

# Diamond wheels with ripper cutter profile for carbide roughing end mills



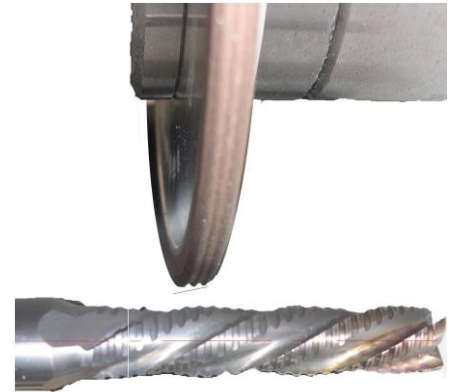
**Specs (resin bond)** 1S1/P1 100 5 6 20  
D64 W125 RPK

## Operation:

**Grinding:** Ripper cutter profile

**Workpiece:** end mill

**Material:** Tungsten carbide



## Dressing :

**Stick :** White Al Oxide 180# grit size.

**Operation :** manual

## Machine:

**Model:** CNC grinding machine

**Coolant:** oil, with good filtration.

**Spindle power:** not important

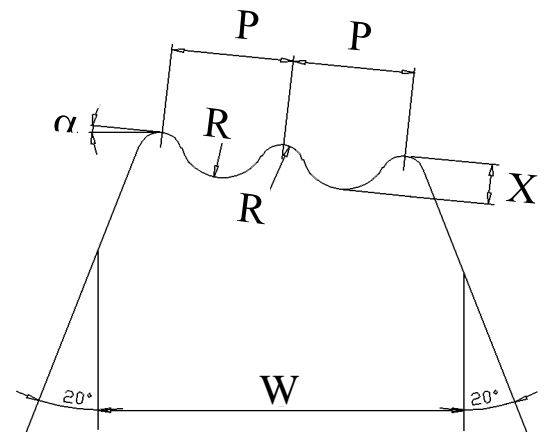
**Pressure:** 6-8 bar

## Parameters:

**Wheel speed:** 22 ÷ 26 m/s

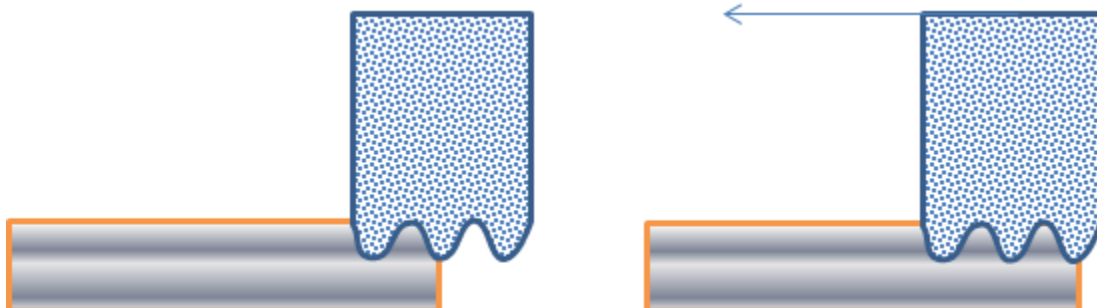
**Depth of cut :** one pass

**Feed:** 100-300 mm/min



## Note:

It is important the right position of the wheel, and the axial movement must be  $P = \text{pitch (half profile)}$ :



Check that the diameter of the wheel would not be too big (avoid collision with the following tip)

Please contact us in order to discuss about your special profile, we can modify straight wheels at stock (shape 14A1) in few days, at your disposal for further information.

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