



Saw sharpening Product catalogue

English | 2025

Premium grinding solutions since 1919
www.tyrolit.com

TYROLIT

The Tyrolit Group

Tyrolit is one of the world's leading manufacturers of grinding and dressing tools, as well as a system provider for the construction industry. For over 100 years, our innovative tools and solutions have played a crucial role in technological advancements across various industries.

With roots in the heart of the Austrian Alps, Tyrolit combines the strengths of family values with a global vision and over a century of individual corporate and technological experience.

We aim to impress both internal and external target groups and foster fair, enduring partnerships. In pursuit of our goals, we consistently optimise the quality of our products and services while continuously adjusting our business processes to meet evolving market demands.



Facts & figures



80,000+
standard products



30+
global production sites



4,500+
valued employees



140+
countries within our reach



500+
patents worldwide

Business units

METAL INDUSTRIES



Automotive Industry

Our grinding solutions are used for the high-precision machining of engine components and transmission components.



Steel & foundry

With our many years of experience in machining high alloyed steels, we are the market leader in the Steel Industry.



Precision industries

The broad field of precision industries includes tools and system solutions for various fields of application.



Industrial specialised trade

The comprehensive commercial range for cutting, grinding and surface treatment is available worldwide.

CONSTRUCTION



Construction industry

The customised diamond tools are specifically designed to meet the requirements of customers in the construction industry.



Trade & Letting

The comprehensive assortment of leading system solutions for all construction-applications is available worldwide.



Building professionals

For professional construction users, we offer perfectly matched machines and tools as well as rapid service.

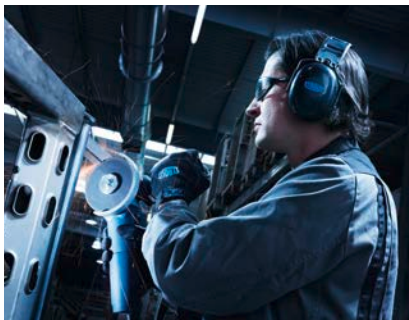


Project Services

Our Project Services team develops individual system solutions for customised special construction applications.

100 years of progressive thinking

A passion for technology, many years of experience and a high level of innovation have gone into the production of exceptional sanding solutions since our company was founded.

**Pioneers in hand-held cutting**

– We were the first European company to mass-produce glass fibre-reinforced cut-off wheels and are the inventors of super-thin technology, today's market standard for particularly high-quality cut-off wheels.

**Technology leader in precision grinding**

– We are one of the world's leading suppliers of high-precision grinding tools for applications in the automotive, turbine and Tooling Industry as well as for numerous other precision industries.

**Market leader in cutting in the Steel Industry**

– We are the leading manufacturer of the world's largest cut-off wheels with diameters of up to 2 metres for hot cutting-off semi-finished products in the Steel Industry.

**Leading solutions for professional construction operators**

– Our innovative system solutions and patented diamond technology (TGD®) set standards for performance and comfort in applications in the construction industry.

**Innovator in the machining of automotive glass**

– We were the first company to produce diamond tools for grinding automotive glass at speeds of up to 40 m/ min and successfully revolutionised edge grinding on the market.

**Developer of innovative wire**

– sawing technology- We have driven the development of wire sawing technology for applications in the natural stone and construction industry, which is still considered the benchmark in the industry today.

Worldwide production and sales locations

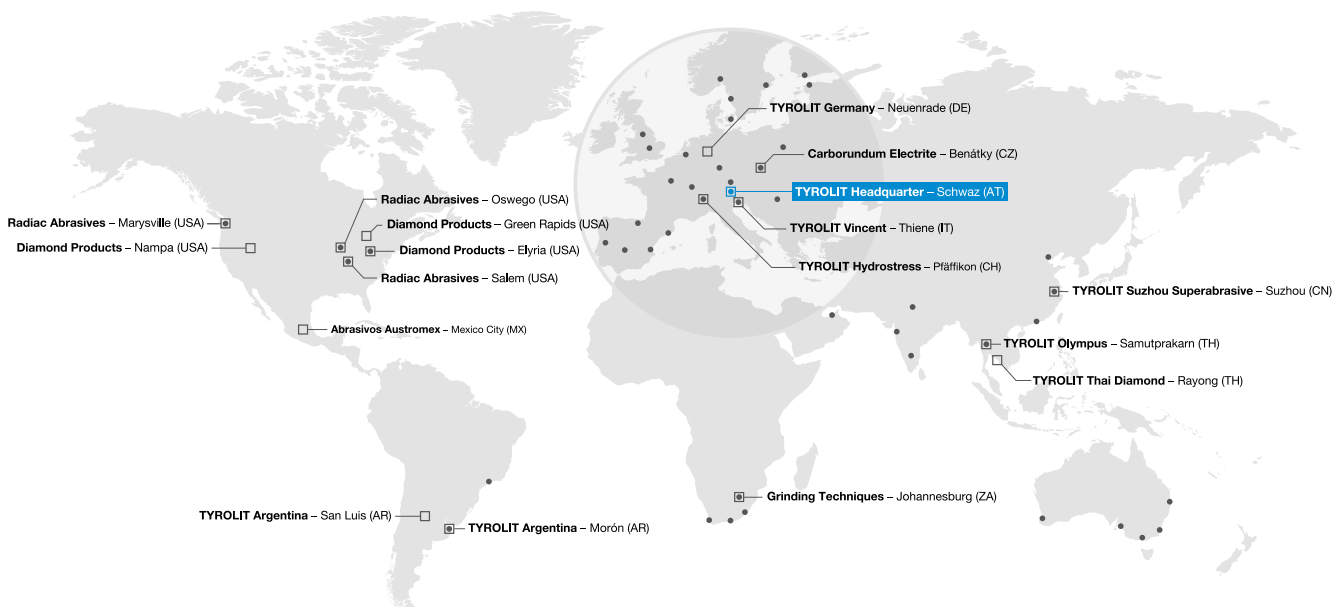
Tyrolit is represented in 29 countries with its own production and sales companies and works with local partners in a further 65 countries.



Production location in Suzhou (China)



European logistics centre in Benátky (Czech Republic)







Why should you buy Tyrolit?

Tyrolit is the technology leader in the field of tool grinding. This know-how is also reflected in the efficient machining of all types of saws. The careful selection and combination of the raw materials used and state-of-the-art manufacturing technologies guarantee the best quality of our grinding tools.

Our expertise in saw sharpening

Our deep understanding of grinding technology is grounded in our focus on the specific needs of saw manufacturers and sharpening. This expertise allows us to provide suppliers with a comprehensive portfolio of products and services.

Customer benefits

Benefit from our experience and secure quality and productivity advantages for your production. Tyrolit optimises your grinding process and thus stands for cost savings and quality improvement.

Application example

By specifically adapting the abrasive and bond system and using new backing materials, it was possible to reduce the risk of fracture of the grinding tool from 30% to 0% during face grinding of carbide-tipped circular saws and to increase the standing time by 10% and the output per hour by 15%. At the same time, the surface finish on the ground saw tooth was improved.

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Specific information

Precision tool

Product label precision tool



Precision tool specification

Ceramics conventional

89A 60 M 5 V 217

					Binding index	Internal code that defines the binding variant
					Bond	
					V	Vitrified bonded
					B	Resin bound
					E	Elastic bound
					G	Galvanically bonded
					Structure	The higher the number, the more open the wheel
					Hardness	The hardness is alphabetical in ascending order
					G	Soft
					R	Hardness
					Grain size description	Grain size specification in mesh (sieve size per inch)
					14 - 36	GROB
					46 - 60	MEDIUM
					80 - 220	FEIN
					800 - 1 200	VERY FINE
Abrasive description						
10A						
Regular aluminium oxide						
50A						
Mixture 89A and 10A						
52A						
Semi-friable aluminium oxide						
80A						
Mixture 88A and special aluminium oxide						
87A						
Mixture 89A and 88A						
88A						
Aluminium oxide pink						
89A						
Aluminium oxide white						
91A						
Aluminium oxide red						
92A						
Mixture 89A and special aluminium oxide						
93A						
Mixture 89A and 91A						
97A						
Special aluminium oxide						
454A						
Mixture of sintered aluminium oxide and 89A						
455A						
Mixture of sintered aluminium oxide and 89A						
C						
Silicon carbide green						
1C						
Silicon carbide black						
50C						
Silicon carbide green/black mixture						
SA						
Aluminium oxide						
SD15A*						
Mixture						
SD25A*						
Mixture						
SD33A*						
Aluminium oxide						
SD35A*						
Mixture						
SD44A*						
Aluminium oxide						
SD46A*						
Mixture						
SD55A*						
Aluminium oxide						
SD56A*						
Mixture						
SD65A*						
Mixture						
SD78A*						
Special aluminium oxide						
SD82A*						
Mixture						
SD83A*						
Mixture						
SD85A*						
Mixture						

*New specification logic - product remains unchanged

B 126 C50 B 54

		Binding index	Internal code that defines the binding variant		
		Bond			
		B	Resin bound		
	M	Metal bound			
	Concentration	The grain concentration denotes the amount of grain in carats per unit volume of the grinding layer			
	Grain size description	Grain size specification in μm (average grain diameter according to FEPA)			
	35 - 181 μm				
Abrasive description					
	B	CBN			
	D	Diamond			



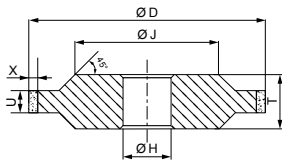
Grinding tools for circular saws

Grinding tools for tungsten carbide and carbide-tipped circular saws

Clearance grinding

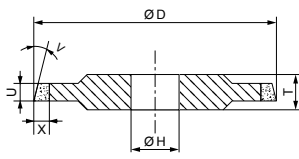


These resin-bonded diamond wheels are available as cup shaped and peripheral wheels. They are also available with single or double coating. Double-coated discs achieve very good cutting edge quality thanks to the combination of two grit sizes and high concentration. This product is available for all common automatic sharpening machines in diameters of 100-150mm. Tyrolit offers a complete assortment for HM circular saws. Customisation in terms of dimensions and specifications is possible depending on customer requirements. Please contact our sales engineers.

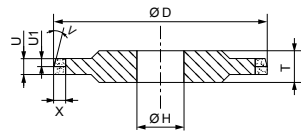


Shape 14A1

	Shape	Type number	D × D × H	Specification	U-X	Machine	Stock
	14A1	462574	150 × 8 × 20	D 64 C100 B48 AL	5-10	e.g. Akemat	
		462886	150 × 8 × 20	D 64 C100 B48 AL	5-8	e.g. Walter AG	

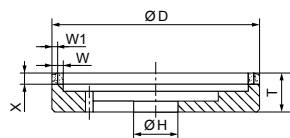


Shape 14B1



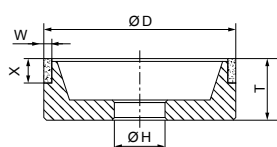
Shape 14M1Z

	Shape	Type number	D × D × H	Specification	U-X-V°	Machine	Stock
	14B1	462503	127 × 8 × 32	D 54 C125 B48 AL	5-8-15	e.g. Akemat	-
	14M1Z	462587	200 × 10 × 32	D 126 C100 B48 AL / D 46 C75 B48	2,5-8-8	e.g. Akemat, Two-layer disc	
		462891	200 × 8 × 32	D 126 C100 B48 AL / D 46 C75 B48	2,5-8-8	e.g. Walter AG, Two-layer disc	-
		462890	175 × 8 × 32	D 126 C100 B48 AL / D 76 C75 B48	2,5-8-8	e.g. Walter AG, Two-layer disc	
		462889	150 × 8 × 32	D 126 C100 B48 AL / D 76 C75 B48	2,5-8-8	e.g. Walter AG, Two-layer disc	-
		462505	127 × 8 × 32	D 126 C100 B48 AL / D 46 C75 B48	2,5-6-5	e.g. Akemat, Two-layer disc	
		462509	127 × 8 × 32	D 126 C100 B48 AL / D 46 C75 B48	2,5-6-15	e.g. Akemat, Two-layer disc	
		462514	127 × 8 × 32	D 126 C125 B48 AL / D 54 C100 B48	32 2,5-6-15	e.g. Akemat, Two-layer disc	-

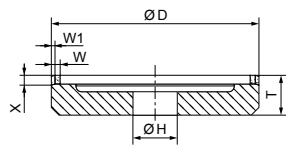


Shape 6A2ZH

	Shape	Type number	D × D × H	Specification	W-X	Machine	Stock
	6A2ZH	462827	125 × 20 × 32	D 126 C100 B65 AL / D 46 C75 B65	2,5-6	e.g. Vollmer Dornhan, double covering	
		462829	125 × 20 × 50,8	D 126 C100 B6 5AL / D 46 C75 B65	2,5-10	e.g. Vollmer Dornhan, double covering	-

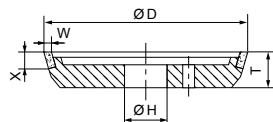


Shape 6A9



Shape 6A9Z

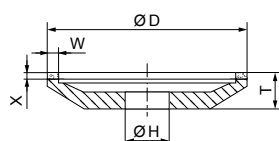
	Shape	Type number	D × D × H	Specification	W-X-V°	Machine	Stock
	6A9	862410	100 × 40 × 27	D 39 75 B52	3-10		
	6A9Z	462824	125 × 26 × 25	D 126 C100 B65 AL / D 46 C75 B65	2,5-6-8	e.g. Vollmer Dorn- han, double covering	
		462734	125 × 20 × 20	D 126 C100 B65 AL / D 46 C75 B65	2,5-6-8	Double coating	
		389569	100 × 20 × 25	D 126 C100 B 42 AL / D 46 75 B42	5-2,5-6	e.g. Vollmer Dorn- han, double covering	-
		365225	100 × 20 × 25	D 126 C100 B65 AL / D 46 C75 B65	2,5-6-8	e.g. Vollmer Dorn- han, double covering	
		462801	100 × 24 × 32	D 126 C100 B65 AL / D 46 C75 B65	2,5-10-8	e.g. Vollmer Dorn- han, double covering	
		462803	100 × 24 × 25	D 126 C125 B65 AL / D 46 C100 B65	2,5-10-8	e.g. Vollmer Dorn- han, double covering	
	6B9H	462830	125 × 20 × 50.8	D 64 C100 B74 AL	3-6-8	e.g. Vollmer Dornhan	



Shape 11B9H

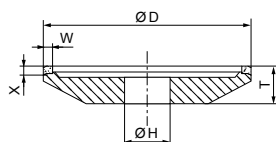
	Shape	Type number	D × D × H	Specification	W-X-V°	Machine	Stock
	11B9H	462756	125 × 18 × 32	D 54 C100 B48 AL	3-6,5-5	e.g. Vollmer Bibe- rach	

	Shape	Type number	D × D × H	Specification	W-X-V°	Machine	Stock
	11V9N	397048	125 × 26 × 25	D 54 C100 B73 AL	3-5-5	e.g. Vollmer Dornhan	
		477813	100 × 20 × 25	D 54 C75 B74 AL	3-6-5	e.g. Vollmer Dornhan	

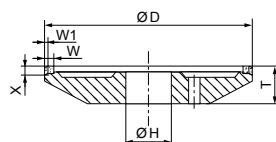


Shape 12A2D

	Shape	Type number	D × D × H	Specification	W-X-V°	Machine	Stock
	12A2D	462949	100 × 27 × 20	D 64 C50 B52 AL	6-4		-
		462950	100 × 27 × 20	D 126 C75 B52 AL	6-4		



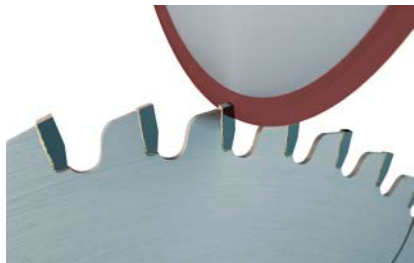
Shape 12A9H



Shape 12A9Z

	Shape	Type number	D × D × H	Specification	W-X-V°	Machine	Stock
	12A9H	462757	125 × 18 × 32	D 91 C100 B48 AL	5-6	e.g. Vollmer Biberach	
	12A9Z	286864	125 × 18 × 32	D 126 C125 B65 AL / D 46 100 B65	5-2,5-6	e.g. Vollmer Biberach, double covering	-
		390582	125 × 18 × 32	D 126 C100 B65 AL / D 46 75 B65	5-2,5-6	e.g. Vollmer Biberach, double covering	-
		387531	125 × 22 × 32	D 126 C100 B65 AL / D 46 C75 B65	2,5-10-8	e.g. Vollmer Biberach, double covering	-
		403578	125 × 22 × 32	D 126 C125 B48 AL / D 46 C100 B48	2,5-10-8	e.g. Vollmer Biberach, double covering	

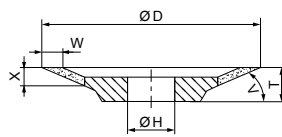
Tip face grinding



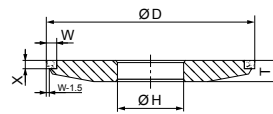
Tyrolit offers you a wide assortment of tools matched to various grinding machines for narrow or wide tooth pitches thanks to customised coating thicknesses and carrier body shapes. This enables perfect surface geometries to be achieved.

Customised dimensions and specifications are possible depending on customer requirements. Please contact our sales engineers.

This product is available for all common sharpening machines in diameters of 100-200 mm.

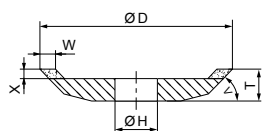


Shape 3V9

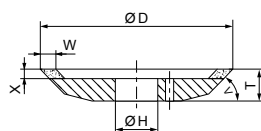


Shape 4B9

	Shape	Type number	D × D × H	Specification	W-X-V°	Machine	Stock
	3V9P	34656319	175 × 18 × 32	D 54 C100 B52 AL	3-5,5-68	e.g. Vollmer Biberach, CHX840	-
	3V9	563857	125 × 13 × 32	D 46 C100 B48 AL	2,5-5,5-70	e.g. Vollmer, Biberach	-
		578936	150 × 13 × 32	D 46 C100 B48 AL	2,5-5,5-70	e.g. Akemat	-
	4B9	369110	125 × 11,5 × 32	D 54 C75 B74 AL	2,5-1,2-15	e.g. Vollmer, Biberach	-
		820013	125 × 12 × 32	D 126 C75 B70 AL	3-1,8-15	e.g. Vollmer, Biberach	-
	4A2N	462839	100 × 8 × 25	D 64 C100 B52 AL	4-2	e.g. Vollmer Dornhan	
	4B9	462730	125 × 8 × 20	D 54 C75 B52 AL	3-1,8-15		
		462729	100 × 8 × 20	D 54 C75 B52 AL	3-1,8-15		
	4B9H	405549	175 × 12 × 50,8	D 76 C125 B48 AL	4-2-15	e.g. Vollmer Dornhan	
	4B9N	463032	125 × 8 × 25	D 76 C125 B48 AL	3-1,8-15	e.g. Widma	
		462845	100 × 8 × 25	D 54 C100 B52 AL	3-1,8-15	e.g. Vollmer Dornhan	

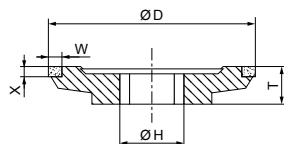


Shape 4V2

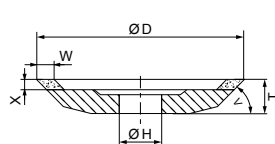


Shape 4V2H

	Shape	Type number	D × D × H	Specification	W-X-V°	Machine	Stock
	4V2	462768	125 × 12 × 32	D 46 C125 B48 AL	4-2-30	e.g. Vollmer Biberach	
		462769	125 × 12 × 32	D 76 C125 B48 AL	4-2-30	e.g. Vollmer Biberach	
		462630	150 × 12 × 32	D 76 C125 B48 AL	4-2-30	e.g. Vollmer Biberach	-
		462631	150 × 12 × 32	D 46 C125 B48 AL	4-2-30	e.g. Vollmer Biberach, Walter AG	-
	4V2H	379577	200 × 13 × 32	D 46 C125 B48 AL	4-2-30	e.g. Vollmer Biberach, Walter AG	-
		462760	200 × 13 × 32	D 76 C125 B48 AL	4-2-30	e.g. Vollmer Biberach	-
		462898	160 × 13 × 32	D 76 C125 B48 AL	4-2-30	e.g. Walter AG	-
		462896	150 × 13 × 32	D 76 C125 B48 AL	3-3-30	e.g. Walter AG	



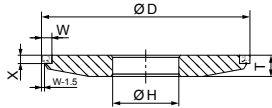
Shape 12B9N



Shape 12V2N

	Shape	Type number	D × D × H	Specification	W-X-V°	Machine	Stock
	12B9N	462833	D 54 C75 B48 AL	125 × 26 × 25	3-3-15	e.g. Vollmer Dornhan	
	12V2	462766	D 46 C125 B48 AL	200 × 13 × 32	4-2-30	e.g. Vollmer Biberach	
		462654	D 46 C125 B48 AL	200 × 14 × 32	4-2-30	e.g. Akemat	
	12V2N	463026	D 46 C100 B48 AL	100 × 10 × 25	4-2-30	e.g. Widma	
		462840	D 46 C125 B48 AL	100 × 10 × 25	4-2-30	e.g. Vollmer Dornhan	

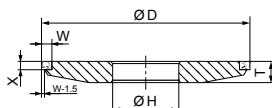
Tip face grinding with large pitch



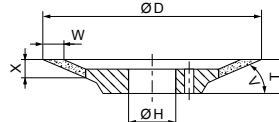
Shape 4B9

	Shape	Type number	D × D × H	Specification	W-X-V°	Machine	Stock
	4B9	665040	125 × 14 × 32	D 54 C75 B70 AL	3-3,8-15	e.g. Vollmer, Biberach, large Tooth pitch	-
		462788	125 × 12 × 32	D 54 C125 B48 AL	3-3,8-15	e.g. Vollmer Biberach	

Tip face grinding with narrow pitch



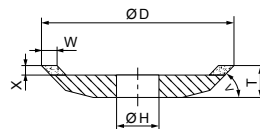
Shape 4B9



Shape 3V9H

	Shape	Type number	D × D × H	Specification	W-X-V°	Machine	Stock
	3V9H	580905	200 × 13 × 32	D 46 C125 B250 AL	2,5-4,4-70		-
	4B9	462646	150 × 12 × 32	D 76 C100 B74 AL	3-2-15	e.g. Akemat, T=12 in Zng. corr.	
		462785	125 × 11,5 × 32	D 76 C125 B48 AL	2,5-1,2-15	e.g. Vollmer Biberach	

Tip face grinding for narrow chip spaces



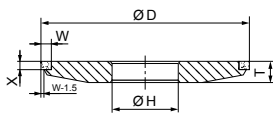
Shape 4V2

	Shape	Type number	D × D × H	Specification	W-X-V°	Machine	Stock
	4V2	34588157	125 × 12 × 32	D 54 C75 B70 AL	4-2-30	e.g. Vollmer Biberach	-

Flank grinding

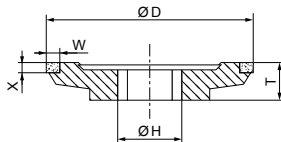


This Tyrolit product is suitable for both regrinding and production grinding and offers a high stock removal rates on tungsten carbide. This is achieved through a reduced concentration and an adapted bond system. The diamond discs are available for all common sharpening machines in diameters of 76–100 mm. Important to note: The 76–80 mm diameter should be used especially for narrow tooth pitches.



Shape 4B9

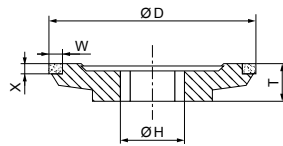
	Shape	Type number	D × D × H	Specification	W-X-V°	Machine	Stock
	4B9	462796	100 × 10 × 32	D 91 C50 B52 AL	6-4	e.g. Vollmer Biberrach	
		328027	100 × 10 × 32	D 91 C50 B42 AL	5-4	e.g. Vollmer	-



Shape 12B9N

	Shape	Type number	D × D × H	Specification	W-X-V°	Machine	Stock
	12B9N	462668	100 × 14 × 32	D 91 C50 B52 AL	6-4-7	e.g. Akemat	
		462863	100 × 14 × 20	D 91 C50 B52 AL	4,5-4	e.g. Vollmer Dornhan	
		474564	100 × 14 × 20	D 91 C50 B53 AL	4,5-4	e.g. Vollmer	-
		331135	100 × 14 × 32	D 64 C75 B74 AL	4,5-4	e.g. Walter AG	-
		840511	100 × 14 × 20	D 64 C75 B74 AL	4,5-4	e.g. Walter AG	
		462658	76 × 14 × 20	D 91 C50 B52 AL	4,5-4	e.g. Akemat	
		462854	76 × 14 × 20	D 91 C50 B52 AL	4,5-4	e.g. Vollmer Dornhan	
		15810	76 × 14 × 20	D 64 C75 B74 AL	4,5-4	e.g. Walter AG	
	3A1R	395363	100 × 17 × 20	D 91 C75 B53 AL	10-4	e.g. Walter AG	

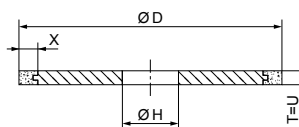
Hollow tooth grinding



Shape 1A1W

	Shape	Type number	D × D × H	Specification	U-X	Machine	Stock
	1A1W	673788	D 76 C125 B ST	7 × 3 × 6	3-2	S6x39	
		198544	D 76 C125 B ST	6 × 3 × 6	3-1,5	S6x42	

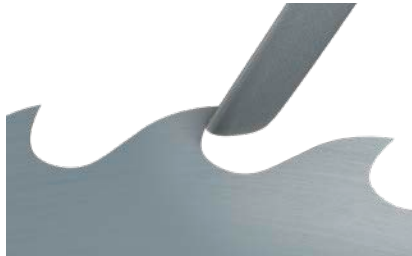
Chip breaker flute grinding



Shape 1A1R

	Shape	Type number	D × D × H	Specification	U-X-R	Machine	Stock
	1A1R	396426	125 × 0,4 × 32	D 126 C125 M ST	0,4-5		
		396424	125 × 0,5 × 32	D 126 C125 M ST	0,5-5		
		882740	125 × 0,8 × 32	D 126 C100 B53 ST	0,8-5		
	1F1R	394798	50 × 0,3 × 20	D 46 C125 M ST	0,3-5-0,15		
		332698	50 × 0,5 × 20	D 46 C125 M ST	0,5-5-0,25	e.g. Walter AG	
		394814	30 × 0,3 × 8	D 46 C125 M ST	0,3-5-0,15		
		394810	30 × 0,4 × 8	D 46 C125 M ST	0,4-5-0,2		
	14F1R	332701	75 × 0,5 × 20	D 126 C125 M ST	0,5-5-0,25	e.g. Walter AG	

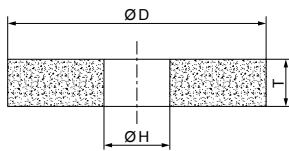
Conventional grinding tools for circular saws made from high-speed steel



Tyrolit offers you a wide assortment of tools matched to various grinding machines and tooth pitches. These are suitable for dry and wet grinding for HSS. The products are available in different edge profiles shape 1, 1F, 1C in the diameter range of 150-350 mm

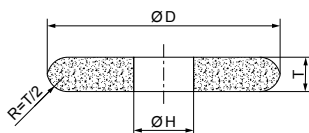
Customised dimensions and specifications are possible depending on customer requirements. Please contact our sales engineers.

Tooth form grinding - resin bonded



Shape 1

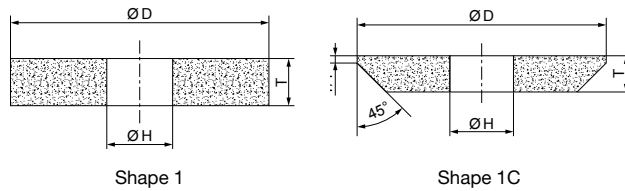
	Shape	Type number	D × D × H	Specification	Vmax m / s	Ben note	VP	Stock
	1	34340600	350 × 13 × 127	765A 80 P6 B100	63		1	-
		34340597	350 × 10 × 32	765 A60 P6 B100	63		1	-
		226680	350 × 13 × 127	M455A 802 M6 B22	63		1	-
		487467	350 × 10 × 127	M455A 80 M6 B22	63		1	-
		226679	350 × 10 × 127	M455A 802 M6 B22	63		1	-
		223733	300 × 12 × 40	M455A 609 M7 B82	63		1	-
		267138	300 × 12 × 40	M455A 809 M6 B22	63		1	-
		313636	300 × 10 × 40	M455A 609 M7 B82	63		1	-
		179959	300 × 10 × 40	M455A 80 M6 B22	63		1	-
		527875	300 × 10 × 32	M455A 609 L7 B82	63		1	-
		241857	300 × 10 × 32	M455A 809 K6 B22	63		1	-
		237227	250 × 10 × 32	M455A 609 M7 B82	63		1	-
		19117	150 × 4 × 20	A 60 N 4B2	63		10	-



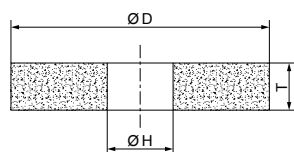
Shape 1F

	Shape	Type number	D × D × H	Specification	Vmax m / s	Remark	VP	Stock
	1F	150402	300 × 10 × 32	M455A 609 L7 B82	63		1	-
		476545	250 × 12 × 32	M455A 609 M7 B82	63		1	-
		150403	200 × 10 × 32	M455A 609 M7 B82	63		1	-

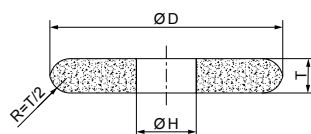
Tooth form grinding - Vitrified bonded



	Shape	Type number	D×D×H	Specification	Vmax m / s	Remark	VP	Stock
	1	7318	200×3×32	88A 80 M5V V217	40		10	-
		448603	200×2×32	88A 80 M5A V217	40		10	-
		719904	150×6×38	88A 60 K5A V217	40		10	-
		490222	150×6×38	88A 80 K5A V217	40		10	-
		291120	150×4×32	88A 80 M5A V217	40		10	-
		9293	150×4×20	88A 80 M5A V217	40		10	-
		55375	150×3×32	88A 80 M5A V217	40		10	-
		18825	150×3×30	88A 80 M5A V217	40		10	-
	1	719922	250×13×32	89A 60 M5A V217	40		10	-
		33249	250×13×20	89A 60 M5A V217	40		10	-
		461239	250×10×32	89A 60 M5A V217	40	Side surface impregnation	1	-
		525686	200×8×32	89A 60 M5A V217	40		10	-
		3077	200×8×20	89A 60 M5A V217	40		10	-
		110554	200×6×32	89A 60 K5A V217	40		10	-
		7328	200×6×32	89A 60 M5V V217	40		10	-
		3070	200×6×20	89A 60 M5A V217	40		10	-
		51494	200×13×32	89A 60 M5A V217	40		10	-
		3091	200×10×32	89A 60 K5A V217	40		10	-
		3092	200×10×32	89A 60 M5V V217	40		10	-
		608080	200×10×32	89A 60 M5A V217	40		10	-
		762445	200×10×32	89A 60 M5A V217	40	Side surface impregnation	10	-
	1C	28549	200×10×32	89A 60 M5A V217	63		10	-
	1	3085	200×10×20	89A 60 M5A V217	40		10	-
		50845	175×8×51	89A 60 M5A V217	40		10	-
		123222	175×6×51	89A 60 M5A V217	40		10	-
		50844	175×4×51	89A 60 M5A V217	40		10	-
		719906	175×3×51	89A 60 M5A V217	40		10	-
		455124	150×8×32	89A 60 M5A V217	40		10	-
		305800	150×6×32	89A 60 M5A V217	40		10	-
		10265	150×10×32	89A 60 M5A V217	40		10	-

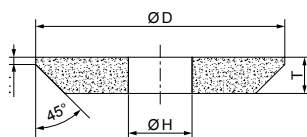


Shape 1



Shape 1F

	Shape	Type number	D × D × H	Specification	Vmax m / s	Remark	VP	Stock
	1	901258	250 × 6 × 32	SA 60 L5 VN-MOD	63		10	-
		901256	250 × 5 × 32	SA 60 L5 VN-MOD	63		10	-
		901254	250 × 4 × 32	SA 80 L4 VN-MOD	63		10	-
		804976	200 × 8 × 32	SA 60 L5 VN-MOD	63		10	-
		805000	200 × 6 × 32	SA 60 L5 VN-MOD	63		10	-
		804993	200 × 5 × 32	SA 60 L5 VN-MOD	63		10	-
		804945	200 × 4 × 32	SA 80 L5 VN-MOD	63		10	-
		922860	200 × 3 × 32	SA 80 L5 VN-MOD	63		10	-
		804957	200 × 3.5 × 32	SA 80 L5 VN-MOD	63		10	-
		922857	200 × 2 × 32	SA 80 L4 VN-MOD	63		10	-
		867603	200 × 2.5 × 32	SA 80 L4 VN-MOD	63		10	-
		804979	200 × 10 × 32	SA 60 L5 VN-MOD	63		10	-
		804963	200 × 1.75 × 32	SA 80 L4 VN-MOD	63		10	-
		922647	200 × 1.5 × 32	SA 80 L4 VN-MOD	63		10	-
		441302	150 × 8 × 32	SA 60 L5 VN-MOD	63		10	-
		740907	150 × 6 × 38	SA 80 J5 VN-MOD	63		10	-
		17256	150 × 6 × 38	SA 60 K5 VN-MOD	63		10	-
		946904	150 × 6 × 32	SA 60 L5 VN-MOD	63		10	-
		47005	150 × 6 × 32	SA 80 L4 VN-MOD	63		10	-
		667182	150 × 5 × 32	SA 80 L5 VN-MOD	63		10	-
		47010	150 × 4 × 32	SA 80 L4 VN-MOD	63		10	-
		159000	150 × 4 × 32	SA 80 L5 VN-MOD	63		10	-
		47009	150 × 3 × 32	SA 80 L4 VN-MOD	63		10	-
		226295	150 × 3 × 32	SA 80 L5 VN-MOD	63		10	-
		935730	150 × 2 × 32	SA 80 L4 VN-MOD	63		10	-
		123688	150 × 2.5 × 32	SA 80 L4 VN-MOD	63		10	-
		441301	150 × 10 × 32	SA 60 L5 VN-MOD	63		10	-
		292129	150 × 1.5 × 32	SA 80 L4 VN-MOD	63		10	-
		437634	250 × 10 × 32	52 A54 M5A V217	63	Side surface impregnation	10	-
	1F	805017	250 × 8 × 32	SA 60 K5 VN-MOD	63		10	-
		805015	250 × 13 × 32	SA 60 K5 VN-MOD	63		10	-
		805018	250 × 10 × 32	SA 60 K5 VN-MOD	63		10	-
		805007	200 × 8 × 32	SA 60 K5 VN-MOD	63		10	-
		805008	200 × 10 × 32	SA 60 K5 VN-MOD	63		10	-
		804983	200x10x32	SA 60 L5 VN-MOD	63		10	-



Shape 1C

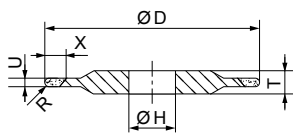
	Shape	Type number	D × D × H	Specification	Vmax m / s	Remark	VP	Stock
	1C	162874	200 × 12 × 20	88A 60 N4A V217 / 89A 60 M5A V217	40	Two-layer disc	10	-
		720012	200 × 10 × 32	88A 60 N4A V217 / 89A 60 M5A V217	40		10	-
		719918	200 × 10 × 20	88A 60 N4A V217 / 89A 60 M5A V217	40		10	-
		172352	175 × 8 × 20	88A 60 N4A V217 / 89A 60 M5A V217	40		10	-

Grinding tools with CBN for circular saws made of high-speed steel

Tooth form grinding

This Tyrolit product is suitable for both repair and production grinding and offers you high stock removal rates on HSS. The CBN tool for tooth form grinding has been specially designed for wet grinding with emulsion and oil. The CBN tools are available for all common automatic sharpening machines in diameters of 150-200 mm.

Customised dimensions and specifications are possible depending on customer requirements. Please contact our sales engineers.



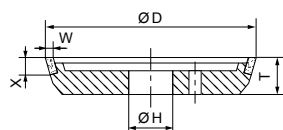
Shape 14F1



Shape	Type number	D × D × H	Specification	U-X-R	Remark	Stock
14F1	34587357	200 × 8 × 32	B 126 C125 B87 ST	1-8,4-0,5	e.g. Schmidt-Tempo, Loroach, Record	
	462924	200 × 8 × 32	B 126 C125 B87 ST	1,3-8,4-0,65	e.g. Schmidt-Tempo, Loroach, Record	-
	454693	200 × 8 × 32	B 126 C125 B87 ST	1,6-8,4-0,8	e.g. Schmidt-Tempo, Loroach, Record	-
	462928	200 × 8 × 32	B 126 C125 B87 ST	2-8,4-1	e.g. Schmidt-Tempo, Loroach, Record	-
	462932	200 × 8 × 32	B 151 C125 B87 ST	2,5-8,4-1,25	e.g. Schmidt-Tempo, Loroach, Record	
	462937	200 × 8 × 32	B 151 C125 B87 ST	3-12,5-1,5	e.g. Schmidt-Tempo, Loroach, record	-
	34050324	200 × 8 × 32	B 151 C125 B87 ST	4-12,5-2	e.g. Schmidt-Tempo, Loroach, Record	
	34069157	200 × 8 × 32	B 151 C125 B87 ST	5-12,5-2,5	e.g. Schmidt-Tempo, Loroach, Record	
	462948	200 × 8 × 32	B 151 C125 B54 AL	6-12,5-3	e.g. Schmidt-Tempo, Loroach, record	
	462909	150 × 20 × 20	B 126 C125 B87 ST	1-8,4-0,5	e.g. Schmidt-Tempo	
	462911	150 × 20 × 20	B 126 C125 B87 ST	1,3-8,4-0,65	e.g. Schmidt-Tempo	
	462914	150 × 20 × 20	B 126 C125 B87 ST	2-8,4-1	e.g. Schmidt-Tempo	
	462916	150 × 20 × 20	B 151 C125 B87 ST	2,5-8,4-1,25	e.g. Schmidt-Tempo	
	462918	150 × 20 × 20	B 151 C125 B87 ST	3-8,4-1,5	e.g. Schmidt-Tempo	

Clearance grinding

This resin-bonded CBN wheel is ideal for use on HSS materials. And available in diameters of 100-125 mm.

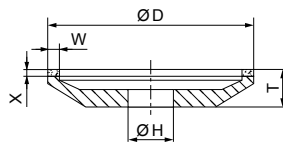
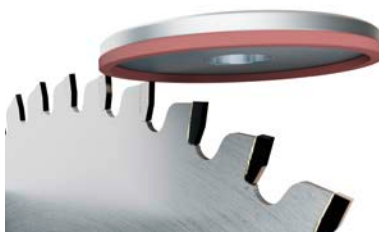
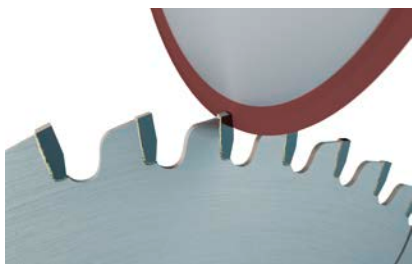


Shape 11B9H

	Shape	Type number	D × D × H	Specification	W-X-V°	Remark	Stock
	11B9H	489258	125 × 18 × 32	B 91 C100 B74 AL	3-6,5-5	e.g. Vollmer Biberach	
	11V9N	489320	100 × 20 × 25	B 91 C75 B74 AL	3-6-5	e.g. Vollmer Dornhan	

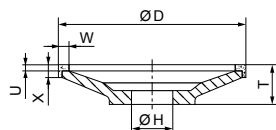
Face and clearance grinding

These resin bonded wheels are versatile in the HSS range.



Shape 12A2

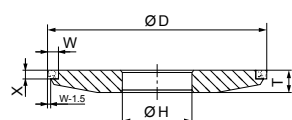
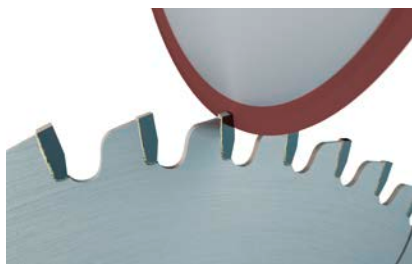
	Shape	Type number	D × D × H	Specification	W-X	Remark	Stock
	12A2	463058	125 × 16 × 20	B 126 C50 B54 AL	5-2		
		463057	100 × 14 × 20	B 126 C50 B54 AL	5-2		



Shape 12C2F

	Shape	Type number	D × D × H	Specification	U-W-X	Remark	Stock
	12C2F	646778	125 × 23 × 20	B 91 C75 B45 AL-AMIGO	5-5-4		-
		641839	125 × 23 × 20	B 151 C75 B45 AL-AMIGO	5-5-4		-

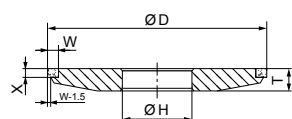
Tip face grinding



Shape 4B9

	Shape	Type number	D × D × H	Specification	W-X-V°	Remark	Stock
	4B9	462789	125 × 12 × 20	B 91 C75 B54 AL	3-1,8-15	e.g. Vollmer Biberach	
		462793	125 × 14 × 20	B 91 C75 B54 AL	3-3,8-15	e.g. Vollmer Biberach	

Flank grinding



Shape 4B9

	Shape	Type number	D × D × H	Specification	W-X	Remark	Stock
	4B9	462736	100 × 10 × 32	B 91 C50 B54 AL	5-4		

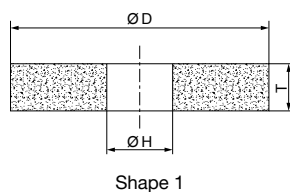
Bevel grinding

	Shape	Type number	D × D × H	Specification	U-W-V°	Machine	Stock
	14B1R	463063	200 × 8 × 32	B 126 C100 B48 ST	1,5-5-10	e.g. Schmidt-Tempo	

Form grinding

Grinding wheels for form grinding on circular saw blades; available in different bond variants to increase the lateral stability of the grinding wheel

Form grinding

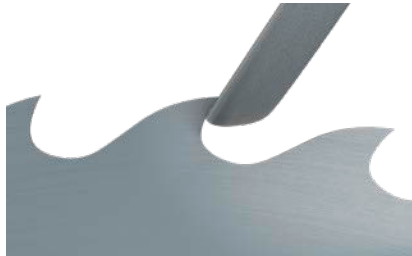


	Shape	TN	D × D × H	Specification	Vmax m/s	Machine	Stock
	1	491885	500 × 50 × 127	C46-BE19F	32	e.g. Engländer&Beyer	
		491895	500 × 50 × 127	C46-BE16	32	e.g. Engländer&Beyer	
		491882	400 × 25 × 127	C46-BE19F	32	e.g. Gerling, Englän- der&Beyer	
		491893	400 × 25 × 127	C46-BE16	32	e.g. Gerling, Englän- der&Beyer	
		491883	400 × 50 × 127	C46-BE19F	32	e.g. Engländer&Beyer	
		491894	400 × 50 × 127	C46-BE16	32	e.g. Engländer&Beyer	
		491880	350 × 40 × 127	C46-BE19F	32	e.g. Gerling	
		826979	300 × 35 × 127	C46-BE19F	32	e.g. Gerling	
		491875	250 × 25 × 32	C46-BE19F	32	e.g. Vollmer, Pet- schauer	
		491888	250 × 25 × 32	C46-BE16	32	e.g. Vollmer, Pet- schauer	
		491889	250 × 40 × 25	C46-BE16	32	e.g. Petschauer	
		491874	200 × 25 × 32	C46-BE19F	32	e.g. Vollmer, Pet- schauer	



Grinding tools for bandsaws

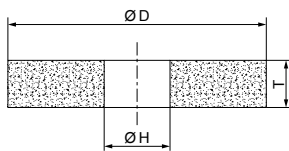
Conventional grinding tools for bandsaws made from high-speed steel



Tyrolit offers you a wide assortment of tools matched to various grinding machines and tooth pitches. These are suitable for dry and wet grinding for HSS, CV and stellite bandsaws. The products are available in different edge profiles shape 1, 1F, 1C in the diameter range of 150-350 mm

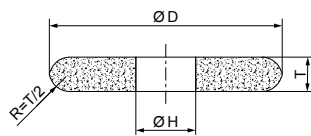
Customised dimensions and specifications are possible depending on customer requirements. Please contact our sales engineers.

Tooth form grinding - resin bonded



Shape 1

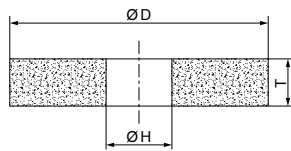
	Shape	Type number	D×D×H	Specification	Vmax m / s	Remark	VP	Stock
	1	469639	300×32×32	455 A80 M6 B22	35	e.g. Iseli & Co. AG, log band gang saws	1	
		469638	300×30×32	455 A80 M6 B22	35		1	
		469637	300×25×32	455 A80 M6 B22	35		1	
		469632	300×22×32	455 A80 M6 B22	35		1	
		469627	300×20×32	455 A80 M6 B22	35		1	
		469626	300×18×32	455 A80 M6 B22	35		1	
		469625	300×16×32	455 A80 M6 B22	35		1	
		469624	300×13×32	455 A80 M6 B22	35		1	
		239527	300×10×32	455 A80 M6 B22	35		1	
		469657	250×32×25	455 A80 M6 B22	35		1	
		469656	250×30×25	455 A80 M6 B22	35		1	
		469655	250×25×25	455 A80 M6 B22	35		1	
		469654	250×20×25	455 A80 M6 B22	35		1	
		469648	250×18×25	455 A80 M6 B22	35		1	
		469646	250×16×25	455 A80 M6 B22	35		1	
		469644	250×12×25	455 A80 M6 B22	35		10	
		469643	250×10×25	455 A80 M6 B22	35		10	
		34340600	350×13×127	765A 80 P6 B100	63	for stellite band and gang saws	1	-
		34340597	350×10×32	765A 60 P6 B100	63		1	-
		226680	350×13×127	M455 A80 M6 B22	63		1	-
		487467	350×10×127	M455 A80 M6 B22	63		1	-
		226679	350×10×127	M455 A802 M6 B22	63		1	-
		223733	300×12×40	M455 A60 M7 B82	63		1	-
		267138	300×12×40	M455 A809 M6 B22	63		1	-
		313636	300×10×40	M455 A60 M7 B82	63		1	-
		179959	300×10×40	M455 A80 M6 B22	63		1	-
		527875	300×10×32	M455 A60 L7 B82	63		1	-
		241857	300×10×32	M455 A809 K6 B22	63		1	-
		237227	250×10×32	M455 A60 M7 B82	63		1	-



Shape 1F

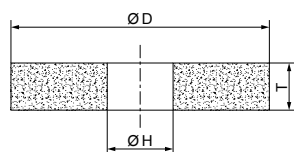
	Shape	Type number	D × D × H	Specification	Vmax m / s	Remark	VP	Stock
	1F	150402	300 × 10 × 32	M455 A60 L7 B82	63	For stellited band and gang saws	1	-
		476545	250 × 12 × 32	M455 A60 M7 B82	63		1	-
		150403	200 × 10 × 32	M455 A60 M7 B82	63		1	-

Tooth form grinding - Vitrified bonded

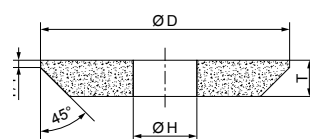


Shape 1

	Shape	Type number	D × D × H	Specification	Vmax m / s	Remark	VP	Stock
	1	719904	150 × 6 × 38	88A 60 K5A V217	40		10	-
		490222	150 × 6 × 38	88A 80 K5A V217	40		10	-
		448603	200 × 2 × 32	88A 80 M5A V217	40		10	-
		291120	150 × 4 × 32	88A 80 M5A V217	40		10	-
		9293	150 × 4 × 20	88A 80 M5A V217	40		10	-
		55375	150 × 3 × 32	88A 80 M5A V217	40		10	-
		18825	150 × 3 × 30	88A 80 M5A V217	40		10	-
		7318	200 × 3 × 32	88A 80 M5 V217	40		10	-



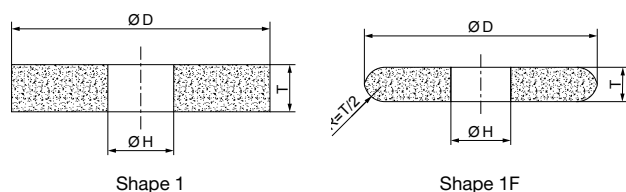
Shape 1



Shape 1C

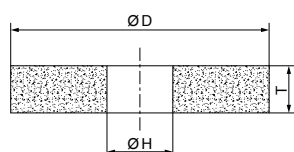


Shape	Type number	D×D×H	Specification	Vmax m / s	Remark	VP	Stock
1	110554	200×6×32	88A 60 K5A V217	40		10	-
	3091	200×10×32	89A 60 K5A V217	40		10	-
	719922	250×13×32	89A 60 M5A V217	40		10	-
	33249	250×13×20	89A 60 M5A V217	40		10	-
	461239	250×10×32	89A 60 M5A V217	40	Side surface impreg- nation	1	-
	525686	200×8×32	89A 60 M5A V217	40		10	-
	3077	200×8×20	89A 60 M5A V217	40		10	-
	3070	200×6×20	89A 60 M5VA 217	40		10	-
	51494	200×13×32	89A 60 M5A V217	40		10	-
	608080	200×10×32	89A 60 M5A V217	40		10	-
	762445	200×10×32	89A 60 M5A V217	40	Side surface impreg- nation	10	-
	3085	200×10×20	89A 60 M5A V217	40		10	-
	50845	175×8×51	89A 60 M5A V217	40		10	-
	123222	175×6×51	89A 60 M5A V217	40		10	-
	50844	175×4×51	89A 60 M5A V217	40		10	-
	719906	175×3×51	89A 60 M5A V217	40		10	-
	455124	150×8×32	89A 60 M5A V217	40		10	-
	305800	150×6×32	89A 60 M5A V217	40		10	-
	10265	150×10×32	89A 60 M5A V217	40		10	-
1C	28549	200×10×32	89A 60 M5A V217	40		10	-
1	7328	200×6×32	89A 60 M5 V217	40		10	-
	3092	200×10×32	89A 60 M5 V217	40		10	-



	Shape	Type number	D × D × H	Specification	Vmax m / s	Remark	VP	Stock
	1	17256	150 × 6 × 38	SA 60 K5 VN-MOD	63		10	-
	1F	805017	250 × 8 × 32	SA 60 K5 VN-MOD	63		10	-
		805015	250 × 13 × 32	SA 60 K5 VN-MOD	63		10	-
		805019	250 × 12 × 32	SA 60 K5 VN-MOD	63		10	-
		805018	250 × 10 × 32	SA 60 K5 VN-MOD	63		10	-
		805007	200 × 8 × 32	SA 60 K5 VN-MOD	63		10	-
		805009	200 × 12 × 32	SA 60 K5 VN-MOD	63		10	
		805008	200 × 10 × 32	SA 60 K5 VN-MOD	63		10	-
	1	901258	250 × 6 × 32	SA 60 L5 VN-MOD	63		10	-
		901256	250 × 5 × 32	SA 60 L5 VN-MOD	63		10	-
		901255	250 × 4.5 × 32	SA 60 L5 VN-MOD	63		10	
		804977	200 × 9 × 32	SA 60 L5 VN-MOD	63		10	
		804976	200 × 8 × 32	SA 60 L5 VN-MOD	63		10	-
		805002	200 × 7 × 32	SA 60 L5 VN-MOD	63		10	-
		805000	200 × 6 × 32	SA 60 L5 VN-MOD	63		10	-
		805001	200 × 6.5 × 32	SA 60 L5 VN-MOD	63		10	
		804993	200 × 5 × 32	SA 60 L5 VN-MOD	63		10	-
		804996	200 × 5.5 × 32	SA 60 L5 VN-MOD	63		10	
		804995	200 × 4.5 × 32	SA 60 L5 VN-MOD	63		10	
		804979	200 × 10 × 32	SA 60 L5 VN-MOD	63		10	-
		441302	150 × 8 × 32	SA 60 L5 VN-MOD	63		10	-
		946904	150 × 6 × 32	SA 60 L5 VN-MOD	63		10	-
		909887	150 × 5.5 × 32	SA 60 L5 VN-MOD	63		10	
		441301	150 × 10 × 32	SA 60 L5 VN-MOD	63		10	-
	1F	804986	200 × 8 × 32	SA 60 L5 VN-MOD	63		10	-
		804983	200 × 10 × 32	SA 60 L5 VN-MOD	63		10	-
	1	740907	150 × 6 × 38	SA 80 J5 VN-MOD	63		10	-
		901254	250 × 4 × 32	SA 80 L4 VN-MOD	35		10	-
		901252	250 × 3 × 32	SA 80 L4 VN-MOD	35		10	
		901253	250 × 3.5 × 32	SA 80 L4 VN-MOD	35		10	
		804964	200 × 2 × 32	SA 80 L4 VN-MOD	35		10	
		922857	200 × 2 × 32	SA 80 L4 VN-MOD	35		10	-
		804967	200 × 2.75 × 32	SA 80 L4 VN-MOD	35		10	
		804966	200 × 2.5 × 32	SA 80 L4 VN-MOD	35		10	-
		867603	200 × 2.5 × 32	SA 80 L4 VN-MOD	35		10	-
		804965	200 × 2.25 × 32	SA 80 L4 VN-MOD	35		10	-
		804963	200 × 1.75 × 32	SA 80 L4 VN-MOD	35		10	-
		804962	200 × 1.5 × 32	SA 80 L4 VN-MOD	35		10	-
		922647	200 × 1.5 × 32	SA 80 L4 VN-MOD	35		10	-

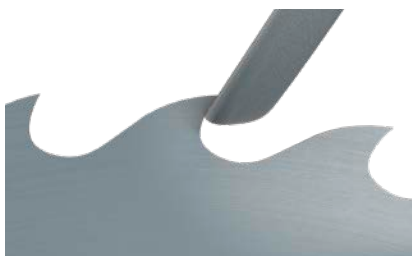
	Shape	Type number	D×D×H	Specification	Vmax m / s	Remark	VP	Stock
	1	47005	150×6×32	SA 80 L4 VN-MOD	35		10	-
		47010	150×4×32	SA 80 L4 VN-MOD	35		10	-
		47009	150×3×32	SA 80 L4 VN-MOD	35		10	-
		292130	150×2×32	SA 80 L4 VN-MOD	35		10	
		935730	150×2×32	SA 80 L4 VN-MOD	35		10	-
		444687	150×2.75×32	SA 80 L4 VN-MOD	35		10	
		123688	150×2.5×32	SA 80 L4 VN-MOD	35		10	-
		212089	150×2.25×32	SA 80 L4 VN-MOD	35		10	
		241847	150×1.75×32	SA 80 L4 VN-MOD	35		10	
		292129	150×1.5×32	SA 80 L4 VN-MOD	35		10	-
		804945	200×4×32	SA 80 L5 VN-MOD	63		10	-
		804954	200×3×32	SA 80 L5 VN-MOD	63		10	-
		922860	200×3×32	SA 80 L5 VN-MOD	63		10	-
		804958	200×3.75×32	SA 80 L5 VN-MOD	63		10	
		804957	200×3.5×32	SA 80 L5 VN-MOD	63		10	-
		804955	200×3.25×32	SA 80 L5 VN-MOD	63		10	
		93906	150×5×32	SA 80 L5 VN-MOD	63		10	
		667182	150×5×32	SA 80 L5 VN-MOD	63		10	-
		292131	150×4×32	SA 80 L5 VN-MOD	63		10	
		159000	150×4×32	SA 80 L5 VN-MOD	63		10	-
		110674	150×4.5×32	SA 80 L5 VN-MOD	63		10	
		226295	150×3×32	SA 80 L5 VN-MOD	63		10	-
		935731	150×3.5×32	SA 80 L5 VN-MOD	63		10	
		437634	250×10×32	52A 54 M5A V217 E5 63		Side surface impregnation	10	-
		19117	150×4×20	A 60 N4 B2	63		10	-



Shape 1C

	Shape	Type number	D×D×H	Specification	Vmax m / s	Remark	VP	Stock
	1C	162874	200×12×20	88A 60 N4A V217 / 89A 60 M5A V217	40		10	-
		720012	200×10×32	88A 60 N4A V217 / 89A 60 M5A V217	40	Two-layer disc	10	-
		719918	200×10×20	88A 60 N4A V217 / 89A 60 M5A V217	40		10	-
		172352	175×8×20	88A 60 N4A V217 / 89A 60 M5A V217	40		10	-

Grinding tools with CBN for bandsaws made of high-speed steel

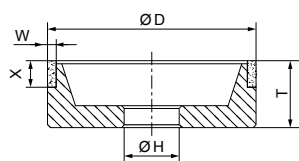


This Tyrolit product is suitable for both repair and production grinding and offers you high stock removal rates on HSS. The CBN tool for tooth form grinding has been specially designed for wet grinding with emulsion and oil. The CBN tools are available for all common automatic sharpening machines in diameters of 150-350 mm.

Tooth form grinding

	Shape	Type number	D × D × H	Specification	Vmax m / s	Remark	Stock
	1FF1R	860493	300 × 10 × 127	10-5-9	B 151 C100 B74 AL		
		659662	250 × 10,5 × 40	10,5-5-12	B 151 C75 B74 AL		
		859934	200 × 10 × 127	10-6-9	B 151 C100 B74 AL		
	3FF1R	893810	350 × 10 × 127	6-4-8	B 151 C125 B70 AL	e.g. Iseli & Co. AG, Blockband- Gang saws	
		259467	300 × 12 × 40	10-5-15	B 126 C100 B74 AL		
		132283	250 × 11 × 32	6-6-9	B 151 C100 B74 AL		
		789465	250 × 11 × 25	8-6-9	B 151 C75 M112 ST		

Side grinding



Shape 6A9

	Shape	Type number	D × D × H	Specification	Vmax m / s	Remark	Stock
	6A9	34670479	125 × 35 × 20	3-10	B 126 C100 B250 AL		
		34670480	125 × 35 × 20	3-10	B L126-3-PD	STARTEC-BASIC	

Precision data sheet			Mounting by: am:	
Customer	ATDB no.		Country:	
	Target group:		Product family:	
	Requirement d. Pos:			
	Customer: *		Classification:	
	Department:		Customer no:	
	Contact person:		Tel. / Fax:	
Customer	Shape: *		1 set = pcs:	
	Dimensions (mm): *			
	Dimensions (mm):		Tolerance:	
	Specification:			
	Manufacturer:		Current price:	
	Vs max. (m/s) *		Order quantity:	
Customer	Grinding process:			
	Machine manufacturer:			
	Vs (m/s):			
	Cooling lubricant:			
	Dressing tool:			
	Dressing cycle:		Dressing amount:	
Workpiece	Workpiece: *		Dimensions (mm): *	
	Material group: *		Allowance (mm):	
	Condition: *		Hardness: *	
Goal	Roughness depth:		Contact time:	
	Lifetime:			
	Additive:			
Sample	Specification:			
	Specification:			
	Specification:			
Info			Drawing:	
Distributor:				

*MANDATORY fields highlighted in grey

Tyrolit - Schleifmittelwerke Swarovski AG & Co K.G.

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