



DR. MÜLLER
DIAMANTMETALL®

INDIVIDUAL
PREMIUM

For **MAXIMUM EFFICIENCY** in the grinding process



MDR-280 PP B126

X-66897

SN-744083/01

EN13236 Vmax=80m/s

HOB AND BROACHING
TOOL GRINDING

STRATA

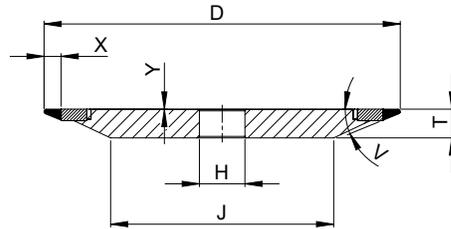
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STRATA

Two layers for higher efficiency and improved cost-effectiveness

TECHNICAL FEATURES

Application:	Hob and broaching tool grinding	Coolant:	Oil
Material:	HSS, hardened tool steel, PM steel (hardness 58 – 65 HRC)	Grain size:	B91 – B126
Machines:	Schneeberger, Landis, Klink	Type of tool:	4K9
		Dimensions:	D 200mm – D 250mm



KEY FEATURES

- ▲ New, reinforced ceramic CBN high-performance bond with stronger, improved grit holding forces
- ▲ Increased porosity for a higher removal rate and cooler grinding

YOUR BENEFITS

- ▲ More economical process by increasing the infeed rate while simultaneously optimising the G-ratio
- ▲ Grinding time reduction by increasing the infeed rate by 30 %
- ▲ 20 % better wheel life compared to the competition
- ▲ Reduction of process forces
- ▲ Improved cooling thanks to larger chip space
- ▲ Lower peripheral velocity improves energy transfer to the hob tool

APPLICATION

- ▲ Cutting speeds: 35 - 50 m/s
- ▲ Infeed for roughing: 80 - 150 μm ae/radius
- ▲ Smoothing: 30 - 50 μm ae/radius
- ▲ Feed: 4000 - 5000 mm/min

DRESSING RECOMMENDATION IN DIAMOND ROLL DRESSING PROCESS

- ▲ Dressing process: In the same direction
- ▲ Grinding wheel cutting speed: 15 - 35 m/s
- ▲ Dressing roll cutting speed: 12 - 25 m/
- ▲ Feed: 150 - 300 mm/min
- ▲ Infeed: 1 - 4 μm

3236 $v_{\text{max}}=80\text{m/s}$