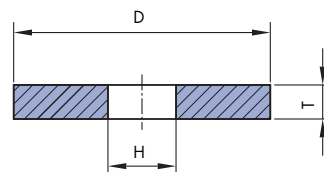




Manual grinding on stationary grinding machines

Grinding wheel F1

D x T x H
Flat grinding wheel

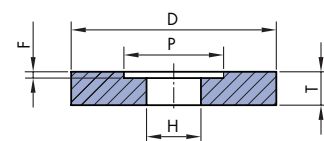


Order printout sample:
F1 300x30x127
10C60K6VL

D	T	H
125	10 to 25	22.7, 16, 20
150	10 to 25	16, 20, 25, 32
175	10 to 25	20, 25, 32
200	10 to 25	20, 25, 32, 40
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	127, 152.4, 203, 305

Grinding wheel F5

D x T x H - P x F
Flat, recessed on one side

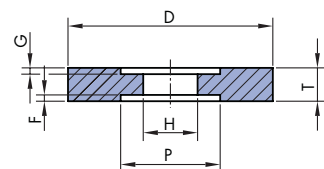


Order printout sample:
F5 300x50x127-190x20
23A60M7VL

D	T	H	P	F
200	10 to 25	20, 25, 32	110	
250	10 to 32	51, 76	130	
300	13 to 50	76, 127	190	F = max. T/2
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	290	

Grinding wheel F7

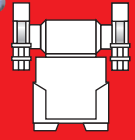
D x T x H - P x F / G
Flat, recessed on both sides









Order printout sample:
F7 300x50x127-190x15/10
10C60K6VL

D	T	H	P	F,G
200	20 to 40	20, 25, 32	110	
250	10 to 32	51, 76	130	
300	13 to 50	76, 127	190	F+G = max. T/2
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	290	

Quality of grinding wheels for manual grinding



Ground material		Quality	
		Coarse grinding	Finishing
Steels 	Non-alloyed	11A36P5VL	11A60M6VL
	Alloyed	22A46M5VL	22A60K6VL
	High-alloyed	40A60M7VL	40A60K6VL
Hard metals 	Tungsten carbides	10C60K6VL, 11A30P7VL	10C80K6VL
Alloys 	Gray Steel Nodular	90C46M6VL, 12A24P4VL 12A36M5VL 41A36L5VL	
Non-ferrous metals 	Al and alloys Cu and alloys	90C46K7VL 90C46K7VL	
Non-metals  	Plastic materials Ceramics	90C46J8VL 90C46J8VL	

