CATETO

DA OLTRE 40 ANNI NEGLI ABRASIVI

scheda informativa
profili & forme

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SCHEDA informativa

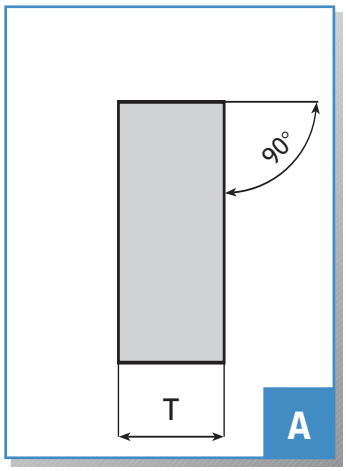
Per essere nelle condizioni di offrire alla clientela un servizio migliore e nel migliore tempo possibile è indispensabile compilare correttamente la scheda informativa

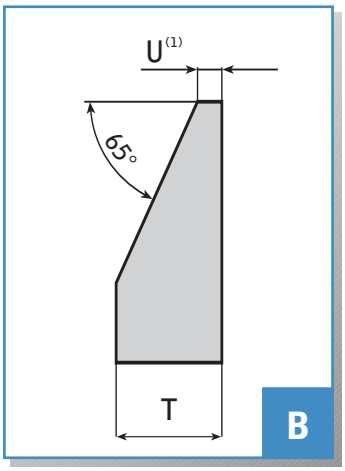
scheda informativa

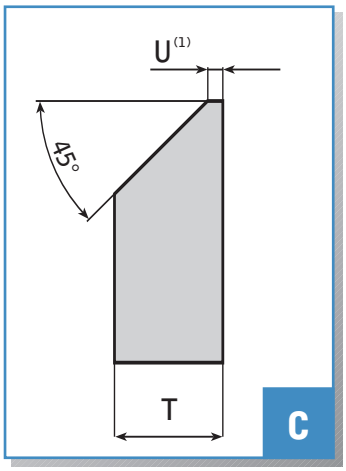
CLIENTE:					
SEDE/INDIRIZZO:					
DATA:					
Informazioni sulla rettifica		**Op. di rettifica**			
Tipo e marca (fabbricante)		Tipo di operazione	sgrossatura	semifinitura	finitura
Cond. di lavoro (O=ottime - B=buone - S=scarse)		Superficie da lavorare	continua	interrotta	altro
Potenza mandrino (Hp)		Tipo di lavorazione	in passata	a tuffo	altro
Velocità di rettifica (mt./sec.)		Sist. di raffreddamento	a secco	olio intero	emulsione
N° giri pezzo (g./min.)		Ut. ravvivatore	utensile	rullo diam.	Vel.:
Alimentazione		**Note/commenti**			
Tipo ravvivatura					
Dimensioni mola					
diametro est.					
foro					
spessore					
Informazioni su pezzo da rettificare		**La mola**	*(specificare se la mola è porosa)*		
Denominazione		**Caratteristiche attuali**			
Forma e dimensioni (*)		Abrasivo			
Tipo materiale		Grana			
Durezza		Durezza			
Trattamento		Struttura			
Sovrametallo da asportare		Legante			
Tolleranze dimensionali		Vel. mt./sec.			
Finitura richiesta (Ra)		**Caratteristiche ottimali**			
Altro		Abrasivo			
		Grana			
(*) Disegno particolare da lavorare	**(o della mola)**	Durezza			
		Struttura			
		Legante			
		Vel. mt./sec.			
		Scopo della prova:			
		Aumento produttività			
		Migliorare tenuta			
		Aumento pezzi x ravv.			
		Eliminare bruciature			
		Migliorare rugosità			
		Altro			
		Note e commenti:			

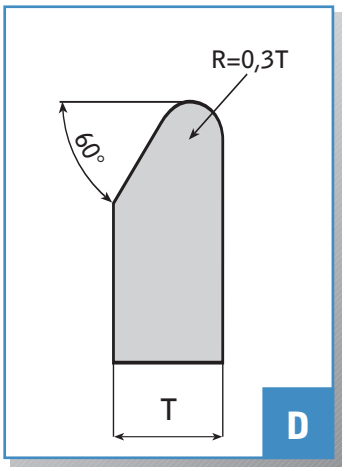
scheda

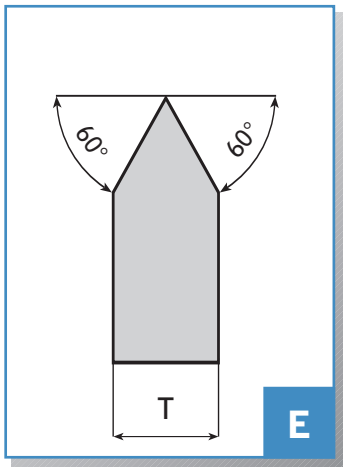
Profili standard (FEPA)

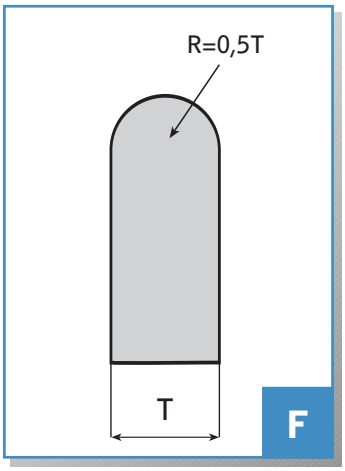


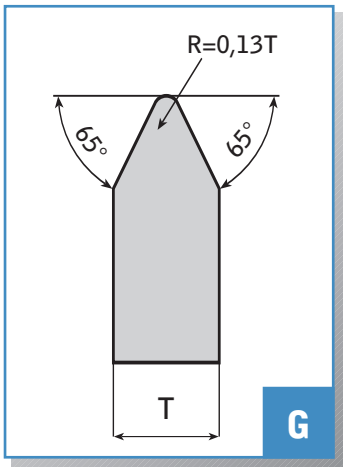


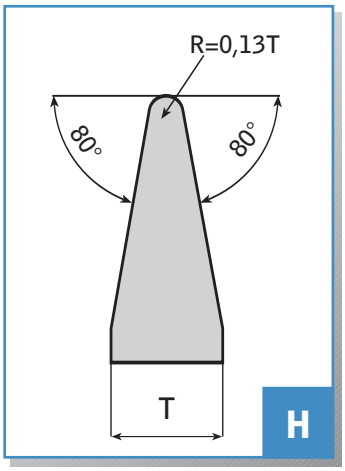


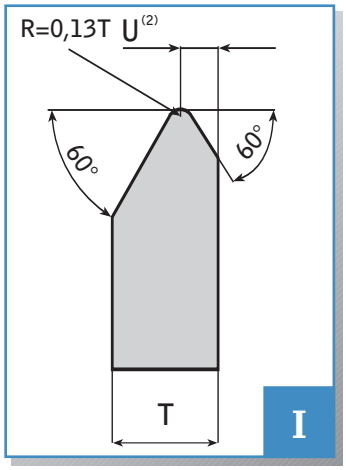


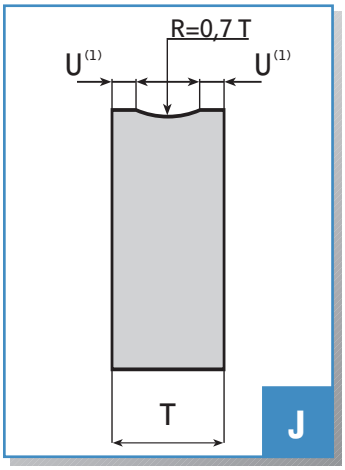


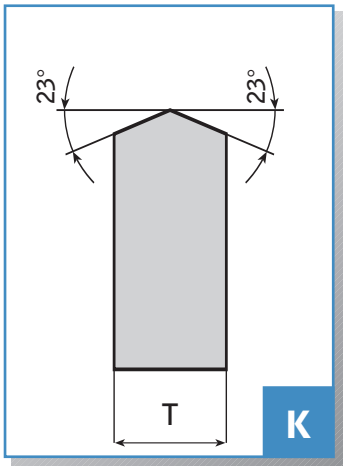


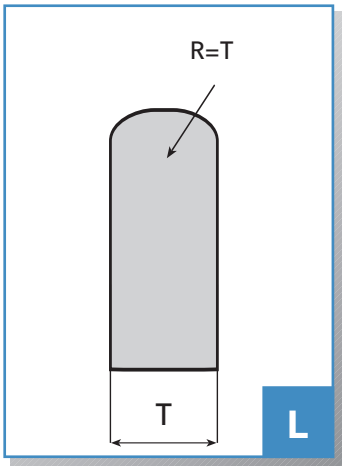


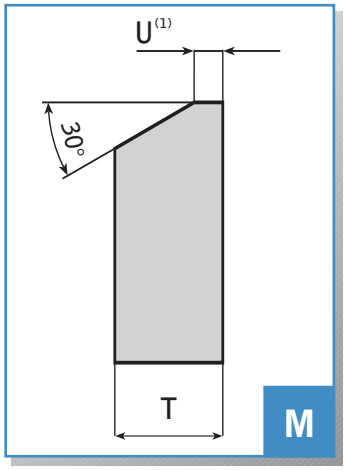


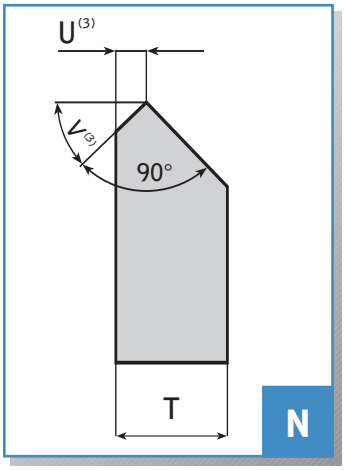


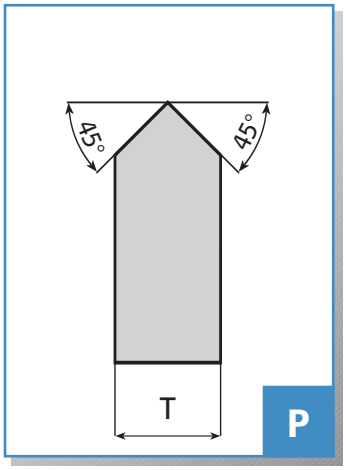












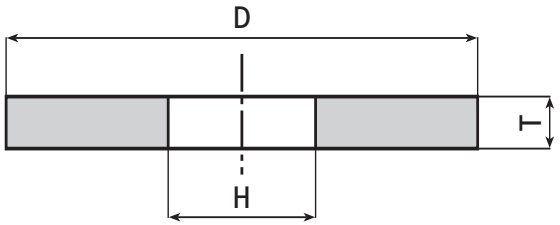
LEGENDA

(1) U= 0,25T (max 3 mm)

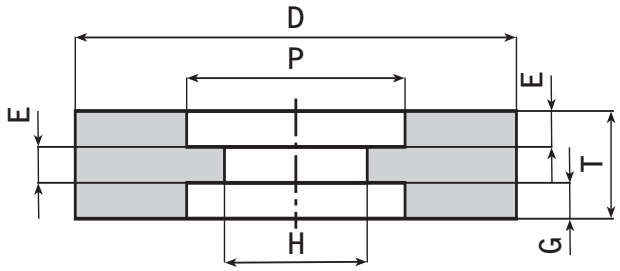
(2) U= 0,33T

(3) U e V devono essere specificati

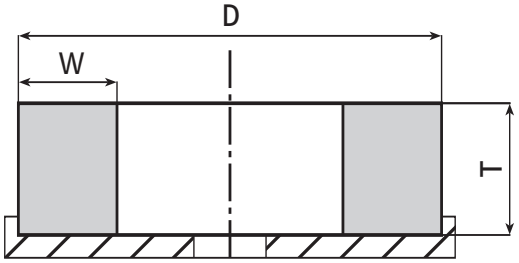
Forme mole standard (FEPA)



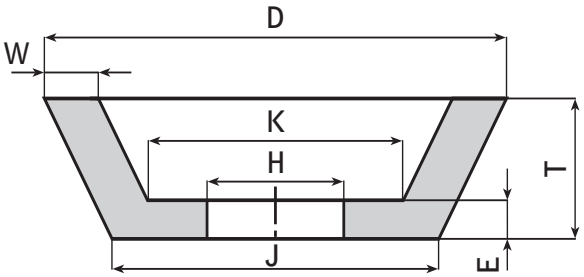
D x T x H
Tipo 1: mola a disco



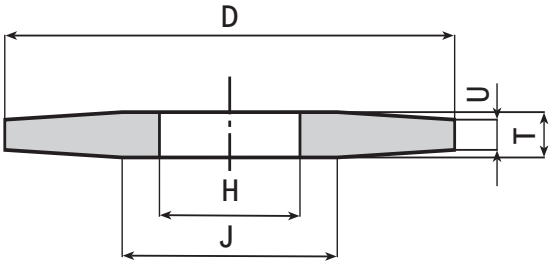
D x T x H - P x F/G
Tipo 7: mola con 2 incavi cilindrici



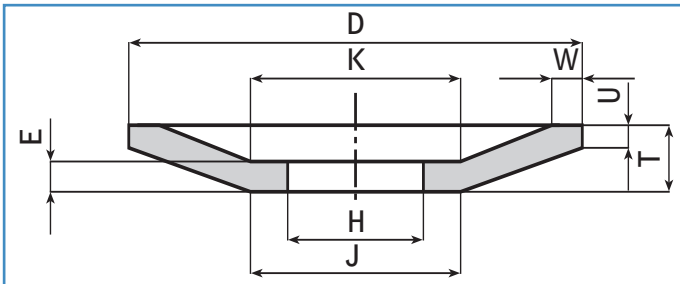
D x T - W...
Tipo 2: mola ad anello incollata su piastra



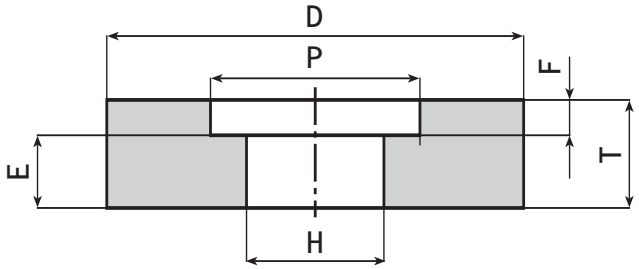
D x T x H - P x F/G
Tipo 11: tazza conica



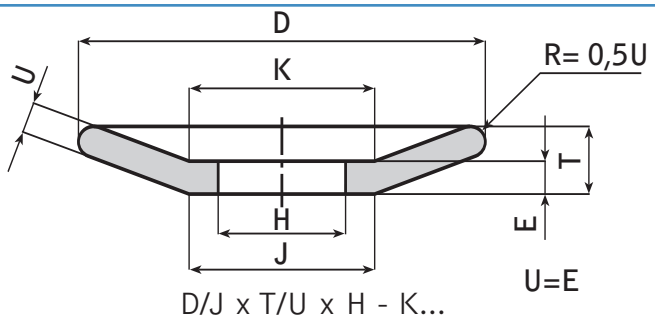
D/J x T/U x H
Tipo 4: mola a disco biconica



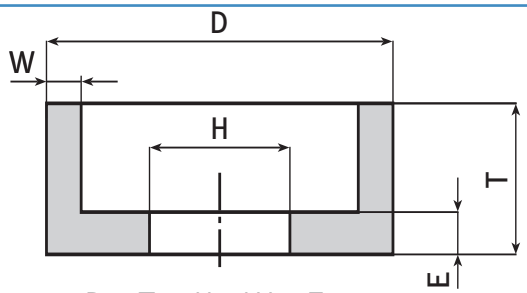
D/J x T/U x H - W...E...K...
Tipo 12: mola a scodella



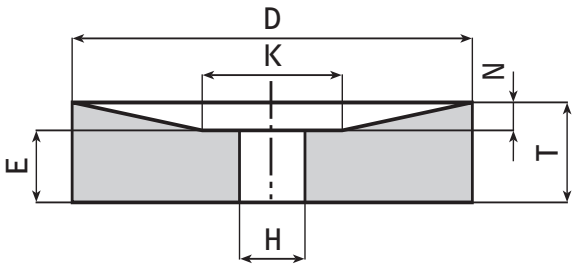
D/T x H - P x F
Tipo 5: mola con incavo cilindrico



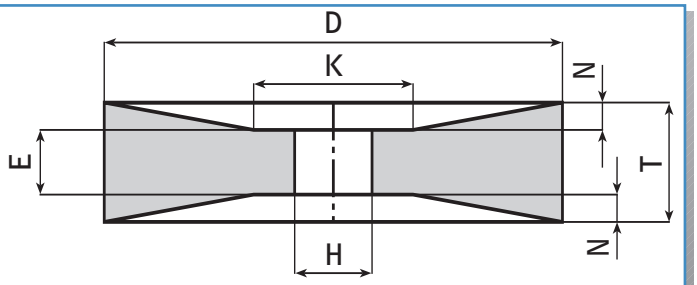
D/J x T/U x H - K...
Tipo 13: mola a scodella



D x T x H - W... E...
Tipo 6: tazza cilindrica

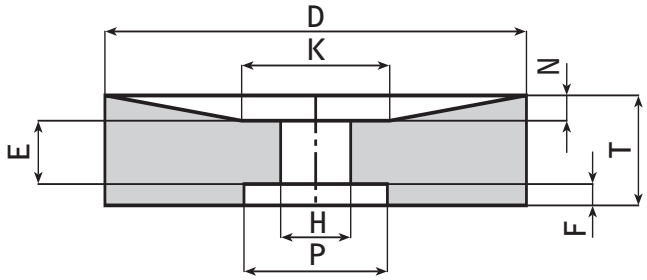


D/K x T/N x H
Tipo 20: mola con 1 incavo svasato



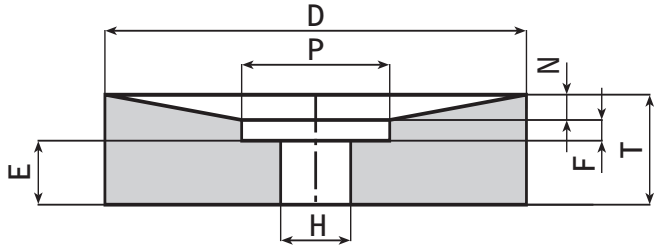
D/K x T/N x H

Tipo 21: mola con 2 incavi svasati



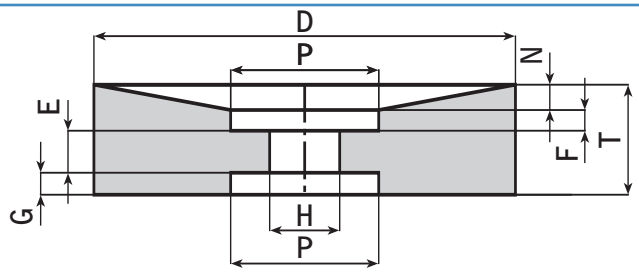
D x T/N x H - P x F

Tipo 22: mola con incavo svasato su un lato e incavo cilindrico sull'altro lato



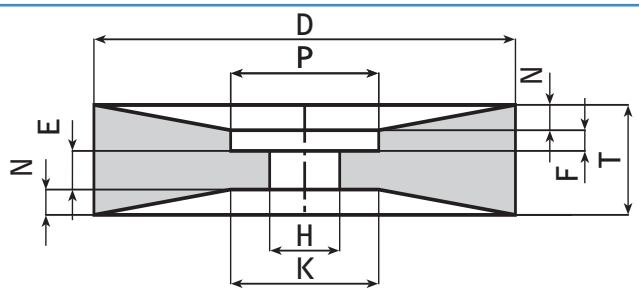
D x T/N x H - P x F

Tipo 23: mola con incavo svasato su un incavo cilindrico, entrambi sullo stesso lato



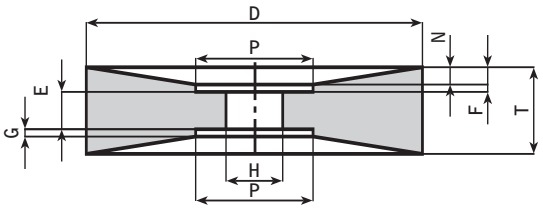
D x T/N x H - P x F/G

Tipo 24: mola con incavo svasato su un incavo cilindrico e incavo cilindrico su lato opposto



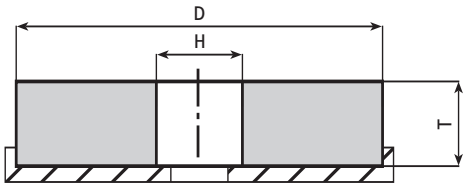
D x T/N x H - P x F

Tipo 25: mola con incavo svasato su un incavo cilindrico e incavo svasato su lato opposto



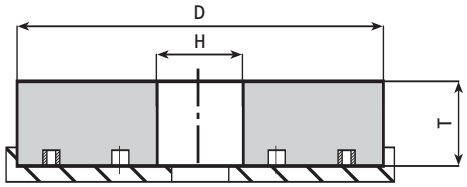
D/K x T/N x H - P x F

Tipo 26: mola con incavo svasato su un incavo cilindrico su entrambi i lati



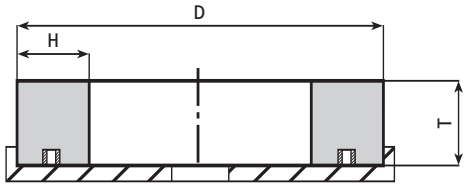
D x T x H

Tipo 35: mola frontale incollata su piastra



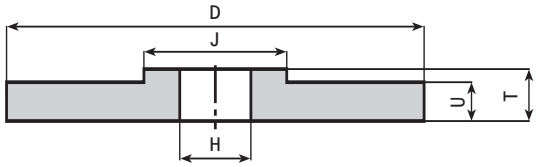
D x T x H

Tipo 36: mola frontale con inserti filettati



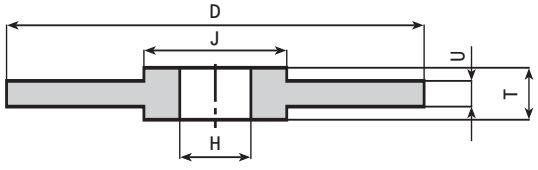
D x T - W...

Tipo 37: mola ad anello con inserti filettati



D/J x T/U x H

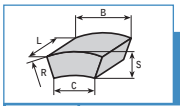
Tipo 38: mola con un mozzo



D/J x T/U x H

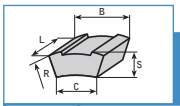
Tipo 39: mola con due mozzi

Tipi di segmenti abrasivi standard



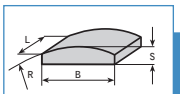
A

Tipo numero	Dimensioni B	C	S	L	R	Volume cm³
A1	160	118	35	150	252	725
A2	178	145	60	115sp	320	1,163
A4	124	94	23	150	175	360
A5	80	70,5	25	160	210	303,5
A6	90	58	30	160	200	372
A9	71	48	20	140	127	167
A10	79	70	20	140	180	210
A12	75	55	20	140	175	191
A15	107	100	30	60	300	186
A16	54	40	18	120	150	112
A17	70	38	25	100	87,5	135
A18	77	47	20	110	100	141
A35	120	68	45	160	175	715
A36	72	45	25	100	110	144
A37	175	120	60	200	350	1,776
A41	135	105	35	185	225	781
A44	80	71	25	160	250	299
A46	86	60	20	95	100	146
A50	70	60	32,5	47	200	103
A51	178	128	40	150	237,5	929
A53	67	41	20	110	101	120
A56	130	89,5	35	160	165	622
A58	73,5	42,5	27	150	150	243
A60	110	92	30	70	182,5	211
A61	137,5	97	42	180	225	898
A65	141	104	38	180	225	857
A68	73	45	18	110	100	118
A70	96	70	20	120	150	205
A71	56	45	20	120	115	119
A72	83	70	30	140	190	325
A73	74	39	28	150	150	244
A76	195	165	60	250	400	2,7
A83	76	35	55,5	60	100	184
A87	75	54	20	140	160	186
A123	58	39	17	125	100	104
A125	75	52	20	140	160	180
A126	70	46	20	140	150	155
A127	77	44	20	110	150	138
A128	63	43	20	90	100	97
A129	72	40	27	150	150	232
A141	79	70	20	200	175	304,5
A143	103,5	77,5	25	150	200	342
A152	109	100	27	120	419,5	342



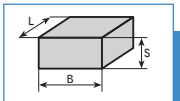
B

Tipo numero	Dimensioni B	C	S	L	R	Volume cm³
B40	190	144	60	240	300	2,070
B88	80	55	18	100	100	105
B130	195	148,5	60	240	302	2,130



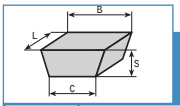
C

Tipo numero	Dimensioni B	S	R	L	Volume cm³
C86	285	60	164	230	2,041
C154	152	55	250	375	1,780



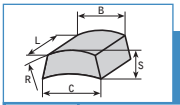
D

Tipo numero	Dimensioni B	S	L	Volume cm³
D19	120	40	180	864
D20	52	50	200	520
D34	120	40	220	1,056
D66	145	80	150	1,74
D75	52	25,5	255	338
D85	60	25,5	300	459
D124	110	50	250	1,375
D131	22	50	200	220
D132	26	50	200	260
D133	30	52	200	312
D142	80	25	200	400
D144	30	20	5	3
D149	52	50	150	390
D150	26	50	150	195
D157	25	13	100	32,5
D158	52	3	150	23,4
D191	80	25	150	300
D192	90	35	150	472
D193	90	35	175	551
D194	80	25	175	350
D195	90	25	155	349
D196	63	19	120	144
D341	90	60	200	1,080
D661	100	80	150	1,200
D751	25	25	250	156



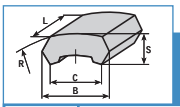
E

Tipo numero	Dimensioni B	S	R	L	Volume cm³
E33	54	46	21	65	65
E55	59,5	48	21	121	136
E67	65	46	20	100	111
E90	70	64	25	150	251
E105	103	94	38	180	673
E108	103	94	38	150	561
E109	55	50	15	90	71
E112	70	64	25	110	184
E114	65	58	20	70	86
E120	60	54	22	110	138
E121	89	77	24	140	279
E140	72	66	25	150	259
E147	100	85	35	150	486



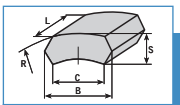
F

Tipo numero	Dimensioni B	C	S	L	R	Volume cm³
F11	80	93	25	120	200	268
F14	47	54	20	110	115	112
F38	45	550	16	90	90	71
F59	59	66	20	100	150	127
F63	78	92	25	150	200	337
F74	80	90	30	150	200	382
F77	48	50	16	100	75	78
F82	63	75	20	140	175	189
F103	47	52	15	60	75	44
F107	50	56	20	110	150	121
F115	45	50	16	90	150	69
F133	48	54	16	110	90	93
F134	45	50	20	90	90	89
F138	45	50	15	80	75	58
F145	68	75	20	125	175	180



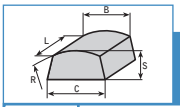
H

Tipo numero	Dimensioni B	C	S	L	R	Volume cm³
H3	120	114	32	152	230	514
H7	109	96,5	25	127	137,5	321
H52	127	118	32	178	454	670
H79	119,5	107	33	176	210	658
H80	126	105	38	153	240	610
H110	127	118	32	178	228,5	647
H111	145	130	63	210	450	1720
H113	127	115	38	152	213	660
H117	112,6	95	63	213	305	1334
H118	90	75	52	210	254	862
H122	112,6	95	63	142/130	305	831
H151	90	75	52	150/15°	254	653
H155	111	94	63	145/137	305	870
H156	111	94	63	155/147	305	938



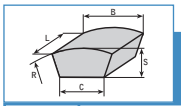
K

Tipo numero	Dimensioni B	C	S	L	R	Volume cm³
K119	75	90	35	180	191	542



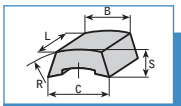
I

Tipo numero	Dimensioni B	C	S	L	R	Volume cm³
I39	78	103	38	150	254	495
I43	78	103	38	180	254	596
I54	62	80	35	150	205	367
I64	58	65	25	100	225	147
I78	83	94	25	127	152,5	249
I89	64	70	25	150	175	242
I102	55	60	18	65	150	62
I104	60	65	20	60	135	69
I116	56	62	20	70	178	77,3
I137	55	60	18	80	150	76
I139	98	120	38	150	279,4	603
I146	85	103	38	150	228,5	513
I148	62,5	70	25	150	420	243
I153	63,5	69,5	25	150	225	242



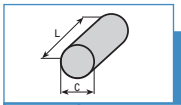
L

Tipo numero	Dimensioni B	C	S	L	R	Volume cm³
L62	117,5	79,5	42,5	152	330	622



M

Tipo numero	Dimensioni B	C	S	L	R	Volume cm³
M8	81	84	25	120	125	248
M57	79,5	84	25	120	220	241
M69	56	61	17	90	150	89
M98	45	50	15	90	90	61
M106	70	78	20	90	175	128
M135	59	66	20	100	150	120
M136	81	84	25	120	137,5	247



N

Tipo numero	Dimensioni D	L	Volume cm³
N91	20	150	235,60
N92	15	150	132,53
N93	60	200	565,48
N94	30	150	212,06
N95	50	200	392,70
N96	35	76	73,12
N97	25	200	196,35
N98	20	200	314,16
N99	30	200	282,74
N100	13	150	99,55
N101	25	150	368,15

DESIGNAZIONE

Tipo **A•B•F•M•H•K•E•L**:
B/C x S x L - R
Esempio F38
45/50 x 16 x 90 - 90

Tipo **C**:
B x S x L - R
Esempio C86
285 x 60/S_1 x 164 - 230

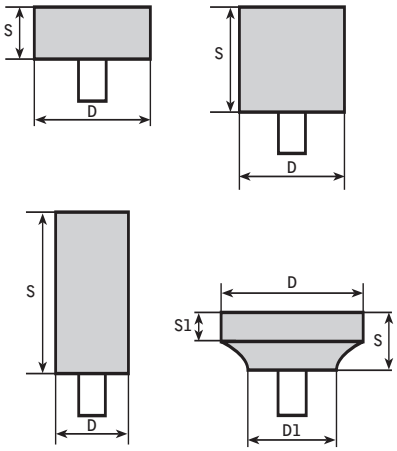
Tipo **D**:
B x S x L
Esempio D144
30 x 20 x 5

Tipo **E**:
B/C x S x L
Esempio E112
10/64 x 25 x110

Tipo **N**:
D x L
Esempio N101
25 x 150

Mole montate su perno metallico

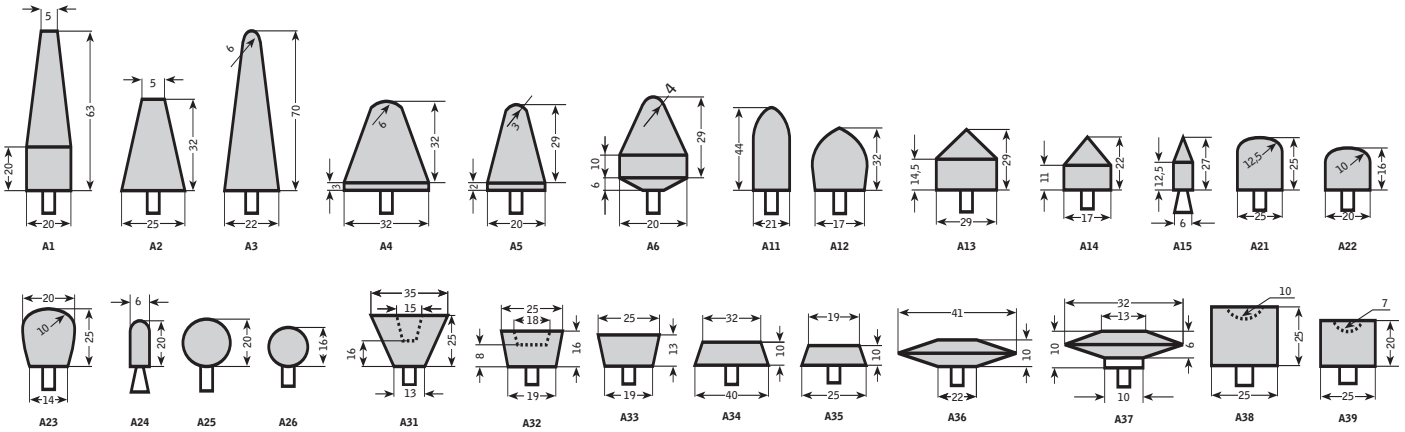
Normalizzazione FEPA
Tipo Cilindrico
Gruppo W



Tipo	Diam. mola	Spess. (S/S1)	Diam. perno mm
W151	5	3,2	3
W152	5	6	3
W153	5	10	3
W154	5	13	3
W158	6	3,2/5	3
W159	6	5	3
W160	6	6	3
W161	6	8	3
W162	6	10	3
W163	6	13	3
W164	6	20	3
W167	8	6	3
W168	8	8	3
W169	8	10	3
W170	8	13	3
W171	8	20	3
W173	10	3,2/6	3
W174	10	6	3
W175	10	10	3
W176	10	13	3-6
W177	10	20	3-6
W178	10	25	3-6
W179	10	32	6
W183	13	6	3-6
W184	13	10	3-6
W185	13	13	3-6
W186	13	20	3-6
W187	13	25	3-6
W188	13	40	6
W189	13	50	6
W191	16	3,2/8	3-6
W192	16	6/10	3-6
W193	16	10	3-6
W194	16	13	3-6
W195	16	20	3-6
W196	16	25	3-6

Tipo	Diam. mola	Spess. (S/S1)	Diam. perno mm
W197	16	50	6
W198	16	63	6
W200	20	3,2/8	3
W201	20	6/10	3-6
W202	20	10	3-6
W203	20	13	3-6
W204	20	20	3-6
W205	20	25	6
W206	20	32	6
W207	20	40	6
W208	20	50	6
W209	20	63	6
W211	22	3,2/8	3-6
W212	22	6/10	3-6
W213	22	10	3-6
W215	25	3,2/8	3-6
W216	25	6/10	3-6
W217	25	10/13	6
W218	25	13	6
W219	25	20	6
W220	25	25	6
W221	25	40	6
W222	25	50	6
W223	25	63	6
W225	32	6/10	6
W226	32	10/13	6
W227	32	13	6
W228	32	20	6
W229	32	25	6
W230	32	32	6
W231	32	40	6
W232	32	50	6
W235	40	6/10	6
W236	40	13	6
W237	40	25	6
W238	40	40	6

Normalizzazione FEPA - Tipo sagomato
Gruppo A perno mm 6



Normalizzazione FEPA - Tipo sagomato
Gruppo B perno mm 3