

## Common Grinding Wheels - other

Written by YingLong

Wednesday, 27 October 2010 17:12 - Last Updated Wednesday, 27 October 2010 17:19

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### 2. Choice the Grit. Sizes

**Grit Sizes**

**Usage**

**4,5,6,8,10,12,14,16,20,22,24,30**

**Rough Grinding and Cutting**

**36,40,46,54**

**Common Semi-precision Grinding**

**60,70,80,90,100**

**Common Fine Grinding**

**120,150,180,220,240,W63,W50,W40,W28.W20**

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### Polishing and Threading

W14,W10,W7,W5,W3.5,W2.5W1.5,W1.0,W0.5

### Mirror –surface grinding and Finer Polishing

## 3. To Choose the Bonds:

□ **Vitrified Bond.** It is suitable for the cylindrical grinding and ex-circular grinding , center-less grinding .surface grinding and thread grinding ,forming –grinding etc.

□ **Resin Bond.** It can used to grind the steel precision grinding of the stones, cutting and polishing, but it should be kept away from alkaline solution

## 4. Hardness.

The Hardness of the abrasive tools indicates the difficulty of abrasive tools falling off the surface of the abrasive tools in cutting. Generally, the grinding wheels in soft hardness are used for cutting harder work-pieces, whereas the wheels in a bit higher hardness are used for cutting soft work-pieces

### 5. Structure No.

Structure No. is the percentage of the grain volume in the volume of the abrasive tools. The bigger the grain is, the denser the structure is; otherwise, the structure is porous. The abrasive tools in the porous structure are characterized by more holes among grains and easily removing metal fillings, and excellent capacity of heat –radiating and burning no work-pieces, the one in dense structure feature well, which can keep the shape well and high clearness of the work-Pieces, also high grinding efficiency