

**VITRIFIED  
 CYLINDRICAL  
 GRINDING WHEELS**

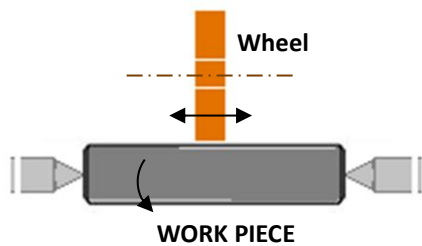
Cylindrical grinding wheels are used to grind the periphery of rigidly supported and rotating work-piece.

## Grinding method and wheel shape

Cylindrical grinding methods can be divided into:

### ■ Traverse Grinding

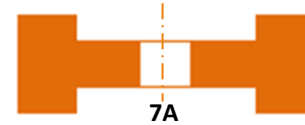
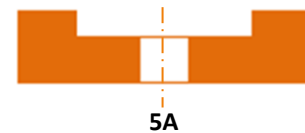
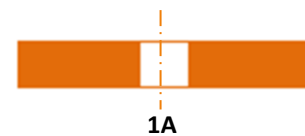
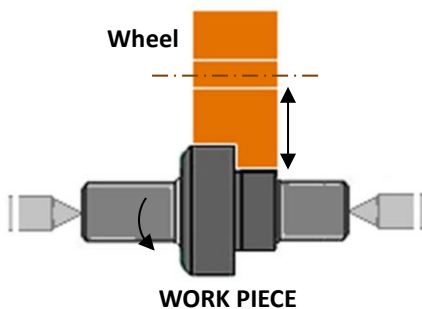
Traverse grinding operation is when the wheel is fed parallel to the surface being machined.



Regular shape of cylindrical grinding wheel include 1A, 5A, 7A and 20A shows below. Special shape and angle for angular grinding is also customized.

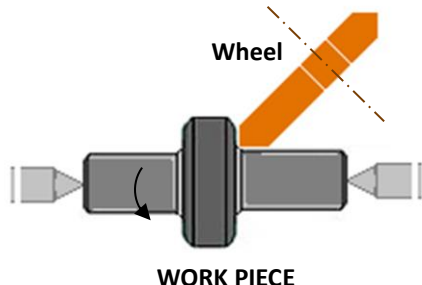
### ■ Plunge Grinding

Plunge grinding operation is when the wheel is fed perpendicular to the surface being machined.



### ■ Angular Grinding

Angular grinding is grinding the periphery and end face of work-piece simultaneously.



## Spec & Size

### ■ Regular specification of cylindrical grinding

Material of Work-piece	Hardness	Recommended Specification			
S09CK、S45C、SK1~7, etc	HRC<25	A	60-80	M	V <sub>10W</sub>
	HRC>25	38A	60-80	M	V
SMn、SCr、SCM、SNCM, etc	HRC<55	WA	60-80	L	V <sub>10W</sub>
	HRC>55	RA	60-80	L	V <sub>10W</sub>
SKS、SKD、SKT, etc	HRC<60	RA	60-80	K	V <sub>10W</sub>
	HRC>60	32A	60-80	J	V <sub>10W</sub>
SUS 400 series		WA	60-80	K	V <sub>10W</sub>
SUS 300 series		32A	60-80	H	V
SUH 1&3		WA	60-80	J	V <sub>10W</sub>
SUH 4		32A	60-80	H	V <sub>10W</sub>
SKH		32A 60-80 I V、GC 60-80 K V			
FC	HRC<20	GC	60-80	J	V
FCMW、FCMB、FCMP, etc	HRC<20	WA	60-80	I	V
Iron	HRC<20	38A 60-80 K V			
Copper, aluminum, plastic, rubber and other materials		GC/C 60-80 I V、GC/C 46-80 H V			

### ■ Regular wheel size of cylindrical grinding (unit : mm)

D	T											H			
	13	16	19	25	32	38	50	65	75	100	125				
255	●	●	●	●	●	●	●					50.8	76.2	101.6	127.0
305	●	●	●	●	●	●	●					50.8	76.2	101.6	127.0
355	●	●	●	●	●	●	●	●	●			76.2	101.6	127.0	152.4
405			●	●	●	●	●	●	●			127.0	152.4	203.2	
455			●	●	●	●	●	●	●			127.0	152.4	203.2	228.6
510			●	●	●	●	●	●	●	●		127.0	152.4	203.2	228.6
												254.0	304.8		
610				●	●	●	●	●	●	●		203.2	228.6	254.0	304.8
760				●	●	●	●	●	●	●	●	304.8			
810				●	●	●	●	●	●	●		304.8			
915					●	●	●	●	●	●	●	304.8			
1060						●	●	●	●			304.8	508.0		
1260						●	●	●	●			304.8	508.0		

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

## COMPANY INFORMATION

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