

Features:

- * Surfaces Grinding with straight or recessed wheels on machines with rotating or reciprocating table results in larger contact area than in cylindrical grinding. Therefore, it is necessary to use a softer grade wheels, particularly when large diameter and/or wide wheels are used.
- * When grinding a large number of components, the grinding is not continuous. In this case, the components tend to dress the wheel, so a harder grade wheel should be used.



Recommendations

Wheel Diameter (mm)		180 - 205		255 - 355		405 - 510	610
Material	Contact Area	Broad Contract	Narrow Contact Interrupted Cut	Broad Contract	Interrupted Cut	Standard	Standard
Soft Steel (Unhardened Steel)		WA46-K8V	WA46-K8V	WA46-J8V	WA46-K8V	WA36-K8V	WA36-K8V
		WA60-K8V	WA60-K8V	WA46-K8V	WA60-K8V	WA46-K8V	WA46-J8V
Alloy Steel (Hardened)		93A46-H10V	93A60-H9V	93A46-H10V	93A46-H8V	93A46-H10V	93A46-H12V
		3KG46-JV	3KG60-GV	3KG46-GV	3KG46-GV	5KG46-GV	5KG-46GV
High-Speed Steel (Hardened)		32A46-H12VP					
		93A46-H10V	93A60-H10V	93A46H-10V	93A46-H8V	93A46-H12VP	93A36-H12VP
		3KG46-IV	3KG60-IV	3KG46-GV	3KG46-GV	3KG46-G12VP	3KG46-G12VP
Stainless Steel	400 Series	WA46-G10V	WA46-J8V	WA46-G12V	WA46-G10V		WA36-G12VP
	300 Series	GC46-G12V	GC46-I10V	GC36-IQOV	GC46-H12VP		GC30-H12VP
Chromium-Plated Material		93A60-H10V		93A60-G12V		93A60-H10V	
		3KG60-G12V					
Cast Iron	Ordinary	C46-J6V	C46-J8V	C46-J6V		C36-I6V	C36H-12VP
	Special	GC46-J9V	C46-J6V	GC46-J9V		GC36-I10V	GC36-H12VP
Non-Ferrous Metals		C36-H6V	C46-H6V	C36-H6V		C36-H6V	C36-H6V
			C46-H6V				
Tungsten Carbide		GC90-H9V	-	-	-	-	-

Note:

* 3KG & 5KG are micro-crystalline abrasive, used primarily for precision grinding of difficult-to-grind steels and well defines cutting edges, a cool cut and excellent shape retention.