

## MANUFACTURING AND SHARPENING OF **END MILLS ON CNC MACHINES**

### FLUTE GRINDING

#### Description

##### Shape 1A1 | 14A1

##### Palladio Black:

Hybrid metal bonded wheel for HM grinding

##### Palladio Gold:

Resin bonded wheel for HM and Cermet grinding

##### Palladio Ruby:

Resin bonded wheel with CBN for HSS grinding

#### Standard diameters

100 mm | 125 mm  
150 mm



#### Description

##### Shape 14V1 | 14B1

##### Palladio Black:

Hybrid metal bonded wheel for HM grinding

##### Palladio Gold:

Resin bonded wheel for HM and Cermet grinding

##### Palladio Ruby:

Resin bonded wheel with CBN for HSS grinding

#### Standard diameters

75 mm | 100 mm  
125 mm | 150 mm



## MANUFACTURING AND SHARPENING OF **END MILLS ON CNC MACHINES**

### FLUTE GRINDING

**Description**

**Shape 1V1 | 1B1**

**Palladio Black:**

Hybrid metal bonded wheel for HM grinding

**Palladio Gold:**

Resin bonded wheel for HM and Cermet grinding

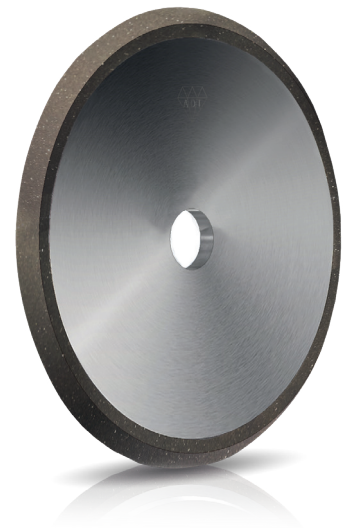
**Palladio Ruby:**

Resin bonded wheel with CBN for HSS grinding

**Standard diameters**

75 mm | 100 mm

125 mm | 150 mm



### CLEARANCE ANGLE GRINDING

**Description**

**Shape 11V9**

**Palladio Black:**

Hybrid metal bonded wheel for HM grinding

**Palladio Gold:**

Resin bonded wheel for HM and Cermet grinding

**Palladio Ruby:**

Resin bonded wheel with CBN for HSS grinding

**Standard diameters**

75 mm | 100 mm

125 mm



## MANUFACTURING AND SHARPENING OF **END MILLS ON CNC MACHINES**

### CLEARANCE ANGLE GRINDING AND GASHING

#### Description

##### Shape 12V9

##### Palladio Black:

Hybrid metal bonded wheel for HM grinding

##### Palladio Gold:

Resin bonded wheel for HM and Cermet grinding

##### Palladio Ruby:

Resin bonded wheel with CBN for HSS grinding

#### Standard diameters

75 mm | 100 mm

125 mm | 150 mm



#### Description

##### Shape 6V5

##### Palladio Gold:

Resin bonded wheel for HM and Cermet grinding

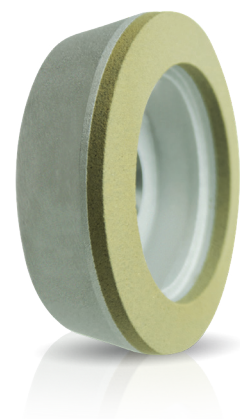
##### Palladio Ruby:

Resin bonded wheel with CBN for HSS grinding

#### Standard diameters

75 mm | 100 mm

125 mm



## MANUFACTURING AND SHARPENING OF **END MILLS ON CNC MACHINES**

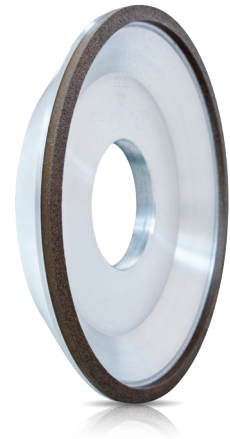
### CLEARANCE ANGLE GRINDING

**Description**  
**Shape 11A2**

**Palladio Gold:**  
Resin bonded wheel for HM and  
Cermet grinding

**Palladio Ruby:**  
Resin bonded wheel with CBN for  
HSS grinding

**Standard diameters**  
125 mm



### CHIP BREAKING

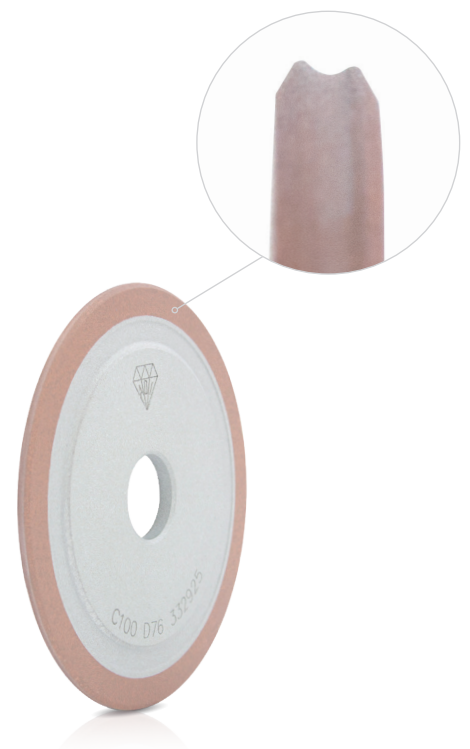
**Description**  
**Shape 14S1**

**Palladio Black:**  
Hybrid metal bonded wheel for HM  
grinding

**Palladio Gold:**  
Resin bonded wheel for HM and  
Cermet grinding

**Palladio Ruby:**  
Resin bonded wheel with CBN for  
HSS grinding

**Standard diameters**  
75 mm | 100 mm  
125 mm | 150 mm



## POLISHING AND HONING OF **END MILLS ON CNC MACHINES**

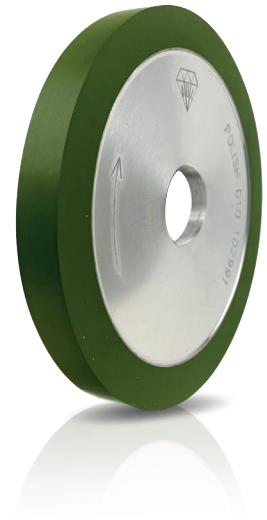
### Description

Shape **1A1 | 3A1 | 14A1 | 1V1  
11V9 | 12V9 | 6A9**

Rubber bond wheel used for superfinishing that cannot be achieved with resin bonded wheels

### Standard diameters

100 mm



## CYLINDRICAL GRINDING OF **HM/HSS RODS ON CNC MACHINES**

### DIAMETER REDUCTION

### Description

Shape **3V1 | 14V1**

Metal or resin bonded wheel with steel lightened body for Rollomatic machines

### Standard diameters

**3V1:** 200 mm | 250 mm

**14V1:** 150 mm



## GRINDING OF PCD/PCBN INSERTS ON CNC MACHINES

### Description Shape 6A2

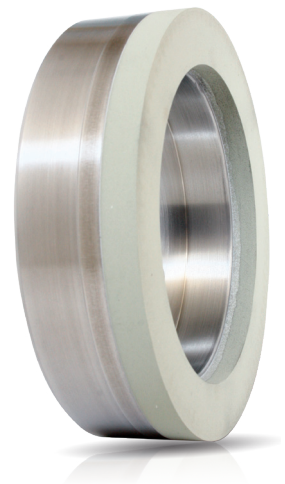
Vitrified bonded wheel for the grinding of PCD/PCBN inserts

### Standard diameters

150 mm

### Machines

*Ewag, Coburn and others*



### Description Shape 11A2

Vitrified bonded wheel for the grinding of PCD/PCBN inserts

### Standard diameters

250 mm | 400 mm

### Machines

*Agathon, Wendt ed altre*

