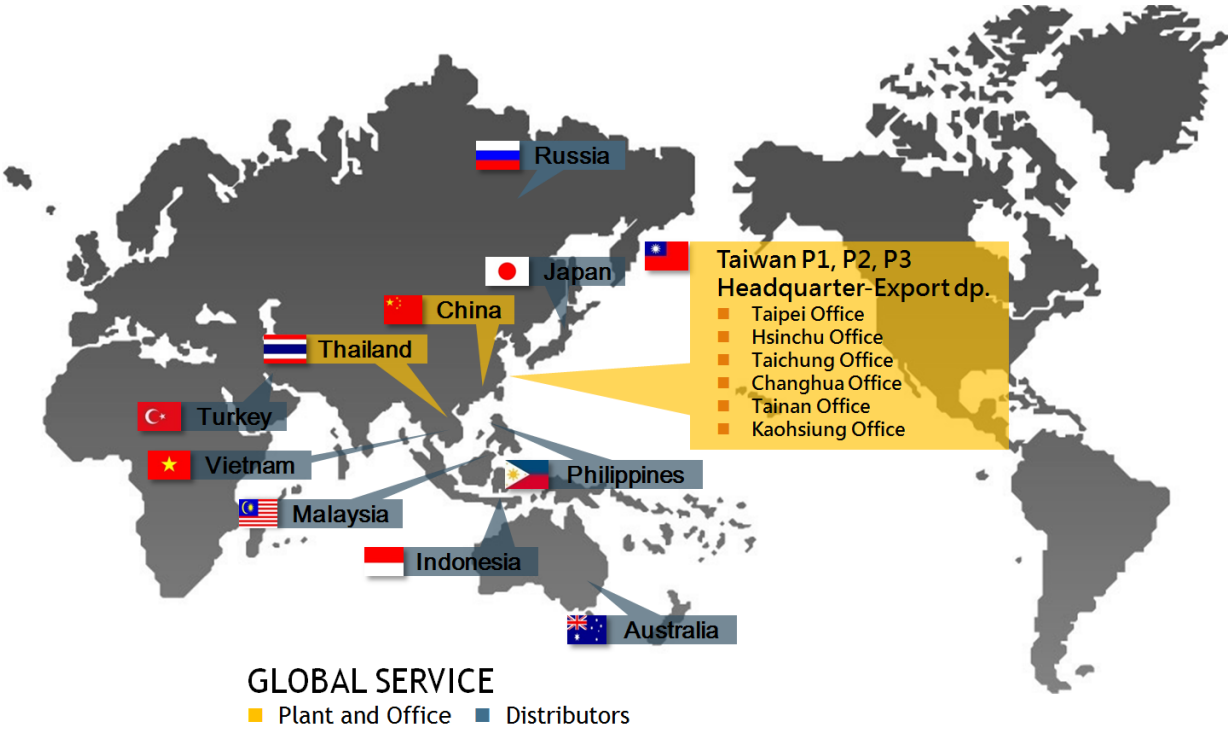
Anchor®

深化技術
先端應用

Fine Tech
New Apps

Grinding wheels for metal cutting tools

Global service



Grinding process for Drills and Mills

The grinding process of drills and mills includes the cutting of T/C steel bars, centerless grinding of the steel bars, fluting, edge grinding, Gash, OD/Relief and pinch peel grinding.

Process	Wheel type	Anchor Specification
Cut-off	Precision cutting wheel	BCW
Centerless Grind	Centerless and Control wheel	BCG
Flute	Fluting wheel	BMW HBMW MMW
OD/Relief、Gash	Clearance and face grinding wheel	BMW HBMW MMW

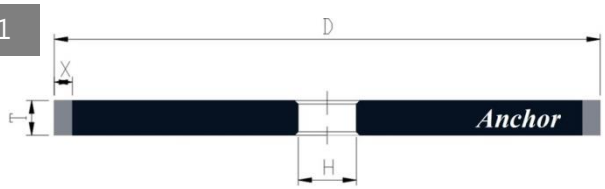
Standard marking of grinding wheel

Abrasive	Grit Size	Hardness	Concentration	Bond	Shape	Wheel size
SDC	120	N	100	BMW	1A1	D x T x H x X
SD SDC For T/C CBN For HSS	Coarse ↑ 80 100 120 140 170 200 230 325 500 600 800 1000 UP ↑ ↓ Fine	Soft ↑ N O P ↓ Hard	Low ↑ 75 100 125 150 ↓ High	BMW HBMW Resin Bond MMW Metal Bond	1A1 1V1 3A1 3V1 14A1 14V1 Flute 11A2 12A2 11V9 12V9 OD Gash 1A1R Cut-off 1A1 9A1 Centerless	75 100 125 150 Diameter / mm 3 – 16 Thickness / mm

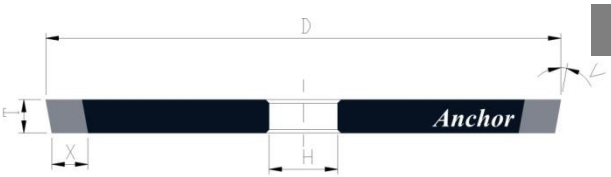
■ Other sizes can also be customized. For details, please refer to the official website for diamond grinding wheel size and shape markings. ◦

Regular shape of metal cutting tool grinding wheels

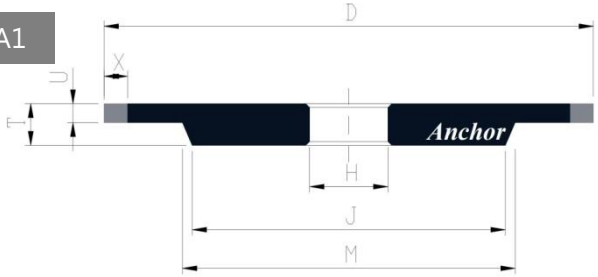
1A1



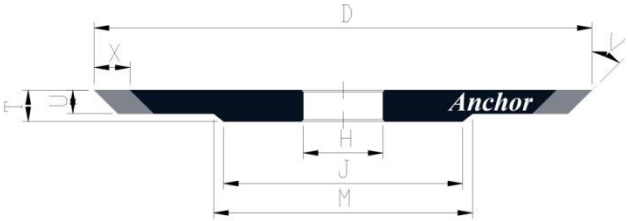
1V1



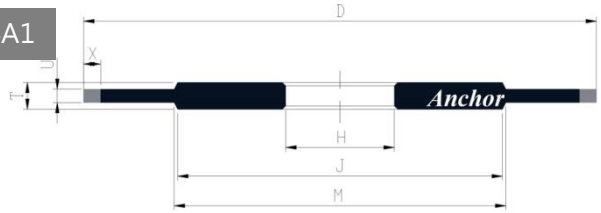
3A1



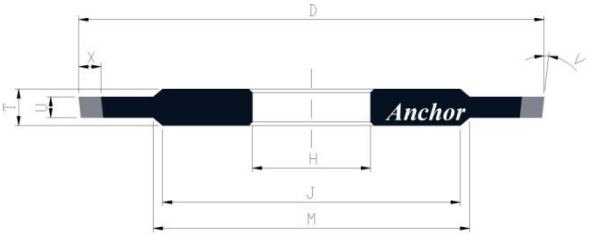
3V1



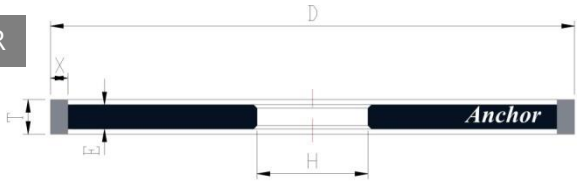
14A1



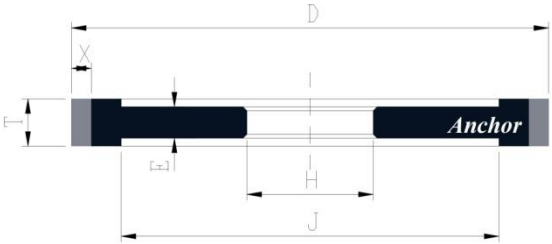
14V1



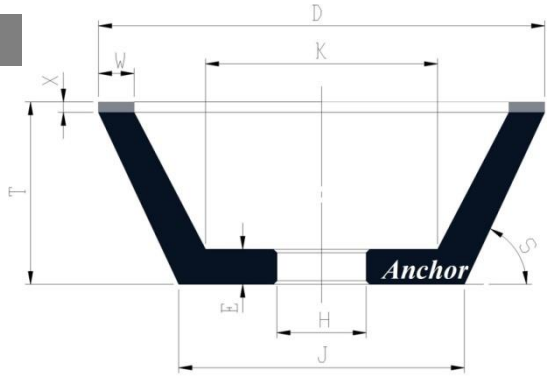
1A1R



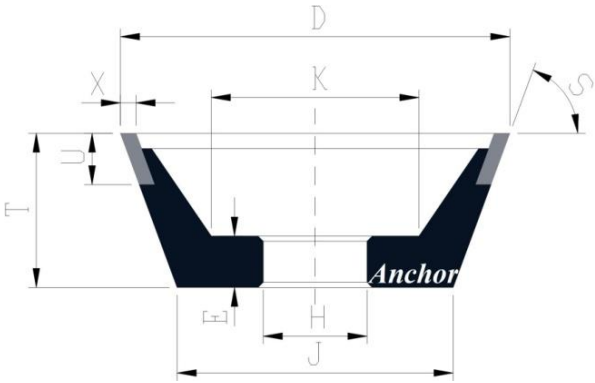
9A1



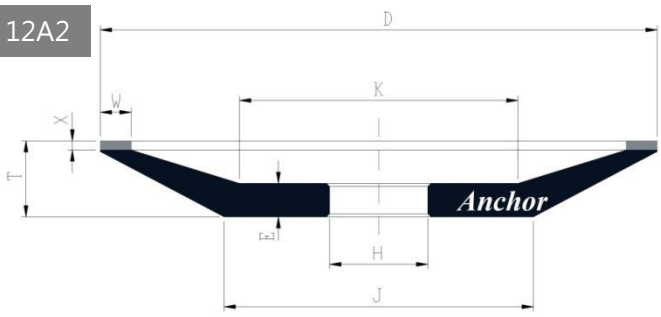
11A2



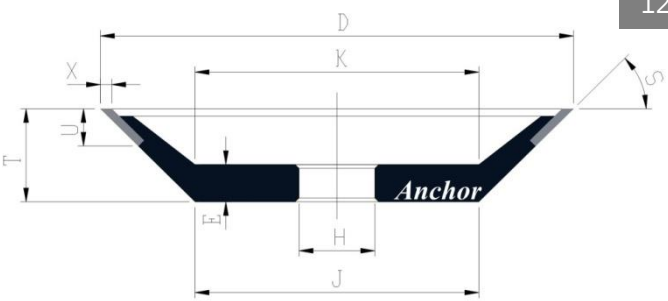
11V9



12A2



12V9



Diamond precision cutting wheel is applied on T/C bars cutting, a new Anchor specification of BCW shows excellent cutting ability and life time. CBN could be used to cut ferrous materials.

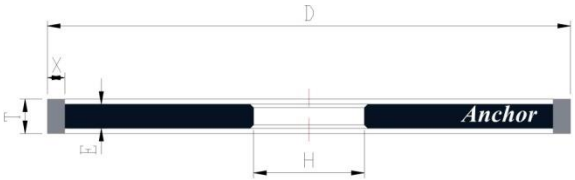
Steel bar cutting

Product Characteristics :

1. Excellent cutting ability
2. Long life time
3. High precision

Standard specification and size

1A1R



Specification	D	T	H	E	X
● SDC120P125BCW1A1R	153	0.8	19.05 / 31.75	0.6	7.5
● SDC120P125BCW1A1R	153	1	19.05 / 31.75	0.8	7.5
● SDC120P125BCW1A1R	153	1.2	19.05 / 31.75	1	7.5
SDC120N125BCW1A1R	158	0.8	19.05 / 31.75	0.7	10
SDC120N125BCW1A1R	158	1	19.05 / 31.75	0.8	10
SDC120N125BCW1A1R	158	1.2	19.05 / 31.75	1	10
SDC120R125BCW1A1R	180	0.8	19.05 / 31.75	0.6	6
SDC120R125BCW1A1R	180	1	19.05 / 31.75	0.8	6
SDC120R125BCW1A1R	180	1.2	19.05 / 31.75	1	6
SDC120N100BCW1A1R	200	0.8	19.05 / 31.75	0.6	6
SDC120N100BCW1A1R	200	1	19.05 / 31.75	0.8	6
SDC120N100BCW1A1R	200	1.2	19.05 / 31.75	1	6

● In stock ◦

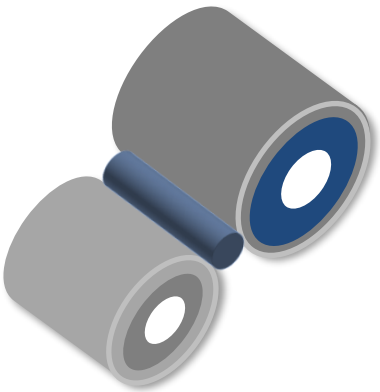
Unit : mm

■ There are also dry cutting specs and CBN specs for HSS cutting. Other specifications and sizes can also be customized.

■ The thickness could reach 0.4mm with a steel core, 0.2mm without a steel core.

Diamond, CBN Centerless grinding wheel

Used for grinding the diameter of cutting tools, Anchor centerless grinding wheels can be customized in various size according to the type and brand of machine. The design of integrated coarse and fine grinding helps customers reduce grinding costs and improve production efficiency.



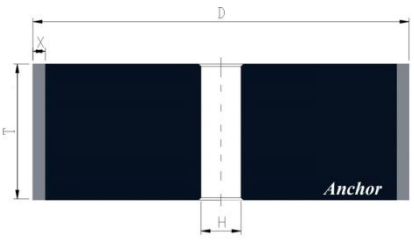
Centerless grinding

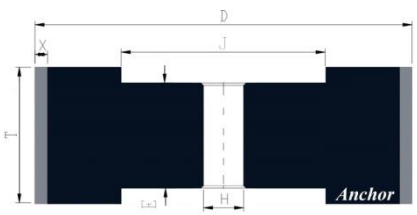
Product Characteristics：

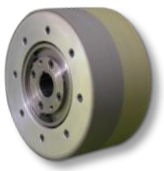
1. High precision and cutting ability
2. Customize for various brands of machine
3. Use with rubber bond control wheels

Standard specification and size

1A1 、 9A1





	Specification	D	T	H	X
	SDC100N100BCG1A1	300	100	120	5, 10
	SDC140N100BCG9A1	300	150	120	5, 10
	SDC600N100BCG9A1	300	150	120	5, 10
	SDC80N100BCG9A1	450	205	228.6	5, 10
	SDC1000N100BCG9A1	450	205	228.6	5, 10
	CBN80/400N100BCG1A1	300	100	120	5, 10
	CBN140/400V100BCG9A1	400	205	228.6	5, 10
	CBN100/170V100BCG9A1	450	205	228.6	5, 10
	CBN100/170V100BCG9A1	500	205	304.8	5, 10

- SDC is suit for tungsten carbide bars (T/C) 、CBN is suit for HSS bars.

Unit : mm

- Other specifications and sizes can also be customized.

Case study

	Grit size for rough and finish grinding	
Rough grinding	#100	
Finishing	#325	
Polishing	#1000 and up	Successfully reaching Ra0.027um in polishing case.

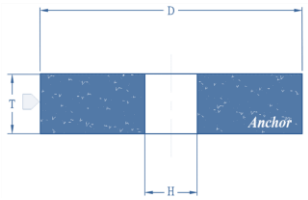
Rubber bond control wheel

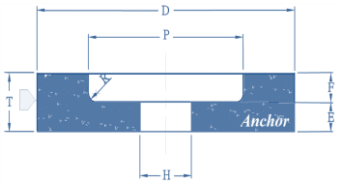
The main functions of control wheels are:

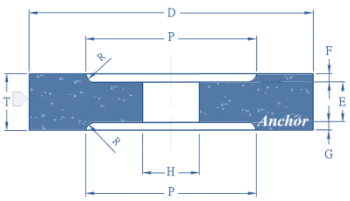
1. Control the rotation speed and feed speed of the workpiece
2. Provide support for workpiece during grinding operations
3. Control the diameter of the workpiece

Standard specification and size

1A、5A、7A







	Specification	D	T	H	P	E	F	G
	A150R0R1A	205	150	90	-	-	-	-
	A150R0R1A	255	205	111.2	-	-	-	-
	A150R0R5A	255	150	111.2	170	100	-	-
	A150R0R7A	305	205	127	200	110	75	20
	A150R0R7A	305	205	177.8	210	155	25	25

■ Other specifications and sizes can also be customized.

Unit : mm

Size recommend of centerless and control wheel

Wheel diameter	Wheel thickness	Regulator diameter	Regulator thickness
300	100 150	205	100 150
350	150 205	205	150 205
400	150 205	255	150 205
450	150 205	255	150 205
500	150 205	305	150 205

Unit : mm

Vitrified dressing tools

“Truing" - after the grinding wheel is installed, the special shape and angle required to be grind or the acentiric and deformed wheel need to be smoothed to be concentric with the grinding wheel spindle, , as shown in Figure 1 below.

"Dressing" - When the surface of the grinding wheel is quite smooth and the abrasive grains are not protruding enough. This situation of grinding will burn the workpiece or cause slippage. Therefore, the smooth surface of the grinding wheel must be dressed, that is, the bond, iron filings, etc. surrounding the abrasive must be removed so that the sharp angle of the abrasive can completely expose, as shown in Figure 2 below.

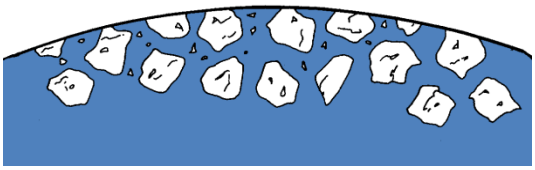
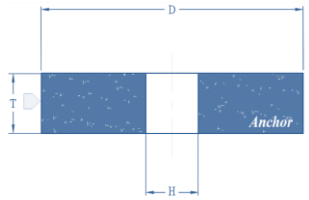


Figure 1 Truing

Figure 2 Dressing

Standard specification and size

1A、RT



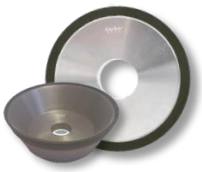
	Specification	D	T	H	for grit size
	● GC46J8V1A	180	13	31.75	#80 and coarser
	● GC80K5V1A	180	13	31.75	#100 - #200
	● GC120H5V1A	180	13	31.75	#230 - #325
	● GC220H5V1A	180	13	31.75	#400 and finer
	● GC400H8V1A	180	13	31.75	#600 and finer
	WA220J8V1A	180	10	31.75	#400 and finer
		T	A	W	-
	● WA220H5V-RT	100	18	8	Dressing stick

Unit : mm

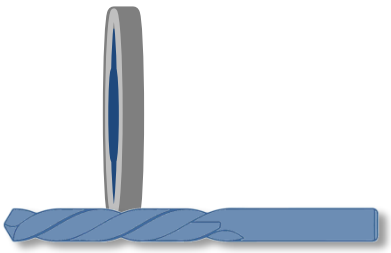
● In stock。

■ Other specifications and sizes can also be customized.

Anchor provides a full range of corresponding products according to processing requirements and tool types for metal cutting tools . Especially the MMW and HBMW bond grinding wheels have good retention and cutting ability.

Bond type	Products characteristics
 **MMW** (Metal bonds) **Efficiency**	Excellent cutting ability and fine heat emission, make it suitable for heavy duty deep creep stock removal. The best solution for the bar diameter above 8mm. Recommended for flute grinding.
 **HBMW** (Polyimide bonds) **Durable**	Superior free cutting behavior, maximum profile accuracy and significant durability. Suit for bar diameter above 6mm. Recommended for flute grinding.
 **BMW** (Resin bonds) **Economical**	Economic output combined with good cutting efficiency. Suit for bar diameter below 6mm. Recommended for flute, clearance angles and gash grindings.

Durable for heavy cutting and lower loading.



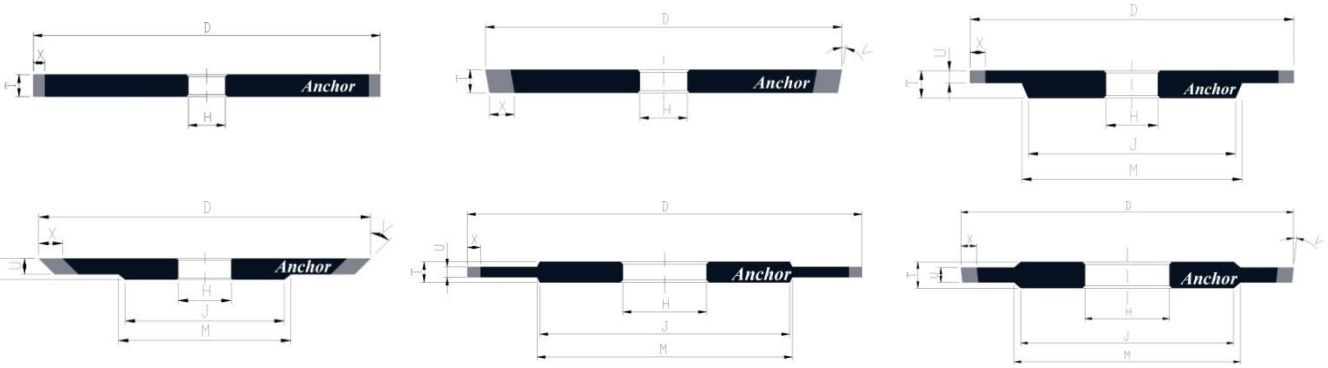
Fluting

Product Characteristics :

1. Excellent cutting performance and heat dissipation, suitable for the creep feed grinding
2. Suit for bar diameter above 6mm
3. Recommended processing method : FLUTE

Standard specification and size

1A1、1V1、3A1、3V1、14A1、14V1



Specification	D	T	H	X	V
SD270N125MMW 1A1	75	6	31.75	6	-
SD270N125MMW 1A1	75	6	31.75	8	-
SD270N125MMW 1A1	75	8	20	10	-
SD270N125MMW 1A1	75	10	20	10	-
SD270N125MMW 1A1	75	12	20	10	-
SD270N125MMW 1A1	100	8	20	6	-
SD270N125MMW 1A1	100	8	20	8	-
SD270N125MMW 1A1	100	10	20	8	-
SD270N125MMW 1A1	100	10	31.75	10	-
SD270N125MMW 1A1	100	12	20	10	-

- SDC is suit for tungsten carbide bars (T/C) 、CBN is suit for HSS bars.
- Other specifications and sizes can also be customized.

Unit : mm

Metal bond fluting wheel (MMW)

Specification	D	T	H	U	X	V
SD270N125MMW 1A1	125	6	20	-	8	-
SD270N125MMW 1A1	125	6	20	-	10	-
SD270N125MMW 1A1	125	8	20	-	8	-
SD270N125MMW 1A1	125	10	20	-	10	-
SD270N125MMW 1A1	125	12	20	-	10	-
SD270N125MMW 1A1	125	16	20	-	10	-
SD270N125MMW 1A1	150	8	20	-	10	-
SD270N125MMW 1A1	150	10	20	-	10	-
SD270N125MMW 1A1	150	12	20	-	10	-
SD270N125MMW 1V1	75	10	20	-	6	30°
SD270N125MMW 1V1	100	6	20	-	6	20°
SD270N125MMW 1V1	100	10	20	-	6	30°
SD270N125MMW 1V1	125	6	20	-	10	10°
SD270N125MMW 1V1	125	10	20	-	10	10°
SD270N125MMW 1V1	125	10	20	-	10	20°
SD270N125MMW 1V1	125	12	20	-	10	10°
SD270N125MMW 1V1	150	8	20	-	10	10°
SD270N125MMW 1V1	150	10	20	-	10	10°
SD270N125MMW 1V1	150	10	20	-	10	45°
SD270N125MMW 3A1	125	8	20	5	10	-
SD270N125MMW 3A1	150	8	20	5	8	-
SD270N125MMW 3A1	150	8	20	6	10	-
SD270N125MMW 3A1	150	8	40	5	8	-
SD270N125MMW 3A1	150	8	40	6	10	-
SD270N125MMW 3A1	150	8	50	5	8	-
SD270N125MMW 3A1	150	8	50	6	10	-
SD270N125MMW 3V1	75	12	20	10	6	30°
SD270N125MMW 3V1	100	6	20	3	10	60°
SD270N125MMW 14A1	100	10	20	8	10	-
SD270N125MMW 14A1	125	8	20	5	10	-

- SDC is suit for tungsten carbide bars (T/C) 、CBN is suit for HSS bars.
- Other specifications and sizes can also be customized.

Unit : mm

Metal bond fluting wheel (MMW) case study

The Qw value is used to calculate the amount of workpiece removal per unit time through parameters such as the grinding wheel depth of cut (Ae) and traverse feed speed (Vt), and is used as a reference value to evaluate the cutting efficiency of the grinding wheel.

Calculation of Qw value

$$Qw = \frac{Ae \times Vt}{60}$$

Vt = Traverse speed
Ae = Infeed (depth of cut)
Vc = Recommend wheel speed

Vt (mm/min)

Ae (mm)	30	40	50	60	70	80	90	100	120	140	160	180	200
2.6	1.3	1.7	2.2	2.6	3.0	3.5	3.9	4.3	5.2	6.1	6.9	7.8	8.7
2.8	1.4	1.9	2.3	2.8	3.3	3.7	4.2	4.7	5.6	6.5	7.5	8.4	9.3
3.0	1.5	2.0	2.5	3.0	3.5	4.0	4.5	5.0	6.0	7.0	8.0	9.0	10.0
3.2	1.6	2.1	2.7	3.2	3.7	4.3	4.8	5.3	6.4	7.5	8.5	9.6	10.7
3.4	1.7	2.3	2.8	3.4	4.0	4.5	5.1	5.7	6.8	7.9	9.1	10.2	11.3
3.6	1.8	2.4	3.0	3.6	4.2	4.8	5.4	6.0	7.2	8.4	9.6	10.8	12.0
3.8	1.9	2.5	3.2	3.8	4.4	5.1	5.7	6.3	7.6	8.9	10.1	11.4	12.7
4.0	2.0	2.7	3.3	4.0	4.7	5.3	6.0	6.7	8.0	9.3	10.7	12.0	13.3
4.2	2.1	2.8	3.5	4.2	4.9	5.6	6.3	7.0	8.4	9.8	11.2	12.6	14.0
4.4	2.2	2.9	3.7	4.4	5.1	5.9	6.6	7.3	8.8	10.3	11.7	13.2	14.7
4.6	2.3	3.1	3.8	4.6	5.4	6.1	6.9	7.7	9.2	10.7	12.3	13.8	15.3
4.8	2.4	3.2	4.0	4.8	5.6	6.4	7.2	8.0	9.6	11.2	12.8	14.4	16.0
5.0	2.5	3.3	4.2	5.0	5.8	6.7	7.5	8.3	10.0	11.7	13.3	15.0	16.7

Vf start value

Vf optimization potential

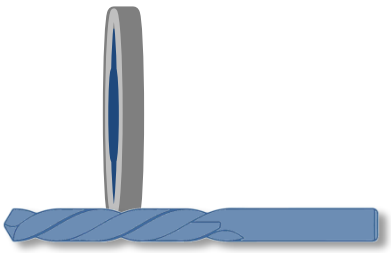
Recommended Qw values for MMW

	Qw mm^3/s	
Wheel speed Vc	Standard performance	High performance
15 – 25 m/s	3 – 6	7 - 10

Case study

Wheel specification	SD270N125MMW1A110	Workpiece Material	T/C
Wheel size	100X10X31.75X10	Wheel speed	21 – 22.5 m/s
Machine	ANCA	Infeed	3 mm
Traverse speed	100 mm/min	Dressing	800 pcs / time
Test result	QW = 3 X 100/60 = 5 good cutting ability, stable loading, significantly reduced production cost.		

Lower loading for heavy stock removal.



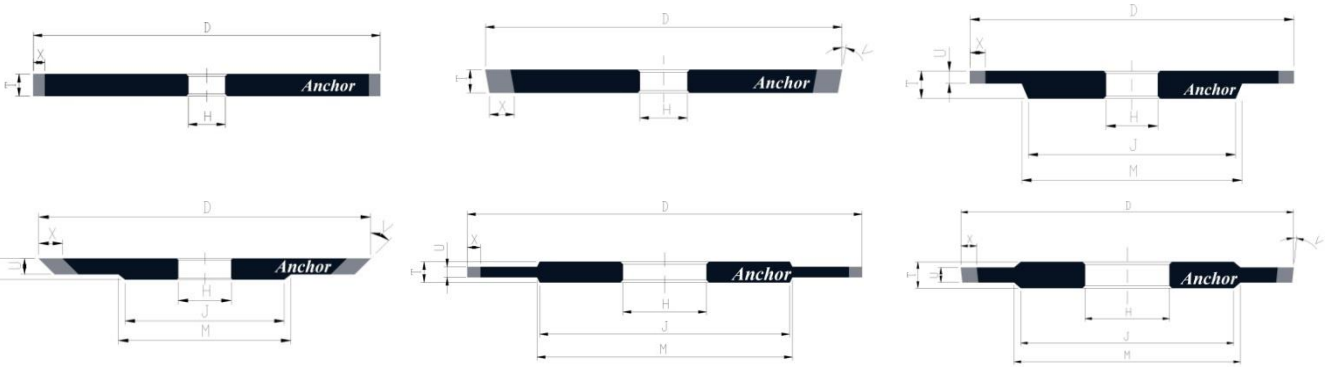
Fluting

Product Characteristics :

1. Excellent cutting ability and durability, good wheel shape retention
2. Suit for bar diameter above 6mm.
3. Recommended processing method : FLUTE

Standard specification and size

1A1、1V1、3A1、3V1、14A1、14V1



Specification	D	T	H	X	V
SDC270N125HBMW 1A1	75	6	20	6	-
SDC270N125HBMW 1A1	75	6	20	10	-
SDC270N125HBMW 1A1	75	8	20	10	-
SDC270N125HBMW 1A1	75	10	20	10	-
SDC270N125HBMW 1A1	100	6	20	6	-
SDC270N125HBMW 1A1	100	8	20	6	-
SDC270N125HBMW 1A1	100	10	20	10	-
SDC270N125HBMW 1A1	100	10	31.75	10	-
SDC270N125HBMW 1A1	100	12	20	10	-
SDC270N125HBMW 1A1	100	15	20	10	-
SDC270N125HBMW 1A1	125	8	20	6	-
SDC270N125HBMW 1A1	125	8	20	8	-
SDC270N125HBMW 1A1	125	8	20	10	-

- SDC is suit for tungsten carbide bars (T/C) 、CBN is suit for HSS bars.
- Other specifications and sizes can also be customized.

Unit : mm

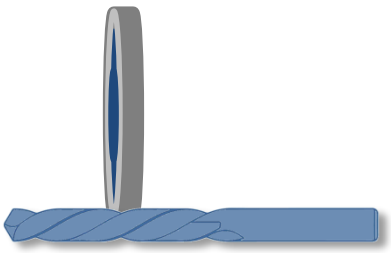
Polyimide resin bond fluting wheel (HBMW)

規格 Specification	外徑 D	厚度 T	孔徑 H	端部 U	鑽石層 X	角度 V
SDC270N125HBMW 1A1	125	10	20	-	8	-
SDC270N125HBMW 1A1	125	10	20	-	10	-
SDC270N125HBMW 1A1	125	12	20	-	10	-
SDC270N125HBMW 1A1	125	15	20	-	10	-
SDC270N125HBMW 1A1	150	8	20	-	6	-
SDC270N125HBMW 1A1	150	10	20	-	10	-
SDC270N125HBMW 1A1	150	10	31.75	-	10	-
SDC270N125HBMW 1A1	150	16	20	-	10	-
SDC270N125HBMW 1V1	75	8	20	-	6	20°
SDC270N125HBMW 1V1	100	6	20	-	10	20°
SDC270N125HBMW 1V1	100	8	20	-	6	15°
SDC270N125HBMW 1V1	100	10	20	-	10	10°
SDC270N125HBMW 1V1	100	12	20	-	10	10°
SDC270N125HBMW 1V1	125	6	20	-	10	15°
SDC270N125HBMW 1V1	125	8	20	-	10	45°
SDC270N125HBMW 1V1	125	10	20	-	6	10°
SDC270N125HBMW 1V1	125	10	20	-	10	20°
SDC270N125HBMW 1V1	125	16	20	-	10	20°
SDC270N125HBMW 1V1	150	6	20	-	10	10°
SDC270N125HBMW 1V1	150	8	20	-	10	10°
SDC270N125HBMW 1V1	150	10	20	-	10	10°
SDC270N125HBMW 1V1	150	12	20	-	10	10°
SDC270N125HBMW 3A1	125	6	20	3	6	-
SDC400N125HBMW 3A1	125	6	20	2	10	-
SDC270N125HBMW 3V1	125	8	20	5	10	10°
SDC270N125HBMW 3V1	125	8	20	5	10	45°
SDC270N125HBMW 14A1	150	15	31.75	13	10	-

- SDC is suit for tungsten carbide bars (T/C) 、CBN is suit for HSS bars.
- Other specifications and sizes can also be customized.

Unit : mm

Economical type for efficient fluting.



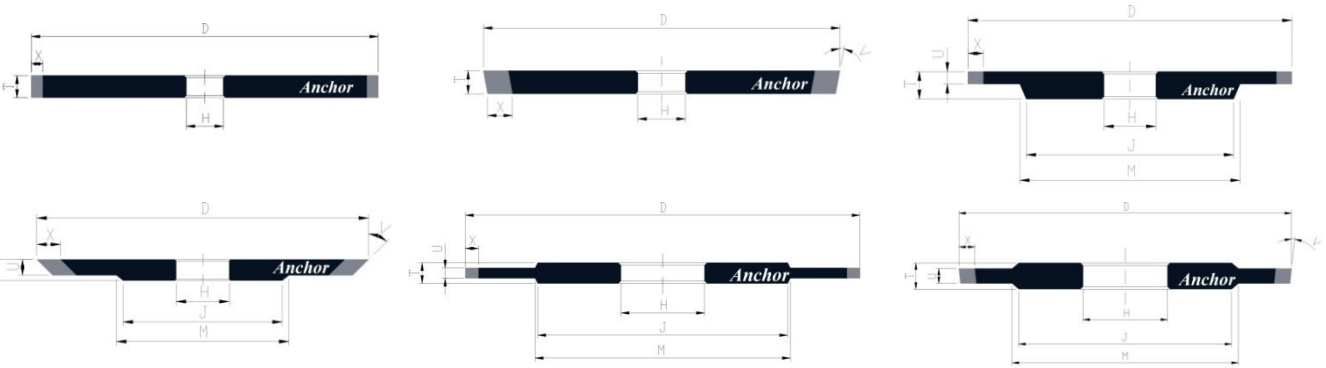
Fluting

Product Characteristics :

1. Good cutting ability and affordable price
2. Suit for bar diameter below 6mm.
3. Recommended processing method : FLUTE

Standard specification and size

1A1、1V1、3A1、3V1、14A1、14V1



Specification	D	T	H	X	V
SDC270N125BMW 1A1	75	4	20	5	-
SDC270N125BMW 1A1	75	4	20	6	-
SDC270N125BMW 1A1	75	6	20	8	-
SDC270N125BMW 1A1	100	6	20	5	-
SDC270N125BMW 1A1	100	6	20	6	-
SDC270N125BMW 1A1	100	6	20	8	-
SDC270N125BMW 1A1	100	6	20	10	-
SDC270N125BMW 1A1	125	5	20	6	-
SDC270N125BMW 1A1	125	6	20	6	-
SDC270N125BMW 1A1	125	8	20	10	-
SDC270N125BMW 1A1	150	10	31.75	6	-
SDC270N125BMW 1A1	150	10	20	10	-

- SDC is suit for tungsten carbide bars (T/C) 、CBN is suit for HSS bars.
- Other specifications and sizes can also be customized.

Unit : mm

Resin bond fluting wheel (BMW)

規格 Specification	外徑 D	厚度 T	孔徑 H	端部 U	鑽石層 X	角度 V
SDC270N125BMW 1V1	75	6	20	-	8	30°
SDC270N125BMW 1V1	75	6	20	-	8	35°
SDC270N125BMW 1V1	75	6	20	-	8	40°
SDC270N125BMW 1V1	75	6	20	-	10	10°
SDC270N125BMW 1V1	100	6	20	-	8	45°
SDC270N125BMW 1V1	100	6	20	-	10	15°
SDC270N125BMW 1V1	100	6	20	-	10	20°
SDC270N125BMW 1V1	100	6	20	-	10	30°
SDC270N125BMW 1V1	100	6	20	-	10	45°
SDC270N125BMW 1V1	100	6	20	-	10	60°
SDC270N125BMW 1V1	125	6	20	-	10	15°
SDC270N125BMW 1V1	125	6	31.75	-	10	45°
SDC270N125BMW 1V1	150	8	20	-	10	15°
SDC270N125BMW 3A1	75	8	20	6	6	-
SDC270N125BMW 3A1	100	6	20	3	6	-
SDC270N125BMW 3A1	100	6	20	4	8	-
SDC270N125BMW 3A1	125	8	20	4	8	-
SDC270N125BMW 3A1	125	8	20	6	10	-
SDC270N125BMW 3A1	150	8	20	4	8	-
SDC270N125BMW 3A1	150	12	20	6	10	-
SDC270N125BMW 3V1	75	8	20	4	4	45°
SDC270N125BMW 3V1	75	8	20	4	6	30°
SDC270N125BMW 3V1	100	6	20	3	8	30°
SDC270N125BMW 3V1	100	6	20	4	8	30°
SDC270N125BMW 3V1	100	8	20	5	10	15°
SDC270N125BMW 3V1	125	6	20	4	8	45°
SDC270N125BMW 3V1	125	8	20	6	8	45°
SDC270N125BMW 3V1	150	6	20	3	6	30°
SDC270N125BMW 3V1	150	6	20	4	10	10°

- SDC is suit for tungsten carbide bars (T/C) 、CBN is suit for HSS bars.
- Other specifications and sizes can also be customized.

Unit : mm

Resin bond Gash、OD/Relief wheel (BMW)

Economical type for efficient fluting.

Gash

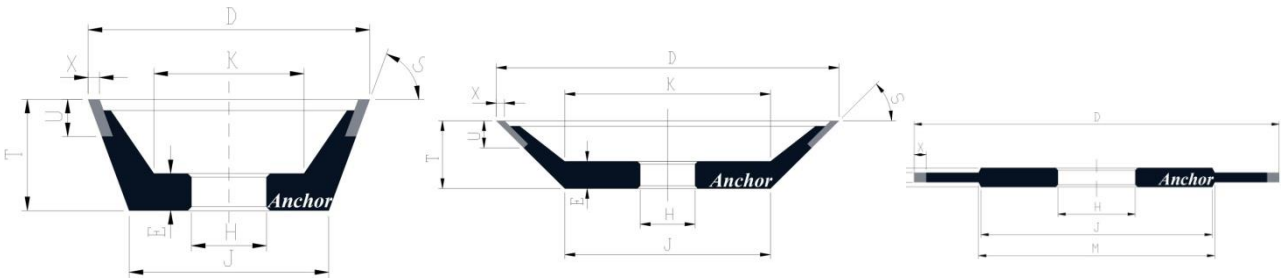
Product Characteristics：

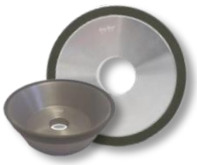
1. Good wear resistance and affordable price
2. Recommended processing method ：OD/Relief, Gash

OD/Relief

Standard specification and size

11V9、12V9、14A1





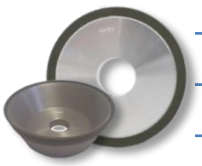
Specification	D	T	H	U	X
SDC325N100BMW 14A1	75	10	20	2	5
SDC325N100BMW 14A1	75	10	20	3	5
SDC325N100BMW 14A1	75	6	20	4	6
SDC325N100BMW 14A1	100	10	20	2	5
SDC325N100BMW 14A1	100	10	20	3	6
SDC325N100BMW 14A1	100	8	20	4	10
SDC325N100BMW 14A1	125	10	20	3	5
SDC325N100BMW 14A1	125	10	20	4	6
SDC325N100BMW 14A1	125	10	31.75	6	5
SDC325N100BMW 14A1	125	8	20	4	10
SDC325N100BMW 14A1	150	6	20	3	8
SDC325N100BMW 14A1	150	10	20	4	8

■ SDC is suit for tungsten carbide bars (T/C) 、CBN is suit for HSS bars.

■ Other specifications and sizes can also be customized.

Unit : mm

Gash、OD/Relief wheel (BMW, HBMW, MMW)



Specification	D	T	H	U	X	V
SDC325N100BMW 11V9	75	25	20	7	3	70°
SDC325N100BMW 11V9	75	30	20	8	4	70°
SDC325N100BMW 11V9	75	30	20	10	4	70°
SDC325N100BMW 11V9	75	32	20	10	5	70°
SDC325N100BMW 11V9	100	35	20	8	3	70°
SDC325N100BMW 11V9	100	35	31.75	10	3	70°
SDC325N100BMW 11V9	100	35	20	10	4	70°
SDC325N100BMW 11V9	100	35	20	10	5	70°
SDC325N100BMW 11V9	100	35	20	12	4	70°
SDC325N100BMW 11V9	100	35	31.75	12	5	70°
SDC325N100BMW 11V9	125	40	20	10	3	70°
SDC325N100BMW 11V9	125	45	31.75	10	4	70°
SDC325N100BMW 12V9	75	20	20	6	3	45°
SDC325N100BMW 12V9	75	20	20	10	3	45°
SDC325N100BMW 12V9	100	20	20	6	3	45°
SDC325N100BMW 12V9	100	30	20	8	3	45°
SDC325N100BMW 12V9	100	22	20	8	5	45°
SDC325N100BMW 12V9	100	35	20	10	3	45°
SDC325N100BMW 12V9	100	20	20	9	7	45°
SDC325N100BMW 12V9	125	25	20	10	3	45°
SDC325N100BMW 12V9	125	25	20	10	5	45°
SDC325N100BMW 12V9	125	25	20	12	3	30°

HBMW
MMW

SDC325N125HBMW 11V9	75	32	20	10	4	70°
SDC325N125HBMW 11V9	95	30	20	10	4	70°
SDC325N125HBMW 11V9	80	40	20	10	4	80°
SDC325N125HBMW 11V9	125	40	20	10	4	70°
SD325N125MMW 11V9	75	30	20	8	3.5	70°
SD325N125MMW 11V9	75	30	20	10	5	70°
SD325N125MMW 12V9	125	16	31.75	8	3	30°

- SDC is suit for tungsten carbide bars (T/C) 、CBN is suit for HSS bars.
- Other specifications and sizes can also be customized.

Unit : mm

Technical data sheet

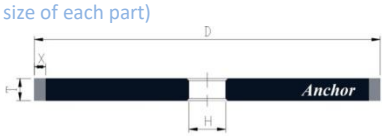
Customer Name		Date		Draw No.	

Present Brand

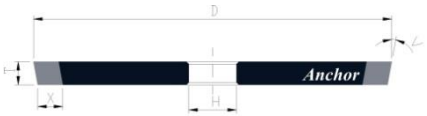
Specification and wheel size	Price	Consumption /month	Wheel Brand

Status and improvement requirements of current grinding wheels

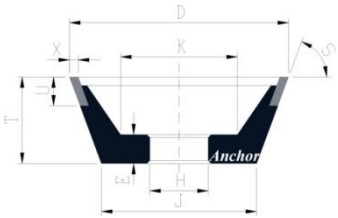
Workpiece information		***Machine and parameter***		
Name of workpiece		Machine brand		
Material	○ T/C ○ HSS	Wheel speed	m/s	RPM
Hardness	HRC/HRA	Feed rate	V=	mm/min
Dimension	Flute diameter Flute length Shank Length Diameter	In-feed method	Feed Once mm Feed Twice Coarse mm Fine mm	
Process part	○ FLUTE ○ OD/RELIEF ○ TOP OD/RELIEF ○ GASH			
Size of wheel	(Please fill in size of each part)			



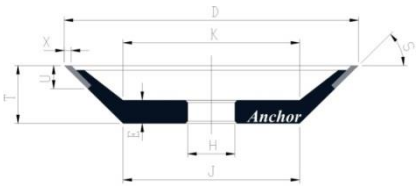
1A1 → D x T x H x X



1V1 → D x T x H x X x V



11V9→ D x T x H x E x K x J x U x X x S



12V9→ D x T x H x E x K x J x U x X x S

Inquiry online →