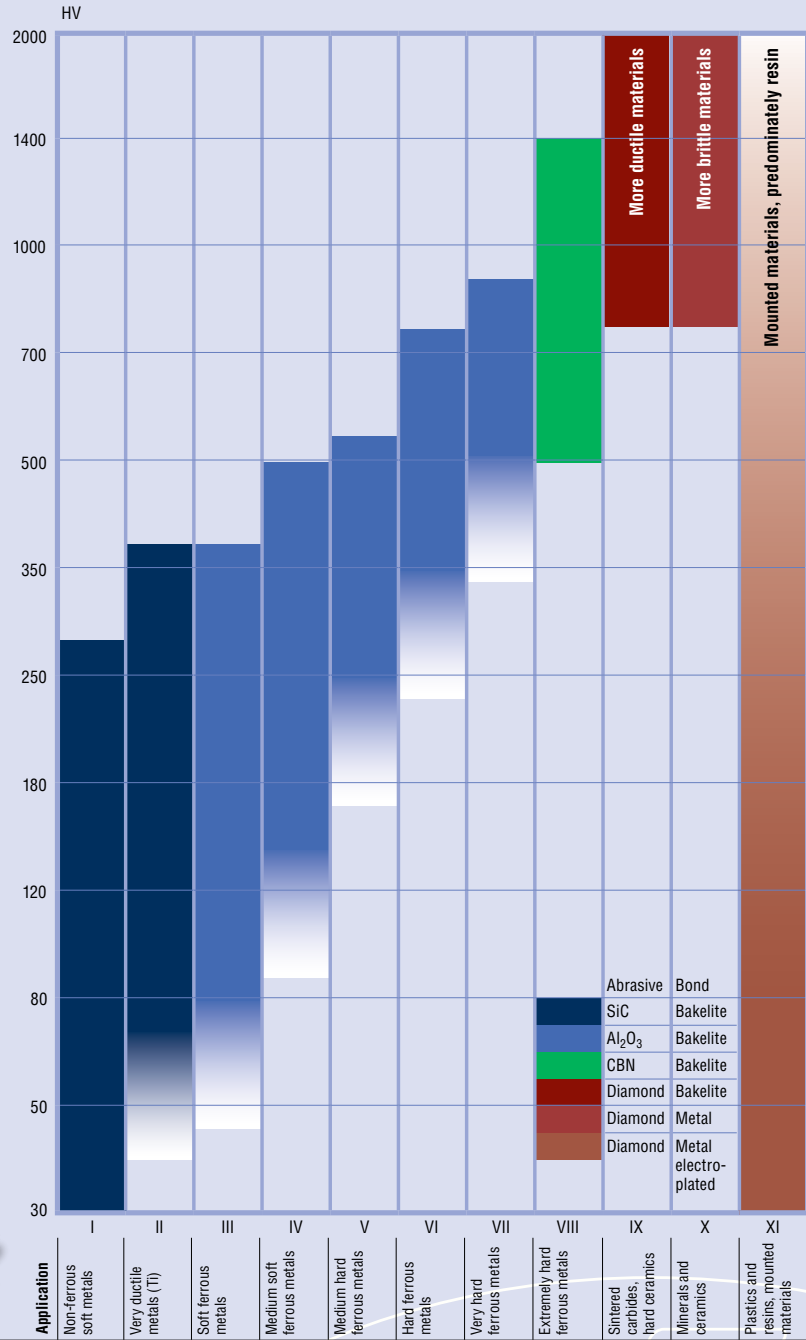


Select the correct cut-off wheel

- Go upwards on the y-axis of the overview to the right until you find the hardness value of your material.
- Move to the right, until you cross the cut-off wheel that fits your application. If you only have one material to cut, find the wheel where your material's hardness is placed as close to the middle as possible. For two or more materials, see if you can find a wheel that covers the whole hardness range. The bars that fade out at the bottom represent wheels that can be used for lower hardness also. However, this is not a very economical solution, and it should only be used in exceptional cases.
- Find the number (I-XI) of the respective wheel, and see the table below for the code of the correct wheel for your cut-off machine.



Cut-off machine	Std. wheel size* (mm)										
Magnutom-500	508 x 3.5 x 32										
Exotom-100/-150 Magnutom-400	432 x 3.0 x 32										
Axitom-5 (1,950 rpm)	350 x 2.5 x 32										
Labotom-15 (2,350 rpm)	350 x 2.5 x 32										
Exotom/Unitom-2/-5/-50 (2,775 rpm)	350 x 2.5 x 32										
Unitom/Discotom-50/-60/-65/-100	300 x 2.0 x 32										
Discotom-5/-6/-10/ Labotom-3/-5	250 x 1.5 x 32										
Discotom/Labotom	235 x 1.5 x 22										
Discoplan-TS	200 x 1.0 x 22										
1) 406 x 1.8 x 32 2) 350 x 1.5 x 32 3) 356 x 1.5 x 32 4) 305 x 1.8 x 32 5) 305 x 1.5 x 32 6) 350 x 1.8 x 32 7) Width = 1.3 8) Width = 1.1 9) Width = 0.8 10) Fibreglass reinforced 11) For hard and ductile materials, Ni-base alloys 12) 3D cut-off wheels 13) Width=0.6 14) Width=0.4 15) For sintered carbides in steel 16) Width=2.4 17) Width=3.2											
Precision cut-off machine	Std. wheel size* (mm)										
Secotom-1/-10/-15/-50**	200 x 0.8 x 22										
Accutom-10/-100/-5/-50	150 x 0.5 x 12.7										
Accutom-2	125 x 0.5 x 12.7										
Minitom	125 x 0.5 x 12.7										
Wheels with special sizes	100 x 0.3 x 12.7										
	75 x 0.15 x 12.7										
*) Diameter x Width x Bore in mm, **) On Secotom-1 only use MOD20 + B0D20											