



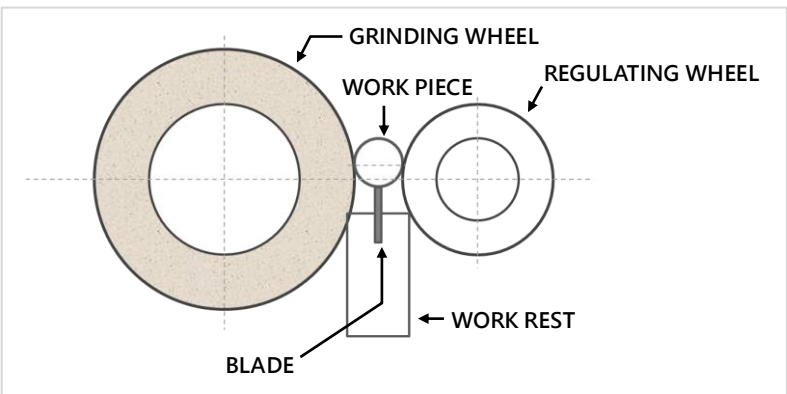
**VITRIFIED
 CENTERLESS
 GRINDING WHEELS**

Anchor Centerless Wheels are available in a range of specifications for high metal removal rates and optimum wheel life.

■ CENTERLESS GRINDING

CENTERLESS GRINDING METHOD

Centerless grinding differs from cylindrical grinding operations in that no spindle or fixture is used to locate and secure the work piece; the work piece is secured between a centerless grinding wheel and a regulating wheel. There are four forms of centerless grinding, differentiated primarily by the method used to feed the workpiece through the machine. (1) Through-feed grinding (2) In-feed grinding (3) End-feed grinding (4) In-feed and Through-feed mix grinding.



REGULATING WHEELS and MACHINE TYPE

Regulating wheels are always made by resin bond, the main function include:

- A. Control the feed rate and speed of work piece.
- B. Secure the work piece.
- C. Control the diameter of work piece.

Wheel and Regulating wheel size comparative table / Unit : mm

Grinding Wheel Size			Regulating Wheel Size		
Diameter	Thickness		Diameter	Thickness	
305	100	127 150	205	100	127 150
355	150	205	205	150	205
405	150	205 255	255	150	205 255
455	150	205 255 305	255	150	205 255 305
510	150	205 255 305	305	150	205 255 305
610	205	255 305	305	205	255 305

SPICIFICATION

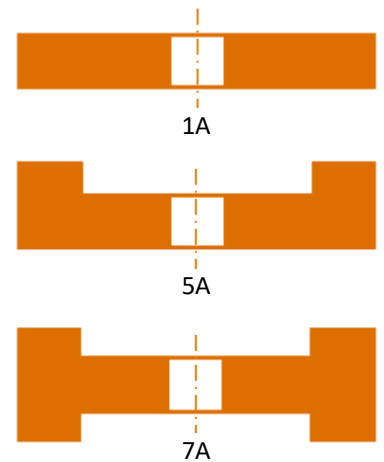
Standard size of centerless grinding wheel (unit : mm)

D	T							H
	75	100	127	150	205	255	305	
305	●	●	●	●	●			120.0 127
355				●	●			127.0 177.8 180.0
405				●	●			203.2 228.6
455				●	●	●	●	228.6 254.0
510				●	●	●	●	228.6 254.0 304.8
610					●	●	●	304.8

Standard size of regulating wheel (unit : mm)

D	T							H
	75	100	127	150	205	255	305	
255	●	●	●	●	●			90.0
305				●	●	●	●	111.2
355				●	●	●	●	127.0

■ The figure below shows the standard shape and face 1A, 5A and 7A of centerless wheel.



Standard specification of centerless and regulating wheel (unit : mm)

MATERIAL OF WORK PIECE	HARDNESS	SPECIFICATION				
S09CK · S45C · SK1~7	HRC<25	38A	60-80	L	5-7	V
	HRC>25	50A	60-80	L	5-7	V _{10W}
SMn · SCr · SCM · SNCM	HRC<55	50A	60-80	L	5-7	V _{10W}
	HRC>55	25A	60-80	K-L	5	V _{10W}
SKS · SKD · SKT	HRC<60	25A	60-80	K-L	5	V _{10W}
	HRC>60	32A	60-80	K-L	5	V _{10W}
SUS 400 series		32A	60-80	K-L	5	V _{10W}
SUS 300 series		GC	60-80	K	5	V
SUH 1&3		WA	60-80	L-N	5	V _{10W}
SUH 4		WA	60-80	L-N	5	V _{10W}
SKH		32A	60-80	K-L	5	V _{10W}
SUJ2 · SUJ3	HRC>60	25A	100	I J	4	VHB
FC	HRC<20	GC	60-80	K	5-7	V
FCMW · FCMB · FCMP	HRC<20	GC	60-80	K	5-7	V
Iron	HRC<20	A	60-80	K-M	5	V _{10W}
Chrome plated		25A	60-80	L-M	5	V _{10W}
Copper, aluminum, plastic, rubber and other materials		GC	60-80	K	5-7	V
Regulating wheel		A 120 R R · A 150 R R · A 180 R R				

■ For any further inquiry, please contact us via the company information below.

COMPANY INFORMATION

CARBO TZUJAN INDUSTRIAL CO., LTD.

- For details, please contact the following agency.

Anchor[®]

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- While using grinding wheels, it is essential that you observe correct procedures to protect yourself.