



STELLA GRUPPE

German Precision Grinding Wheels

SURFACE GRINDING

Peripheral grinding

Side grinding

Profile grinding



STELLA KERAMIK GmbH
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German Precision Grinding Wheels

SURFACE GRINDING

STELLA has experience in producing precision grinding wheels for more than 80 years. By means of special combinations of high-quality abrasive grain types, improved vitrified bonds and innovative manufacturing processes a new generation of conventional grinding tools has been designed: **STELLA select (STs)**.

In order to achieve optimal cutting features for surface grinding we use abrasive grain compositions of sintered aluminium oxide and special corundums (e.g. monocrystalline or ruby fused aluminium oxide). Highest porosity that is matched to the grinding task by its size and distribution abets the chip removal.

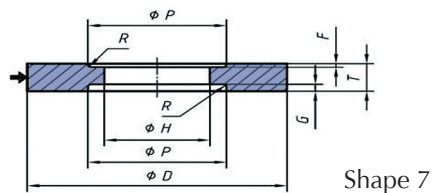
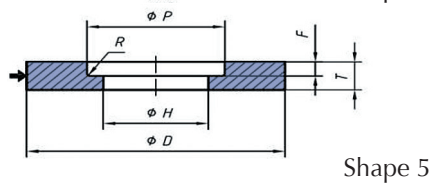
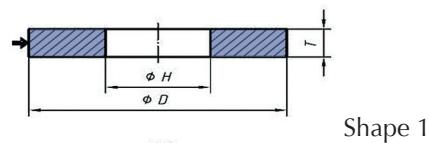
Special vitrified bonding systems which are adjusted to the particular grinding application by their elasticities, consistencies and their flowability ensure that the selected abrasive grains are integrated in an optimal way into the abrasive wheel's matrix.

What are the distinctive features of **STs** grinding wheels?

They do not have only a high and constant cutting efficiency but also a very good form retention in connection with an optimal and economic utilization of the abrasive grains. Due to expanded dressing cycles the grinding process times are shortened and the wheel's lifetime is extended. The cool cutting effect is an additional important advantage.

Peripheral grinding

current shapes



Speeds: 40 m/s, 50 m/s

Field of application

Specification of grinding wheels

Universal use	up to D 400 mm	larger than D 400 mm
Unhardened steel	40A 40 K12P03 V6	40A 40 Jot14P03 V6
Mild steel and low-alloy steel hardened	20A 46 Jot7 V8 20A 46 Jot12P2 VX12	20A 36 Jot7 V8 20A 36 H12P03 V8
High-alloy steel hardened	20A 46/2 H14P2 V6 20A 46 i12P2 VX12 92A 46 H14P2 V10	20A 36 G16P03 V10 92A 36 G16P03 V10
Steel, stainless and acid-proof	20A 46/2 G15 V6 20A 46/2 H14 V6	20A 36 G16P03 V10
Iron casting materials, e.g. GG, GGG	423A 46 i16P03/3 V24	423A 46 G16P03/3 V24
Non-ferrous metals (aluminium, copper, bronze)	60C SNS 463 V31	
Plastic materials, rubber	38A 16/5 i15 V6	

Machines of (e.g.):

aba z&b	Mägerle
Blohm	Mikromat
Elb	Reform
Geibel&Hotz	Rosa
Jakobsen	Okamoto
Jung	Waldrich
Junker	WMW
Logomatic	

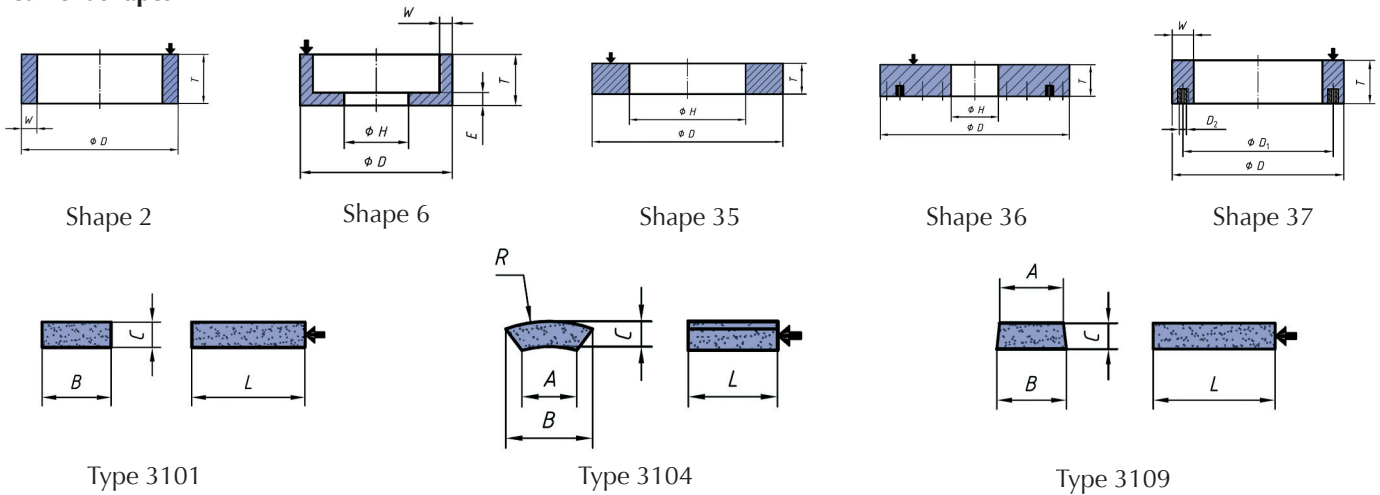
For special applications, e.g. surface grinding of guideways or of circular saw blades, we customize shape, dimension and specification to your individual operating conditions and requirements.





Side grinding

current shapes



Machines of (e.g.):

Diskus Reform
 Elb Sielemann
 Göckel WMW
 Kehren

For special applications, e.g. double face grinding, we customize shape, dimension and specification to your individual operating conditions and requirements.

Speeds: 32 m/s, 40 m/s

Field of application	Specification of grinding wheels		
Universal use	up to D 200 mm	larger than D 200 mm	Segments
Unhardened steel	21A 46 i7 V1 40A 40 K12P03 V55	40A 40 Jot12P03 V55	40A 36 i14P03 V55 92A 36 H15 V8KK3 40A 36 Jot16 BKK2/3
Mild steel and low-alloy steel hardened	20A 40 H7 V8 20A 46 H14P2 V6 92A 46 G16P2 V8	20A 46 G14P2 V6 92A 46 F16P2 V8	20A 36 G14P03 V55 92A 30/2 H16 V8KK3 20A 36 Jot16 BKK2/3
High-alloy steel hardened	20A 46 H16P2 V6 92A 46 G18P2 V8 20A 36 K-L14 BKK2	20A 36 F18P2 V6 92A 36 E18P2 V8 223A 36/7 Jot7 B	20A 36 F18P03/3 V6 92A 30/2 G18 V8KK3
Steel, stainless and acid-proof	253A 46 G16P03 V8	253A 46 E18P03 V8	253A 36 E18P03 V8
Iron casting materials, e.g. GG, GGG	20A 46 H14P03 V6	20A 46 G14P03 V6	43A 30/2 K16 V6KK3 92A 36 H13 V8KK3
Non-ferrous metals (aluminium, copper, bronze)	60C 46 G16P03 V30	60C 36 F18P03 V30	60C 30/2 F18P3 V30

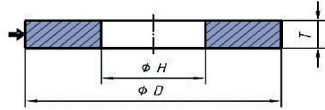


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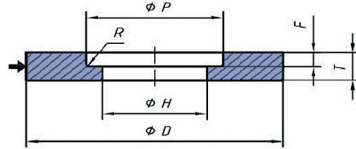
German Precision Grinding Wheels

Profile grinding

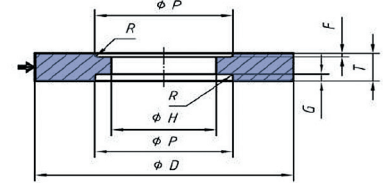
current shapes



Shape 1



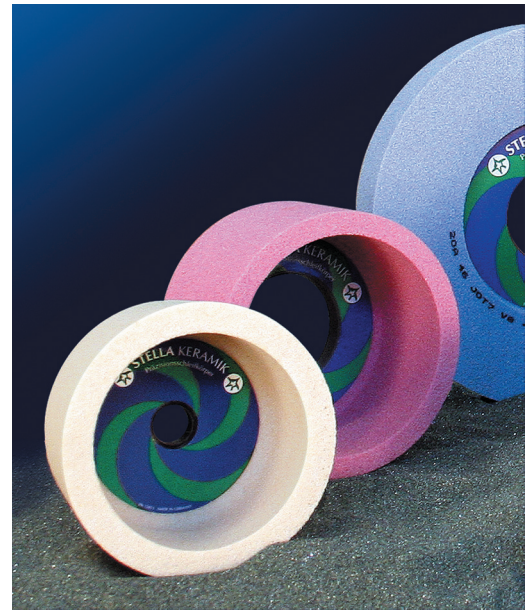
Shape 5



Shape 7

Machines of (e.g.):

aba z&b	Logomatic
Blohm	Mägerle
Elb	Rosa
Favretto	Oerlikon
Jung	Okamoto



For special applications, e.g. profile grinding of turbine blades, we customize shape, dimension and specification to your individual operating conditions and requirements.

Speeds: 40 m/s, 50 m/s

Field of application Specification of grinding wheels

Universal use	Reciprocating grinding		Creep-feed grinding	
	wide profiles	narrow profiles	wide profiles	narrow profiles
Unhardened steel	20A 80 i10P02 V55	20A 120 Jot10P1 V55	20A 60 H18P2 V6 92A 60 G-H18P2 V6	20A 120 G15P1 V6 92A 120 G15P1 V6
Mild steel and low-alloy steel hardened	20A 80 i12P2 V55 92A 80 i12P2 V10	20A 120 i12P1 V55 92A 120 i12P1 V10	20A 60 H20P2 V10 92A 60 H20P2 V10	20A 120 G18P1 V10 92A 120 G18P1 V10
High-alloy steel hardened	20A 80 H12P2 V55 92A 80 H12P2 V10	20A 120 H12P1 V55 92A 120 H12P1 V10	20A 60 G22P2 V10 92A 60 G22P2 V10	20A 120 F20P1 V10 92A 120 F20P1 V10

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

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