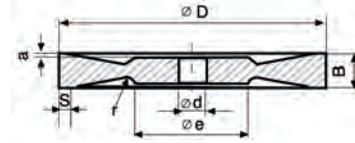


#### FORM F

Üç konik çanak zımpara taşı, Takım bilemek için  
Flaring cup wheel tapered inside for grinding tools

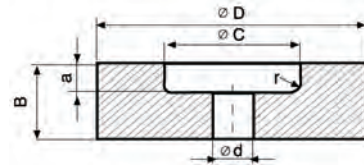


TİP 21

FORM	ØD	B	d	Øe	r	g
F100 x 6	100	6	20	50	5	1,5
F100 x 10	100	10	20	50	5	3
F150 x 6	150	6	20	70	5	1,5
F150 x 10	150	10	20	70	10	3(2,5)
F150 x 15	150	15	20	70	10	4,5(2,5)
F175 x 20	175	20	32(20)	70	10	6 (3)
F175 x 25	175	25	32(20)	70	10	7,5(4,5)

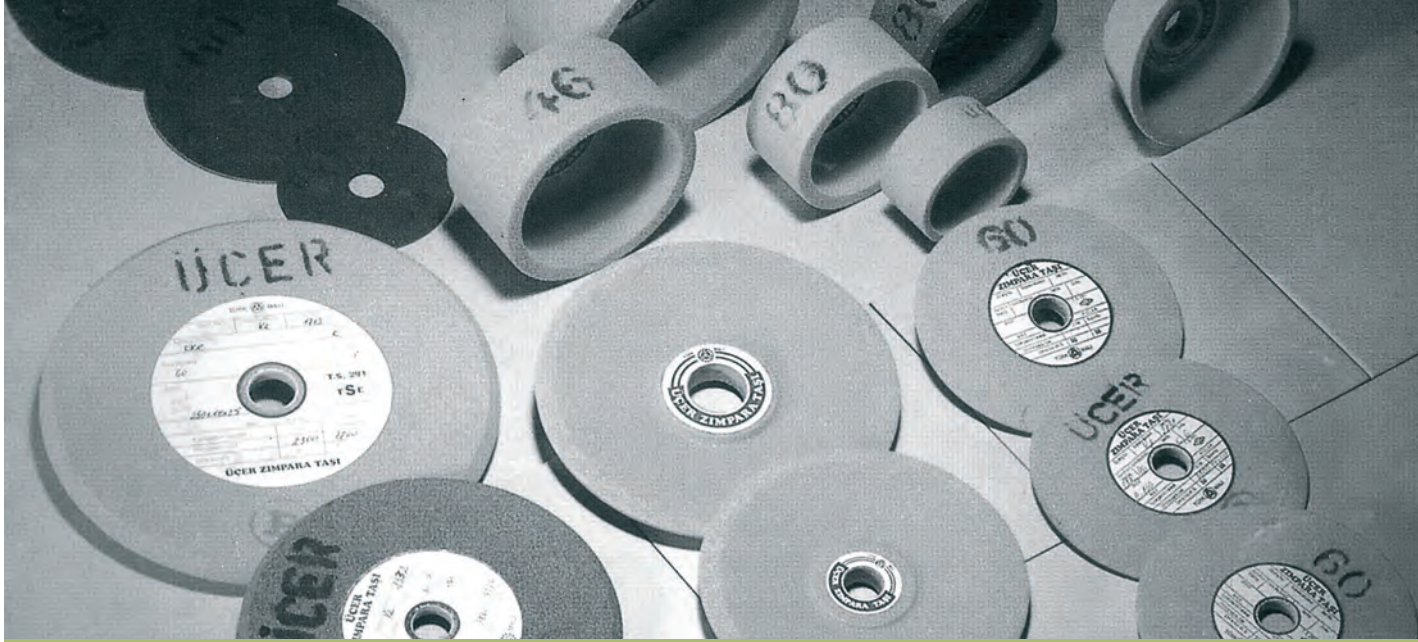
#### FORM G

Tek taraflı oyuklu zımpara taşı  
Grinding wheel recessed on one side



TİP 5 / TİP 23

FORM	ØD	B	Ød	a	Øc	r
G 150	150	32	20	20	80	3,2
G 175	175	32	32(51)	20	90	3,2
G 200	200	40	32(51)	25	110	3,2
(G 225)	225	40	51	25	135	5
G 250	250	40	76(51)	25	150	5
G 300	300	50(40)	76(127)	30(25)	150	5
G 350	350	63	127	41	210	6





## TAKIM BİLEME TAPLARI


TOOL GRINDING WHEELS

WERKZEUGSCHLEIFSCHEIBEN



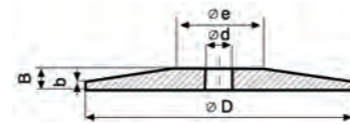
 HSS ve CARBON çeliðinden üretilen takımların bilenmesinde kullanılan Üçer Bileme Taðları EK 60 K 6 ke standart kalitede üretilmektedir. Ýstenilen taþın üretilmesinde müpteriden, taþın devir sayısı malzemenin cinsi, malzemenin sertliði soðutucu sıvı kullanıp kullanmadığı gibi bilgiler istenir. Bu bilgiler doğrultusunda yüzey pürüzlüğüne göre kum tane irilikleri deðiştirilerek arana yüzey kalitesi yakalanmış olur. Standartların dışında müpteri talepleri doğrultusunda yüzey pürüzlerine göre kum irilikleri deðiştirilerek istenilen yüzeylerde takım bileme taþı hazırlanabilmektedir.

 Üçer Tool Grinding Wheels, which are used for grinding the tools made of HSS and CARBON steel, are manufactured in line with the high quality standards. Before production of the grinding wheels, some specific information such as the RPM of the grinding wheel, type of the tool, hardness of material, and whether cooling fluid is used or not is required. In the light of this information, the size of the grit to be used is modified according to the roughness of the surface to achieve the required surface quality. Grinding wheels can be custom-made by modification of the grit size according to the requirements of the customer considering the surface roughness.

 Uçer Werkzeugschleifscheiben, welche für aus HSS-Stahl und Kohlenstoffstahl hergestellte Schleifwerkzeuge benutzt werden, werden im Hochqualitätsstandard erzeugt. Vor der Herstellung der Schleifscheiben werden einige Informationen benötigt; wie zum Beispiel die Drehzahl, die Art des Werkzeugs, die Härte des Werkzeugs, und ob die Kühlflüssigkeit verwendet wurde oder nicht. Mit Hilfe dieser Informationen werden die Größen der Sandstücke entsprechend der Rauheit der Oberfläche geändert und die abgezielte Oberfläche wird schließlich erreicht. Das Schleifen kann also vorbereitet werden, indem die Größen der Sandstücke entsprechend den Anforderungen der Kunden für die Oberfläche geändert werden.

#### FORM A

Bir tarafı konik Zımpara taþı, takım bilemek için  
Grinding wheel, tapered on one side, for grinding tools

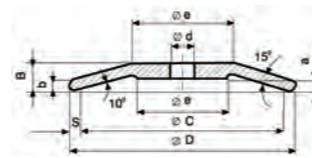


TİP 3

FORM	Ø D	B	Ø d	b	Ø e
A 75*	75	5	13	1	30
A 80	80	5	20 (13)	1	40 (30)
A 100	100	6	20	1.5	50
A 125	125	7	20 (32)	2	63 (68)
A 150	150	8	20 (32)	2	75 (83)
A 175	175	10	20 (32)	3	85 (95)
A 200	200	12 (14)	32 (20)	3	100 (95)
A 250	250	14	32 (20)	3	125

#### FORM B

Dimensions: D x B/b x d  
Torna edilmiş ve diþ açılmış frezelerin bilenmesi için tabak zımpara taþı  
Dish wheel for lathed and threaded milling cutters  
Tellerschleifscheibe für gedrehte und eingezogene Fräser

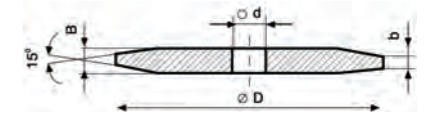


TİP 12 / TİP 13

FORM	Ø D	B	Ø d	a	b	Ø c	Ø e	s
B 75*	75	8	13	2	2	67	28	4
B 80	80	8	20	2	2	72	30	4
B 100	100	12	20	4	3	88	35	6
B 125	125	14	20	5	3	113	40	6
B 150	150	15	20	5	3	136	50	7
B 175	175	18	20	7	3	159	60	8
B 200	200	19	32	7	3	180	70	10
B 250	250	21	32	7	3	226	100	12

#### FORM C

Ýki tarafı konik, takım bilemek için zımpara taþı  
Grinding wheel, tapered on both sides for grinding tools

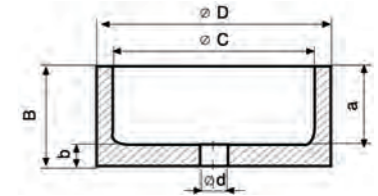


TİP 4

FORM	Ø D	B	Ø d	b
C 75*	75	8	13	2
C 80	80	8	20	2
C 100	100	9	20	2
C 125	125	10	20	2
C 150	150	12	20	2
C 175	175	14	20	3
C 200	200	16	32	3
C 250	250	19	32	4

#### FORM D

Düz çanak zımpara taþı  
Grinding wheel, tapered on both sides for grinding tools

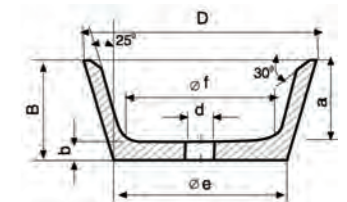


TİP 6

FORM	Ø D	B	Ø d	a	Ø C	r	s
D50	50	32	13	26	44	3	3(5)
(D63)	63	40	20	32	55	4	4
D75*	75	40	20	32	67	4	4
D80	80	40	20(13)	32	72	4	4(6)
D100	100	50(40)	20	40	90	4	5(8)
D125	125	63(50)	20(32)	51	110	5	7,5(8)
D150	150	80(63)	20(32)	64	130	5	10

#### FORM E

Konik çanak zımpara taþı  
Flaring cup wheel



TİP 11

FORM	Ø D	B	Ø d	a	Ø e	Ø f	a1
E50	50	25(32)	13	19	32(27)	25(22)	6
(E 63)	63	32	20	24	45	38	8
E 75*	75	30	20	22	53	45	8
E80	80	32	20(13)	24	55(57)	48(46)	6(8)
E100	100	35(40)	20	25	75(71)	65	10
E125	125	45(40)	20(32)	33	92(96)	80(81)	10(12)
E150	150	50	20(32)	38	114	100(96)	13(12)