

Grinding Techniques (Pty) Ltd.

ON THE CUTTING EDGE OF TECHNOLOGY




ISO 9001:2000





Founded in 1981, Grinding Techniques (Pty) Ltd. is the largest privately owned abrasive manufacturer in Africa, operating under the principal business ethos of developing mutually beneficial business partnerships with our valued customers.



A wide spectrum of quality Bonded Abrasives are manufactured to ISO 9001:2000 standards; the company also converts Coated Abrasives, and markets Tungsten Carbide Burrs, diamond products and other ancillary items. In addition, Grinding Techniques (Pty) Ltd. is the Southern African agent for Tyrolit abrasives. The company distributes through a network of branches in South Africa, and exports extremely successfully on a worldwide basis.

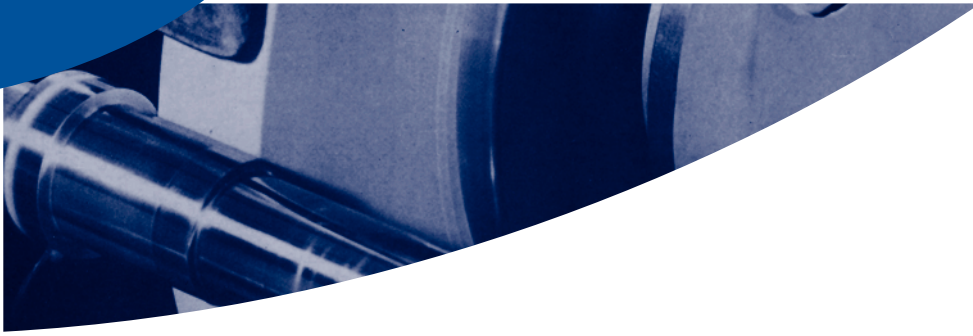


Grinding Techniques (Pty) Ltd. is an equal opportunity employer, committed to environmental protection and constant product improvement through ongoing research.



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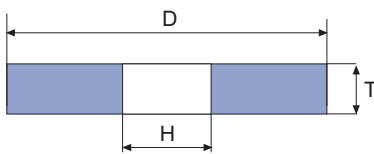
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SPECIFICATIONS

SHAPE 1

Straight Grinding Wheels



ORDERING DATA:

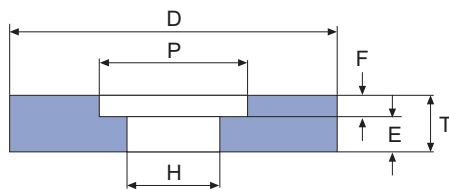
Diameter (D) x Thickness (T) x Height (H) - Shape 1
 These grinding wheels can also be supplied in shapes 20 and 21 (Page 10) or with wheel faces as per Page 11

D	T							H	
250	13	16	20	25				76,2	127
300	13	16	20	25	32	40	50	127	
350	16	20	25	32	40	50		127	
400	20	25	32	40	50	63	80	127	
450	20	25	32	40	50	63	80	127	203,2
500	25	32	40	50	63	80	100	203,2	304,8*
600	32	40	50	63	80	100		203,2	304,8*
750	32	40	50	63	80	100	125	304,8	
900	32	40	50	63	80	100	125	304,8	
1000	50	63	80	100	125			304,8	

*For peripheral speeds up to 45m/s only

SHAPE 5

Straight Grinding Wheel - recessed one side



ORDERING DATA:

Diameter (D) x Thickness (T) x Height (H) - P x F - Shape 5
 These grinding wheels can also be supplied in shapes 22, 23 and 25 (Page 10) or with wheel faces as per Page 11

*For peripheral speeds up to 45m/s only

D	T			H	P	F
300	40	50		127	190	13
350	40	50		127	215	13
400	40	50	63	127	215	13
	80					25
	100					40
450	40	50	63	127	215	13
	80					25
	100					40
	40	50	63	203,2	290	13
	80					25
	100					40
500	40	50	63	203,2	290	13
	80					25
	100					40
	40	50	63	304,8*	390	13
	80					25
	100					40
600	63			203,2	290	13
	80					25
	100					50
	63			304,8*	390	13
	80					25
	100	125				50
750	63			304,8	410	13
	80					25
	100	125	160			50
900	63			304,8	440	13
	80					25
	100	125	160			50

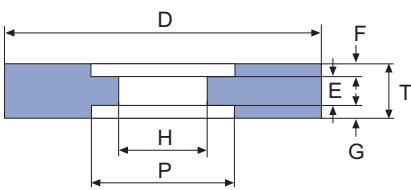
All dimensions in millimetres.

The specifications in this catalogue are recommendations only. For further information or special application specifications, please contact Grinding Techniques Technical Department (011) 271 6400 or email: info@grindtech.com

SPECIFICATIONS

SHAPE 7

Straight Grinding Wheels - recessed both sides



ORDERING DATA:

according to SN-standard - Shape 7

without SN-standard:

Diameter (D) x Thickness (T) x Height (H) - P x F/G
- Shape 7

These grinding wheels can also be supplied in shapes 24 and 26 (Page 10) or with wheel faces as per Page 11

***For peripheral speeds up to 45m/s only**

D	T			H	P		
300	40	50		127	190	6	6
350	40	50		127	215	6	6
400	40	50	63	127	215	6	6
	80					13	13
	100					13	25
450	40	50	63	127	215	6	6
	80					13	13
	100			13	25		
	40	50	63	203,2	290	6	6
80			13			13	
100			13			25	
500	40	50		203,2	290	6	6
	63	80				13	13
	100			13	25		
	40	50		304,8*	390	6	6
63	80		13			13	
100			13			25	
600	50			203,2	290	6	6
	63	80				13	13
	100					13	40
	50			304,8*	390	6	6
	63	80				13	13
100	125		13	13			
750	80			304,8	410	13	13
	100	125	160			13	40
900	80			304,8	440	13	13
	100	125	160			13	40

All dimensions in millimetres.

The specifications in this catalogue are recommendations only. For further information or special application specifications, please contact Grinding Techniques Technical Department (011) 271 6400 or email: info@grindtech.com

APPLICATION TABLE

FIELD OF APPLICATION			SPECIFICATIONS		
ROUGHING			up to ø 450	ø500 and above	
Universal Use	Steel	Soft	15A46 L6V86	15A46 K6V86	
		Hardened	15A46 K7V86	15A46 J7V86	
Specific Use	Steel	Soft	15A54 K6V86	15A36 L6V86	
			15A60 K6V86	9A46 K6V86	
			9A60 K6V86	15A46 L6V86	
		Hardened to 63Rc	9A46 J7V86	9A46 J8V86	
			9A60 H8V86	9A60 J7V86	
			15A60 J7V86		
		Hardened over 63Rc	31A60 H8V86	31A60 H8V86	
			31A80 H8V86		
		Stainless, acid, and heat resistant - Soft	- Hardened	15A46 K6V86	15A46 K6V86
				15A60 J7V86	
8C80 K8V1					
15A60 J6V86	11A46 K6V86				
Hard-chrome-plated	Nitriding unprocessed	8C60 J8V1			
		15A60 K6V86	15A60 K6V86		
Nitriding unprocessed	Nitride hardened	11A46 J8V86	8C54 J8V1		
		8C60 J8V1	11A46 J8V86		
Cast	Cast	—	—		
		15A46 K6V86	15A46 L6V86		
Cast Iron	Grey	15A46 L6V86			
		11A46 K6V86	11A46 K6V86		
		8C46 I7V1	8C46 I7V1		
Spheroid	Spheroid	8C60 I7V1			
		8C46 I7V	8C46 I7V1		
Tungsten Carbide			8C46 J6V1	8C46 J6V1	
Aluminium and non-ferrous metals			8C60 J6V1		
Rubber			8C60 H10V11P	8C46 H10V11P	
			9A46 E12V86P	8C36 F12V86P	
			31A46 E12V86P	31A46 E12V86P	

FIELD OF APPLICATION		SPECIFICATIONS	
Crankshaft Grinding	Roughing	A36 M5V86	
		A54 L6V86	
	Finishing	A54 M6V86	
Re-grinding – general purpose	Re-built (welded)	A54 LM6V86	
		A46 L5V86	
Camshaft Grinding			
Cast Iron Alloy	Roughing	15A36 L7V86	
		15A60 L5V86	
Steel	Soft	15A36 M5V86	
	Hardened	Roughing	15A46 L6V86
		Finishing	15A60 L5V86
	Re-grinding	1A60 M5V86	

FIELD OF APPLICATION		SPECIFICATIONS
Bearing Diameters		
Cast Iron Alloy	Roughing	15A36 L7V86
	Finishing	15A60 K6V86
Steel	Soft	15A36 M5V86
	Hardened	A54 L5V86
Roll Grinding		
Hot Mill:	Roughing rolls	6CA36 N8B3-Z
	Forged steel work rolls	9AC302 L8B3-Z
	High speed steel rolls	5A54 K7V86
Cold mill:	Work rolls	A46 N8B3-Z
	Forged steel rolls	9AC302 L8B3-Z
	Finish rolls	6AC120 M8B3-Z
	Taper, drive, idler rolls	5A80 K8V86
	Polishing coated rolls (Tyrolit)	C400K8 B122-50

APPLICATION TABLE

FIELD OF APPLICATION			SPECIFICATIONS			
FINISHING AND FINE GRINDING			Finishing up to ø450	ø500 and above	Fine & Superfine Grinding	
Universal Use	Steel	Soft	15A60 K6V86	15A60 J6V86		
		Hardened	15A60 J8V86 15A80 J8V86	15A60 I8V86		
Specific Use	Steel	Soft	15A60 K6V86 15A60 L6V86 15A80 K6V86 15A80 L6V86	15A60 J6V86 15A60 K6V86		
		Hardened to 63Rc	15A60 J8V86 9A60 J7V86 15A80 J8V86	15A60 I8V86 9A60 J8V86	8C320 E3E	
		Hardened over 63Rc	31A80 G8V86 15A80 H8V86 8C120 K8V1	31A60 H8V86	8C320 E3E	
		Stainless, acid, and heat resistant	- Soft	11A60 K8V86	11A60 J6V86	
			- Hardened	11A80 I8V1 8C80 J8V1	11A60 I8V86	8C320 E3E
		Hard-chrome-plated	15A60 L6V86 15A80 L6V86	15A60 K6V86 15A80 K6V86	8C320 E3E	
		Nitriding unprocessed	11A60 K6V86 8C80 J8V1	11A60 K6V86 8C60 H8V1		
		Nitride hardened	8C60 I7V11 8C80 J8V1	8C54 I8V1 8C60 H8V1	8C320 E3E	
		Cast	15A60 K5V86	15A54 K6V86 15A60 J6V86		
		Stellite		11A60 K8V86	11A54 J7V86	
		Cast Iron	Grey	8C60 I7V11 31A60 K6V86	8C54 I7V11 31A60 J8V86	
Spheroid	8C60 I7V11 31A60 I6V86		8C54 I7V11 31A60 I8V86			
Tungsten Carbide		8C60 K6V1 8C80 J6V1 8C120 I8V1	8C60 I8V1	8C320 E3E		
Aluminium and non-ferrous metals, plastics		8C70 H8V11	8C60 H8V11			
Rubber		31A80 F12V86P 8C60 H10V11P	8C60 H10V11P			
PLUNGE-CUT GRINDING						
Straight and angular, 35 and 45 m/s			Ø400 and above			
Steel	Soft		15A60 K6V86 15A80 K6V86			
		Small profiles	31A180 J6V86			
	Hardened		15A60 J6V86 15A80 J6V86			
		Small profiles	31A180 I6V86			
	Over 63Rc	8C120 L5V11				