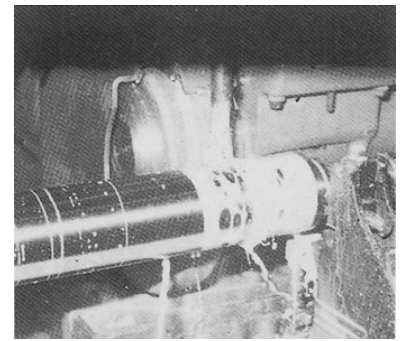


Cylindrical grinding may include all outside diameter grinding, even though the finished workpiece is not a cylinder.

The workpiece may be conical in shape or consist of a special form, ground with a wheel dressed into a specific shape. Wheels in this category are used for grinding works which are held between centres and chucks.



## Standard Size & Specifications: Type 1–Straight Wheels

Requirements in cylindrical grinding vary from fast stock removal, where rough finish is allowed, to ultra-smooth finishing, which is called mirror finish. Wheels with coarse grit and rough dressing are suitable for fast stock removal. In contrast, wheel with fine grit and smooth dressing result in smooth finish.

Hard material requires softer wheels than soft material in the same wheel dimension. Workpieces with small diameters or sharp corners, finer grit is more important than harder grade. Workpieces with wide shoulders require softer and coarser wheels, particularly when the workpiece is hardened.

## Starting Recommendation of Specifications

Workpiece Materials		Wheel Diameter (Vitrified)			
		355mm 14"	355-405mm 14"~16"	455-510mm 18"~20"	610mm 24"~30"
Carbon Steel	< HRC25	FA60-MV	FA54-MV	FSA46-MV	FSA46-LV
	≥ HRC25	38A60-MV	FSA54-LV	FSA46-LV	FSA46-KV
Alloy Steel	< HRC55	38A60-LV	FA54-LV	FSA46-LV	FSA46-LV
	≥ HRC55	SA60-KV	SA54-K	SA46-KV	SA46-JV
Tool Steel	< HRC60	38A60-KV	PA54-KV	PA46-KV	PA46-JV
	≥ HRC60	SA60-JV	SA54-JV	SA46-JV	SA46-IV
Stainless Steel heat resistance Steel		SA60-KV	SA54-KV	SA46-KV	SA46-JV
Cast Iron		C60-JV	C54-KV	C46-KV	C36-KV
Special Cast Iron		GC60-IV	GC54-JV	GC46-JV	GC36-JV
Chilled Iron		GC60-IV	GC54-JV	GC46-JV	GC36-JV
Malleable Iron		FA60-MV	FA54-MV	FA46-MV	FA46-LV
Brass		C46-JV~ C36-JV			
Bronze		FA54-LV~ FA36-LV			
Al. Alloy		C46-JV~ C36-JV			
Super Al. Alloy		GC80-IV~ GC60-IV			
Chromium Plating		93A46-HVP~ 93A60-IVP			
Rubber		CGC-36~ 60-H~ LV			

Size (D x T x H)		Spec.	Max. rpm	Product Code
mm	inch			
305 x 32 x 76.2	12" x 1-1/4" x 3"	WA46-K8V	2,087	YVW55018-
305 x 32 x 101.6	12" x 1-1/4" x 4"	WA46-K8V	2,087	YVW55015-
355 x 38 x 127	14" x 1-1/2" x 5"	38A60-K8V	1,793	YVT56011-
405 x 25 x 127	16" x 1" x 5"	FA60-K8V	1,572	
		SA60-K5V		
		5KG60-JV		
405 x 25 x 203.2	16" x 1" x 8"	FA60-K8V	1,572	
		SA60-K5V		
405 x 38 x 127	16" x 1-1/2" x 5"	FA60-K8V	1,572	
		SA60-K8V		
405 x 50 x 127	16" x 2" x 5"	FA60-K8V	1,572	YVW57003-
		WA46-K8V		
455 x 50 x 127	18" x 2" x 5"	FSA60-K8V	1,399	
		5KG60-KV		
510 x 25 x 203.2	20" x 1" x 8"	PA60-K8V	1,248	
		PA80-K8V		
510 x 38 x 127	20" x 1-1/2" x 5"	SA46-H8V	1,248	
		FSA60-K8V		
510 x 50 x 127	20" x 2" x 5"	FSA60-K8V	1,248	
		PA60-K8V		
510 x 50 x 203.2	20" x 2" x 8"	FSA60-K8V	1,248	
		PA60-K8V		
		SA60-K5V		
510 x 50 x 304.8	20" x 12" x 12"	FSA46-J8V	1,248	
		SA46-J8V		
510 x 75 x 203.2	20" x 3" x 8"	FSA60-K8V	1,248	
		PA60-J8V		
610 x 25 x 304.8	24" x 1" x 12"	PA80-L8V	1,044	
		FSA60-K8V		
610 x 50 x 304.8	24" x 2" x 12"	FSA60-K8V	1,044	
		FSA80-K8V		
760 x 50 x 304.8	30" x 2" x 12"	FSA60-K8V	838	
		SA60-K8V		
760 x 75 x 304.8	30" x 3" x 12"	FSA60-K8V	838	
		SA60-K8V		
760 x 100 x 304.8	30" x 4" x 12"	FSA60-K8V	838	

