

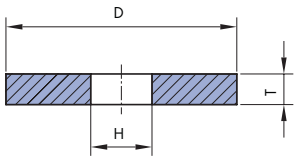


# Surface grinding with grinding wheel face

## Grinding wheel F1

D x T x H

Flat grinding wheel



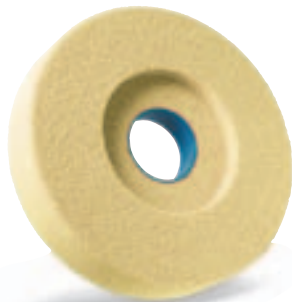
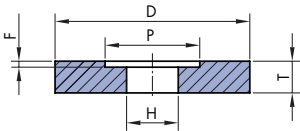
Order printout sample:  
F1 300x30x127  
82A46/3G16/3SV12L

D	T	H
100	10 to 32	10, 13, 16, 20, 25, 32
125	10 to 32	13, 16, 20, 25, 32, 40
150	10 to 32	13, 16, 20, 25, 32, 40
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 160	76, 127, 152.4, 203
600	32 to 160	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 300x50x127-200x20  
3LA60H16/2SV12L

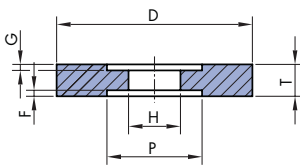
D	T	H	P	F
100	10 to 32	25, 32, 40	60	
125	10 to 32	25, 32, 40, 51	75	
150	25 to 32	25, 32, 40, 51	75	
200	25 to 32	25, 32, 40, 51	110	
225	20 to 40	25, 32, 40, 51	110	
250	20 to 40	40, 51, 76	130	
300	32 to 80	76, 127	190	
350	40 to 80	76, 127	215	
400	40 to 80	127, 152.4	230	
450	40 to 100	127, 152.4	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 300x50x127-100x15/10  
23A46H18/4VV12L

D	T	H	P	F,G
100	10 to 32	25, 32, 40	60	
125	10 to 32	25, 32, 40, 51	75	
150	10 to 32	25, 32, 40, 51	75	
200	10 to 40	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	25 to 160	152.4, 203, 305	290	

F+G = max. T/2

# Quality of grinding wheels for surface grinding with wheel face

01



Ground material		Quality
<b>Steels</b> 	Universal Non-hardened steel Hardened up to 62 HRc Hardened over 62 HRc High-speed steels (HSS) Stainless Nitriding	3LA60H1V6/2SV12L 3LA60H16/2SV12L , 12A46I14/2SV12L 3LA60H16/2SV12L , 23A46H18/4VV12L 03B126N14/1SVC75, 3SA46H18/3VV12L, 82A46/3G16/3SV12L 62A46G16/2SV12L, 82A46/3G16/2SV12L 22A46H18/4VV12L 10C46H14/2SV12L, 82A46I14/2SV12L
<b>Hard metals</b> 	Tungsten carbides	01D126N6VC75, 10C60J6VL
<b>Alloys</b> 	Gray Nodular Steel	90C46J6VL 90C46J6VL 12A46J7VL
<b>Non-ferrous metals</b> 	Al and alloys Cu and alloys	90C46G10/3SV16WL 90C46G10/3SV16WL
<b>Non-metals</b> 	Plastic materials Rubber	90C46G16 /2SVWL 90C46G16/2SVWL

