

Tool Grinding Wheels

For Tool & Cutter Grinding

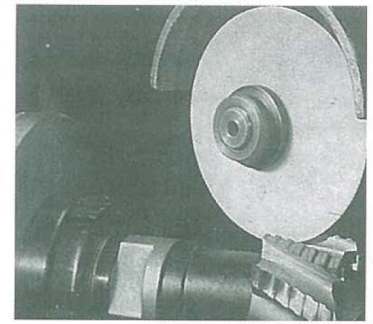
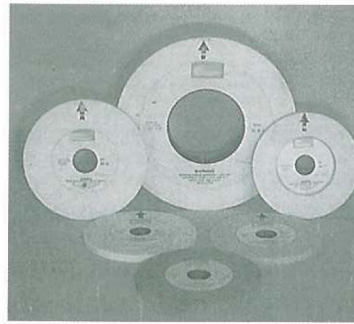
Typical Application:

Off-hand grinding

Twist drills with wheel periphery

Cylindrical, taper, and chamfer grinding

Broaches, chasers, etc. , with form-true
periphery



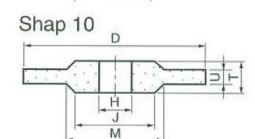
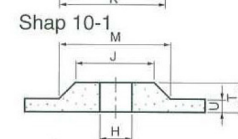
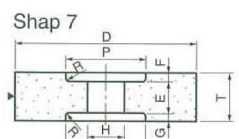
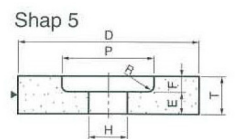
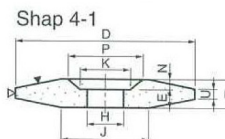
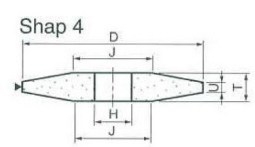
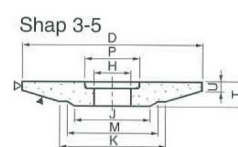
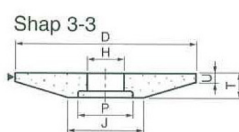
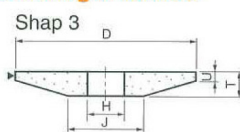
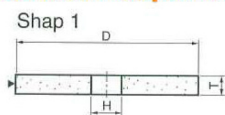
Vitrified Tool Room Wheel Starting Recommendations

Vitrified

Workpiece	Operation	Wheel Shape	High Speed Steels		Carbide Tools	
			Small Size	Large Size	Standard	Improved Finish
Bits	Off-hand	1	38A60-MV	38A46-MV	GC80-KV	GC120-JV
	Forming	1	WA60-JV	WA46-KV	GC80-JV	GC120-HV
	Forming	6 & 11	WA60-IV	WA46-JV	GC80-HV	GC120-HV
	Surface	1	WA60-KV	WA46-KV	GC80-HV	GC120-HV
Steel Shank Of Tools	Off-hand	1	38A46-PV	38A36-MV	—	—
Milling Cutter	Sharpening	12	WA60-KV	WA46-KV	GC80-HV	GC120-HV
	Grinding the sides	6 & 11	WA80-KV	WA60-KV	GC80-HV	—
End Mill	Sharpening	12	WA100-MV	WA80-LV	—	—
	Grinding the end	6 & 11	WA100-MV	WA80-KV	—	—
Twist Drill	Pointing	6 & 11	WA80-KV	WA46-LV	GC80-HV	—
	Pointing	1	WA60-KV	WA46-LV	GC80-HV	—
	Thining	1	WA80-MV	WA60-MV	GC80-HV	—
Reamer	Sharpening	12	WA80-KV	WA60-LV	—	—
	Fluting	1	WA80-JV	WA60-KV	—	—
Tap	Reliel	1	WA80-IV	—	—	—
	Fluting	1	32A150-NV	32A80-LV	—	—
	Threading	1	WA80-KV	—	—	—
Hob	Sharpening	1 or 4	32A46-KV	32A60-JV	—	—
Broach	Sharpening	12	32A100-HV	32A80-JV	—	—
Pinion Cutter	Sharpening	1	WA60-JV	—	—	—
Cutlery	Sharpening	12	WA80-120-JV	—	GC80-IV	GC120-JV

Note: Diamond wheels can be used grind carbide tools, and for HSS, use CBN wheels, Please refer to our catalogue of super abrasives for further information.

Standard Shapes & Sizes: Straight Wheels



(inch)

(mm)

D	T	H	P	J	D	T	H	P	J
2"	1/4". 3/8"	3/8". 1/2"		1"	50mm	6. 10mm	9.53 12.70mm		25mm
3"	1/4". 3/8". 1/2"	3/8". 1/2". 3/4"		1 1/2"	75	6. 10. 13	9.53 12.70 19.05		38
3 1/2"	1/4". 3/8". 1/2"	3/8". 1/2". 3/4"		1 3/4"	90	6. 10. 13	9.53 12.70 19.05		45
4"	1/4". 3/8". 1/2"	1/2". 3/4". 1-1/4"		2"	100	6. 10. 13	12.70 19.05 31.75		50
4-1/2"	1/4". 3/8". 1/2"	1/2". 3/4". 1-1/4"		2 1/4"	115	6. 10. 13	12.70 19.05 31.75		58
5"	1/4". 3/8". 1/2". 5/8"	1/2". 3/4". 1-1/4"		2 1/2"	125	6. 10. 13. 16	12.70 19.05 31.75		65
6"	1/4". 3/8". 1/2". 5/8". 3/4"	1/2". 3/4". 1-1/4"	3 1/8"	3"	150	6. 10. 13. 16. 19	12.70 19.05 31.75	80	75
7"	1/4". 3/8". 1/2". 5/8". 3/4". 1". 1-1/4"	1-1/4". 1-1/2". 2"	4"	3 1/2"	180	6. 10. 13. 16. 19. 25. 32	31.75 38.10 50.80	100	90
8"	1/4". 3/8". 1/2". 5/8". 3/4". 1". 1-1/4"	1-1/4". 1-1/2". 2"	4"	4"	205	6. 10. 13. 16. 19. 25. 32	31.75 38.10 50.80	100	100
10"	1/4". 3/8". 1/2". 5/8". 3/4". 1". 1-1/4"	1-1/4". 1-1/2". 2". 3"	5 3/8"	5"	255	6. 10. 13. 16. 19. 25. 32	31.75 38.10 50.80 76.20	135	125

Note: Standard sizes of U are 2. 3. 4. 5. 6. 8. 10. 19. please specify it when ordering.

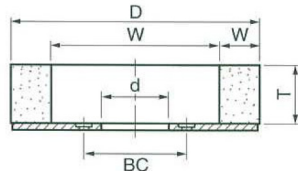
Tool Grinding Wheels

Plate Mounted

■ Type 2-1/Plate Mounted Wheels

Plate Mounted Wheels

Shape 2-1



Size (D x T x H)		Spec.	Max. rpm	Products Code	Plate No.	
mm	inch					
125 x 25 x 100 W25	5" x 1" x 3-1/2" W1"	FA80IV	4,584			
150 x 25 x 100 W25	5" x 1" x 4" W1"	WA46-KV WA60-JV 32A46-KV GC60-IV GC60-JV GC80-IV GC100-IV GC120-IV	3,600			
150 x 32 x 100 W25	6" x 1-1/4" x 4" W1"	WA60-JV GC60-JV	3,600			
150 x 38 x 100 W25	6" x 1-1/2" x 4" W1"	WA60-JV GC60-JV	3,600			
180 x 38 x 130 W25	7" x 1-1/2" x 5" W1"	WA60-JV GC60-JV	3,600			
205 x 50 x 141 W32	8" x 2" x 5-1/2" W1-1/4"	WA46-KV PSA46-KV	2,795			
230 x 50 x 125 W52.5	9" x 2" x 4-15/16" W2-1/32"	WA46-MV WA60-JV9NP3 32A80-JV9NP3 5KG80-JV9BP3	2,520			
255 x 50 x 179 W38	10" x 2" x 7" W1-1/2"	WA46-KV 32A46-KV GC60JV GC120-IV	2,247			
255 x 50 x 191 W32	10" x 2" x 7-1/2" W1-1/4"	PSA60-KV 32A54-JV	2,247			
355 x 10 x 279 W38	14" x 4" x 11" W1-1/2"	WA46-KV GC60-JV	1,614			

Plate No.	D x T x H	Bolt Pattern			BC (PCD)
		No.	Size	Type	
A50937	5" x 1/8" x 1-3/8"	4	19/64"	D	2-1/4"
A47466	6" x 1/8" x 1-1/4"	4	7/16"	D	3-1/4"
A39027	7" x 3/16" x 1-3/4"	4	5/16"	D	3-1/4"
A50831	8" x 3/16" x 3-1/8"	4	19/64"	D	3-13/16"
A47248	9" x 1/8" x 2"	6	9/32"	S	4"
A83831	10" x 1/8" x 2"	6	13/32"	D	3-1/2"
A110170	10" x 1/4" x 3-3/4"	4	13/32"	B	5"
A52814	14" x 1/4" x 1-1/4"	4	9/16"	D	8"

Note:

1. Type of Bolt Hole:

D= Plain, straight for hex or socket head screw 

S= Countersunk for flat head screw 

B= Counterbored 

2. BC= Diameter of bolt circle; each line describes one bolt circle.

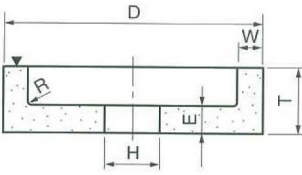
Brackets () show the bolt circles included on the same plate.

Tool Grinding Wheels

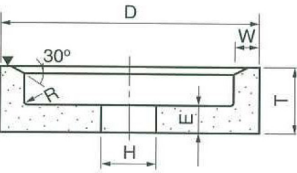
■ Type 6

-Straight Cup Wheels

Shape 6A



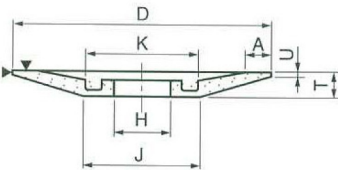
Shape 6Y



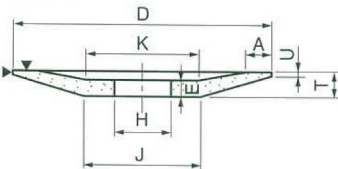
Size (D x T x H)		Spec.	Max. rpm	Products Code	
mm	inch				
73 x 38 x 7.94 W8, E10	2-7/8" x 1-1/2" x 5/16" W5/16", E3/8"	38A60-N8V 38A80-N7V	7639 7639	YXT27008- YXT27004-	
90 x 38 x 12.70 W13, E13	3-1/2" x 1-1/2" x 1/2" W1/2", E1/2"	38A60-KV	6366		
100 x 38 x 12.70 W13, E13	4" x 1-1/2" x 1/2" W1/2", E1/2"	38A60-KV 32A60-KV	5730 5730		
100 x 38 x 31.75 W13, E13	4" x 1-1/2" x 1-1/4" W1/2", E1/2"	38A60-KV 32A60-KV	5730 5730		
100 x 50 x 20.00 W13, E13	4" x 2" x 20mm W1/2", E1/2"	WA80-JV WA80-L7V WA80-M7V GC120-J8V	5730 5730 5730 5730	YWY60009- YWY60008- YWG60032-	
125 x 38 x 31.75 W13, E13 (Face Y)	5" x 1-1/2" x 1-1/4" W1/2", E1/2" (Face Y)	38A46-KV 38A60-KV 32A60-JV 5SG60-KV	4584 4584 4584 4584		
125 x 50 x 15.88 W13, E13	5" x 2" x 5/8" W1/2", E1/2"	38A60-JV 32A60-JV	4584 4584		
125 x 50 x 17.00 W12, E12	5" x 2" x 17mm W1/2", E1/2"	WA60-J8V	4584	YWX60025-	
150 x 38 x 12.70 W25, E13	6" x 1-1/2" x 1/2" W1", E1/2"	PSA60-JV 32A46-KV	3820 3820		
150 x 75 x 25.4 W19, E19	6" x 3" x 1" W3/4", E3/4"	38A36-K8V 32A46-J8V	3820 3820	YWT61004- YWT61005-	
180 x 50 x 31.75 W13, E13	7" x 2" x 1-1/4" W1/2", E1/2"	WA46-JV 32A46-JV	3183 3183		
180 x 125 x 25.4 W25, E25	7" x 5" x 1" W1", E1"	38A36-K8V	3183	YWT62001-	
205 x 125 x 25.4 W25, E25	8" x 5" x 1" W1", E1"	38A36-J8V 38A36-K8V 38A46-J8V	2795 2795 2795	YWT63004- YWT63005- YWT63006-	
240 x 38 x 38.10 W38, E16	9-1/2" x 1-1/2" x 1-1/2" W1/2", E5/8"	53A46-LV 32A46-LV	2520		
255 x 100 x 38.10 W32, E25	10" x 4" x 1-1/2" W1-1/4", E1"	38A46-IV	2247		
305 x 65 x 177.80 W38, E22	12" x 2-1/2" x 7" W1-1/2", E7/8"	38A46-LV 32A46-LV	2087 2087		

■ Type 12-Dish Wheels

Shape 12



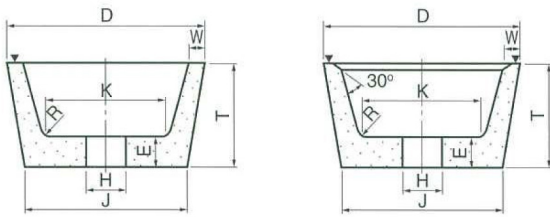
Shape 12-1



Size						Spec.	Max. rpm	Products Code	
D x T x H (mm)	J	K	D x T x H (inch)	J	K				
75 x 13 x 13 A3, E8	38	38	3" x 1/2" x 1/2" A1/8", E5/16"	1-1/2"	1-1/2"	32A60-KV	8,488		
100 x 13 x 19.05 A5, E8	50	50	4" x 1/2" x 3/4" A3/16", E5/16"	2"	2"	WA60-KV 32A60-KV 5KG60-KV	6,366		
150 x 13 x 31.75 A10, E8	75	75	6" x 1/2" x 1-1/4" A3/8", E5/16"	3"	3"	WA60-KV 32A46-KV 32A60-KV 5KG46-KV 5KG60-KV	4,244		
150 x 19 x 31.75 A10, E10	75	75	6" x 3/4" x 1-1/4" A3/8", E3/8"	3"	3"	WA60-J8V	4,244	YWX31002-	
180 x 13 x 31.75 A11, E9	70	83	7" x 1/2" x 1-1/4" A7/16", E11/32"	2-3/4"	3-1/4"	WA60-JV 32A46-KV 32A60-KV 32A80-KV	3,600		
180 x 19 x 31.75 A13, E13	70	83	7" x 3/4" x 1-1/4" A1/2", E1/2"	2-3/4"	3-1/4"	WA46-JV 32A46-JV	3,600		
205 x 19 x 31.75 A13, E13	100	100	8" x 3/4" x 1-1/4" A1/2", E1/2"	4"	4"	WA60-KV 32A60-KV	3,600		
255 x 25 x 25.4 A50, E18	159	92	10" x 1" x 1" A2", E11/16"	6-1/4"	3-5/8"	WA54-JV 32A54-JV	2,497		
255 x 25 x 31.75 A50, E18	159	92	10" x 1" x 1-1/4" A2", E11/16"	6-1/4"	3-5/8"	WA54-JV 32A54-JV	2,497		

Tool Grinding Wheels

■ Type 11-Flaring Cup Wheels



Shape	Size						Spec.	Max. rpm	Product Code	
	D x T x H (mm)	J	K	D x T x H (inch)	J	K				
11A	90 x 38 x 31.75 W6, E10	70	55	3-1/2" x 1-1/2" x 1-1/4" W1/4", E3/8"	2-3/4"	2-1/8"	WA60-K8V	6366	YXX29002-	
	100 x 50 x 31.75 W10, E13	75	60	4" x 2" x 1-1/4" W3/8", E1/2"	3"	2-3/8"	WA60-J8V	5730	YWX40014-	
	115 x 50 x 31.75 W6, E13	95	80	4-1/2" x 2" x 1-1/4" W1/4", E1/2"	3-3/4"	3-1/8"	WA46-KV WA60-JV 32A46-KV	4982		
	125 x 50 x 31.75 W6, E13	95	70	5" x 2" x 1-1/4" W1/4", E1/2"	3-3/4"	2-3/4"	WA60-I8V	4584	YWX40001-	
	180 x 50 x 31.75 W19, E13	127	95	5" x 2" x 1-1/4" W3/4", E1/2"	5"	3-3/4"	WA46-HV WA60-JV 32A46-JV 5KG46-KV	3183		
11Y	75 x 32 x 19.05 W6, E10	57	40	3" x 1-1/4" x 3/4" W1/4", E3/8"	2-1/4"	1-16/9"	WA60-JV 32A60-KV	7639		
	90 x 38 x 31.75 W6, E10	70	55	3-1/2" x 1-1/2" x 1-1/4" W1/4", E3/8"	2-3/4"	2-1/8"	WA60-K8V 32A60-K8V	6366		
	100 x 38 x 19.05 W6, E13	75	67	4" x 1-1/2" x 3/4" W1/4", E1/2"	3"	2-5/8"	WA60-K8V 5KG60-KV	5730		
	100 x 38 x 31.75 W6, E13	75	67	4" x 1-1/2" x 1-1/4" W1/4", E1/2"	3"	2-5/8"	WA46-KV WA60-KV WA80-JV WA100-KV 32A60-JV 32A80-JV 5KG46-KV 5KG60-KV 5KG80-KV	5730		
	125 x 45 x 31.75 W6, E13	95	78	5" x 1-3/4" x 1-1/4" W1/4", E1/2"	3-3/4"	3-1/16"	WA46-KV WA60-JV WA60-KV 32A46-KV 32A60-KV 32A80-KV 5KG46-KV 5KG60-KV 5KG60-LV	4584		
	150 x 50 x 31.75 W10, E13	115	95	6" x 2" x 1-1/4" W3/8", E1/2"	4-1/2"	3-3/4"	WA46-KV WA60-JV 32A46-IV 32A46-JV 32A46-KV 32A60-KV	4584		