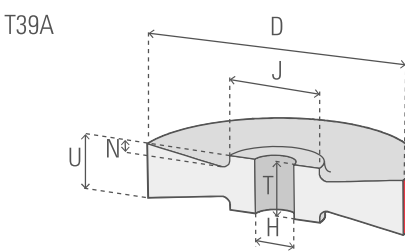
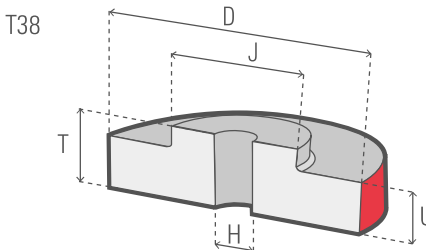
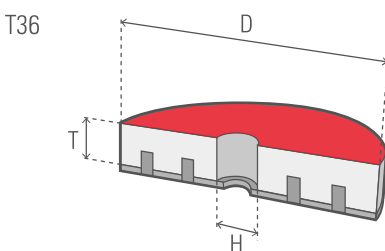
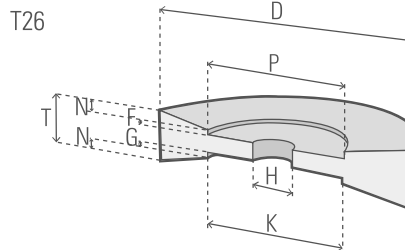
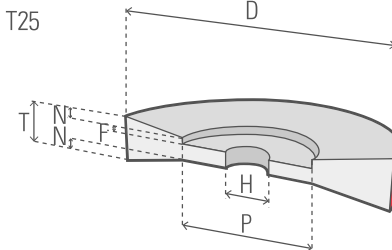
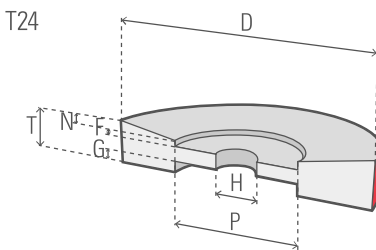
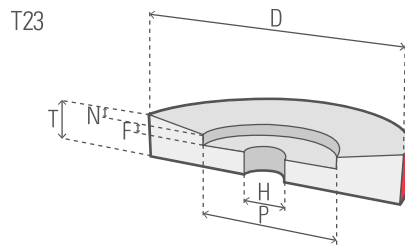
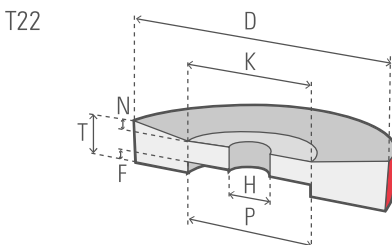
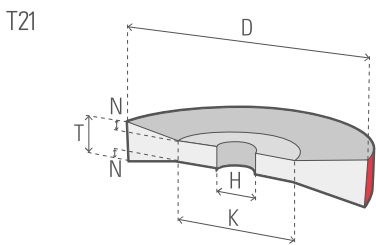
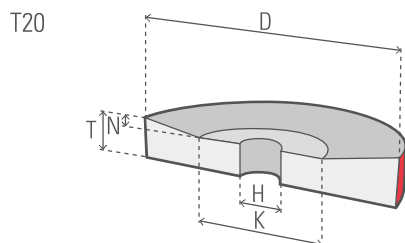
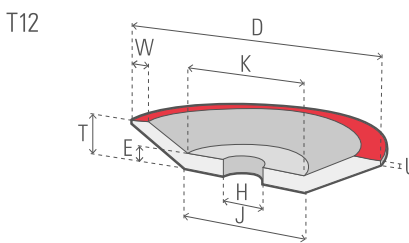
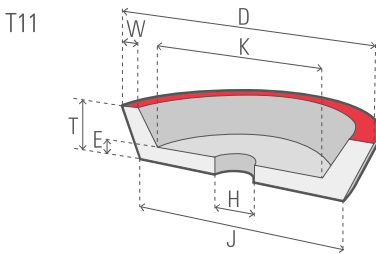
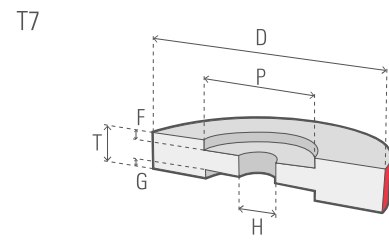
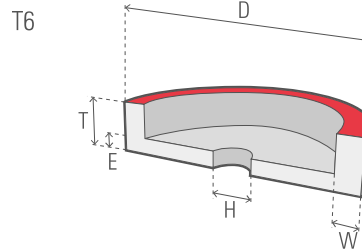
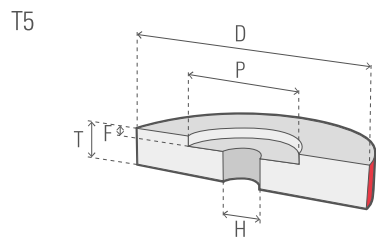
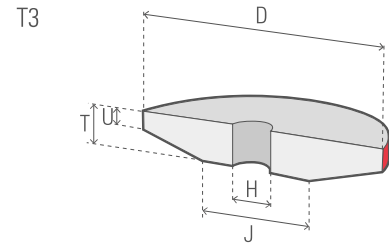
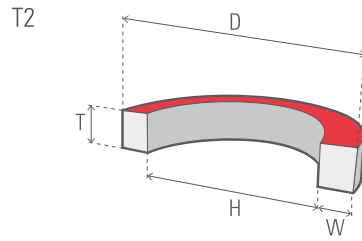
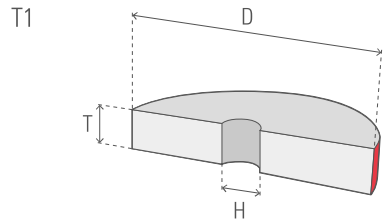


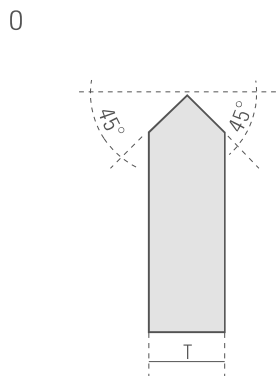
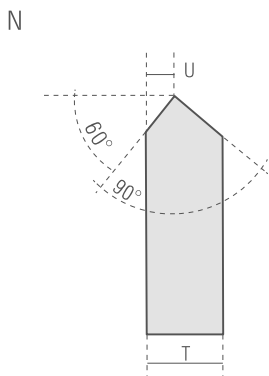
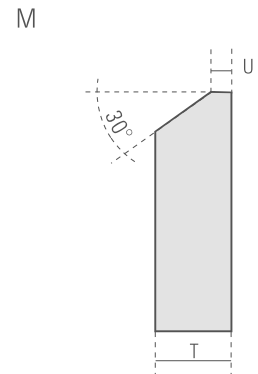
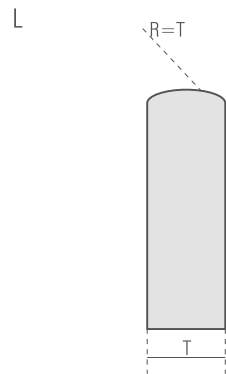
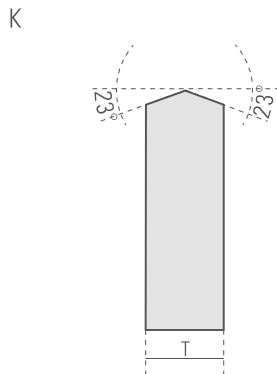
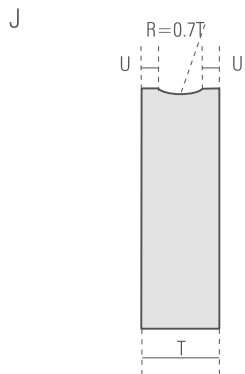
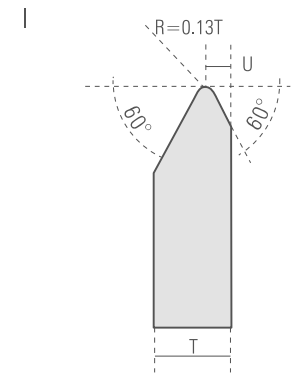
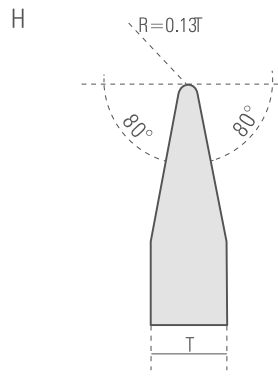
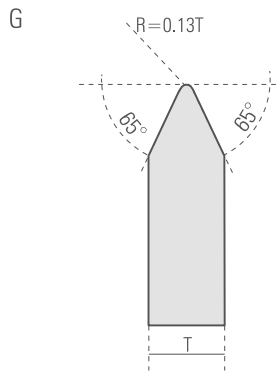
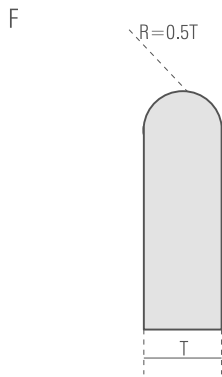
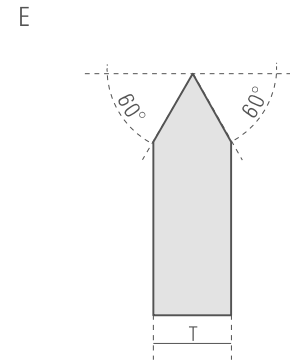
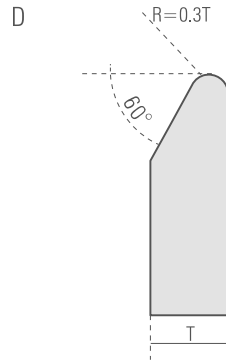
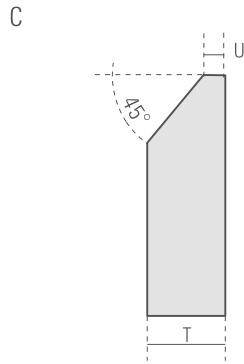
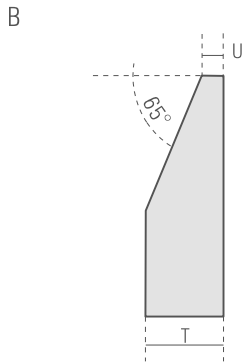
WHEEL SHAPES

ACCORDING TO FEPA STANDARDS



STANDARD PROFILES

ACCORDING TO FEPA STANDARDS

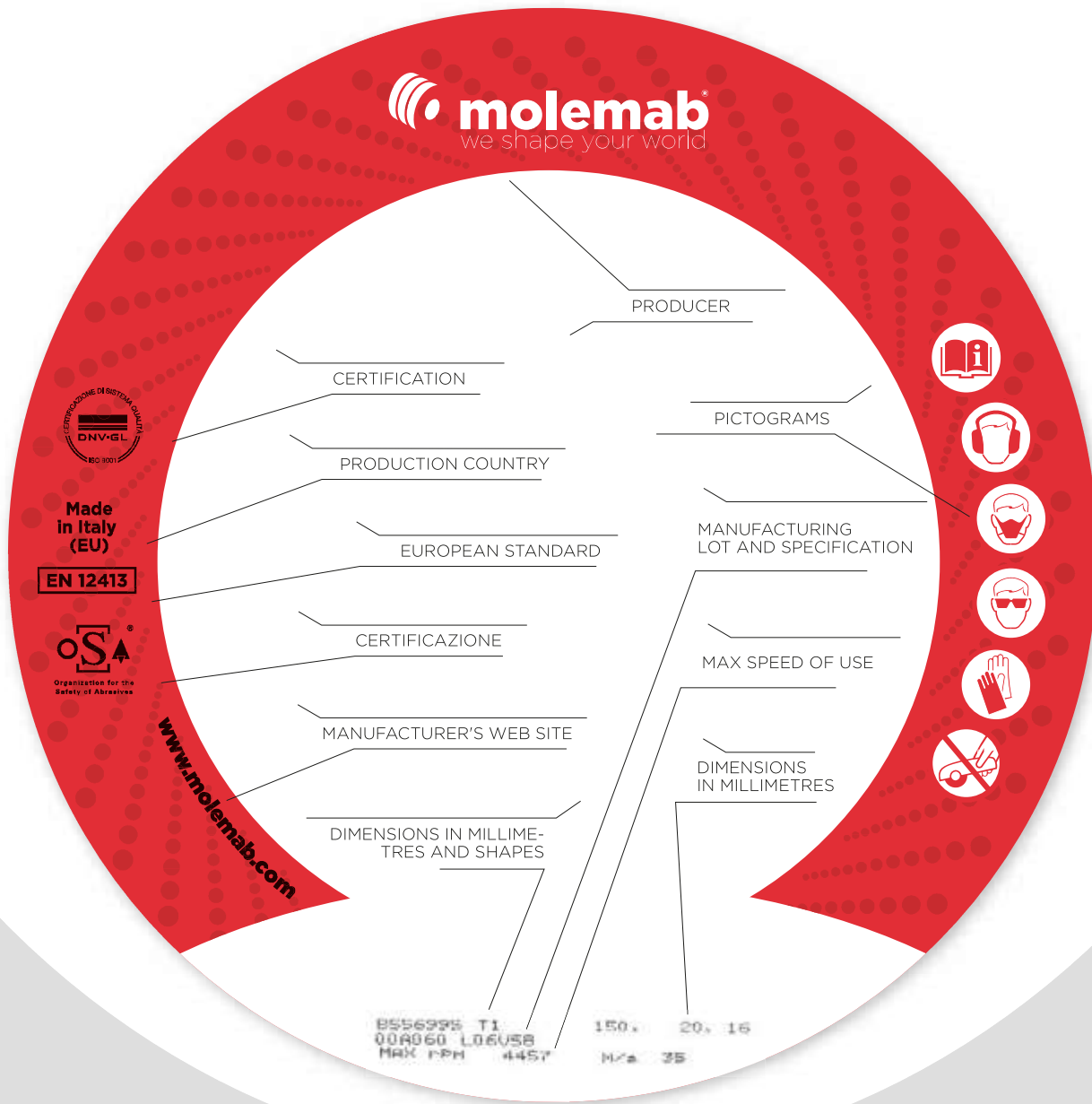


Special profiles available upon request

To modify the standard FEPA profile, add 1 after the letter (e.g.: PRQ1) and then the desired values.

molemab MARKING

IN COMPLIANCE WITH THE SAFETY RULES
THE WHEELS ARE MARKED AS FOLLOWS



Specifications

OOA 060 L 06 V58 PA

Abrasive type
Conventional aluminium oxide
Silicon carbide
Microcrystalline aluminium oxide

Grit size
Very coarse
Coarse
Medium
Fine
Very fine

Hardness
Very soft /soft medium
Hard
Very Hard

Structure
natural porosity
closed/open
Open induced porosity
High induced porosity
Very high induced porosity

Bond type
Vitrified for regular Aluminium Oxide
Vitrified for silicon carbide
Vitrified for microcrystalline Aluminium Oxide
Resinoid for Aluminium Oxide and Silicon Carbide
Rubber for regulating wheels

Porosity
Porous fine
Porous
Super-porous
Porous structured



Abrasive Type	Typology	Grit Size	Wheel hardness	Structure	Bond type	Induced porosity
Classification molemab	Conventional aluminium oxide	Coarse	Very soft	Closed	Vitrified for aluminium oxide	Porous fine
00A	Semi-pure	14	C	3	V11	PF0
09A	White	16	D	4	V20	PF1
11A	Pink	20	E	5	V27	Porous
14A	Mix of special aluminium	24	F	6	V30	P1
15A	Mix Grey and white	Medium	Soft	Medium	V34	P2
31A	Ruby	30	G	7	V85	Super porous
43A	Monocrystalline	36	H	8	V86	P3
45A	Mix of Monocrystalline	46	I	Open	V92	P4
51A	Mix of special aluminium	54	J	10	EG Line	Structured porous
75A	Semi-friable	60	K	11	VX	
91A	Mix of white and pink	Fine	Medium	12	VK	P12
	Silicon carbide	70	L	13	VG	P13
04C	Black	80	M	14	V40	
06C	Mixing	100	N	Very open	Vitrified for silicon carbide	
08C	Green	120	O	15		
	Sintered aluminium oxide	150	Hard	16	V01	
OMA	Mix special Arctic	180	P	17	V11	
SA	Ceramic Abrasive	Very fine	Q	18	V55	
AZ	Ceramic Abrasive NG	220	R		EG Line	
TA	Ceramic Abrasive	240	S		VJ	
		280	T		For Perfecta aluminium oxide and silicon carbide	
		320	Very hard			
		400	U		BGL	
			V		BGT	
			W		BGW	
			X		Resinoid MVC	
			Y		BGT	
			Z			
					Rubber	
					R	

GRINDING WHEEL SPEED TABLE

RPM AND M/SEC CORRESPONDING
PERIPHERAL SPEED FOR SOME WHEEL DIAMETERS

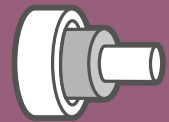
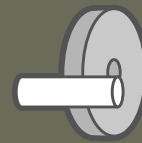


diameter	m/sec									
	20	25	32	35	40	45	50	63	80	100
6	64.000	80.000	102.000	112.000	128.000	143.500	160.000	201.000		
8	48.000	60.000	76.500	84.000	95.500	107.500	120.000	150.500	191.000	
10	38.200	48.000	61.200	67.000	76.500	86.000	95.500	120.500	153.000	153.000
13	29.500	36.800	47.100	51.500	58.800	66.200	73.500	92.600	118.000	147.000
16	23.900	29.850	38.200	41.800	47.800	53.750	59.700	75.200	95.500	120.000
20	19.500	23.900	30.600	33.500	38.200	43.000	47.800	60.200	76.500	95.500
25	15.300	19.100	24.500	26.800	30.600	34.500	38.200	48.200	61.200	76.500
32	11.950	14.950	19.100	20.900	23.900	27.000	30.000	37.600	48.000	60.000
40	9.550	11.950	15.300	16.750	19.100	21.500	23.900	30.100	38.200	47.800
50	7.650	9.550	12.550	13.400	15.300	17.200	19.100	24.100	30.600	38.200
63	6.100	7.600	9.750	10.650	12.150	13.650	15.200	19.100	24.300	30.350
80	4.800	6.000	7.650	8.400	9.550	10.750	12.000	15.100	19.100	23.900
100	3.850	4.800	6.150	6.700	7.650	8.600	9.550	12.100	15.300	19.100
125	3.100	3.850	4.900	5.350	6.150	6.900	7.650	9.650	12.250	15.300
150	2.550	3.200	4.100	4.500	5.100	5.750	6.400	8.050	10.200	12.750
180	2.150	2.700	3.400	3.750	4.250	4.780	5.350	6.700	8.500	10.650
200	1.950	2.400	3.100	3.350	3.850	4.300	4.800	6.050	7.650	9.550
230	1.700	2.100	2.700	2.950	3.350	3.750	4.200	5.250	6.650	8.350
250	1.550	1.950	2.450	2.700	3.100	3.450	3.850	4.850	6.150	7.650
300	1.300	1.600	2.050	2.250	2.550	2.870	3.200	4.050	5.100	6.400
350/356	1.100	1.400	1.750	1.950	2.200	2.460	2.750	3.450	4.400	5.500
400/406	960	1.200	1.550	1.700	1.950	2.150	2.400	3.050	3.850	4.800
450/457	850	1.100	1.400	1.500	1.700	1.910	1.700	2.700	3.400	4.250
500/508	765	960	1.250	1.350	1.550	1.720	1.950	2.450	3.100	3.850
600/610	640	800	1.050	1.150	1.300	1.450	1.600	2.050	2.550	3.200
660	580	725	930	1.050	1.200	1.300	1.450	1.850	2.350	2.900
750/762	510	640	820	895	1.050	1.150	1.300	1.650	2.050	2.550
800/813	480	600	765	840	960	1.075	1.200	1.550	1.950	2.400
900/914	425	535	680	750	850	955	1.100	1.350	1.700	2.150
1000/1016	385	480	615	670	765	860	960	1.250	1.550	1.950
1050/1067	365	455	585	640	730	820	910	1.150	1.500	1.850
1100/1120	350	435	560	610	695	785	870	1.100	1.400	1.750
1200/1220	320	400	510	560	640	720	800	1.050	1.300	1.600

STANDARD WORKING PARAMETERS FOR CONVENTIONAL GRINDING WHEELS



Parameters for aluminium oxide and silicon carbide grinding wheels	Operation / Material	Surface grinding	External grinding	Internal grinding
Peripheral speed of the grinding wheel (m/sec)		20 ÷ 35 m/sec	30 ÷ 50 m/sec	25 ÷ 35 m/sec
Workpiece speed m/min $\frac{\text{m/min}}{3,14 \times D \text{ in m}} = \text{revolutions per min}$	Roughing or unhardened	10 ÷ 20 m/minute	20 ÷ 50 m/minute	30 ÷ 60 m/minute
	Finishing or hardened	5 ÷ 10 m/minute	10 ÷ 15 m/minute	20 ÷ 40 m/minute
Ratio between peripheral Wheel speed and peripheral Working speed	Roughing	-	40 ÷ 60	60 ÷ 70
	Medium removal	-	60 ÷ 80	70 ÷ 80
	Finishing	-	80 ÷ 120	80 ÷ 90
Transverse movement t=grinding wheel thickness	Roughing or unhardened	1/4 ÷ 1/2 t	1/4 ÷ 1/2 t	1/4 ÷ 1/2 t
	Finishing or hardened	1/10 ÷ 1/5 t	1/10 ÷ 1/5 t	1/10 ÷ 1/5 t
Depth of cut (measured on the radius for external and internal grinding)	Roughing or unhardened	0,01 ÷ 0,05 mm	0,01 ÷ 0,05 mm	0,005 ÷ 0,02 mm
	Finishing or hardened	0,005 ÷ 0,02 mm	0,005 ÷ 0,02 mm	0,005 ÷ 0,01 mm



GRINDING WHEEL SAFETY

molemab products are manufactured in compliance with international safety standards. To guarantee compliance to European Standards, molemab is a member of FEPA, the European Abrasives Federation, and o.S.a. (Abrasive Safety Organization). The United States apply the 1988 ANSI (American National Standard Institute) Safety Code Standard B7.1 and the 1970 OSHA (Occupational Health and Safety Act) Regulations. Other European and non-European countries have their own regulations regarding safety and the use of grinding wheels. The procedures described below must be carefully followed to minimize the risk of accidents.

1. RECEPTION AND STORAGE

Handling: Grinding wheels must be handled with care, avoiding impacts and falls.

Visual check: Upon reception, the wheels must be checked visually.

Storage: Except for thin grinding wheels, all wheels must be stored vertically on suitable shelves. The storage location must be dry and not subject to significant or sudden temperature changes.

Expiry date: Resin bond wheels have a "Use Before Date" and must be stored for use in chronological order. Vitrified bond wheels can be stored for an indefinite period of time.

2. BEFORE MOUNTING

Visual check: Never use broken or cracked grinding wheels.

Sound test: A sound test must be carried out on new or partially used wheels. Smaller wheels can be held on a finger or mounted on the spindle vertically, heavier wheels must be placed standing vertically on the floor.





Using a small non-metal mallet, hit the wheel on the right and at the left of the vertical centre line. If the sound is ringing and clear, the grinding wheel is free of cracks or breakages. A dull, hollow sound indicates the presence of cracks.

Machine conditions: All machine parts subject to wear must be in good condition and regularly checked.

3. MOUNTING THE WHEEL

Carton labels: Always use carton labels that are slightly larger than the diameter of the flanges, to ensure that the clamping pressure of the flanges on the wheel is uniform.

Bore: The grinding wheel must fit the spindle correctly. Never force the wheel onto the spindle and do not use grinding wheels with a bore that is too large for the spindle.

Flanges: Carefully follow the instructions regarding type of flange and installation of the wheel.

Speed: Confirm the maximum working speed shown on the grinding wheel and check it against the speed of the machine. Never exceed the maximum speed specified by the manufacturer

Safety cover: Check that all safety covers and guards are in good conditions to ensure containment of airborne fragments in case the wheel should break.

4. OPERATION

Balancing: All wheels are systematically balanced by molemab.

The first on-machine balancing must be carried out after mounting the grinding wheel with the arrow located at the bottom (unless otherwise specified).

New generation grinding machines are often equipped with an automatic balancing system.

However, it necessary to check again the wheel balancing when it is disassembled and reassembled after working, and when the flanges are replaced.

Starting the wheel: Before starting to remove material, the grinding wheel must be run at maximum speed for at least one minute.

During this operation, all personnel must remain in safe areas.

Dressing and sharpening the wheel: Dressing frequency depends on the type of operation.

All the operations described above must be carried out by qualified personnel.



The background of the page features a large, semi-transparent image of grinding wheels. The wheels are arranged in a way that shows their curved surfaces and the gaps between them. The color palette is a range of muted greens, from light to dark, creating a textured, industrial feel.

24

HORIZONTAL
SPINDLE SURFACE
GRINDING WHEELS
SHAPES T1 - T5 - T7

29

RING AND CYLINDRICAL
CUP WHEELS
FOR SURFACE GRINDING
SHAPE T6

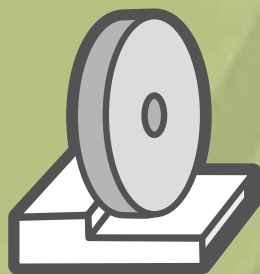
30

ABRASIVE SEGMENTS

31

SURFACE GRINDING
SEGMENTS

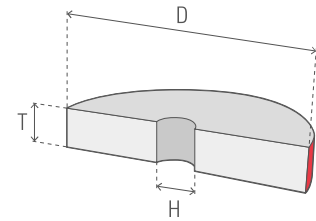
Surface grinding





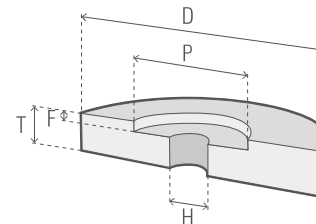
SHAPES AND DIMENSIONS			
Shape	D	T	H
T1	150	20	31,75 - 32
	180	6 - 8 - 10 - 13 - 16 - 20	31,75 - 32
	200	6 - 8 - 10 - 13 - 16 - 20	31,75 - 32
	225	20	50,8
	250	25	76,2
	300	25 - 32 - 40	76,2 - 127
	350	32 - 40 - 50	127
	400	40 - 50 - 60 - 76	127
	450	50 - 63 - 76	203,2
	508	50 - 63 - 80	203,2

SHAPE T1



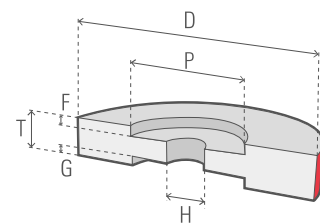
SHAPES AND DIMENSIONS					
Shape	D	T	H	P	F
T5	180	20	31,75	100	6
	200	25	31,75	110	10
	225	25	50,8	110	10
	250	32	76,2	125	12
	300	40	127	190	13
	300	50	127	190	13
	350	50	127	210	10
	400	50	127	210	10

SHAPE T5



SHAPES AND DIMENSIONS						
Shape	D	T	H	P	F	G
T7	300	50	76,2	155	10	10
	300	50	127	155	10	10
	350	50	127	210	10	10
	400	60	127	210	10	10
	400	76	127	210	20	10
	450	80	203,2	290	13	13
	508	100	203,2	300	15	15
	600	100	304,8	390	15	15

SHAPE T7



Other sizes available upon request

Horizontal spindle surface grinding wheels



MILD, ANNEALED QUENCHED AND TEMPERED STEEL < 35 HRC										
T1-T5	thickness 25 to 40	T1-T5-T7	thickness 50 to 90	T1-T5-T7	thickness 100 to 150	application				
300	11A 036 I 10 V86	●					SURFACE			
	11A 046 I 10 V86	●					SURFACE			
350	11A 036 I 10 V86	●	350	11A 036 I 10 V86	●		SURFACE			
	11A 046 I 10 V86	●		11A 046 I 10 V86	●		SURFACE			
400	11A 036 I 10 V86	●	400	11A 036 I 10 V86	●	400	11A 036 H 10 V86	●	SURFACE	
	11A 046 I 10 V86	●		11A 46 FG12 VX P4	●		11A 46 F12 VX P4	●	SURFACE	
	11A 046 G12 VXP4	●		09A 046 FG12 V34 P3	●	09A 046 FG12 V34 P3	●	09A 046 FG12 V34 P3	●	SURFACE
		●		09A 054 FG12 VG P13	●	09A 054 FG12 VG P13	●	09A 054 FG12 VG P13	●	SURFACE
		450	11A 036 I 10 V86	●			SURFACE			
			11A 46 FG12 VX P4	●			SURFACE			
			09A 046 FG12 V34 P3	●	450	09A 046 FG12 V34 P3	●	SURFACE		
			09A 054 FG12 VG P13	●		09A 054 FG12 VG P13	●	SURFACE		
		500	11A 036 I 10 V86	●			SURFACE			
			11A 46 FG12 VX P4	●			SURFACE			
			09A 046 FG12 V34 P3	●	500	09A 046 FG12 V34 P3	●	SURFACE		
			09A 054 FG12 VG P13	●		09A 054 FG12 VG P13	●	SURFACE		
				610	11A 036 I 10 V86	●	SURFACE			
					09A 046 FG12 V34 P3	●	SURFACE			
					09A 054 FG12 VG P13	●	SURFACE			
QUENCHED AND TEMPERED (HIGH RESISTANCE) AND HARDENED STEEL < 54 HRC										
T1-T5	thickness 25 to 40	T1-T5-T7	thickness 50 to 90	T1-T5-T7	thickness 100 to 150	application				
300	09A 046 FG12 V34 P3	●					SURFACE			
	09A 054 FG12 VG P13	●					SURFACE			
350	09A 046 FG12 V34 P3	●	350	09A 046 FG12 V34 P3	●		SURFACE			
	09A 054 FG12 VG P13	●		09A 054 FG12 VG P13	●		SURFACE			
	45A 54/60 E14 VK P1	●		45A 54/60 DE14 VK P1	●		SURFACE			
	OMA 54/60 FG11 VG5 P13	●		OMA 54/60 F11 VG5 P13	●		SURFACE			
400	09A 046 FG12 V34 P3	●	400	09A 046 FG12 V34 P3	●	400	09A 046 FG12 V34 P3	●	SURFACE	
	09A 054 FG12 VG P13	●		09A 054 FG12 VG P13	●		09A 054 F12 VG P13	●	SURFACE	
	45A 54/60 E14 VK P1	●		45A 54/60 DE14 VK P1	●	45A 54/60 DE14 VK P1	●	SURFACE		
	OMA 54/60 FG11 VG5 P13	●		OMA 54/60 F11 VG5 P13	●	OMA 54/60 F11 VG5 P13	●	SURFACE		
		450	09A 046 FG12 V34 P3	●	450	09A 046 FG12 V34 P3	●	SURFACE		
			09A 054 FG12 VG P13	●		09A 054 F12 VG P13	●	SURFACE		
			45A 54/60 DE14 VK P1	●		45A 54/60 DE14 VK P1	●	SURFACE		
			OMA 54/60 F11 VG5 P13	●		OMA 54/60 EF11 VG5 P13	●	SURFACE		

The coloured dot shows the actual colour of the wheel = ● (yellow wheel)

Horizontal spindle surface grinding wheels



QUENCHED AND TEMPERED (HIGH RESISTANCE) AND HARDENED STEEL < 54 HRC						
T1-T5	thickness 25 to 40	T1-T5-T7	thickness 50 to 90	T1-T5-T7	thickness 100 to 150	application
		500	09A 046 FG12 V34 P3 ●	500	09A 046 FG12 V34 P3 ●	SURFACE
			09A 054 FG12 VG P13 ●		09A 054 F12 VG P13 ●	SURFACE
			45A 54/60 DE14 VK P1 ●		45A 54/60 DE14 VK P1 ●	SURFACE
			OMA 54/60 F11 VG5 P13 ●		OMA 54/60 EF11 VG5 P13 ●	SURFACE
		610		610	09A 046 FG12 V34 P3 ●	SURFACE
					09A 054 F12 VG P13 ●	SURFACE
			45A 54/60 DE14 VK P1 ●		45A 54/60 DE14 VK P1 ●	SURFACE
					OMA 54/60 EF11 VG5 P13 ●	SURFACE
HARDENED AND CEMENTED STEEL < 58 HRC						
T1-T5	thickness 25 to 40	T1-T5-T7	thickness 50 to 90	T1-T5-T7	thickness 100 to 150	application
400	OMA 54/60 F11 VG5 P13 ●	400	OMA 54/60 F11 VG5 P13 ●	400	OMA 54/60 EF11 VG5 P13 ●	SURFACE
	43A 060 FG12 VG4 P13 ●		43A 060 FG12 VG4 P13 ●		43A 060 F12 VG4 P13 ●	SURFACE
		450	OMA 54/60 F11 VG5 P13 ●	450	OMA 54/60 EF11 VG5 P13 ●	SURFACE
			43A 060 FG12 VG4 P13 ●		43A 060 F12 VG4 P13 ●	SURFACE
		500	OMA 54/60 F11 VG5 P13 ●	500	OMA 54/60 EF11 VG5 P13 ●	SURFACE
			43A 060 FG12 VG4 P13 ●		43A 060 F12 VG4 P13 ●	SURFACE
				610	OMA 54/60 EF11 VG5 P13 ●	SURFACE
					43A 060 F12 VG4 P13 ●	SURFACE
HARDENED AND CEMENTED STEEL < 62 HRC						
T1-T5	thickness 25 to 40	T1-T5-T7	thickness 50 to 90	T1-T5-T7	thickness 100 to 150	application
400	1TA 046 FG12 VG4 P3 ●	400	1TA 046 F12 VG4 P3 ●	400	1TA 046 F12 VG4 P3 ●	SURFACE
	2SA 054 F12 VG4 P13 ●		2SA 054 EF12 VG4 P13 ●		2SA 054 EF12 VG4 P13 ●	SURFACE
		450	1TA 046 F12 VG4 P3 ●	450	1TA 046 F12 VG4 P3 ●	SURFACE
			2SA 054 EF12 VG4 P13 ●		2SA 054 EF12 VG4 P13 ●	SURFACE
		500	1TA 046 F12 VG4 P3 ●	500	1TA 046 F12 VG4 P3 ●	SURFACE
			3SA 054 EF12 VG4 P13 ●		3SA 054 EF12 VG4 P13 ●	SURFACE
				610	1TA 046 F12 VG4 P3 ●	SURFACE
					3SA 054 EF12 VG4 P13 ●	SURFACE

Horizontal spindle surface grinding wheels



FERRITIC STAINLESS STEEL, SERIES 400 AND INCONEL									
T1-T5	thickness 25 to 40	T1-T5-T7	thickness 50 to 90	T1-T5-T7	thickness 100 to 150	application			
300	09A 060 FG12 VG P13	○				SURFACE			
350	09A 060 FG12 VG P13	○				SURFACE			
400	09A 060 FG12 VG P13	○	400	09A 060 FG12 VG P13	400	SURFACE			
	9A 060 EF16 VK2 P13	●				CREEP-FEED			
	09A 070/2 H10 V86 P1	○		09A 070/2 H10 V86 P1		○	CREEP-FEED		
	09A 100 I14 VG PF1	○		09A 100 I14 VG PF1		○	CREEP-FEED		
			450	09A 060 FG12 VG P13	○	450	09A 060 F12 VG P13	○	SURFACE
			500	09A 060 FG12 VG P13	○	500	09A 060 F12 VG P13	○	SURFACE
HARDENED STAINLESS STEEL									
T1-T5	thickness 30 to 50	T1-T5-T7	thickness 60 to 80	T1-T5-T7	thickness 100 to 150	application			
350	08C 046 G12 VJ P3	●				SURFACE			
400	08C 046 G12 VJ P3	●	400	08C 046 G12 VJ P3	●	SURFACE			
450	08C 046 G12 VJ P3	●	450	08C 046 G12 VJ P3	●	SURFACE			
500	08C 046 G12 VJ P3	●	500	08C 046 G12 VJ P3	●	500	08C 046 F12 VJ P3	●	SURFACE
AUSTENITIC STAINLESS STEEL SERIES 300 AND NIMONIC									
T1-T5	thickness 30 to 50	T1-T5-T7	thickness 60 to 80	T1-T5-T7	thickness 100 to 150	application			
350	45A 060 E14 VK P13	○				SURFACE			
400	45A 060 E14 VK P13	○	400	45A 060 DE14 VK P13	○	SURFACE			
450	45A 060 E14 VK P13	○	450	45A 060 DE14 VK P13	○	SURFACE			
500	45A 060 E14 VK P13	○	500	45A 060 DE14 VK P13	○	500	45A 060 DE14 VK P13	○	SURFACE
				610		45A 060 DE14 VK P13	○	SURFACE	



Horizontal spindle surface grinding wheels



FERRITIC, NODULAR PEARLITIC AND HARDENED CAST IRON						
T1-T5	thickness 30 to 50	T1-T5-T7	thickness 60 to 80	T1-T5-T7	thickness 100 to 150	application
400	09A 046 FG12 V34 P3	400	09A 046 FG12 V34 P3	400	09A 046 FG12 V34 P3	SURFACE
	09A 054 FG12 VG P4		09A 054 FG12 VG P4		09A 054 F12 VG P4	SURFACE
			91A 70/1 G12 VG P2		91A 70/1 G12 VG P2	SURFACE
		500	09A 046 FG12 V34 P3	500	09A 046 FG12 V34 P3	SURFACE
			09A 054 FG12 VG P4		09A 054 F12 VG P4	SURFACE
			91A 70/1 G12 VG P2		91A 70/1 G12 VG P2	SURFACE
		610	91A 70/1 G12 VG P2	610	91A 70/1 G12 VG P2	SURFACE

GREY CAST IRON						
T1-T5	thickness 30 to 50	T1-T5-T7	thickness 60 to 80	T1-T5-T7	thickness 100 to 150	application
400	08C 060 H10 V11 P1	400	08C 060 H10 V11 P1	400	08C 060 G10 V11 P1	SURFACE
	08C 060 G10 VJ P3		08C 060 G10 VJ P3		08C 060 FG10 VJ P3	SURFACE
		500	08C 060 H10 V11 P1	500	08C 060 G10 V11 P1	SURFACE
			08C 060 G10 VJ P3		08C 060 FG10 VJ P3	SURFACE

NON FERROUS METALS, ALUMINIUM, BRONZE, COPPER AND NON FERROUS ALLOYS						
T1-T5	thickness 30 to 50	T1-T5-T7	thickness 60 to 80	T1-T5-T7	thickness 100 to 150	application
300	08C 060 H10 V11 P1					SURFACE
	08C 060 G10 VJ P3					SURFACE
350	08C 060 H10 V11 P					SURFACE
	08C 060 G10 VJ P3					SURFACE
400	08C 060 H10 V11 P1	400	08C 060 H10 V11 P1	400		SURFACE
	08C 060 G10 VJ P3		08C 060 G10 VJ P3			SURFACE
		450	08C 060 H10 V11 P1	450	08C 060 G10 V11 P1	SURFACE
			08C 060 G10 VJ P3		08C 060 FG10 VJ P3	SURFACE

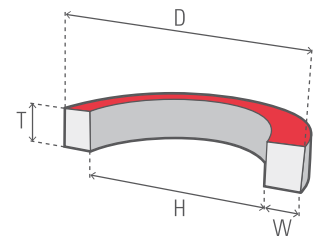
EXAMPLE OF ORDER

SHAPE	DIMENSIONS (mm)	NOTE	SPEED	SPECIFICATION	
T5	500x80x203,2	P=280 F=15	35 m/sec	09A 046 FG12 V34 P3	The coloured dot shows the actual colour of the wheel

Ring wheels and cylindrical cup for surface grinding

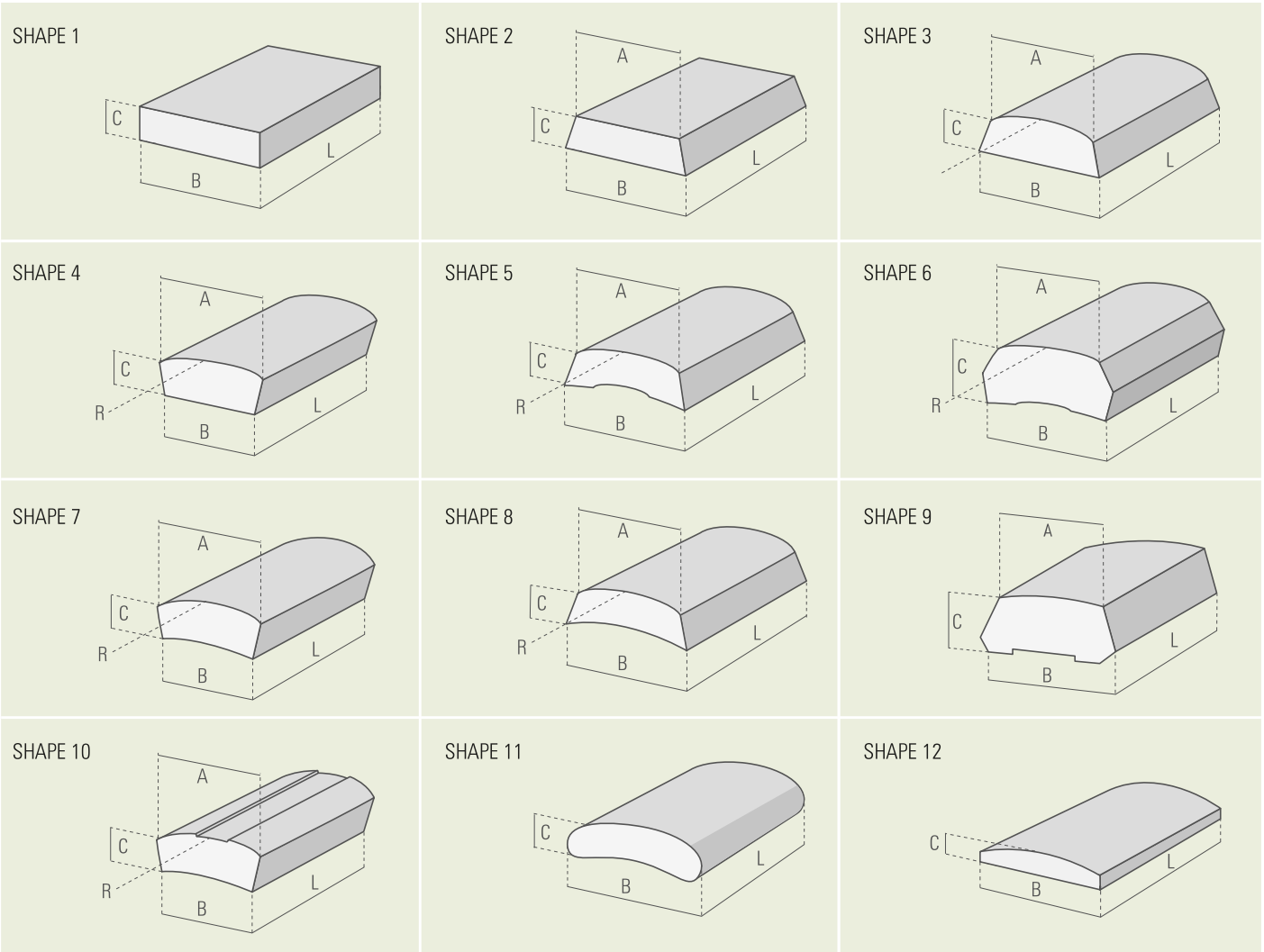


SHAPE T2

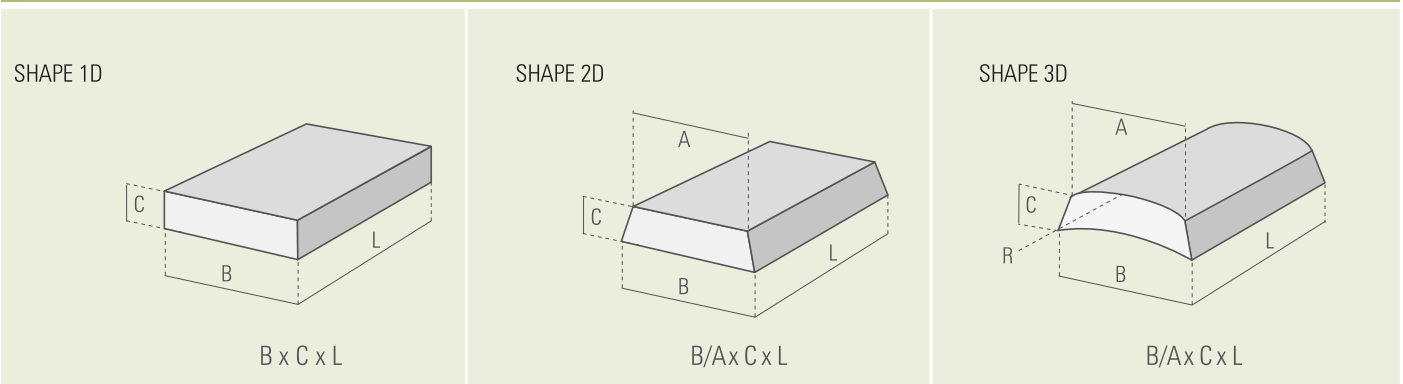


SHAPE T6

SHAPES AND DIMENSIONS					
Shape	D	T	H		
T2	175	80	135		
	200	100	160		
	250	100	200		
MILD, QUENCHED AND TEMPERED AND HARDENED STEEL ≤ 52 HRC					
T2	T= 80	T2	T= 100	application	
175	09A 036 G08 V86	○		SURFACE	
	09A 046 G08 V86	○		SURFACE	
200			09A 036 G08 V86	○	SURFACE
			09A 046 G08 V86	○	SURFACE
250			09A 036 G08 V86	○	SURFACE
			09A 046 G08 V86	○	SURFACE
HARDENED AND CEMENTED STEEL ≥ 58 HRC					
T2	T= 80	T2	T= 100	application	
175	09A 036 F12 V34P3	●		SURFACE	
	09A 046 F12 V34P3	●		SURFACE	
200			09A 036 F12 V34P3	●	SURFACE
			09A 046 F12 V34P3	●	SURFACE
250			09A 036 F12 V34P3	●	SURFACE
			09A 046 F12 V34P3	●	SURFACE
SHAPES AND DIMENSIONS					
Shape	D	T	H	W	E
T6	178	78	78	19	19
	200	80	78	22	22
MILD, QUENCHED AND TEMPERED AND HARDENED STEEL ≤ 58 HRC					
T6	T= 78	T6	T= 80	application	
178	09A 30 H08 V86	○		SURFACE	
	09A 36 H08 V86	○		SURFACE	
200			09A 30 H08 V20	○	SURFACE
			09A 36 H08 V20	○	SURFACE
HARDENED AND CEMENTED STEEL ≥ 58 HRC					
T6	T= 78	T6	T= 80	application	
178	09A 36 G10 V34P	●		SURFACE	
200			09A 36 G10 V34P	●	SURFACE



HOW TO IDENTIFY SIZES





Surface grinding segments

The following tables list the most common abrasive segment shapes and sizes. Other specifications and shapes are available upon request

SPECIFICATIONS					
MATERIAL	TYPE	CONTINUOUS CUTTING		DISCONTINUOUS CUTTING	
		SPECIFICATION		SPECIFICATION	
Steel	Mild steel	09A036H08V86	○	11A024I08V86	○
	Low/medium hardness steel			11A030H09V86	○
	Hardened steel	09A036G10V20P	○	11A036G08V86	○
	Alloy steel Hardness ≤ 58 HRC	09A030G10V92	●		
High alloy steels Tools steel HSS Hardness ≥ 58 HRC	09A036F12V34P	●	3SA046F12V114P 3AZ046F10VG4P13	● ●	
Stainless steel	Unhardened stainless steel	09A024H09V86	○	11A024I08V86	○
	Hardened and alloyed steel	09A36G09V86	○	11A036G09V86	○
Cast iron	Steel cast iron, Grey cast iron	09A024H09V86	○	11A024I08V86	○
	Engine head cast iron	06C036I07V11	●		
	Annealed and ductile iron				
Hard metal	Tungstene carbide	08C060G08V01	●		
Non ferrous metals	Aluminium, bronze, copper, non-ferrous alloys	08C046G05V01	●		
		08C046H05V11	●		



EXAMPLE OF ORDER

SHAPE	DIMENSIONS (mm)	SPECIFICATION		The coloured dot shows the actual colour of the wheel
8	50/45 x 16 x 90	09A 36 G10 V34P	●	