

## 2. Choice the Grit. Sizes

Girt 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

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:

①Vitrified Bond. It is suitable for the cylindrical grinding and ex-circular grinding , center-less grinding .surface grinding and thread grinding ,forming grinding etc.

②Resin 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

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## 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 other, 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