

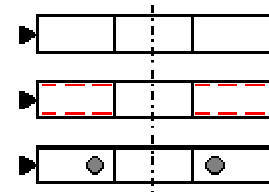
Grinding-wheels (1 out of 3)

TYPE 1 straight-type

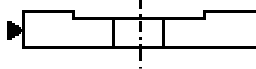
Resinoid bond **B**

Resinoid bond reinforced by glass fiber **BF**

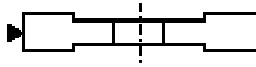
Resinoid bond reinforced by steel bar **BF (S)**



TYPE 5 straight-type grinding-wheel recessed on one side, resinoid bond **B**



TYPE 7 straight-type grinding-wheel recessed on both sides, resinoid bond **B**



TYPE 1 scope of dimensions

Diameter	Thickness	Hole	Typical dimensions
50	10	13	
	20, 40	20	
60	6	13	
70	6	20	
75	6	10	
	6	12	
	6	20	
	13	20	
	20	10	
80	6	20	
	10, 20	20	
100	6	16	
	6-40	20	100x20x20; 100x25x20
115	7	51	
125	5-32	20	125x6x20; 125x10x20; 125x20x20; 125x25x20
	20, 25	32	
150	5-32	20	150x6x20; 150x10x20; 150x16x20; 150x20x20; 150x25x20
	5-32	32	150x6x32; 150x20x32; 150x25x32
	20	51	
175	20	20	
	20; 25	32	
180	20	20	
200	20	20	
	8-40	32	200x20x32; 200x25x32; 200x32x32
	80	75	
	25	76	
	13	90	
225	5	60	
230	38	100	

Grinding-wheels (2 out of 3)

TYPE 1 scope of dimensions (continuation)

Diameter	Thickness	Hole	Typical dimensions
250	5, 6	20	
	6-40	32	250x6x32; 250x10x32; 250x20x32; 250x25x32; 250x32x32
	60	50	
	10-50	51	
	20-40	76	250x25x76; 250x32x76
	20, 25, 32	100	
	10, 25, 32	127	
300	6-35	32	300x32x32; 300x35x32
	30-50	51	300x40x51
	15-40	76	300x40x76
	6-40	127	300x40x127
	77	230	
350	10-32	32	
	40-50	127	350x40x127; 350x50x127
	30-50	51	350x40x51;
400	40, 50	51	400x40x51
	10-60	127	400x40x127; 400x50x127
	40, 50	203	400x50x203
450	30, 50	127	450x50x127
	50, 80	203	
500	12	51	
	7, 12, 16	76	
	40	127	
	20, 50, 60	152	
	50,8	152,4	
	50, 60, 80	203	
	50	254	
	80, 100	305	
600	45	76	
	60, 80	203	
	80, 100	305	
750	28	480	
760	63, 75	305	
800	80	400	

Application:

- for rough grinding on swing-frame grinders, stationary grinders, portable grinding tools: electrical and pneumatic grinders
- for cylindrical grinding on centreless grinders used as grinding wheels and on centre-type grinders

Straight-type grinding-wheels recessed on one side TYPE 5			
Diameter	Thickness	Hole	Recess
125	32	20	70x12; 70x16; 75x16
125	50	51	80x10; 82x25
150	32	32	20x15; 75x16
250	32	25	150x16
350	50	51	120x27
Straight-type grinding-wheels recessed on both sides TYPE 7			
250	40	76	150x10x10
300	50	76	150x10x10
600	80	305	365x20x20
Straight-type grinding-wheels recessed on both sides taper cap TYPE 26			
500	7	60	

Application:

- for rough grinding on stationary and portable grinders
- for cylindrical grinding on centreless grinders used as grinding wheels and on centre-type grinders

Permitted peripheral speed: 45 m/s

Permissible rotation speed dependent on the diameter:

Diameter:	rpm
100	8590
125	6870
150	5730
180	4770
200	4300
250	3440
300	2860
350	2450
400	2150
450	1910
500	1720
600	1430

Exemplary marking:

- 1 - 200 x 20 x 32 - 95A 24 Q B
- 1 - 150 x 25 x 32 - 95A 24 P BF
- 1 - 450 x 80 x 203 - 95A 14 Q BF (S)