



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 mm
Grinding Machine	<input type="checkbox"/> Dry grinding <input type="checkbox"/> Wet grinding					
	Type of coolant:					
	Wheel speed:			m/s (rpm)		
	Work piece speed:			m/min (rpm)		
Grinding 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				Supposed annual need:	
	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 reminder of a wheel which has worked to your satisfaction to make sure 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

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Komplementär K&R Schleifscheibenfabrik Verwaltungsgesellschaft mbH, Sitz Bad Karlshafen Amtsgericht Kassel, HRB 9000

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Geschäftsführer:
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Dr. Ingo Kuhl

Commerzbank AG
(BLZ 520 800 80) Kto.-Nr. 124 497 00
IBAN: DE39 5208 0080 0012 4497 00
SWIFT-BIC: DRES DEFF 520

Kasseler Sparkasse
(BLZ 520 503 53) Kto.-Nr. 118 007 005
IBAN: DE88 5205 0353 0118 0070 05
SWIFT-BIC: HELA DEF1 KAS

VerbundVolksbank OWL eG
(BLZ 472 601 21) Kto.-Nr. 111 140 700
IBAN: DE 21 4726 0121 0111 1407 00
SWIFT-BIC: DGPB DE3M XXX

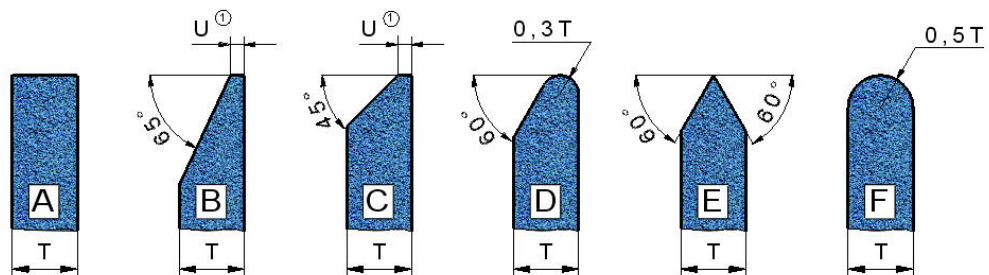
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Common forms of grinding wheels according to ISO

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

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



If other widths are required, please mention when ordering!