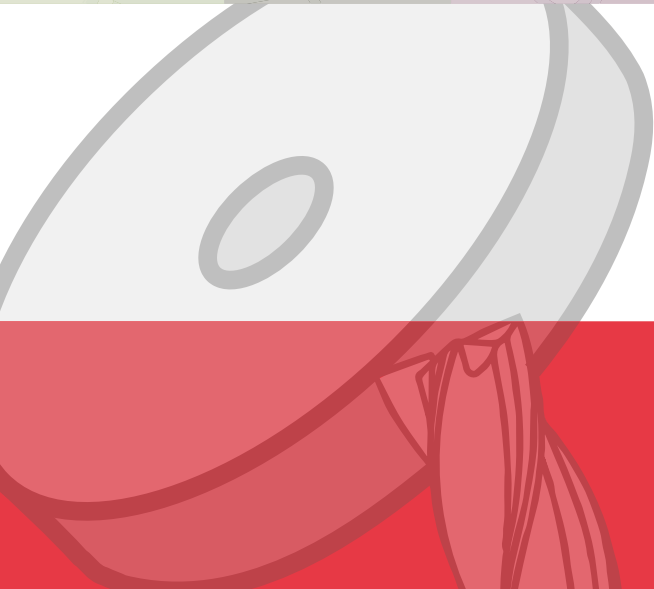


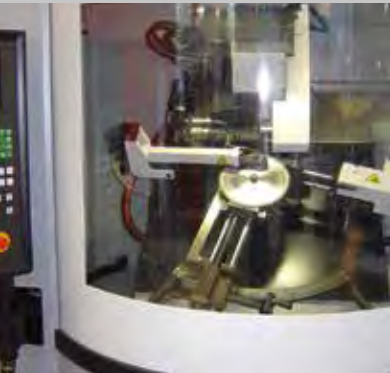
DIAMOND / CBN
GRINDING WHEELS

CNC PRECISION
GRINDING



 **molemab**[®]
we shape your world

we shape your world



- POWER THROUGH INNOVATION
- DEVELOPMENT IN DIALOG WITH THE CUSTOMERS
- HIGH FLEXIBILITY
- CUSTOMER-ORIENTED SERVICE

Welcome to the world of
precision grinding wheels



GET IN SHAPE WITH US

We are a competent manufacturer of Diamond and CBN grinding wheels with many years of experience in this area.

Using our technical Know How and our high quality products, we help our customers in close cooperation to increase their productivity.

A high degree of flexibility along with our ability to adapt to customer requirements and a customer orientated service differentiates us from many competitors.

Your Molemab Team



We view the problems of our customers as individual challenges to which we dedicate ourselves in our modern grinding centre.

Through customized test programs and technical analysis solutions are identified and defined. Following this, our highly qualified application engineers support customers with the successful implementation.



11V9 / 12V9-45° Cup wheels

FORTE 1D



metal bonded diamond wheel
for HM-applications

Shapes:

11V9 / 12V9-45°

Application:


CNC tool grinding


Recommend

Cutting speed v_C :

$v_C = 27 - 30$ m/s



 excellent
edge stability

 high cutting
performance

FORTE 1B

metal bonded CBN-wheel
for HSS-applications

Shapes:

11V9 / 12V9-45°

Application:

CNC tool grinding

Recommend

Cutting speed v_C :

$v_C = 27 - 35$ m/s



FORTEpro series

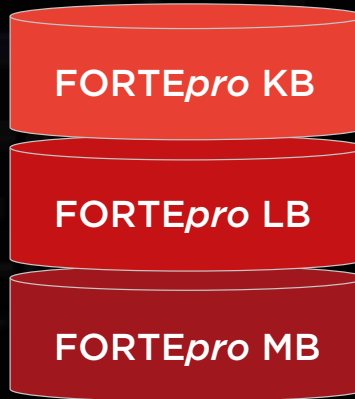


metal hybrid diamond- and CBN-wheels in TRIBOND system

HM-application



HSS-application

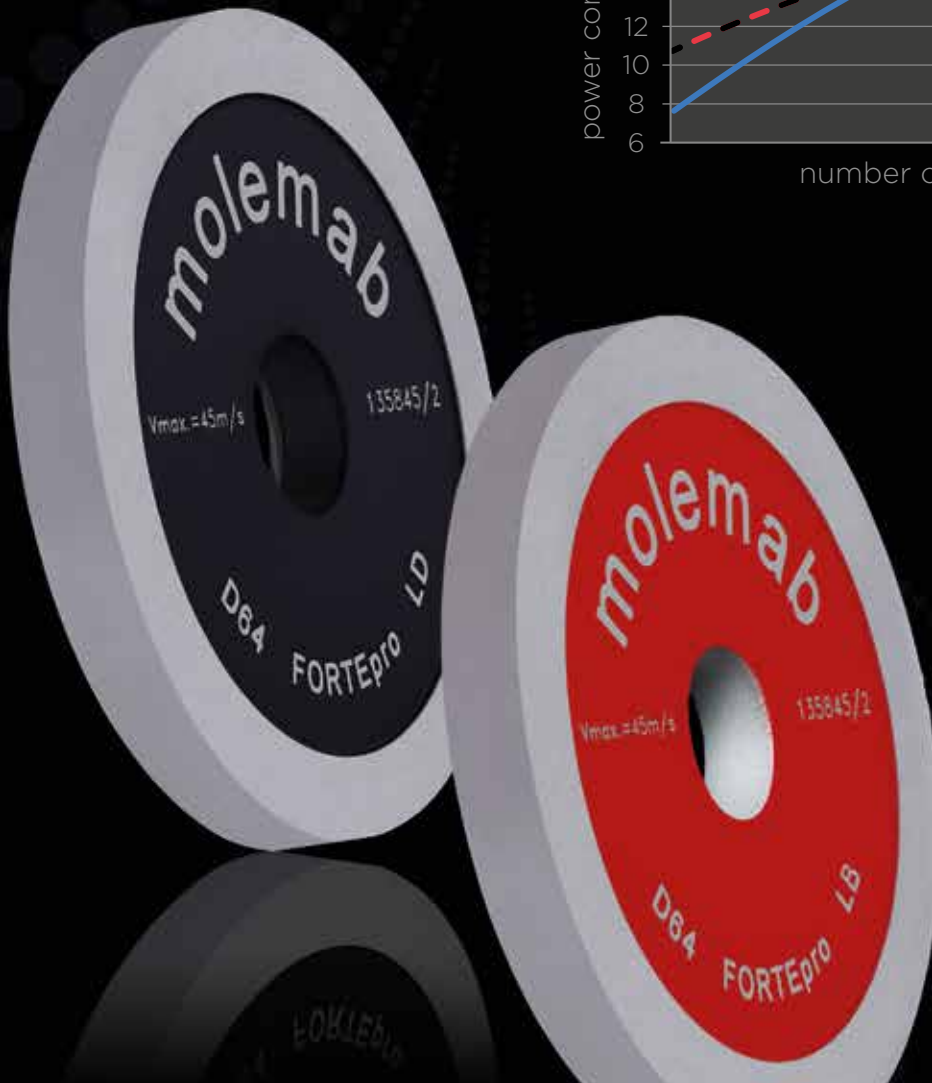
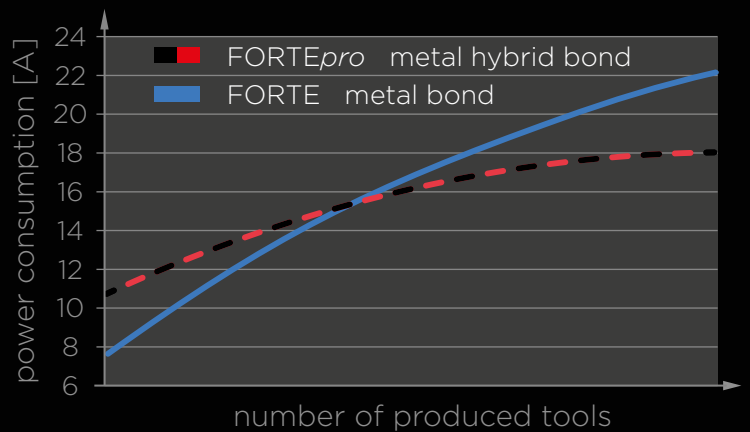


-  high cutting performance
-  high cutting performance and edge stability
-  high edge stability

e.g. D54 FORTEpro LD

$v_f = 60 - 120 \text{ mm/min}$

$v_c = 16 - 18 \text{ m/s}$







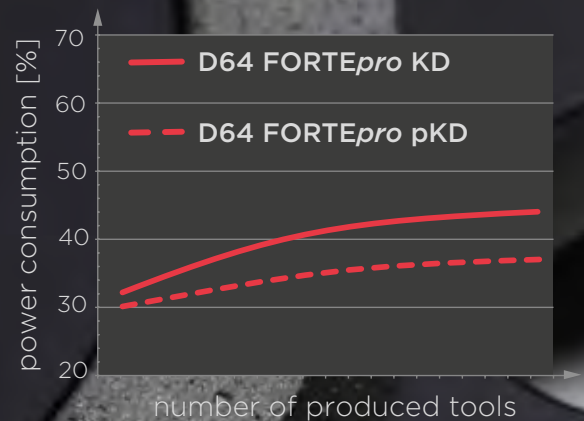
-  new improved grinding characteristic
-  improved edge stability
-  high cutting performance

FORTEpro series „porous“

NEW

Advantages

-  better cooling
-  better chip removal
-  less power consumption
-  better stock removal



594 1/min
=45m/s
KD 148221/1

$\omega = 8594$ 1/min
max. =45m/s
pKD 14822

Dressing

To ensure optimum performance it is recommended to dress and balance the **FORTEpro** wheels mounted on your mandrels with SiC wheels (quality 8C80 J6 V01).

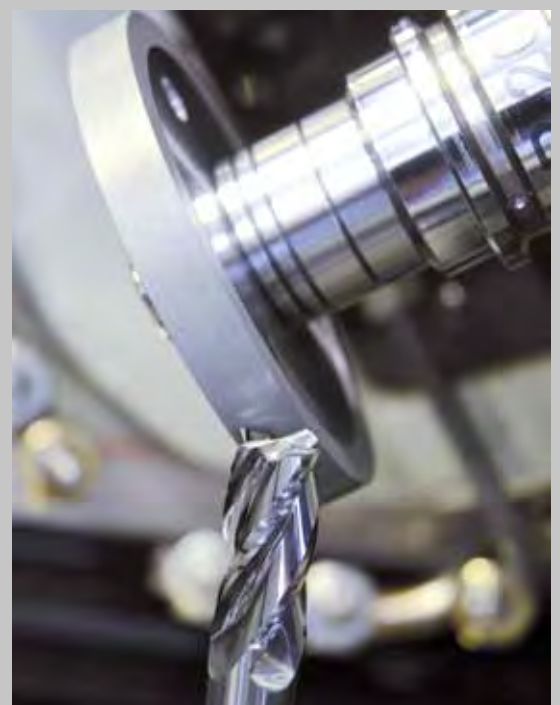
Dimensions on request.

Sharpening

To ensure optimum performance it is recommended to sharpen the **FORTEpro** wheel before use (rotation direction and speed of the wheel should be the same as for the grinding operation).

Sharpening sticks to be used:

15x15x50	9A220	H8	V
15x15x100	9A220	H8	V
50x20x200	9A180	H8	V

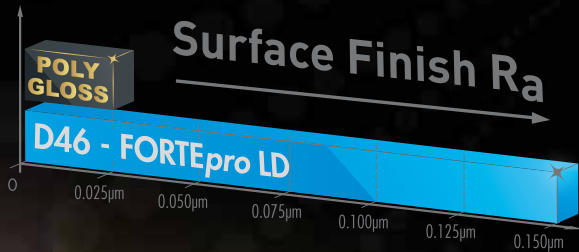


FORTEpro series covers most common grinding applications on CNC machines.

Polygloss HD




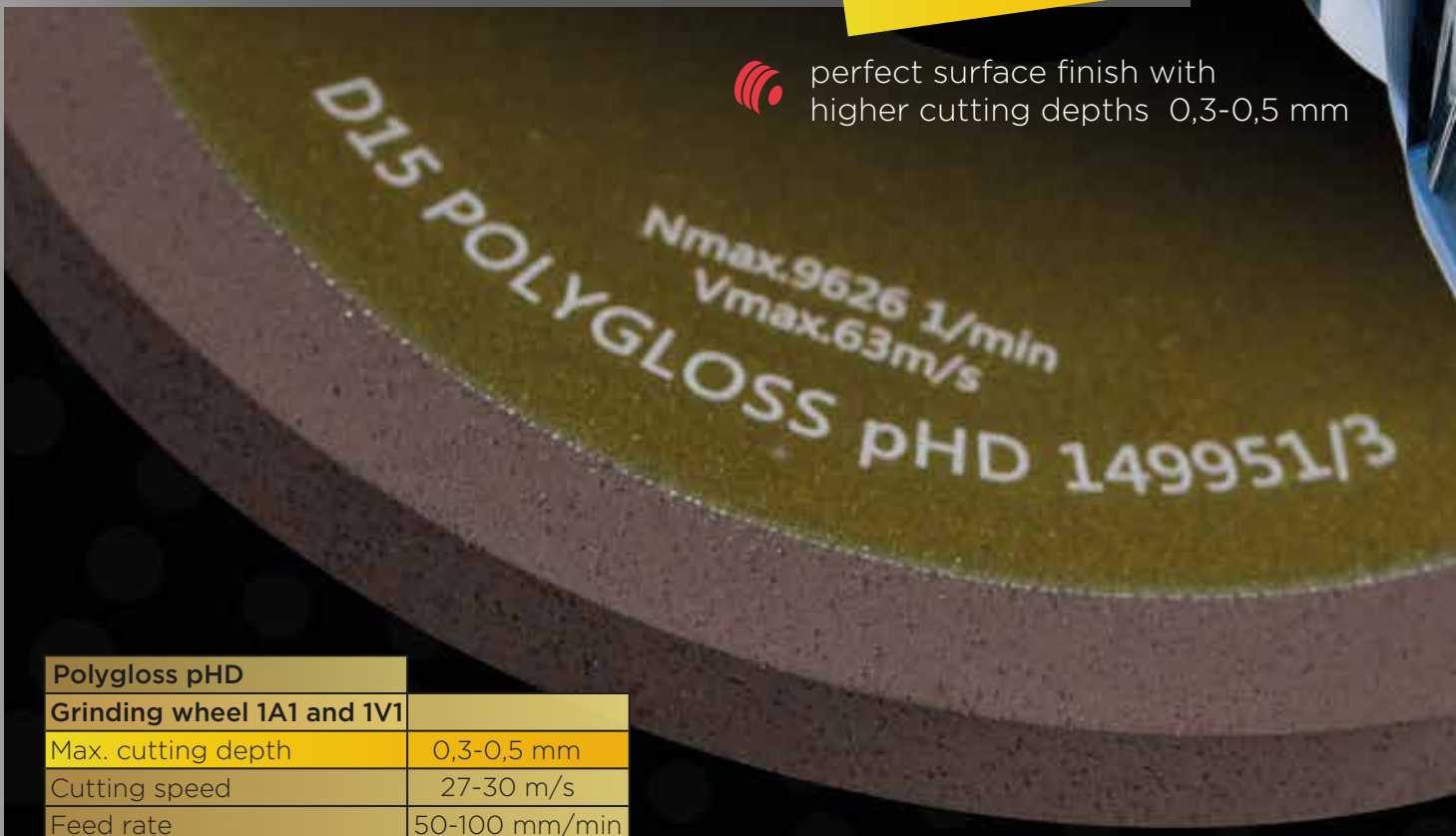
Polygloss HD	
Grinding wheel 1A1 and 1V1	
Max. cutting depth	0,1 mm
Cutting speed	27-30 m/s
Feed rate	50-100 mm/min
Grinding wheel 11V9	
Max. cutting depth	0,1 mm
Cutting speed	27-30 m/s
Feed rate	50-100 mm/min
Grinding wheel 12V9-45°	
Max. cutting depth	0,1 mm
Cutting speed	27-30 m/s
Feed rate	20-60 mm/min



Polygloss pHD

NEW

 perfect surface finish with higher cutting depths 0,3-0,5 mm



Polygloss pHD	
Grinding wheel 1A1 and 1V1	
Max. cutting depth	0,3-0,5 mm
Cutting speed	27-30 m/s
Feed rate	50-100 mm/min

Polishing wheel



molemab's new grinding wheel generation for flute- and cutting edge polishing.

Using solid carbide cutting tools with polished cutting edges offers considerable advantages particularly with regard to the processing of:

- aluminium, copper and brass
- titanium
- wood
- plastics
- laminated materials
- tools for hard machining

Solid carbide cutting tools with polished cutting edges guarantee:

- optimized cutting edge geometry with no chunking
- better chip removal
- longer service life
- reduced temperature development
- optimized surface quality
- reduced power consumption of the machine tool

In order to ensure the success of the polishing wheels you have to comply with the following requirements:

The grinding wheel should be balanced (if possible fixed on the flange) before usage

The grinding wheel should be dressed on the spindle

The grinding machine and the spindle bearing must be in good order and condition

Only, if all these conditions are met, the successful application of the abrasive wheel can be guaranteed.

Dressing

To ensure optimum performance it is recommended to dress the wheels mounted on your mandrels with white corundum dressing wheels: **quality 9A180 EF14 V11 P1**
Dimensions on request.

Sharpening

To ensure optimum performance it is recommended to sharpen the Polygloss HD wheel before use (rotation direction and speed of the wheel should be the same as for the grinding operation).

Sharpening stick to be used:

13x25x100	9A1000/1 D13 V16
13x25x50	9A1000/1 D13 V16

Our wheels are successfully used worldwide in the following branches.



Industrial branches

Aviation Industry
Aerospace Industry
Automotive Industry
Rail Industry
Engine Industry
Shipbuilding Industry
Machine Building Industry
Mining Industry
Oil Industry
Paper Industry
Healthcare Industry

Metalworking and
Processing Industry





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