



## F1-AF

Brusne plošče za čiščenje utorov / Grinding wheels for cleaning grooves



| Oblika Form | Dimenzije D x T x H Dimensions D x T x H   | Obodna hitrost Peripheral speed |
|-------------|--|---------------------------------|
|             | D = 300 - 600 mm<br>x<br>T = 6, 8, 10, 12, 16, 20 mm<br>x<br>H = 20, 22, 25.4, 30, 32, 127, 150 mm | 63 m/s<br>80 m/s                |

| Kvaliteta Quality | Jeklo Steel | Nerjaveče jeklo Stainless steel | Siva litina Cast iron | Nodularna litina Nodular alloys | Alu. litina Alu. cast | Livarski pesek Casting sand |
|-------------------|-------------|---------------------------------|-----------------------|---------------------------------|-----------------------|-----------------------------|
| A30-20P-S4BF      | ●           |                                 |                       | ○                               |                       |                             |
| 12A30-20R5BF      | ●           | ●                               |                       |                                 |                       |                             |
| 19A24S4BF         |             |                                 | ●                     |                                 | ○                     | ○                           |
| 52C24R5BF         |             |                                 | ●                     |                                 | ○                     | ○                           |
| 128A24-16R5B      |             |                                 | ●                     | ○                               |                       |                             |
| 417A24-16R5BF     |             |                                 | ●                     | ●                               |                       |                             |
| 47A24R5BF         |             |                                 | ●                     | ○                               | ○                     |                             |
| ZA24-16S4BF       |             |                                 | ●                     | ●                               |                       |                             |
| 54A24R5BF         |             |                                 | ○                     |                                 | ●                     |                             |
| C24S4BF           |             |                                 |                       |                                 |                       | ●                           |

● Primerna kvaliteta / Main application ○ Pogojno uporabna kvaliteta / Possible application

### NAMEN UPORABE / APPLICATIONS

- Ročno čiščenje utorov različnih kvalitete
- Uporablja se na stabilnih strojih
- Manual cleaning of grooves of various qualities
- For use on stationary grinding machines.

### PREDNOSTI / ADVANTAGES

- Visok učinek brušenja na časovno enoto in visoka vzdržnost brusnih plošč
- Specialne kvalitete 47A, ZA20 in 417A se odlikujejo po velikem odvzemu materiala na časovno enoto, veliko vzdržnostjo in pri brušenju ne pregrevajo obdelovancev
- High grinding efficacy and high durability of grinding wheels
- Special qualities 47A, ZA20 and 417A are distinguished by high material removal rates, high durability and absence of workpiece overheating during grinding.

## F35-U, F36

Brusne plošče z vgrajenimi maticami  
Grinding wheels with integrated nuts



| Oblika Form | Dimenzije D x T x H Dimensions D x T x H                                    | Obodna hitrost Peripheral speed |
|-------------|---|---------------------------------|
|             | D = 300 - 600 mm<br>x<br>T = 40 - 110 mm<br>x<br>H = po naročilu / to order | 50 m/s                          |
|             |   | 63 m/s                          |

Navoj matice je lahko levo ali desno sučni / Nut with left or right thread

| Kvaliteta Quality | D x T x H (mm)  | J (mm) | T (mm) | Dk1/št. matic No. of knots mm/kom piece | Dk2/št. matic No. of knots mm/kom piece | Navoj Thread |
|-------------------|-----------------|--------|--------|---|---|--------------|
| F35-U             | 450 x 60 x 200  | 428    | 11     |   |   |              |
| F35-U             | 450 x 60 x 0    | 428    | 11     |   |   |              |
| F36               | 350 x 100 x 255 |        |        | 300/8                                   |   | M12          |
| F36               | 450 x 90 x 255  |        |        | 375/10                                  |   | M10          |
| F36               | 508 x 100 x 350 |        |        | 456/24                                  |   | M10          |
| F36               | 508 x 100 x 406 |        |        | 456/24                                  |   | M10          |
| F36               | 508 x 110 x 406 |        |        | 456/24                                  |   | M10          |
| F36               | 602 x 100 x 325 |        |        | 530/12                                  | 370/6                                   | M16          |
| F36               | 602 x 125 x 325 |        |        | 530/12                                  | 370/6                                   | M16          |
| F36               | 602 x 75 x 325  |        |        | 530/12                                  | 370/6                                   | M16          |

| Kvaliteta Quality | Jeklo Steel | Nerjaveče jeklo Stainless steel | Siva litina Cast iron | Nodularna litina Nodular alloys | Alu. litina Alu. cast | Magneti Magnets |
|-------------------|-------------|---------------------------------|-----------------------|---------------------------------|-----------------------|-----------------|
| 947C60G8B         |             |                                 |                       |                                 |                       | ●               |
| 147A46H5B         | ●           | ●                               |                       |                                 |                       |                 |
| 417A14-24R5B      |             |                                 | ●                     | ●                               |                       |                 |
| ZA14-24S4BF       | ●           | ●                               | ●                     | ●                               |                       |                 |
| 54A24-16R5BF      |             |                                 | ○                     |                                 | ●                     |                 |

● Primerna kvaliteta / Main application ○ Pogojno uporabna kvaliteta / Possible application

### NAMEN UPORABE / APPLICATIONS

- Za eno ali dvokolatno ploskavno avtomatsko brušenje odlitkov
- Uporablja se v proizvodnji magnetov, vzmeti ter brušenje odlitkov za avtomobilsko industrijo
- For single and bi-wheel automatic flat grinding of casts
- Manufacture of magnets and springs and grinding of casts for the automotive industry

### PREDNOSTI / ADVANTAGES

- Visok učinek brušenja na časovno enoto in visoka vzdržnost brusnih plošč
- Specialne kvalitete 417A, 47A in ZA16 se odlikujejo po velikem odvzemu materiala na časovno enoto, veliko vzdržnostjo in brušenju brez pregrevanja obdelovancev
- High grinding efficacy and high durability of grinding wheels
- Special qualities 417A, 47A and ZA16 are distinguished by high material removal rates, high durability and absence of workpiece overheating during grinding.



SWATYCOMET, umetni brusni in nekovine, d.o.o.  
Titova cesta 60, 2000 Maribor, Slovenija  
t: +386 (0)2 333 16 00, +386 (0)3 7575 000  
f: +386 (0)2 333 17 90, +386 (0)3 7575 100  
www.swatycomet.si, e: info@swatycomet.si

SMOLNO VEZANI BRUSI s SiC in korundnimi zrnji  
RESIN BONDED WHEELS with SiC and Al oxide



# Brusi za livarsko industrijo Foundry grinding wheels



- Izredna vzdržljivost z dodatkom cirkon korundnih zrn
- Za vse vrste odlitkov

- Exceptional durability due to addition of zirconium oxide
- For all types of casts



# SWATYCOMET

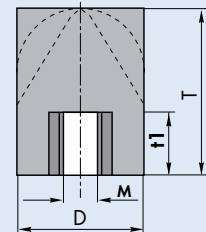




**F15, F17, F18, F18R, F19**  
Brusni čepi / Cone and plug wheels



| Oblika Form | Kvaliteta Quality  | Dimenzije D x T x M Dimensions D x T x M  | Obodna hitrost Peripheral speed |
|-------------|--------------------|---|---------------------------------|
| F15         | 12A20R5B /47A16R5B | D = 32 - 60 mm<br>x<br>T = 50 - 100 mm<br>x<br>M = M10, M12, M14, M16,<br>3/8", 1/2", 5/8"-11 | 50 m/s                          |
| F17         |                    |   |                                 |
| F18         |                    |   |                                 |
| F18R        |                    |   |                                 |
| F19         |                    |   |                                 |



**NAMEN UPORABE / APPLICATIONS**

- Brušenje, čiščenje odlitkov vseh kvalitiet
- Brusni se uporabljajo pri maksimalni obodni hitrosti 50 m/s
- Grinding and cleaning of casts of all qualities
- Grinding wheels are used at the maximum peripheral speed of 50 m/s.

**PREDNOSTI / ADVANTAGES**

- Visoka vzdržnost čepov in veliki odvzemi materiala na časovno enoto
- Specialna kvaliteta 47A16 se odlikuje po velikem odvzemu materiala na časovno enoto, brez pregrevanja obdelovanca
- High durability of cone and plug wheels with high material removal rates
- Special quality 47A16 is distinguished by high material removal rates without workpiece overheating.

**F1, F1-AF**  
Brusne plošče / Grinding wheels



| Oblika Form | Kvaliteta Quality  | Dimenzije D x T x H Dimensions D x T x H                              | Obodna hitrost Peripheral speed |
|-------------|--------------------|---|---------------------------------|
| F1          | 15A30P4BF/47A24RBF | D = 50 - 100 mm<br>x<br>T = 4 - 15 mm<br>x<br>H = 6, 8, 10, 12, 13 mm | 50 m/s                          |
| F1-AF       |                    |   | 63 m/s                          |
|             |                    |   | 80 m/s                          |

**NAMEN UPORABE / APPLICATIONS**

- Čiščenje odlitkov, odkovkov, razrezanih in varjenih materialov
- Uporabljajo se na ročnih brusilnih strojih
- Cleaning of casts, forged pieces and cut and welded materials
- For use on manual grinding machines.

**PREDNOSTI / ADVANTAGES**

- Kvalitetno brušenje na različnih materialih
- Specialna kvaliteta se odlikuje po velikem odvzemu materiala na časovno enoto, brez pregrevanja obdelovanca
- High-quality grinding of various materials
- Special quality is distinguished by high material removal rates without workpiece overheating.

**F1, F1-AF**  
Brusne plošče / Grinding wheels



| Oblika Form | Dimenzije D x T x H Dimensions D x T x H                                 | Obodna hitrost Peripheral speed |
|-------------|--|---------------------------------|
| F1          | D = 75 - 250 mm<br>x<br>T = 20 - 50 mm<br>x<br>H = 16, 20, 25, 30, 32 mm | 50 m/s                          |
| F1-AF       |  | 63 m/s                          |
|             |  | 80 m/s                          |

| Kvaliteta Quality | Jeklo Steel | Nerjaveče jeklo Stainless steel | Siva litina Cast iron | Nodularna litina Nodular alloys | Alu. litina Alu. cast |
|-------------------|-------------|---------------------------------|-----------------------|---------------------------------|-----------------------|
| A14-30Q4B         | ●           |                                 |                       | ○                               |                       |
| 12A24P6B          | ●           | ●                               |                       |                                 |                       |
| 91C24R5B          |             |                                 | ●                     |                                 | ○                     |
| 47A24R5B          | ●           | ●                               | ●                     | ○                               | ○                     |
| ZA14-30Q4B        | ●           | ●                               | ●                     | ●                               |                       |
| 54A24R5B          |             |                                 | ○                     |                                 | ●                     |

● Primerna kvaliteta / Main application ○ Pogojno uporabna kvaliteta / Possible application

**NAMEN UPORABE / APPLICATIONS**

- Čiščenje odlitkov, odkovkov, razrezanih in varjenih materialov
- Uporabljajo se na ročnih in stabilnih brusilnih strojih
- Cleaning of casts, forged pieces and cut and welded materials
- For use on manual and stationary grinding machines.

**PREDNOSTI / ADVANTAGES**

- Visok učinek brušenja na časovno enoto in visoka vzdržnost brusnih plošč
- Specialne kvalitete 47A in ZA se odlikujejo po velikem odvzemu materiala na časovno enoto, veliko vzdržnostjo in pri brušenju ne pregrejajo obdelovanca
- High grinding efficacy and high durability of grinding wheels
- Special qualities 47A and ZA are distinguished by high material removal rates, high durability and absence of workpiece overheating during grinding.

**F1-AO, F1-AFG, F1-AF**  
Brusne plošče / Grinding wheels

| Oblika Form | Dimenzije D x T x H Dimensions D x T x H  | Obodna hitrost Peripheral speed |
|-------------|---|---------------------------------|
| F1-AO       | D = 300 - 600 mm<br>x<br>T = 25 - 125 mm<br>x<br>H = 40, 50, 60, 76.2, 127, 150,<br>152.4, 200, 200.3, 305 mm | 50 m/s                          |
| F1-AFG      |   | 63 m/s                          |
| F1-AF       |   | 80 m/s                          |

| Kvaliteta Quality | Jeklo Steel | Nerjaveče jeklo Stainless steel | Siva litina Cast iron | Nodularna litina Nodular alloys | Alu. litina Alu. cast | Liv. pesek Casting sand |
|-------------------|-------------|---------------------------------|-----------------------|---------------------------------|-----------------------|-------------------------|
| A14-24O-S4B       | ●           |                                 |                       | ○                               |                       |                         |
| 12A14-24O-R5B     | ●           | ●                               |                       |                                 |                       |                         |
| 47A14-24R5B       | ●           | ●                               | ●                     | ○                               | ○                     |                         |
| 52C14-24R5B       |             |                                 | ●                     |                                 | ○                     | ○                       |
| 128A14-24R5B      |             |                                 | ●                     | ○                               |                       |                         |
| 417A14-24R5B      |             |                                 | ●                     | ●                               |                       |                         |
| ZA14-24S4BF       | ●           | ●                               | ●                     | ●                               |                       |                         |
| 58C14-24S4BF      |             |                                 | ●                     |                                 |                       | ●                       |
| 54A24-16R5BF      |             |                                 | ○                     |                                 | ●                     |                         |
| 90C24-16S4BF      |             |                                 | ○                     |                                 |                       | ●                       |

● Primerna kvaliteta / Main application ○ Pogojno uporabna kvaliteta / Possible application

**NAMEN UPORABE / APPLICATIONS**

- Čiščenje in grobo brušenje vseh kvalitiet odlitkov in odkovkov na stabilnih strojih (ročno dodajanje lažjih obdelovancev). Delovne obodne hitrosti so 50; 63; 80 m/s.
- Čiščenje in grobo brušenje vseh kvalitiet težjih obdelovancev, s pomočjo visečih, ročno vodenih strojev; delovna obodna hitrost je 63 m/s.
- Čiščenje in grobo brušenje vseh kvalitiet težjih obdelovancev, z avtomatskimi stroji-Andromat. Delovna obodna hitrost je 80 m/s
- Cleaning and coarse grinding of cast and forged pieces of all qualities, use on stationary grinding machines (manual feeding of light workpieces). Peripheral operating speeds: 50, 63 and 80 m/s
- Cleaning and coarse grinding of heavy workpieces of all qualities using suspended, manually controlled machines. Peripheral operating speed: 63 m/s
- Cleaning and coarse grinding of heavy workpieces of all qualities using Andromat automatic machines. Peripheral operating speed: 80 m/s.

**PREDNOSTI / ADVANTAGES**

- Visok učinek brušenja na časovno enoto in visoka vzdržnost brusnih plošč
- Specialne kvalitete 417A, 47A in ZA16 se odlikujejo po velikem odvzemu materiala, veliko vzdržnostjo in brušenju brez pregrevanja obdelovanca
- High grinding efficacy and high durability of grinding wheels
- Special qualities 417A, 47A and ZA16 are distinguished by high material removal rates, high durability and absence of workpiece overheating during grinding.