



Centerless external cylindrical grinding

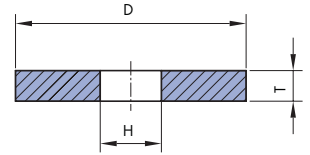
Grinding wheel F1

D x T x H

Flat grinding wheel



Order printout sample:
F1 300x50x127
11A54M5VL



D	T	H
250	to 150	51, 76, 100, 120
300	to 150	76, 127
350	to 150	76, 127, 151
400	to 150	127, 151, 203
450	to 150	127, 151, 203
500	to 150	203, 305
600	to 150	203, 305

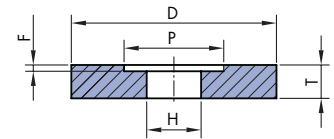
Grinding wheel F5

D x T x H - P x F

Flat, recessed on one side



Order printout sample:
F5 300x50x127-200x20
40A46K6VL



D	T	H	P	F
250	to 150	51, 76	130	F = max. T/2
300	to 150	76, 127	190	
350	to 150	76, 127	215	
400	to 150	127, 151, 203	230	
450	to 150	127, 151, 203	290	
500	to 150	203, 305	290	
600	to 150	203, 305	290	

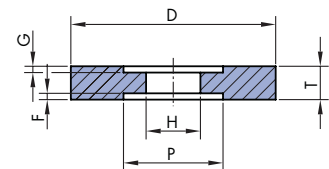
Grinding wheel F7

D x T x H - P x F / G

Flat, recessed on both sides



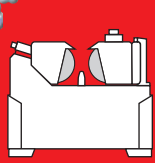
Order printout sample:
F7 300x50x127-100x15/10
22A46L6VL



D	T	H	P	F, G
250	to 150	51, 76	130	F+G = max. T/2
300	to 150	76, 127	190	
350	to 150	76, 127, 151	215	
400	to 150	127, 151, 203	230	
450	to 150	127, 151, 203	290	
500	to 150	203, 305	290	
600	to 150	203, 305	290	

Quality of grinding wheels for centerless external cylindrical grinding

04



Ground material		Quality
Steels 	Non-hardened steel Hardened up to 62 HRc Hardened over 62 HRc High-speed steels (HSS) Stainless steel	15A60M6B, 11A54M5VL, 11A100L7VL 47A60N6B, 22A46L6VL, 47A60N6B, 40A46K6VL, 22A100L7VL 47A60N6B, 82A46K6VL, 82A100K7VL 22A46K8VL, 22A100K8VL
Alloys 	Gray Nodular Steel	417A46M6B, 12A46M6VL, 12C100K7VL 417A46M6B, 41A46L6VL, 41A120K7VL 22A46L6VL
Non-metals 	Plastic materials Ferrites	90C60K7B, 90C46K7VL, 90C100J8VL 90C60K7VL, 90C100J8VL
Control wheels		A80T35B, 15A100R5B