



External cylindrical grinding

Grinding wheel F1

D x T x H

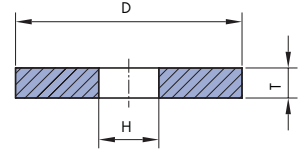
Flat grinding wheel



Order printout sample:

F1 300x30x127

3LA70G5VL



D	T	H
200	10 to 32	13, 16, 20, 25, 32, 40, 51
225	10 to 32	16, 20, 25, 32, 40, 50, 60
250	10 to 32	20, 25, 32, 40, 51, 76
300	10 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

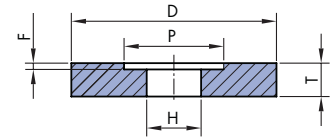
Flat, recessed on one side



Order printout sample:

F5 300x50x127-190x20

22A60I12/2SVL



D	T	H	P	F
200	20 to 40	25, 32, 40, 51	110	
225	20 to 40	25, 32, 40, 51	110	
250	20 to 40	40, 51, 76	130	
300	32 to 80	76, 127	190	
350	40 to 80	76, 127	215	
400	40 to 80	127, 152.4	230	
450	40 to 100	127, 152.4	290	
500	40 to 160	127, 152.4	290	
600	32 to 160	127, 152.4	290	

F = max. T/2

Grinding wheel F7

D x T x H - P x F / G

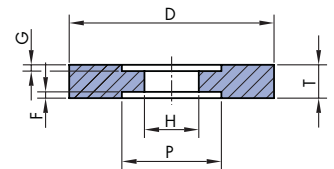
Flat, recessed on both sides



Order printout sample:

F7 300x50x127-190x15/10

23A46H14/2SVL



D	T	H	P	F,G
200	10 to 32	25, 32, 40, 51	110	
225	20 to 40	25, 32, 40, 51	110	
250	10 to 40	40, 51, 76	130	
300	13 to 80	76, 127	190	
350	16 to 80	76, 127	215	
400	20 to 80	127, 152.4	230	
450	20 to 100	127, 152.4, 203	290	
500	25 to 160	152.4, 203, 305	290	
600	32 to 160	152.4, 203, 305	290	

F+G = max. T/2

Quality of grinding wheels for external cylindrical grinding

03



Ground material		Quality
Steels 	Universal Non-hardened steel Hardened up to 62 HRc Hardened over 62 HRc High-speed steels (HSS) Stainless steels	3LA70G5VL 22A60I12/2SVL, 114A46L/M8B 3LA70H16/2SVL, 23A60H16/2SVL 03B91N5VC100, 82A60F18/2SVL 03B91N5VC100, 82A60F18/2SVL, 47A46M8B 22A46G18/2SVL, 47A46J8B
Hard metals 	Tungsten carbides	01D126P4VC100, 10C60I6VL
Alloys 	Gray Nodular Steel	10C46I6VL, 41A46K6B 90C46I6VL, 41A46K6B 12A36J7VL
Non-ferrous metals 	Al and alloys Cu and alloys	90C46G10/3SVWL, 54A60L5B 90C46G10/3SVWL, 22A30N6B, 50C100F10B
Non-metals 	Plastic materials Rubber	90C46H14/2SVWL 90C46G16/2SVWL, 22A40J8B