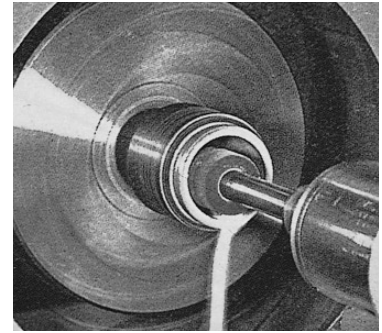
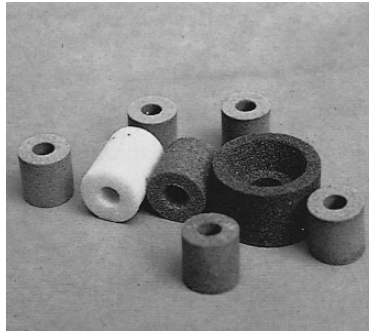


Internal grinding refers to the grinding of bores or holes and probably one of the most difficult type of grinding. Requirements of internal grinding range from very rapid removal of stock to processes capable of generating size and concentricity measured in millionths of inches.



Recommendations

Vitrified Bond

Wheel's dimension (D)	Mild Steel		Alloy Steel		Tool Steel		Stainless Steel		Cast Iron	
	HRC < 25	HRC > 25	HRC < 25	HRC > 55	HRC < 60	HRC > 60	300series	400series	ordinary	special
Up to 16mm(5/8")	FA 80-MV	WA80-LV	WA80-LV	32A80-LV	WA80-LV	32A80-KV	GC54-K	GC80-LV	C80-KV	C80-JV
19-32mm(3/4" ~ 1-1/4")	FA60-LV	WA60-KV	WA60-KV	32A60-KV	WA60-KV	32A60-JV	~	GC60-KV	C60-JV	C60-IV
38-50mm(1-1/2" ~ 2")	FA54-KV	WA54-JV	WA54-JV	32A54-JV	WA54-IV	32A54-IV	GC36-K	GC54-JV	C54-IV	C54-HV
65-75mm(2-1/2" ~ 3")	FA46-KV	WA46-JV	WA46-JV	32A46-JV	WA46-JV	32A46-IV		GC46-JV	C46-IV	C46-HV
Over 90mm(3-1/2")	FA46-JV	WA46-IV	WA46-IV	32A46-IV	WA46-IV	32A46-HV		GC46-IV	C36-IV	C36-HV

Note: 1. In internal grinding, it is recommended that the wheel diameter should be 60-80% of the hole diameter.

2. When grinding, the over travel of wheel at the ends of the hole being ground should be controlled to under 1/3 of the wheel thickness to avoid a producing bellmouthed hole condition.

Standard Dimensions

D	T							H			P
3/8" (10)	1/4"(6)	3/8"(10)	1/2"(13)	—	—	—	—	1/8"(3.18)	—	—	—
1/2" (13)	1/4"(6)	3/8"(10)	1/2"(13)	—	—	—	—	1/8"(3.18)	3/16"(4.77)	—	—
5/8" (16)	1/4"(6)	3/8"(10)	1/2"(13)	5/8"(16)	3/4"(19)	1"(25)	—	1/8"(3.18)	1-3/16"(3.18)	1/4"(6.35)	3/8"(9.53)
3/4" (19)	1/4"(6)	3/8"(10)	1/2"(13)	5/8"(16)	3/4"(19)	1"(25)	—	3/16"(4.77)	1/4"(6.35)	3/8"(9.53)	1/2"(12.7)
7/8" (22)	1/4"(6)	3/8"(10)	1/2"(13)	5/8"(16)	3/4"(19)	1"(25)	—	3/16"(4.77)	1/4"(6.35)	3/8"(9.53)	1/2"(12.7)
1" (25)	1/4"(6)	3/8"(10)	1/2"(13)	5/8"(16)	3/4"(19)	1"(25)	—	3/16"(4.77)	1/4"(6.35)	3/8"(9.53)	5/8"(15.88)
1-1/8" (28)	1/4"(6)	3/8"(10)	1/2"(13)	5/8"(16)	3/4"(19)	1"(25)	1-1/4"(32)	3/16"(4.77)	1/4"(6.35)	3/8"(9.53)	5/8"(15.88)
1-1/4" (32)	1/4"(6)	3/8"(10)	1/2"(13)	5/8"(16)	3/4"(19)	1"(25)	1-1/4"(32)	3/8"(9.53)	1/2"(12.7)	5/8"(15.88)	5/8"(15.88)
1-1/2" (38)	3/8"(10)	1/2"(13)	5/8"(16)	3/4"(19)	1"(25)	1-1/4"(32)	1-1/2"(38)	3/8"(9.53)	1/2"(12.7)	5/8"(15.88)	3/4"(19.05)
1-3/4" (45)	3/8"(10)	1/2"(13)	5/8"(16)	3/4"(19)	1"(25)	1-1/4"(32)	1-1/2"(38)	3/8"(9.53)	1/2"(12.7)	5/8"(15.88)	1"(25)
2" (50)	3/8"(10)	1/2"(13)	5/8"(16)	3/4"(19)	1"(25)	1-1/4"(32)	1-1/2"(38)	3/8"(9.53)	1/2"(12.7)	5/8"(15.88)	1"(25)
2-1/2" (65)	3/8"(10)	1/2"(13)	5/8"(16)	3/4"(19)	1"(25)	1-1/4"(32)	1-1/2"(38)	1/2"(12.7)	5/8"(15.88)	3/4"(19.05)	1-1/4"(32)
3" (75)	3/8"(10)	1/2"(13)	5/8"(16)	3/4"(19)	1"(25)	1-1/4"(32)	1-1/2"(38)	1/2"(12.7)	5/8"(15.88)	3/4"(19.05)	1-1/4"(32)
3-1/2" (90)	1/2"(13)	5/8"(16)	3/4"(16)	1"(25)	1-1/4"(32)	1-1/2"(38)	2"(50)	5/8"(15.88)	3/4"(19.05)	7/8"(22.23)	1-1/4"(32)
4" (100)	1/2"(13)	5/8"(16)	3/4"(16)	1"(25)	1-1/4"(32)	1-1/2"(38)	2"(50)	5/8"(15.88)	3/4"(19.05)	7/8"(22.23)	1-1/2"(40)
4-1/2" (115)	1/2"(13)	5/8"(16)	3/4"(16)	1"(25)	1-1/4"(32)	1-1/2"(38)	2"(50)	5/8"(15.88)	3/4"(19.05)	7/8"(22.23)	1-1/2"(40)
5" (125)	1/2"(13)	5/8"(16)	3/4"(16)	1"(25)	1-1/4"(32)	1-1/2"(38)	2"(50)	5/8"(15.88)	3/4"(19.05)	7/8"(22.23)	2-1/2"(65)
6"(150)	1/2"(13)	5/8"(16)	3/4"(16)	1"(25)	1-1/4"(32)	1-1/2"(38)	2" (50)	5/8"(15.88)	3/4"(19.05)	7/8"(22.23)	2-1/2"(65)

