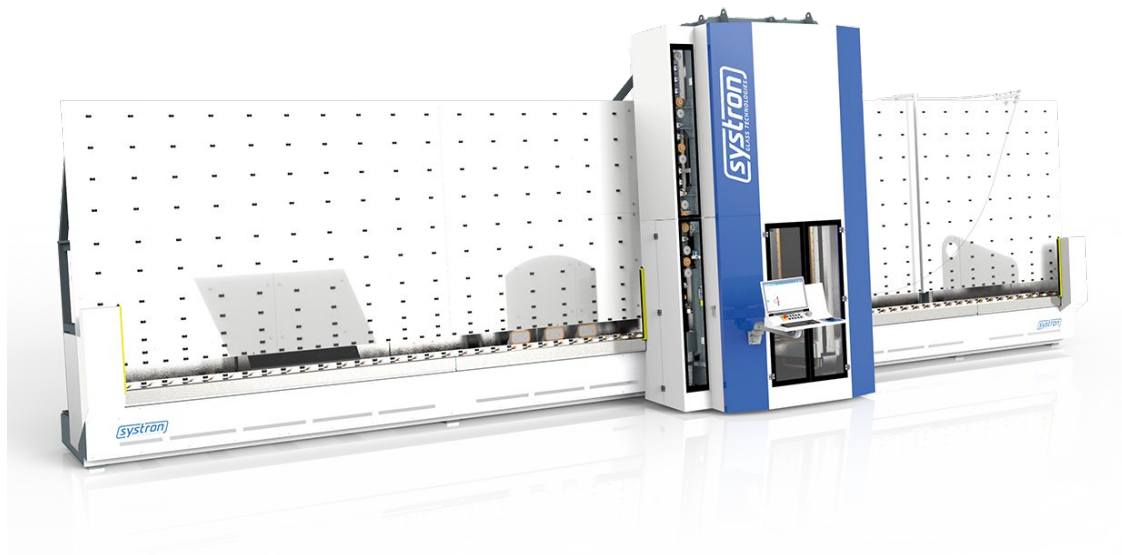
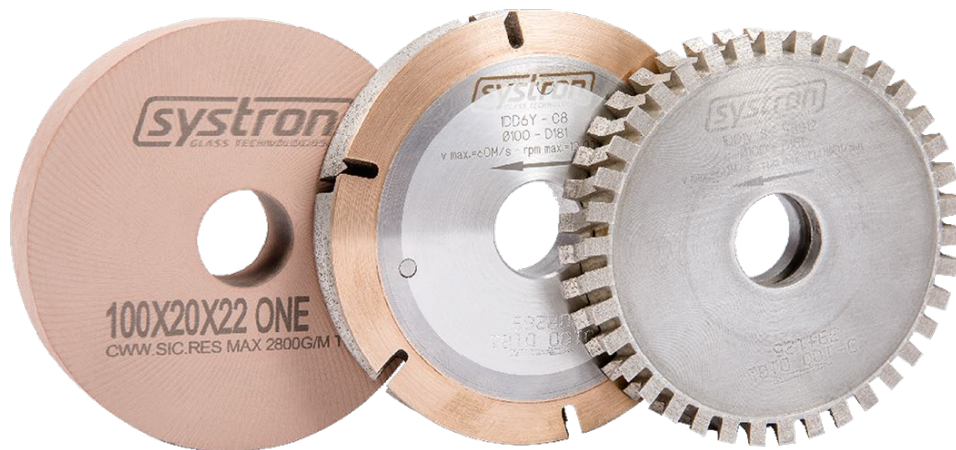




CATALOGUE TOOLS for pro/ proHD



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CATALOGUE 2022 - systronTOOLS

Diamond and Polishing Tools



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systron pro/ proHD basic approach for Diamond and Polishing tools

For glass thickness

C4 }
C5 } COARSE and FINE wheel
C6 } are mounted on one cone/ tool holder
C8 }

This already leads to a considerable time saving as a tool change is avoided, even if the tool change is extremely quickly on a systron machine

For glass thickness

C10 }
C12 } coarse and fine wheel are mounted
C15 } on a separated cone/ tool holder
C19 }

Polishing wheels

C4
↓
C19 are mounted on a separate cone/ holder corresponding to glass thickness

systronTOOLS have

- a defined recommendation for prm

segmented tools: 8.500-9.000 rpm

6 or 12 slots coarse: 7.000 rpm (range 6.500 to 7.500)

3 slots fine: 7.000 – 7.500 rpm (range 6.500 – 7.500)

- a defined recommendation for traverse speed

see tables on pages 10-12

IMPORTANT: These new specifications work best if a "running in " phase is observed

This means until reaching the full cutting ability the traverse speed acc. to attached table is to be maintained!

- it can absolutely occur that initially force is slightly higher until full cutting ability is reached
- regulating rpm is often the easiest and fastest method:
 - o REDUCE rpm in case force increases (to about 6.000 - 6.500 rpm)
 - o INCREASE rpm in case of unclean edges (step by step for +500 rpm)
 - o **ALWAYS SHARPEN AFTER CHANGRING RPM!**
 - o **DO NOT REDUCE TRAVERSE SPEED TO LOW- TOOLS MIGHT GET BLUNT! (-10% to -20% OK, not further)**

Tool-Designs



FA tools with 6 slots

Pregrinding C3- C6

Pregrinding C8- C19 with low removal

Fine grinding Laminated glass



FA tools with 38 segments

Pregrinding C8 - C19 Standard

Pregrinding Laminated 6 - Laminated 24



FA tools with 3 slots

Fine grinding C3 - C19



Flat Edge tools with 38 segments

Pregrinding C10 - C19 high removal and over-breakage

Pregrinding Laminated 6 - Laminated 24, also oscillating

systron PRO LINE FLOAT Diameter 100 mm

Glass	Grit	Part#	Design
C3	D107	000-017034	FA 6 Slots x=7,5
	D126	000-017035	FA 6 Slots x=7,5
	D151	000-008646	FA 6 Slots x=7,5
	D64	000-008647	FA 3 Slots x=5
C4	D107	000-014284	FA 6 Slots x=7,5
	D126	000-016637	FA 6 Slots x=7,5
	D151	000-008648	FA 6 Slots x=7,5
	D64	000-008649	FA 3 Slots x=5
C5	D107	000-017017	FA 6 Slots x=7,5
	D126	000-017036	FA 6 Slots x=7,5
	D151	000-008650	FA 6 Slots x=7,5
	D64	000-008651	FA 3 Slots x=5
C6	D151	000-011760	FA 6 Slots x=7,5
	D64	000-008653	FA 3 Slots x=5
C8	D151	000-011743	FA 38 segments x= 5,5
	D151	000-008654	FA 6 Slots x=7,5
	D64	000-008655	FA 3 Slots x=5
C10	D151	000-011746	FA 38 segments x= 5,5
	D181	000-008656	FA 6 Slots x=7,5
	D64	000-008657	FA 3 Slots x=5
C12	D151	000-011748	FA 38 segments x= 5,5
	D181	000-008658	FA 6 Slots x=7,5
	D64	000-008659	FA 3 Slots x=5
C15	D181	000-011750	FA 38 segments x= 5,5
	D181	000-008660	FA 6 Slots x=7,5
	D64	000-008661	FA 3 Slots x=5
C19	D181	000-011751	FA 38 segments x= 5,5
	D181	000-008662	FA 6 Slots x=7,5
	D64	000-008663	FA 3 Slots x=5



marked = our recommendation

text BOLD = Coarse Grit Tool

FLAT EDGE WHEELS FOR HIGH REMOVAL RATES

C10	D151	000-015716	T= 12 38 Seg x=6
C12	D151	000-017841	T= 14 38 Seg x=6
C15	D181	000-009157	T= 17 38 Seg x=6
C19	D181	000-009158	T= 21 38 Seg x=6



Your advantages at a glance:

- 7,5 mm diamond layer for FA wheels coarse grit 3-19mm
- 5 mm diamond layer for FA wheels fine grit 3-19mm
- Outstanding increase of traverse speed up to 15 m/min
- Perfect Finishing results
- Multiple Reprofilng possible
- Outstanding price/performance ratio

systron *PRO* LINE VSG Diameter 100 mm

Glass	Grit	Part#	Design
LAM 6 33.1 - 33.2	D181	000-008631	FA 38 Segments x= 5,5
	D64	000-008632	FA 6 Slots x= 5
LAM 8 44.1 - 44.2	D181	000-008633	FA 38 Segments x= 5,5
	D64	000-008634	FA 6 Slots x= 5
LAM 10 55.1 - 55.2	D181	000-008635	FA 38 Segments x= 5,5
	D64	000-008636	FA 6 Slots x= 5
LAM 12 66.2 - 66.4	D181	000-008637	FA 38 Segments x= 5,5
	D64	000-008638	FA 6 Slots x= 5
LAM 16 88.2 - 88.4	D181	000-008639	FA 38 Segments x= 5,5
	D64	000-008640	FA 6 Slots x= 5
LAM 20 1010.2 - 1010.4	D181	000-008641	FA 38 Segments x= 5,5
	D64	000-008642	FA 6 Slots x= 5
LAM 24 1212.2 - 1212.4	D181	000-008643	FA 38 Segments x= 5,5
	D64	000-008644	FA 6 Slots x= 5
UNI 6-16	D181	000-008645	FE 38 Segments x= 6



Your advantages at a glance:

- 5,5 mm diamond layer for coarse grits
- 5 mm diamond layer for fine grits
- Enormous increase of traverse speed up to 12m/min
- Pregrinding with FA profile guarantees increased life of fine wheels
- Perfect Finishing results
- Reprofilng possible
- Outstanding price/performance ratio



POLISHING WHEELS

systron POLISHING LINE Diameter 100 mm			
Glass	Grit	Part#	Design
3 - 8 LAM6	BD400	010-003518	100x15x22 4 waterholes
10 - 12 LAM8 - LAM12	BD400	010-002829	100x20x22 4 waterholes
15 - 19 LAM16	BD400	010-002830	100x25x22 no waterholes

recommended
for C3-C5



Your advantages at a glance:

- simple to use
- TOP Polishing results with one pass
- Good price/ performance ratio

systron PRO POLISHING LINE Diameter 100 mm			
Glass	Grit	Part#	Design
3 - 8 LAM 6	SYSTRON ONE	000-009315	100x15x22 no waterholes
10 - 12 LAM8 - LAM12	SYSTRON ONE	000-008384	100x20x22 no waterholes
15 - 19 LAM16	SYSTRON ONE	000-009109	100x25x22 no waterholes
LAM20 - LAM24	SYSTRON ONE	000-011754	100x30x22 no waterholes

recommended
for C3-C5

Polishing wheels for internal processing			
3 - 12	SYSTRON ONE	000-009849	20 x 20 x 6
15 - 19		000-009850	20 x 25 x 6
3 - 12	BD400	000-001990	25 x 20 x 6
15 - 19		010-002826	25 x 25 x 6

for small radii



Your advantages at a glance:

- high traverse speeds
- high gloss with one pass
- lifetime increase up to 50%
- Outstanding price/performance ratio

syston FLOAT Trap Routers Diameter 14 mm			
Glass	Grit	Part#	Design
C3	D76	010-003508	router 14 x 70 x R1/2"
C4	D76	010-003509	router 14 x 70 x R1/2"
C5	D76	010-003510	router 14 x 70 x R1/2"
C6	D76	010-003511	router 14 x 70 x R1/2"
C8	D76	010-003512	router 14 x 70 x R1/2"
C10	D76	010-003513	router 14 x 70 x R1/2"
C12	D76	010-003514	router 14 x 70 x R1/2"
C15	D76	010-003515	router 14 x 70 x R1/2"
C19	D76	010-003516	router 14 x 70 x R1/2"



Your advantages at a glance:

- free cutting bond ensures clean edges
- constant feed rates from 0,5-0,6 m/min
- removal up to 1mm
- outstanding price/ performance ratio

PARAMETER-GUIDE FLOAT GLASS

proHD - TRAPEZOIDAL WHEELS

RECOMMENDATIONS FOR PROLine FLOAT tools

Trapezoidal wheels	COARSE D107- D126- D151 - D181			FINE - D64			POLISHING - ONE		
	removal mm	speed m/min	rpm min ⁻¹	removal mm	speed m/min	rpm min ⁻¹	speed m/min	rpm U/min	pressure N
4 mm	1,2 - 1,7	11 - 14	6500-7000	0,3	13 - 15	7000-7500	5 - 7	3200-3500	100 - 150
5 mm	1,2 - 1,7	11 - 14	6500-7000	0,3	13 - 15	7000-7500	5 - 7	3200-3500	
6 mm	1,2 - 1,7	8 - 12	6500-7000	0,3	12 - 14	7000-7500	5 - 7	3200-3500	
8 mm	1,2 - 1,7	8 - 12	6500-7000	0,3	9 - 12	7000-7500	3,5 - 6	3200-3500	140 - 170
10 mm	1,7	6 - 10	6500-7000	0,3 - 0,4	8 - 10	7000-7500	3,5 - 5	3200-3500	
12 mm	1,6-1,7	4 - 8	6500-7000	0,3 - 0,4	7 - 9	7000-7500	3 - 4	3200-3500	150 - 200
15 mm	1,6-1,7	3,5 - 4	6500-7000	0,3 - 0,4	3,5-5	7000-7500	2,5 - 3	3200-3500	
19 mm	1,6-1,7	2,5 - 3	6500-7000	0,3 - 0,4	3 - 4	7000-7500	1,5 - 2,5	3200-3500	

FA SEGMENTED D151/181			
	removal mm	speed m/min	rpm U/min
10-19 mm	1,5 - 2,5	6 - 10	8800

FE SEGMENTED D151/ 181			
	removal mm	speed m/min	rpm U/min
10-19 mm	1,5 - 2,5	8 - 12	8800



Remark: removal parameters refer to standard removal rates of 1,5mm to 2mm for glass 4 to 8 - 2mm for glass 10 and 3mm from glass 12

Remark 2: With D107-D126 for C3-C4-C5 reduce feed rate by 2m/min

If necessary, adapt accordingly!

PARAMETER- GUIDE FLOAT GLASS

proHD - TRAPEZOIDAL ROUTERS

	TRAP ROUTER D 14mm			TRAP ROUTER D 10mm			POLISHING D 25mm	
	removal mm	speed mm/min	rpm min ⁻¹	removal mm	speed mm/min	rpm min ⁻¹	speed mm/min	rpm min ⁻¹
4 mm	0,2	300 - 400	9000 - 10000	0,2	300	9000 - 10000	1000	4000 - 4500
5 mm	0,2	300 - 400		0,2	300			
6 mm	0,2	300		0,2	250			
8 mm	0,2	300	8.500- 9500	0,2	250	8.500- 9500	800 - 1000	
10 mm	0,2	250 - 300		0,2	250			
12 mm	0,2	250 - 300		0,2	200			
15 mm	0,2	250	8500 - 9000	0,2	200	8500 - 9000		
19 mm	0,2	200 - 250		0,2	150 - 200			

