

Grinding

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**Recommended Wheels and Coolants Applicable to:**

**Corrosion-resistant Alloys**

**High-temperature Alloys**

Type of Grinding	Wheels*	Manufacturer	Type of Work	Coolant
<b>Cylinder grinding</b>				
Straight or tapered O.D.	53A80-J8V127	Norton	Sharp corners and fine finish	Heavy-duty soluble coolant 25:1 mix CASTROL 653
Form work, single wheel section method	38A60-J8-VBE	Norton	Removing stock, sharp corner work, straight radius work	Dry
Form work, crush-roll method	53A220-L9VB	Norton	Precision forms, radius	Straight oil
Centerless	53A80-J8VCN	Norton	Thin-walled material, solid or heavy-walled material	Heavy-duty soluble coolant 25:1 mix CASTROL 653
<b>Internal grinding</b>				
Straight or tapered	23A54-L8VBE	Norton	Small holes, medium-sized holes, large holes, small counter-bores	Heavy-duty soluble coolant 25:1 mix >CASTROL 709
<b>Surface grinding</b>				
Straight wheel	32A46-H8VBE 38A46-I-V	Norton	-	Dry or any heavy-duty soluble coolant 25:1 mix CASTROL 653
Double-opposed disk type	87A46-G12-BV 87A46-J11-BW	Gardner	Through-feed work, Ferris wheel work, thin work	Heavy-duty soluble coolant 10:1 mix CASTROL 653
Cylinder or segmental-type	32A46-F12VBE	Norton	Thin work, bevels, and close-tolerance work	Sal-soda in water CASTROL 653

Single wheel section method	32A46-F12VBEP	Norton	Profile work	Dry
<b>Thread grinding</b>				
External threads	A100-T9BH	Norton	-	VANTOL 5299-M or equivalent
<b>Honing</b>				
Internal	C120-E12-V32 C220-K4VE J45-J57	Bay State Carborundum Sunnen	-	VANTOL 5299-C or equivalent
<b>Rough grinding</b>				
Cut-off (wet)	86A461-LB25W	Norton	-	CASTROL 653
Cut-off (dry)	4NZA24-TB65N	Norton	-	Dry
Snagging	4ZF1634-Q5B38	Norton	-	Dry

\*The wheels indicated have been optimized for speeds between 6000 and 6500 surface ft./min