

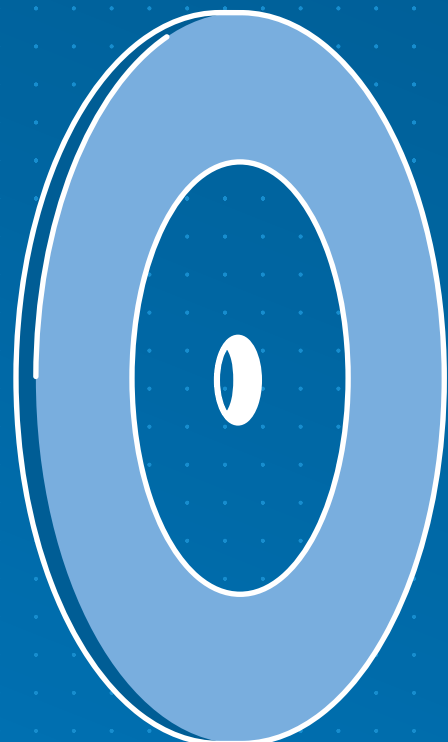
# Diamondtools

<b>206</b>	Technical Information
<b>207</b>	Qualities and application
<b>208</b>	Vacuum-Brazed Diamond cutting discs
<b>209</b>	Diamond cutting discs
<b>217</b>	Diamond cup wheels



## Product line marking

Product lines are labelled in the table header with the appropriate tabs. Further information on page **14** and **15**.



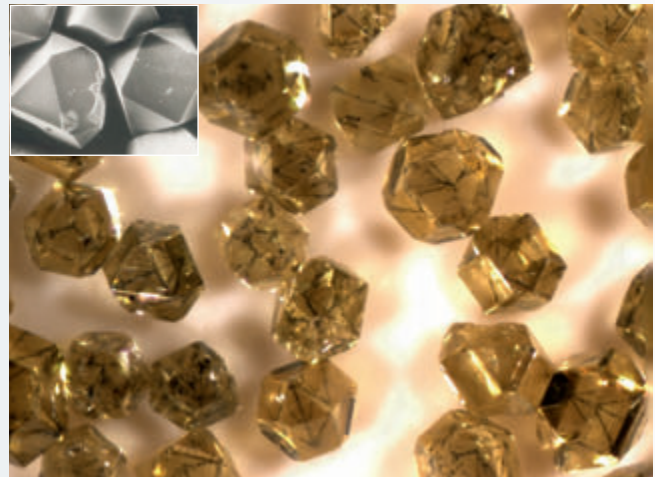
## Technical Information

### The Diamond

Diamonds are the hardest known material. They are selected depending on the field of application. For diamond blade manufacture synthetic diamonds are solely used. Compared to natural diamonds, their properties are reproducible and controllable. The following quality characteristics are significant for selecting diamonds:

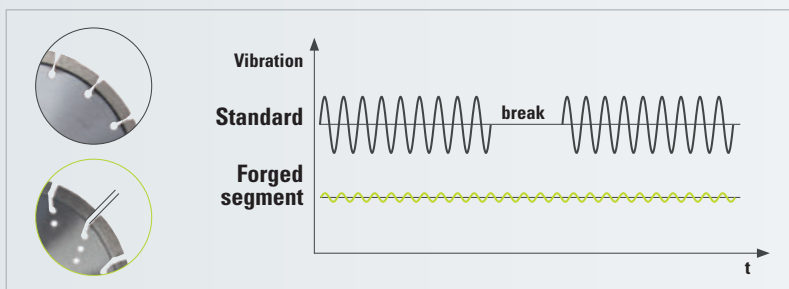
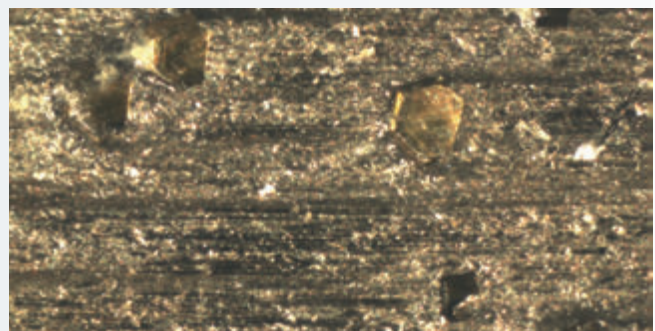
- degree of purity
- defined breaking strength
- sharp edges
- consistent geometry

Diamonds are classified by quality levels and grain sizes.

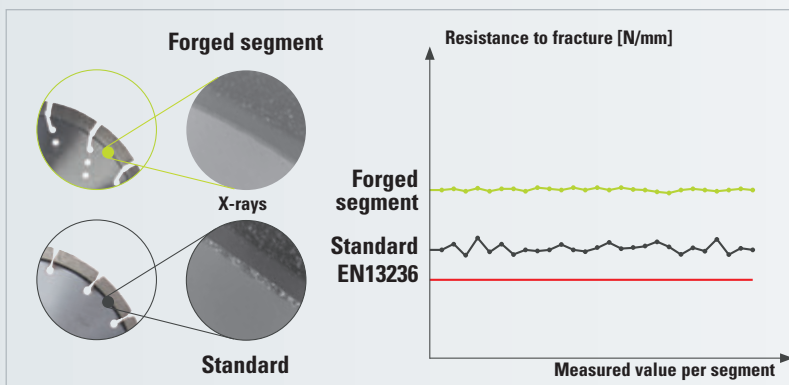


### The Segment

The segments consist of diamond embedded metal powder. The metal bond must be suited to the material to be cut. The metal powder consists, for example, of bronze, cobalt, iron, metal carbides, tungsten carbide. The various properties of metal powder provide for sharpness and wear and tear of the segment. Segment coating is carried out by sintering. Therefore, abrasive materials require a hard bond against what hard materials call for soft bond.



Comparison of cutting properties low vibration cutting discs with narrow gaps



Welding properties of forged segment: with highest safety against fracture

Due to the patented forged segment geometry even high segments can be arranged with small gaps in between. This produces considerably lower vibration for the user. Another essential advantage is safety. The dense segments have been forged without any pores. This ensures welding properties which provide much more safety against fracture compared to the usual sintered segments.

- Universal and fast – owing to new types of alloys in the segments
- Less vibration – owing to a trapezoid segment geometry
- More safety – owing to segment feet which are free of pores and provide for the utmost safety
- Against a fracture of the segment
- Longer life – owing to higher segments and retarded diamond shedding

## User instructions

Type	Catalogue page	Tiles			Granite, hard materials			Concrete			Construction material			Asphalt, abrasive materials			Grey iron		Segment height	
		Tiles	Fine stoneware	Granite tiles	Granite	Porphyry	Clinker bricks	Reinforced concrete	Exposed aggregate concrete	Concrete products	Bricks, masonry	Roof tiles	Gas concrete, pumice	Sand-lime brick	Refractory bricks	Screed	Asphalt	Fresh concrete		Grey iron
<b>Diamond cutting discs</b>																				
VDCM	208																			
VDC	209																			
LD MULTI S13	210																			13
LD 3 S13	211																			13
TURBO HP S12	211																			12
ABRASIV S13	217																			13
LD7 S13	217																			13
LD7 S10	218																			10
LD3 S10	212																			10
TURBO S10	212																			10
BLUE CUT plus S10	213																			10
BLUE CUT S10	215																			10
BC7	213																			7
BG-Laser	214																			7
TC7	214																			7
<b>Tile cutting discs</b>																				
FAST CUT S7	215																			7
FLIESE S7	216																			7
FC7	216																			7
<b>Diamond cup wheels</b>																				
DST HP S5	218																			5
DST S6	219																			6
DST S5	219																			5

**High Performance**
**High Performance**

- extremely quick cut, even through difficult materials
- Very good service life and designed for universal applications, for professional use

**Industry**
**Industry**

- quick cut and reliable
- long service life

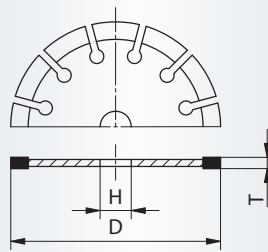
**Base**
**Base**

- price-conscious and good



### VDCM Multi, the exceptional cutting disc for nearly any workpiece

Ordering example: A34911152022



Packing unit:  
1 pc.  
 $v_{max}$ : 80 m/s

**VDC MULTI**  
Series

Description	D mm	T mm	H mm	n max. (1/min)	Product-Number	recommended for	
VDCM 115020	115	2,0	22,23	13.300	A34911152022	① 5 8 10 11 12	■
VDCM 125020	125	2,0	22,23	12.200	A34911252022	① 5 8 10 11 12	■
VDCM 180026	180	2,6	22,23	8.500	A34911802622	① 5 8 10 11 12	■
VDCM 230030	230	3,0	22,23	6.600	A34912303022	① 5 8 10 11 12	■

The segment coating made of carbide granulates prevents the disc from getting stuck in soft workpieces. The result is a clean cut.

#### Special properties:

- Low temperatures
- No dust and build-up of odours
- No expiry date
- No reduction in diameter

#### Ideal for cutting of

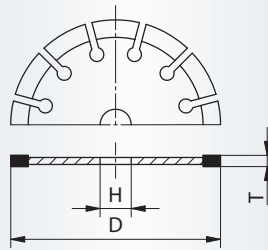
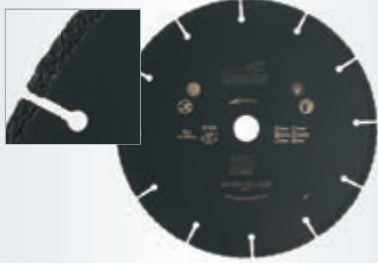
- Grey cast iron (GG, GGG)
- Glass-fibre reinforced plastic (GRP)
- Normal and red brass
- Steel
- Bricks
- Reinforced concrete
- Stone, tiles, wood



High Performance

## VDC, a revolution in the cutting of grey cast iron

Ordering example: A34901152222



Packing unit:  
1 pc.  
 $v_{max}$ : 80 m/s

**VDC**  
iSeries

Description	D mm	T mm	H mm	n max. (1/min)	Product-Number	recommended for	
VDC 115022	115	2,2	22,23	13.300	A34901152222	5	■
VDC 125022	125	2,2	22,23	12.200	A34901252222	5	■
VDC 180026	180	2,6	22,23	8.500	A34901802622	5	■
VDC 230030	230	3,0	22,23	6.600	A34902303022	5	■
VDC 350036	350	3,6	32,00	5.500	A34903503632	5	■

NEW

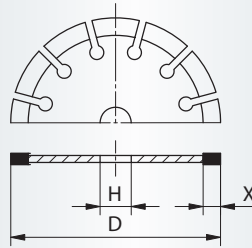
### Special properties:

- Low temperatures
- No dust and build-up of odours
- No expiry date
- No reduction in diameter

### Ideal for cutting of

- Grey cast iron (GG, GGG)
- Glass-fibre reinforced plastic (GFK)
- Normal and red brass

**LD Multi S13, the professional disc for granite, concrete and construction material** *Ordering example: A344031151213083*



**Packing unit:**

1 pc.

$v_{maks.}$ : 80 m/s

Ø 300, 350, 400 mm: 100m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PROMAX	LD Multi S13	115	13	22,23	13.300	A344031151213083	10 11 14	■
PROMAX	LD Multi S13	125	13	22,23	12.200	A344031251213093	10 11 14	■
PROMAX	LD Multi S13	150	13	22,23	10.200	A344031501213113	10 11 14	■
PROMAX	LD Multi S13	180	13	22,23	8.500	A344031801213133	10 11 14	■
PROMAX	LD Multi S13	230	13	22,23	6.600	A344032301213153	10 11 14	■
PROMAX	LD Multi S13	300	13	25,4	6.400	A344033002213183	10 11 14	■
PROMAX	LD Multi S13	350	13	25,4	5.500	A344033502213213	10 11 14	■
PROMAX	LD Multi S13	400	13	25,4	4.800	A344034002213243	10 11 14	■

**This diamond cutting disc excels in:**

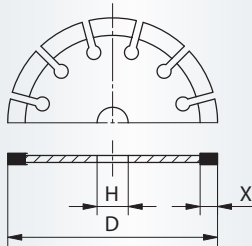
- Most universal properties along with optimum cutting speed
- Long life
- Extreme running smoothness
- Low vibration due to trapezoid segment geometry
- The production process for the segments in forging technology has been covered by patents

**Bonding method:** laser welded

**Note:** Cutting discs with 300 to 400 mm diameter are available on request with 30 mm bore. Please refer to the chart on page 207 for detailed information on applications.

**Turbo HP S12, with turbo segments, also suitable for reinforced concrete**

Ordering example: A344031151212093



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PROMAX	TURBO HP S12	115	12	22,23	13.300	A344031151212093	10 11 14	■
PROMAX	TURBO HP S12	125	12	22,23	12.200	A344031251212103	10 11 14	■
PROMAX	TURBO HP S12	150	12	22,23	10.200	A344031501212123	10 11 14	■
PROMAX	TURBO HP S12	180	12	22,23	8.500	A344031801212143	10 11 14	■
PROMAX	TURBO HP S12	230	12	22,23	6.600	A344032301212153	10 11 14	■

**This diamond cutting disc excels in:**

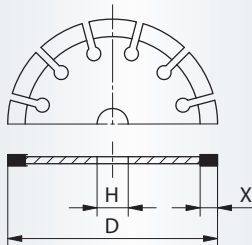
- A wide field of applications
- Long life
- Good cutting speed

**Bonding method:** laser welded

Please refer to the chart on page 207 for detailed information on applications.

**LD3 S13, for top performance in concrete and construction material**

Ordering example: A3440311517113038

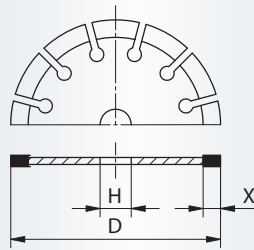
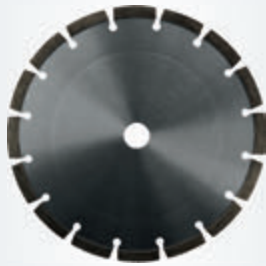


**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for		
PROMAX	LD3 S13	115	13	22,23	13.300	A344031151713083	10 11 14	■	NEW
PROMAX	LD3 S13	125	13	22,23	12.200	A344031251713093	10 11 14	■	NEW
PROMAX	LD3 S13	150	13	22,23	10.200	A344031501713113	10 11 14	■	NEW
PROMAX	LD3 S13	180	13	22,23	8.500	A344031801713133	10 11 14	■	NEW
PROMAX	LD3 S13	230	13	22,23	6.600	A344032301713153	10 11 14	■	NEW
PROMAX	LD3 S13	300	13	25,4	6.400	A344033002713183	10 11 14	■	NEW
PROMAX	LD3 S13	350	13	25,4	5.500	A344033502713213	10 11 14	■	NEW
PROMAX	LD3 S13	400	13	25,4	4.800	A344034002713243	10 11 14	■	NEW

## LD3 S10, for a high cutting rate in concrete and construction material

Ordering example: A344131151210083



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PREMIUMFLEX	LD3 S10	115	10	22,23	13.300	A344131151210083	⑩ ⑪	■
PREMIUMFLEX	LD3 S10	125	10	22,23	12.200	A344131251210093	⑩ ⑪	■
PREMIUMFLEX	LD3 S10	150	10	22,23	10.200	A344131501210113	⑩ ⑪	■
PREMIUMFLEX	LD3 S10	180	10	22,23	8.500	A344131801210143	⑩ ⑪	■
PREMIUMFLEX	LD3 S10	230	10	22,23	6.600	A344132301210163	⑩ ⑪	■

**This diamond cutting disc excels in:**

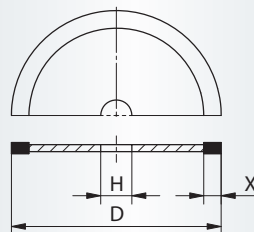
- Universal use in concrete/building material
- Excellent price-performance ratio

**Bonding method:** laser welded

Please refer to the chart on page 207 for detailed information on applications.

## Turbo S 10, the disc for the clear cut in building material or concrete

Ordering example: A344141151110013



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PREMIUMFLEX	TURBO S10	115	10	22,23	13.300	A344141151110013	⑩ ⑪	■
PREMIUMFLEX	TURBO S10	125	10	22,23	12.200	A344141251110013	⑩ ⑪	■
PREMIUMFLEX	TURBO S10	150	10	22,23	10.200	A344141501110013	⑩ ⑪	■
PREMIUMFLEX	TURBO S10	180	10	22,23	8.500	A344141801110013	⑩ ⑪	■
PREMIUMFLEX	TURBO S10	230	10	22,23	6.600	A344142301110013	⑩ ⑪	■

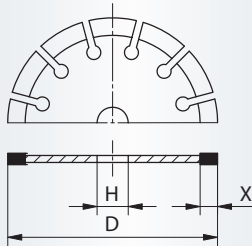
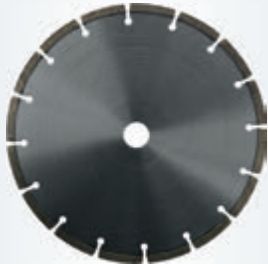
**This diamond cutting disc excels in:**

- Various applications
- Clear cuts

Please refer to the chart on page 207 for detailed information on applications.

**BLUE CUT plus S10, the universal disc for construction sites**

Ordering example: A344141151110093



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PREMIUMFLEX	BLUE CUT plus S10	115	10	22,23	13.300	A344141151110093	⑩ ⑪	■
PREMIUMFLEX	BLUE CUT plus S10	125	10	22,23	12.200	A344141251110093	⑩ ⑪	■
PREMIUMFLEX	BLUE CUT plus S10	180	10	22,23	8.500	A344141801110093	⑩ ⑪	■
PREMIUMFLEX	BLUE CUT plus S10	230	10	22,23	6.600	A344142301110093	⑩ ⑪	■

**This diamond cutting disc excels in:**

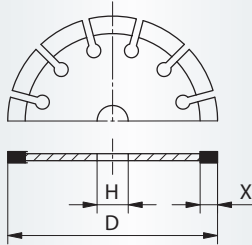
- An optimum price-performance ratio

Please refer to the chart on page 207 for detailed information on applications.



**BC7, the cost-effective disc for building and handicraft**

Ordering example: A345241151107085



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
BASE-X	BC7	115	7	22,23	13.300	A345241151107085	⑩	■ <b>NEW</b>
BASE-X	BC7	125	7	22,23	12.200	A345241251107095	⑩	■ <b>NEW</b>
BASE-X	BC7	230	7	22,23	6.600	A345242301107165	⑩	■ <b>NEW</b>

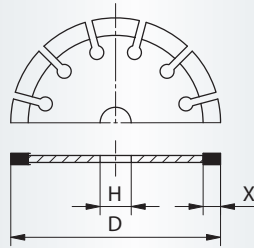
# 214 Diamond cutting discs

**ROTLUFF**

**Base**

## TC7, the cost-effective turbo disc for a clean cut

Ordering example: A345241151107775



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

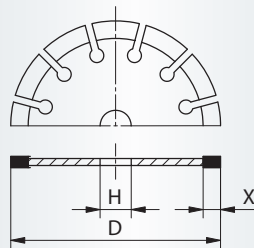
	Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
<b>NEW</b>	BASE-X	TC7	115	7	22,23	13.300	A345241151107775	10	■
<b>NEW</b>	BASE-X	TC7	125	7	22,23	12.200	A345241251107775	10	■
<b>NEW</b>	BASE-X	TC7	230	7	22,23	6.600	A345242301107775	10	■

**ROTLUFF**

**Base**

## BG-Laser, the price-conscious disc for granite and concrete

Ordering example: A345231251207105

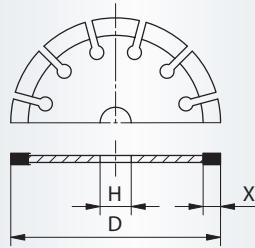


**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

	Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
<b>NEW</b>	BASE-X	BG-L	125	7	22,23	12.200	A345231251207105	11 14	■
<b>NEW</b>	BASE-X	BG-L	230	7	22,23	6.600	A345232301207165	11 14	■

**Blue Cut S10, the popular disc for construction sites**

Ordering example: A345231251207105

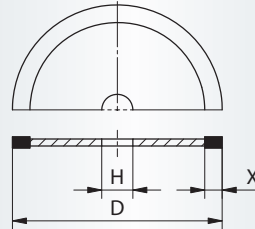


**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for				
BASE-X	Blue Cut S10	100	10	16,00	15.300	A345241001110075	⑩ ⑪			■	<b>NEW</b>
BASE-X	Blue Cut S10	115	10	22,23	13.300	A345241151110085	⑩ ⑪			■	<b>NEW</b>
BASE-X	Blue Cut S10	125	10	22,23	12.200	A345241251110095	⑩ ⑪			■	<b>NEW</b>
BASE-X	Blue Cut S10	150	10	22,23	10.200	A345241501110125	⑩ ⑪			■	<b>NEW</b>
BASE-X	Blue Cut S10	180	10	22,23	8.500	A345241801110145	⑩ ⑪			■	<b>NEW</b>
BASE-X	Blue Cut S10	230	10	22,23	6.600	A345242301110165	⑩ ⑪			■	<b>NEW</b>

**FAST CUT S7, the extra thin turbo cutting disc for ceramics and stoneware**

Ordering example: A344091151107013



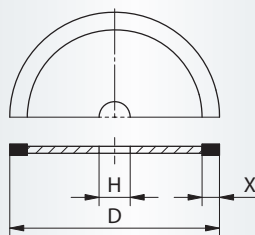
**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for			
PROMAX	FAST CUT S7	115	7	22,23	13.300	A344091151107013	⑩ ⑫ ⑭			■
PROMAX	FAST CUT S7	125	7	22,23	12.200	A344091251107013	⑩ ⑫ ⑭			■
PROMAX	FAST CUT S7	150	7	22,23	10.200	A344091501107013	⑩ ⑫ ⑭			■
PROMAX	FAST CUT S7	180	7	22,23	8.500	A344091801107013	⑩ ⑫ ⑭			■
PROMAX	FAST CUT S7	230	7	22,23	6.600	A344092301107013	⑩ ⑫ ⑭			■



## FLIESE S7, the popular cutting disc for tiles and ceramics

Ordering example: A34411151107013



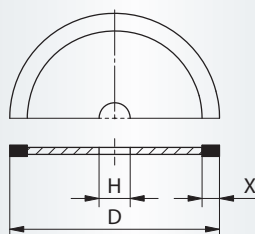
**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PREMIUMFLEX	FLIESE S7	115	7	22,23	13.300	A34411151107013	12	■
PREMIUMFLEX	FLIESE S7	125	7	22,23	12.200	A344111251107013	12	■
PREMIUMFLEX	FLIESE S7	150	7	22,23	10.200	A344111501107013	12	■
PREMIUMFLEX	FLIESE S7	180	7	22,23	8.500	A344111801107013	12	■
PREMIUMFLEX	FLIESE S7	230	7	22,23	6.600	A344112301107013	12	■



## FC7, the cost-effective tile cutting disc

Ordering example: A345211151107015

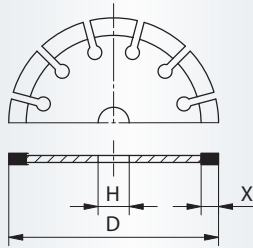


**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
<b>NEW</b> BASE-X	FC7	115	7	22,23	13.300	A345211151107015	12	■
<b>NEW</b> BASE-X	FC7	125	7	22,23	12.200	A345211251107015	12	■
<b>NEW</b> BASE-X	FC7	230	7	22,23	6.600	A345212301107015	12	■

**ABRASIV S13, the professional disc for fresh concrete and much more**

Ordering example: A344053002213203



**Packing unit:**

1 pc.

$v_{max}$ : 80 m/s

Ø 300, 350, 400 mm: 100m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PROMAX	ABRASIV S13	115	13	22,23	13.300	A344051151213083	10 11 15 16	■
PROMAX	ABRASIV S13	125	13	22,23	12.200	A344051251213093	10 11 15 16	■
PROMAX	ABRASIV S13	180	13	22,23	8.500	A344051801213133	10 11 15 16	■
PROMAX	ABRASIV S13	230	13	22,23	6.600	A344052301213163	10 11 15 16	■
PROMAX	ABRASIV S13	300	13	25,4	6.400	A344053002213203	10 11 15 16	■
PROMAX	ABRASIV S13	350	13	25,4	5.500	A344053502213243	10 11 15 16	■
PROMAX	ABRASIV S13	400	13	25,4	4.800	A344054002213283	10 11 15 16	■
PROMAX	ABRASIV S13	450	13	25,4	3.400	A344054502213253	10 11 15 16	■
PROMAX	ABRASIV S13	500	13	25,4	3.100	A344055002213303	10 11 15 16	■

**This diamond cutting disc excels in:**

- Very universal properties along with optimum life
- Extreme running smoothness
- Low vibration due to trapezoid segment geometry
- The production process for the segments in forging technology has been covered by patents

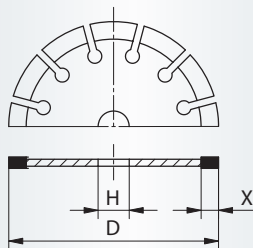
**Bonding method:** laser welded

**Note:** Cutting discs with 300 to 400 mm diameter are available on request with 20 mm bore.

Please refer to the chart on page 207 for detailed information on applications.

**LD7 S13, for top performance in asphalt**

Ordering example: A344073002213183



**Packing unit:**

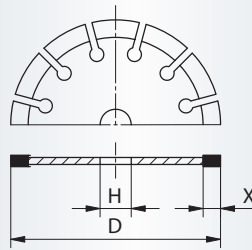
1 pc.

$v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for		
PROMAX	LD7 S13	300	10	22,23	5.100	A344073002213183	16	■	NEW
PROMAX	LD7 S13	350	10	22,23	4.400	A344073502213213	16	■	NEW
PROMAX	LD7 S13	400	10	22,23	3.800	A344074002213243	16	■	NEW
PROMAX	LD7 S13	450	10	22,23	3.900	A344074502213253	16	■	NEW
PROMAX	LD7 S13	500	10	22,23	3.100	A344075002213303	16	■	NEW

## LD7 S10 for a perfect cutting of asphalt

Ordering example: A344173002210183



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PREMIUMFLEX	LD7 S10	300	10	25,4	5.100	A344173002210183	15 16	■
PREMIUMFLEX	LD7 S10	350	10	25,4	4.400	A344173502210213	15 16	■
PREMIUMFLEX	LD7 S10	400	10	25,4	3.800	A344174002210243	15 16	■
PREMIUMFLEX	LD7 S10	450	10	25,4	3.400	A344174502210283	15 16	■
PREMIUMFLEX	LD7 S10	500	10	25,4	3.100	A344175002210303	15 16	■

**This diamond cutting disc excels in:**

- Especially shaped segments providing extreme running smoothness and core protection

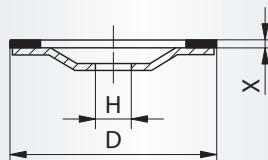
**Bonding method:** laser welded

**Note:** Cutting discs with 300 to 400 mm diameter are available on request with 20 mm bore.

Please refer to the chart on page 207 for detailed information on applications.

## DST HP S5 to meet the highest expectations for stock removal and smooth running

Ordering example: A344331001505083



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PROMAX	DST HP S5	100	5	22,23	15.300	A344331001505083	10 11 14 15	■
PROMAX	DST HP S5	125	5	22,23	12.200	A344331251505083	10 11 14 15	■
PROMAX	DST HP S5	180	5	22,23	8.500	A344331801505123	10 11 14 15	■

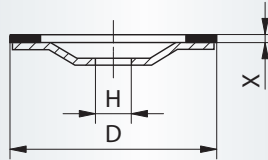
**This diamond cup wheel excels in:**

- High performance segments for maximum stock removal
- Universal segment alloy for concrete/granite
- Low vibration during working due to inductive welded segments (no imbalance in tool)
- Optimum suction at segment

Please refer to the chart on page 207 for detailed information on applications.

**DST S6, the cup wheel for universal application**

Ordering example: A344431251606183



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PREMIUMFLEX	DST S6	125	6	22,23	12.200	A344431251606183	10 11	■
PREMIUMFLEX	DST S6	180	6	22,23	8.500	A344431801606183	10 11	■

**This diamond cup wheel excels in:**

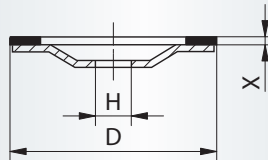
- Excellent price-performance ratio
- Optimum arrangement of segments for high grinding performance and clean surface

Please refer to the chart on page 207 for detailed information on applications.



**DST S5, the cost-effective cup wheel for numerous application**

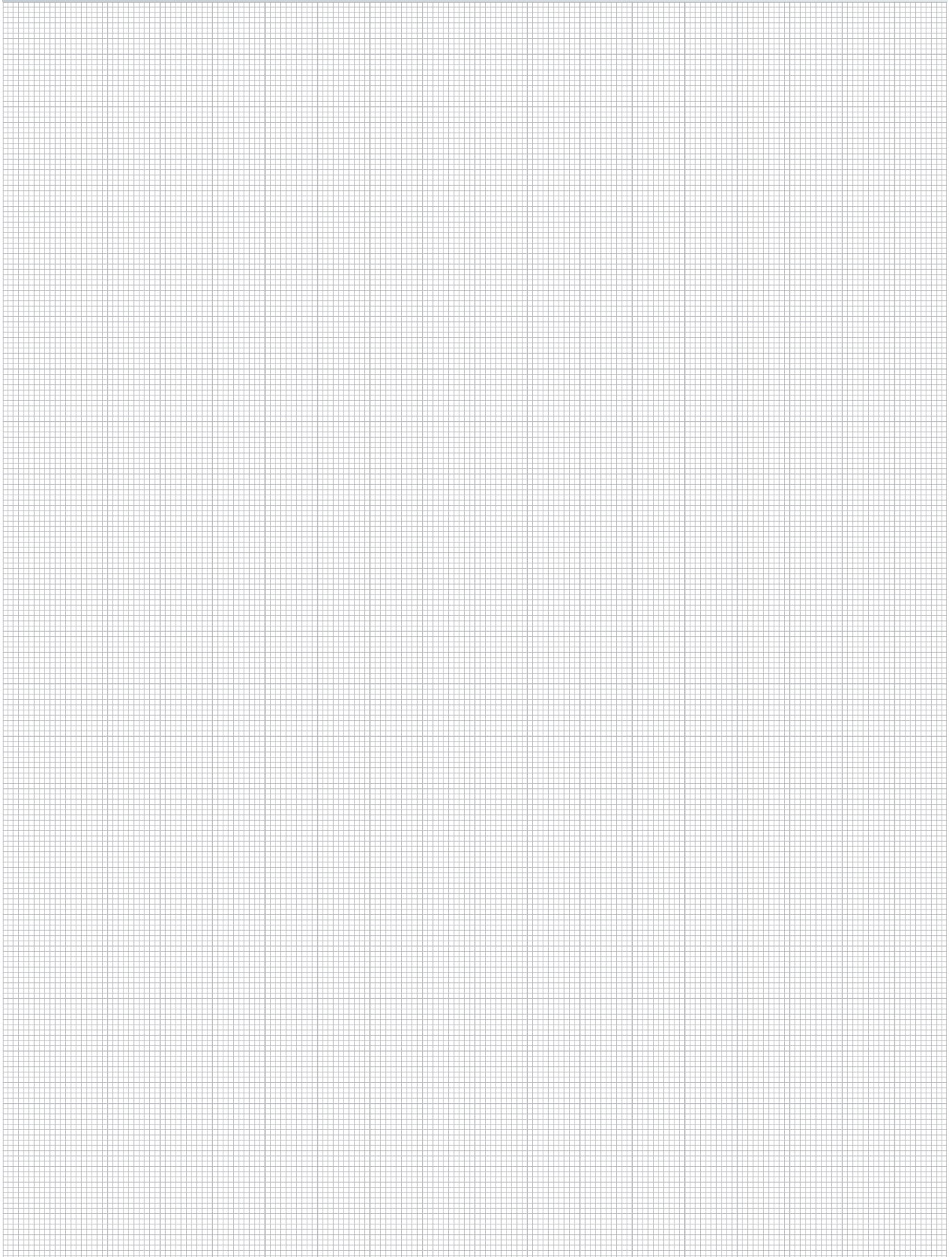
Ordering example: A345531151607185



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for		
BASE-X	DST S5	115	5	22,23	13.300	A345531151607185	10 11	■	<b>NEW</b>
BASE-X	DST S5	125	5	22,23	12.200	A345531251607185	10 11	■	<b>NEW</b>

Notes

A large rectangular area filled with a fine grid pattern, intended for taking notes. The grid is composed of small, uniform squares.