

# KREBS & RIEDEL

## SCHLEIFSCHEIBENFABRIK

GmbH & Co. KG



Please send back to:

**KREBS & RIEDEL**  
Postfach 1233  
34385 Bad Karlshafen  
Deutschland

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					<b>Supposed annual need:</b> _____
If no, what should be improved						
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

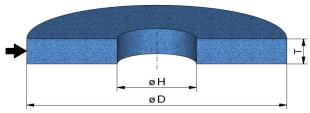
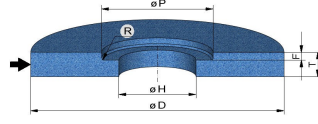
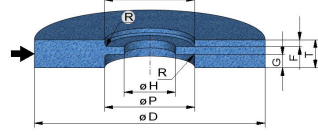
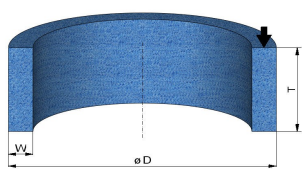
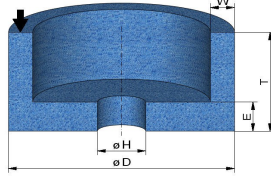
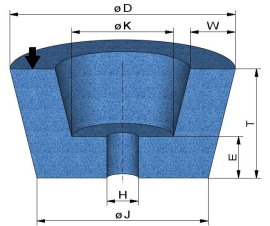
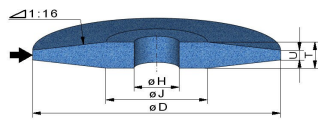
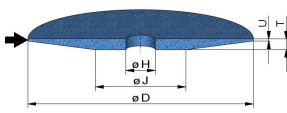
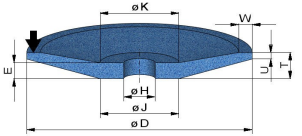
Please underline the grain and grade you want

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

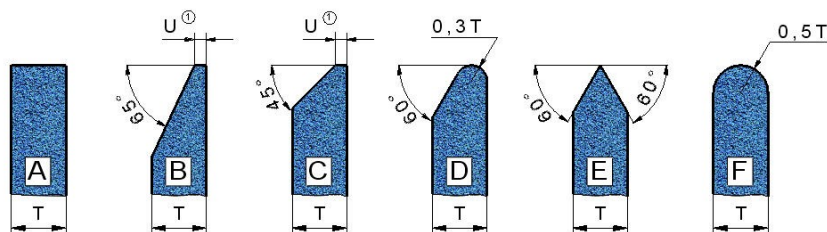
KREBS & RIEDEL Schleifscheibenfabrik GmbH & Co. KG, Sitz Bad Karlshafen Amtsgericht Kassel, HRA 12042  
Komplementär K&R Schleifscheibenfabrik Verwaltungsgesellschaft mbH, Sitz Bad Karlshafen Amtsgericht Kassel, HRB 9000

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

### Common forms of grinding wheels according to ISO

<p>Straight wheel FORM 1</p> 	<p>Straight wheel recessed one side FORM 5</p> 	<p>Straight wheel recessed both sides FORM 7</p> 
<p>Cylinder wheel FORM 2</p> 	<p>Cylindrical cup wheel FORM 6</p> 	<p>Flaring cup wheel FORM 11</p> 
<p>Wheel, tapered both sides FORM 4</p> 	<p>Wheel, tapered one side FORM 3</p> 	<p>Dish wheel FORM 12</p> 
<p><b>At diverent forms, please enclose separate sketch !</b></p>		

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



If other widths are required, please mention when ordering!