



**DISCO**

Kiru · Kezuru · Migaku Technologies



# Metal Bond/Resin Bond Blades with Steel Core **A1A/K1A**SERIES

**Maximizes blade rigidity with an integrated steel core**



## **Steel Core Blades - High load, Deep Cut Processing**

DISCO has combined a steel core with metal bond blades and resin bond blades to attain high rigidity. As a result, when using multiple blades mounted on a slicer, deep cutting and high-load processing can be achieved. A wide variety of blade types are available for processing different applications.

- High rigidity is attained by combining a steel core with the blade
- Maximum outer diameter is 205 mm



## **A1A Series - Metal Bond**

### **High rigidity. Long Life**

The long life of the metal bond and the high rigidity of the steel core enables deep cutting of hard materials such as ceramics and ferrite.



Ceramics

### **Applications**

*Ceramics, Various types of glass, Ferrite, Quartz, Crystal, Metals, etc.*

## **K1A Series - Resin Bond**

### **High rigidity, Enhanced Quality**

The excellent cutting ability of the resin bond and the rigidity of the steel core allows cutting and grooving of glass and crystal materials.



Glass

### **Applications**

*Ceramics, Various types of glass, Ferrite, Quartz, Crystal, Metals, etc.*

## Processing Data

### Comparison of efficiency for bond types



## Metal Bond/Resin Bond Blades with Steel Core

# A1A/K1A SERIES



## Specifications

Type	Thickness accuracy <sup>*2</sup>	Bonding strength <sup>*2</sup>		Bond <sup>*2</sup>		O.D.	Thickness <sup>*5</sup>	I.D.	Angle
A Metalbond	1 Standard accuracy <sup>*3</sup> 9 ±0.010 2 ±0.005 3 ±0.002	400 L		50 MJ45		76.2	0.4	40	45°
K Resinbond	7 Standard accuracy <sup>*3</sup> 9 ±0.010 2 ±0.005								

<sup>\*1</sup> Products that include a special specification may be denoted with \*MAT/RAT-\*\*\*\*\*

<sup>\*2</sup> Regarding the combination of blades Internal code and bonding strength of each blade correspond to the bond type. Please refer to the chart below.

<sup>\*3</sup> Varies according to the blade.

<sup>\*4</sup> All slit widths are 0.5 mm (except for the SS type). The specification of standard slits varies according to the outer diameter of the blade. When placing orders, please refer to the chart above.

<sup>\*5</sup> Stated in blade thickness/substrate thickness only for the 1A1R shape. Example: 76.2 x 0.5 / 0.4 x 40

Basic shape	Internal code <sup>*2</sup>	Slit (Available for A1A Type only) <sup>*4</sup>						Grit type	Grit size	Concentration	
1A1		O.D.	76.2	100	125	150	200	SD Synthetic Diamond	80 #80	25	
1A1R			- 80	- 101.6	- 127	- 152.4	- 205	SDC Coated Synthetic Diamond	100 #100	50	
1E1		S1	No. of slits	8	8	16	16	16	150 #150	75	
1M1			Depth	7mm	10mm	12mm	15mm	15mm	B cBN	100	
1N1		S2	No. of slits	72	80	80	80	80	BC Coated cBN	180 #180	125
1V1			Depth	2mm	2mm	2mm	2mm	2mm			
		S3	Large slit	No. of slits	8	8	16	16			
			Depth	7mm	10mm	12mm	15mm	15mm			
			Small slit	No. of slits	64	64	64	64			
			Depth	2mm	2mm	2mm	2mm	2mm			
		SS	Optional								

Internal code	Bonding strength	Bond	Thickness accuracy
<b>Metal Bond</b>			
6	L	MJ45	1,2,3,9
		MJ35	
		MJ30	
		MJ25	
N	MJ15	2,7,9	
	MJ10		
<b>Resin Bond</b>			
6	N	BR10	2,7,9
		BR120	

### Standard specification range<sup>\*6</sup>

#### A1A Type (Metal Bond)

Thickness <sup>*7</sup>	0.3~	0.4~	0.5~	0.7~3.0
Grit size	#180~#800	#120~#800	#100~#800	#80~#800
O.D.	76.2,80	100,101.6	125,127	150,152.4
	200,205			

A1A1R is out of this standard specification range.

<sup>\*6</sup> Please contact a DISCO representative for details.

<sup>\*7</sup> \*Thickness\* means the thickness of diamonds' layer. (The thinnest steel core is 0.3 mm)

#### K1A Type (Resin Bond)

Thickness <sup>*7</sup>	0.3~	0.4~	0.5~	0.7~3.0
Grit size	#180~#320	#120~#320	#100~#320	#80~#320
O.D.	76.2,80	100,101.6	125,127	150
	180,203.2			

K1A1R is out of this standard specification range.

Available for K1A1R only.

<sup>\*6</sup> Please contact a DISCO representative for details.

<sup>\*7</sup> \*Thickness\* means the thickness of diamonds' layer. (The thinnest steel core is 0.3 mm)

### When ordering

Please contact a DISCO representative with your product needs such as type, thickness, outer and inner diameter, and quantity.

When you place the first order with us, please explain application information such as materials to cut or grind, sizes, shape, machine, type, and other specification.

We are ready to help you to determine which is our most appropriate product type for your application.

Due to improvements in our products, it is possible that product specifications may be changed without advanced notice. Please confirm the product specifications with a DISCO representative.

### To use these DISCO wheels safely...

Please read carefully and follow the instructions below to prevent any accidents or injuries.

- USE a safety cover (nozzle case, cover), equipped as a standard accessory, to avoid injury.
- DO NOT EXCEED the maximum rpm if it is specified.
- FOLLOW the instruction manual of the machine to mount wheel properly.
- DO NOT DROP OR HIT wheels. this may cause wheel breakage or injury.
- Always CHECK the wheel for chipping or any other wheel damage before starting to use the wheel. DO NOT USE the wheel if there is any damage.
- READ the operation manual of the cutting/ grinding equipment before use.
- DO NOT USE a wheel with a modified or customized equipment.
- DO NOT USE a wheel that has a different size from the one recommended for your machine.
- DO NOT USE a wheel for any other purpose than Grinding, Cutting, or Polishing.
- Always USE water or coolant to prevent wheel breakage.



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