



# FLUTE GRINDING WHEELS



## Flute Grinding Wheels

CUMI is one of the very few manufacturers today producing the complete range of wheels for the cutting tool industry.

CUMI's unique bond systems cater to variety of applications in the cutting tool industry.

These bond systems provide better form retention and also reduces cycle time through higher material removal rate.

The latest generation SG products gives much higher in feeds, lower cycle time and generates high tolerances at lower cost per tool.

### Commonly used Machines:

- HERTLINE
- NORMAC
- GEFRA

### PRODUCT RANGE

Parameters	Dia (mm)	Thickness (mm)	Grain Size	Grain	Bond	Benefits
Drill Flute Grinding	150 - 500	3 - 20	80 - 120	AA, SA, SG	BHK, BHX, BHP, BH99	<ul style="list-style-type: none"> <li>• Burn free finish</li> <li>• More parts / dress</li> <li>• Longer wheel life</li> </ul>
Tap Flute Grinding	100 - 450	2 - 25	80 - 120	SA, RA, SG, AA	BHK, BHX, BHP, BH99	<ul style="list-style-type: none"> <li>• Burn free finish</li> <li>• More parts / dress</li> <li>• Excellent form retention</li> </ul>

### PRODUCT RECOMMENDATION

Operation	Component	Size	Selection		
			Conventional	Premium	
Flute Grinding	Drill	300 x T x 127	AA100 R19 BHK / 80	3SG 100 R19 BHX / 80	
		406 x T x 203.2		BH99 / 80	
Flute Grinding	Taps	457 x T x 203.2	RA 80 R19 BHK / 80	3SA 80 R19 BHX / 80	
		(T = 3 to 20 mm)		BH99 / 80	
		150 x T x 76.2		SGA 80 TDR 366 / 80	3SA 80 R20 BHX / 80
		200 x T x 76.2			
300 x T x 76.2					
400 x T x 127					
(T = 3 to 20 mm)					