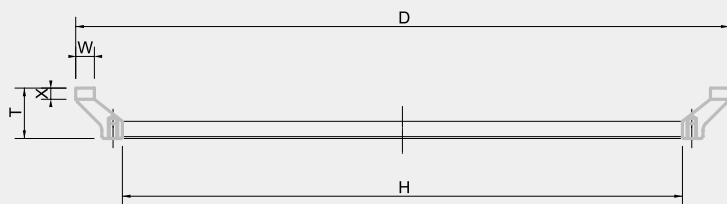
2A2T



Type	D	T	W	X	H	Grit Size	Bond	Concentration	Body	Comment
2A2T	250	42	6	6	215	D46	RMX3-N	C125	A	
2A2T	250	42	8	6	215	D46	RMX3-N	C125	A	
2A2T	250	42	10	6	215	D46	RMX3-N	C125	A	
2A2T	250	42	6	6	215	D46	RMX3-N	C125	A	
2A2T	250	42	8	6	215	D46	RMX3-N	C125	A	
2A2T	250	42	10	6	215	D46	RMX3-N	C125	A	

Machine : AGATHON PA 250

12A2T



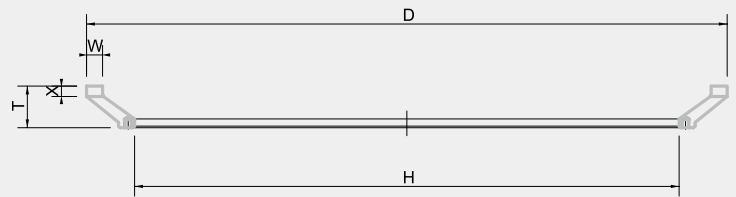
Type	D	T	W	X	H	Grit Size	Bond	Concentration	Body	Comment
12A2T	350	27	8	6	300	D46	RMX3-N	C125	A	
12A2T	350	27	10	6	300	D46	RMX3-N	C125	A	
12A2T	350	27	12	6	300	D46	RMX3-N	C125	A	
12A2T	350	27	8	6	300	D54	RMX3-N	C125	A	
12A2T	350	27	10	6	300	D54	RMX3-N	C125	A	
12A2T	350	27	12	6	300	D54	RMX3-N	C125	A	

Machine : AGATHON 350 COMBI

Insert Grinding

Peripheral Grinding for Cemented Carbide - 3

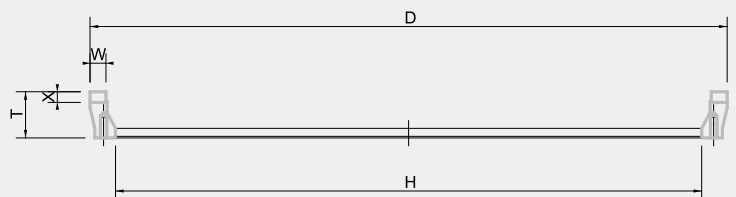
12A2T



Type	D	T	W	X	H	Grit Size	Bond	Concentration	Body	Comment
12A2T	400	26	8	6	340	D46	RMX3-N	C125	A	
12A2T	400	26	10	6	340	D46	RMX3-N	C125	A	
12A2T	400	26	12	6	340	D46	RMX3-N	C125	A	
12A2T	400	26	8	6	340	D54	RMX3-N	C125	A	
12A2T	400	26	10	6	340	D54	RMX3-N	C125	A	
12A2T	400	26	12	6	340	D54	RMX3-N	C125	A	

Machine : AGATHON 400 COMBI, 400 PENTA

11A2T



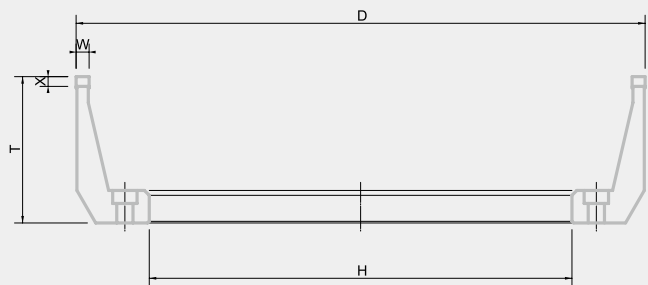
Type	D	T	W	X	H	Grit Size	Bond	Concentration	Body	Comment
11A2T	400	29	8	6	368	D46	RMX3-N	C125	A	
11A2T	400	29	10	6	368	D46	RMX3-N	C125	A	
11A2T	400	29	12	6	368	D46	RMX3-N	C125	A	
11A2T	400	29	8	6	368	D54	RMX3-N	C125	A	
11A2T	400	29	10	6	368	D54	RMX3-N	C125	A	
11A2T	400	29	12	6	368	D54	RMX3-N	C125	A	

Machine : AGATHON 400 COMBI, 400 PENTA

Insert Grinding

Peripheral Grinding for Cemented Carbide - 4

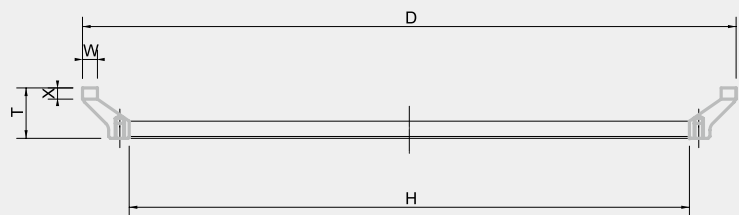
6A2M



Type	D	T	W	X	H	Grit Size	Bond	Concentration	Body	Comment
6A2M	350	90	8	6	260	D46	RMX3-N	C125	A	
6A2M	350	90	8	6	260	D46	RMX3-N	C125	A	
6A2M	350	90	8	6	260	D46	RMX3-N	C125	A	
6A2M	350	90	8	6	260	D54	RMX3-N	C125	A	
6A2M	350	90	8	6	260	D54	RMX3-N	C125	A	
6A2M	350	90	8	6	260	D54	RMX3-N	C125	A	

Machine : WENDT WAM

2A2T



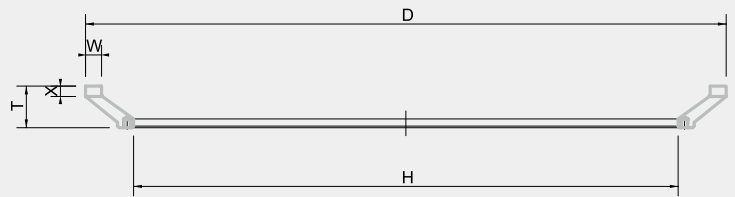
Type	D	T	W	X	H	Grit Size	Bond	Concentration	Body	Comment
2A2T	350	45	8	6	310	D46	RMX3-N	C125	A	
2A2T	350	45	8	6	310	D46	RMX3-N	C125	A	
2A2T	350	45	8	6	310	D46	RMX3-N	C125	A	

Machine : WENDT WCD

Insert Grinding

Peripheral Grinding for Cemented Carbide - 5

11A2T

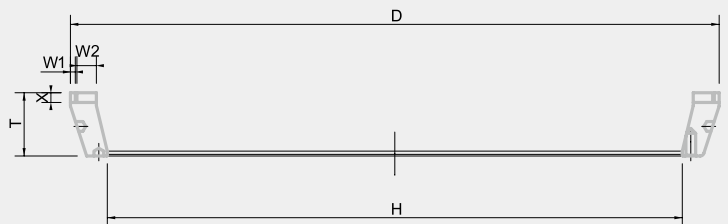


Type	D	T	W	X	H	Grit Size	Bond	Concentration	Body	Comment
11A2T	400	39	8	6	355.06	D46	RMX3-N	C125	E	
11A2T	400	39	10	6	355.06	D46	RMX3-N	C125	E	
11A2T	400	39	12	6	355.06	D46	RMX3-N	C125	E	
11A2T	400	39	15	6	355.06	D46	RMX3-N	C125	E	
11A2T	400	39	8	6	355.06	D54	RMX3-N	C125	E	
11A2T	400	39	10	6	355.06	D54	RMX3-N	C125	E	
11A2T	400	39	12	6	355.06	D54	RMX3-N	C125	E	
11A2T	400	39	15	6	355.06	D54	RMX3-N	C125	E	

Machine : WENDT WAC

11A2T

Double Layer



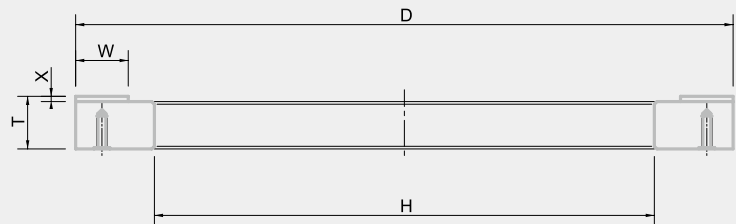
Type	D	T	W1	W2	X	H	Grit Size 1	Grit Size 2	Bond	Concentration	Body	Comment
11A2T	400	39	3	8	6	355.06	D46	D20	RMX3-N	C125	E	For CERMET
11A2T	400	39	3	10	6	355.06	D46	D20	RMX3-N	C125	E	For CERMET
11A2T	400	39	3	12	6	355.06	D46	D20	RMX3-N	C125	E	For CERMET
11A2T	400	39	3	8	6	355.06	D54	D20	RMX3-N	C125	E	For CERMET
11A2T	400	39	3	10	6	355.06	D54	D20	RMX3-N	C125	E	For CERMET
11A2T	400	39	3	12	6	355.06	D54	D20	RMX3-N	C125	E	For CERMET

Machine : WENDT WAC

Insert Grinding

Top & Bottom Grinding for Cemented Carbide

2A2T

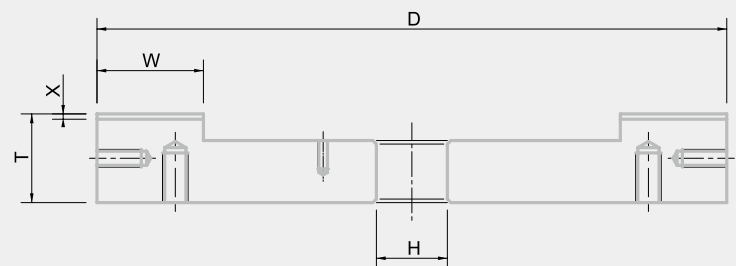


Type	D	T	W	X	H	Grit Size	Bond	Concentration	Body	Comment
6A2T	500	40	40	4	380.15	D126	RMX3-N	C100	A	
6A2T	500	40	40	4	380.15	D64	RMX3-N	C100	A	
6A2T	500	40	40	4	380.15	D46	RMX3-N	C100	A	
6A2T	500	40	40	4	380.15	D126	K2-N	C85	A	For CERMET
6A2T	500	40	40	4	380.15	D64	K2-N	C85	A	For CERMET
6A2T	500	40	40	4	380.15	D46	K2-N	C85	A	For CERMET

Machine : WENDT WBN

6A2M

with Planetary Kinematics



Workpiece	Material	Machine	Wheel Shape	Mesh	Bond	Coolant
Inserts	Tungsten Carbide	Viotto	6A2	D64 ~ D46	RMX3-N	Oil
Plane knives	Cermet	AMT	Ø350~Ø760		K2-N	Emulsion
Etc.	Ceramic	Peter Wolters Fujisanki ...	W40~W190		EG-Q	





Resin Tools

www.shinhandia.co.kr



Head Office & Factory

36B – 10L, Namdong Industrial Complex, 610 – 9, Namchon-dong, Namdong-gu, Incheon, 405 – 100, South Korea
TEL. +82. 32. 814. 2211 FAX. +82. 32. 814. 1193 E-mail. webmaster@shinhandia.co.kr

R&BD Center

7 – 5, Songdo-dong, Yeonsu-gu, Songdo International City, Incheon, 406 – 840, South Korea
TEL. +82. 32. 814. 2211 FAX. +82. 32. 814. 1193 E-mail. webmaster@shinhandia.co.kr

USA

Shinhan Diamond America, Inc., 900 S. Ajax Ave. City of Industry, CA 91748, USA
TEL. +1. 626. 363. 9258 FAX. +1. 626. 363. 9259 E-mail. jkoh@shinhandia.co.kr

China

No. 45 Dongjing Road, Qingdao Free Trade Zone, Shandong Province, China
TEL. +86. 532. 8676. 8555 FAX. +86. 532. 8676. 8355 E-mail. webmaster@shinhandia.co.kr
Web. www.shinhandia.cn

Germany

Mergenthaleralle 79 – 81, 65760, Eschborn, Germany
TEL. +49. 6196. 775. 872 FAX. +49. 6196. 775. 874 E-mail. webmaster@shinhandia.co.kr

Shanghai

1633 room, 16/F Oriental Century Plaza, No. 345 Xian Xia Road, Shanghai, 200336, China
TEL. +86. 21. 6229. 2685 FAX. +86. 21. 6229. 2010 E-mail. webmaster@shinhandia.co.kr