Universal grinding wheels from
KREBS & RIEDEL

Our MULTO series

KREBS
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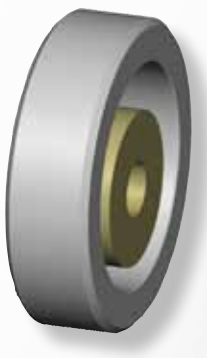
Our MULTO selection

The newly developed V86 and V87 bonding systems supplement our well-proven MULTO Classic (V84) and MULTO Blue (V85) systems. Thanks to optimal bonding of the abrasive particles, this low-temperature vitrified bond system with its increased porosity is also suitable for working speeds up to vc = 80 m/s.

Features:

- High to very high porosity with optimal profile retention
- Low percentage of bonding material („cool grind“)
- Minimal wear to dressing tools
- Faster grinding times
- Reduced work-piece thermal damage

The MULTO grinding process



Internal grinding using oscillating and plunge-cut processes

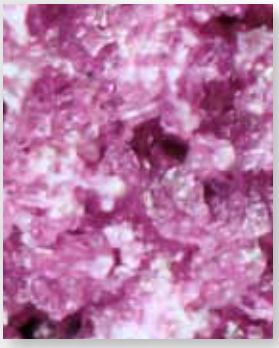
Surface and profile grinding using reciprocating and creep-feed grinding

External cylindrical grinding using oscillating, plunge and angular-plunge processes

Profile and generating type gear grinding

MULTO Classic (V84)

The universal classic! Its success is based on a wide spectrum of applications. This is achieved by application tested selection of the combination of abrasive particles, percentage of the bonding material and the microstructures. Multo Classic (V84) is a proven bond system for many grinding applications and a wide range of materials.



MULTO Blue (V85)

Would you like increased material removal rates for your robust parts ? Then our MULTO Blue (V85), with sintered aluminium oxide is just the right solution. Long tool life combined with substantial cutting performance reduces your per unit costs.

MULTO Green (V86)

Multo Green (V86) was developed for external cylindrical angular-plunge grinding when the grinding wheel must work with light pressure to insure that the “N” face of the work-piece is at exactly 90° to the circumference. Our MULTO Green (V86) bonding system has frequently proven its worth in these applications even at working speeds of up to vc = 63 m/s.

MULTO Yellow (V87)

MULTO Yellow (V87) was developed to further increase wheel form holding ability when very high porosity is required. To reduce dressing tool wear, sintered micro cristalline aluminium oxide is not used.

The correct grinding wheel, every time and for every application

We do not just pursue our uncompromising requirement for quality for the tools in our MULTO series, but also for our entire manufacturing range:

- Aluminium Oxide and silicon carbide wheels with vitrified and resin bonding with an external diameter up to 900 mm for cylindrical grinding, flat grinding, tool grinding, centerless grinding, rough grinding, etc.
- Cut-off wheels with resin bonding, with or without fibre reinforcement up to an external dia meter of 600 mm for wet or dry chop cuts, for reciprocal or rotary cutting, etc.
- Foundry grinding wheels with or without fibre reinforcement for contract foundry and the casting industry, for reciprocal grinding machi nes, bench grinders, robotic grinding equipment, etc.
- CBN and diamond grinding wheels with vitrified bonding with working speeds of up to 160 m/s for internal grinding, flat grinding, cylindrical grinding, tool grinding, special grinding methods, etc.

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