

URDIAMANT

DIAMANTOVÉ NÁSTROJE PRO OPRACOVÁNÍ SKLA
DIAMOND TOOLS FOR GLASS GRINDING
DIAMANT- SCHLEIFSCHEIBEN FÜR GLASBEARBEITUNG



Diamantové nástroje pro opracování skla

Diamond tools for glass grinding

Diamant- Schleifscheiben für Glassbearbeitung

1.0 Úvod

Brousící kotouče s diamantem tvoří skupinu nástrojů vyráběných pod značkou URDIAMANT. Jsou určeny pro opracování skla, keramiky, porcelánu a pod.

2.0 Charakteristika brousícího kotouče

Brousící kotouč s diamantovým brusivem je charakterizován těmito základními znaky:

Typ kotouče.....	str. 2 ÷ 3
2.1 Druh pojiva.....	str. 4
2.2 Zrnitost brusiva.....	str. 4
2.3 Vliv zrnitosti brusiva.....	str. 4
2.4 Doporučené pracovní podmínky.....	str. 4
Rozměry.....	str. 5 ÷ 26

3.0 Způsob objednání

V objednávce je nutné uvést:

- 1) označení brousícího kotouče
14EE1 13 - 150 - 8/90
(tvar, rozměry)
- 2) druh pojiva BZ-S6/20
- 3) zrnitost diamantu D107

Pokud se vyskytne potřeba brousících kotoučů, které nejsou v tomto katalogu uvedeny, musí být objednávka projednána individuálně.

1.0 Introduction

Diamond grinding wheels are a group of tools which is produced with trademark URDIAMANT. They have been determined for machining of glass, ceramics, porcelain, etc.

2.0 Characterisation of the grinding wheel

The following datas are characteristic for the choice of the diamond wheel:

Type of the wheel.....	page 2 ÷ 3
2.1 Type of bond.....	page 4
2.2 Grain size of diamond.....	page 4
2.3 Influence of grain size.....	page 4
2.3 Recommend working condition.....	page 4
Dimensions.....	page str. 5 ÷ 26

3.0 How to order product

Each order has to contain following data:

- 1) indication of grinding wheel
14EE1 13 - 150 - 8/90
(shape, dimensions)
- 2) type of bond BZ-S6/20
- 3) grain size of diamond D107

Tool not mentioned in this catalogue can be settled with producer.

1.0 Einführung

Diamant-Schleifscheiben bilden die Gruppe der Werkzeuge, die unter Bezeichnung URDIAMANT hergestellt werden. Sie sind zur Anwendung Glas, Keramik und usw. bestimmt.

2.0 Charakteristik der Schleifscheibe

Die Schleifscheibe mit Diamant-Schleifmittel wird durch folgende Grundmerkmale:

Scheibenform.....	Seite 2 ÷ 3
2.1 Bindung.....	Seite 4
2.2 Korngröße.....	Seite 4
2.3 Einfluß der Korngröße.....	Seite 4
2.2 Schleifparameter.....	Seite 4
Abmessungen.....	Seite str. 5 ÷ 26

3.0 Bestellung

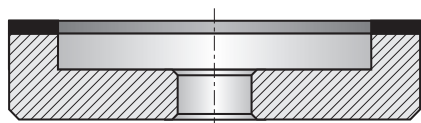
In der Bestellung ist nötig anführen:

- 1) Bezeichnung der Schleifscheibe
14EE1 13 - 150 - 8/90
(Form, Abmessungen)
- 2) Bindungsart BZ-S6/20
- 3) Diamant-Körnung D107

Im Fall, daß verlangte Schleifscheiben in diesem Katalog nicht angeführt sind, muss Ihre Bestellung individuell behandelt werden.

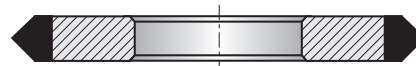
1-D-W/X

FEPA 6A2



13-D-U/V°

FEPA 1E1



1-D-W/X

FEPA 6A2



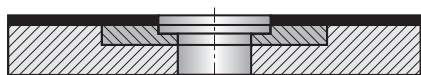
13-D-U/V°

FEPA 1E1



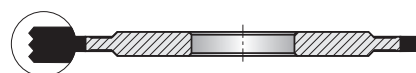
1-D-W/X

FEPA 6A2



13/3-D-U/V°

FEPA 14EEE1



1-D-W/X

FEPA 6A2



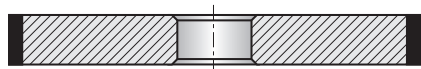
13-D-U/V°

FEPA 14E1



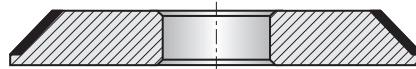
2-D-T/X

FEPA 1A1



15-D-W/V°

FEPA 1V9



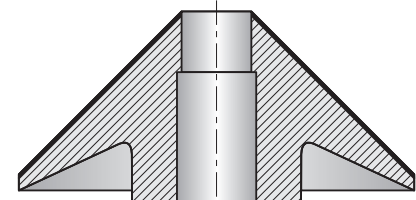
13-D-U/V°

FEPA 3E1



15-D-W/V°

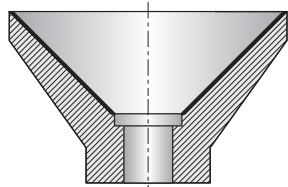
FEPA 1V9



16-D-W/V°

FEPA 12V10

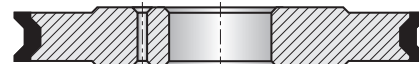
14



25-D-W/s-V°

FEPA 1DD1Y

22



20-D-R/W

FEPA 1FF1V

15



27-D-S-V°

FEPA 1Y9T

23



21-D-T/X-R

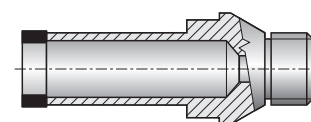
FEPA 1FF1

17



VRTÁKY / DRILLS / BOHRER

24



22-D-R/W/X

FEPA 1FF6Y

18



TABLETY / TABLETS / TABLETE

25



23-D-W/s-V°

FEPA 1DD6Y

20



PRSTENCE / RINGS / RINGE

25



27

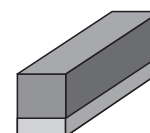
FEPA 1D6Y

21



HRANOLY / RECTANGLE / PRISMA

26



2.1 Druh pojiva

2.1 Type of bond

2.1 Bindung

POJIVO / BOND / BINDUNG	POUŽITÍ-SKLO / USE-GLASS / ANWENDUNG-GLASS
BZ-S6, BZ-S6/20, 30, 40, BZ-S1, BZ-ST10, BZ-ST20, BZ-ST30 (Měkké / Soft / Weich)	Ruční broušení / Hand grinding / Handschleifen
BZ-S6/50, BZ-XT10, BZ-XT20, BZ-XT30 (Tvrdé / Hard / Hard)	Strojní broušení / Machine grinding / Maschinenschleifen
K 03	Tablety, prstence, hranoly pro optiku Tablets, ring, rectangular for optics Tabletten, Ringen und Prismen für die Optik

2.2 Zrnitost brusiva

2.2 Grain size of diamond

2.2 Korngröße

ISO 6106 (FEPA)		US Standard ASTM-E-11-70	ČSN - 224015
Diamant / Diamond	KBN / CBN		
D 711	B 711	25/30	
D 601	B 601	30/35	630/500
D 501	B 501	35/40	500/400
D 426	B 426	40/45	400/315
D 356	B 356	45/50	315/250
D 301	B 301	50/60	250/200
D 251	B 251	60/70	200/160
D 213	B 213	70/80	160/125
D 181	B 181	80/100	125/100
D 151	B 151	100/120	100/80
D 126	B 126	120/140	80/63
D 107	B 107	140/170	63/50
D 91	B 91	170/200	50/40
D 76	B 76	200/230	40/28
D 64	B 64	230/270	36/25
D 54	B 54	270/325	
D 46	B 46	325/400	
D 39	B 39	400/500	

2.3 Vliv zrnitosti brusiva

2.3 Influence of grain size

2.3 Einfluß der Korngröße

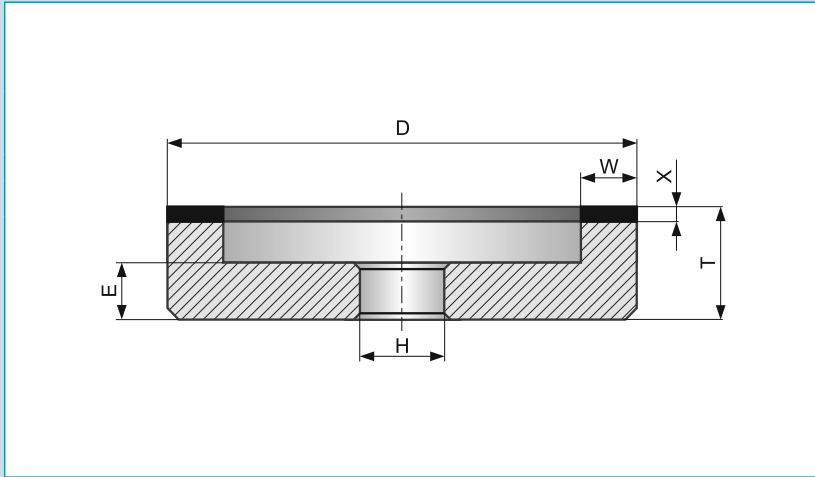
ZRNITOST GRAIN SIZE KORNGRÖßE	POUŽITÍ / USE / ANWENDUNG	ZRNITOST GRAIN SIZE KORNGRÖßE	POUŽITÍ / USE / ANWENDUNG
250/200	Pro účinné broušení a hrubování Effective grinding, roughing Effektives Schleifen und Schruppen	80/63	Pro dokončovací broušení Finishing grinding Fertigschleifen
200/160		63/50	
160/125		50/40	
125/100	Pro účinné broušení Effective grinding Effektives Schleifen	40/36	Pro jemné broušení (matování) Fine grinding (matting) Feinschleifen
100/80		36/25	
		25/20	

2.4 Doporučené pracovní podmínky

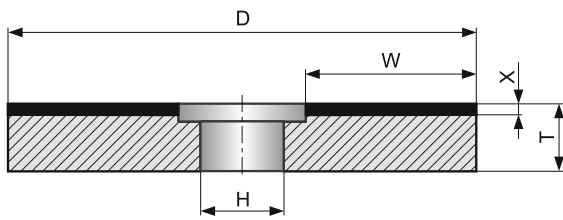
2.4 Recommended working condition

2.4 Schleifparameter

ZPŮSOB BROUŠENÍ WAY OF GRINDING SCHLEIFART	OBVODOVÁ RYCHLOST PERIPHERAL VELOCITY UMFANGSGESCHWINDIGKEIT
Broušení s ručním posuvem skla Grinding with the hand feed of glass Schleifen mit dem Handvorschub	Hrubování / Roughing / Schruppen Dokončování / Finishing / Fertigschleifen 25 - 30 m/s 25 - 30 m/s
Automatické broušení na linkách Grinding on automatic lines Automatischeschleifen	Hrubování / Roughing / Schruppen Dokončování / Finishing / Fertigschleifen 25 - 35 m/s 20 - 25 m/s


ROZMĚRY / DIMENSION / ABMESSUNGEN

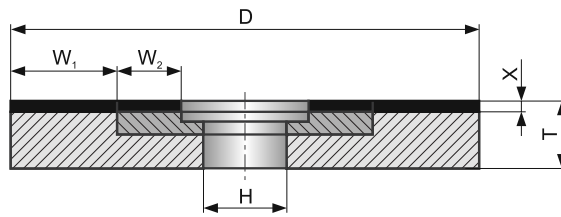
D	W	X						T - X	E	H
		1,5	2,0	3,0	4,0	5,0	8,0			
[mm]	[mm]							[mm]	[mm]	[mm]
50	2	●	●	●	●	-	-	20	10	20
75	10	●	●	●	●	-	-	20	10	13
100	10	●	●	●	●	-	-	23	10	20
	15	●	●	●	●	-	-	23	10	20
120	8	-	-	-	-	●	-	25	10	50
125	10	●	●	●	●	-	-	23	10	20
	15	●	●	●	●	-	-	23	10	20
150	6	●	●	●	●	-	-	30	10	30
	10	●	●	●	●	-	-	23	10	20
	15	●	●	●	●	-	-	23	10	20
	20	●	●	●	●	-	-	23	10	20
	25	●	●	●	●	-	-	25	10	20
175	10	●	●	●	●	-	-	25	13	32
	15	●	●	●	●	-	-	25	13	32
	20	●	●	●	●	-	-	25	13	32
	25	●	●	●	●	-	-	25	13	32
200	10	●	●	●	●	-	-	25	13	32
	15	●	●	●	●	-	-	25	13	32
	20	●	●	●	●	-	-	25	13	32
	25	●	●	●	●	-	-	25	13	32
250	10	●	●	●	●	-	-	25	13	32
	15	●	●	●	●	-	-	25	13	32
	20	●	●	●	●	-	-	25	13	32
	25	●	●	●	●	-	-	25	13	32



ROZMĚRY / DIMENSION / ABMESSUNGEN

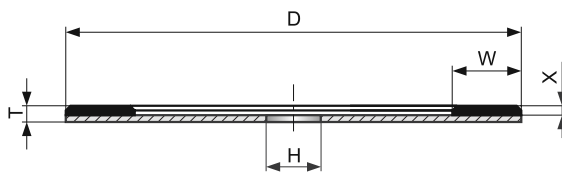
D	W	X	T	H
[mm]	[mm]	[mm]	[mm]	[mm]
175	50	+	+	+
200	50	+	+	+
250	50	+	+	+
	75	+	+	+
	117	+	+	+
300	60	+	+	+
355	135	+	+	+
500	145	+	+	+

- + Doporučený rozměr X = 1 ÷ 4 mm. T a H dle dohody.
- + Recommended dimension X = 1 ÷ 4 mm. T and H should be settled with the producer.
- + Empfohlene Abmessung X = 1 ÷ 4 mm. T und H sind mit Hersteller vereinbaren.


ROZMĚRY / DIMENSION / ABMESSUNGEN

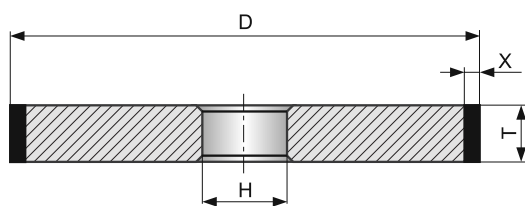
D	W ₁	W ₂	X	T	H
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]
500	72	135	+	+	+

- + Doporučený rozměr X = 1 ÷ 4 mm. T a H dle dohody.
- + Recommended dimension X = 1 ÷ 4 mm. T and H should be settled with the producer.
- + Empfohlene Abmessung X = 1 ÷ 4 mm. T und H sind mit Hersteller vereinbaren.


ROZMĚRY / DIMENSION / ABMESSUNGEN

D	W	X	T	H
[mm]	[mm]	[mm]	[mm]	[mm]
200	30	1,5	4,0	24

Přiskyřičné i kovové pojivo.
Resinoid and metal bond.
Kunstharzbindung und Metallbindung



ROZMĚRY / DIMENSION / ABMESSUNGEN

D	T	X	H
[mm]	[mm]	[mm]	[mm]
15	6	2	6
	8	2	6
20	6	2	2
	8	2	6
25	6	2	8
	8	2	10
30	8	2	10
	10	2	10
35	8	2	10
	10	2	10
40	8	2	10
	10	2	10
50	3	8	10
	4	8	10
	5	8	10
	8	2	10
	10	2	10
	12	2	10
60	8	2	13
	10	2	13
	12	2	13
75	10	2	13
80	3	10	13
	4	10	13
	5	10	13
	6	10	13
	7	10	13
100	3	10	20
	4	10	20
	5	10	20
	6	10	20
	7	10	20

ROZMĚRY / DIMENSION / ABMESSUNGEN

D	T	X	H
[mm]	[mm]	[mm]	[mm]
100	10	2	20
	20	2	20
	30	12	20
	40	5	20
125	10	2	20
	12	2	20
150	3	10	20
	4	10	20
	5	10	20
	6	10	20
	7	10	20
	10	2	20
	12	2	20
	20	2	20
	20	6	20
	30	12	20
175	10	2	32
	10	2	63,4 **
	12	2	32
	12	2	63,4 **
	20	2	32
200	20	2	63,4 **
	3	10	32
	4	10	32
	5	10	32
	6	10	32
	7	10	32
	10	3	32
	12	3	32
100	13	3	32
	15	3	32
	16	10	42

ROZMĚRY / DIMENSION / ABMESSUNGEN

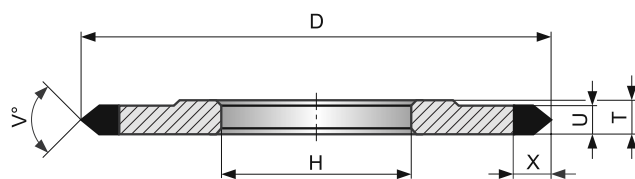
D	T	X	H
[mm]	[mm]	[mm]	[mm]
200	20	3	32
	20	10	42
	30	12	42
250	10	3	76
	10	12	42
	12	3	76
	15	3	76
	20	3	76
	25	3	76
	30	12	42
	60	3	76
300	80	3	76
	12	3	127
	16	10	42
	15	3	127
	20	3	127
	25	3	127
	30	12	42
350	12	4	+
	15	4	+
	20	4	+
	25	4	+

** 3 x Ø 8,4 x 120° / Ø 76

+) dle dohody / by agreement / laut Vereinbarung

13-D-U/V°

FEPA
3E1

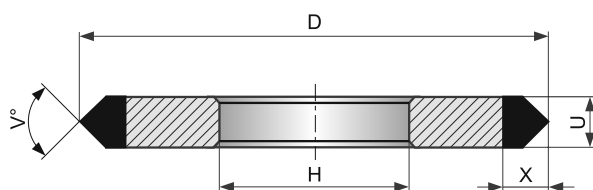


ROZMĚRY / DIMENSION / ABMESSUNGEN

D	U					X	V	H
	3	4	5	6	7			
[mm]						[mm]	[°]	[mm]
80	●	●	●	-	-	10	70 ÷ 135	42
100	●	●	●	●	●	10	70 ÷ 135	42
120	●	●	●	●	●	10	70 ÷ 135	42
150	●	●	●	●	●	10	70 ÷ 135	42
200	●	●	●	●	●	10	70 ÷ 135	42

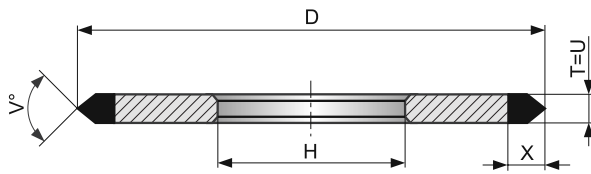
13-D-U/V°

FEPA
1E1



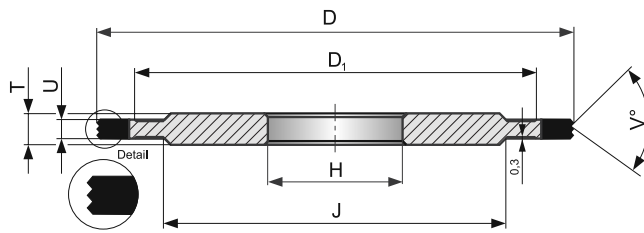
ROZMĚRY / DIMENSION / ABMESSUNGEN

D [mm]	U												H [mm]
	8		10		11		13		16		22		
	X	V	X	V	X	V	X	V	X	V	X	V	
50	8	85°÷130°	8	85°÷135°	-	-	8	85°÷130°	-	-	-	-	24
60	8	85°÷130°	8	85°÷135°	-	-	8	85°÷130°	-	-	-	-	32
80	12	85°÷130°	12	85°÷130°	12	80°÷130°	12	85°÷130°	12	100°÷130°	12	100°÷130°	42
100	12	85°÷130°	12	85°÷130°	12	80°÷130°	12	85°÷130°	12	100°, 120°, 130°	12	100°, 120°, 130°	42

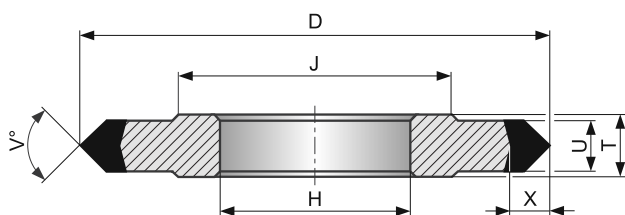


ROZMĚRY / DIMENSION / ABMESSUNGEN

D	U					X	V	H
	3	4	5	6	7			
[mm]						[mm]	[°]	[mm]
50	●	●	●	-	-	10	70 ÷ 90	24
80	●	●	●	●	●	10	70 ÷ 135	42
100	●	●	●	●	●	10	70 ÷ 135	42
120	●	●	●	●	●	10	70 ÷ 135	42
150	●	●	●	●	●	10	70 ÷ 135	42
200	●	●	●	●	●	10	70 ÷ 135	42



Označení Marking Bezeichnung	ROZMĚRY / DIMENSION / ABMESSUNGEN						
	D	D ₁	J	H	T	U	V
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[°]
13/3 - 100 - 6 - 100°	100	77	60	42	8	6	100
13/3 - 100 - 6 - 105°	100	77	60	42	8	6	105
13/3 - 100 - 8 - 105°	100	77	60	42	10	8	105
13/3 - 120 - 6 - 100°	120	97	78	42	8	6	100
13/3 - 120 - 8 - 100°	120	97	78	42	10	8	100
13/3 - 120 - 8 - 105°	120	97	78	42	10	8	105
13/3 - 150 - 5 - 95°	150	127	108	42	7	5	95
13/3 - 150 - 6 - 90°	150	127	108	42	8	6	90
13/3 - 150 - 6 - 100°	150	127	108	42	8	6	100
13/3 - 150 - 8 - 90°	150	127	108	42	10	8	90
13/3 - 150 - 8 - 100°	150	127	108	42	10	8	100
13/3 - 150 - 8 - 105°	150	127	108	42	10	8	105
13/3 - 200 - 6 - 100°	200	177	158	42	8	6	100
13/3 - 200 - 8 - 105°	200	177	158	42	10	8	105
13/3 - 200 - 10 - 100°	200	177	158	42	12	10	100
13/3 - 200 - 10 - 105°	200	177	158	42	12	10	105

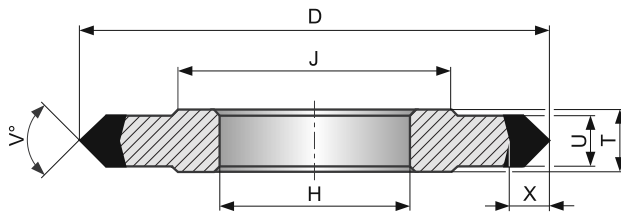


ROZMĚRY / DIMENSION / ABMESSUNGEN

D	T	U							X	V	H	J
		8	10	11	13	16	18	22				
[mm]	[mm]								[mm]	[°]	[mm]	[mm]
120	10	●	-	-	-	-	-	-	12	75 ÷ 135	42	70
	12	-	●	-	-	-	-	-	12	80 ÷ 130	42	70
	13	-	-	●	-	-	-	-	12	80 ÷ 130	42	70
	15	-	-	-	●	-	-	-	12	80 ÷ 130	42	70
	18	-	-	-	-	●	-	-	12	115, 130	42	70
	20	-	-	-	-	-	●	-	12	115	42	70
	24	-	-	-	-	-	-	●	12	100, 115, 120	42	70
	24	-	-	-	-	-	-	●	15	80 ÷ 90	42	70
150	10	●	-	-	-	-	-	-	12	80 ÷ 130	42	106
	12	-	●	-	-	-	-	-	12	80 ÷ 130	42	106
	13	-	-	●	-	-	-	-	12	80 ÷ 130	42	106
	15	-	-	-	●	-	-	-	12	80 ÷ 130	42	106
	18	-	-	-	-	●	-	-	12	90, 120, 130	42	106
	24	-	-	-	-	-	-	●	12	100 ÷ 135	42	106
	24	-	-	-	-	-	-	●	15	80 ÷ 90	42	106
200	10	●	-	-	-	-	-	-	12	80 ÷ 130	42	135
	12	-	●	-	-	-	-	-	12	80 ÷ 130	42	135
	13	-	-	●	-	-	-	-	12	80 ÷ 130	42	135
	15	-	-	-	●	-	-	-	12	80 ÷ 130	42	135
	18	-	-	-	-	●	-	-	12	80 ÷ 130	42	135
	24	-	-	-	-	-	-	●	12	100 ÷ 130	42	135
	24	-	-	-	-	-	-	●	15	80 ÷ 90	42	135
250	10	●	-	-	-	-	-	-	12	80 ÷ 130	42	198
	12	-	●	-	-	-	-	-	12	80 ÷ 130	42	198
	13	-	-	●	-	-	-	-	12	80 ÷ 130	42	198
	15	-	-	-	●	-	-	-	12	80 ÷ 130	42	198
	18	-	-	-	-	●	-	-	12	80 ÷ 130	42	198
	24	-	-	-	-	-	-	●	12	120	42	198
	24	-	-	-	-	-	-	●	15	80 ÷ 90	42	198
300	10	●	-	-	-	-	-	-	12	80 ÷ 130	42	248
	12	-	●	-	-	-	-	-	12	80 ÷ 130	42	248
	13	-	-	●	-	-	-	-	12	80 ÷ 130	42	248

13-D-U/V°

FEPA
14E1

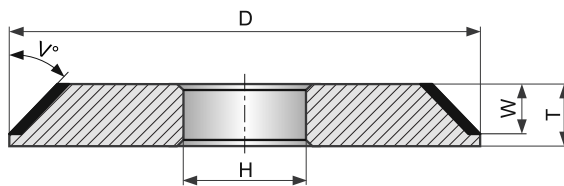


ROZMĚRY / DIMENSION / ABMESSUNGEN

D	T	U							X	V	H	J
		8	10	11	13	16	18	22				
[mm]	[mm]								[mm]	[°]	[mm]	[mm]
300	15	-	-	-	●	-	-	-	12	80 ÷ 130	42	248
	18	-	-	-	-	●	-	-	12	80 ÷ 130	42	248
	24	-	-	-	-	-	-	●	12	100 ÷ 130	42	248
	24	-	-	-	-	-	-	●	15	80 ÷ 90	42	248

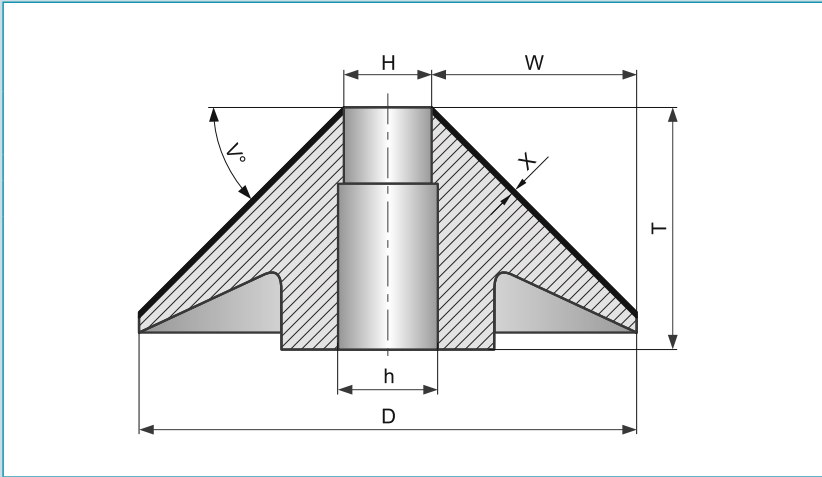
15-D-W/V°

FEPA
1V9



ROZMĚRY / DIMENSION / ABMESSUNGEN

D	W	T	H	V
[mm]	[mm]	[mm]	[mm]	[°]
175	3,5	7	63,4x3xØ8,4x120°/Ø76	45
200	4,5	6,7	50,8	45
200	12	12	63,4x3xØ8,4x120°/Ø76	45
200	12	12	32,0	45

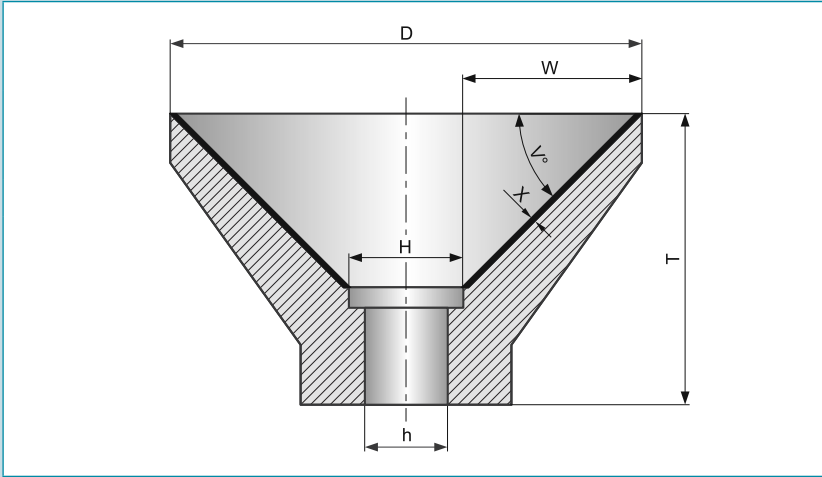


urdiamant

15-D-W/V°

FEPA
1V9

Označení Marking Bezeichnung	ROZMĚRY / DIMENSION / ABMESSUNGEN					
	D	W	X	H	T	V
	[mm]	[mm]	[mm]	[mm]	[mm]	[°]
15 -100 - 42,5/30°	100	42,5	1,5	15	42	30°
15 - 100 - 42,5/45°	100	42,5	1,5	15	46	45°
15 - 125 - 55/30°	125	55	1,5	15	42	30°
15 - 125 - 55/45°	125	55	1,5	15	58	45°

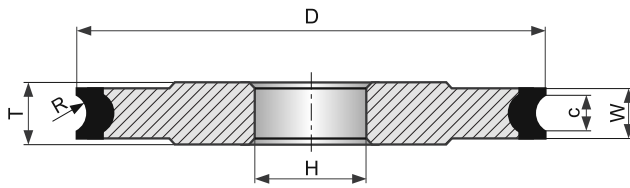


urdiamant

16-D-W/V°

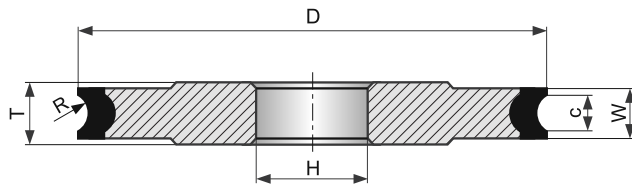
FEPA
12V10

Označení Marking Bezeichnung	ROZMĚRY / DIMENSION / ABMESSUNGEN					
	D	W	X	H	T	V
	[mm]	[mm]	[mm]	[mm]	[mm]	[°]
16 - 100 - 40/30°	100	40	1,5	15	55	30°
16 - 100 - 40/45°	100	40	1,5	15	71	45°
16 - 125 - 52,5/30°	125	52,5	1,5	15	61	30°
16 - 125 - 52,5/45°	125	52,5	1,5	15	83	45°



ROZMĚRY / DIMENSION / ABMESSUNGEN							Sklo Glass
D	W	c	h	R	H	T	
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]
100	5	2,4	1	1,25	22	9,0	2
	6	4,0	1,3	2,2	22	10,0	3
	7	5,0	1,5	2,8	22	10,5	4
	8	6	1,7	3,5	22	12,0	5
	9	7	1,7	4,5	22	13	6
	11	9	2	6,0	22	14	8
	13	11	2,7	7	22	17	10
	13	12	2	10	22	17	10
	15	13	3	8,5	22	19	12
120	5	2,4	1	1,25	22	9	2
	6	4	1,3	2,2	22	10	3
	7	5	1,5	2,8	22	10,5	4
	8	6	1,7	3,5	22	12	5
	9	7	1,7	4,5	22	13	6
	11	9	2	6	22	14	8
	13	11	2,7	7	22	17	10
	13	12	2	10	22	17	10
	15	13	3	8,5	22	19	12
150	5	2,4	1	1,25	22	9	2
	6	4	1,3	2,2	22	10	3
	7	5	1,5	2,8	22	10,5	4
	8	6	1,7	3,5	22	12	5
	9	7	1,7	4,5	22	13	6
	11	9	2	6	22	14	8
	13	11	2,7	7	22	17	10
	13	12	2	10	22	17	10
	15	13	3	8,5	22	19	12
175	5	2,4	1	1,25	60 *	9	2
	5	2,4	1	1,25	63,4 **	9	2
	6	4	1,3	2,2	60 *	10	3
	6	4	1,3	2,2	63,4 **	10	3
	7	5	1,5	2,8	60 *	10,5	4

ROZMĚRY / DIMENSION / ABMESSUNGEN							Sklo Glass	
D	W	c	h	R	H	T		
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	
175	7	5	1,5	2,8	63,4 **	10,5	4	
	8	6	1,7	3,5	60 *	12	5	
	8	6	1,7	3,5	63,4 **	12	5	
	9	7	1,7	4,5	60 *	13	6	
	9	7	1,7	4,5	63,4 **	13	6	
	11	9	2	6	60 *	14	8	
	11	9	2	6	63,4 **	14	8	
	13	11	2,7	7	60 *	17	10	
	13	11	2,7	7	63,4 **	17	10	
	13	12	2	10	60 *	17	10	
	13	12	2	10	63,4 **	17	10	
	15	13	3	8,5	60 *	19	12	
	15	13	3	8,5	63,4 **	19	12	
	200	6	4	1,3	2,2	60 *	10	3
		7	5	1,5	2,8	60 *	10,5	4
8		6	1,7	3,5	60 *	12	5	
9		7	1,7	4,5	60 *	13	6	
11		9	2	6	60 *	14	8	
250	5	2,4	1	1,25	60 *	10	2	
	5,5	3,9	1,6	2	191,3 ***	16,5	3	
	5,5	3,3	0,7	2	191,3 ***	16,5	3	
	5,5	3,3	0,7	2	177,8	19,5	3	
	5,5	3	0,7	2	60 *	10	3	
250	8	6	2	3,25	191,3 ***	16,5	4	
	8	6	2	3,25	177,8	19,5	4	
	8	6	2	3,25	60 *	10	4	
	8,8	6,6	1,7	4	191,3 ***	16,5	5	
	8,8	6,6	1,7	4	177,8	19,5	5	
	8,8	6,6	1,7	4	60 *	12	5	



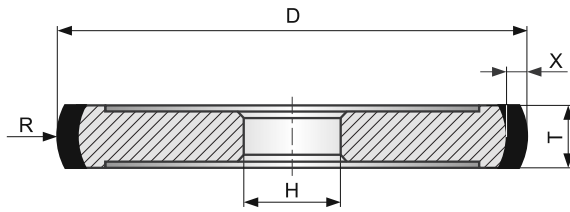
ROZMĚRY / DIMENSION / ABMESSUNGEN

ROZMĚRY / DIMENSION / ABMESSUNGEN							Sklo Glass
D	W	c	h	R	H	T	
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]
250	9,5	7,1	1,7	4,6	177,8	19,5	6
	9,5	7,1	1,7	4,6	60 *	14	6
	12	10	3,2	5,5	177,8	17,5	8
	14	12	4	6,5	177,8	17,5	10
	20	14	4,1	8	140	32	12
	24	20	3,8	15	140	32	16

* 3 × Ø 9 × 120° / Ø 100

** 3 × Ø 8,4 × 120° / Ø 76

*** 6 × M8 × 60° / Ø 216

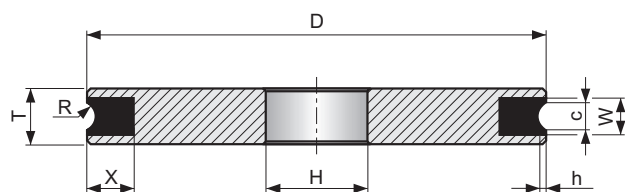


ROZMĚRY / DIMENSION / ABMESSUNGEN

D	T	R	X	H
[mm]	[mm]	[mm]	[mm]	[mm]
30	8	8,5	2,0	13
50	6	die dohody by settlement nach dem Vereinbarung	die dohody by settlement nach dem Vereinbarung	24
	8			24
	10			24
	13			24
	16			24
	22			24
75	8	8,5	2,0	13
80	6	die dohody by settlement nach dem Vereinbarung	die dohody by settlement nach dem Vereinbarung	42
	8			42
	10			42
	13			42
	16			42
	22			42
	30			42
100	6	die dohody by settlement nach dem Vereinbarung	die dohody by settlement nach dem Vereinbarung	42
	8			42
	10			42
	13			42
	16			42
	22			42
	30			42
120	6	die dohody by settlement nach dem Vereinbarung	die dohody by settlement nach dem Vereinbarung	42
	8			42
	10			42
	13			42
	16			42
	22			42
	30			42

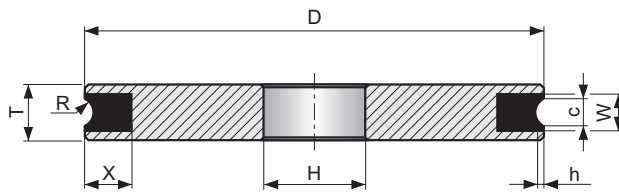
ROZMĚRY / DIMENSION / ABMESSUNGEN

D	T	R	X	H
[mm]	[mm]	[mm]	[mm]	[mm]
125	12	12,5	2,0	13
150	6	die dohody by settlement nach dem Vereinbarung	die dohody by settlement nach dem Vereinbarung	42
	8			42
	10			42
	13			42
	16			42
	22			42
	30			42
200	6	die dohody by settlement nach dem Vereinbarung	die dohody by settlement nach dem Vereinbarung	42
	8			42
	10			42
	13			42
	16			42
	22			42
	30			42
250	8	die dohody by settlement nach dem Vereinbarung	die dohody by settlement nach dem Vereinbarung	42
	10			42
	13			42
	16			42
	22			42
	30			42
	300			10
13		42		
16		42		
22		42		
30		42		



ROZMĚRY / DIMENSION / ABMESSUNGEN								Sklo Glass
D	W	R	c	h	T	H	x	
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]
100	5	1,25	2,4	1	9	22	10	2
	6	2,2	4	1,3	10	22	10	3
	7	2,8	5	1,5	11	22	10	4
	8	3,5	6	1,7	12	22	10	5
	9	4,5	7	1,7	13	22	10	6
	11	6	9	2	15	22	10	8
	13	7	11	2,7	17	22	10	10
	15	8,5	13	3	19	22	10	12
120	5	1,25	2,4	1	9	22	10	2
	6	2,2	4	1,3	10	22	10	3
	7	2,8	5	1,5	11	22	10	4
	8	3,5	6	1,7	12	22	10	5
	9	4,5	7	1,7	13	22	10	6
	11	6	9	2	15	22	10	8
	13	7	11	2,7	17	22	10	10
	15	8,5	13	3	19	22	10	12
150	5	1,25	2,4	1	9	22	10	2
	6	2,2	4	1,3	10	22	10	3
	7	2,8	5	1,5	11	22	10	4
	8	3,5	6	1,7	12	22	10	5
	9	4,5	7	1,7	13	22	10	6
	11	6	9	2	15	22	10	8
	13	7	11	2,7	17	22	10	10
	15	8,5	13	3	19	22	10	12
175	5	1,25	2,4	1	9	22	10	2
	5	1,25	2,4	1	9	60 *	10	2
	5	1,25	2,4	1	9	63,4 **	10	2
	6	2,2	4	1,3	10	60 *	10	3
	6	2,2	4	1,3	10	63,4 **	10	3
	7	2,8	5	1,5	11	60 *	10	4
	7	2,8	5	1,5	11	63,4 **	10	4
	8	3,5	6	1,7	12	60 *	10	5

ROZMĚRY / DIMENSION / ABMESSUNGEN								Sklo Glass	
D	W	R	c	h	T	H	x		
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	
175	8	3,5	6	1,7	12	63,4 **	10	5	
	9	4,5	7	1,7	13	60 *	10	6	
	9	4,5	7	1,7	13	63,4 **	10	6	
	11	6	9	2	15	60 *	10	8	
	11	6	9	2	15	63,4 **	10	8	
	13	7	11	2,7	17	60 *	10	10	
	13	7	11	2,7	17	63,4 **	10	10	
	15	8,5	13	3	19	60 *	10	12	
	15	8,5	13	3	19	63,4 **	10	12	
	200	5	1,25	2,4	1	9	60 *	10	2
6		2,2	4	1,3	10	60 *	10	3	
7		2,8	5	1,5	11	60 *	10	4	
8		3,5	6	1,7	12	60 *	10	5	
9		4,5	7	1,7	13	60 *	10	6	
11		6	9	2	15	60 *	10	8	
13		7	11	2,7	17	60 *	10	10	
15		8,5	13	3	19	60 *	10	12	
250		5	1,25	2,4	1	9	191,3 ***	10	2
		5	1,25	2,4	1	9	177,8	10	2
	5	1,25	2,4	1	9	60 *	10	2	
	6	2,2	4	1,3	10	191,3 ***	10	3	
	6	2,2	4	1,3	10	177,8	10	3	
	6	2,2	4	1,3	10	60 *	10	3	
	7	2,8	5	1,5	11	191,3 ***	10	4	
	7	2,8	5	1,5	11	177,8	10	4	
	7	2,8	5	1,5	11	60 *	10	4	
	8	3,5	6	1,7	12	191,3 ***	10	5	
	8	3,5	6	1,7	12	177,8	10	5	
	8	3,5	6	1,7	12	60 *	10	5	
	9	4,5	7	1,7	13	191,3 ***	10	6	
	9	4,5	7	1,7	13	177,8	10	6	
9	4,5	7	1,7	13	60 *	10	6		



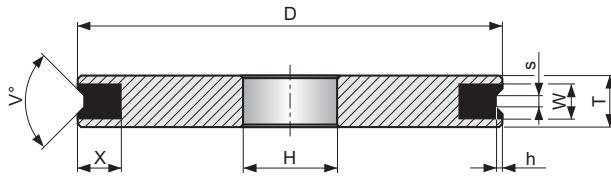
ROZMĚRY / DIMENSION / ABMESSUNGEN

Sklo
Glass

D	W	R	c	h	T	H	x	
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]
250	11	6	9	2	15	191,3 ^{***}	10	8
	11	6	9	2	15	177,8	10	8
	11	6	9	2	15	60 [*]	10	8
	13	7	11	2,7	17	191,3 ^{***}	10	10
	13	7	11	2,7	17	177,8	10	10
	13	7	11	2,7	17	60 [*]	10	10
	15	8,5	13	3	19	191,3 ^{***}	10	12
	15	8,5	13	3	19	177,8	10	12
	15	8,5	13	3	19	60 [*]	10	12

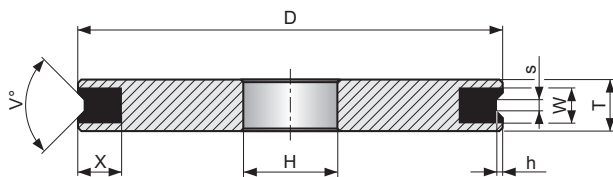
* 3 x Ø 9 x 120° / Ø 100

*** 6 x M8 x 60° / Ø 216



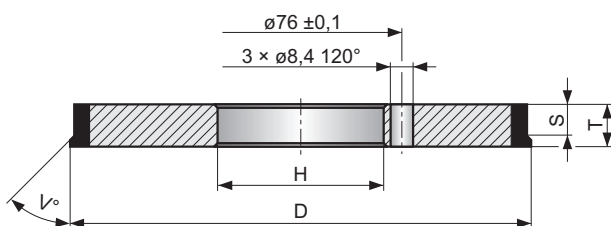
Označení Marking Bezeichnung	ROZMĚRY / DIMENSION / ABMESSUNGEN								Sklo Glass
	D	T	W	s	h	H	V	x	
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[°]	[mm]	[mm]
23 - 100 - 4/2 - 45°	100	10	4	2	1	22	90	~10	3
23 - 100 - 5/2,5 - 45°	100	11	5	2,5	1,25	22	90	10	4
23 - 100 - 6/3 - 45°	100	12	6	3	1,5	22	90	10	5
23 - 100 - 7/4 - 45°	100	13	7	4	1,5	22	90	10	6
23 - 100 - 9/6 - 45°	100	15	9	6	1,5	22	90	10	8
23 - 100 - 11/8 - 45°	100	17	11	8	1,5	22	90	10	10
23 - 120 - 4/2 - 45°	120	10	4	2	1	22	90	10	3
23 - 120 - 5/2,5 - 45°	120	11	5	2,5	1,25	22	90	10	4
23 - 120 - 6/3 - 45°	120	12	6	3	1,5	22	90	10	5
23 - 120 - 7/4 - 45°	120	13	7	4	1,5	22	90	10	6
23 - 120 - 9/6 - 45°	120	15	9	6	1,5	22	90	10	8
23 - 120 - 11/8 - 45°	120	17	11	8	1,5	22	90	10	10
23 - 150 - 4/2 - 45°	150	10	4	2	1	22	90	10	3
23 - 150 - 5/2,5 - 45°	150	11	5	2,5	1,25	22	90	10	4
23 - 150 - 6/3 - 45°	150	12	6	3	1,5	22	90	10	5
23 - 150 - 7/4 - 45°	150	13	7	4	1,5	22	90	10	6
23 - 150 - 9/6 - 45°	150	15	9	6	1,5	22	90	10	8
23 - 150 - 11/8 - 45°	150	17	11	8	1,5	22	90	10	10
23 - 175 - 4/2 - 45°	175	10	4	2	1	60*	90	10	3
23 - 175 - 4/2 - 45°	175	10	4	2	1	63,4**	90	10	3
23 - 175 - 5/2,5 - 45°	175	11	5	2,5	1,25	60*	90	10	4
23 - 175 - 5/2,5 - 45°	175	11	5	2,5	1,25	63,4**	90	10	4
23 - 175 - 6/3 - 45°	175	12	6	3	1,5	60*	90	10	5
23 - 175 - 6/3 - 45°	175	12	6	3	1,5	63,4**	90	10	5
23 - 175 - 7/4 - 45°	175	13	7	4	1,5	60*	90	10	6
23 - 175 - 7/4 - 45°	175	13	7	4	1,5	63,4**	90	10	6
23 - 175 - 9/6 - 45°	175	15	9	6	1,5	60*	90	10	8
23 - 175 - 9/6 - 45°	175	15	9	6	1,5	63,4**	90	10	8
23 - 175 - 11/8 - 45°	175	17	11	8	1,5	60*	90	10	10
23 - 175 - 11/8 - 45°	175	17	11	8	1,5	63,4**	90	10	10

* 3 x Ø 9 x 120° / Ø 100 ** 3 x Ø 8,4 x 120° / Ø 76

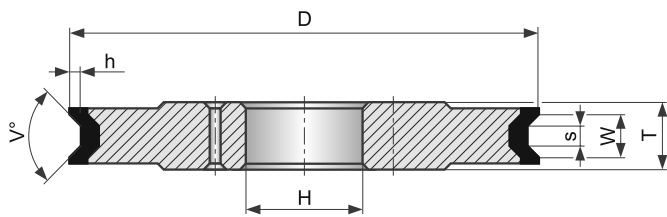


Označení Marking Bezeichnung	ROZMĚRY / DIMENSION / ABMESSUNGEN								Sklo Glass
	D	T	W	s	h	H	V	x	
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[°]	[mm]	[mm]
23 - 200 - 4/2 - 45°	200	10	4	2	1	60*	90	10	3
23 - 200 - 5/2,5 - 45°	200	11	5	2,5	1,25	60*	90	10	4
23 - 200 - 6/3 - 45°	200	12	6	3	1,5	60*	90	10	5
23 - 200 - 7/4 - 45°	200	13	7	4	1,5	60*	90	10	6
23 - 200 - 9/6 - 45°	200	15	9	6	1,5	60*	90	10	8
23 - 200 - 11/8 - 45°	200	17	11	8	1,5	60*	90	10	10

* 3 x ∅ 9 x 120° / ∅ 100 ** 3 x ∅ 8,4 x 120° / ∅ 76

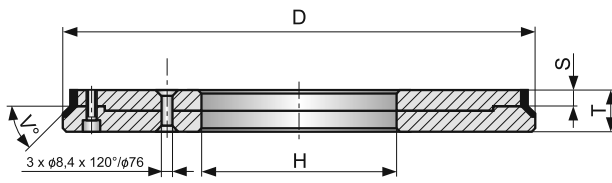


Označení Marking Bezeichnung	ROZMĚRY / DIMENSION / ABMESSUNGEN				
	D	S	T	H	V
	[mm]	[mm]	[mm]	[mm]	[°]
27 - 175 - 12/16 - 45°	175	12	16	63,4	45
27 - 175 - 10/14 - 45°	175	10	14	6,34	45



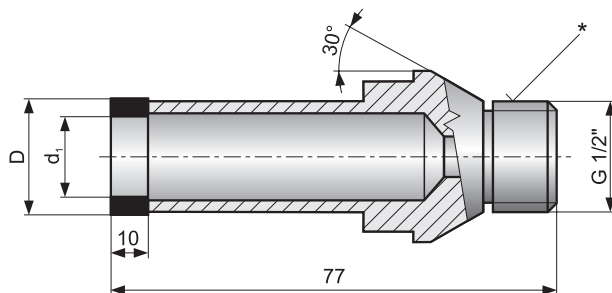
Označení Marking Bezeichnung	ROZMĚRY / DIMENSION / ABMESSUNGEN							Sklo Glass
	D	T	W	s	h	H	V	
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[°]	[mm]
25 - 100 - 4/2 - 45°	100	11	4	2	1	22	90	3
25 - 100 - 5/2,5 - 45°	100	12	5	2,5	1,25	22	90	4
25 - 100 - 6/3 - 45°	100	13	6	3	1,5	22	90	5
25 - 100 - 7/4 - 45°	100	14	7	4	1,5	22	90	6
25 - 100 - 9/6 - 45°	100	16	9	6	1,5	22	90	8
25 - 100 - 11/8 - 45°	100	18	11	8	1,5	22	90	10
25 - 150 - 4/2 - 45°	150	11	4	2	1	22	90	3
25 - 150 - 5/2,5 - 45°	150	12	5	2,5	1,25	22	90	4
25 - 150 - 6/3 - 45°	150	13	6	3	1,5	22	90	5
25 - 150 - 7/4 - 45°	150	14	7	4	1,5	22	90	6
25 - 150 - 9/6 - 45°	150	16	9	6	1,5	22	90	8
25 - 150 - 11/8 - 45°	150	18	11	8	1,5	22	90	10
25 - 175 - 4/2 - 45°	175	11	4	2	1	60 *	90	3
25 - 175 - 4/2 - 45°	175	11	4	2	1	63,4 **	90	3
25 - 175 - 5/2,5 - 45°	175	12	5	2,5	1,25	60 *	90	4
25 - 175 - 5/2,5 - 45°	175	12	5	2,5	1,25	63,4 **	90	4
25 - 175 - 6/3 - 45°	175	13	6	3	1,5	60 *	90	5
25 - 175 - 6/3 - 45°	175	13	6	3	1,5	63,4 **	90	5
25 - 175 - 7/4 - 45°	175	14	7	4	1,5	60 *	90	6
25 - 175 - 7/4 - 45°	175	14	7	4	1,5	63,4 **	90	6
25 - 175 - 9/6 - 45°	175	16	9	6	1,5	60 *	90	8
25 - 175 - 9/6 - 45°	175	16	9	6	1,5	63,4 **	90	8
25 - 175 - 11/8 - 45°	175	18	11	8	1,5	60 *	90	10
25 - 175 - 11/8 - 45°	175	18	11	8	1,5	63,4 **	90	10
25 - 200 - 4/2 - 45°	200	11	4	2	1	60 *	90	3
25 - 200 - 5/2,5 - 45°	200	12	5	2,5	1,25	60 *	90	4
25 - 200 - 6/3 - 45°	200	13	6	3	1,5	60 *	90	5
25 - 200 - 7/4 - 45°	200	14	7	4	1,5	60 *	90	6
25 - 200 - 9/6 - 45°	200	16	9	6	1,5	60 *	90	8
25 - 200 - 11/8 - 45°	200	18	11	8	1,5	60 *	90	10

* 3 x Ø 9 x 120° / Ø 100 ** 3 x Ø 8,4 x 120° / Ø 76



Označení Marking Bezeichnung	ROZMĚRY / DIMENSION / ABMESSUNGEN				
	D	S	T	H	V
	[mm]	[mm]	[mm]	[mm]	[°]
27 - 175 - 3 - 45°	175	3	11,5	63,4 × 3 × Ø 8,4×120° / Ø 76	45
27 - 175 - 4 - 45°	175	4	12,5	63,4 × 3 × Ø 8,4×120° / Ø 76	45
27 - 175 - 5 - 45°	175	5	13,5	63,4 × 3 × Ø 8,4×120° / Ø 76	45
27 - 175 - 6 - 45°	175	6	14,5	63,4 × 3 × Ø 8,4×120° / Ø 76	45
27 - 175 - 7 - 45°	175	7	15,5	63,4 × 3 × Ø 8,4×120° / Ø 76	45
27 - 175 - 10 - 45°	175	10	18,5	63,4 × 3 × Ø 8,4×120° / Ø 76	45
27 - 175 - 12 - 45°	175	12	20,5	63,4 × 3 × Ø 8,4×120° / Ø 76	45

VRTÁKY DRILLS BOHRER



- *) dle požadavku - válcová upínací část o $\varnothing 12,5$ mm bez závitů
- *) nach Wunsch - zylindrische Spannteil mit $\varnothing 12,5$ mm ohne Gewinde
- *) by requirement - cylindrical clamping segment $\varnothing 12,5$ mm without thread

Označení / Marking / Bezeichnung

		D		d ₁
		[mm]		[mm]
46	-	5	-	3,5
46	-	6	-	4,5
46	-	7	-	5,5
46	-	8	-	6,5
46	-	9	-	7,5
46	-	10	-	8,5
46	-	11	-	9,5
46	-	12	-	10,5
46	-	13	-	11,5
46	-	13,5	-	15
46	-	14	-	12,5
46	-	15	-	13,5
46	-	16	-	14,5
46	-	17	-	15,5
46	-	18	-	16,5
46	-	19	-	17,5
46	-	20	-	18,5
46	-	22	-	20,5
46	-	23	-	21
46	-	24	-	22,5
46	-	25	-	23,5
46	-	26	-	24,5
46	-	26,5	-	24,5
46	-	27	-	25,5
46	-	28	-	26,5
46	-	30	-	28,5
46	-	32	-	30
46	-	35	-	33
46	-	36	-	34
46	-	37	-	35
46	-	38	-	36
46	-	38,5	-	36

Označení / Marking / Bezeichnung

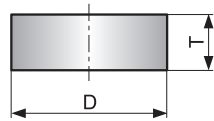
		D		d ₁
		[mm]		[mm]
46	-	40	-	38
46	-	42	-	40
46	-	44	-	42
46	-	45	-	43
46	-	46,5	-	44
46	-	50	-	48
46	-	52	-	50
46	-	53	-	51
46	-	54	-	52
46	-	55	-	53
46	-	57	-	55
46	-	58	-	56
46	-	60	-	58
46	-	63	-	61
46	-	65	-	63
46	-	67	-	65

$\varnothing 60 \div \varnothing 100$
 Rozměry dle vzájemné dohody zákazníka s výrobcem.
 Dimension should be settled with the producer.
 Abmessung sind mit dem Hersteller vereinbaren.

DOPORUČENÉ OTÁČKY A POSUV: RECOMMENDED REVOLUTION AND FEED: EMPHOHLENE DREHZAHLN UND VORSCHUB:

Vrták Drill Bohrer	Posuv Feed Vorschub	Otáčky Revolution Drehzahl
D	[cm . min ⁻¹]	[ot.min ⁻¹] [rev.min ⁻¹] [U.min ⁻¹]
[mm]		
6 ÷ 10	2,0 ÷ 3,0	6000 ÷ 5000
11 ÷ 20	1,5 ÷ 2,5	4500 ÷ 2500
22 ÷ 36	1,0 ÷ 2,0	2500 ÷ 1500
40 ÷ 53	0,5 ÷ 1,0	1400 ÷ 800

TABLETY
TABLETS
TABLETE



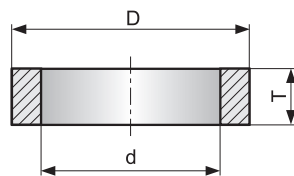
Označení / Marking / Bezeichnung

		D	x	T
		[mm]		[mm]
58	-	5	x	3,5
58	-	5	x	5,0
58	-	7,5	x	5,0
58	-	8	x	3,0
58	-	8	x	3,5

Označení / Marking / Bezeichnung

		D	x	T
		[mm]		[mm]
58	-	10	x	3,0
58	-	10	x	3,5
58	-	10	x	5,0
58	-	15	x	5,0
58	-	20	x	6,5

PRSTENCE
RINGS
RINGE



Označení / Marking / Bezeichnung

D		d	x	T
[mm]		[mm]		[mm]
3,9	/	1,8	x	3
4,5	/	2,8	x	3
5,4	/	3,5	x	3
6,5	/	4,2	x	3
7,7	/	5,2	x	3
8	/	3,0	x	3
9,2	/	6,3	x	3

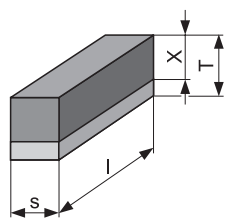
Označení / Marking / Bezeichnung

D		d	x	T
[mm]		[mm]		[mm]
10	/	3,5	x	3
10,7	/	7,4	x	3
12,8	/	9	x	3
15	/	11,5	x	3
17,5	/	13,5	x	3
18,5	/	15,2	x	3
22	/	18	x	3

Označení / Marking / Bezeichnung

D		d	x	T
[mm]		[mm]		[mm]
28	/	22	x	6
32	/	26	x	6
38	/	32	x	6
56,5	/	48,5	x	6
70	/	60	x	6
87	/	77	x	6
108	/	98	x	6

HRANOLY
RECTANGLE
PRISMA



Označení Marking Bezeichnung	ROZMĚRY / DIMENSION / ABMESSUNGEN			
	l	x	T	s
	[mm]	[mm]	[mm]	[mm]
K3	6	5	8	6

A large, empty rectangular box with a thin blue border, intended for handwritten notes or comments.

Empty rectangular area for notes.



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