



STELLA GRUPPE

German Precision Grinding Wheels

ROUGH GRINDING

Column and swing frame grinders

Manual grinders

Mounted points and nut inserted grinding cones



STELLA KERAMIK GmbH
Schwarzenbach/Saale

SCHMIRGELWERK CHEMNITZ GmbH
Chemnitz

CAPILLAR SCHLEIFKÖRPERWERK GmbH
Crosta / Bautzen



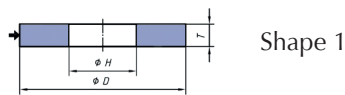
STELLA GRUPPE

German Precision Grinding Wheels

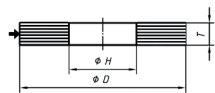
ROUGH GRINDING

Column and swing frame grinders

current shapes



Shape 1



Shape 1
fabric-reinforced

Speeds: 32 m/s, 50 m/s, 63 m/s, 80 m/s

Field of application

Specification of grinding wheels — Grinding robots and grinding manipulators

Universal use	Specification of grinding wheels — Grinding robots and grinding manipulators	
	for 63 m/s	for 80 m/s
Steel, steel casting (GS)	5A 14 P7 B	72/8A 16/00 R5 BF
Iron casting materials, grey cast iron, ductile graphite iron (GG, GGG)	61/8A 14/00 Qu8 B	72/8A 16/00 R5 BF
Chilled cast iron, malleable cast iron	20A 14 O7 B	

Machines

Column and swing frame grinders, grinding robots and grinding manipulators

Field of application

Specification of grinding wheels – Column grinders

Universal use	for 32 m/s	for 50 m/s	for 63 m/s	for 80 m/s
Steel, steel casting (GS)	1A 20/2 Qu5 V9 1A 36 P6 V9	5A 14/00 P5 B 61A 16/00 P5 B	61A 16/00 O5 B	61A 16/00 N5 BF
Steel, high-alloy hardened	21A 36 P6 V9			
Iron casting materials, grey cast iron, ductile graphite iron (GG, GGG)		61A 20/00 P8 B 62A 14/00 Qu5 B 61C 20/00 Qu5 B	61A 20/00 O6 B	61A 20/00 N5 BF
Chilled cast iron, malleable cast iron		5A 14/00 O8 B	20A 14/00 O7 B	5A 16/00 N5 BF
Non-ferrous metals (aluminium, copper, bronze)		61C 20/00 O8 B		

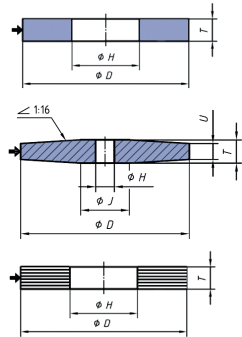
Field of application

Specification of grinding wheels – Swing frame grinders

Universal use	for 50 m/s	for 63 m/s	for 80 m/s
Steel, steel casting (GS)	5A 14/00 Qu5 B 61A 16/00 Qu5 B	61A 16/00 P5 B	61A 16/00 P5 BF
Iron casting materials, grey cast iron, ductile graphite iron (GG, GGG)	61A 16/00 Qu6 B	61A 20/00 Qu5 B	62A 20/00 P5 BF
Chilled cast iron, malleable cast iron	5A 14/00 P5 B	5A 16/00 P5 B	5A 16/00 O5 BF

Manual grinders

current shapes



Shape 1

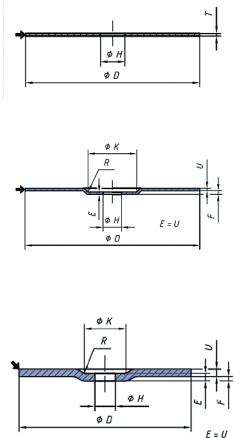
Shape 4

Shape 1 or 4
fabric-reinforced

Machines

Straight grinders,
e.g. Atlas Copco

current shapes



Shape 41

Shape 42

Shape 27

Machines

Angle grinders,
e.g. Atlas Copco
AEG
Bosch
Stihl

Speed: 50 m/s, 80 m/s

Field of application	Specification of grinding wheels	
	for 50 m/s	for 80 m/s
Universal use		
Steel, steel casting (GS)	1A 20/24 Qu5 B	1A 20/24 O5BF
Iron casting materials, grey cast iron, ductile graphite iron (GG, GGG)	1A 20/24 Qu5 B 61C 20/24 Qu5 B	1A 20/24 P5 BF
Chilled cast iron, malleable cast iron	1A 20/24 O5 B	1A 20/24 O5 BF
Non-ferrous metals (aluminium, copper, bronze)	61C 24/2 O5 B	

Speed: 80 m/s

Field of application	Specification of grinding wheels	
	Cut-off wheels	Snagging wheels
Universal use		
Steel, steel casting (GS)	1A 36 S3 BF-S-	1A 30 P4 BF-S-
Iron casting materials, grey cast iron, ductile graphite iron (GG, GGG)	1A 36 S3 BF-S-	1A 30 P4 BF-S- 61C 30 R6 BF-W-
Steel, stainless and acid proof (INOX)	21A 46 INOX BF-S- 21A 36 S BF-W-	21A 30 INOX BF-S-
Non-ferrous metals (aluminium, copper, bronze)	21A 46 Alu BF-W- 21A 36 Alu BF-W-	21A 36 Alu BF-W-
Stone, concrete	61C 36 S3 BF-S-	61C 30 R6 BF-W-





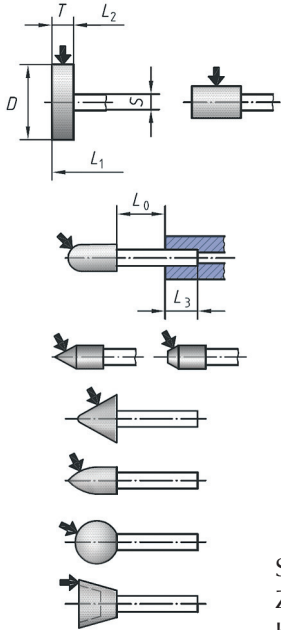
STELLA GRUPPE

German Precision Grinding Wheels

Mounted points and nut inserted grinding cones

current shapes

Speeds: up to 50 m/s



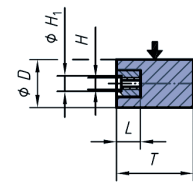
Shape 52
ZY, WR, WK,
KE, SP, KU, TO

Field of application

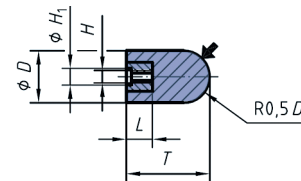
Specification of grinding tools

Universal use	Mounted points	Grinding cones
Steel, steel casting (GS)	21A 30/17 R4 V49 41A 30/2 P5 V49 43A 20/13 R5 B	20A 30 P8 B 8A 24 Qu5 B
Iron casting materials, grey cast iron, ductile graphite iron (GG, GGG)	41A 30/2 R4 V49 8A 20/2 R5 B 65C 24/11 Qu5 B	20A 20/2 O5 V49 8A 20/2 P5 B
Chilled cast iron, malleable cast iron	26A 30 Qu5 V49	61C 20/15 O5 B
Steel, stainless and acid-proof	21A 46 N6 V49 1A 24/7 S4 B	8A 24 Qu-R5 B

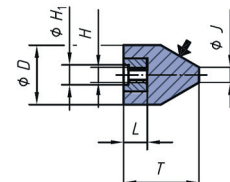
Machines: Straight grinders



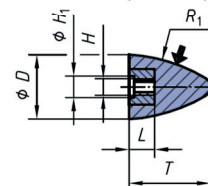
Shape 18



Shape 18R



Shape 16



Shape 19

Please observe the FEPA safety recommendations for the correct use of grinding tools.
www.fepa-abrasives.org

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