

MICRO TOOL GRINDING WHEELS



SWISS PRODUCT



ACTION SUPER ABRASIVE SA

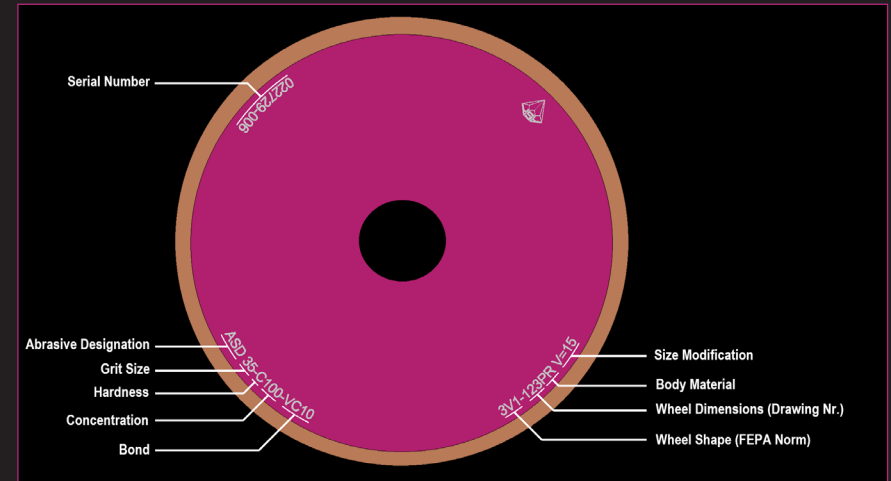


Order information

The following descriptions are required for processing your enquiries or orders. Furthermore, please also indicate the application of the wheel, used coolant and machine type.

It is important to inform us about the most important criteria required in expected balance between form hold, surface quality and grinding conditions.

Explanation engraving



Summary

Our know-how combined with years of collaboration in the Swiss watch and medical industry have given us a great advantage in developing Diamond & CBN grinding wheels regards manufacturing micro tools for every application.

Thanks to these many years of experience, we can offer you a wide range of grinding wheels including solution thinking support for most multi-axis CNC machines combined with delivery times within 2 to 3 weeks.

The number following the wheel shape (FEPA), determines all dimensions of the wheel, also we add additional space regards size modification or any other customer modification, for example an angle.

Most of the ASA grinding wheels are custom-made. Throughout our many years of experience, we have met a great deal of specific customer demands. Our main goal still lie today in the ability to respond within 2 to 3 weeks, to manufacture the grinding wheels according the customer specifications, dimensions and drawings.

«Promises kept. Deadlines met. Performance delivered.»

Cutting speed in meter per second Vc [m/s]

	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	35	40	45	50
250	1146	1222	1299	1375	1451	1528	1604	1681	1757	1833	1910	1986	2063	2139	2215	2292	2674	3056	3438	3820
200	1432	1528	1623	1719	1814	1910	2005	2101	2196	2292	2387	2483	2578	2674	2769	2865	3342	3820	4297	4775
175	1637	1746	1855	1964	2074	2183	2292	2401	2510	2619	2728	2838	2947	3056	3165	3274	3820	4365	4911	5457
150	1910	2037	2165	2292	2419	2546	2674	2801	2928	3056	3183	3310	3438	3565	3692	3820	4456	5093	5730	6366
125	2292	2445	2597	2750	2903	3056	3209	3361	3514	3667	3820	3973	4125	4278	4431	4584	5348	6112	6875	7639
100	2865	3056	3247	3438	3629	3820	4011	4202	4393	4584	4775	4966	5157	5348	5539	5730	6685	7639	8594	9549
75	3820	4074	4329	4584	4838	5093	5348	5602	5857	6112	6366	6621	6875	7130	7385	7639	8913	10186	11459	12732
50	5730	6112	6494	6875	7257	7639	8021	8403	8785	9167	9549	9931	10313	10195	11077	11459	13369	15279	17189	19099
40	7162	7639	8117	8594	9072	9549	10027	10504	10982	11459	11937	12414	12892	13369	13846	14324	16711	19099	21486	23873
Revolution per minute Ns [RPM]																				
Vc = Cutting speed in meter/second											$N_s = \frac{V_c \cdot 1000 \cdot 60}{\varnothing \cdot \pi}$					$V_c = \frac{N_s \cdot \varnothing \cdot \pi}{1000 \cdot 60}$				
Ns = Revolution per minute																				
∅ = Wheel diameter																				



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