

DIAMANT

DIAMANT

DIAMOND

DIAMANTE

GYÉMÁNT

DIAMANTE

SELECTION OF DIAMOND TOOLS 378



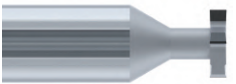
MILLING CUTTERS 384



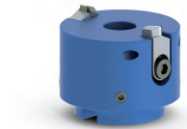
CHAMFERING TOOLS 390



ENGRAVING TOOLS 391



SPECIAL MILLING TOOLS 392



FACE MILLING CUTTERS 394



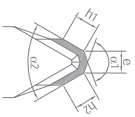
DRILLS 395



REAMERS 396



TURNING TOOLS 398



RANGE OF SPECIAL SHAPES 401



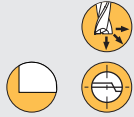
DIADIX® WHEEL DRESSERS 403







CUTTING CONDITIONS 406

SELECTION OF DIAMOND TOOLS


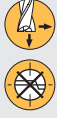


✓ = item from stock

MILLING CUTTERS		Z			PCD ●	CVD ■	DIA ◆		
DIXI 72420-SH Ø 2.00 - 20.00		1 - 2	384		✓	✓			
DIXI 70520-SH Ø 1.00 - 20.00		1 - 2	385		✓	✓			
DIXI 70600 PCD Ø 1.00 - 10.00		1	386		✓				
DIXI 70600 DIA Ø 3.00 - 6.00		1	386				✓		
DIXI 72310 DIA Ø 0.40 - 2.00		1	387				✓		
DIXI 72421 DIA Ø 6.00 - 12.00		1	388				✓		
DIXI 70320-SH Ø 2.00 - 20.00		1 - 2	389		✓				
DIXI 70320 DIA Ø 2.00 - 20.00		1	388				✓		

CHAMFERING TOOLS

DIXI 76230 DIA Ø 0.10 - 0.30		1	390				✓		
DIXI 76231 DIA		1	390				✓		

ENGRAVING TOOLS

DIXI 70170 DIA Ø 0.05 - 0.10		1	391				✓		
DIXI 70170 PCD Ø 0.10 - 0.20		1	391		✓				

○ good ⊙ excellent

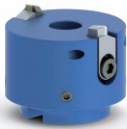

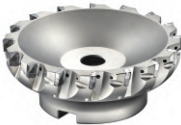



Cu alloy Silver Gold	Cu alloy difficult to machine	Al 4 - 8% Si	Al 8 - 13% Si	Graphite	Unsintered carbide Ceramics	Plastic	Carbon fibres	
⊙	⊙	⊙	○	○	○	⊙	○	
⊙	⊙	⊙	○	○	○	⊙	○	
⊙	⊙	⊙	○	○	○	⊙	○	
⊙	⊙	⊙	○			⊙		
⊙	⊙	⊙	○			⊙		
⊙	⊙	⊙	○			⊙		
⊙	⊙	⊙	○	○	○	⊙	○	
⊙	⊙	⊙	○			⊙		
⊙	⊙	⊙	○			⊙		
⊙	⊙	⊙	○			⊙		
⊙	⊙	⊙	○			⊙		
⊙	⊙	⊙	○			⊙		
⊙	⊙	⊙	○	○	○	⊙	○	





SELECTION OF DIAMOND TOOLS

✓ = item from stock











FACE MILLING CUTTERS

	Z	Page		PCD ●	CVD ■	DIA ◆		
DIXI 81000 Ø 40 - 100	2	394						
DIXI 80000 Ø 40 - 125	6 - 16	395						









DRILLS

DIXI 11140	1	395						
DIXI 11180	2	395						

REAMERS

POLY 40010-TC Ø 8.00 - 22.10	4	396						
POLY 40010-FC Ø 8.00 - 22.10	4	396						
DIXI 25800	-	396						
DIXI 25810	-	396						

TURNING TOOLS

DIXI 20610	-	397						
DIXI 20770	-	397						
DIXI 26500 TR	-	398			✓			
DIXI 26500 FT	-	398			✓			




○ good ⊙ excellent

Cu alloy Silver Gold	Cu alloy difficult to machine	Al 4 - 8% Si	Al 8 - 13% Si	Graphite	Unsintered carbide Ceramics	Plastic	Carbon fibres	
⊙	⊙	⊙	○			⊙		
⊙	⊙	⊙	○					
⊙	⊙	⊙	○	○	○	⊙	○	
⊙	⊙	⊙	○	○	○	⊙	○	
⊙	⊙	⊙	○	○	○	⊙	○	
⊙	⊙	⊙	○	○	○	⊙	○	
⊙	⊙	⊙	○	○	○	⊙	○	
⊙	⊙	⊙	○	○	○	⊙	○	



SELECTION OF DIAMOND TOOLS

✓ = item from stock

		Z	Page		PCD ●	CVD ■	DIA ◆		
TURNING TOOLS									
DIXI 26500 AV		-	398		✓				
DIXI 26500 AR		-	398		✓				
DIXI 264X0		-	397						
DIADIX® WHEEL DRESSERS									
DIXI 1973		-	403						
DIXI 1978		-	404		✓	✓			

ON REQUEST



○ good ⊙ excellent

Cu alloy Silver Gold	Cu alloy difficult to machine	Al 4 - 8% Si	Al 8 - 13% Si	Graphite	Unsintered carbide Ceramics	Plastic	Carbon fibres	
⊙	⊙	⊙	○	○	○	⊙	○	
⊙	⊙	⊙	○	○	○	⊙	○	
⊙	⊙	⊙	○	○	○	⊙	○	



DIXI 72420 - 72420-SH

END MILLS, CENTRE CUTTING
AND THROUGH COOLANT

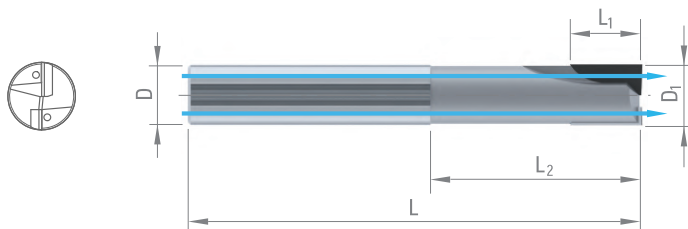
Z = 1-2



P. 406



$D_1 \geq \varnothing 6$



- Cu alloy
Silver
Gold
- Cu alloy
difficult
to machine
- Al
4-8%
Si
- Al
8-13%
Si
- Graphite
- Unsilited
carbide
Ceramics
- Plastic
- Carbon
fibres

D_{1h10}	L_1	L_2	D_{h5}	L	Z	PCD	CVD
1.00	2.0	-	6	42	1	979179	
1.50	3.0	-	6	42	1	977382	
2.00	3.0	6	6	42	1	66785	
2.00 >	3.0	20	6	75	1	970175	
3.00	4.0	6	6	42	1	67540	301958
3.00 >	4.0	6	6	42	2		305549
3.00 >	4.0	15	6	75	2	970176	
3.00 >	4.0	20	6	75	2	970177	
4.00	4.0	8	6	50	1	957593	
4.00 >	6.5	10	6	50	1	67541	
4.00 >	6.5	15	6	75	2	970178	301959
4.00 >	6.5	25	6	75	2	970179	
5.00	5.0	10	6	50	2	957595	
5.00 >	6.5	10	6	50	2	53153	
5.00 >	6.5	35	6	75	2	970166	
6.00	6.0	12	6	57	2	976391	301960
6.00 >	8.0	34	6	75	2	976392	301961
6.00 >	8.0	50	6	100	2	976393	
7.00	8.0	34	8	75	2	976394	
8.00	7.0	14	8	63	2	976395	301962
8.00 >	10.0	34	8	75	2	976396	301963
8.00 >	10.0	50	8	100	2	976397	
8.00 >	10.0	75	8	125	2	976398	
9.00	10.0	35	10	75	2	976399	
10.00	8.0	16	10	75	2	976410	
10.00 >	12.0	35	10	75	2	976411	301965
10.00 >	12.0	75	10	125	2	976412	
11.00	12.0	38	12	83	2	976413	
12.00	10.0	20	12	83	2	976414	
12.00 >	12.0	38	12	83	2	976415	301966
12.00 >	12.0	75	12	125	2	976416	
14.00	12.0	24	14	83	2	976417	338991
14.00 >	12.0	38	14	83	2	976418	
14.00 >	12.0	75	14	125	2	976419	
16.00	14.0	28	16	92	2	976420	338992
16.00 >	14.0	42	16	92	2	976421	
16.00 >	14.0	75	16	125	2	976422	
20.00	18.0	36	20	104	2	976423	
20.00 >	18.0	50	20	125	2	976424	

On request



DIXI 70520 - 70520-SH

END MILLS, CENTRE CUTTING
WITH CORNER RADIUS
AND THROUGH COOLANT

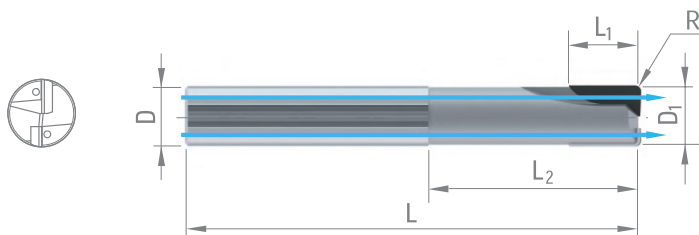
Z = 1-2



P. 406



$D_1 \geq \varnothing 6$



- Cu alloy
Silver
Gold
- Cu alloy
difficult
to machine
- Al
4-8%
Si
- Al
8-13%
Si
- Graphite
- Unsilited
carbide
Ceramics
- Plastic
- Carbon
fibres

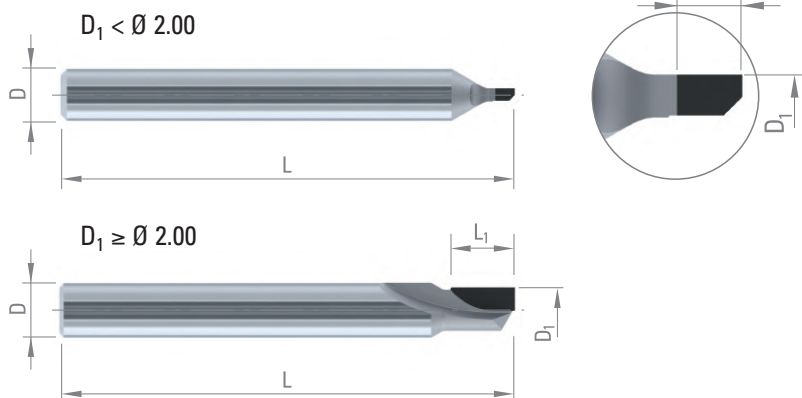
D_{1h10}	L_1	L_2	D_{h5}	L	R	Z	PCD	CVD
1.00	2.0	-	6	42	0.1	1	984384	
2.00	3.0	6	6	42	0.1	1	967923	
2.00 >	3.0	6	6	42	0.2	1	973528	
3.00	4.0	15	6	75	0.1	2	987438	338995
3.00 >	4.0	15	6	75	0.3	2	305810	
4.00	4.0	8	6	50	0.1	1	967925	
4.00 >	6.5	10	6	50	0.5	1	971465	
4.00 >	6.5	15	6	75	0.1	2	305811	
4.00 >	6.5	15	6	75	0.5	2	302378	
5.00	5.0	10	6	50	0.1	2	305812	
5.00 >	5.0	10	6	50	0.5	2	975839	
6.00	6.0	12	6	57	0.1	2	967926	338996
6.00 >	6.0	12	6	57	0.5	2	968992	
6.00 >	8.0	34	6	75	0.1	2	995208	
6.00 >	8.0	34	6	75	0.5	2	974475	
6.00 >	8.0	34	6	75	1.0	2	974476	
8.00	7.0	14	8	63	0.1	2	967927	339000
8.00 >	10.0	34	8	75	0.5	2	974477	
8.00 >	10.0	34	8	75	1.0	2	974478	
10.00	12.0	35	10	75	0.1	2	953153	339001
10.00 >	12.0	35	10	75	0.5	2	974479	
10.00 >	12.0	35	10	75	1.0	2	974480	
10.00 >	12.0	75	10	125	0.5	2	974482	
10.00 >	12.0	75	10	125	1.0	2	974481	
12.00	10.0	20	12	83	0.1	2	984083	339004
12.00 >	12.0	38	12	83	0.5	2	974483	
12.00 >	12.0	38	12	83	1.0	2	974484	
12.00 >	12.0	75	12	125	0.5	2	974485	
12.00 >	12.0	75	12	125	1.0	2	974486	
14.00	12.0	24	14	83	0.1	2	305814	
14.00 >	12.0	24	14	83	0.5	2	305816	339012
14.00 >	12.0	24	14	83	1.0	2	305817	
16.00	14.0	28	16	92	0.1	2	993052	
16.00 >	14.0	42	16	92	0.5	2	305818	339014
16.00 >	14.0	42	16	92	1.0	2	305139	
20.00	18.0	36	20	104	0.1	2	987718	
20.00 >	18.0	36	20	104	0.5	2	305819	
20.00 >	18.0	36	20	104	1.0	2	305820	



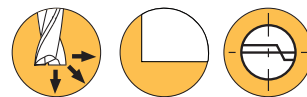
DIXI 70600 PCD

SLOT DRILLS, CENTRE CUTTING
FOR FINISHING OPERATION

Z = 1



P. 406



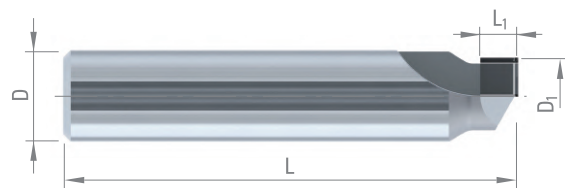
Cu alloy Silver Gold	Cu alloy difficult to machine	Al 4-8% Si	Al 8-13% Si	Graphite
Unstirred carbide Ceramics	Plastic	Carbon fibres		

D_{1h10}	L_1	L_2	D_{h5}	L	PCD
1.00	2.0	-	6	35	302387
2.00	3.0	6	6	35	302388
3.00	4.0	6	6	42	302389
4.00	6.5	10	6	42	302390
5.00	6.5	10	6	50	302391
6.00	8.0	15	6	50	302393
8.00	10.0	15	8	60	339191
10.00	12.0	20	10	60	339192

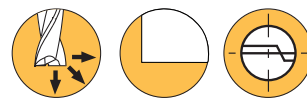
DIXI 70600 DIA

MONOCRISTALLINE DIAMOND
END MILLS, CENTRE CUTTING

Z = 1



P. 406



Cu alloy Silver Gold	Cu alloy difficult to machine	Al 4-8% Si	Alu 8-13% Si	Plastic
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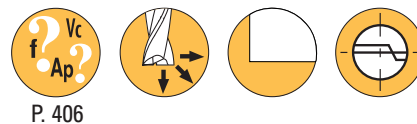
D_1	L_1	D_{h5}	L	DIA
3.00	2.5	6	30	302394
4.00	2.5	6	30	302395
5.00	2.5	6	30	302396
6.00	2.5	6	30	302397



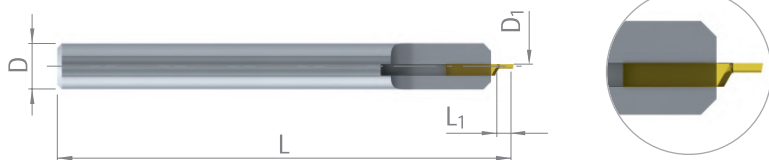
DIXI 72310 DIA

MONOCRISTALLINE DIAMOND
MICRO END MILLS

Z = 1



P. 406



- Cu alloy
Silver
Gold
- Cu alloy
difficult
to machine
- Al
4-8%
Si
- Alu
8-13%
Si
- Plastic

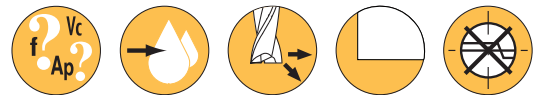
D ₁	L ₁	D _{h5}	L	DIA
0.40	0.8	3	30	953424
0.50	1.0	3	30	953425
0.60	1.2	3	30	953426
0.70	1.4	3	30	953427
0.80	1.6	3	30	953428
0.90	1.8	3	30	953429
1.00	2.5	3	30	953430
1.10	2.5	3	30	953431
1.20	2.5	3	30	953432
1.30	2.5	3	30	953433
1.40	2.5	3	30	953434
1.50	2.5	3	30	953435
1.60	2.5	3	30	953436
1.70	2.5	3	30	953437
1.80	2.5	3	30	953438
1.90	2.5	3	30	953439
2.00	2.5	6	30	953440



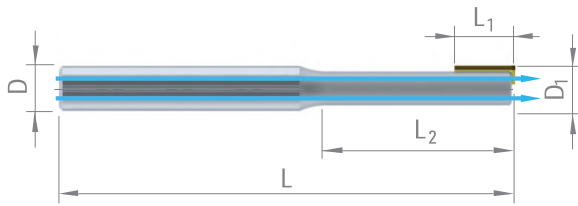
DIXI 72421-SH DIA

MONOCRISTALLINE DIAMOND
END MILLS

Z = 1



P. 406



D_1	L_2	D_{h5}	L_1	L	DIA Plastic	DIA
6.00	25	6	4	57	970120	341428
			6	57	970122	341429
			8	57	974360	341430
8.00	25	8	4	63	970126	341432
			6	63	970128	341434
			8	63	970129	341435
10.00	25	10	4	75	974317	341436
			6	75	974318	341437
			8	75	974319	341438
12.00	25	12	4	83	974321	341439
			6	83	974322	341440
			8	83	974323	341441

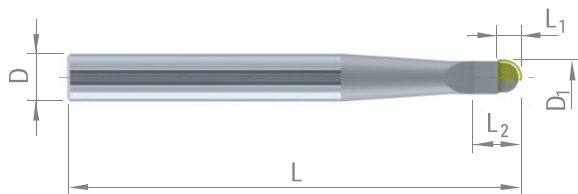
DIXI 70320 DIA

MONOCRISTALLINE DIAMOND
BALL-NOSE END MILLS

Z = 1



P. 406



D_1	L_1	L_2	D_{h5}	L	DIA
2.00	2.0	4	6	57	341443
3.00	2.5	6	6	75	341445
4.00	3.0	8	6	75	341447
6.00	4.0	12	8	75	341449
8.00	5.0	16	10	75	341450
10.00	6.0	20	12	75	341451



DIXI 70320-SH PCD

BALL-NOSE END MILLS
WITH THROUGH COOLANT

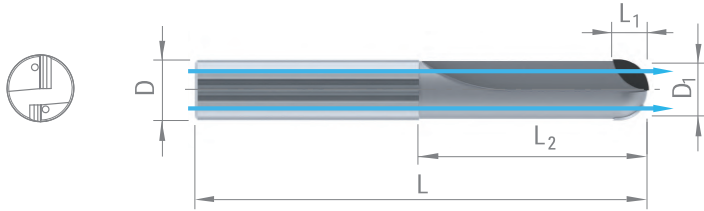
Z = 1-2



P. 406



> Ø 6



- Cu alloy
Silver
Gold
- Cu alloy
difficult
to machine
- Al
4-8%
Si
- Alu
8-13%
Si
- Graphite
- Unsilited
carbide
Ceramics
- Plastic
- Carbon
fibres

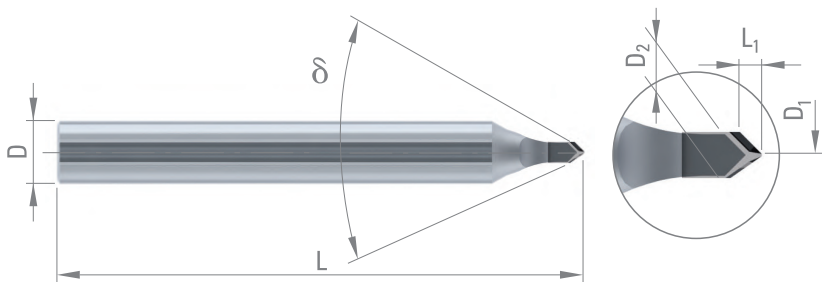
$D_{1\ h10}$	L_1	D	L_2	L	Z	PCD
2.00	2.0	6	6.0	42	1	953442
			25.0	75	1	970874
3.00	2.5	6	6.0	42	1	953443
			25.0	75	1	970875
			25.0	75	2	970876
			8.0	50	1	959468
4.00	3.0	6	10.0	50	1	953444
			10.0	50	2	970877
			25.0	75	2	970878
			35.0	75	2	981585
5.00	4.0	6	10.0	50	2	953445
			25.0	75	2	970883
6.00	4.0	6	12.0	57	2	976433
			34.0	75	2	976434
			50.0	100	2	976435
8.00	5.0	8	14.0	63	2	976436
			34.0	75	2	976437
			75.0	125	2	976438
10.00	6.0	10	16.0	72	2	976439
			35.0	75	2	976440
			75.0	125	2	976441
12.00	7.0	12	20.0	83	2	976442
			38.0	83	2	976443
12.00	7.0	12	75.0	125	2	976444
14.00	8.0	14	24.0	83	2	305821
16.00	9.0	16	28.0	92	2	300800
20.00	11.0	20	36.0	104	2	305822



DIXI 76230 DIA

MONOCRISTALLINE DIAMOND
CHAMFERING TOOLS

Z = 1



Cu alloy Silver Gold	Cu alloy difficult to machine	Al 4-8% Si	Al 8-13% Si	Plastic
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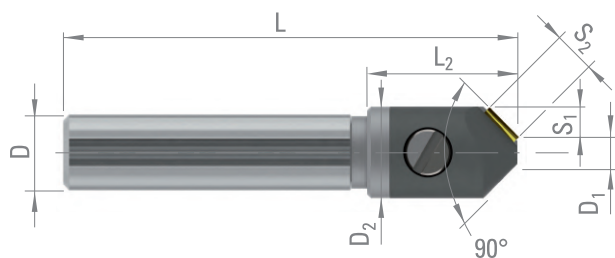
δ	L_1	D_2	D_1	D_{h5}	L	DIA
30°	2.80	2	* 0.30	6	50	978382
60°	1.40	3	* 0.10	6	50	302596
	1.30	3	* 0.30	6	50	978381
90°	0.80	3	* 0.10	6	50	302595
	0.70	3	* 0.30	6	50	977871

* not cutting

DIXI 76231 DIA

MONOCRISTALLINE DIAMOND
CHAMFERING TOOLS

Z = 1



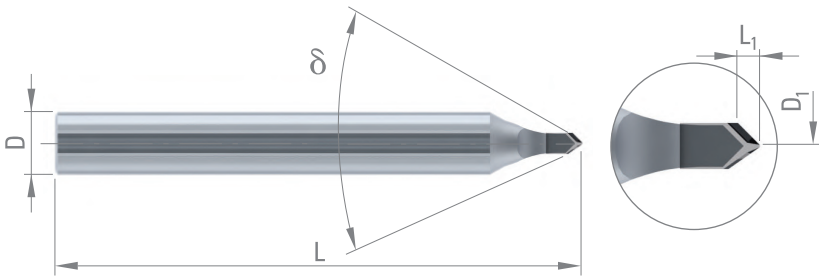
Cu alloy Silver Gold	Cu alloy difficult to machine	Al 4-8% Si	Al 8-13% Si	Plastic
----------------------------	-------------------------------------	------------------	-------------------	---------

D_1	D_2	L_2	S_1	S_2	D_{h5}	L	DIA
4	10	-	3	4.10	10	60	974354
4	12	20	4	5.50	10	60	974355
4	14	20	5	7.00	10	60	974356
4	16	20	6	8.50	10	60	974357



DIXI 70170 DIA

MONOCRISTALLINE DIAMOND ENGRAVING TOOLS



δ	L_1	D_{h5}	L	D_1	DIA
60°	1.40	6	50	0.05	302597
				0.10	302598
90°	0.80	6	50	0.05	302599
				0.10	302600



P. 408



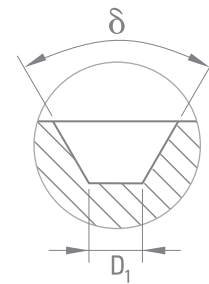
Cu alloy
Silver
Gold

Cu alloy
difficult
to machine

Al
4-8%
Si

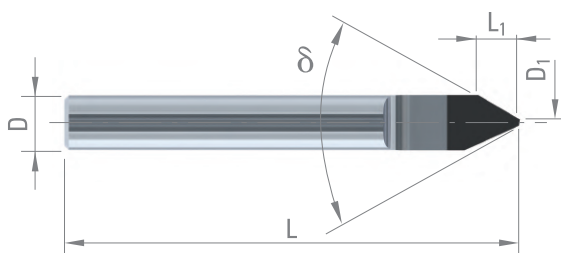
Alu
8-13%
Si

Plastic



DIXI 70170 PCD

PCD ENGRAVING TOOLS



δ	L_1	D_{h5}	L	D_1	PCD
60°	5	6	50	0.10	303081
				0.20	303082
90°	3	6	50	0.10	303083
				0.20	303084



P. 408



Cu alloy
Silver
Gold

Cu alloy
difficult
to machine

Al
4-8%
Si

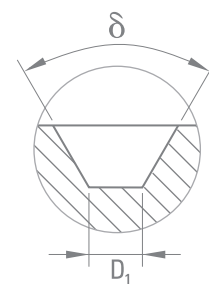
Al
8-13%
Si

Graphite

Unstirred
carbide
Ceramics

Plastic

Carbon
fibres



TOOLS ON REQUEST

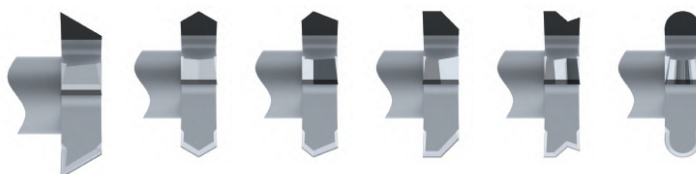
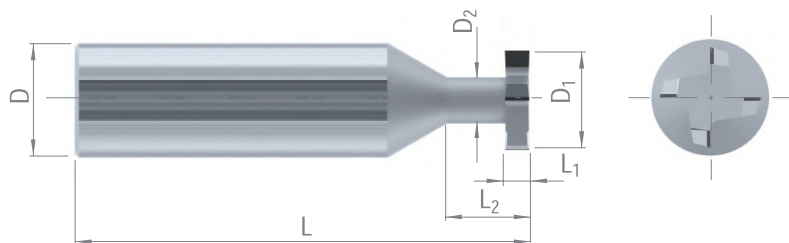
Cutting material PCD CVD DIA

Material to be machined:

DIXI 15150 TOOLS ON REQUEST

T-SLOT CUTTERS

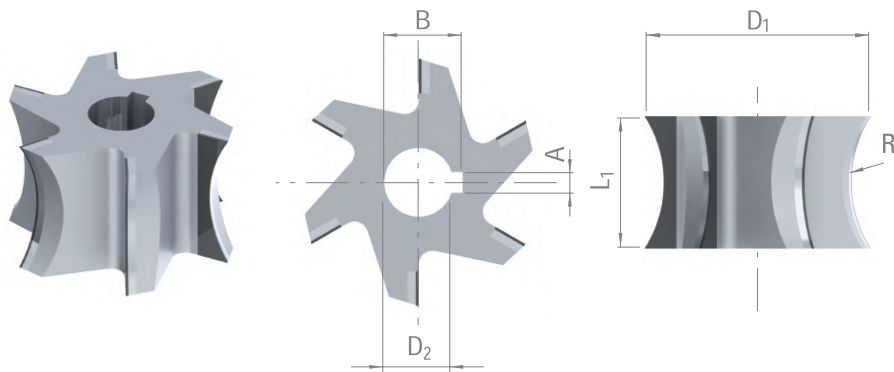
Z = _____
 D = _____
 D₁ = _____
 D₂ = _____
 L = _____
 L₁ = _____
 L₂ = _____
 R = _____



DIXI 16560 TOOLS ON REQUEST

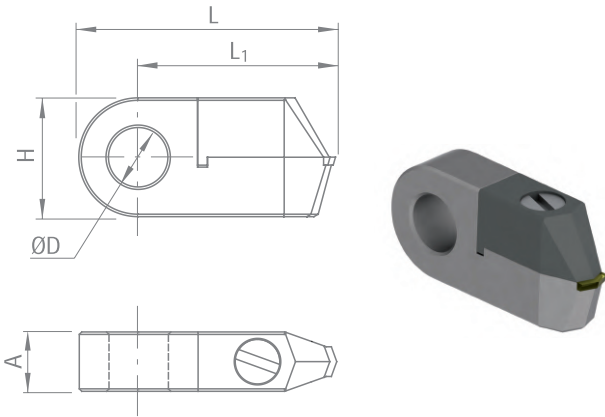
CONCAVE SLITTING SAWS

D₁ = _____
 D₂ = _____
 L₁ = _____
 R = _____
 A = _____
 B = _____

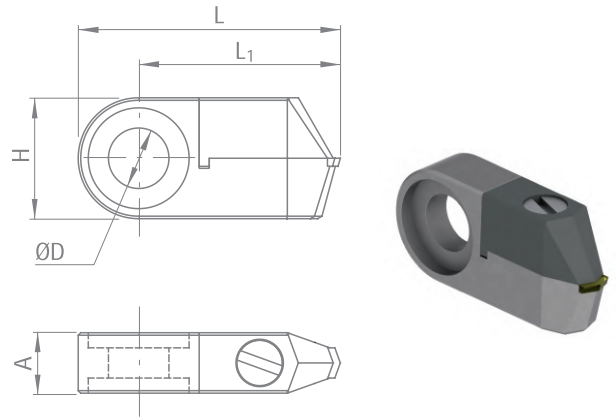


TURNING AND MILLING DIAMOND TOOLS

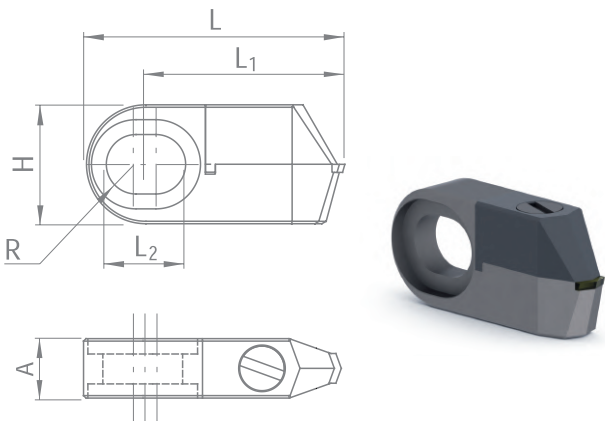
Ref. A



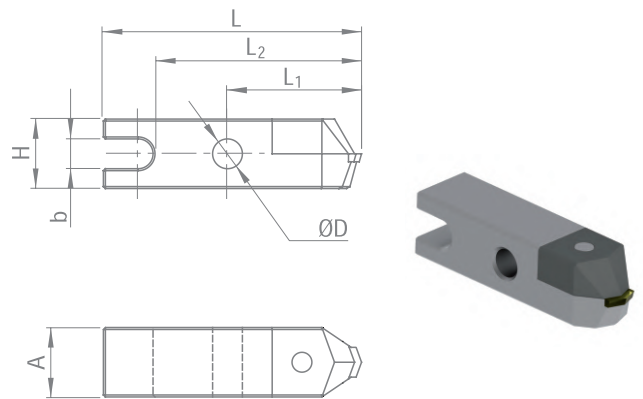
Ref. B



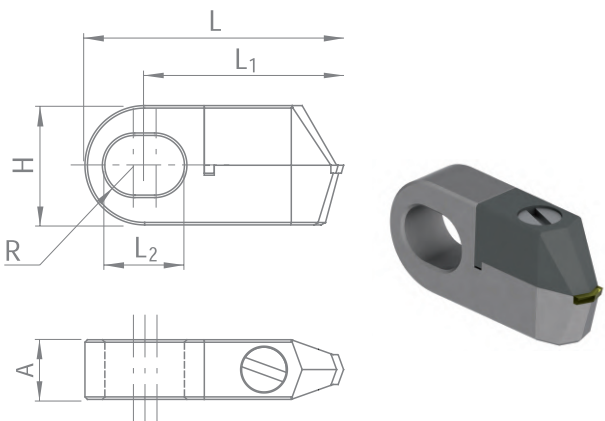
Ref. C



Ref. D



Ref. E



A large variety of diamond tools for turning and milling on request.

When ordering, please specify the cutting material (PCD - DIA - CVD)

and the material to be machined.

For a range of special shapes, see pages 401-402.

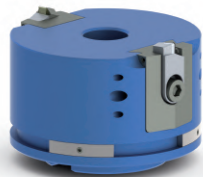


DIXI 81000

FACE MILLING HEAD FOR MIRROR FINISH

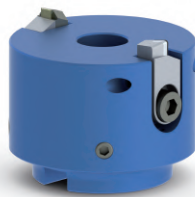


P. 409



Face milling head with inclination setting

D ₁	D	L	Art.
60	22	50	996583
85	27	55	962824
100	27	55	964272
125	40	58	994652



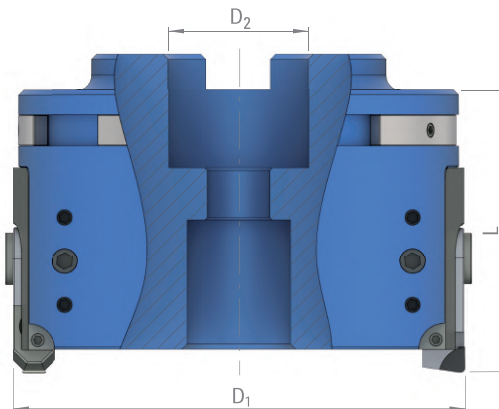
Face milling head

D ₁	D	L	Art.
40	16	55	970446
50	16	45	971872
60	22	40	962823



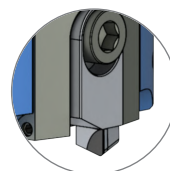
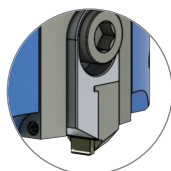
Face milling head with shank

D ₁	D	L	Art.
40	12	55	964273



Finishing insert (monocrystalline diamond)

Material to be machined	DIA
Plastic	968111
Aluminium / Copper	969556
Titanium	968526
Brass	969557



Roughing insert (PCD)

Material to be machined	PCD
Non ferrous materials	968117

DIXI 20370

CUTTING PINS Ø 8 x 31 FOR BERMAQ MACHINES

Ref. 1



Ref. 2



Ref. 3



Ref. 4



Description	Material	Color	Art.
Ref. 1 Pin for roughing	PCD	black	968179
Ref. 2 Pin for finishing	PCD	red	968181
Ref. 3 Pin for satined surface	PCD	green	974193
Ref. 4 Pin for transparent surface finish	DIA	blue	968178



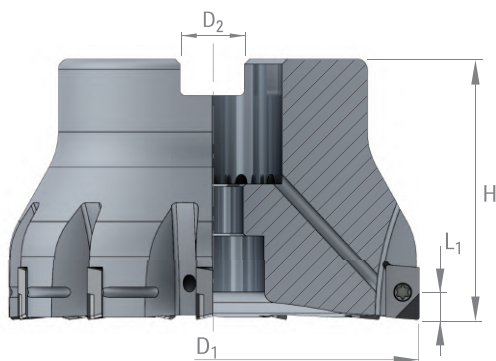
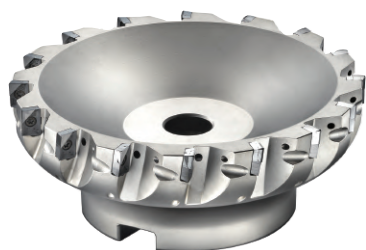
DIXI 80000

ADJUSTABLE HOLDER FOR ISO INSERTS
FOR FACE MILLING APPLICATION

Z = 6-16



P. 409



D ₁	L ₁	H	D ₂	Z	Weight [kg]	Art.
40.00	3.0	40	16	6	0.20	955446
50.00	3.0	40	22	7	0.35	955447
63.00	3.0	40	22	8	0.60	955448
80.00	3.0	50	27	11	1.20	955449
100.00	3.0	50	32	13	2.00	955451
125.00	3.0	50	32	16	2.20	955452

DIXI 2642 - 26420

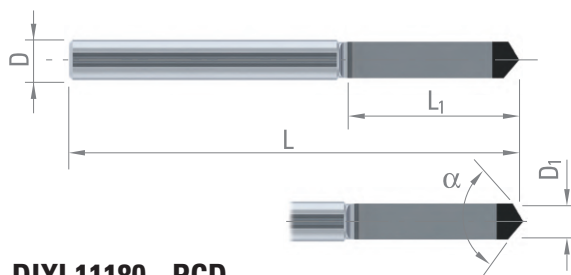
ISO INSERTS FOR DIXI 80000

Description	Art.
APKT 100305 PDER AK 10F poly	996517
APKT 100305 PDER-S AM5040 TiAlN coated	996516
APKT 100305 PDER-S AP20F TiAlN coated	996518
APKT 100305 PDER-U AP5020F TiAlN coated	996519
APKT100305 PCD	955606

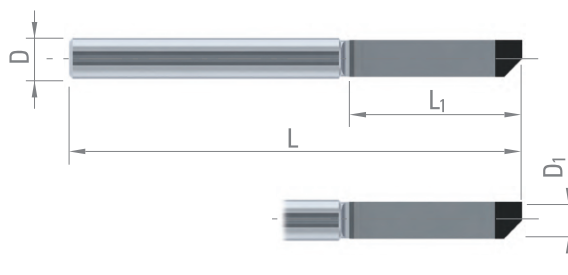
DIXI 11140 - 11180 TOOLS ON REQUEST

STRAIGHT FLUTE DRILLS

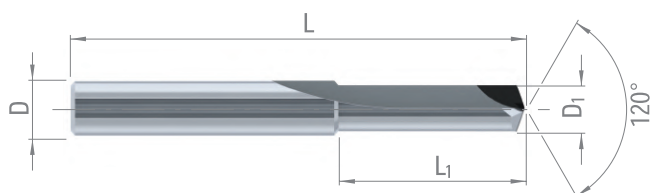
DIXI 11140 A - PCD



DIXI 11140 B - PCD



DIXI 11180 - PCD



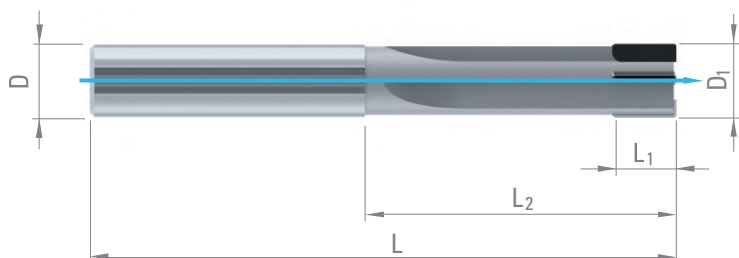
POLY 40010 TOOLS ON REQUEST



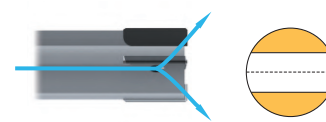
REAMERS



POLY 40010-TC



POLY 40010-FC



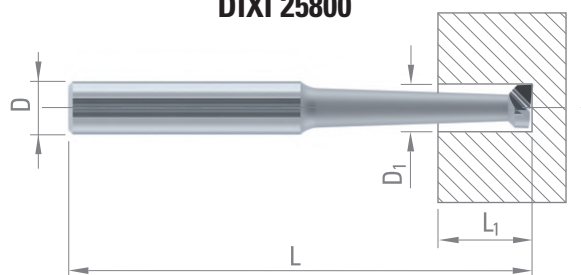
D_1	L_1	L_2	D_{h5}	L	Z	PCD
8.000 - 9.100	7	34	8	64	4	●
9.102 - 10.100	7	44	10	80	4	●
10.101 - 11.100	7	44	10	80	4	●
11.101 - 12.300	7	63	12	108	4	●
12.300 - 13.100	7	63	12	108	4	●
13.101 - 14.500	7	58	16	108	4	●
14.501 - 16.100	7	58	16	108	4	●
16.101 - 18.100	7	58	16	108	4	●
18.101 - 20.500	7	58	20	108	4	●
20.501 - 22.100	7	58	20	108	4	●

DIXI 25800 - 25810 TOOLS ON REQUEST



BORING TOOLS

DIXI 25800



DIXI 25810



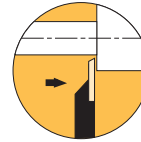


TURNING TOOLS

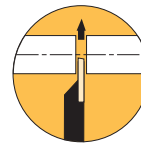


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DIXI 20610



DIXI 20770



Available with cylindrical shank under references **DIXI 20611 / 20771**

DIXI 264X0 TOOLS ON REQUEST

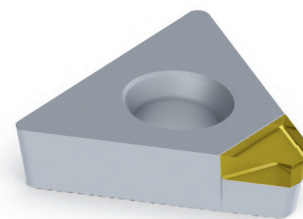


INSERTS AS PER DIN 4987/ISO 1832

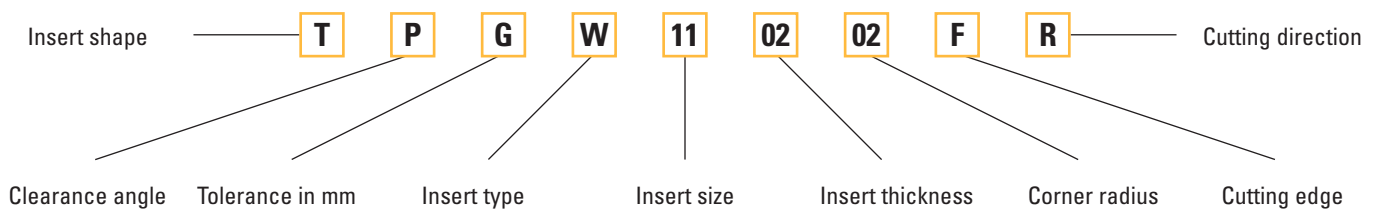
When ordering, please attach a sketch of the insert showing the diamond part. Please specify the ISO designation, the cutting material (PCD - DIA - CVD), the material to be machined.

Special ISO inserts available on request.

For a range of special shapes, see pages **401-402**.



Designation example (according to DIN 4987 / ISO 1832) DIXI 26400 TPGW 110202 FR



DIXI 26500 R

TURNING INSERTS
RIGHT-HAND CUTTING

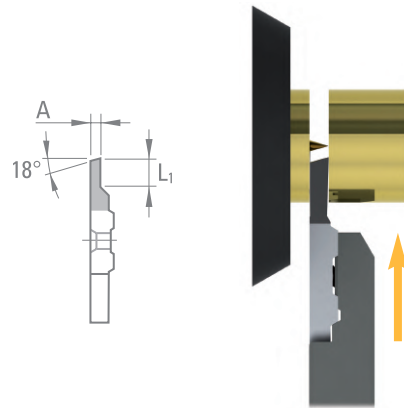


P. 410

PARTING OFF

DIXI 26500 TR

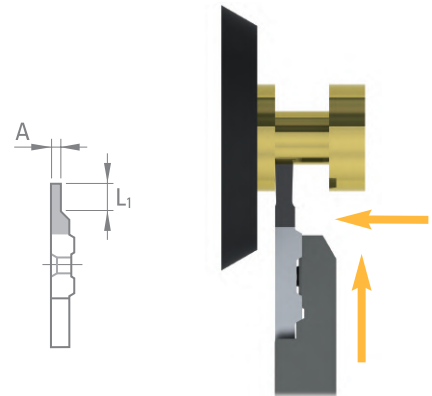
R	A	L ₁	PCD	PCD finishing
TR06R-0.8	0.8	3.0	976284	303109
TR06R-1.0	1.0	4.0	976286	303111
TR06R-1.2	1.2	5.0	976288	303113
TR06R-1.5	1.5	5.0	976290	303115
TR06R-1.8	1.8	6.0	976292	303117
TR06R-2.0	2.0	6.0	976294	303119



PLUNGING / TURNING

DIXI 26500 FT

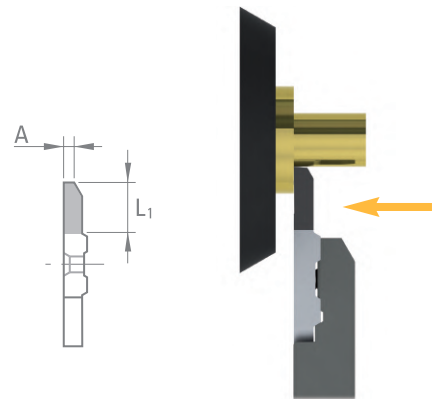
R	A	L ₁	PCD	PCD finishing
FT06R-2.0	2.0	4.0	976278	303103



FRONT TURNING

DIXI 26500 AV

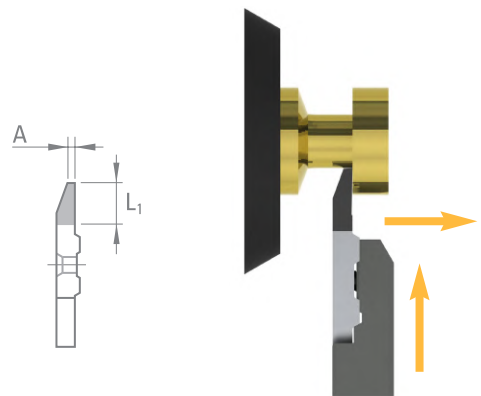
R	A	L ₁	PCD	PCD finishing
AV06R-1.5	1.5	5.0	976280	303105



BACK TURNING

DIXI 26500 AR

R	A	L ₁	PCD	PCD finishing
AR06R-1.0	1.0	5.0	976282	303107



**TURNING INSERTS
LEFT-HAND CUTTING**

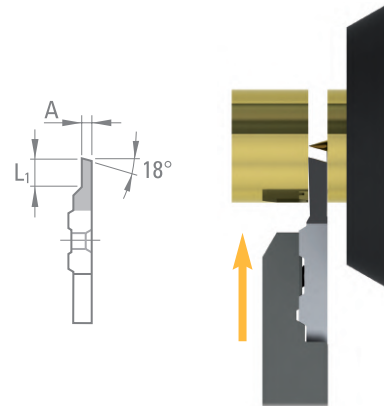


P. 410

PARTING OFF

DIXI 26500 TR

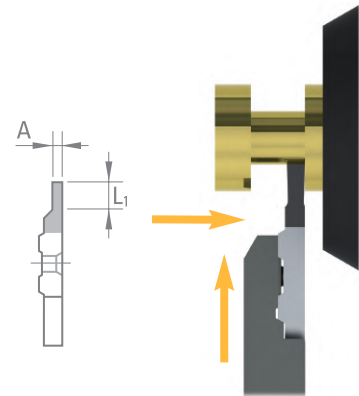
L	A	L ₁	PCD	PCD finishing
TR06L-0.8	0.8	3.0	976285	303110
TR06L-1.0	1.0	4.0	976287	303112
TR06L-1.2	1.2	5.0	976289	303114
TR06L-1.5	1.5	5.0	976291	303116
TR06L-1.8	1.8	6.0	976293	303118
TR06L-2.0	2.0	6.0	976295	303120



PLUNGING / TURNING

DIXI 26500 FT

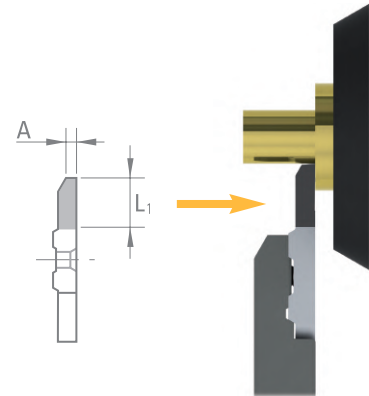
L	A	L ₁	PCD	PCD finishing
FT06L-2.0	2.0	4.0	976279	303104



FRONT TURNING

DIXI 26500 AV

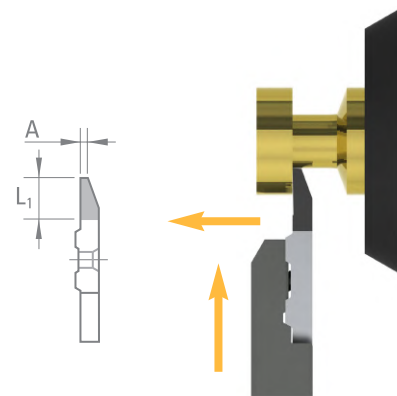
L	A	L ₁	PCD	PCD finishing
AV06L-1.5	1.5	5.0	976281	303106



BACK TURNING

DIXI 26500 AR

L	A	L ₁	PCD	PCD finishing
AR06L-1.0	1.0	5.0	976283	303108



TOOL HOLDERS



R	S	Insert size	Art.
0606R-130	6	06	64940
0706R-130	7	06	64942
0806R-130	8	06	64944
1006R-130	10	06	64946
1206R-130	12	06	64948
1606R-130	16	06	64950



L	S	Insert size	Art.
0606L-130	6	06	64941
0706L-130	7	06	64943
0806L-130	8	06	64945
1006L-130	10	06	64947
1206L-130	12	06	64949
1606L-130	16	06	64959



Screw M2.50x6 Art. 66586



Torx 8 Art. 65785

RANGE OF SPECIAL SHAPES



RANGE OF SPECIAL SHAPES



DIXI 1973

DIADIX® HOLDERS, DRESSING

DIXI 1973.0823	8	19459
DIXI 1973.1023	10	18512
DIXI 1973.1223	12	19979

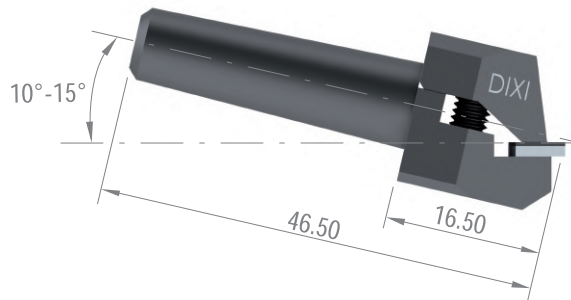
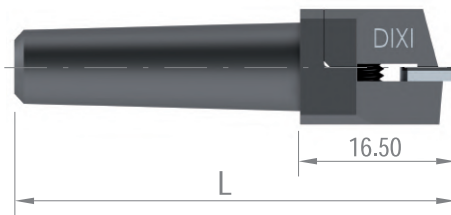
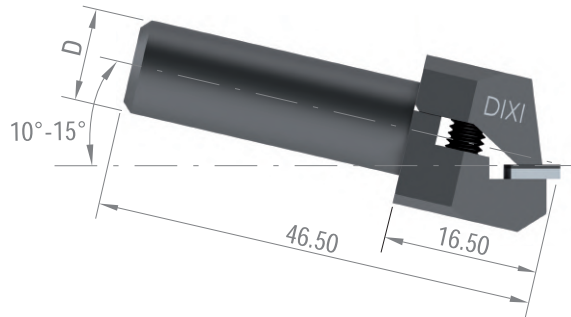
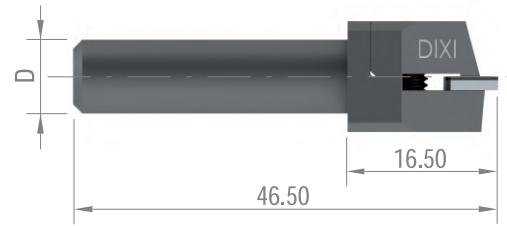
DIXI 1973.1013	10	23707
----------------	----	-------

This wheel-dresser compensates the 10° - 15° negative angle of the diamond-holder on certain machines, which enables the desired 0° dressing angle to be maintained.

Ref.	Morse taper	L	Art.
DIXI 1973.0023	CM0	46.5	18737
DIXI 1973.0123	CM1	59.5	18514

Ref.	Morse taper	Art.
DIXI 1973.0013	CM0	23850
DIXI 1973.0113	CM1	23727

This wheel-dresser compensates the 10° - 15° negative angle of the diamond-holder on certain machines, which enables the desired 0° dressing angle to be maintained.

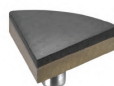


DIXI 1978

INSERTS FOR ROUGH WHEEL DRESSING



Ref.	PCD
DIXI 1978.360°	23829



Ref.	PCD
DIXI 1978.23	18814

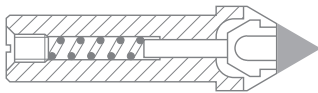
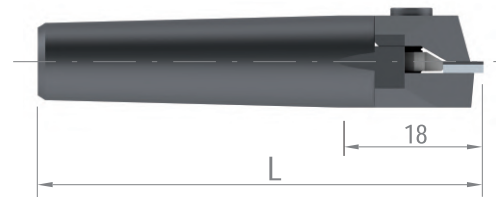
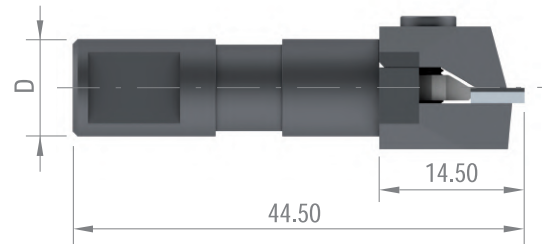
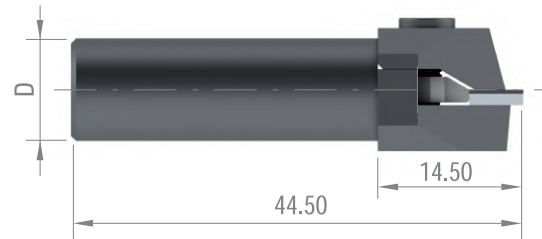
DIXI 1973

DIADIX® HOLDERS, PROFILING

DIXI 1973.1025	10	24550
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DIXI 1973.0925-1	9.525 (3/8")	24549
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Ref.	Morse taper	L	Art.
DIXI 1973.0125	CM1	36.5	26549
DIXI 1973.0125	CM1	58.5	24551

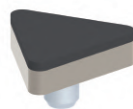


Tool holder for profile dressing
with automatic centering of the insert.

On request, DIXI can develop special holders
for various machines such as: Agathon,
Kellenberger, Studer, Tripet, Tschudin (HTT),
Voumard, etc...

DIXI 1978

INSERTS FOR PROFILING DEVICES



Ref.	PCD	CVD
DIXI 1978.2500	24623	973739

Ref.	R	PCD	CVD
DIXI 1978.2512	0.125	24624	973736
DIXI 1978.2520	0.200	24625	973732
DIXI 1978.2525	0.250	24626	973737
DIXI 1978.2550	0.500	24627	973738





DIADIX® WHEEL-DRESSERS

CHARACTERISTICS

Bonded to a tungsten carbide pin, the diamond layer enables a significant cost saving through the combination of the three cutting points and circular segment. The polycrystalline diamond retains its sharpness and efficiency until it has been completely used. The DIADIX® wheel-dresser breaks the crystals of the grinding wheel instead of planishing them, thereby revealing a greater number of cutting points on the grinding wheel.

ADVANTAGES

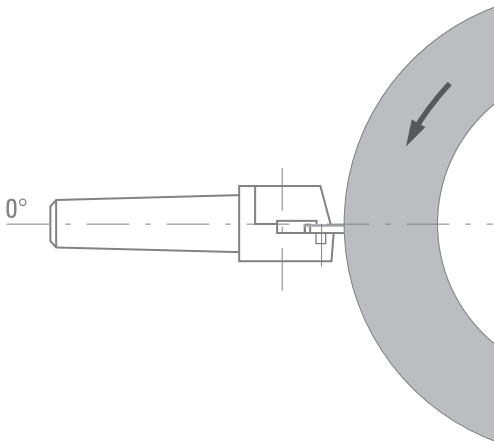
The grinding wheels redressed with a DIADIX® tool produce more work-pieces with a better finish and greater accuracy. The redressing intervals are longer, thus reducing down time. These advantages mean a significant improvement of productivity.

CONDITIONS OF USE

- Wheels: Aluminium oxide (Al₂O₃) and in certain cases silicon carbide (SiC)
- Hardness: up to L, eventually M (see table)
- Structure: from 3 to 20, depending on the cases (see table)
- Grit size: 46 - 220
- Grinding machines: planer type, internal and external cylindrical type, from any manufacturer

I 1	J 1	K 1	L 1	M 1
I 2	J 2	K 2	L 2	M 2
I 3	J 3	K 3	L 3	M 3
I 4	J 4	K 4	L 4	M 4
I 5	J 5	K 5	L 5	M 5
I 6	J 6	K 6	L 6	M 6
I 7	J 7	K 7	L 7	M 7
I 8	J 8	K 8	L 8	M 8
I 9	J 9	K 9	L 9	M 9
I 10	J 10	K 10	L 10	M 10
●	●	●	●	●
●	●	●	●	●
●	●	●	●	●

Light letters = Uncertain area
Heavy letters = Certain area



DIADIX® WHEEL-DRESSERS

WORKING CONDITIONS

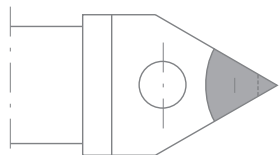
The wheel-dresser must be leveled with the wheel axis.

Dressing angle: 0°

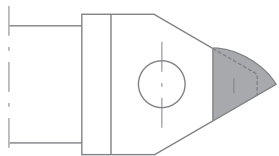
Feed rate: faster than with a single crystal natural diamond

Cutting depth: possible up to 0.50 mm

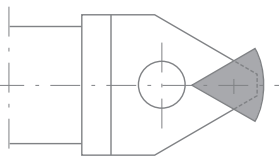
Coolant: necessary



← Examples of insert positioning



← For **roughing** operations.
 The wheel becomes more efficient when using the appropriate feed.



← For **finishing** operations.
 In employing the whole or part of the insert's radius, the grinding wheel gives an impeccable finish.



CUTTING CONDITIONS

Material to be machined		DIA	
		Vc [m/min]	
N	Copper alloys - easy to machine (brass - bronze)	400	800
N	Copper alloys - difficult to machine / Aluminium bronze (CuAlFe) (Ampco)	300	700
N	Aluminium alloys / Magnesium alloy	500	2000
N	Aluminium alloys Si < 3 - 8%	400	1800
N	Cast aluminium Si > 8 - 13%	400	1500
N	Plastic	500	1500
N	Gold, silver	200	750

DIXI 70600 - 70320 - 70520 - 72420 - 72421

CUTTING CONDITIONS

Material to be machined		PCD		CVD		DIA	
		Vc [m/min]		Vc [m/min]		Vc [m/min]	
N	Copper alloys - easy to machine (brass - bronze)	200	1000	400	1200	400	800
N	Copper alloys - difficult to machine / Aluminium bronze (CuAlFe) (Ampco)	100	1500	200	1700	300	700
N	Aluminium alloys / Magnesium alloy	700	3000	400	1200	500	2000
N	Aluminium alloys Si < 3 - 8%	300	3500	400	1200	400	1800
N	Cast aluminium Si > 8 - 13%	100	3000	200	900	400	1200
N	Graphite	200	1000	400	1200		
N	Unsintered carbide and ceramics	200	1000	400	1200		
N	Plastic	500	2000	400	1200	500	1500
N	Carbon fibres	1000	3000	400	1200		
N	Gold, silver	300	1000	400	1200	200	750



$$n \text{ [tr/min]} = \frac{Vc \text{ [m/min]} \times 1000}{\pi \times D_1 \text{ [mm]}}$$

$$Vf \text{ [mm/min]} = n \text{ [tr/min]} \times fz \text{ [mm]} \times z$$

Feed per revolution **fz [mm]**

$\varnothing D_1$ 0.30 - 1.00	$\varnothing D_1$ 1.00 - 2.00
0.0005 - 0.005	0.005 - 0.03
0.0005 - 0.005	0.005 - 0.03
0.0005 - 0.005	0.005 - 0.03
0.0005 - 0.005	0.005 - 0.03
0.0005 - 0.005	0.005 - 0.03
0.0005 - 0.005	0.005 - 0.03
0.0005 - 0.005	0.005 - 0.03

fz [mm]	Roughing		Finishing		Finishing
	PCD -CVD		PCD -CVD		DIA
	ap [mm]	ae [mm]	ap [mm]	ae [mm]	ap + ae [mm]
0.05 - 0.25	≤ 1 x D	≤ 1 x D	0.10 - 0.30	0.10 - 0.30	max. = 0.05
0.05 - 0.20	≤ 0.6 x D	≤ 0.6 x D	0.10 - 0.30	0.10 - 0.30	
0.05 - 0.25	≤ 1 x D	≤ 1 x D	0.10 - 0.30	0.10 - 0.30	
0.05 - 0.20	≤ 1 x D	≤ 1 x D	0.10 - 0.30	0.10 - 0.40	
0.05 - 0.20	≤ 1 x D	≤ 1 x D	0.10 - 0.30	0.10 - 0.30	
0.05 - 0.20	≤ 1 x D	≤ 1 x D	0.10 - 0.30	0.10 - 0.30	
0.025 - 0.125	≤ 1 x D	≤ 1 x D	0.10 - 0.30	0.10 - 0.30	
0.05 - 0.30	≤ 1 x D	≤ 1 x D	0.10 - 0.30	0.10 - 0.30	
0.05 - 0.30	≤ 1 x D	≤ 1 x D	0.10 - 0.30	0.10 - 0.30	
0.05 - 0.25	≤ 0.6 x D	≤ 0.6 x D	0.10 - 0.30	0.10 - 0.30	



CUTTING CONDITIONS

Material to be machined

	DIA n [rev/min]	Ø D ₁ 0.05 - 0.10		Ø D ₁ 0.15 - 0.40	
		Vf [mm/min]	ap [mm]	Vf [mm/min]	ap [mm]
N Copper alloys - easy to machine (brass - bronze)	15'000 - 30'000	50 - 125	0.05 - 0.10	75 - 200	0.05 - 0.10
N Copper alloys - difficult to machine / Aluminium bronze (CuAlFe) (Ampco)	15'000 - 30'000	50 - 115	0.05 - 0.10	75 - 150	0.05 - 0.10
N Aluminium alloys Si < 8%	15'000 - 30'000	50 - 125	0.05 - 0.10	75 - 200	0.05 - 0.10
N Plastic	15'000 - 30'000	50 - 125	0.05 - 0.10	75 - 200	0.05 - 0.10
N Gold, silver	15'000 - 30'000	50 - 125	0.05 - 0.10	75 - 200	0.05 - 0.10

Material to be machined

	PCD n [rev/min]	Ø D ₁ 0.05 - 0.10		Ø D ₁ 0.15 - 0.40	
		Vf [mm/min]	ap [mm]	Vf [mm/min]	ap [mm]
N Copper alloys - easy to machine (brass - bronze)	12'500 - 17'500	75 - 250	0.05 - 0.20	150 - 400	0.10 - 0.40
N Copper alloys - difficult to machine / Aluminium bronze (CuAlFe) (Ampco)	12'500 - 17'500	75 - 250	0.05 - 0.20	150 - 350	0.10 - 0.40
N Aluminium alloys Si < 8%	12'500 - 17'500	75 - 250	0.05 - 0.20	150 - 400	0.10 - 0.40
N Plastic	12'500 - 17'500	75 - 250	0.05 - 0.20	150 - 400	0.10 - 0.40
N Gold, silver	12'500 - 17'500	75 - 250	0.05 - 0.20	150 - 400	0.10 - 0.40



CUTTING CONDITIONS

Material to be machined		PCD	CVD	ap [mm]	fz [mm]
		Vc [m/min]	Vc [m/min]		
N	Copper alloys - easy to machine (brass - bronze)	< 3000	< 3000	0.10 - 3.50	0.05 - 0.25
N	Copper alloys - difficult to machine / Aluminium bronze (CuAlFe) (Ampco)	< 3000	< 3000	0.10 - 3.50	0.05 - 0.25
N	Aluminium alloys / Magnesium alloy	< 7000	< 7000	0.10 - 3.50	0.05 - 0.25
N	Aluminium alloys Si < 3 - 8%	< 6000	< 6000	0.10 - 3.50	0.05 - 0.25
N	Cast aluminium Si > 8 - 13%	< 5000	< 5000	0.10 - 3.50	0.05 - 0.25

CUTTING CONDITIONS

Material to be machined		PCD + DIA		ap [mm]	fz [mm]
		Vc [m/min]			
N	Copper alloys - easy to machine (brass - bronze)	400	800	< 2	0.02 - 0.2
N	Copper alloys - difficult to machine / Aluminium bronze (CuAlFe) (Ampco)	300	700	< 2	0.02 - 0.2
N	Aluminium alloys / Magnesium alloy	500	2000	< 2	0.02 - 0.2
N	Aluminium alloys Si < 3 - 8%	400	1800	< 2	0.02 - 0.2
N	Cast aluminium Si > 8 - 13%	400	1200	< 2	0.02 - 0.2
N	Plastic	500	1500	< 2	0.02 - 0.2
N	Gold, silver	200	750	< 2	0.02 - 0.2



CUTTING CONDITIONS

Material to be machined		PCD		CVD		DIA	
		Vc [m/min]		Vc [m/min]		Vc [m/min]	
N	Copper alloys - easy to machine (brass - bronze)	300	1000	300	1000	300	1000
N	Copper alloys - difficult to machine / Aluminium bronze (CuAlFe) (Ampco)	250	800	250	800	250	800
N	Aluminium alloys / Magnesium alloy	300	1000	300	1000	300	1000
N	Aluminium alloys Si < 3 - 8%	300	1000	300	1000	300	1000
N	Cast aluminium Si > 8 - 13%	250	800	250	800	250	800
N	Graphite	80	1500	80	1500		
N	Unsintered carbide and ceramics	100	800	100	800		
N	Plastic	100	600	100	600	100	600
N	Carbon fibres	100	600	100	600		
N	Gold, silver	300	1000	300	1000	300	1000

$$n \text{ [tr/min]} = \frac{Vc \text{ [m/min]} \times 1000}{\pi \times D_1 \text{ [mm]}}$$

$$Vf \text{ [mm/min]} = n \text{ [tr/min]} \times fz \text{ [mm]} \times z$$

PCD -CVD		DIA	
Depth of cut (mm)	Feed (mm/rev)	Depth of cut (mm)	Feed (mm/rev)
< 10	0.05 - 0.50	< 0.05	0.05 - 0.50
< 6	0.05 - 0.50	< 0.05	0.05 - 0.50
< 10	0.05 - 0.50	< 0.05	0.05 - 0.50
< 10	0.05 - 0.50	< 0.05	0.05 - 0.50
< 6	0.05 - 0.50	< 0.05	0.05 - 0.50
< 10	0.05 - 0.50		
< 5	0.05 - 0.20		
< 10	0.10 - 0.60	< 0.05	0.10 - 0.60
< 3	0.05 - 0.60		
< 6	0.05 - 0.50	< 0.05	0.05 - 0.50

