

# SWATYCOMET

## CBN-V SPECIAL



**Vitrified bonded  
CBN abrasives  
for grinding  
the most complex  
tool parts!**



*SWATYCOMET*

**NEW GENERATION  
PRODUCTS**



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## CBN-V SPECIAL

Oblikovanje: CARRERA CAPTURE Srečko Franek s.p.



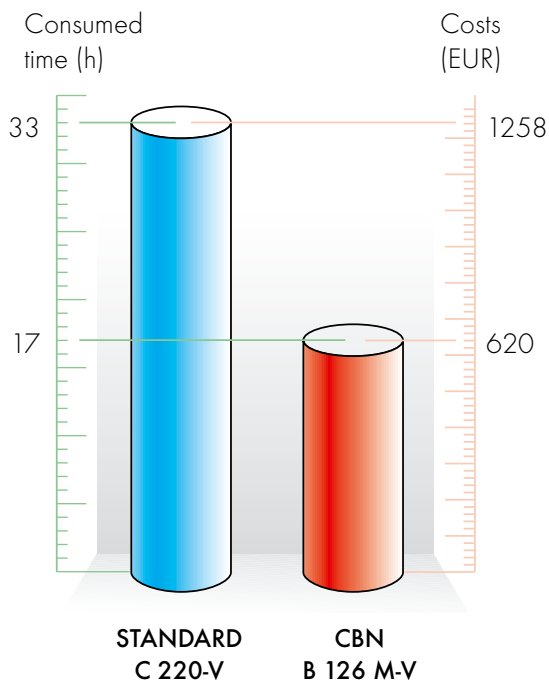
### Example:

Grinding type: **External cylindrical**

Grinding wheel dimensions: **400 x 25 x 6 x 127**

Grinding wheel composition: **B126 M6V3 C100**

Machined material: **Vanadis 10 SC**



The comparative calculation was done for 100 units.

### Advantages:

- Reduced machining costs.
- Effective grinding of the most difficult materials for tool production.
- Minimal number of dressing strokes.
- Shorter grinding times.
- Lower grinding forces.

### Applications:

- Grinding of high alloy tool parts (for machining plastics, sheet metal and styrofoam, and thermoforming), with hardnesses of up to 70 HRC.
- OCR12 VM
- Titanium alloys
- K340
- V2000
- V10
- M330
- INCONEL



### Recommendations:

- Internal grinding: **B126 J7V1 C100**
- External grinding: **B126 M6V3 C100**
- Flat grinding: **B126 M6V3 C100**
- Coordinate grinding: **B126 K6V1 C100**

### Dimensions:

- Continuous type for diameters from 3 mm to 500 mm.
- Segmental type without diameter limitations.