



CENTRELESS GRINDING WHEELS

Unmatched versatility. High performance grinding solutions for a range of components, materials and sizes.

Commonly used in the grinding of bearings, bars, taps drills and a range of auto parts.

Sak Abrasives Ltd.

TOPLINE
Let the sparks fly

User segments

- Automotive: Engine valves, gear shafts, fuel injection, gudgeon pins, pistons etc.
- Bearings: Taper rollers, bearing races and tracks
- Bar manufacturing: Grinding stainless steel bright bars etc.
- Cutting tools: Taps and drills

The TOPLINE advantage

- Resinoid and vitrified bonds for a wide price-performance range
- Advanced bond systems for high performance on different materials
- Freer cutting and good component finish

TOPLINE Recommendations

Component	TOPLINE specification
Axels (Auto)	1A 60 L5 VT4C
Bolts	1A 60 M5 VT4C
Bushings (Hard)	1A 60 L5 VT4C
Bushings (Cast iron)	5C 463 L5 VSA
Carbon steel/Cast iron/Copper	5C 463 L5 VSA
Drills	1A 60 M5 VT4C
Ebonite	5C 463 L5 VSA
Roller bearing cups (small dia)	1A 60 L5 VS10
Bearing rollers	1A 60 M5 VS10
Spine shafts	1A 60 L5 VT4C
Soft steel	1A 60 N5 VT4C
Hard steel	1A 60 L5 VS10
High speed steel (roughing)	1A 463 L5 VS10
Stainless steel	5C 463 L5 VSA
Valve stems	1A 60 L5 VS10
Valve tappets	1A 60 L5 VS10
Tungsten carbide	6G 60 K5 VSA

Abrasive	Grit	Hardness	Type	Bond		
1A	24, 36, 463, 54, 60, 80	K, L, M, O, Q	1	VT4		
Dia. (In.)	Thick. (In.)	Bore (In.)	Dia. (mm)	Thick. (mm)	Bore (mm)	Speed (rpm)
12	3 3/4	5 5/8	300	80	140	2100
12	4	5	300	100	127	2100
14	1, 1 1/4, 1 1/2	5	350	25, 32, 38	127	1800
14	2, 4, 6	5, 6	350	50, 100, 150	127, 152.4	1800
16	1	5, 8	400	25	127, 203.2	1575
16	1 1/2, 2	5, 8	400	38, 50	127, 203.2	1575
16	4	10	400	100	254	1575
16	8	8	400	200	203.2	1575
18	3	1 1/2	450	75	38.1	1400
20	1 - 10	12	500	25 - 250	304.8	1260
24	2 1/2	12	600	63	304.8	1050
24	2 - 8	12	600	50 - 200	304.8	1050
24	10, 20	12	600	250, 500	304.8	1050

Abrasive	Grit	Hardness	Type	Bond		
8M	46, 54, 60, 80, 90	C, H, I, J, K	1	B		
Dia. (In.)	Thick. (In.)	Bore (In.)	Dia. (mm)	Thick. (mm)	Bore (mm)	Speed (rpm)
7	1/2 - 1	1 1/4	175	13 - 25	31.75	3600
8	1/2	1 1/4	200	13	31.75	3150
10	1	3	250	25	76.2	2520
12	1	3	300	25	76.2	2100
12	1, 1 1/2	5	300	25, 38	127	2100
14	1 - 2	5	350	25 - 50	127	1800
20	6, 8	12	500	150, 200	304.8	1260
24	6, 8	12	600	150, 200	304.8	1050
24	10, 20	12	600	250, 500	304.8	1050

