GRINDING TOOLS FOR THE TOOL INDUSTRY

Abrasive tools are commonly used during cutting tool manufacturing process. Complicated grinding operations and high customer requirements force grinding tool producers to develop new solutions to optimize the cost and time of the grinding process.

Constantly for over 35 years we have been focusing on our customers and their needs, developing solutions that ensure better quality and higher efficiency.

GRINDING OPERATIONS IN THE TOOLMAKING INDUSTRY

MANUFACTURING OF DRILLS, TAPS AND MILLING CUTTERS

- Raw material cutting-off
- Centerless grinding
- Drill flute grinding
- Tap flute grinding
- Clearance grinding
- Drill end work
- Tap end work
- Drill and milling cutter sharpening

INDUSTRIAL KNIFE, BLADEAND CUTTING TOOL SHARPENING

Guillotine cutting tool sharpening

LATHE TOOL SHARPENING

- HSS lathe tool sharpening
- Carbide lathe tool sharpening



MANUFACTURING OF DRILLS, TAPS AND MILLING CUTTERS

There are several operations involved in manufacturing process of cutting tools which use a grinding wheel. For instance raw material cutting-off, centerless grinding of bars or grinding of individual surfaces depending on the function of the tool. An important requirement at every stage of grinding is high precision of abrasive tools, grinding process repeatability and high efficiency. The solutions we offer allow to achieve high quality of ground surfaces and high efficiency of the process.

RAW MATERIAL CUTTING-OFF

| TYPE 1X | TYPE 41





41 - D × T × H

Examples of implemented abrasive tools in industry [*]			
Туре	Dimensions [mm]	Technical characteristics	Speed [m/s]
1X	508 × 10 × 304,8	98A903S5VTE72	80
41	400 × 4,0 × 32	95A24RBF	100

[*] For the full range of dimensions and available technical characteristics ask the Sales Department.

CENTERLESS GRINDING

| TYPE 1Y | TYPE 7





7 - D × T × H - P...F...G...

	Examples of implemented abrasive tools in industry [*]			
Туре	Dimensions [mm]	Technical characteristics	Speed [m/s]	
1Y	610 × 250/150 × 304,8	94A60/100M8VTE35	50	
1Y	610 × 250/150 × 304,8	94A60/100N7VTE35	50	
7	600 × 270 × 304,8 - P380F10G10	99AY60M6VTE10	50	



DRILL FLUTE GRINDING TYPE 1





Examples of implemented abrasive tools in industry [*]			
Туре	Dimensions [mm]	Technical characteristics	Speed [m/s]
1	285 × 2 × 203,2	97AM90W7BP89	80
1	295 × 2,5 × 203,2	97AM90W7BP89	80
1	406 × 3,5 × 304,8	97AM90W7BP89	80
1	406 × 4,5 × 304,8	97AM3XT100X7BP89	80
1	406 × 12 × 203,2	52A70X10B787	80

[*] For the full range of dimensions and available technical characteristics ask the Sales Department.





Examples of implemented abrasive tools in industry [*]			
Туре	Dimensions [mm]	Technical characteristics	
1A1	100 × 10 × 10 × 20	D64C100NBN6	
1A1	125 × 10 × 10 × 20	D64C100NBN6	
1A1	150 × 10 × 10 × 32	D64C100NBN6	

[*] For the full range of dimensions and available technical characteristics ask the Sales Department.



Examples of implemented abrasive tools in industry [*]			
Туре	Dimensions [mm]	Technical characteristics	Speed [m/s]
1	205 × 7 × 76,2	97AM3XT90V11B3PL	80
1	205 × 7 × 76,2	97AM3XT90W7BP89	80
1	205 × 8 × 76,2	97AM3XT100X7BP89	100





- CLEARANCE GRINDING
 - | TYPE 1



Examples of implemented abrasive tools in industry [*]			
Туре	Dimensions [mm]	Technical characteristics	Speed [m/s]
1	305 × 3,5 × 203,2	97AM90W7BP89	80
1	305 × 16 × 203,2	97AM90W7BP89	80

[*] For the full range of dimensions and available technical characteristics ask the Sales Department.

DRILL END WORK



• TAP END WORK





Examples of implemented abrasive tools in industry [*]			
Туре	Dimensions [mm]	Technical characteristics	Speed [m/s]
1	225 × 4 × 76,2	97AM90X7BP89	80
1	300 × 6 × 203,2	97AM90V11B3PL	80
1	500 × 16 × 304,8	97AM90V11B3PL	80

[*] For the full range of dimensions and available technical characteristics ask the Sales Department.





Examples of implemented abrasive tools in industry [*]			
Туре	Dimensions [mm]	Technical characteristics	Speed [m/s]
1	187 × 4 × 76,2	97AM3XT100X7BP89	100
1	187 × 6 × 76,2	97AM3XT100X7BP89	100
1	187 × 12 × 76,2	97AM3XT90V11B3PL	80
5	187 × 20 × 76,2 - P125F10	97AM3XT90V11B3PL	80



DRILL AND MILLING CUTTER SHARPENING TYPE 1





Examples of implemented abrasive tools in industry [*]			
Туре	ype Dimensions [mm] Technical characteristics Speed [r		Speed [m/s]
1	150 × 5 × 20	9A3X80M7VE01N	35

[*] For the full range of dimensions and available technical characteristics ask the Sales Department.

| TYPE 11V9 | TYPE 12V9



11V9 - D × T × X × U × H



12V9 - D × T × X × U × H

Examples of implemented abrasive tools in industry [*]			
Туре	Dimensions [mm]	Technical characteristics	
11V9	100 × 35 × 3 × 10 × 20	B64V240NBN6	
11V9	100 × 35 × 3 × 10 × 20	D64C100NBN6	
12V9	125 × 25 × 3 × 10 × 32	B64V240NBN3	
12V9	125 × 25 × 3 × 6 × 32	D64C100NBN3	



INDUSTRIAL KNIFE, BLADE AND CUTTING TOOL SHARPENING

GUILLOTINE CUTTING TOOL SHARPENING

Despite the multitude of applications of industrial knives, their many shapes and materials from which they are made, we are able to propose optimal characteristics of abrasive tools for sharpening applications.

For these operations, ANDRE offers a wide range of conventional abrasive tools, including segments and a group of superhard tools that make it possible to achieve high quality ground surfaces while ensuring the high performance of the grinding wheels used.

TYPE 3109





Examples of implemented abrasive tools in industry [*]			
Туре	Dimensions [mm]	Technical characteristics	
3109	70/64 × 25 × 150	9A2X30I7BW7C	
3109	103/94 × 38 × 208	9A3X24H12VE01NPP	

[*] For the full range of dimensions and available technical characteristics ask the Sales Department.

| TYPE 11A2 | TYPE 6A2 | TYPE 12A2-45



11A2 - D × T-X × W × X × H



6A2 - D × T-X × W × X × H



12A2-45 - D × T-X × W × X × H



Examples of implemented abrasive tools in industry [*]			
Туре	Dimensions [mm]	Technical characteristics	
11A2	125 × 23 × 6 × 4 × 20	B126V180LBL2	
11A2	150 × 23 × 6 × 4 × 32	B126V180LBL2	
6A2	125 × 23 × 6 × 4 × 32	B126V180LBL2	
6A2	150 × 23 × 6 × 4 × 32	B126V180LBL2	
12A2-45	125 × 23 × 6 × 4 × 32	B126V180LBL2	
12A2-45	150 × 23 × 6 × 4 × 32	B126V180LBL2	



LATHE TOOL SHARPENING

The purpose of this grinding operation is to give the desired geometry to the lathe tool edge. The proposed ANDRE abrasive tools allow to obtain the appropriate geometry while maintaining high efficiency of the tool used.

For this operation, ANDRE offers a wide range of conventional and superhard grinding wheels with appropriately selected characteristics.

HSS LATHE TOOL SHARPENING

TYPE 1



| **TYPE 1A1** | **TYPE 6A2**



Examples of implemented abrasive tools in industry [*]					
Туре	Dimensions [mm]	Technical characteristics	Speed [m/s]		
1	250 × 25 × 32	99A80L6VTE10	35		
1	350 × 50 × 51	99A60K7VE01	35		

[*] For the full range of dimensions and available technical characteristics ask the Sales Department.





1A1 - D × T × X × H

6A2 - D × T-X × W × X × H

Examples of implemented abrasive tools in industry [*]					
Туре	Dimensions [mm]	Technical characteristics			
1A1	150 × 15 × 4 × 20	B126V180LBG2			
1A1	200 × 20 × 4 × 32	B126V180LBG2			
6A2	125 × 23 × 15 × 4 × 32	B107V180GBL2			
6A2	150 × 23 × 15 × 4 × 32	B107V180GBL2			

[*] For the full range of dimensions and available technical characteristics ask the Sales Department.

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CARBIDE LATHE TOOL SHARPENING | TYPE 1





Examples of implemented abrasive tools in industry [*]					
Туре	Dimensions [mm]	Technical characteristics	Speed [m/s]		
1	350 × 50 × 51	98C46K6VTC10	35		
1	350 × 50 × 51	98C80K6VTC10	35		

[*] For the full range of dimensions and available technical characteristics ask the Sales Department.

| TYPE 1A1 | TYPE 6A2





1A1 - D × T × X × H

6A2 - D × T-X × W × X × H

Examples of implemented abrasive tools in industry [*]				
Туре	Dimensions [mm]	Technical characteristics		
1A1	150 × 15 × 4 × 20	D126C75LBG2		
1A1	200 × 20 × 4 × 32	D126C75LBG2		
6A2	125 × 23 × 15 × 4 × 32	D107C75GBL2		
6A2	150 × 23 × 15 × 4 × 32	D107C75GBL2		