

KREBS & RIEDEL

SCHLEIFSCHEIBENFABRIK

GmbH & Co. KG



Please send back to:

KREBS & RIEDEL
Postfach 1233
D - 34385 Bad Karlshafen

Company Seal:

Date:

Signature:

Technical specifications

for inquiries / purchase orders of abrasive materials

Inquiry / order dated: _____

Dimensions	Diameter	Width	Arbor hole	Profile*)	Shape (indicate acc. ISO)*	
	Diameter of recess		Depth of recess F		Depth of recess G	
	Grinding method					
<input type="checkbox"/> off-hand <input type="checkbox"/> in-feed by hand <input type="checkbox"/> automatic grinding stock to remove: mm infeed rate: mm (mm/min) <input type="checkbox"/> rough grinding <input type="checkbox"/> cylindrical grinding <input type="checkbox"/> surface grinding <input type="checkbox"/> profile grinding <input type="checkbox"/> tool grinding <input type="checkbox"/> cut-off grinding						
Material	Condition:				Hardness:	
Work piece	Size of surface to be ground:					
Desired surface	<input type="checkbox"/> rough <input type="checkbox"/> medium <input type="checkbox"/> fine <input type="checkbox"/> Rz <input type="checkbox"/> Rt <input type="checkbox"/> Ra <input type="checkbox"/> CLA mm					
Machine	Make:					
	<input type="checkbox"/> Dry grinding		<input type="checkbox"/> Wet grinding		Type of coolant:	
	Wheel speed:		m/s		(rpm)	
Work piece speed:		m/min		(rpm)		
Make of wheel used until now	Manufacturer	Type of abrasive	Grain size	Grade	Structure	Bond
	Was the grinding result satisfactory ? <input type="checkbox"/> yes <input type="checkbox"/> no					
If no, what should be improved				Supposed annual need: _____		
Grain size: <input type="checkbox"/> finer		<input type="checkbox"/> coarser				
Grade: <input type="checkbox"/> softer		<input type="checkbox"/> harder				
Structure: <input type="checkbox"/> more open		<input type="checkbox"/> denser				

Grain size								
rough	6	8	10	12	14	16	20	24
medium	30	36	46	54	60			
fine	70	80	90	100	120	150	180	
very fine	220	240	280	320	400	500	600	

Grade				
extremely soft	A	B	C	D
very soft	E	F	G	
soft	H	I	J	K
medium	L	M	N	O
hard	P	Q	R	S
very hard	T	U	V	W
extremely hard	X	Y	Z	

If possible please send us a remainder of a wheel which has worked to your satisfaction to make shure you are supplied with the type of wheel you need.

*) Shapes and profiles are shown on the next page

Please underline the grain and grade you want

Bremer Straße 44 • 34385 Bad Karlshafen • Telefon: +49 (0)5672 184 0 • Telefax: +49 (0)5672 184 218 • mail@krebs-riedel.de • www.krebs-riedel.de

KREBS & RIEDEL Schleifscheibenfabrik GmbH & Co. KG, Sitz Bad Karlshafen Amtsgericht Kassel, HRA 12042
Komplementär K&R Schleifscheibenfabrik Verwaltungsgesellschaft mbH, Sitz Bad Karlshafen Amtsgericht Kassel, HRB 9000

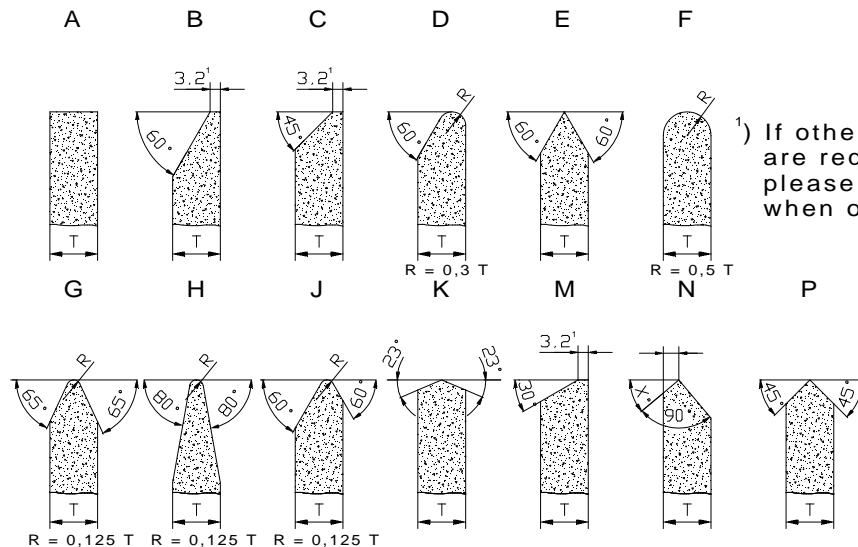
Geschäftsführer:
Dipl. Ing. Michael Krebs; Jost Riedel; Dipl. Ing. J. Dinkel

Common forms of grinding wheels according to ISO

Straight wheel FORM 1 	Straight wheel recessed one side FORM 5 	Straight wheel recessed both sides FORM 7
Cylinder wheel FORM 2 	Cylindrical cup wheel FORM 6 	Flaring cup wheel FORM 11
Wheel, tapered both sides FORM 4 	Wheel, tapered one side FORM 3 	Dish wheel FORM 12

At diverent forms, please enclose separate sketch !

Straight grinding wheels can be provided with different profiles. The profiles are named with letters and have the following meaning:



1) If other widths are required, please mention when ordering.