

# High Performance Glass machining

English

3M™ WENDT™ CNC Tools – new **Silver** and **STAR TRACK** tools

- excellent edge quality
- increased output without glass breakage
- enhanced efficiency due to tool stability
- complete service from one source

## Boost your efficiency in machining glass with 3M™ WENDT™ CNC tools

Our quality tools boost your efficiency in milling and grinding glass - we offer applied solutions. Improve the edge grade, extend the life time of grinding tools and benefit from the further improved price-performance ratio of our products.

- Expanding our range of products with new roughing tools of the **SILVER** line with specialized specifications we are offering excellent milling tools for designing superior outer and inner contours as well as segmented grinding wheels for highest edge quality.
- We provide matching specifications related to your glass thickness – with or without internal cooling, depending on your application.
- Combine the **Silver-** with the **STAR TRACK** tools for fine grinding.
- We offer three different versions for the fine grinding with the **STAR TRACK** line. You can select among
  - standard tools with continuous rim
  - standard tools with internal cooling
  - standard tools with internal cooling and segmented rim
- For optimal clarity of the glass edge we provide first-class proven quality with the **polishing tools PB220**. These can be combined with the **STAR TRACK** tools to complete the process.

### Product benefits at a glance:

#### Milling tools/roughing tools

- long tool life
- high feed rate
- high stock removal rate
- excellent edge quality

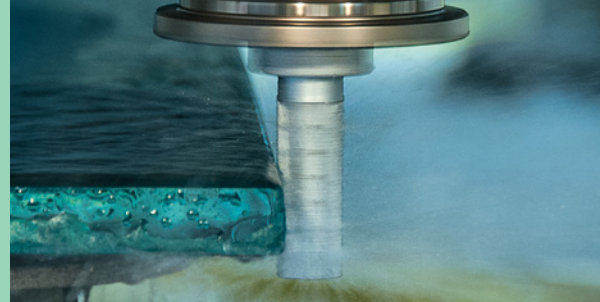
#### Fine grinding tools:

- excellent edge condition for the following polish
- stable profile

#### Polishing tools:

- outstanding polish result
- long tool life

## Application Examples



Machining of glass with segmented router **Silver**



Machining of glass with segmented grinding wheel **Silver**



Edge grinding with **STAR TRACK Flat & Arris wheel**



Polishing with **PB220 wheel**

### CNC tools are suitable for:

- Furniture glass
- Interior glass
- Sanitary area

# 3M™ Diamond Tools for CNC Machines

## 3M™ Segmented Routers Silver

Machines: Intermac, Bavelloni Alpa, Tecnometal, CMS, Denver, Bimatec (Bottero)...

Glass thickness maximum 12 mm

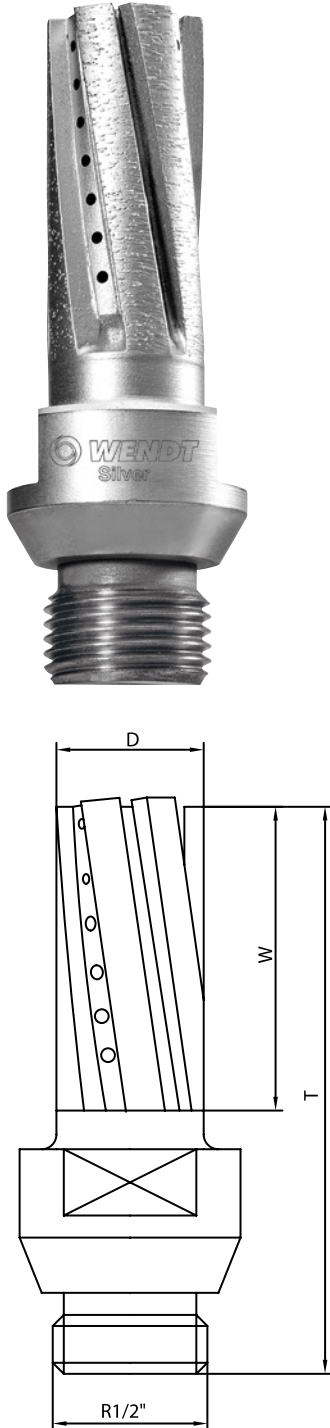
D	Number of segments	Grit	T	W	X	Fitting	3M ID
8	3	FINE	70 mm	30 mm	1.5 mm	R1/2"	ZC000370473
10	3	FINE	70 mm	30 mm	2.0 mm	R1/2"	ZC000370481
12	3	FINE	70 mm	30 mm	2.0 mm	R1/2"	ZC000366901
14	4	FINE	80 mm	45 mm	2.5 mm	R1/2"	ZC000366919
16	4	FINE	80 mm	45 mm	3.0 mm	R1/2"	ZC000370499
20	6	FINE	85 mm	45 mm	3.5 mm	R1/2"	ZC000370507
22	6	FINE	85 mm	45 mm	3.5 mm	R1/2"	ZC000366927

Glass thickness 6 to 15 mm

D	Number of segments	Grit	T	W	X	Fitting	3M ID
8	3	MED	70 mm	30 mm	1.5 mm	R1/2"	ZC000370515
10	3	MED	70 mm	30 mm	2.0 mm	R1/2"	ZC000370523
12	3	MED	70 mm	30 mm	2.0 mm	R1/2"	ZC000366935
14	4	MED	80 mm	45 mm	2.5 mm	R1/2"	ZC000366943
16	4	MED	80 mm	45 mm	3.0 mm	R1/2"	ZC000370531
20	6	MED	85 mm	45 mm	3.5 mm	R1/2"	ZC000370549
22	6	MED	85 mm	45 mm	3.5 mm	R1/2"	ZC000366950

Glass thickness 12 to 19 mm

D	Number of segments	Grit	T	W	X	Fitting	3M ID
8	3	ROUGH	70 mm	30 mm	1.5 mm	R1/2"	ZC000366968
10	3	ROUGH	70 mm	30 mm	2.0 mm	R1/2"	ZC000370556
12	3	ROUGH	70 mm	30 mm	2.0 mm	R1/2"	ZC000366976
14	4	ROUGH	80 mm	45 mm	2.5 mm	R1/2"	ZC000366984
16	4	ROUGH	80 mm	45 mm	3.0 mm	R1/2"	ZC000366992
20	6	ROUGH	85 mm	45 mm	3.5 mm	R1/2"	ZC000370564
22	6	ROUGH	85 mm	45 mm	3.5 mm	R1/2"	ZC000367008



# 3M™ Diamond Tools for CNC Machines

## 3M™ Segmented Grinding Wheels **Silver**

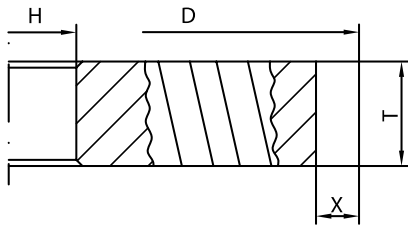
Machines: Intermac, Bavelloni Alpa, Tecnometal, CMS, Denver, Bimatec (Bottero)...

Standard segmented tool, Ø 100 mm, type 1A1S without internal cooling



D	Glass	Grit	T	X	H	3M ID
100	3-6 mm	D151	8 mm	7 mm	22 mm	ZC000367016
100	6-8 mm	D151	10 mm	7 mm	22 mm	ZC000367024
100	10 mm	D181	12 mm	7 mm	22 mm	ZC000370572
100	12 mm	D181	14 mm	7 mm	22 mm	ZC000367032
100	15 mm	D251	17 mm	7 mm	22 mm	ZC000370580
100	19 mm	D251	22 mm	7 mm	22 mm	ZC000367040

Standard segmented tool, Ø 120 mm, type 1A1S without internal cooling



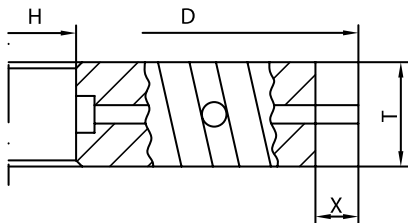
D	Glass	Grit	T	X	H	3M ID
120	3-6 mm	D151	8 mm	7 mm	22 mm	ZC000367057
120	6-8 mm	D151	10 mm	7 mm	22 mm	ZC000370598
120	10 mm	D181	12 mm	7 mm	22 mm	ZC000370606
120	12 mm	D181	14 mm	7 mm	22 mm	ZC000367065
120	15 mm	D251	17 mm	7 mm	22 mm	ZC000367073
120	19 mm	D251	22 mm	7 mm	22 mm	ZC000367081

Standard segmented tool, Ø 100 mm, type 1A1S with internal cooling



D	Glass	Grit	T	X	H	3M ID
100	3-6 mm	D151	8 mm	7 mm	22 mm	ZC000367099
100	6-8 mm	D151	10 mm	7 mm	22 mm	ZC000367107
100	10 mm	D181	12 mm	7 mm	22 mm	ZC000370614
100	12 mm	D181	14 mm	7 mm	22 mm	ZC000367115
100	15 mm	D251	17 mm	7 mm	22 mm	ZC000367123
100	19 mm	D251	22 mm	7 mm	22 mm	ZC000367131

Standard segmented tool, Ø 120 mm, type 1A1S with internal cooling



D	Glass	Grit	T	X	H	3M ID
120	3-6 mm	D151	8 mm	7 mm	22 mm	ZC000367149
120	6-8 mm	D151	10 mm	7 mm	22 mm	ZC000367156
120	10 mm	D181	12 mm	7 mm	22 mm	ZC000367164
120	12 mm	D181	14 mm	7 mm	22 mm	ZC000367172
120	15 mm	D251	17 mm	7 mm	22 mm	ZC000367180
120	19 mm	D251	22 mm	7 mm	22 mm	ZC000367198



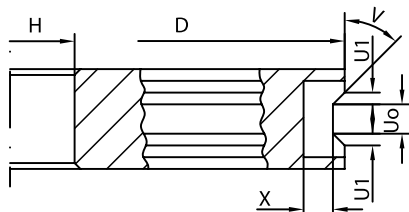
## 3M™ Peripheral wheel **STAR TRACK** Flat & Arris

Machines: Intermac, Bavelloni Alpa, Tecnometal, CMS, Denver, Bimatec (Bottero)...

Standard tool, Ø 100 mm, type 1DD6Y without internal cooling



D	Glass	Grit	U <sub>o</sub>	U <sub>1</sub>	V	X	H	3M ID
100	4 mm	D64	2 mm	1.5 mm	45°	3 mm	22 mm	ZC000370622
100	5 mm	D64	3 mm	1.5 mm	45°	3 mm	22 mm	ZC000370630
100	6 mm	D64	4 mm	1.5 mm	45°	3 mm	22 mm	ZC000370648
100	8 mm	D76	5 mm	2.0 mm	45°	3 mm	22 mm	ZC000370655
100	10 mm	D76	7 mm	2.0 mm	45°	3 mm	22 mm	ZC000370663
100	12 mm	D76	9 mm	2.0 mm	45°	3 mm	22 mm	ZC000370671
100	15 mm	D76	11 mm	2.5 mm	45°	3 mm	22 mm	ZC000370689
100	19 mm	D76	15 mm	2.5 mm	45°	3 mm	22 mm	ZC000370697



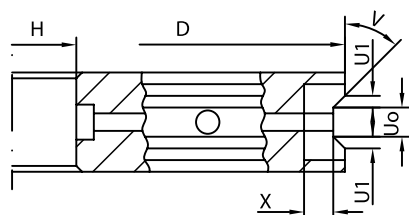
Standard tool, Ø 120 mm, type 1DD6Y without internal cooling

D	Glass	Grit	U <sub>o</sub>	U <sub>1</sub>	V	X	H	3M ID
120	4 mm	D64	2 mm	1.5 mm	45°	3 mm	22 mm	ZC000370705
120	5 mm	D64	3 mm	1.5 mm	45°	3 mm	22 mm	ZC000370713
120	6 mm	D64	4 mm	1.5 mm	45°	3 mm	22 mm	ZC000370721
120	8 mm	D76	5 mm	2.0 mm	45°	3 mm	22 mm	ZC000371299
120	10 mm	D76	7 mm	2.0 mm	45°	3 mm	22 mm	ZC000371281
120	12 mm	D76	9 mm	2.0 mm	45°	3 mm	22 mm	ZC000370739
120	15 mm	D76	11 mm	2.5 mm	45°	3 mm	22 mm	ZC000370747
120	19 mm	D76	15 mm	2.5 mm	45°	3 mm	22 mm	ZC000370754



Standard tool, Ø 100 mm, type 1DD6Y with internal cooling

D	Glass	Grit	U <sub>o</sub>	U <sub>1</sub>	V	X	H	3M ID
100	4 mm	D64	2 mm	1.5 mm	45°	3 mm	22 mm	ZC000370762
100	5 mm	D64	3 mm	1.5 mm	45°	3 mm	22 mm	ZC000370770
100	6 mm	D64	4 mm	1.5 mm	45°	3 mm	22 mm	ZC000370788
100	8 mm	D76	5 mm	2.0 mm	45°	3 mm	22 mm	ZC000370796
100	10 mm	D76	7 mm	2.0 mm	45°	3 mm	22 mm	ZC000370804
100	12 mm	D76	9 mm	2.0 mm	45°	3 mm	22 mm	ZC000370812
100	15 mm	D76	11 mm	2.5 mm	45°	3 mm	22 mm	ZC000370820
100	19 mm	D76	15 mm	2.5 mm	45°	3 mm	22 mm	ZC000370838



Standard tool, Ø 120 mm, type 1DD6Y with internal cooling

D	Glass	Grit	U <sub>o</sub>	U <sub>1</sub>	V	X	H	3M ID
120	4 mm	D64	2 mm	1.5 mm	45°	3 mm	22 mm	ZC000367206
120	5 mm	D64	3 mm	1.5 mm	45°	3 mm	22 mm	ZC000367214
120	6 mm	D64	4 mm	1.5 mm	45°	3 mm	22 mm	ZC000370846
120	8 mm	D76	5 mm	2.0 mm	45°	3 mm	22 mm	ZC000370853
120	10 mm	D76	7 mm	2.0 mm	45°	3 mm	22 mm	ZC000367222
120	12 mm	D76	9 mm	2.0 mm	45°	3 mm	22 mm	ZC000367230
120	15 mm	D76	11 mm	2.5 mm	45°	3 mm	22 mm	ZC000367248
120	19 mm	D76	15 mm	2.5 mm	45°	3 mm	22 mm	ZC000367255

# 3M™ Diamond Tools for CNC Machines

## 3M™ Peripheral wheel **STAR TRACK** Flat & Arris

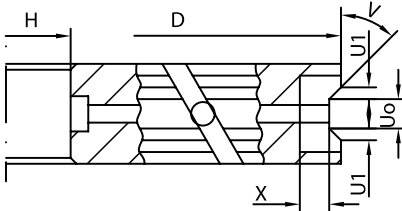
Machines: Intermac, Bavelloni Alpa, Tecnometal, CMS, Denver, Bimatec (Bottero)...

Standard tool, Ø 100 mm, type 1DD6YS with internal cooling and slots



D	Glass	Grit	U <sub>o</sub>	U <sub>1</sub>	V	X	H	3M ID
100	4 mm	D64	2 mm	1.5 mm	45°	3 mm	22 mm	ZC000370861
100	5 mm	D64	3 mm	1.5 mm	45°	3 mm	22 mm	ZC000367263
100	6 mm	D64	4 mm	1.5 mm	45°	3 mm	22 mm	ZC000370879
100	8 mm	D76	5 mm	2.0 mm	45°	3 mm	22 mm	ZC000370887
100	10 mm	D76	7 mm	2.0 mm	45°	3 mm	22 mm	ZC000370895
100	12 mm	D76	9 mm	2.0 mm	45°	3 mm	22 mm	ZC000370903
100	15 mm	D76	11 mm	2.5 mm	45°	3 mm	22 mm	ZC000370911
100	19 mm	D76	15 mm	2.5 mm	45°	3 mm	22 mm	ZC000370929

Standard tool, Ø 120 mm, type 1DD6YS with internal cooling and slots

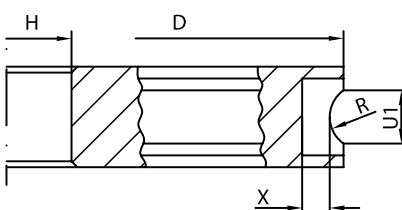


D	Glass	Grit	U <sub>o</sub>	U <sub>1</sub>	V	X	H	3M ID
120	4 mm	D64	2 mm	1.5 mm	45°	3 mm	22 mm	ZC000367271
120	5 mm	D64	3 mm	1.5 mm	45°	3 mm	22 mm	ZC000367289
120	6 mm	D64	4 mm	1.5 mm	45°	3 mm	22 mm	ZC000367297
120	8 mm	D76	5 mm	2.0 mm	45°	3 mm	22 mm	ZC000367305
120	10 mm	D76	7 mm	2.0 mm	45°	3 mm	22 mm	ZC000367313
120	12 mm	D76	9 mm	2.0 mm	45°	3 mm	22 mm	ZC000367321
120	15 mm	D76	11 mm	2.5 mm	45°	3 mm	22 mm	ZC000367339
120	19 mm	D76	15 mm	2.5 mm	45°	3 mm	22 mm	ZC000367347

## 3M™ Peripheral wheel **STAR TRACK** C-shape

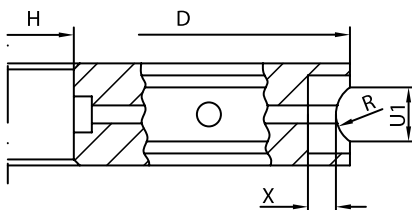
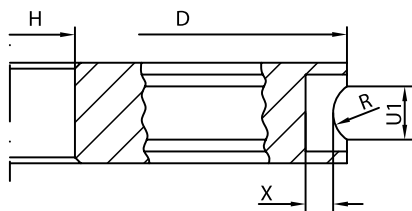
Machines: Intermac, Bavelloni Alpa, Tecnometal, CMS, Denver, Bimatec (Bottero)...

Standard tool, Ø 100 mm, type 1J6Y without internal cooling



D	Glass	Grit	U <sub>1</sub>	R	X	H	3M ID
100	3 mm	D91	4 mm	2.2 mm	3 mm	22 mm	ZC000370937
100	3 mm	D64	4 mm	2.2 mm	3 mm	22 mm	ZC000370945
100	4 mm	D126	5 mm	2.8 mm	3 mm	22 mm	ZC000370952
100	4 mm	D91	5 mm	2.8 mm	3 mm	22 mm	ZC000370960
100	4 mm	D64	5 mm	2.8 mm	3 mm	22 mm	ZC000370978
100	5 mm	D126	6 mm	3.5 mm	3 mm	22 mm	ZC000370986
100	5 mm	D91	6 mm	3.5 mm	3 mm	22 mm	ZC000370994
100	5 mm	D64	6 mm	3.5 mm	3 mm	22 mm	ZC000371000
100	6 mm	D126	7 mm	4.0 mm	3 mm	22 mm	ZC000371018
100	6 mm	D91	7 mm	4.0 mm	3 mm	22 mm	ZC000371026
100	6 mm	D64	7 mm	4.0 mm	3 mm	22 mm	ZC000371034
100	8 mm	D126	9 mm	5.5 mm	3 mm	22 mm	ZC000371042
100	8 mm	D91	9 mm	5.5 mm	3 mm	22 mm	ZC000371059
100	8 mm	D76	9 mm	5.5 mm	3 mm	22 mm	ZC000371067
100	10 mm	D91	11 mm	7.0 mm	3 mm	22 mm	ZC000371075

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Standard tool, Ø 100 mm, type 1J6Y without internal cooling

D	Glass	Grit	U1	R	X	H	3M ID
100	10 mm	D76	11 mm	7.0 mm	3 mm	22 mm	ZC000371083
100	12 mm	D91	13 mm	8.0 mm	3 mm	22 mm	ZC000371091
100	12 mm	D76	13 mm	8.0 mm	3 mm	22 mm	ZC000371109
100	15 mm	D91	16 mm	10 mm	3 mm	22 mm	ZC000371117
100	15 mm	D76	16 mm	10 mm	3 mm	22 mm	ZC000371125
100	19 mm	D91	21 mm	13 mm	3 mm	22 mm	ZC000371133
100	19 mm	D76	21 mm	13 mm	3 mm	22 mm	ZC000371141

Standard tool, Ø 120 mm, type 1J6Y without internal cooling

D	Glass	Grit	U1	R	X	H	3M ID
120	3 mm	D91	4 mm	2.2 mm	3 mm	22 mm	ZC000367354
120	3 mm	D64	4 mm	2.2 mm	3 mm	22 mm	ZC000367362
120	4 mm	D126	5 mm	2.8 mm	3 mm	22 mm	ZC000367370
120	4 mm	D91	5 mm	2.8 mm	3 mm	22 mm	ZC000367388
120	4 mm	D64	5 mm	2.8 mm	3 mm	22 mm	ZC000367396
120	5 mm	D126	6 mm	3.5 mm	3 mm	22 mm	ZC000367404
120	5 mm	D91	6 mm	3.5 mm	3 mm	22 mm	ZC000367412
120	5 mm	D64	6 mm	3.5 mm	3 mm	22 mm	ZC000367420
120	6 mm	D126	7 mm	4.0 mm	3 mm	22 mm	ZC000367438
120	6 mm	D91	7 mm	4.0 mm	3 mm	22 mm	ZC000367446
120	6 mm	D64	7 mm	4.0 mm	3 mm	22 mm	ZC000367453
120	8 mm	D126	9 mm	5.5 mm	3 mm	22 mm	ZC000367461
120	8 mm	D91	9 mm	5.5 mm	3 mm	22 mm	ZC000367479
120	8 mm	D76	9 mm	5.5 mm	3 mm	22 mm	ZC000367487
120	10 mm	D91	11 mm	7.0 mm	3 mm	22 mm	ZC000367495
120	10 mm	D76	11 mm	7.0 mm	3 mm	22 mm	ZC000367503
120	12 mm	D91	13 mm	8.0 mm	3 mm	22 mm	ZC000367511
120	12 mm	D76	13 mm	8.0 mm	3 mm	22 mm	ZC000367529
120	15 mm	D91	16 mm	10 mm	3 mm	22 mm	ZC000367537
120	15 mm	D76	16 mm	10 mm	3 mm	22 mm	ZC000367545
120	19 mm	D91	21 mm	13 mm	3 mm	22 mm	ZC000367552
120	19 mm	D76	21 mm	13 mm	3 mm	22 mm	ZC000367560

Standard tool, Ø 100 mm, type 1J6Y with internal cooling

D	Glass	Grit	U1	R	X	H	3M ID
100	3 mm	D91	4 mm	2.2 mm	3 mm	22 mm	ZC000371158
100	3 mm	D64	4 mm	2.2 mm	3 mm	22 mm	ZC000371307
100	4 mm	D126	5 mm	2.8 mm	3 mm	22 mm	ZC000367578
100	4 mm	D91	5 mm	2.8 mm	3 mm	22 mm	ZC000371166
100	4 mm	D64	5 mm	2.8 mm	3 mm	22 mm	ZC000371174
100	5 mm	D126	6 mm	3.5 mm	3 mm	22 mm	ZC000367586
100	5 mm	D91	6 mm	3.5 mm	3 mm	22 mm	ZC000371182
100	5 mm	D64	6 mm	3.5 mm	3 mm	22 mm	ZC000371190
100	6 mm	D126	7 mm	4.0 mm	3 mm	22 mm	ZC000367594

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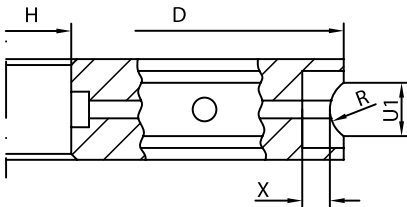
# 3M™ Diamond Tools for CNC Machines

## 3M™ Peripheral wheel **STAR TRACK** C-shape

Machines: Intermac, Bavelloni Alpa, Tecnometal, CMS, Denver, Bimatec (Bottero)...

Continuation of the table from page 7

Standard tool, Ø 100 mm, type 1J6Y with internal cooling



D	Glass	Grit	U1	R	X	H	3M ID
100	6 mm	D91	7 mm	4.0 mm	3 mm	22 mm	ZC000367602
100	6 mm	D64	7 mm	4.0 mm	3 mm	22 mm	ZC000367610
100	8 mm	D126	9 mm	5.5 mm	3 mm	22 mm	ZC000371208
100	8 mm	D91	9 mm	5.5 mm	3 mm	22 mm	ZC000367628
100	8 mm	D76	9 mm	5.5 mm	3 mm	22 mm	ZC000371216
100	10 mm	D91	11 mm	7.0 mm	3 mm	22 mm	ZC000367636
100	10 mm	D76	11 mm	7.0 mm	3 mm	22 mm	ZC000371224
100	12 mm	D91	13 mm	8.0 mm	3 mm	22 mm	ZC000371232
100	12 mm	D76	13 mm	8.0 mm	3 mm	22 mm	ZC000367644
100	15 mm	D91	16 mm	10 mm	3 mm	22 mm	ZC000367651
100	15 mm	D76	16 mm	10 mm	3 mm	22 mm	ZC000367669
100	19 mm	D91	21 mm	13 mm	3 mm	22 mm	ZC000367677
100	19 mm	D76	21 mm	13 mm	3 mm	22 mm	ZC000367685

Standard tool, Ø 120 mm, type 1J6Y with internal cooling

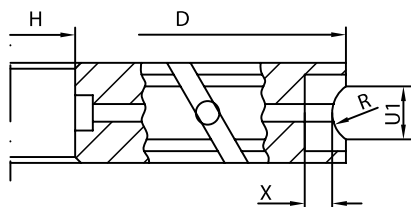
D	Glass	Grit	U1	R	X	H	3M ID
120	3 mm	D91	4 mm	2.2 mm	3 mm	22 mm	ZC000367693
120	3 mm	D64	4 mm	2.2 mm	3 mm	22 mm	ZC000367701
120	4 mm	D126	5 mm	2.8 mm	3 mm	22 mm	ZC000367719
120	4 mm	D91	5 mm	2.8 mm	3 mm	22 mm	ZC000367727
120	4 mm	D64	5 mm	2.8 mm	3 mm	22 mm	ZC000371240
120	5 mm	D126	6 mm	3.5 mm	3 mm	22 mm	ZC000367735
120	5 mm	D91	6 mm	3.5 mm	3 mm	22 mm	ZC000367743
120	5 mm	D64	6 mm	3.5 mm	3 mm	22 mm	ZC000367750
120	6 mm	D126	7 mm	4.0 mm	3 mm	22 mm	ZC000367768
120	6 mm	D91	7 mm	4.0 mm	3 mm	22 mm	ZC000367776
120	6 mm	D64	7 mm	4.0 mm	3 mm	22 mm	ZC000367784
120	8 mm	D126	9 mm	5.5 mm	3 mm	22 mm	ZC000367792
120	8 mm	D91	9 mm	5.5 mm	3 mm	22 mm	ZC000367800
120	8 mm	D76	9 mm	5.5 mm	3 mm	22 mm	ZC000367818
120	10 mm	D91	11 mm	7.0 mm	3 mm	22 mm	ZC000367826
120	10 mm	D76	11 mm	7.0 mm	3 mm	22 mm	ZC000371257
120	12 mm	D91	13 mm	8.0 mm	3 mm	22 mm	ZC000367834
120	12 mm	D76	13 mm	8.0 mm	3 mm	22 mm	ZC000367842
120	15 mm	D91	16 mm	10 mm	3 mm	22 mm	ZC000367859
120	15 mm	D76	16 mm	10 mm	3 mm	22 mm	ZC000367867
120	19 mm	D91	21 mm	13 mm	3 mm	22 mm	ZC000367875
120	19 mm	D76	21 mm	13 mm	3 mm	22 mm	ZC000367883



## 3M™ Peripheral wheel **STAR TRACK C-shape**

Machines: Intermac, Bavelloni Alpa, Tecnometal, CMS, Denver, Bimatec (Bottero)...

Standard tool, Ø 100 mm, type 1J6YS with internal cooling and slots

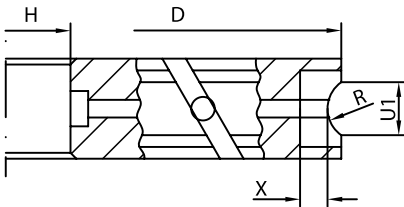


D	Glass	Grit	U1	R	X	H	3M ID
100	3 mm	D91	4 mm	2.2 mm	3 mm	22 mm	ZC000367891
100	3 mm	D64	4 mm	2.2 mm	3 mm	22 mm	ZC000367909
100	4 mm	D126	5 mm	2.8 mm	3 mm	22 mm	ZC000367917
100	4 mm	D91	5 mm	2.8 mm	3 mm	22 mm	ZC000367925
100	4 mm	D64	5 mm	2.8 mm	3 mm	22 mm	ZC000371265
100	5 mm	D126	6 mm	3.5 mm	3 mm	22 mm	ZC000367933
100	5 mm	D91	6 mm	3.5 mm	3 mm	22 mm	ZC000367941
100	5 mm	D64	6 mm	3.5 mm	3 mm	22 mm	ZC000367958
100	6 mm	D126	7 mm	4.0 mm	3 mm	22 mm	ZC000371273
100	6 mm	D91	7 mm	4.0 mm	3 mm	22 mm	ZC000367966
100	6 mm	D64	7 mm	4.0 mm	3 mm	22 mm	ZC000367974
100	8 mm	D126	9 mm	5.5 mm	3 mm	22 mm	ZC000367982
100	8 mm	D91	9 mm	5.5 mm	3 mm	22 mm	ZC000367990
100	8 mm	D76	9 mm	5.5 mm	3 mm	22 mm	ZC000368006
100	10 mm	D91	11 mm	7.0 mm	3 mm	22 mm	ZC000368014
100	10 mm	D76	11 mm	7.0 mm	3 mm	22 mm	ZC000368022
100	12 mm	D91	13 mm	8.0 mm	3 mm	22 mm	ZC000368030
100	12 mm	D76	13 mm	8.0 mm	3 mm	22 mm	ZC000368048
100	15 mm	D91	16 mm	10 mm	3 mm	22 mm	ZC000368055
100	15 mm	D76	16 mm	10 mm	3 mm	22 mm	ZC000368063
100	19 mm	D91	21 mm	13 mm	3 mm	22 mm	ZC000368071
100	19 mm	D76	21 mm	13 mm	3 mm	22 mm	ZC000368089

# 3M™ Diamond Tools for CNC Machines

## 3M™ Peripheral Wheels **STAR TRACK** C-shape

Machines: Intermac, Bavelloni Alpa, Tecnometal, CMS, Denver, Bimatec (Bottero)...

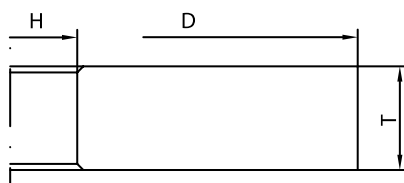


Standard tool, Ø 120 mm, type 1J6YS with internal cooling and slots

D	Glass	Grit	U1	R	X	H	3M ID
120	3 mm	D91	4 mm	2.2 mm	3 mm	22 mm	ZC000368097
120	3 mm	D64	4 mm	2.2 mm	3 mm	22 mm	ZC000368105
120	4 mm	D126	5 mm	2.8 mm	3 mm	22 mm	ZC000368113
120	4 mm	D91	5 mm	2.8 mm	3 mm	22 mm	ZC000368121
120	4 mm	D64	5 mm	2.8 mm	3 mm	22 mm	ZC000368139
120	5 mm	D126	6 mm	3.5 mm	3 mm	22 mm	ZC000368147
120	5 mm	D91	6 mm	3.5 mm	3 mm	22 mm	ZC000368154
120	5 mm	D64	6 mm	3.5 mm	3 mm	22 mm	ZC000368162
120	6 mm	D126	7 mm	4.0 mm	3 mm	22 mm	ZC000368170
120	6 mm	D91	7 mm	4.0 mm	3 mm	22 mm	ZC000368188
120	6 mm	D64	7 mm	4.0 mm	3 mm	22 mm	ZC000368196
120	8 mm	D126	9 mm	5.5 mm	3 mm	22 mm	ZC000368204
120	8 mm	D91	9 mm	5.5 mm	3 mm	22 mm	ZC000368212
120	8 mm	D76	9 mm	5.5 mm	3 mm	22 mm	ZC000368220
120	10 mm	D91	11 mm	7.0 mm	3 mm	22 mm	ZC000368238
120	10 mm	D76	11 mm	7.0 mm	3 mm	22 mm	ZC000368246
120	12 mm	D91	13 mm	8.0 mm	3 mm	22 mm	ZC000368253
120	12 mm	D76	13 mm	8.0 mm	3 mm	22 mm	ZC000368261
120	15 mm	D91	16 mm	10 mm	3 mm	22 mm	ZC000368279
120	15 mm	D76	16 mm	10 mm	3 mm	22 mm	ZC000368287
120	19 mm	D91	21 mm	13 mm	3 mm	22 mm	ZC000368295
120	19 mm	D76	21 mm	13 mm	3 mm	22 mm	ZC000368303

## 3M™ Peripheral Polishing Wheels **PB220**

Machines: Intermac, Bavelloni Alpa, Tecnometal, CMS, Denver, Bimatec (Bottero)...



Polishing Wheel, Ø 100 mm, PB220 Type 1A1

D	Glass	Grit	T	H	3M ID
100	3- 8 mm	FINE	10 mm	22 mm	ZC000368311
100	10+12 mm	FINE	15 mm	22 mm	ZC000368329
100	15 mm	FINE	20 mm	22 mm	ZC000368337
100	19 mm	FINE	25 mm	22 mm	ZC000368345
100	>19 mm	FINE	30 mm	22 mm	ZC000368352

Polishing Wheel, Ø 120 mm, PB220 Type 1A1

D	Glass	Grit	T	H	3M ID
120	3- 8 mm	FINE	10 mm	22 mm	ZC000368360
120	10+12 mm	FINE	15 mm	22 mm	ZC000368378
120	15 mm	FINE	20 mm	22 mm	ZC000368386
120	19 mm	FINE	25 mm	22 mm	ZC000368394
120	>19 mm	FINE	30 mm	22 mm	ZC000368402

# Operating Parameters 3M™ CNC Tools

## 1. 3M™ Segmented Routers **Silver**

1A1WS Ø mm	Operating Parameters	Glass thickness mm			
		6 / 8 / 10	12	15	19
8	RPM (1/min)	12,000			
	Feed rate (mm/min)	200-300	100-200	100-200	150
10	RPM (1/min)	12,000			
	Feed rate (mm/min)	200-300	100-200	100-200	150
12	RPM (1/min)	10,000-12,000			
	Feed rate (mm/min)	300-500	200-400	200-400	400
14	RPM (1/min)	10,000-12,000			
	Feed rate (mm/min)	500-700	400-600	300-500	400
16	RPM (1/min)	10,000-12,000			
	Feed rate (mm/min)	600-800	600-700	500-600	500
20	RPM (1/min)	9,000-11,000			
	Feed rate (mm/min)	800-1,000	700-900	500-700	700

## 2. 3M™ Segmented Grinding Wheels **Silver**

1A1S Glass-thickness mm	RPM 1/min	Removal mm	Feed rate m/min
4	5,000-6,000	1.0-2.0	3.0-3.5
5	5,000-6,000	1.0-2.0	3.0-3.5
6	5,000-6,000	1.0-2.0	3.0
8	5,000-6,000	1.0-2.0	3.0
10	5,000-6,000	1.0-2.0	2.5
12	5,000-6,000	1.0-2.0	2.5
15	5,000-6,000	1.0-2.0	2.0
19	5,000-6,000	1.0-2.0	2.0

## 3. 3M™ Peripheral Wheels **STAR TRACK Flat & Arris**

1DD6Y Glass-thickness mm	RPM 1/min	Removal mm	Feed rate m/min
4	5,000-6,000	0.3-0.5	6.0-8.0
5	5,000-6,000	0.3-0.5	6.0-7.0
6	5,000-6,000	0.3-0.5	6.0-7.0
8	5,000-6,000	0.3-0.5	5.0-6.0
10	5,000-6,000	0.3-0.5	4.0-5.0
12	5,000-6,000	0.3-0.5	3.0-4.0
15	5,000-6,000	0.3-0.5	2.0-3.0
19	5,000-6,000	0.3-0.5	2.0

## 4. 3M™ Peripheral Polishing Wheels **PB220**

1A1 Glass-thickness mm	RPM 1/min	Feed rate m/min
3-6	3,000-3,500	3.0-4.0
8-12	3,000-3,500	2.5-3.0
15-19	3,000-3,500	2.5

## 5. 3M™ Peripheral Wheels **STAR TRACK C-Shape**

1J6Y Glass thickness mm		RPM 1/min	Removal mm	Feed rate m/min
3	Roughing	5,000-6,000	0.5-0.7	4.0-6.0
	Fine-grinding		0.3-0.5	
4	Roughing	5,000-6,000	0.7-1.0	4.0-6.0
	Semi-finish grinding		0.5-0.7	
5	Fine-grinding	5,000-6,000	0.3-0.5	4.0-5.0
	Roughing		0.7-1.0	
6	Semi-finish grinding	5,000-6,000	0.5-0.7	4.0-5.0
	Fine-grinding		0.3-0.5	
8	Roughing	5,000-6,000	0.7-1.0	3.0-5.0
	Semi-finish grinding		0.5-0.7	
10	Fine-grinding	5,000-6,000	0.3-0.5	2.0-4.0
	Semi-finish grinding		0.5-0.7	
12	Fine-grinding	5,000-6,000	0.3-0.5	2.0-4.0
	Semi-finish grinding		0.5-0.7	
15	Fine-grinding	5,000-6,000	0.3-0.5	2.0-3.0
	Semi-finish grinding		0.5-0.7	
19	Fine-grinding	5,000-6,000	0.3-0.5	2.0-3.0
	Semi-finish grinding		0.5-0.7	

We are happy to help you to optimise your grinding process. Please contact our glass grinding experts.



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