

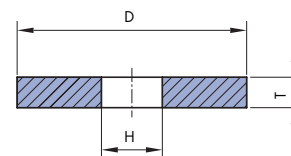


## Crankshaft and camshaft grinding

### Grinding wheel F1

D x T x H

Flat grinding wheel



Order printout sample:

F1 300x30x127

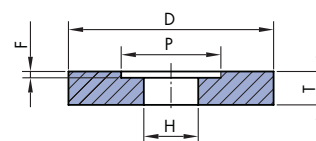
12A46K7VL

D	T	H
250	10 to 32	20, 25, 32, 40, 51, 76
300	13 to 50	32, 40, 51, 76, 127
350	16 to 50	32, 40, 51, 76, 127, 151
400	20 to 80	40, 51, 76, 127, 152.4, 203
450	20 to 80	76, 127, 152.4, 203
500	25 to 100	76, 127, 152.4, 203
600	32 to 100	152.4, 203, 305

### Grinding wheel F5

D x T x H - P x F

Flat, recessed on one side



Order printout sample:

F5 300x50x127-200x20

48A80I18VL

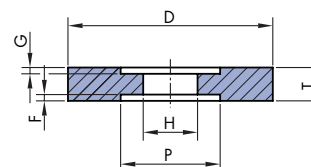
D	T	H	P	F
250	10 to 32	51, 76	130	
300	13 to 50	76, 127	190	
350	16 to 50	76, 127	215	
400	20 to 80	127, 152.4	230	
450	20 to 80	127, 152.4	290	
500	25 to 100	127, 152.4	290	
600	32 to 100	127, 152.4, 305	290	

F = max. T/2

### Grinding wheel F7

D x T x H - P x F / G

Flat, recessed on both sides



Order printout sample:

F7 300x50x127-100x15/10





3SA46K7VL

D	T	H	P	F,G
250	10 to 32	51, 76	130	
300	13 to 50	76, 127	190	
350	16 to 50	76, 127	215	
400	20 to 80	127, 152.4	230	
450	20 to 80	127, 152.4	290	
500	25 to 100	127, 152.4	290	
600	32 to 100	127, 152.4, 305	290	

F+G = max. T/2

# Quality of grinding wheels for crankshaft and camshaft grinding



Ground material		Quality
Camshafts - Cam grinding		
Steel alloy 	Rough grinding Finishing	22A46/3K7VL, 12A46K7VL, 4L8A80I6VW50L, 48A80H12/2SVL
Steel 	Rough grinding Finishing	22A46/3K7VL, 12A46K7VL, 4L8A80I6VW50L, 48A80I8VL
Camshafts - Bearing grinding		
Steel alloy 	Rough grinding Finishing	22A46/3K7VL, 12A46J7VL 3LA70G5VL, 48A80H12/2SVL
Steel 	Rough grinding Finishing	22A46K7VL, 12A46J7VL 3LA70G5VL, 48A80H12/2SVL
Crankshafts		
	Rough grinding Finishing	3SA46K7VL, 22A46K7VL 3SA80J8VL, 48A80J8VL

